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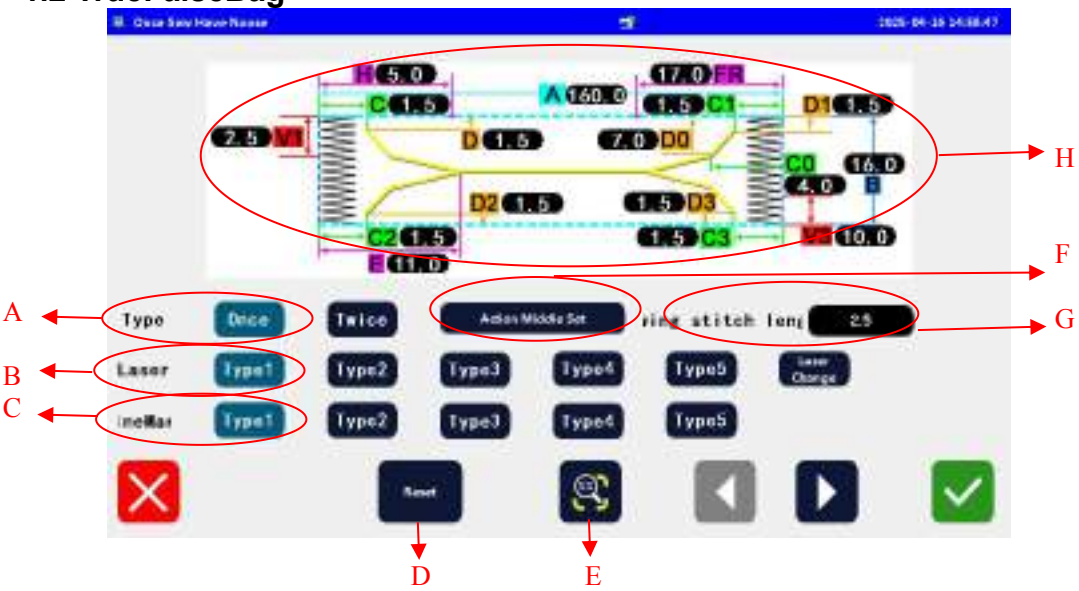
# Chapter 1 Para Pattren

## 1.1 Enter Way

| | |
|---|---|
| 1、Click on the menu on the interface. |  |
| 2、Enter the menu mode interface,click”Para Version”. |  |
| 3、Choice ”TureFalseBag” or ”MoonToothBag”,click Enter. |  |

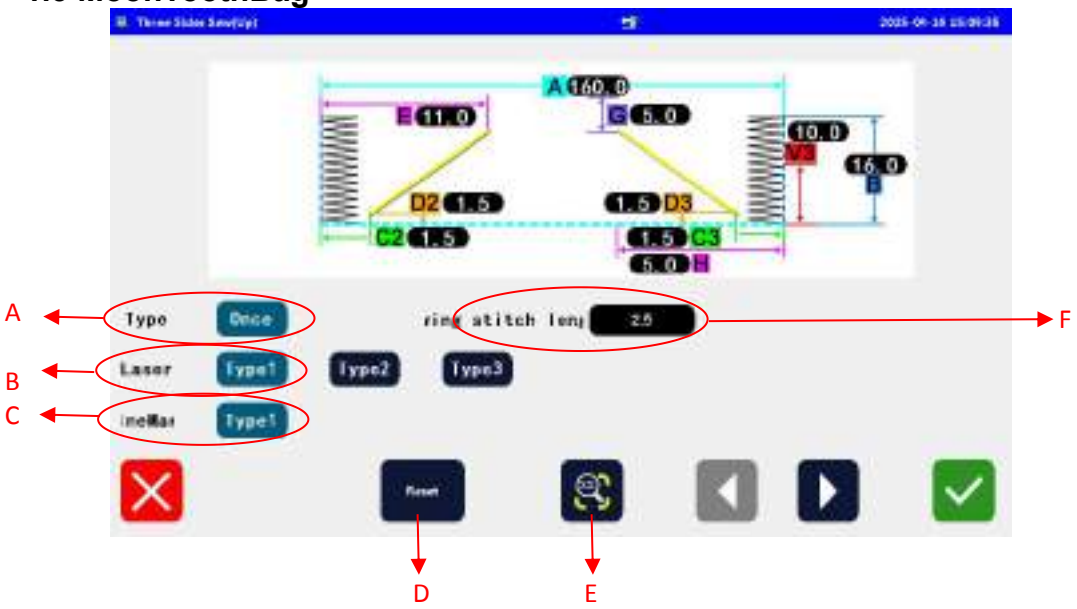
## 1.2 TrueFalseBag




**Function explaination：**

| Order | Function | Content |
|---|---|---|
| A | Type | Single/Double<br>Sigle:Usually fake pockets, ziper bags<br>Double :Usually real pockets, stitching goes around twice |
| B | Laser | Select laser style |
| C | LineMark | Select thread pattern settings |
| D | Reset | Enter parameter directory settings interface |
| E | Pattern preview | Enter parameter directory settings interface |
| F | Laser Middle Set | laser intermediate stitching shape, laser intermediate up/down offset , etc |
| G | Sewing stitch length | Set stitching needle pitch |
| H | Length value | Click the number to modifty the interval distance value |

## 1.3 MoonToothBag



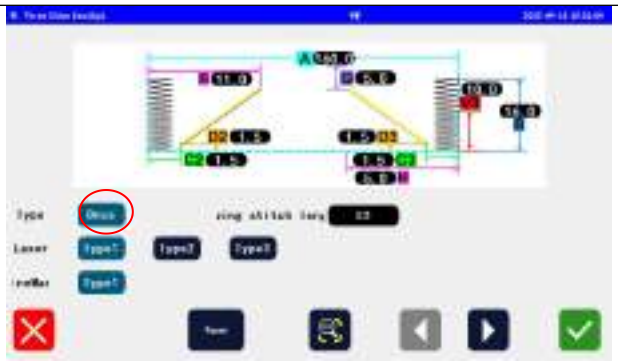
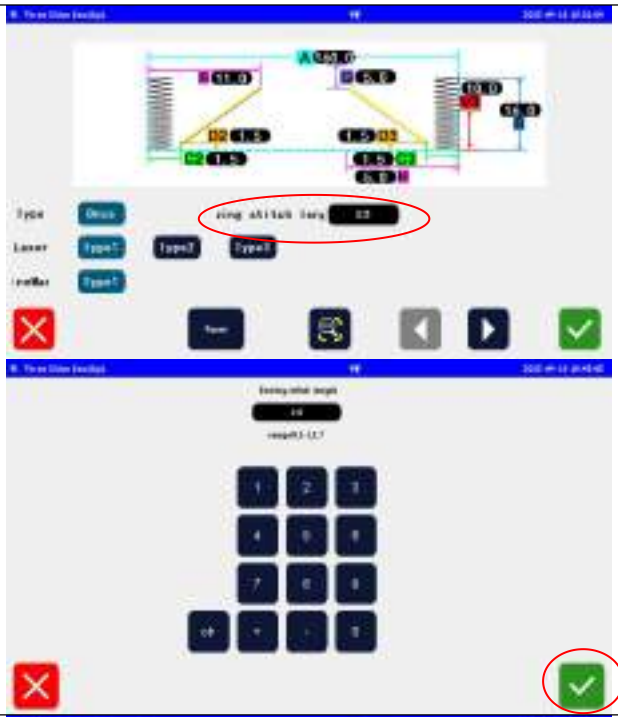
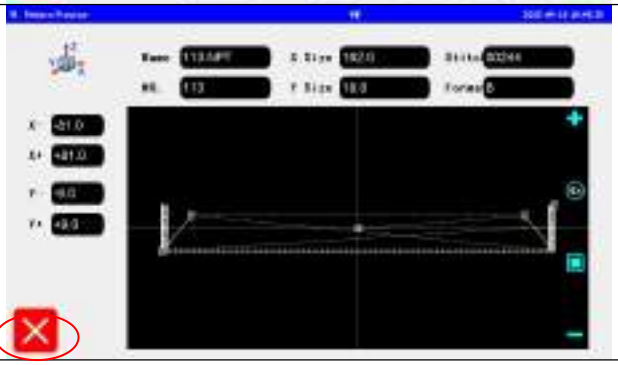

**Function explaination：**

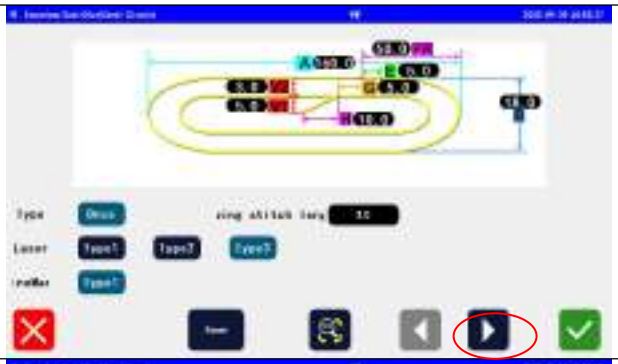
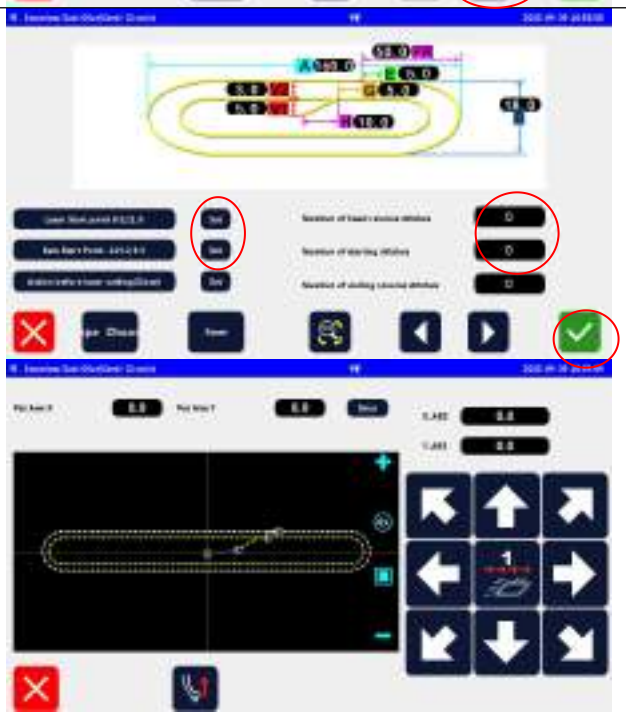
| Number | Function | Content |
|---|---|---|
| A | Type | Select the number of laser operations |
| B | Laser | Select the style the laser |
| C | LineMark | Select the stsitch pattern for the loop |
| D | Reset | Enter the parameter directory setting interface |
| E | Pattern preview | Enter the pattern preview interface |
| F | Sewing stitch length | Set the stitching needle pitch |

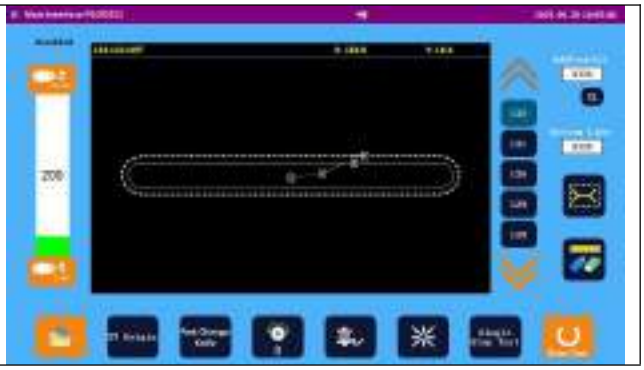
**Example number explain:**

| Number | Content |
|---|---|
| A | Represents the lenght of the pocket |
| B | Represents the width of the pocket |
| C | Distance between the laser and the wide edge of the fabric |
| D | Distance between the laser and the upper/lower edges of the fabric |
| E | Cutting start postion |
| G | Offset distance of the cutting point |
| H | Medium/high speed/high speed offset distance |
| V | Distance beween the laser and the long edge of the fabrice |

## Operation demonstration：

| | |
|---|---|
| 1、Select a laser for one time. |  |
| 2、Set the sewing needle size to 3.0,click ok. |  |
| 3. Select laser type as type 3. Click to preview. |  |
| 4. Enter the graphical preview interface. Click to exit. |  |

| | |
|---|---|
| 5. Click the translation button to enter the next page. |  |
| 6. You can set graphic data, such as setting the number of head reverse sewing times to 2 and the number of needle start reverse sewing times to 2. Click confirm.<br><br>7. Click on Settings to adjust the XY position values of the laser start point and sewing start point. |  |
| 8. Click OK. |  |
| 9. Set the name and number, click OK. |  |

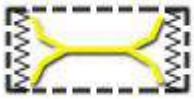
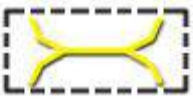
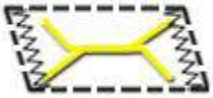
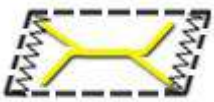
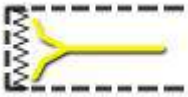
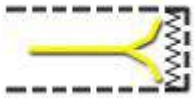
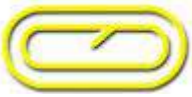
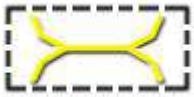
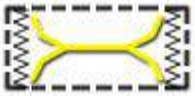
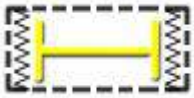
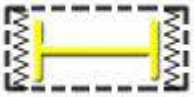
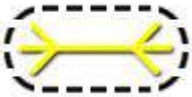
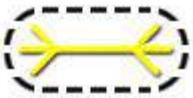
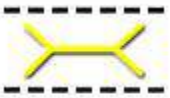
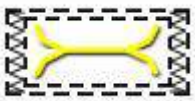
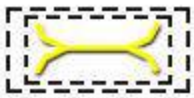
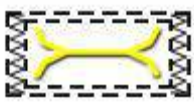
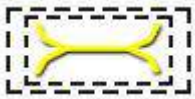
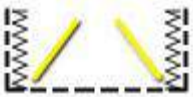
| | |
|---|---|
| 10. The figure is shown on the right. |  |

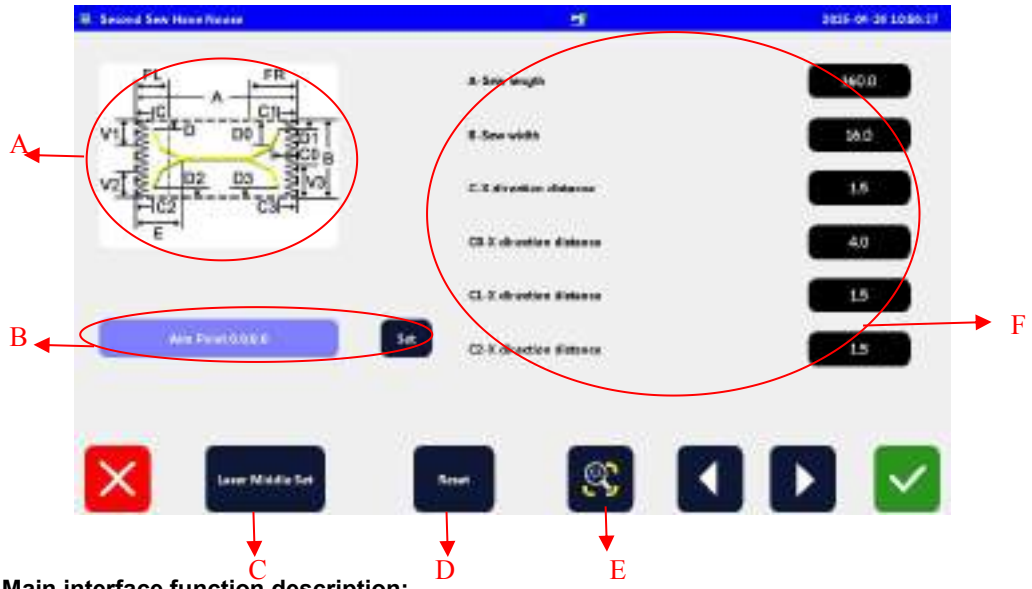
# Chapter 2 Open-bag Design

## 2.1 Entry Mode

| | |
|---|---|
| 1.Click "Menu" on the main interface |  |
| 2.Enetr the menu mode interface and click "Laser mode" |  |
| 3.Enter the "Open-Bag Design" interface |  |

## 2.2 Template Introduction

| formwork drawing | name | formwork drawing | name |
|---|---|---|---|
|  | Second Sew Have Noose |  | Second Sew No Noose |
|  | Four Sides Sew (Left) |  | Four Sides Sew (Right) |
|  | Three Sides Sew (up) |  | Three sides Sew (Right) |
|  | Three sides Sew (Left) |  | Seamless seal Glue (Semi-Circule) |
|  | Once Sew No Noose |  | Once Sew Have Noose |
|  | Straight Cut Once Sew Have Noose |  | Straight Cut Twice Sew Have Noose |
|  | Circle Once Sew |  | Circle Twice Sew |
|  | Common Mode Dark-line |  | Cotton Clothes Twice Sew Have knot |
|  | Cotton Clothes Twice Sew Have knot |  | Cotton Clothes Once Sew Have knot |
|  | Cotton Clothes Once Sew Haven’t knot |  | Secondary Sew Three Sides Sew(up) |



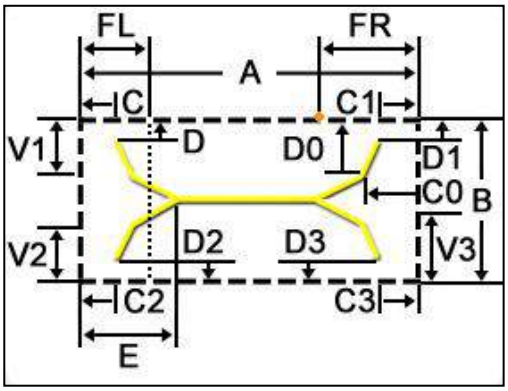

**Main interface function description:**

| Serial | Function | Content |
|---|---|---|
| A | Dispaly Diagram | Pattern data annotation ,area letters correspond to letters in G area |
| B | Pattern Zero Point Setting | Adjust pattern zero point XY postion values |
| C | Laser Middle Setting | Set laser middle cutting shape, laser middle up/down offset, etc. |
| D | Restore Default | Restore deault values |
| E | Preview | Enter marking graphic |
| F | Pattern Paramete Area | Value setting |

## 2.3 Bag Type Parameter Description

By modifying the parameters related to the bag type, the entire bag type can be adjusted as needed. The parameters of different bag types are different.

**The following is a schematic diagram of the parameters of Second Sew Have Noose.**

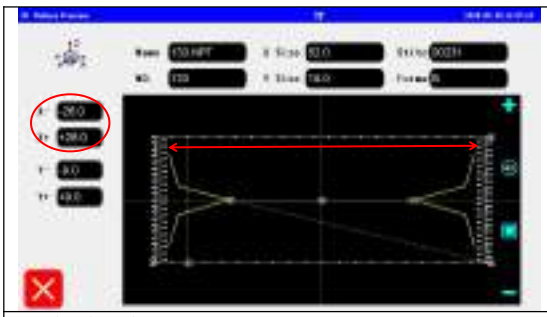



| numb | Parameter |
|---|---|
| A | Sewing length |
| B | Sewing width |
| C | X-direction distance |
| C0 | X-direction distance |
| C1 | X-direction distance |
| C2 | X-direction distance |
| C3 | X-direction distance |
| D | Y-direction distance |
| D0 | Y-direction distance |
| D1 | Y-direction distance |
| D2 | Y-direction distance |
| D3 | Y-direction distance |
| E | Cutting start position |
| FL | Empty Left |
| FR | Code To Right Len |
| V1 | Y Compensate Above Left |
| V2 | Y Compensate Above Left |
| V3 | Y Compensate Above Right |

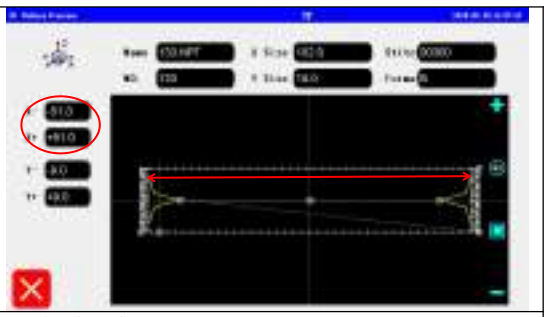
Below is a brief introduction to the definition and setting effects of bag type parameter.

### 2.3.1 A-Sew Lenght

Definition: The horizontal distance of bag type sewing thread, with a numerical range of 0.0-999.9mm
The following figure shows the effect of secondary sewing without a knot when the sewing length is 50 and 100.



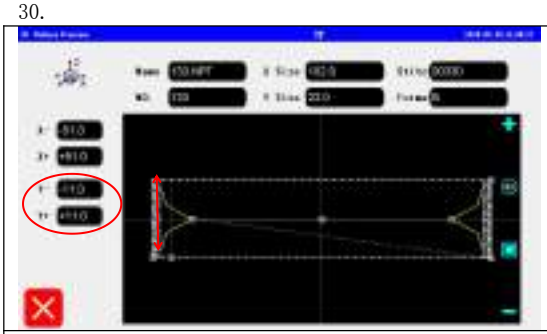
Sewing length=50



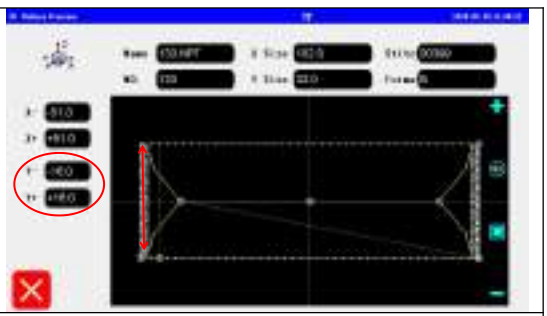
Sewing length=100

### 2.3.2 B-Sewing Width

Definition: The longitudinal distance between the upper and lower sewing threads of a bag type, with a numerical range of 0.0-999.9mm.
The following figure shows the effect of secondary sewing without a knot when the sewing width is 20 and 30.



Sewing width=20

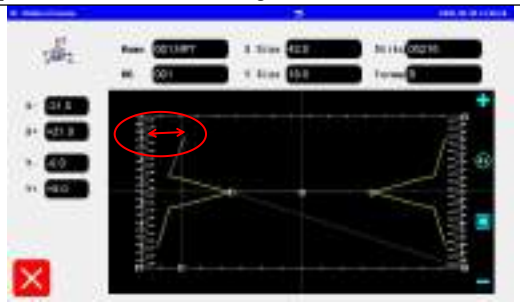


Sewing width=30

### 2.3.3 C-Upper left cutting distance in the X direction

**Definetion**:The horizontal distance from the upper-left cutting point to the sewing line,with a numberical range of 0.0-9999 mm.

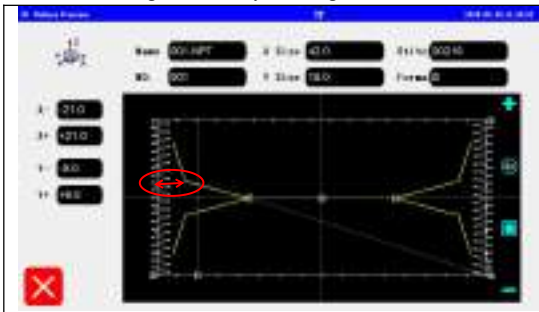
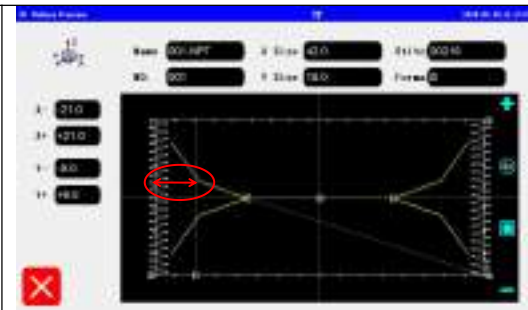
illistration:The figure below shows the effect diagram when horizontal distance for the upper-left cutting point in second stitching without a knot is set to 20 and 10,respectively.

| | |
|---|---|
|  |  |
| Cutting the top left X direction distance=10 | Cutting the top left X direction distance= 20 |

### 2.3.4 C0-Distance from cutting midpoint in the X direction

Definition: The horizontal length from the cutting midpoint to the left and right sewing threads, with a numerical range of 0.0-999.9mm.

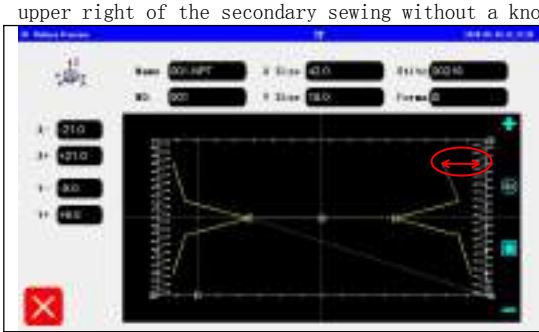
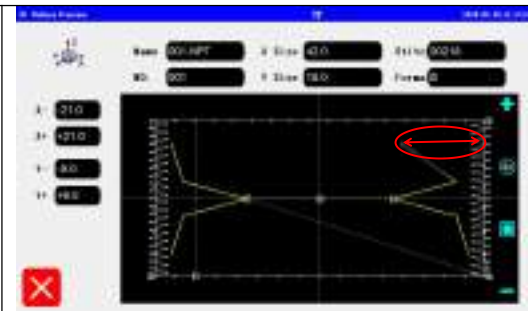
The picture shows the effect of cutting the middle point in the X direction at distances of 4 and 6 without a knot during secondary sewing.

| | |
|---|---|
|  |  |
| Cutting the middle point with a distance of 4 in the X direction | Cutting the middle point with a distance of 6 in the X direction |

### 2.3.5 C1-Upper right cutting distance in the X direction

Definition: The horizontal length from the upper right cutting point to the right sewing thread, with a numerical range of 0.0-999.9mm.

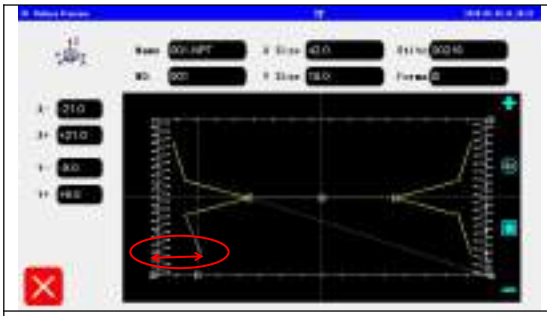
The following image shows the effect when the distance in the X direction of the cutting point on the upper right of the secondary sewing without a knot is 5 and 10.

| | |
|---|---|
|  |  |
| Cutting the top right X direction distance=5 | Cutting the top right X direction distance=10 |

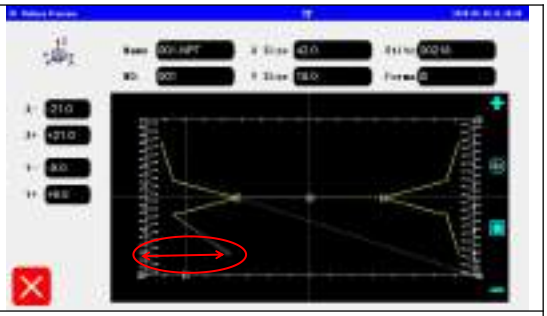
### 2.3.6 C2-Lower left cutting distance in the X direction

Definition: The horizontal length from the lower left cutting point to the left sewing thread, with a numerical range of 0.0-999.9mm.

The following image shows the effect when cutting in the X direction at distances of 5 and 10 from the bottom left without a knot during secondary sewing.



Cutting distance in the lower left X direction=5

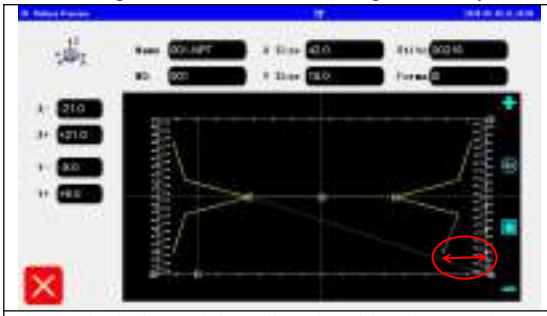


Cut the lower left X direction distance=10

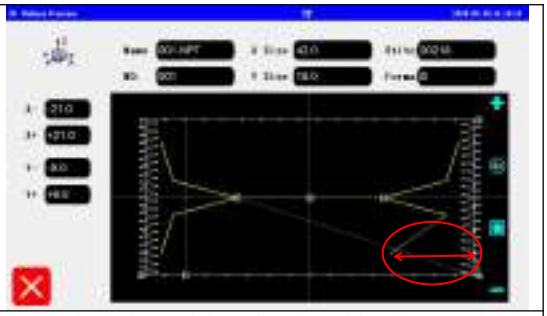
### 2.3.7 C3-X-directional distance for cutting in the lower right corner

Definition: The horizontal length from the lower right cutting point to the right sewing thread, with a numerical range of 0.0-999.9mm.

The following image shows the effect when cutting in the X direction at distances of 5 and 10 from the bottom right without a knot during secondary sewing.



Cutting in the lower right X direction with a distance of 5

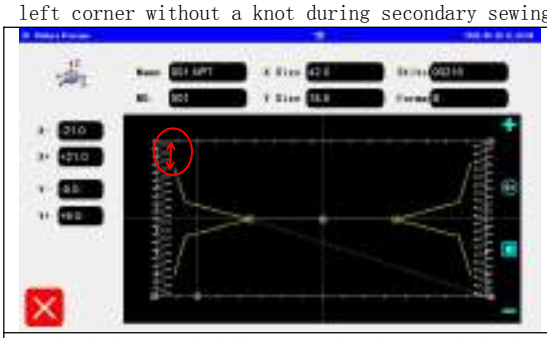


Cutting in the lower right X direction with a distance of 10

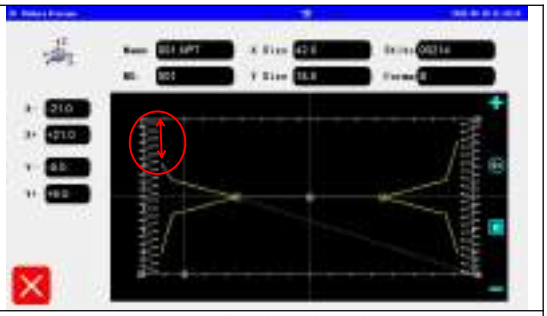
### 2.3.8 D-Upper left cutting Y-direction distance

Definition: The longitudinal length of the sewing thread from the upper left cutting point to the top, with a numerical range of -999.9-999.9mm.

The following image shows the effect when cutting in the Y direction at distances of 2 and 4 in the upper left corner without a knot during secondary sewing..



Cutting in the upper left direction with a distance of 2 in the Y direction

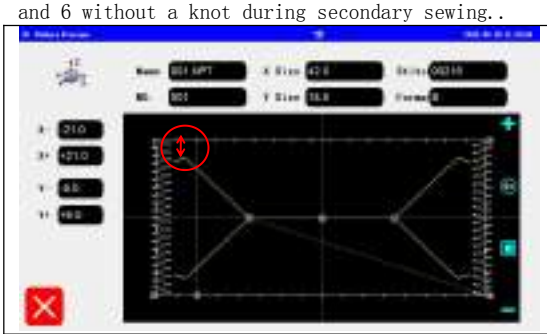


Cutting in the upper left direction with a distance of 4 in the Y direction

### 2.3.9 D0-Y-distance of cutting midpoint

Definition: The longitudinal length of the sewing thread from the cutting midpoint to the upper and lower edges, with a numerical range of 0.0-999.9mm.

The following figure shows the effect of cutting the middle point in the Y direction at distances of 2 and 6 without a knot during secondary sewing..



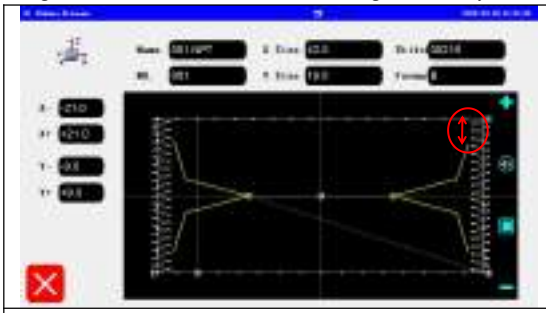
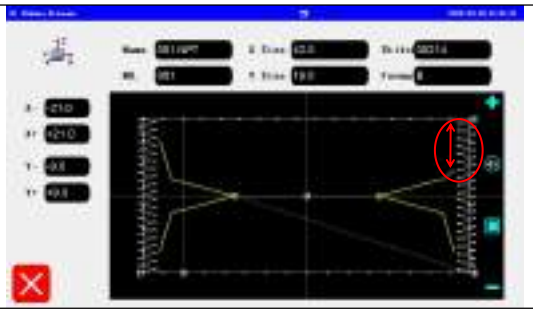
Cutting the middle point with a distance of 2 in the Y direction

Cutting the middle point with a distance of 6 in the Y direction

### 2.3.10 D1-Y-direction distance of upper right cutting

Definition: The longitudinal length of the sewing thread from the upper right cutting point to the top, with a numerical range of 0.0-999.9mm.

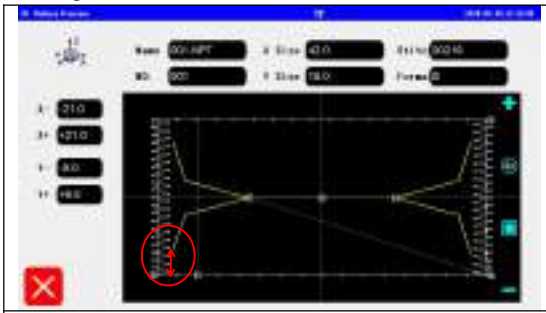
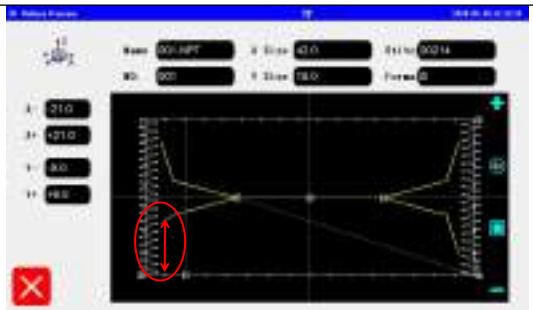
The following image shows the effect when cutting in the Y direction at distances of 2 and 5 in the upper right corner without a knot during secondary sewing.

| | |
|---|---|
|  |  |
| Cutting in the upper right direction with a distance of 2 in the Y direction | Cutting in the upper right direction with a distance of 5 in the Y direction |

### 2.3.11 D2-Bottom left cutting Y-direction distance

Definition: The longitudinal length of the sewing thread from the lower left cutting point to the bottom, with a numerical range of 0.0-999.9mm.

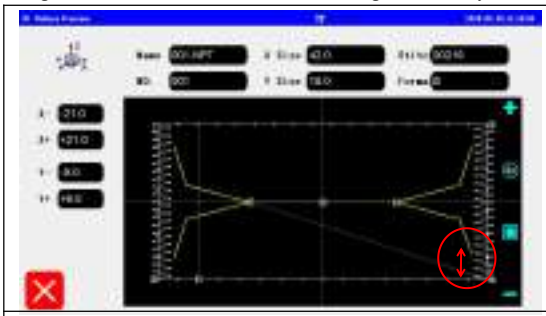
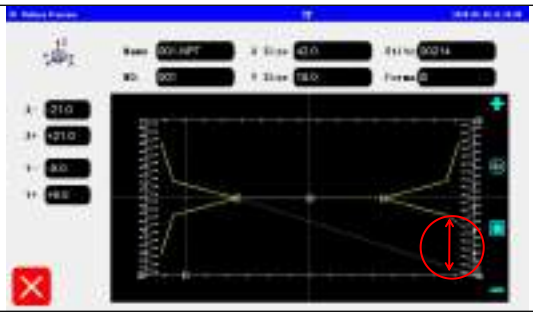
The following image shows the effect when cutting in the Y direction at distances of 2 and 5 for the second sewing without a knot..

| | |
|---|---|
|  |  |
| Bottom left cutting Y-direction distance=2 | Cutting distance in the lower left Y direction=5 |

### 2.3.12 D3-Y-direction cutting distance at the bottom right

Definition: The longitudinal length of the sewing thread from the bottom right cutting point to the bottom, with a numerical range of 0.0-999.9mm.

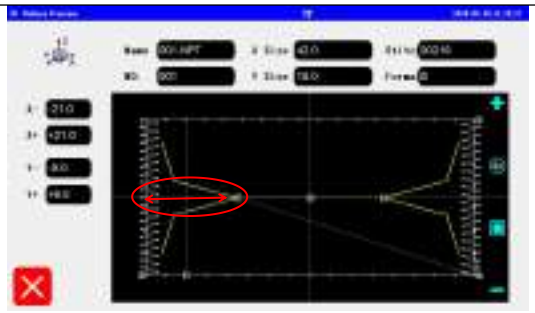
The following image shows the effect when cutting the Y-direction at distances of 2 and 5 in the lower right corner without a knot during secondary sewing.

| | |
|---|---|
|  |  |
| Cutting in the lower right direction with a distance of 2 in the Y direction | Cutting in the lower right direction with a distance of 5 in the Y direction |

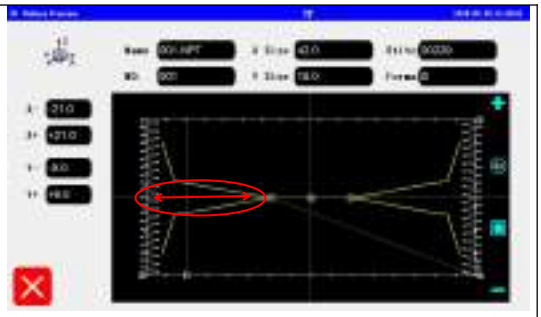
### 2.3.13 E-Starting position of E-cutting

Definition: The horizontal distance from the starting point of the cutting line to the starting points of the upper and lower sewing lines, with a numerical range of 0.0-999.9mm.

The following image shows the effect when the cutting start position is 11 and 30 for the second sewing without a knot.



Starting point of cutting centerline=11

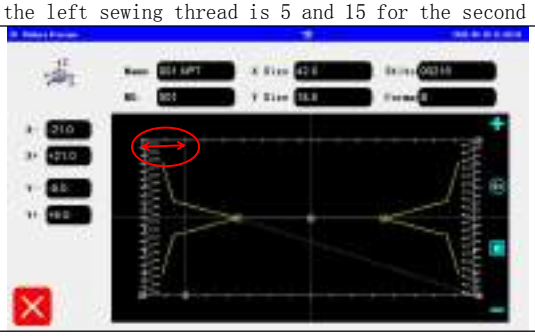


Starting point of cutting centerline=30

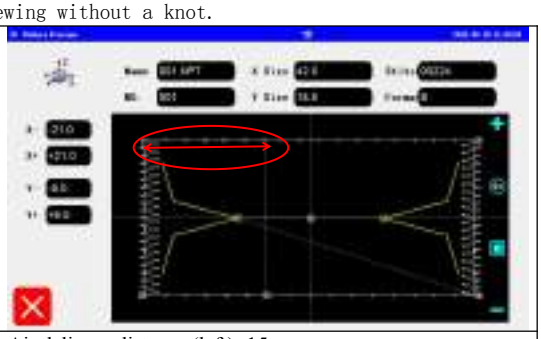
### 2.3.14 FL-Empty Left

Definition: The horizontal distance between the empty feed distance and the left sewing thread, with a numerical range of 0.0-999.9mm.

The following figure shows the effect when the horizontal distance between the empty feed distance and the left sewing thread is 5 and 15 for the second sewing without a knot.



Empty delivery distance (left)=5

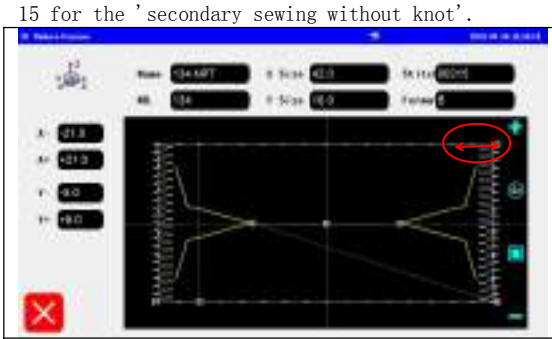


Air delivery distance (left)=15

### 2.3.15 FR-code to right distance (right)

Definition: The lateral distance from the code (side slip 2 lift) to the right, with a numerical range of 0.0-999.9mm.

The following figure shows the effect when the horizontal distance from the code to the right is 5 and 15 for the 'secondary sewing without knot'.



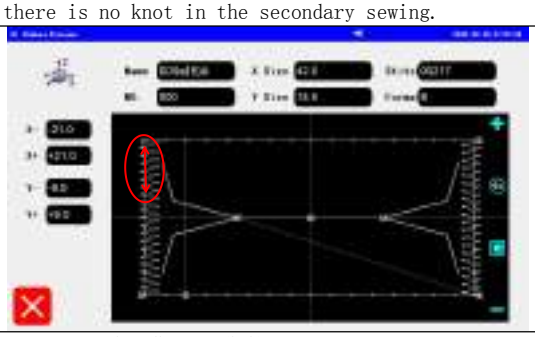
Distance from code to right (right)=5

Distance from code to right (right)=15

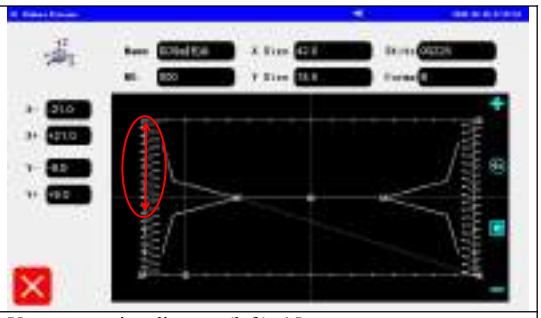
### 2.3.16 V1-Y compensation distance (left)

Definition: When sewing to the upper left corner, continue sewing downwards for a distance and then return, with a numerical range of 0.0-999.9mm.

The following figure shows the effect of Y compensation distance (left) at distances of 5 and 15 when there is no knot in the secondary sewing.



Y compensation distance (left)=5

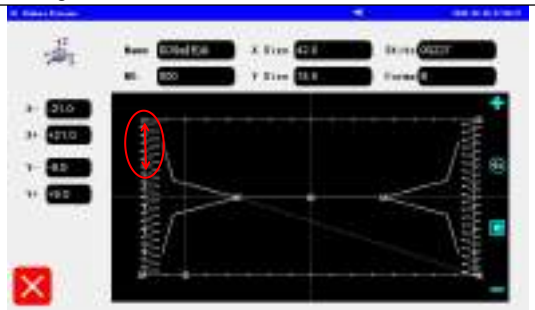
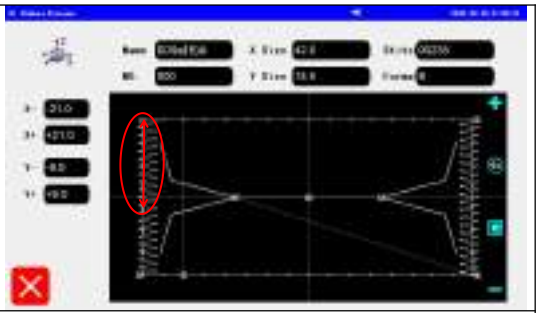


Y compensation distance (left)=15

### 2.3.17 V2-Y compensation distance (left)

Definition: When sewing to the bottom left corner, continue sewing upwards for a distance and then return, with a numerical range of 0.0-999.9mm.

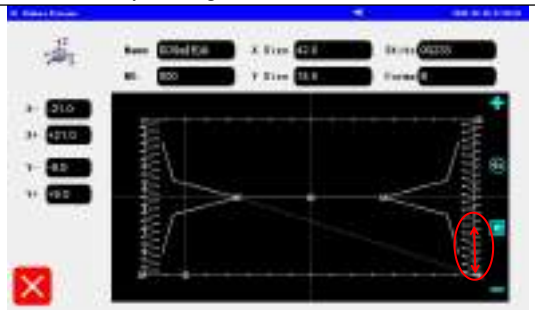
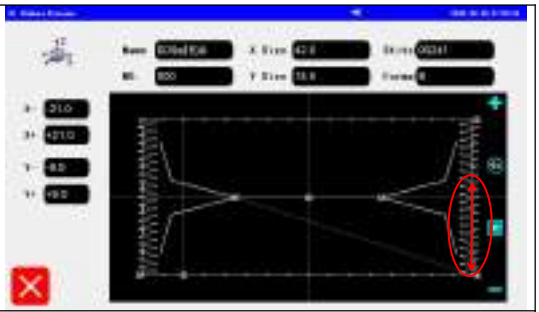
The following figure shows the effect when the Y compensation distance (left) is 5 and 15 for the second sewing without a knot.

| | |
|---|---|
|  |  |
| Y compensation distance (left)=5 | Y compensation distance (left)=15 |

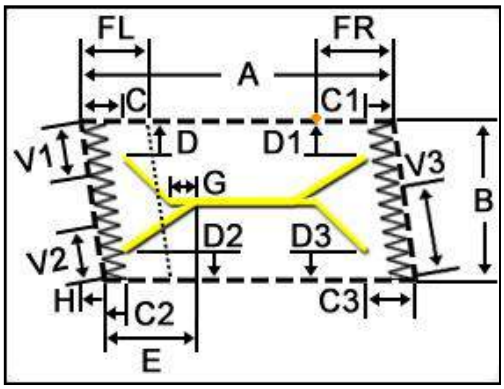
### 2.3.18 V3-Y compensation distance (right)

Definition: When sewing to the bottom right corner, continue sewing upwards for a distance and then return, with a numerical range of 0.0-999.9mm.

The following figure shows the effect when the Y compensation distance (on the right) is 5 and 15 for the secondary sewing without a knot..

| | |
|---|---|
|  |  |
| Y compensation distance (right)=5 | Y compensation distance (right)=15 |

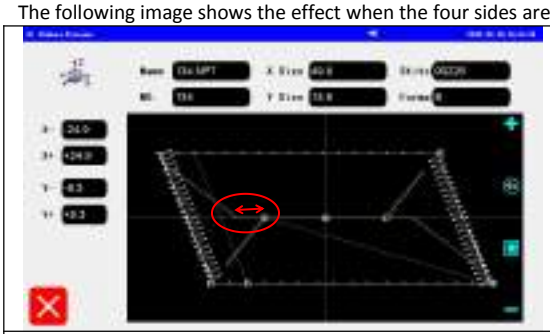
**The following is a schematic diagram of the parameters for Four Sides Sew (Left).**



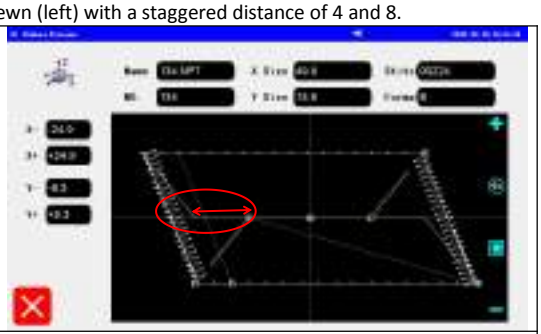

| numb | Parameter |
|---|---|
| A | Sewing length |
| B | Sewing width |
| C | X-direction distance |
| **G** | **Staggered distance** |
| C1 | X-direction distance |
| C2 | X-direction distance |
| C3 | X-direction distance |
| D | X-direction distance |
| **H** | **Bias distance** |
| D1 | Y-direction distance |
| D2 | Y-direction distance |
| D3 | Y-direction distance |
| E | Cutting starting position |
| FL | Empty delivery distance (left) |
| FR | Distance from code to right (right) |
| V1 | Y compensation distance (left) |
| V2 | Y compensation distance (left) |
| V3 | Y compensation distance (right) |

### 2.3.19 G-Staggered distance

Definition: The horizontal distance between two cutting points, with a numerical range of 0.0-999.9mm.
The following image shows the effect when the four sides are sewn (left) with a staggered distance of 4 and 8.



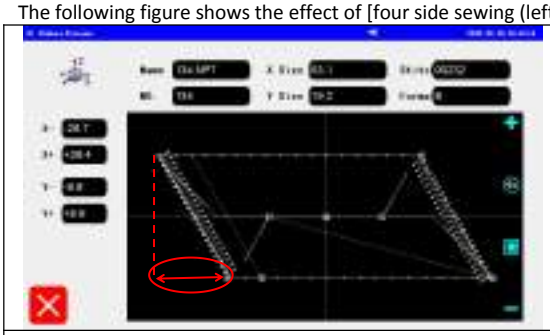
Staggered distancee=4



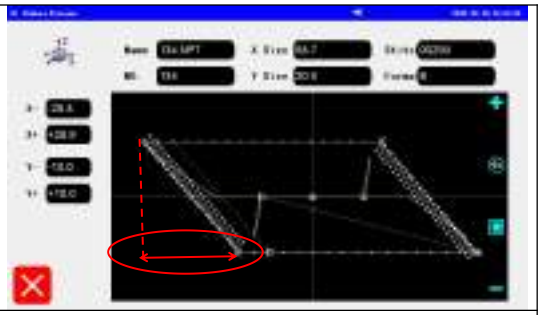
Staggered distance=8

### 2.3.20 H-Bias distance

Definition: The lateral distance offset between the upper and lower sewing threads, with a numerical range of 0.0-999.9mm.
The following figure shows the effect of [four side sewing (left)] when the tilt distance is 10 and 15.

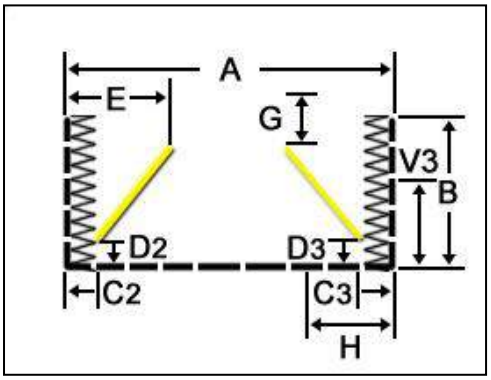


Bias distance=10



Bias distance=10

**The following is a schematic diagram of the parameters for Three Sides Sew (up).**

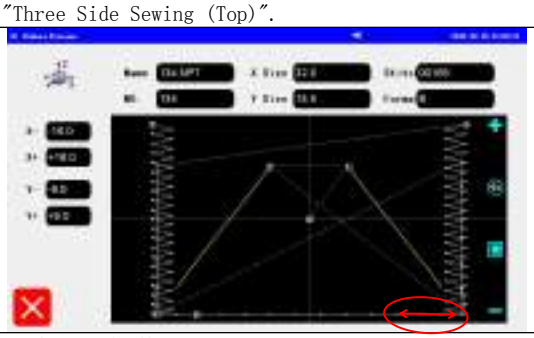



| numb | Parameter |
|---|---|
| A | Sewing length |
| B | Sewing width |
| C2 | X-direction distance |
| C3 | X-direction distance |
| D2 | Y-direction distance |
| D3 | Y-direction distance |
| E | Cutting start position |
| G | Stagger distance |
| **H** | **MH/H Speed Offset Len** |
| **V3** | **Y Compensate Above Right** |

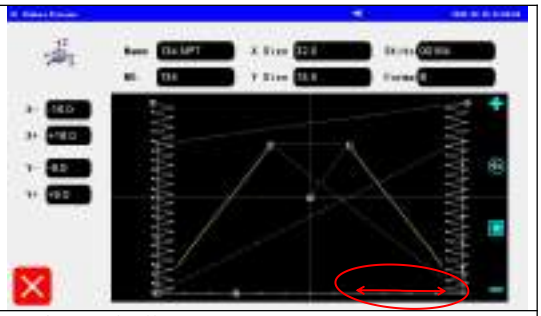
### 2.3.21 H-MH/H Speed Offset Len

Definition: The lateral distance of medium to high speed/high-speed offset, with a numerical range of 0-100mm.

The following figure shows the effect when the high-speed/high-speed offset distance is 4 and 8 in the "Three Side Sewing (Top)".



MH/H Speed Offset Len=4

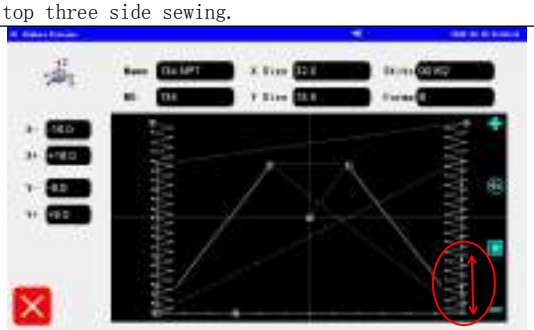


MH/H Speed Offset Len=8

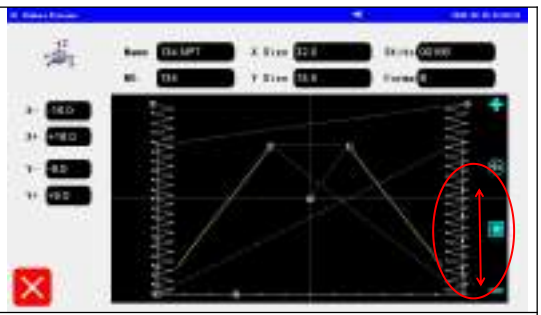
### 2.3.22 V3-Y Compensate Above Right

Definition: The longitudinal distance under Y compensation distance (right), with a numerical range of 0-100mm.

The following figure shows the effect when the compensation distance is 5 and 10 respectively for the top three side sewing.

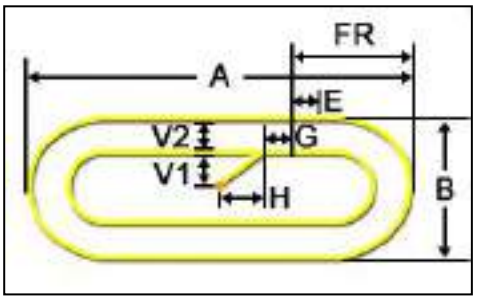


Y Compensate Above Right=5



Y Compensate Above Right=10

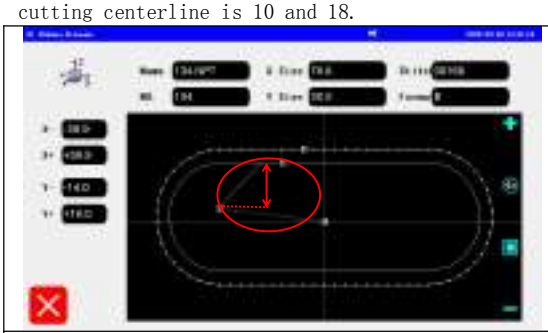
**The figure is a schematic diagram of the parameters of Seamless seal Glue (Semi-Circule).**



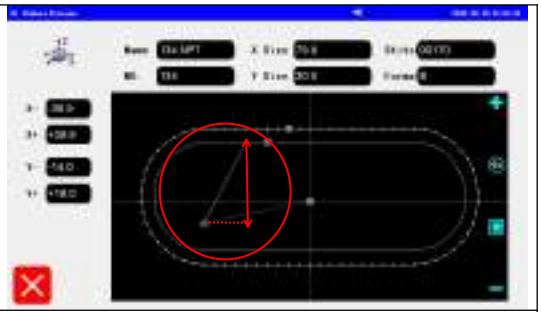

| numb | Parameter |
|---|---|
| A | Sewing length |
| B | Sewing width |
| G | Laser end point offset Len |
| H | Laser point off Ring width |
| E | Sew end point offset Len |
| FR | Laser End Point To Right Len |
| **V1** | **Laser Point To Ring Hight** |
| **V2** | **Two Ring Len** |

### 2.3.23 V1-Laser Point To Ring Hight

Definition: The height of the laser point from the ring, with a numerical range of 0.0-999.9mm.
The following figure shows the effect of seamless sealing (semi-circular) when the starting point of the cutting centerline is 10 and 18.



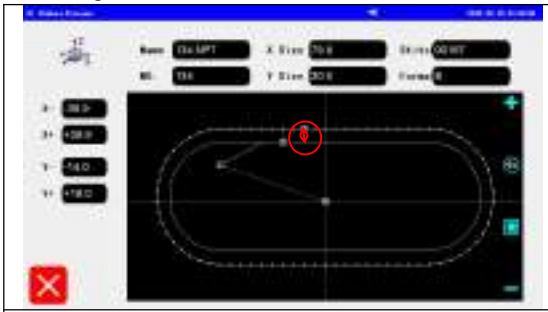
Laser point to ring height=10



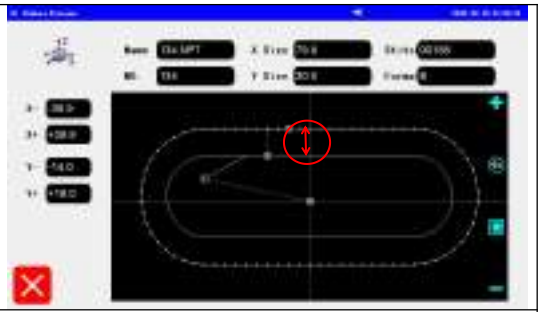
Laser point to ring height=18

### 2.3.24 V2-Two Ring Len

Definition: The longitudinal distance between the laser ring and the sewing ring, with a numerical range of 0.0-999.9mm.
The following figure shows the effect of seamless sealing (semi-circular) when the distance between the two rings is 3 and 6.

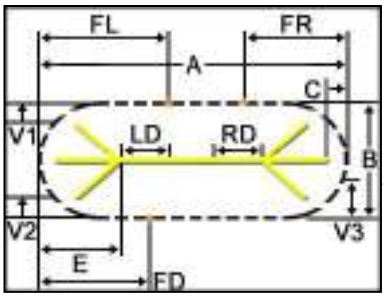


Distance between two rings=3



Distance between two rings=6

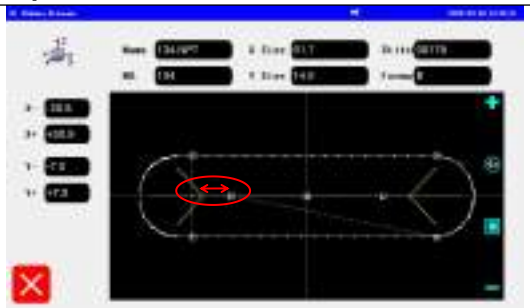
**The figure is a schematic diagram of the parameters for Circle Twice Sew.**



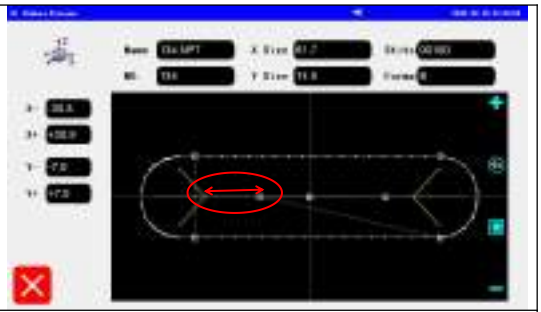

| number | Parameter |
|---|---|
| A | Sewing length |
| B | Sewing width |
| C | X-direction distance |
| FD | Code To Left Down Len |
| **LD** | **Laser End Point To Left Len** |
| **RD** | **Laser End Point To Right Len** |
| E | Cutting Start Position |
| FL | Code To Left Len |
| FR | Code To Right Len |
| V1 | Y Compensate Above Left |
| V2 | Y Compensate Above Left |
| V3 | Y Compensate Above Right |

### 2.3.25 LD-Laser End Point To Left Len

Definition: The lateral distance of the end point of the left laser, with a numerical range of 0-100mm. The following figure shows the effect of secondary sewing of a circle when the distance between the laser endpoint on the left end is 5 and 10.



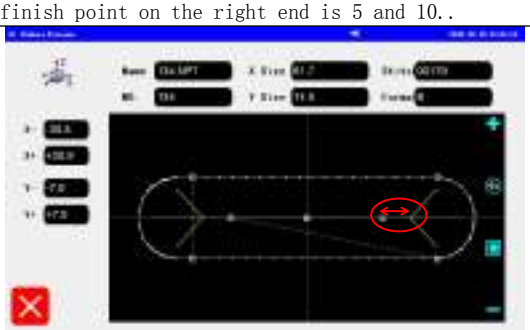
Left end laser endpoint distance=5



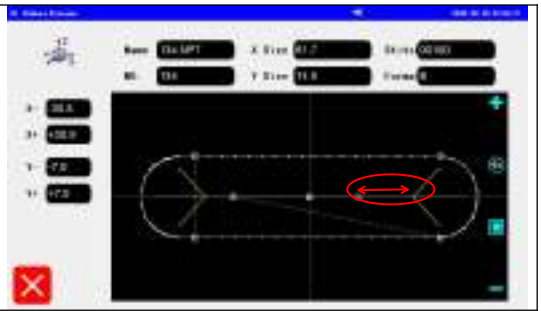
Left end laser endpoint distance=10

### 2.3.26 RD -Laser End Point To Right Len

Definition: The lateral distance from the end point of the right laser, with a numerical range of 0-100mm. The following figure shows the effect of secondary sewing of a circle when the distance between the laser finish point on the right end is 5 and 10..

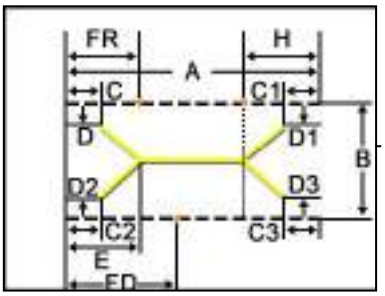


Right end laser endpoint distance=5



Right end laser endpoint distance=10

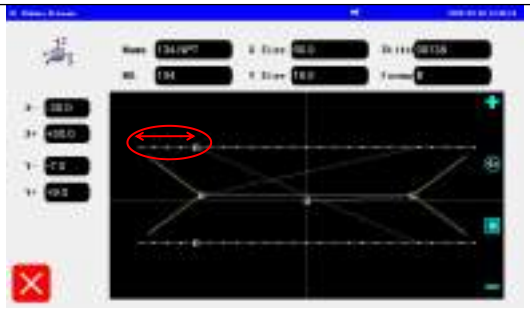
**The figure is a schematic diagram of the parameters for Common Mode Dark-line.**




| numb | Parameter |
|---|---|
| A | Sewing length |
| B | Sewing width |
| C | X-direction distance |
| C1 | X-direction distance |
| C2 | X-direction distance |
| C3 | X-direction distance |
| D | Y-direction distance |
| D1 | Y-direction distance |
| D2 | Y-direction distance |
| D3 | Y-direction distance |
| E | Cutting start position |
| H | Start Stitch Offset Len (right) |
| **FR** | **Code To Left Len** |
| **FD** | **Code To Left Down Len** |

### 2.3.27 FR-Code To Left Len

Definition: The horizontal distance from the code to the left (left), with a numerical range of 0-100mm.
The following figure shows the effect of the 'Normal Mode Dark Line' code when the distance to the left (left) is 10 and 20.

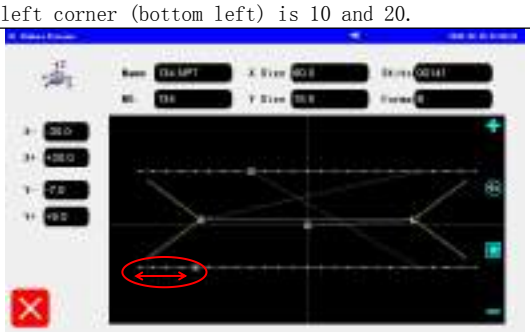


Distance from code to left (left)=10

Distance from code to left (left)=20

### 2.3.28 FD-Code To Left Down Len

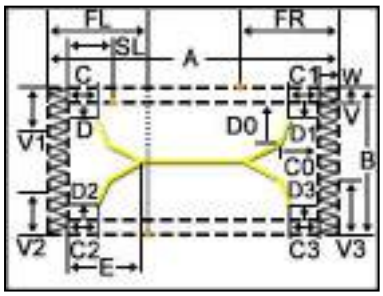
Definition: The horizontal distance from the code to the bottom left corner (bottom left), with a numerical range of 0-100mm.
The following figure shows the effect of the 'Normal Mode Dark Line' code when the distance from the bottom left corner (bottom left) is 10 and 20.



Distance from code to bottom left (bottom left)=10

Distance from code to bottom left (bottom left)=20

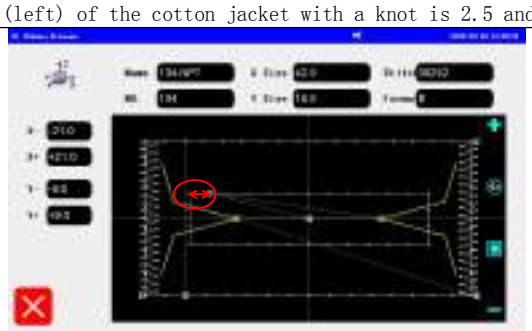
**The figure is a schematic diagram of the parameters for Cotton Clothes Twice Sew Have knot.**



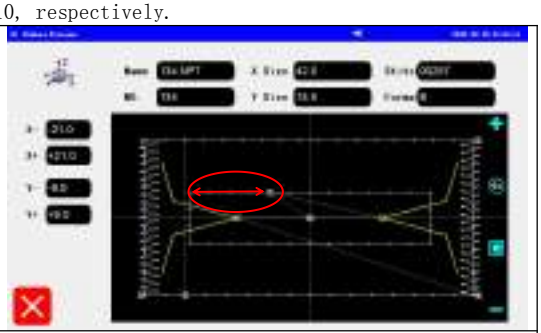

| num | Parameter | numb | Parameter |
|---|---|---|---|
| A | Sewing length | D3 | Y-direction |
| B | Sewing width | E | Cutting start |
| C | X-direction distance | FL | Code To left Len |
| C0 | X-direction distance | FR | Code To Right Len |
| C1 | X-direction distance | V1 | Y Compensate Above Left |
| C2 | X-direction distance | V2 | Y Compensate Above Left |
| C3 | X-direction distance | V3 | Y Compensate Above Right |
| D | Y-direction distance | **SL** | **sew point to left Len** |
| D0 | Y-direction distance | **W** | **Sew width space(rightup)** |
| D1 | Y-direction distance | | |
| D2 | Y-direction distance | **V** | **Sew width space(rightup)** |
| | | | |

### 2.3.29 SL-sew point to left Len (left)

Definition: The horizontal distance from the sewing point to the left end (left), with a numerical range of 0-100mm. The following image shows the effect when the distance from the sewing point to the left end (left) of the cotton jacket with a knot is 2.5 and 10, respectively.



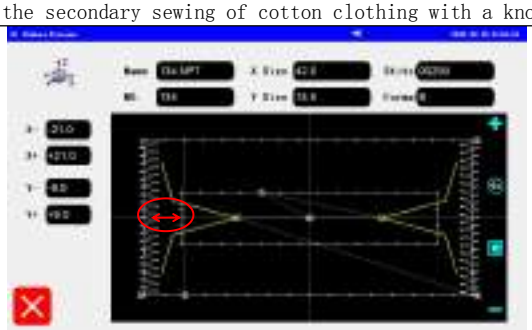
Sewing point to left end distance (left)=2.5



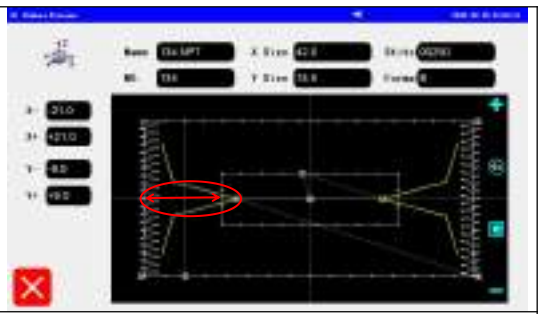
Sewing point to left end distance (left)=10

### 2.3.30 W-Sew width space(rightup)

Definition: The horizontal distance of the sewing width interval (top right), with a numerical range of 0-100mm. The following image shows the effect when the starting point of the cutting line is 5 and 10 for the secondary sewing of cotton clothing with a knot.



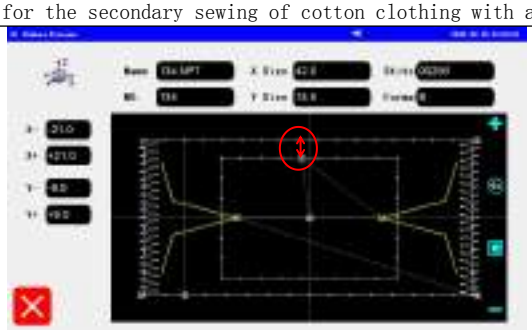
Sewing width interval (top right)=5



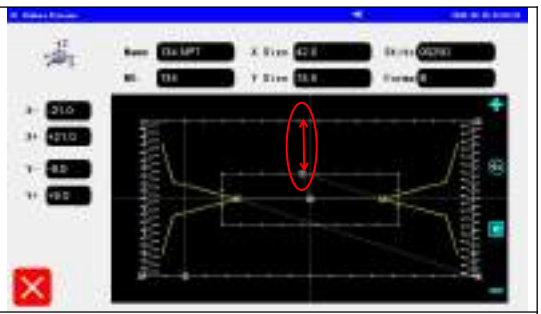
Sewing width interval (top right)=10

### 2.3.31 V-Sew width space(rightup)

Definition: The longitudinal distance of the sewing height interval (top right), with a numerical range of 0-100mm. The following image shows the effect when the starting point of the cutting line is 2 and 6 for the secondary sewing of cotton clothing with a knot..

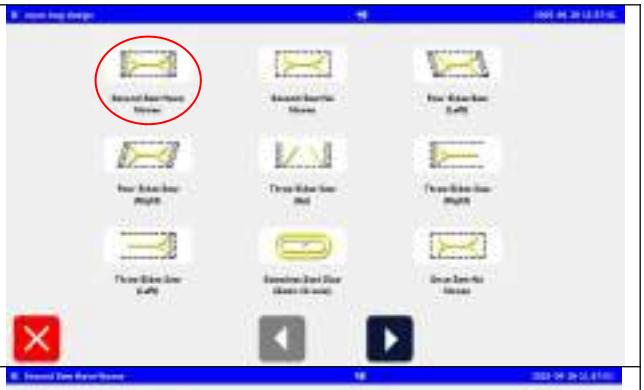
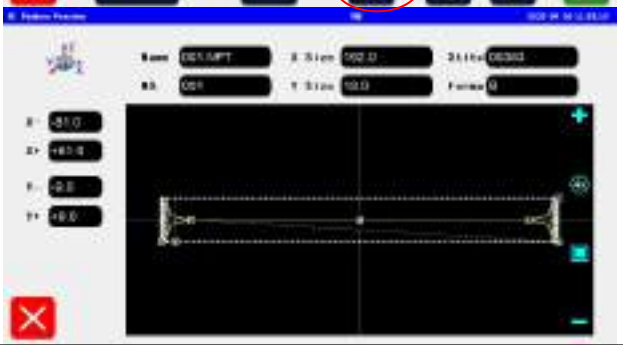


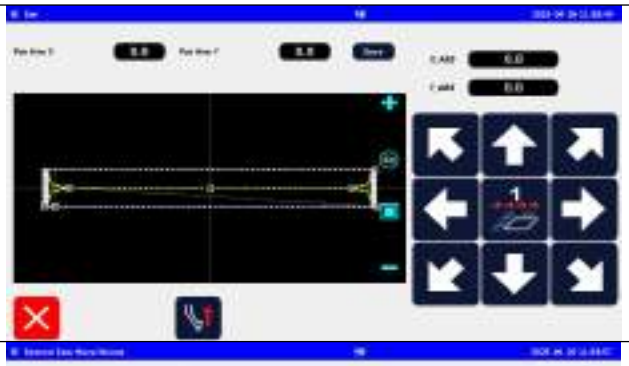
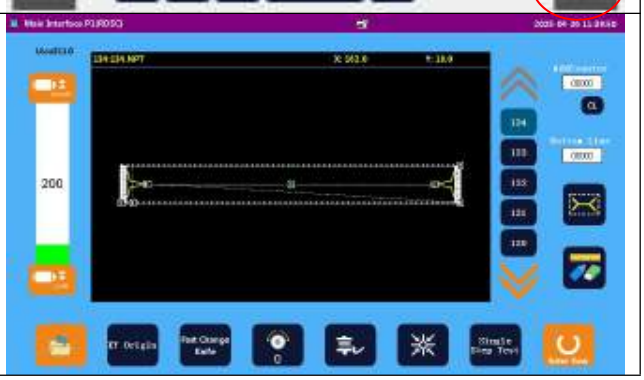
Sewing height interval (top right)=2



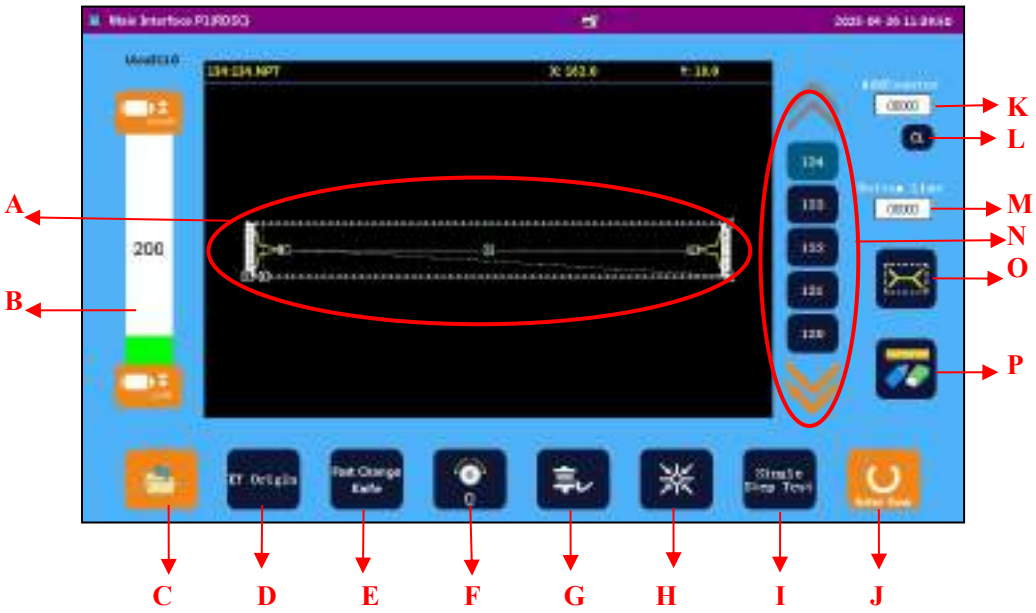
Sewing height interval (top right)=6

## 2.4 Operation Demonstration

| | |
|---|---|
| 1. Select the corresponding bag opening template. |  |
| 2. Set corresponding values for needle spacing, length, width, etc. Use the page turning button to modify other data items. |  |
| 3. Click the preview button to enter the graphic preview interface.<br>Click to exit. |  <br>  |
| 4. Click on Settings and adjust the XY position value of the pattern alignment point through the steering wheel. |  |

| | |
|---|---|
| |  |
| 5. Click OK to save the pattern. |  |
| 6. Click OK. |  |
| 7. Set the name and number, click OK. |  |
| 8. The figure is shown on the right. |  |

# Chapter 3 Setting Functions Related to Pattern Making Styles

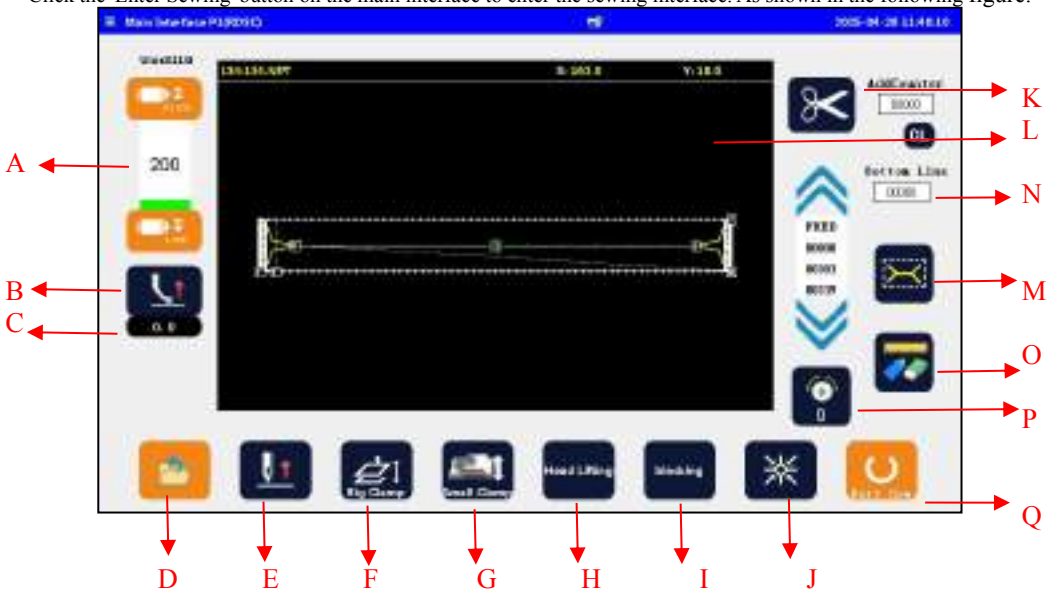



**Main interface function description:**

| Serial | function | content |
|---|---|---|
| A | content | Display the current pattern |
| B | pattern | Adjust sewing speed |
| C | speed | Enter the Menu mode |
| D | menu | Enter the XY origin detection interface |
| E | XY origin detection | Return to origin function |
| F | Quick tool change | Enter the tension adjustment line interface |
| G | Winding mode | Enter the winding mode to set the winding core speed |
| H | home | Return to the origin |
| I | single stepping test | Enter the single step testing interface |
| J | Enter sewing | Enter the sewing interface |
| K | Processing Count | Set the processing count value |
| L | clean up | Quick Clear Key |
| M | Bottom line count | Set the baseline count value |
| N | Pattern number | Switching patterns |
| O | Shortcut Key - Bag Opening | Enter the quick printing interface for bag opening design, |
| P | Shortcut Key - Pattern | Enter pattern modification mode |

## 3.1 Sewing Interface

Click the 'Enter Sewing' button on the main interface to enter the sewing interface. As shown in the following figure.




**Function Description:**

| Serial | function | content |
|---|---|---|
| A | speed | Adjuest sewing speed |
| B | Medium pressure foot | Lift presser foot /Lower presser foot |
| C | Medium pressure foot | Display press foot height numbericaly |
| D | menu | Enter menu mode |
| E | Needle machine | Raise needle/Lower needle |
| F | Large pressure plate | Lower press plate/Life press plate |
| G | Small pressure plate | Lower small press foot/Life height numerically |
| H | Head lifting and lowering | Raise needle/Lower needle |
| I | cutting | Perform material discharge action |
| J | home | Perform return to origin action |
| K | trim | Perform thread cutting action |
| L | pattern | Display current sewing pattern |
| M | Shortcut Key - Bag Opening | Enter quick pattern making interface for pocket design, set |
| N | Bottom line count | Set stitch count value |
| O | Shortcut Key - Pattern | Enter pattern modfification mode |
| P | Set line tension | Entert thread tension tension adjustment interfac |
| Q | Exit sewing | Return to main interface P1 |

## 3.2 Menu Mode

Click the 'Menu' button on the main interface to enter menu mode.

## 3.3 XY Setp Motor Test

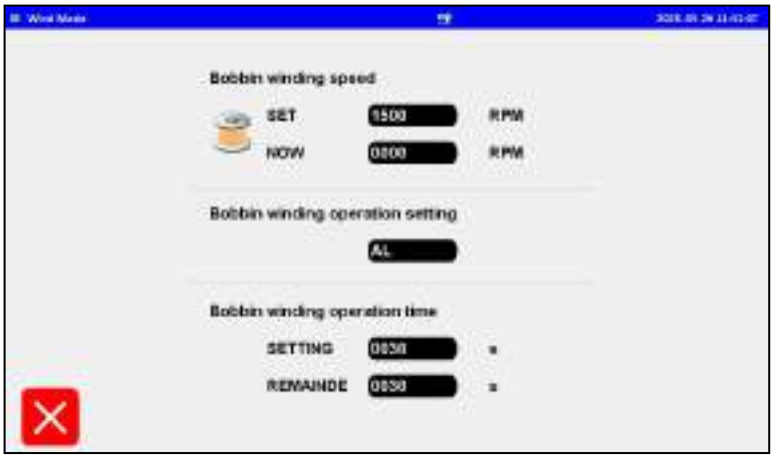
Click the "XY setp motor test" button on the main interface to enter the XY Origin Tset interface.


## 3.4 Changing Needle Thread Tension

Click the "Changing Needle Thread Tension" button on the main interface to enter the setting line tension interface.

## 3.5 Wind Mode

Click the 'Wind Mode' button on the main interface to enter the winding mode interface.




## 3.6 Single Stepping Test

Click the 'Single Stepping Test' button on the main interface to enter the single step test interface.


## 3.7 Opening-bag Design

Click the shortcut key 'Opening-bag design' on the main interface to enter the bag opening design interface.

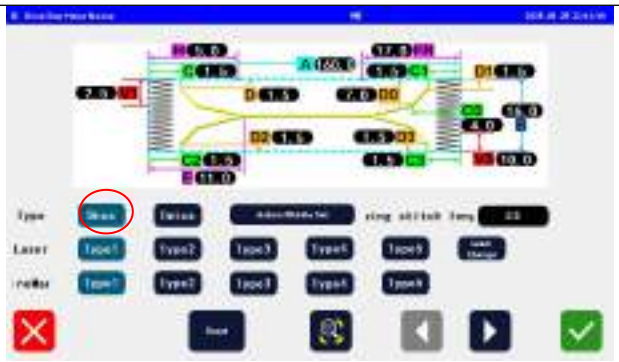
## 3.8 Modification Mode

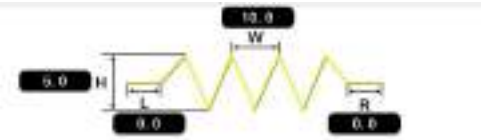
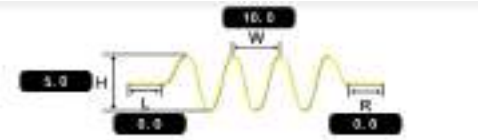
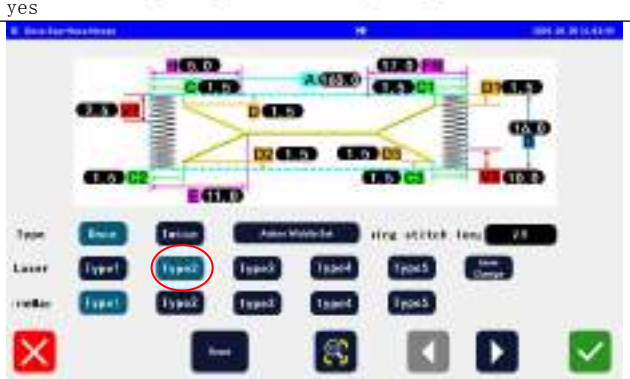
Click the 'Modification Mode' button on the main interface to enter the modification mode interface.

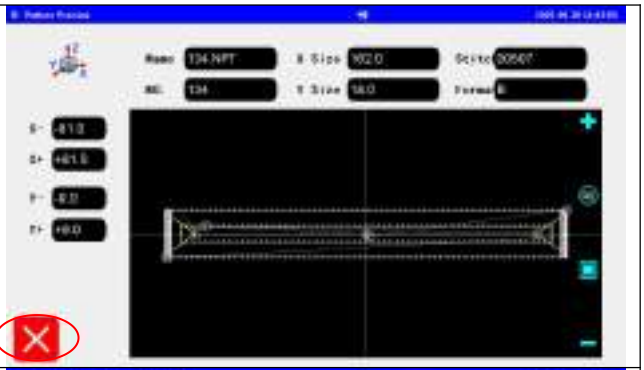
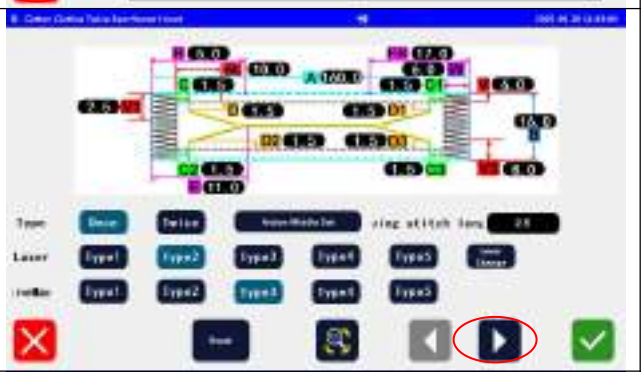
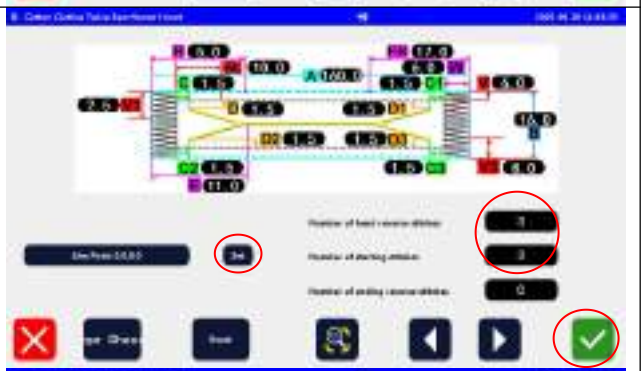

Explanation of Example Image Numbering

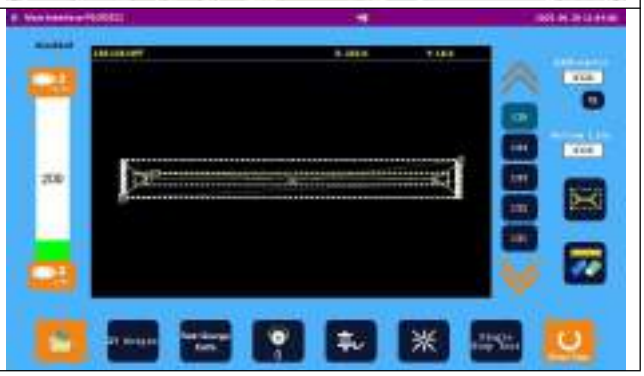
| number | Content |
|---|---|
| A | Represents the lenght o fthe pocket |
| B | Represents the width of the pocket |
| C | Distance between the laser and the width edge of the fabric;The large the value , the farther laser is from fabric |
| D | Distance between the laser and the upper/lower edges of the fabric. |
| E | Cutting start postion |
| FR | Distance from the code to the right edge |
| H | Distance from the code to the right edge |
| V | Distance between the laser and the long edge of the fabric;<br>the larger the value,the farther the laser is from the fabric |

Operation Demonstration:

| | |
|---|---|
| 1、Select the number of laser operations as single. |  |

| | |
|---|---|
| 2、Set the laser stitching shape to straight line<br>The intermediate laser stitching shape can be set to three types: Strapight line ,herringbone stitch, and S-shpaed |  <br>line<br>  <br>zig<br>  <br>yes |
| 3、Select the laser type as Type2. |  |
| 4、Select the stitch type as Type3.Click Preview |  |

| | |
|---|---|
| 5、Enter the graphic preview interface Click Exit. |  |
| 6、Enter the graphic preview interface Click Exit. |  |
| 7、You can set graphic data, such as setting the backstition count 3 and starting stitch count to 3.Click Confirm.<br><br>8、Click Setting, and use the directional pad to adjust the pattern alignment to the target XY postion. |  <br>  |
| 9、Click Confirm. |  |

| | |
|---|---|
| 10、Set the name and number,and click Confirm . |  |
| 11、The graphic is shown as in the right. |  |

## 3.9 Up Counter Set

Click the [Up Counter Set] button on the main interface to enter the counter settings interface.


## 3.10 Line Counter Set

Click the [Line Counter Set] button on the main interface to enter the counter settings interface.


**Included:**

1Production cunt current set value(total count) setting.

2.Production count current value setting.

3.Counter function on/off button.

4.Clear current value button ,witch resets the current count to zero.

**Set Target Count:**In the settings area,input the requied target count value to ensure it meets production requiements.

**Click Confirm Button:**The system will start counting the oriduction data during the production process.

# Chapter 4 Device Detect

**Intertface Function Description:**

**1.Enter the Device Test Interface**

Function Descrption:Users can enter the deive test interface via the device test dectection button in the menu.

**2.Led Detection**

Function Description:Start or stop the screen detection function and set the detection time.

**3.Panel Detection**

Function Description:Users can enter the touchscreen detection

**4.Input Detection、Output Detection**

Function Description:

This function is used to detect the status of input and output signals to ensure the system receives correct signals.

Usage Steps:

1.1 Find the input and output signal detecion button in the device test interface.

1.2 Click this button to start the input signal.

1.3 Observe the signal status displayed on the interface to confirm whether the signal is normal.

**Function Description：**

This function is used to detect the status of the input or ourput signal to ensure the system receives the correct signal.

**Usage Steps：**

1.1Find the input signal test button in the device test interface.

1.2Clikc the button start the input signal test.

1.3Observe the signal status displayed on the interface to confirm whether the signal is nor

**5.XY Step Motor Test**

Can be used to debug the psotion of XY axis clicks and switches.

**6.Servo Test**

This function is used to detect the spindle angel detecion,ensuring that spindle operates within a normal range.

**7.Servo Angle Detection**

Function Decripation:This function is used to detect the spindle operates within the normal range.

**8.Continous Run Detetion**

Function Description: Adjust the action interval time ,the number of material-revceing origin detections,the number of cycles,etc.

**9.Laser Offset**

Function Description:Adjust the laser coordinates and needle coordinates ,set the off set amount.

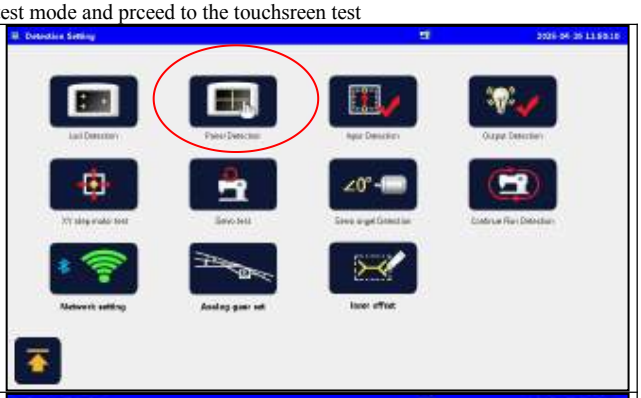
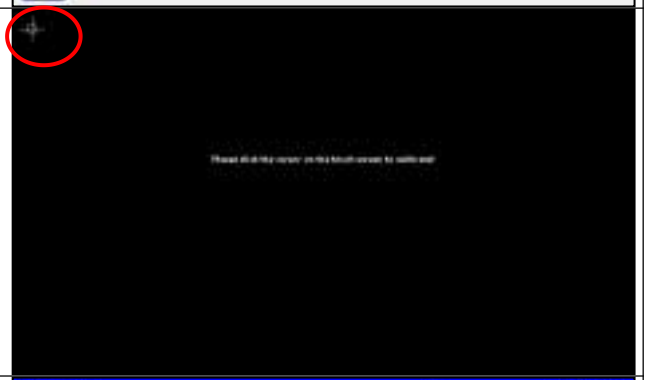
## 4.1 Led Detection

Click the [Port test] button in the menu to enter the test mode.

| | |
|---|---|
| 1、Click the "LCD Test" button. |  |
| 2、Enter the screen test interface and select "Screen Test" |  |
| 3、Set the screen test interval time. |  |
| 4、Click “Stat test” |  |

## 4.2 Panel Detection

Click the [Port Test] button in the menu to enter the test mode and prceed to the touchsreen test

| | |
|---|---|
| 1、Click the "Touchscreen Test" button |  |
| 2、Press he Enter key to confirm |  |
| 3、Follow the cursor and click to calibrate step by step. |  |
| 4、Finally ,return to the "Test Mode" interface. |  |

## 4.3 Input Detection

Click the [input Signal Test] button to enter the input signal test interface.This allows you to click the communication control signals
(ON/OFF).The interface includes the following content as show in the figure below

**Precautions**

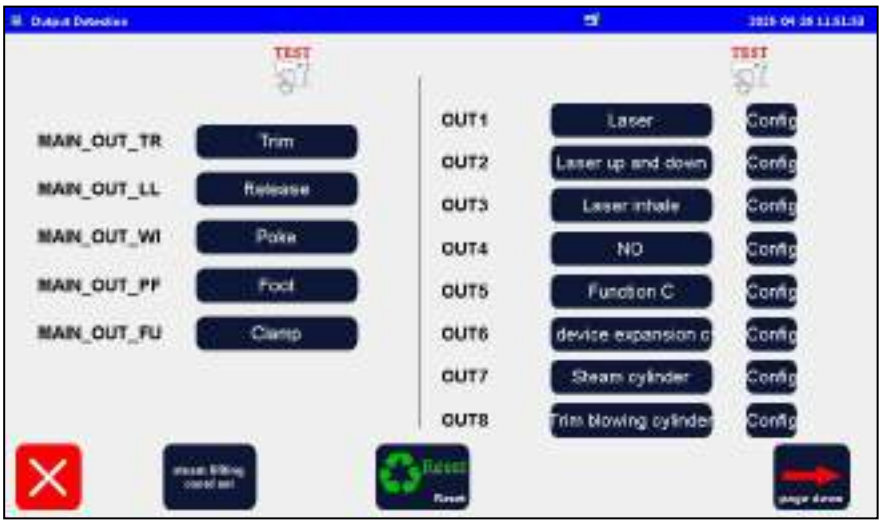
Before performing any operations,ensure that the mechanical device is correctly installed and connected to avoid errors caussed by improper connections.During operation,pay attrion to safety,avoid moving parts to prevent accidental injury.


## 4.4 Output Detection

Click the [Output Singal Test] button to enter the output sinal test interface.
This allows you to Check the communication control signals(OFF/ON).The interface following content as shown in the figure below.

**Precautions**

Before performing any operations,ensure that the mechanical device is correctly installed and connected to avoid errors caussed by improper connections.During operation,pay attrion to safety,avoid moving parts to prevent accidental injury.



## 4.5 XY Step Motor Test


Click the XY stepper motor detection button to enter the XY stepper motor detection interface. On this interface, you can adjust the XY axis click position and switch.

## 4.6 Servo Test


Click the [Servo Motor Detection] button to enter the main spindle speed detection interface.
in this interface,You can perform debugging of the main speed.As shown in the figure:

1.**Display Actual Speed:**Displays the current actual speed of the main spindle(RPM)

2.**Set Speed:**Allows input or button press to reach the target speed.

3.**Control Buttons:**Start,stop ,reset ,and other basic opration buttons.

4.**Alarm:**If the set safety range is exceeded,an alarm message will be displayed.

5.**Adjust and Optimize:**If adjustments to the main spindle speed are needed,you can reset the target value.

## 4.7 Servo Angle Detection


Click the [Main Speedle angel Detection] button to enter the main spindle motor installation angle calibrate interface.In this interface ,you can perform
spindle motor debugging.The interface is shown in the figure below.

1.Before adjustment,ensure necessary safety measures are taken.Install sensor correctyly onto the main spindle and reference point,ensuring they are secure and positioned correctly.Open the interface and complete the initialization settings.

2. In the interface ,locate the "Main Spindle Motor Release/Lock" button.Clicking this button allows the motor to be a released or locked state,enabling free movement for adjustment.

3..Perform messurements by roatating the main spindle to a certain angle ,read multiple positions to the collect data,calibrate the current deviation ,and display it on the interface.

4.After adjusting to the desired postion,locate the "Main Spindle Motor Lock" After adjusting to the desired postion,locate the "Main Spindle Motor Lock"

5.button in the software interface to prevent parametes are within the allowable tolerace range.

6.Final verification:Perform a complete measurement again to ensure all parameters are within the allowable tolerace range.

## 4.8 Continous Run Detetion


Click the 'Continuous Operation Detection' button to enter the continuous operation detection interface. Adjust the action interval time, the number of material receiving origin detections, the number of cycles, etc.

# Chapter 5 System Upgrade and Function Settings

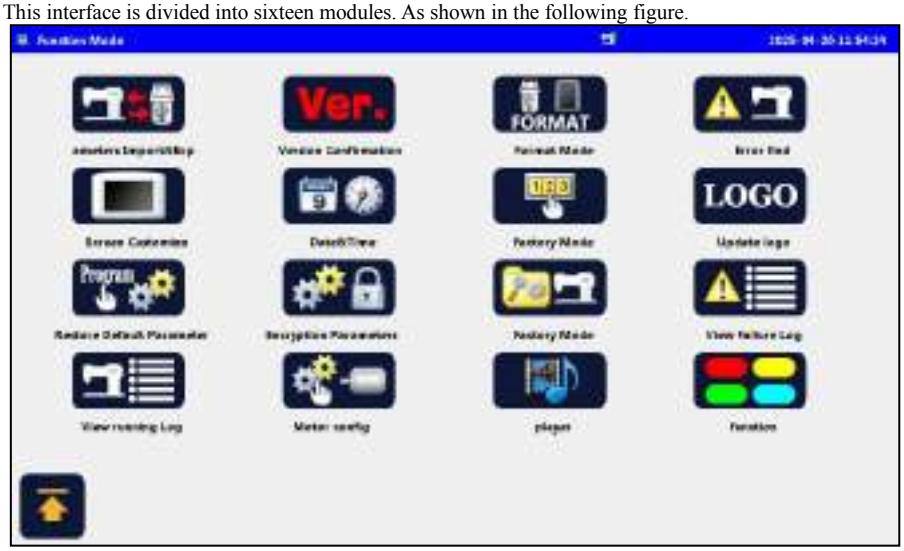
## 5.1 System Upgrade

Click the [System & Upgrade]button in the motor debugging interface ,then click the [Upgrade] button to enter the firmware version mode interface. This interface is used to view the version numbers of the control system,such as the main contriller ,panel,manufcturer logo,and stepper motor versions.


1.**Version Upgrade**:Locate the upgrade file on the USB drive.The system will prompt you to install the update.Click the [One-Click Upgrade] button to start the upgrade proess.Do not turn off the power during the upgrade.After the upgrade is complete,a prompt box will appear.Turn off and restart the power, then wait patiently.After restarting ,check if the new version functions properly to ensure ererything is running smoothy.
2.**Error Handing**:If an upgrade occurs or you need to a pervious version.click the top-left corner upon startup to enter the settings interface and modify the system version.If you encounter error messages,try restating the settings and performing the upgrade again.
**3.System Restore:**Click the[one-Click Restore] button to enter the system restore interface.You can restore interface.You can restore all parameters or select specific parameters to restore.The system will revert to the initial default settings.After restoration is complete,a prompt box will appear.Turn off and restart the power.
**4.**T**robleshooting:**If the upgrade issue persists,contact the company's technical support team.Plese problem
and any solutions you have already tried to help the technicial support team.Please provide a detailed
description of the problem and any solutions you have already tried to help the technicians understand the situation better and offer
assistance.

## 5.2 Function Mode

Click on the [System and Upgrade] ->[Function Settings] button on the motor debugging interface to enter the function mode interface. This interface is divided into sixteen modules. As shown in the following figure.



# Chapter 6 Reserved Para

## 6.1 Reserved Parameter Operation

**Operation steps:**

| | |
|---|---|
| 1. Click on the menu. |  |
| 2. Enter parameter settings. |  |
| 3. Scroll to the last page and click on the reserved parameters. |  |
| 4. Modify parameters. |  |

## 6.2 Parameter Introduction

Reserved Parameters Page 1:


| Serial Number | parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | External pressure frame drop delay | 30 | Range: 0-30000 |
| 2 | External pressure frame drop lift delay | 400 | Range: 0-30000 |
| 3 | internal pressure frame lifting delay | 1600 | Range: 0-30000 |
| 4 | Inner pressure frame drop delay | 350 | Range: 0-30000 |
| 5 | Lifting cylinder 1 cylinder extension delay time | 350 | Range: 0-30000 |
| 6 | Lifting cylinder 1 cylinder retracting delay time | 280 | Range: 0-30000 |
| 7 | Side sliding telescopic extension delay | 150 | Range: 0-30000 |

Reserved Parameters Page 2:


| Serial Number | parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | Side slip retraction delay | 100 | Range: 0-30000 |
| 2 | External pressure frame fixed material open delay | 150 | Range: 0-30000 |
| 3 | External pressure frame fixed material closing delay | 0 | Range: 0-30000 |
| 4 | The lifting delay of the discharging lifting plate 1 | 400 | Range: 0-30000 |
| 5 | Is the feeding and lifting plate used | Used | Used/Not used |
| 6 | Feeding tray rise and fall open delay | 250 | Range: 0-30000 |
| 7 | Feeding tray rise and fall close delay | 200 | Range: 0-30000 |

Reserved Parameters Page 3:


| Serial Number | parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | Delay after front and back fold knife is insert | 170 | Range: 0-30000 |
| 2 | Delay after front and back fold knife is retracted | 170 | Range: 0-30000 |
| 3 | Delay after front and back fold knives are lowered | 160 | Range: 0-30000 |
| 4 | Delay after front and back fold knives rise | 160 | Range: 0-30000 |
| 5 | Feeding tray clamp delay | 250 | Range: 0-30000 |
| 6 | Feeding tray return delay | 200 | Range: 0-30000 |
| 7 | Left and right folded material 1 sandwiched in delay | 160 | Range: 0-30000 |

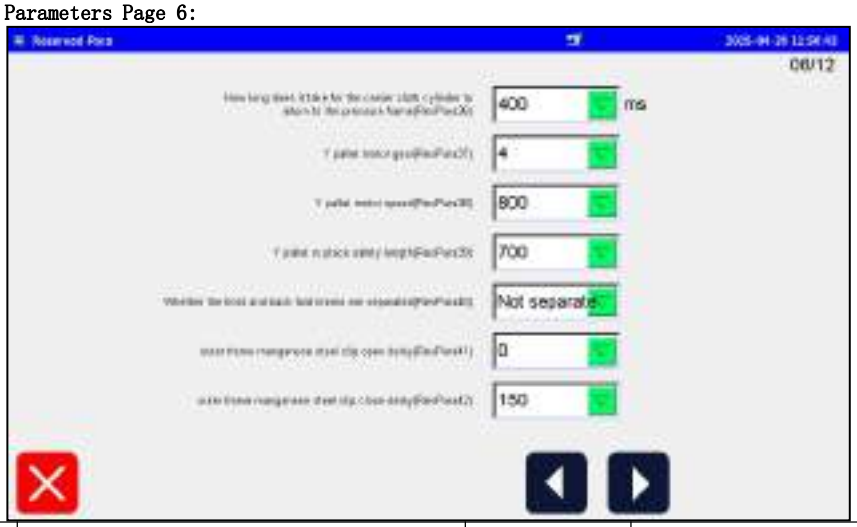
Reserved Parameters Page 4:


| Serial Number | parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | Left and right folding 1 return delay | 160 | Range: 0-30000 |
| 2 | Left and right folding material 2 failing delay | 160 | Range: 0-30000 |
| 3 | Left and right folding 2 rise delay | 160 | Range: 0-30000 |
| 4 | Side sliding telescopic 2 extension delay | 120 | Range: 0-30000 |
| 5 | Lifting and opening delay of bag cloth | 600 | Range: 0-30000 |
| 6 | Side slip telescopic 2 descent delay | 200 | Range: 0-30000 |
| 7 | Side sliding telescopic 2 lifting delay | 30 | Range: 0-30000 |

Reserved Parameters Page 5:


| Serial Number | parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | Delay after the outer pressing frame returns to the reclaiming position | 100 | Range: 0-30000 |
| 2 | X tray motor extension delay | 200 | Range: 0-30000 |
| 3 | X tray motor retract delay | 350 | Range: 0-30000 |
| 4 | Side-slip lift small cylinder fall delay | 100 | Range: 0-30000 |
| 5 | Side-slip lift small cylinder lift delay | 250 | Range: 0-30000 |
| 6 | No-pole motor length | 2500 | Range: 0-25000 |
| 7 | X tray motor speed gear | 5 | Range: 0-9 |

Reserved Parameters Page 6:




| Serial Number | Parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | How long does it take for the carrier to return to the pressure frame | 400 | Range: 0-30000 milliseconds |
| 2 | Y pallet motor gear | 4 | Range: 0-9 |
| 3 | Y pallet motor speed | 800 | Range: 0-800 |
| 4 | Y pallet in place safety length | 700 | Range: 0-2500 |
| 5 | Whether the front and back fold knives are separated | Not separate | Separate/Not Separate |
| 6 | Outer frame manganese steel clip open delay | 0 | Range: 0-30000 |
| 7 | Outer frame manganese steel clip close delay | 150 | Range: 0-30000 |

Reserved Parameters Page 7:


| Serial Number | parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | Fixed material Open position | The splice point | The splice point(The splice point is open)/(star point)star point open |
| 2 | If use bag cloth function | No use | Use/No Use |
| 3 | Whether to shield bag folding action | Do not block | No Shielding/Shield |
| 4 | Stretch cylinder/small cylinder switch | close | Close/Open |
| 5 | Inter pressure frame Expansion and contraction/invalid | Valid | valid/invalid |
| 6 | Is the suction shut-off function used during secondary material retrieval | No use | Use/ no use |
| 7 | Folding knife motor whether used | No use | Use/ no use |

Reserved Parameters Page 8:


| Serial Number | parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | Bag cloth motor whether use | There is a pause | Not used/no pause/pauses |
| 2 | Laser lifting plate lifting time | 300 | Range: 0-9999 |
| 3 | Laser lifting plate telescopic delay | 300 | Range: 0-9999 |
| 4 | Reserved para | 0 | Range: 0-9999 |
| 5 | Whether to use pallet receiving coordinates | Not used | Use/ not used |
| 6 | Y tray receipt motor length | 3500 | Range: 0-25000 |
| 7 | Y tray rise and open delay | 350 | Range: 0-30000 |

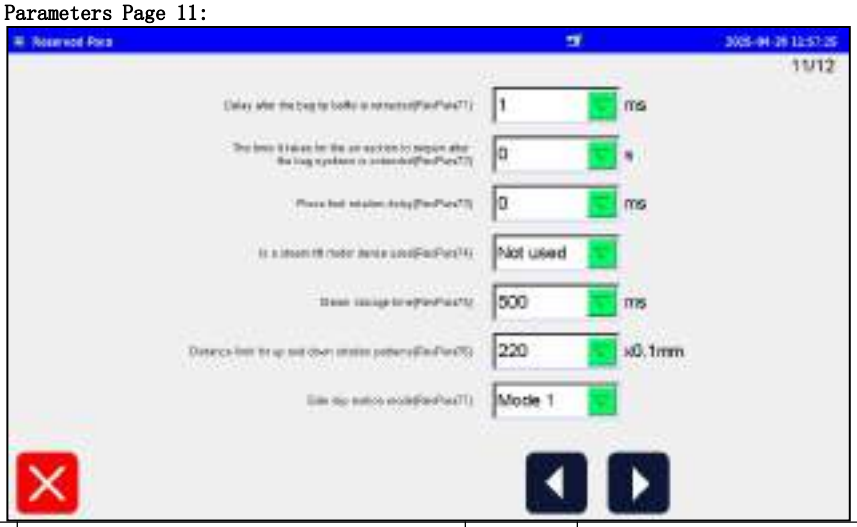
Reserved Parameters Page 9:


| Serial Number | parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | Y tray rise and close delay | 200 | Range: 0-30000 |
| 2 | Y clamp tray open delay | 200 | Range: 0-30000 |
| 3 | Y clamp tray close delay | 100 | Range: 0-30000 |
| 4 | Tray fixed open delay | 200 | Range: 0-30000 |
| 5 | Tray fixed close delay | 200 | Range: 0-30000 |
| 6 | Y pallet reclaimer motor length | 1900 | Range: 0-25000 |
| 7 | Lifting delay of external pressure frame | 400 | Range: 0-30000 |

Reserved Parameters Page 10:


| Serial Number | parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | Y pallet arrival safety length delay | 500 | Range: 0-30000 |
| 2 | Whether to automctically fold after cutting | Not auto | Automatic/Non Automatic |
| 3 | Whether to automatically fold after the second sewing work at the same time | Not same time | Not same time/at the same time |
| 4 | Is the pocket lip baffle effective | Self auto | Invalid/Self auto/vaild auto |
| 5 | Delay between the extension and descent of the bag lip baffle | 800 | Range: 0-3000 milliseconds |
| 6 | Is the left and right folding knives closed | no | yes/no |
| 7 | Delay between lifting and retracting the lip baffle | 1 | Range: 1-3000 milliseconds |

Reserved Parameters Page 11:




| Serial Number | parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | Delay after the bag lip baffle is retracted | 1 | Range: 0-30000 |
| 2 | The time for it takes for the air suction to reopen after the bag eyebrows is extended | 0 | Range: 0-30000 |
| 3 | Press foot rotation delay | 0 | Range: 0-30000 |
| 4 | Is a steam lift motor device used | Not used | Range: 0-30000 |
| 5 | Steam storage time | 500 | Use/ not used |
| 6 | Distance limit for up and down rotation patterns | 220 | Range: 0-30000 |
| 7 | Side slip motion mode | Mode 1 | Range: 0-30000 |

Reserved Parameters Page 12:


| Serial Number | parameter | Default value | Modify the interval |
|---|---|---|---|
| 1 | Sewing mode | Auto mode | Auto mode/normal mode/Placket mode |
| 2 | Wire cutting and blowing cylinder | 200 | Range: 0-2000 |
| 3 | Reserved para | 0 | Range: 0-9999 |