

UN254

双针自动裤耳机

2-needle, Automatic Belt-loop Attaching Machine

简易使用说明书

INSTRUCTION MANUAL

Forewords

Thank you for using our Special Sewing Machine.

It is appreciated that you do read this manual carefully, so that you can operate the machine correctly and effectively. If the user operates the machine contrary to regulations herein, thus causes loss to user or third party, we will not take any responsibility. Besides that, you should keep this manual for future use. For any fault or problem of machine, please ask the professionals or the technicians authorized by us for repair service.


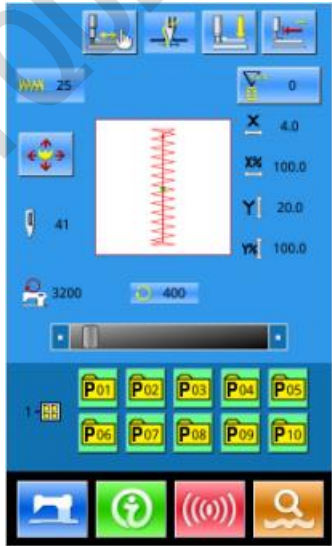
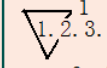
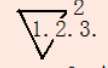




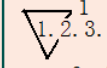
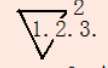




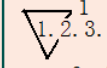
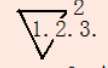







We use the advanced touching operation technique on the operation panel, whose friendly interface and simple operation will bring the big changes to users in their usage. Users can finish the relating operations by using their fingers or other object to touch the screen. **Never use sharp object to touch the screen, otherwise the touching panel will suffer the permanent damage.**

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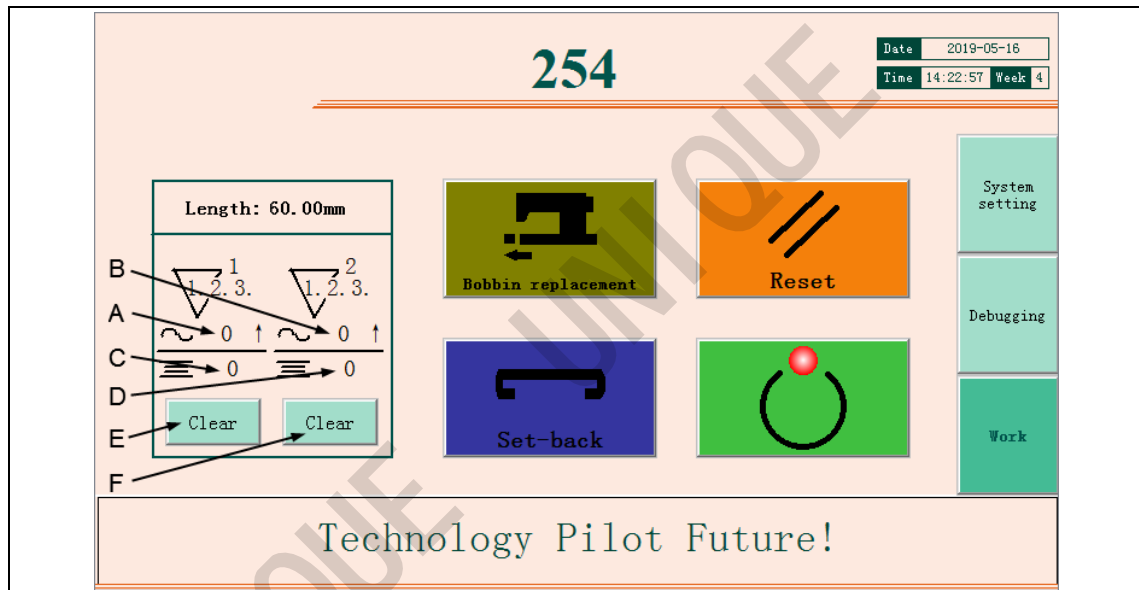
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1. Operating Instruction

1.1 Basic operation

<p>① Turn on the power.</p> <p>② Press READY key . The back-light of LCD displayer changes to blue color and the machine is ready for sewing.</p>													
<div style="text-align: center;"> <h1>254</h1> <p>Date 2019-05-16 Time 14:09:44 Week 4</p> </div> <table border="1" style="width: 100%; text-align: center;"> <tr> <td style="width: 25%;"> <p>Length: 60.00mm</p>   <p>0 ↑ 0 ↑ 0 0</p> </td> <td style="width: 25%;"> <p> Bobbin replacement</p> </td> <td style="width: 25%;"> <p> Reset</p> </td> <td style="width: 25%;"> <p>System setting</p> </td> </tr> <tr> <td></td> <td> <p> Set-back</p> </td> <td> <p></p> </td> <td> <p>Debugging</p> </td> </tr> <tr> <td colspan="3"> <p>Work</p> </td> <td></td> </tr> </table> <p style="text-align: center; font-size: 1.2em;">Technology Pilot Future!</p>		<p>Length: 60.00mm</p>   <p>0 ↑ 0 ↑ 0 0</p>	<p> Bobbin replacement</p>	<p> Reset</p>	<p>System setting</p>		<p> Set-back</p>	<p></p>	<p>Debugging</p>	<p>Work</p>			
<p>Length: 60.00mm</p>   <p>0 ↑ 0 ↑ 0 0</p>	<p> Bobbin replacement</p>	<p> Reset</p>	<p>System setting</p>										
	<p> Set-back</p>	<p></p>	<p>Debugging</p>										
<p>Work</p>													
<p>③ Press Reset key . The feeding mechanism completes the reset action.</p> <p>④ Press Ready key , the indicator light on the Ready key turns green .</p> <p>⑤ Set a garment body to be sewn on the machine.</p> <p>⑥ Press the start switch.</p> <p>⑦ After the machine completes predetermined steps of procedure, the machine actuates the thread trimmer to cut needle and bobbin threads, automatically lifts the presser foot, then stops.</p>													

1.2 Counter operation



A: 1st hook counter. Click “A” to show/hide the 1st hook counter clear key “E”.

B: 2nd hook counter. Click “B” to show/hide the 2nd hook counter clear key “F”.

C: 1st hook counter setting value. Click “C” to modify the 1st hook counter setting value.

D: 2nd hook counter setting value. Click “D” to modify the 2nd hook counter setting value.

E: 1st hook counter clear key. Press the key to clear the 1st hook counter.

F: 2nd hook counter clear key. Press the key to clear the 2nd hook counter.

Remarks:

- The counter can be set to the up counting mode or the down counting mode in the debugging interface → function setting.
- It is possible to set whether the hook base opens automatically when the number or times of sewing reaches the specified value, in debugging interface → function setting.
- After replacing the bobbin, please clear the corresponding counter.

1.3 Replace bobbin operation

254

Date	2019-05-18
Time	14:09:44
Week	4

Length: 60.00mm

Bobbin replacement

Reset

Set-back

Work

System setting

Debugging

Work

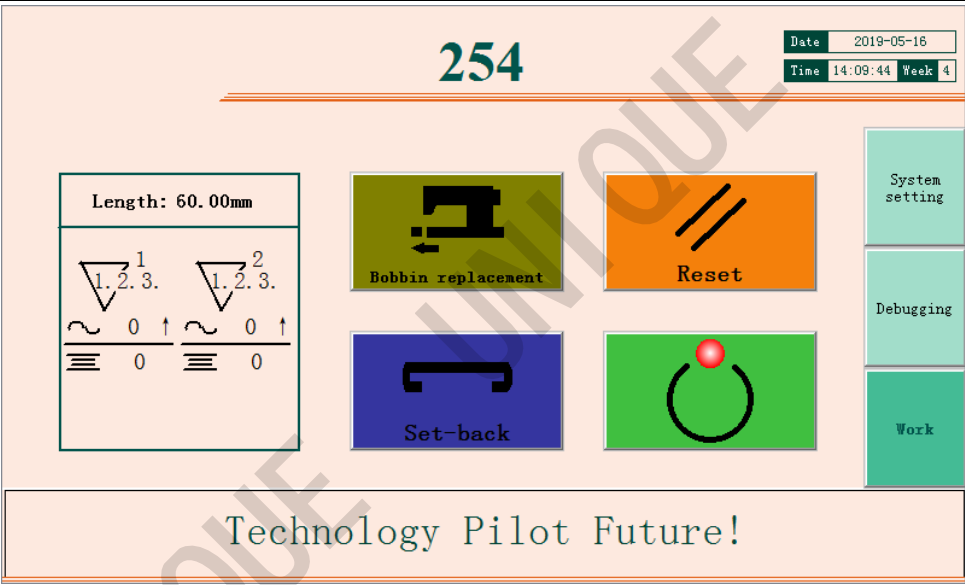
Technology Pilot Future!

① Press the Bobbin replacement key , the hook base moves outward and the fork retracts.


② Replace the bobbin.

③ Press Reset key , the hook base returns to the specified position.

1.4 Replace the belt loop on the fork

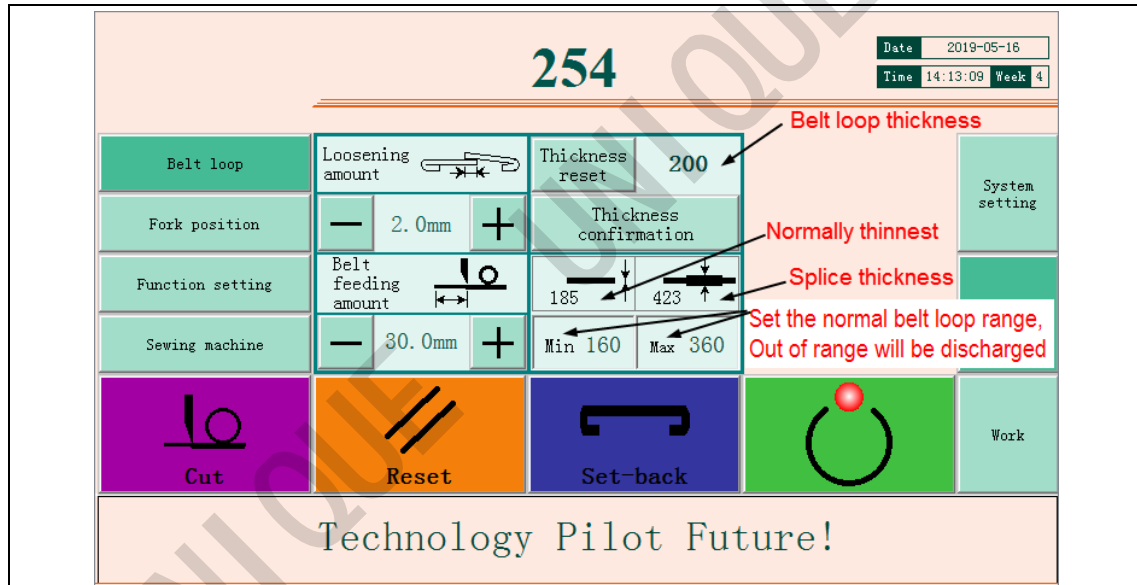




The screenshot shows the control panel of the machine. At the top center, the number "254" is displayed. In the top right corner, there is a date field showing "2019-05-18" and a time/week field showing "14:09:44 Week 4". On the left side, there is a display showing "Length: 60.00mm" and two diagrams of a fork with numbered points (1, 2, 3) and arrows indicating movement. Below these diagrams are two sets of symbols: a wavy line with "0" and an upward arrow, and a horizontal line with "0". In the center, there are four main function buttons: "Bobbin replacement" (green), "Reset" (orange), "Set-back" (blue), and a green button with a red dot and a circular arrow. On the right side, there is a vertical menu with three options: "System setting", "Debugging", and "Work". At the bottom of the panel, the text "Technology Pilot Future!" is displayed.



① Press Set-back key , the fork automatically releases the belt loop and replaces the new belt loop.

2. Debugging operation

2.1 Belt loop setting

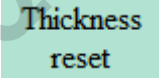


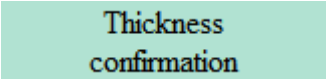
(1) Loosening amount: It can be adjusted by pressing the “-”  and “+”  keys or directly clicking on the numeric value.

(2) Belt feed clamping amount: It can be adjusted by pressing the “-”  and “+”  keys or directly clicking on the numeric value.

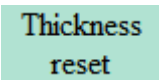
(3) Belt loop thickness setting, there are two ways:

a. Automatic confirmation

① When the belt loop is not placed, press the thickness reset key  to set the thickness zero point.

② Set a belt loop on the machine and keep pressing the thickness confirmation key  to pass the normal loop section and splice section up to detection lever, then release the thickness confirmation key to automatically confirm the thickness.

b. Manual input

① When the belt loop is not placed, press the thickness reset key  to set the

thickness zero point.

- ② Set a belt loop on the machine and press the thickness confirmation key

**Thickness
confirmation**

to pass the normal loop section to detection lever.

- ③ At this time, the value here

**Thickness
reset 200**

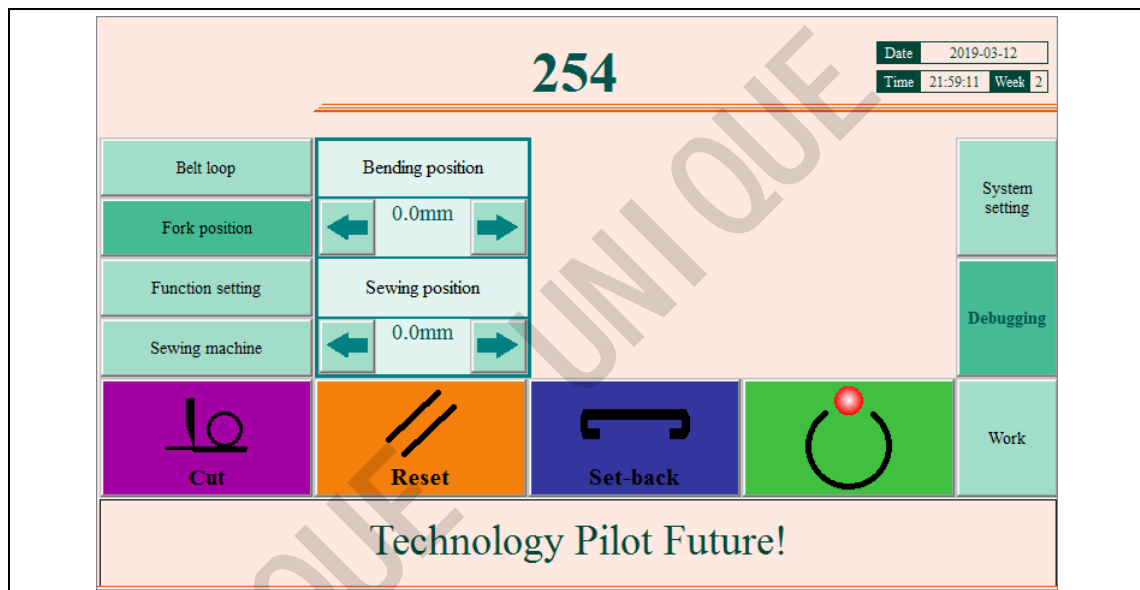
is the normal thickness value.

Enter a reasonable belt loop thickness range in the input box

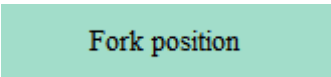




Min 160

Max 360

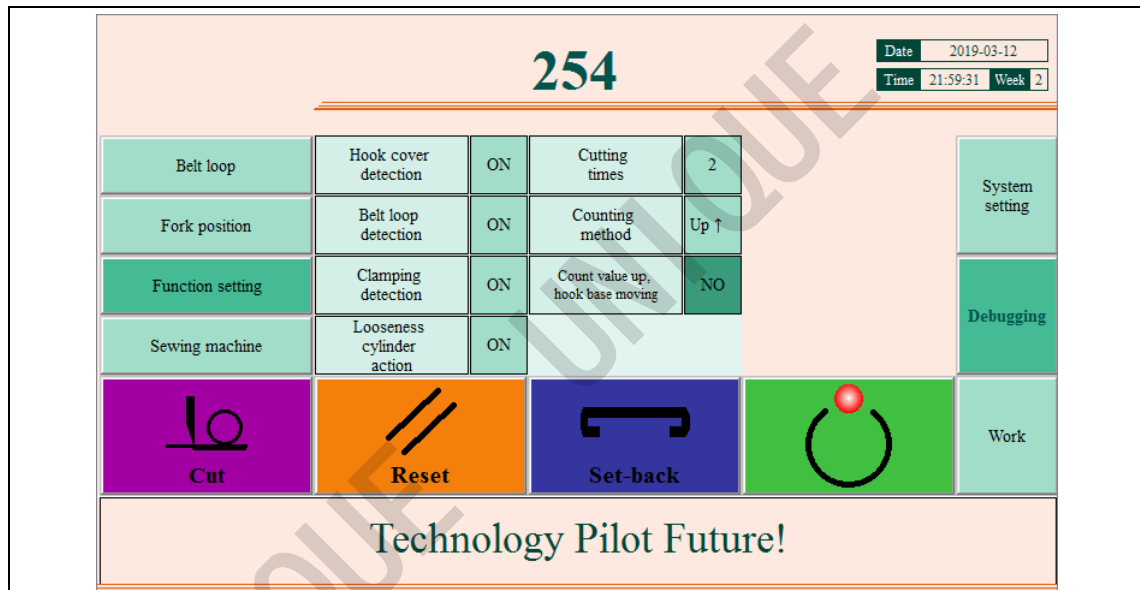
2.2 Fork position

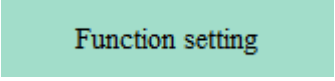


When the position of the fork is deviated, it can be adjusted in the following ways:

- Fork position**
- ① In the debugging interface, press the key  to enter the Fork position fine-tuning interface.
 - ② Bending position: According to the actual deviation to adjust the fork position left or right. Press the left shift key  or the right shift key  to adjust or directly click the value and input.
 - ③ Sewing position: According to the actual deviation to adjust the fork position left or right. Press the left shift key  or the right shift key  to adjust or directly click the value and input.

2.3 Function setting

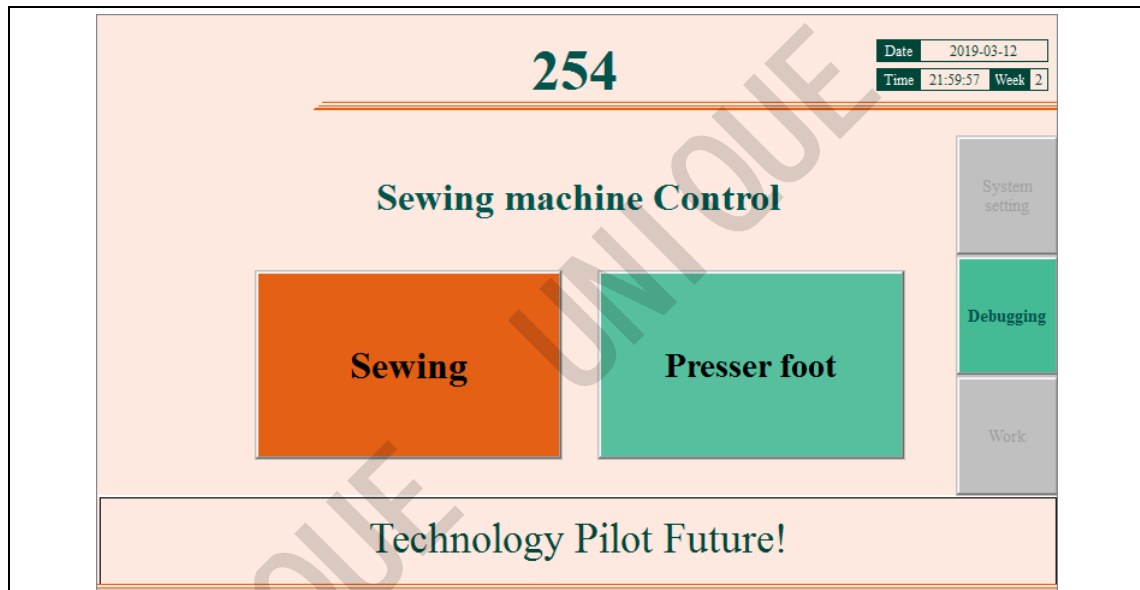


In the debugging interface, press the function setting key  to enter the function setting interface.

The following functions can be set in this interface:

- (1) Alarm function of the hook cover is opened on or off.
- (2) Belt loop splice detection function on or off.
- (3) Clamping detection function on or off.
- (4) Looseness cylinder acts or not.
- (5) Cutting times switching.
- (6) Counting method switching.
- (7) Whether the hook base opens automatically when the number or times of sewing reaches the specified value.

2.4 Sewing machine control



If you need to control the sewing machine separately, you can enter the sewing machine control interface.

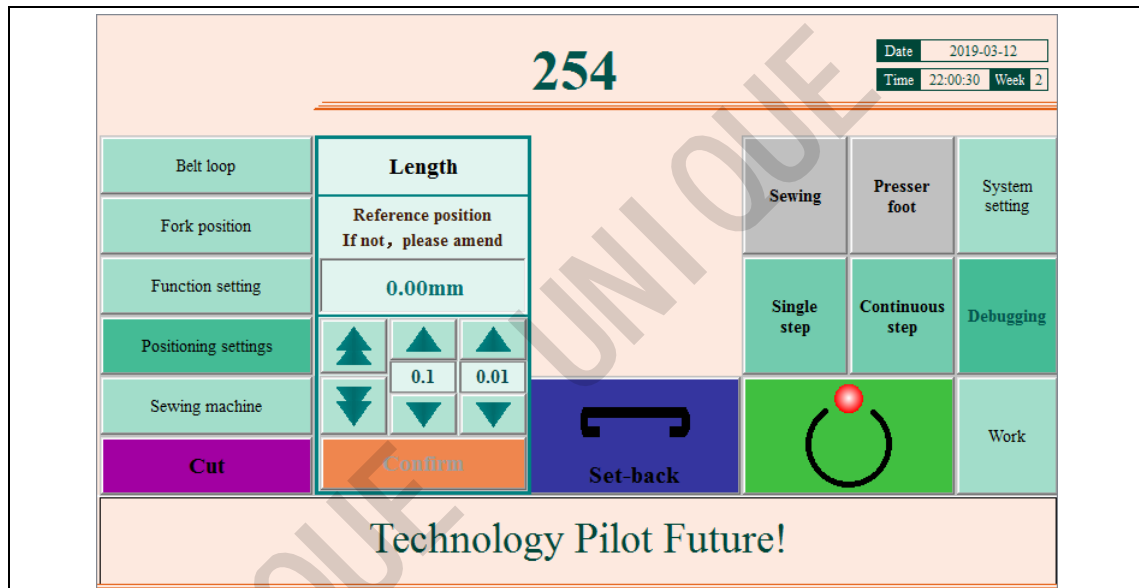
Presser foot

① Press the presser foot key **Presser foot** to control the presser foot to press/lift.

Sewing

② When the sewing machine presser foot is pressed, press the sewing key **Sewing** to perform the sewing operation.

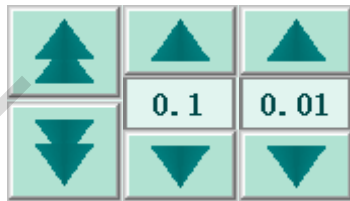
2.5 Adjust the length of the belt loop



① Press and hold the **Debugging** key for 5 seconds to enter the single-machine debugging interface.

② Press the **positioning setting** key to pop up the length positioning setting window.

③ Press the continuous adjustment key, 0.1mm adjustment key or 0.01mm adjustment key



to move the hook base inward or outward and adjust the hook position to the desired position. (Adjustable only when the sewing machine needle is in the upper needle position)

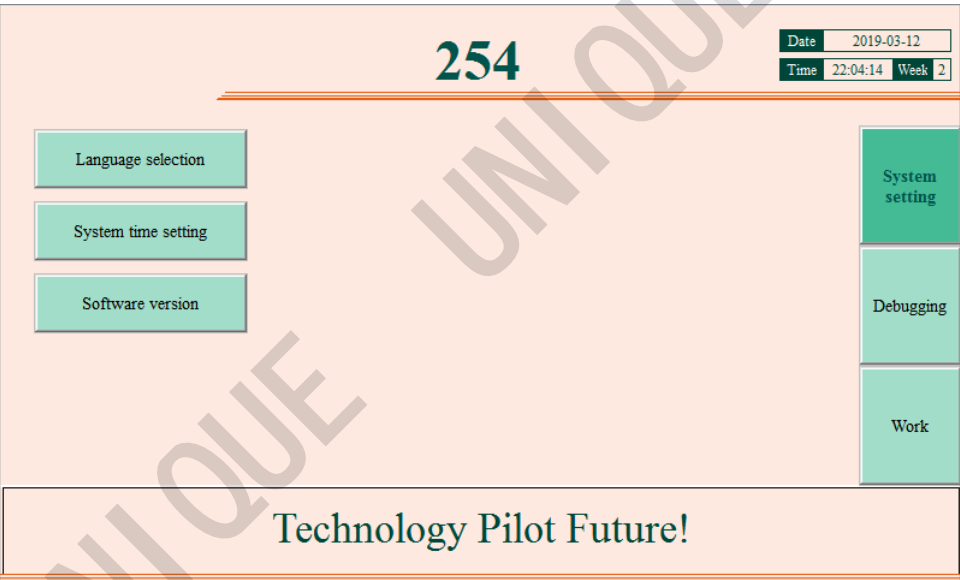
④ The length is shown as the distance between the two pinholes. If the value is deviated, please be sure to change it to the correct value.

⑤ After the adjustment is completed, press the confirm key **Confirm** to set the current position to the length value.

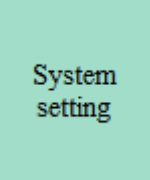
⑥ After adjusting the length, you need to adjust the position of the fork and the presser foot at the same time. After adjustment, you can perform single-step or continuous-step feeding debugging in the single-machine debugging interface to check whether the position of each component is suitable.

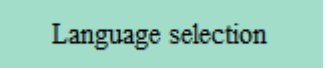
3. System setting

3.1 Language selection

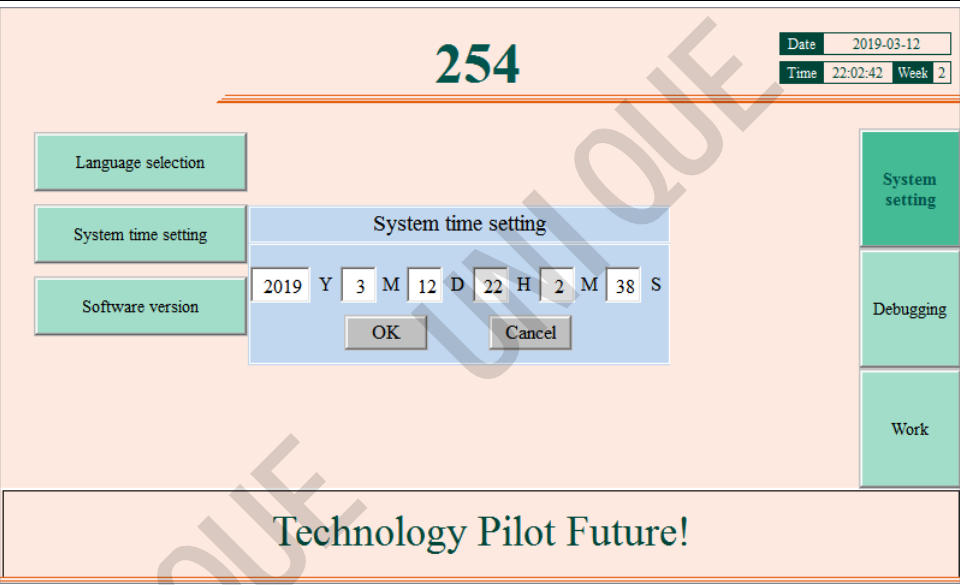


The screenshot shows a system setting interface with a large number '254' at the top center. In the top right corner, there are two status boxes: 'Date 2019-03-12' and 'Time 22:04:14 Week 2'. On the left side, there are three menu items: 'Language selection', 'System time setting', and 'Software version'. On the right side, there are three menu items: 'System setting', 'Debugging', and 'Work'. At the bottom of the interface, there is a banner that reads 'Technology Pilot Future!'.

① Press the system setting key  to enter the system setting interface.

② Click the language selection key  to switch the system language.
Currently supports Simplified Chinese and English.

3.2 System time setting

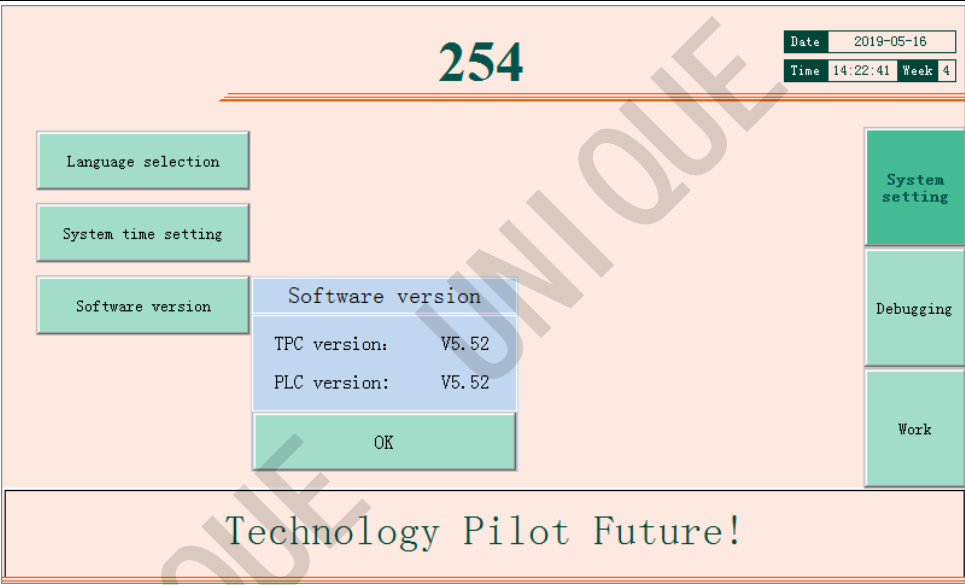


① Press the system time setting key **System time setting** to pop up the system time setting window.

② Set the correct date and time.

③ Press the OK key **OK** to complete the system time setting and close the system time setting window.

3.3 Software version



① Press the software version key **Software version** to pop up the software version window.

② The software version window displays the touch screen program version number and PLC program version number of the current device.

③ Press the OK key **OK** to close the software version window.