

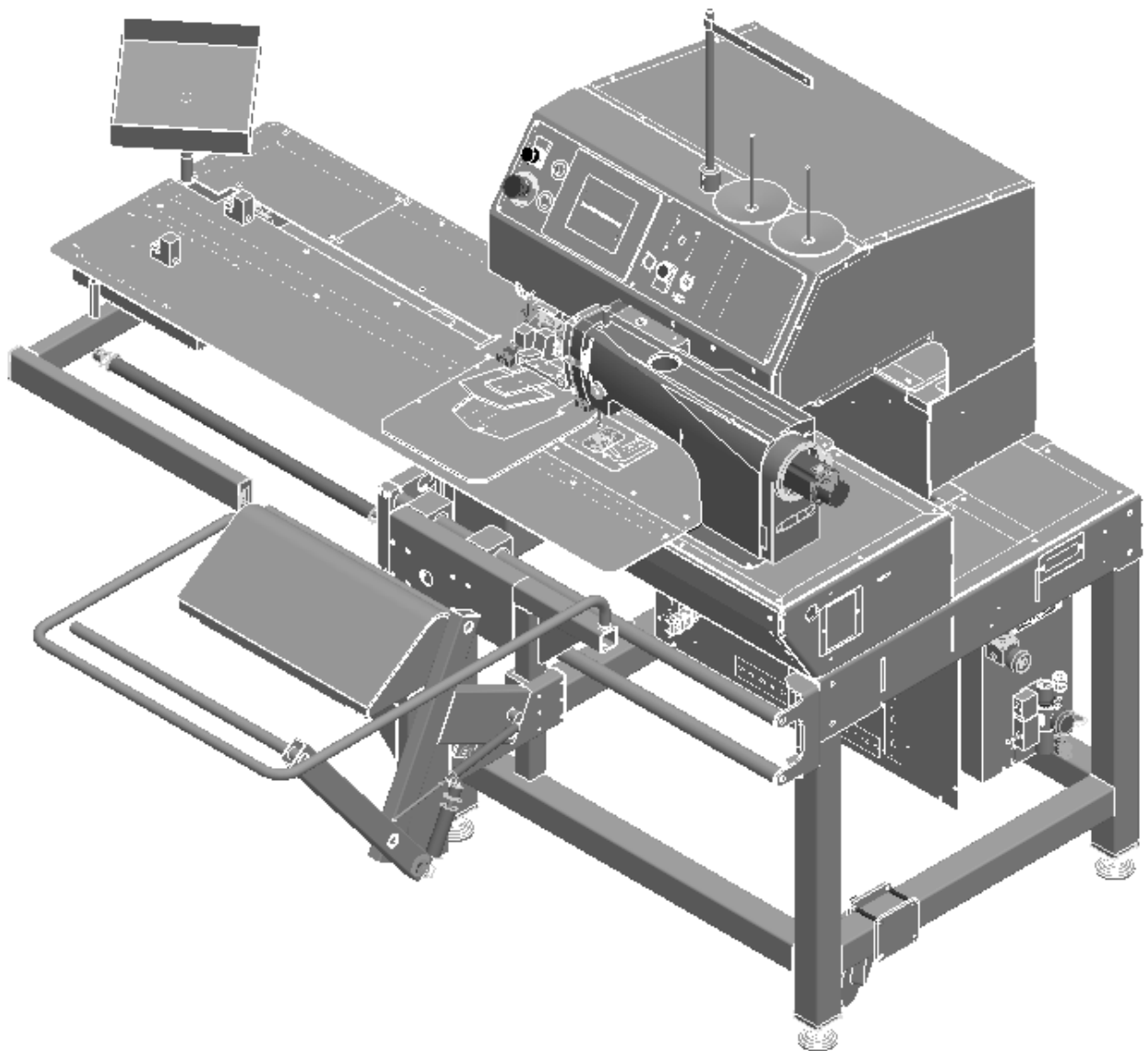
JAM INTERNATIONAL

PROGRAMMABLE AUTOMATIC
FLAT-BED SEWING MACHINE

JT864P-A

JT864P-A-95

INSTRUCTION MANUAL



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GENERAL FEATURES

• GENERAL WARNINGS

- The machine can be operated exclusively by authorized and trained staff and only after having read and understood the present manual.
- The machine must be used exclusively for the purpose for which it has been produced and with the respective safety devices working. The manufacturer is not responsible in case of any different use.
- Before doing any maintenance, replacing any part and when moving away from the working place it is absolutely necessary to deactivate the machine by turning off the main switch, remove the power cable from the socket and cut the air. Exceptions are possible only in case of set up and functionality checks made by authorized staff trained on purpose.
- Interventions on the electric system must be made only by specialized electricians or by staff trained on purpose.

• MANUFACTURER RESPONSABILITY

JAM INTERNATIONAL is not responsible for any mishap, breaking, accidents due to the missing knowledge (or non application) of the instructions contained in the present manual. JAM INTERNATIONAL is not responsible as well for modifications, variations and/or installation of non previously authorized accessories.

Particularly JAM INTERNATIONAL declines any responsibility for damages due to:

- Natural calamities
- Wrong manoeuvring
- Maintenance missing
- Special interventions or machine overhauls made by non authorized staff
- Incorrect use of the machine

• MODIFICATIONS



WARNING! JAM INTERNATIONAL reserves the right to modify the machine for any constructive or functional or commercial exigency, without being bounded to update opportunely the instructions manual and the parts book.

• IDENTIFICATION PLATE

On the machine frame there is the identification plate containing the following information:

- Manufacturer details
- CE mark
- Production year
- Machine model
- Serial no.

JAM INTERNATIONAL S.r.l.		
Ostra Vetere (AN) Tel. +39 071 67872		
MODELLO	_____	○
MATRICOLA	_____	○
ANNO	_____	MADE IN _____

- **TECHNICAL SERVICE**

The **MANUFACTURER** or the **SELLER** offer to the Customer their Technical Service to solve any problem regarding the machine use and maintenance.

Any request for service or spare parts must be forwarded to:

JAM INTERNATIONAL s.r.l.

Via G. Perini 2

60010 Ostra Vetere AN – ITALY

Tel +39 071 67872

Fax +39 071 67873

e-mail parts@jaminternational.it

specifying the following:

- Machine model
 - Serial number
 - Details regarding the faults verified
 - The checks made
 - Any other useful information
- Part number and description of the required spare parts

SAFETY

- **TRAINING**



WARNIG! The use of the machine is allowed exclusively to authorized staff properly trained.

For a proper and safe use of the machine it is necessary to have entirely read and understood the present manual and the attached instructions.

- **SAFETY INSTRUCTIONS**


- Do not try to operate the machine until its functioning hasn't been clearly understood. Anyway the use of the machine is allowed exclusively to authorized staff properly trained. Do not allow unauthorized people and especially children to get near the machine.
- Before starting the machine, the operator must check the presence of clear faults on the safety devices and on the machine and immediately report what found to the person in charge.
- The only working position suitable for the operator is the fabric loading position, that is behind the fixed safety bar. Do not occupy other positions different from the above mentioned one during the machine functioning.
- Never start the machine before having advised and averted anyone present nearby it.
- Do not use the machine while wearing clothes, ornaments or accessories which can get caught on any moving part. Gather up long hairs under a cap. Wear clothes which allow to bear objects and tools in closed pockets.
- The machine user must know the safety devices installed on it, as well as the respective proper modalities of use. Check daily the proper functioning of the emergency buttons and of the safety devices. Never use the machine without its safety devices properly installed and working.
- Pay the maximum attention to every danger and prohibition symbol existing on the machine.
- Keep every plate with danger and prohibition symbols in perfect conditions, clearly visible and readable. In case of tear replace them quickly.
- Do not operate the machine with damp hands and objects when it is connected to the electric system.
- Replace the parts considered damaged with original ones or in any case authorized by the manufacturer. Never try hazardous solutions.

It is extremely dangerous to use the machine without its safety devices (emergency button, belt protection and so on). Never use the machine without the safety devices.

The safety devices removal is allowed exclusively during the machine maintenance and must be done exclusively buy specialized staff

- **NOT ALLOWED USE**

The machine JT864P-A / JT864P-A-95 has been produced to be used in the clothing industry to make seams on jeans and similar and automatic pre-creased pocket setting

	The machine must never be used for not allowed purposes or for purposes different from those for which it has been produced. The manufacturer is not responsible for improper use of the machine
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- **INDIVIDUAL SAFETY DEVICES**

During the machine running as well as during the maintenance and clearing operations it is suggested to use the following individual safety devices: working clothes, shoes with anti-skid sole and gloves.

Wear the protective glasses when using the machine to avoid that, in case of needle breaking, the possible splinters could hit the eyes.

Use the protective glasses and gloves when using lubricants and greases, in order to avoid the contact with eyes and skin and the consequent risk of irritations and inflammations

The employer is compelled to provide the operator with the Individual Safety Devices and to inform him about their proper use and maintenance.




- **REMAINING RISKS**

The machine has been designed and produced with the suitable devices to assure the maximum operator safety.

Where remaining risks exist, these are pointed out through proper labels and danger and prohibition symbols.

- **SAFETY SIGNS**

On the machine there are some labels showing the following symbols to highlight dangers and prohibitions existing on the machine:

	ELECTRIC DANGER This symbol points out the existence of a danger caused by the electric power
	HANDS CRUSHING DANGER
	PROTECTION REMOVAL PROHIBITION This symbols points out the prohibition to remove the safety devices

MOVING – STORAGE – DISPOSAL



WARNING! Any machine transport, moving and storage operation described in this chapter must be carried out exclusively by qualified staff having suitable knowledge to operate safely forklift trucks, crane trucks and anything else necessary to the purpose

- **MOVING**

- To avoid that any part may hurt the persons in case of machine fall, be sure that during the lifting and moving operations there are no persons inside the action range of the lifting machines.
- To lift up and move the machine it is necessary to use suitable means of transport according to its weight.
- Before starting moving the machine, check its stability.

- **STORAGE**

- In case of long storage, keep the machine in a dry place, sheltered from rain and wind.
- Protect well the electrical parts from the dust and from external agents.
- The machine may suffer heavy damages if, while waiting for the installation, it is kept in environments with critical temperatures. Never expose it to temperatures lower than -10°C and higher than $+60^{\circ}\text{C}$.
- Do not deposit the machine or its parts in structures which have not been suitably built.
- It is forbidden to put on the machine any material or equipments.

- **DEMOLITION AND DISPOSAL**

- The disposal of the waste which comes out from the machine demolition must be carried out respecting the environment, avoiding to pollute the ground, the air and the water.
- For a proper disposal it is necessary to respect the local laws in force.

MOVING AND TRANSPORTATION

- **LIFTING**

WARNING :

The lifting operation must be carried out with the maximum care and by AUTHORIZED STAFF only.

During the lifting operations no unauthorized people are allowed to stand nearby.

To lift up and to position the machine use a forklift truck of proportionate dimensions and sturdiness. Insert the forklift under the machine, be sure to take it for the entire width, fasten it well with belts or ropes and lift it paying attention that it doesn't tilt on one side.

- **PACKAGE**

The kind of package may be different according to the machine, the mean of transport and the destination.

- In a wooden crate in case of transport by sea or by air.
- Wrapped in a protection film to be transported with road vehicles.

- **AIR NOISE UTTERED BY THE MACHINE**

The machine described in this manual does not represent a risk factor itself as the peak level of the acoustic pressure on the workplace is minimum.

Therefore the possible high level of acoustic pressure existing in the environment where the machine runs cannot be charged to it.

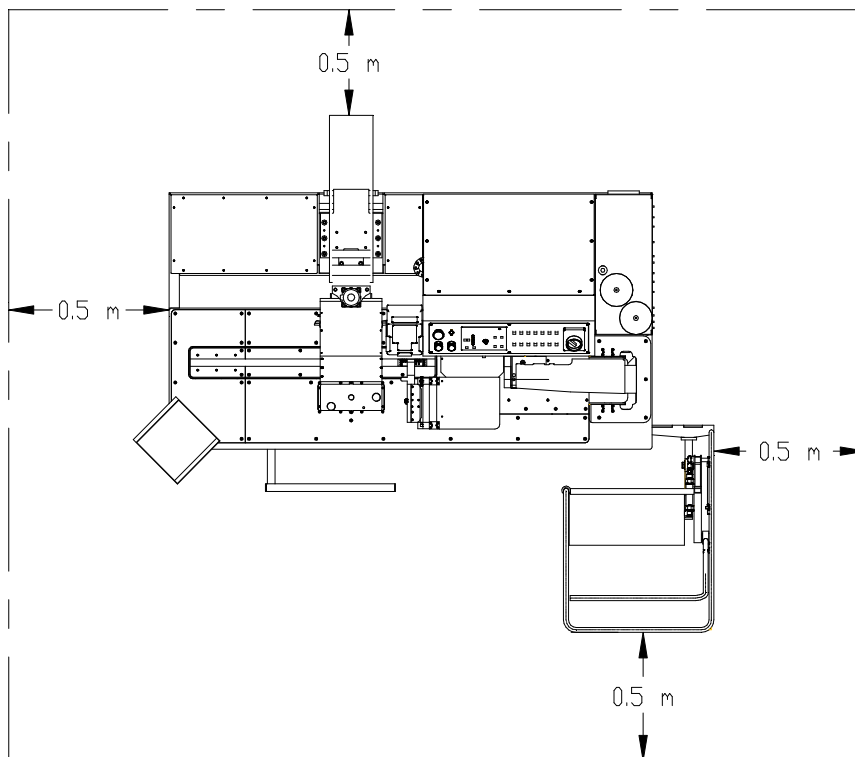
The weighed acoustic pressure level on the working station does not exceed 70 dB(A)

USE OF THE MACHINE

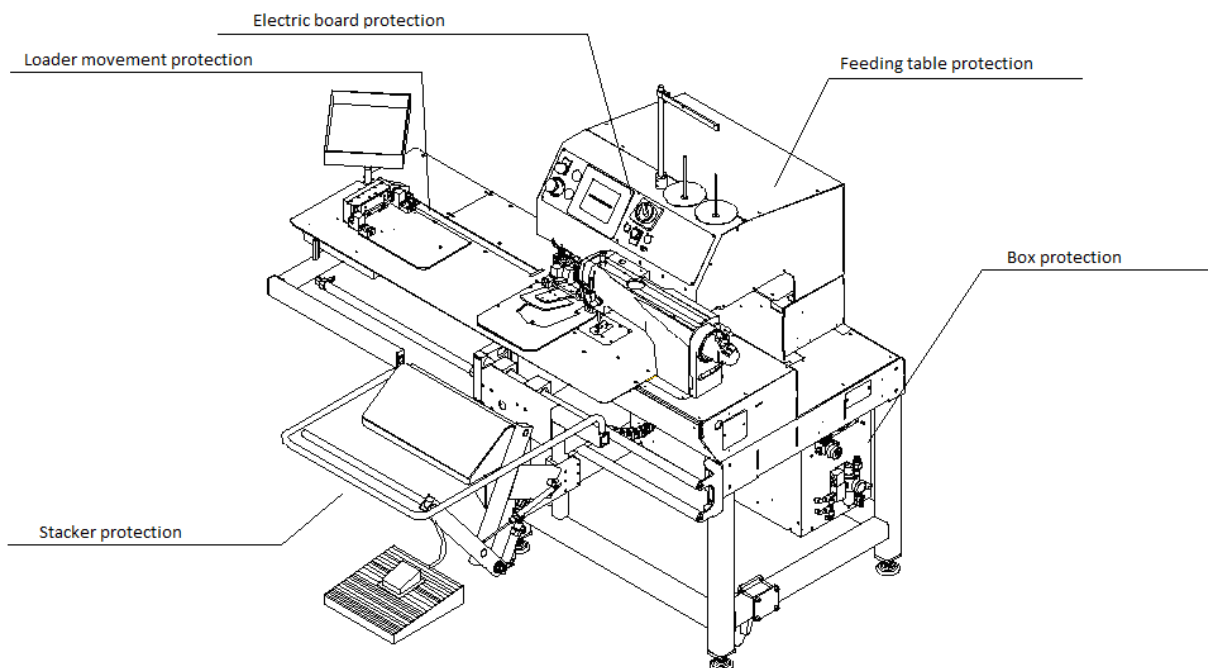
After having unpacked the machine put it in its working place in a flat and stable position.

- **MINIMUM DISTANCES FOR A PROPER MAINTENANCE**

Leave a free space of at least 50 cm on each side of the machine



It is extremely dangerous to use the machine without its safety devices (emergency button, belt protection and so on). Never use the machine without the safety devices.



The safety devices removal is allowed exclusively during the machine maintenance and must be done exclusively by specialized staff.

- **CONNECTION TO THE ELECTRIC SYSTEM**

Connect the power cable to the socket.

WARNING:

Be sure that the power tension corresponds to the one indicated by the manufacturer in the specifications written on this manual.

Be sure to connect properly the earth cable. If the connection of the earth is not safe, there could be the risk to get an electric shock and some problems with the correct machine functioning could occur.

Use the machine in areas electric/electromagnetic noise sources free. Such disturbs could cause problems to the correct machine running.

In case of lightning or electric storms, switch off the machine and disconnect the power cable from the socket to avoid functioning problems or damages to the machine.

- **CONNECTION TO THE PNEUMATIC SYSTEM**

Connect the air pipe to the quick pipe fitting located on the pressure governor, let the air in and check that the air gauge signals a maximum pressure as described in the specifications.

If necessary adjust the pressure on the correct value by lifting and turning the knob of the pressure governor clockwise to increase it or anticlockwise to reduce it.

Block the knob when the air gauge indicates a correct pressure.

MACHINE DESCRIPTION

- **MODEL**

JT864P-A / JT864P-A-95 Automatic programmable pocket setter on shirts, with folding group and automatic stacker, lockstitch, controlled by touch screen panel.

- **SPECIFICATIONS**

Model	JT864P-A / JT864P-A-95			
Electric power	220 V – L+N+Ground			
Working air pressure	U.M.	[bar]	[MPa]	[Psi]
	Pressure	6	0.6	87
Weight	354 kg			
Dimensions [WxDxH]	1890 x 1720 x 1750 mm			

CONTROL PANEL BUTTON INDEX

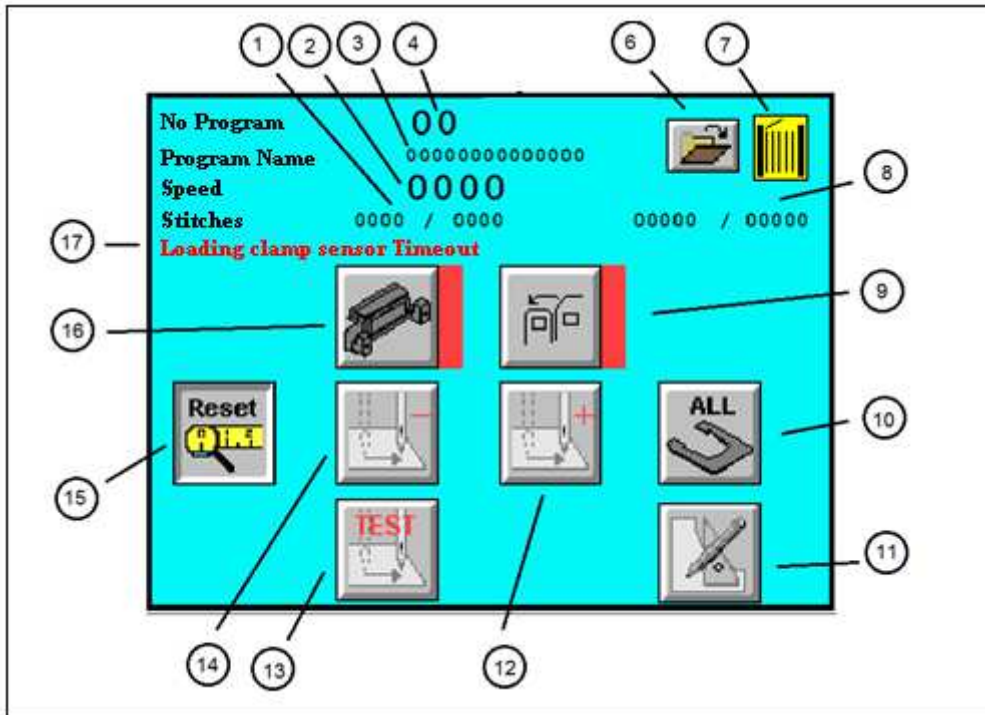

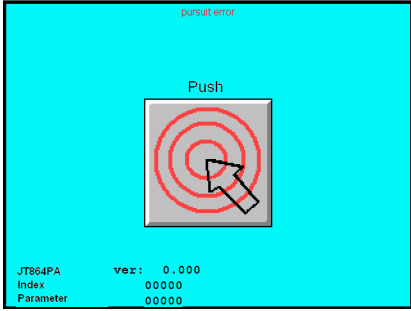

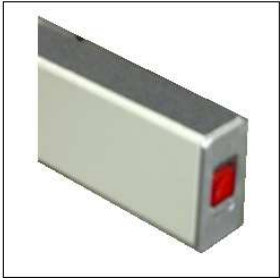
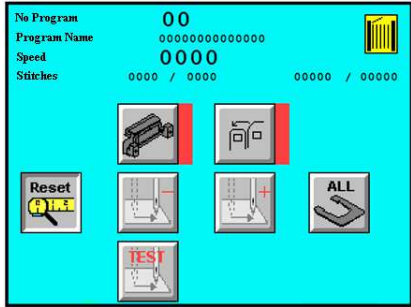


Fig 1. SCREEN

1. Number of stitches on the stitching program
2. Stitching speed
3. Program name
4. Program number
5. ----
6. Program file
7. Bobbin counter reset
8. Bobbing counter setting
9. Stacker button
10. Jig change button
11. Setting button
12. Manual forward movement button
13. Stitching test button
14. Manual backward movement button
15. Reset button
16. Automatic button
17. Warnings

1 STARTING


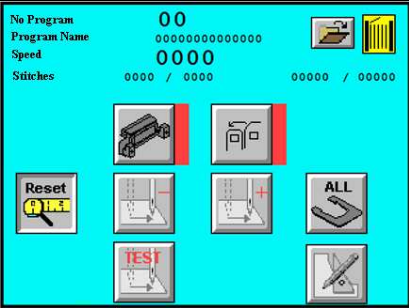

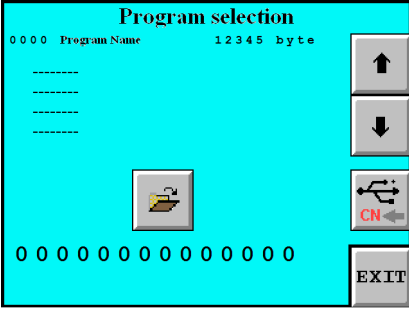


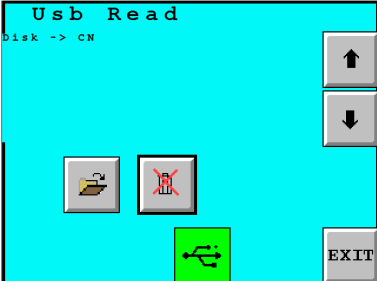




Check that the emergency is over and everything is in order.

<p>1.1 Switch on the machine by turning the main switch from OFF to ON</p>	 <p style="text-align: center;">Fig. 2</p>
<p>1.2 Press the green button, the green screen will appear as in fig. 3</p>	 <p style="text-align: center;">Fig. 3</p>
<p>1.3 Press the touch screen in the centre as pointed out by the arrow (fig.2), the Home screen will appear as in fig. 4</p>	 <p style="text-align: center;">Fig. 4</p>
<p>1.4 Press simultaneously the start buttons (positioned on the right and left side of the panel holder bar as shown in fig. 5). The machine will move to its home position and will lift up the needle and the presser foot.</p>	 <p style="text-align: center;">Fig. 5</p>
<p>1.5 The home screen will appear as shown in fig. 6</p>	 <p style="text-align: center;">Fig. 6</p>


2 MACHINE HOME POSITION

When the machine is in its home position the loader is set in its back position, the upper loader clamp sensor is set on ON, the upper external clamp sensor is set on ON, the internal fixed or retractable clamp sensor is set on OFF, the presser foot and the needle are lifted up.

3 DOWNLOAD THE SEWING PROGRAM FROM THE USB

<p>3.1.1 Insert the USB key in the USB device</p> <p>3.1.2 While the automatic button is  deactivated, press the pedal until the screen will appear as in fig. 7</p>	 <p style="text-align: center;">Fig.7</p>
<p>3.2 OPTION 1</p>	
<p>3.2.1 Press the button “open” , the screen will appear as in fig. 8</p>	 <p style="text-align: center;">Fig.7</p>
<p>3.2.2 Press the button “CN IN” , the screen will appear as in fig. 9, check that the USB icon  is green while the USB key is still connected</p>	 <p style="text-align: center;">Fig.8</p>
<p>3.2.3 Select the program by using the arrows, press the button “open”  and wait for the file transfer to be completed</p>	
<p>3.2.4 Repeat the operation described on 3.2.3 to insert another program or press the button  to go back to the screen as in fig. 8</p>	
<p>3.2.5 Highlight the program to be executed by using the arrows, press the button “open”  and the home screen will appear as in fig. 4</p>	
<p>3.2.6 Press the button “reset”  to get back to the main screen (Fig. 6)</p>	

3.3 OPTION 2

3.3.1 Press the button “setting” , the screen will appear as in fig.10

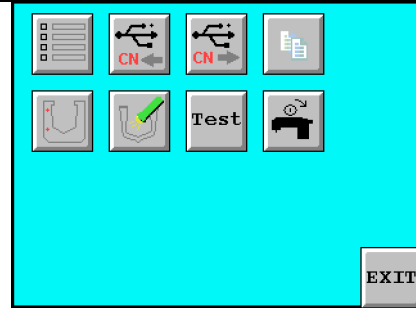





Fig.9

3.3.2 Press the button “CN IN” 

3.3.3 Select the program by using the arrows and press the button “open” 


3.3.4 Repeat the operation described on 3.3.3 to insert another program

3.3.5 Press the button “Exit” , the home screen will appear (fig.4)


3.3.6 Press the button “reset”  to get back to the main screen (fig. 6)

4 AUTOMATIC CYCLE

4.1 STACKER

- 4.1.1 On the main screen (fig.6) press the button “stacker”  to choose to use it or to deactivate is (green=activated / red=deactivated)

4.2 WORKING MODE

- 4.2.1 On the main screen press the button “automatic”  (green= activated / red=deactivated)
- 4.2.2 Once activated the “automatic” button, set the fabric panel under the loading clamp
- 4.2.3 Press the pedal to lower or to lift up the loading clamp in order to adjust correctly the fabric panel position
- 4.2.4 Set the pre - creased pocket inside the loading clamp shape.
- 4.2.5 Press simultaneously the “start” buttons (fig.5)



4.3 CYCLE SEQUENCE

- 4.3.1 After pressing the “start” buttons the loading clamp moves on the “loading point” (under the sewing clamps)
- 4.3.2 The internal sewing clamp lowers
- 4.3.3 The loading clamp lifts up
- 4.3.4 The loader moves to the home position
- 4.3.5 The external sewing clamp lowers
- 4.3.6 The sewing cycle starts
- 4.3.7 Once the sewing cycle has been completed, if the stacker is activated, the garment will be automatically stacked. If the stacker is deactivated the garment must be stacked manually.
- 4.3.8 While the machine is stitching and the loader is in home position, it is possible to load another garment in order to work in sequence.

5 THREAD BREAKAGE

5.1 When the thread sensor is activated, if a needle thread breakage occurs or in case the thread is finished, the machine stops automatically.


5.1.1 Restore the thread

5.1.2 Press the button “manual movement backward”  or the button “manual movement forward”  to move to the chosen position, then press simultaneously the “start” (fig.5)

If the machine shows again the same warning, check carefully the thread position, the needle position and the hook timing, then repeat the operations described on 5.1.2.

6 BOBBIN WARNING

6.1 BOBBIN WARNING SET UP

6.1.1 Press the button “pre – set bobbin counting” on the main screen (Fig. 6)  (circled in red), a numerical keyboard will appear


6.1.2 Set the chosen number (corresponding to “stitches number”)

6.1.3 Press “ENTER” to confirm, go back to the previous screen

6.2 BOBBIN WARNING

6.2.1 When during the seam the bobbin counting reaches the set number, once the seam is finished the machine stops and on the “warning string” (17) the words “BOBBIN WARNING” will appear

6.2.2 Replace the bobbin and check the correct threading.





6.2.3 Clear the counting by pressing twice the button “bobbin” 

6.2.4 Resume work normally



6.2.5 If the problem arises again, repeat the operations described on 6.2..2, 6.2.3, and 6.2.4

7 STITCHING TEST


7.1 SEAM CHECKING

- 7.1.1 Deactivate the button “automatic” and press the button “TEST”  on the main screen (Fig. 6). The “TEST” button will keep pressed.
- 7.1.2 Press the pedal until the screen as Fig. 7 appears. The sewing clamps will lower. Pressing again the pedal the sewing clamps will lift up.
- 7.1.3 Press simultaneously the “START” buttons (Fig.5), the sewing clamps will move to the stitching start point.
- 7.1.4 Press the button “manual forward movement”  to go ahead on the seam path.
- 7.1.5 Pressing the pedal after a few movements, it is possible to lower and to lift up the presser foot.
- 7.1.6 Check that during the seam, the needle and/or the presser foot do not hit the sewing clamps.
- 7.1.7 To get back on the seam path press the button “manual backward movement” .
- 7.1.8 Pressing the pedal while pressing the button “manual forward movement” or the button “manual backward movement”, the seam path will be executed faster.
- 7.1.9 Once the seam path has been checked, press the button . The machine will get to its home position and the button “TEST will be automatically released.
- 7.1.10 If the seam path is not correct or not satisfactory, read CAREFULLY the chapter “SEWING PROGRAM ADJUSTMENT.


8 LOADING AND STITCHING TEST

- 8.1.1 Deactivate the button “automatic” and press the button “TEST”  on the main screen (Fig. 6). The “TEST” button will keep pressed.
- 8.1.2 Press the button “AUTOMATIC”  on the main screen (Fig. 6) to enable it.
- 8.1.3 Once the button “AUTOMATIC” has been activated set the fabric panel under the loading clamp.
- 8.1.4 Press the pedal to lower/lift the loading clamp in order to adjust properly the fabric panel position.
- 8.1.5 Set the pre – creased pocket inside the loading clamp shape.
- 8.1.6 Press simultaneously the “START” buttons
- 8.1.7 After having pressed the “START” buttons , the loading clamp moves to the loading point (under the sewing clamps)
- 8.1.8 The internal sewing clamp lowers
- 8.1.9 The loading clamps lifts up
- 8.1.10 The loader moves to the home position
- 8.1.11 The external sewing clamp lowers
- 8.1.12 The sewing clamps move to the stitching start point.
- 8.1.13 Check that the pocket is positioned at the centre of the external sewing clamp.
- 8.1.14 Execute the operations described from 7.1.4 to 7.1.9
- 8.1.15 If the loaded pocket position is not correct read CAREFULLY the chapter “LOADING POINT ADJUSTMENT”.

9 STITCHING CHECK

- 9.1.1 Deactivate the button “AUTOMATIC” and press the button “TEST”  on the main screen (Fig. 6). The “TEST” button will keep pressed.
- 9.1.2 Set a piece of fabric under the sewing clamps.
- 9.1.3 Press the pedal until the screen as in Fig. 7 appears. The sewing clamps lower.
Pressing again the pedal the sewing clamps lift up.
- 9.1.4 Press simultaneously the “START” buttons (Fig. 5), the machines performs the sewing cycle.

10 PROGRAM SELECTION FROM THE MACHINE MEMORY

10.1.1 Deactivate the “AUTOMATIC” button , press the pedal until the screen as in fig. 7 appears.

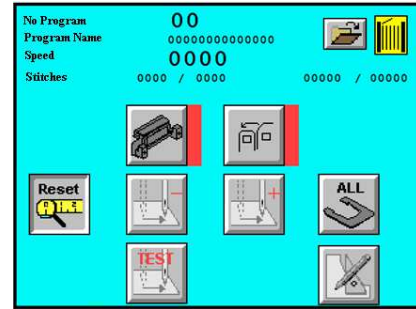


Figura 7

10.1.2 Press the button “OPEN” . The screen as in fig. 8 appears.

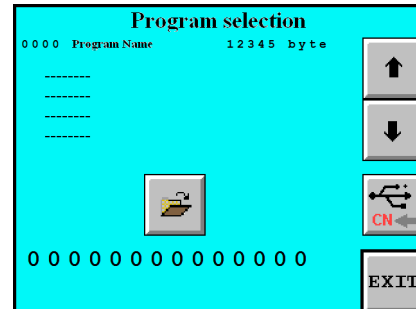


Figura 8

10.1.3 Select the program from the list by using the arrows.

10.1.4 Press the button “FILE” . The screen as fig. 4 appears.



Fig.4


10.1.5 Press the button “RESET”  to get back to the main screen (Fig. 6).

10.1.6 Check the strings on “PROGRAM NUMBER (4) and “PROGRAM NAME”(3) that the program loaded is correct.

11 PROGRAM COPY

11.1 SELECTION OF A PROGRAM TO BE COPIED

11.1.1 Follow the procedures of chapter 10 (from 10.1.1 to 10.1.6)

11.1.2 Deactivate the “AUTOMATIC” button , press the pedal until the screen as fig. 7 appears.

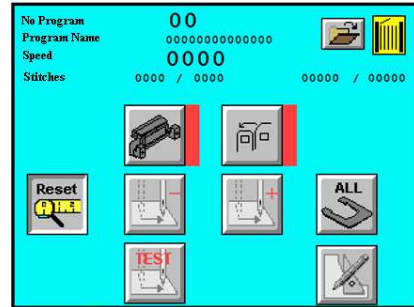



Fig. 7

11.1.3 Press the button “SETTING” . The screen as fig.10 will appear

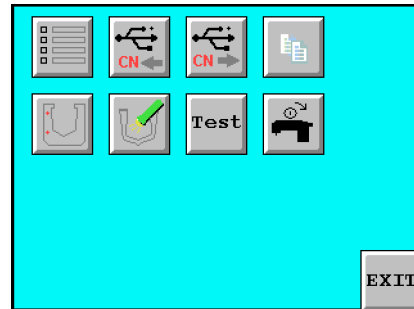


Fig.10

11.1.4 Press the button “COPY” . The screen as fig. 11 will appear

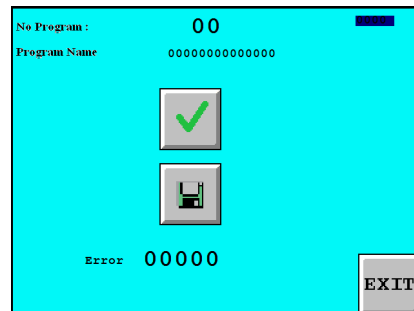





Fig.11

11.1.5 Press the button “PROGRAM NUMBER”  (where highlighted), a numerical keyboard will appear.

11.1.6 Insert the new program number.

11.1.7 Press the button “ENTER” to get back to the previous screen.

11.1.8 Press the button “CONFIRM” , which will disappear and the button “SAVE”  will appear.

11.1.9 To change the name of the saved program, press “PROGRAM NAME”  (where highlighted). An alphanumeric keyboard will appear.

11.1.10 Enter the new program name.

11.1.11 Press the button “ENTER” to get back to the previous screen.


11.1.12 Press the button “SAVE” . The screen as fig. 10 will appear.

11.1.13 Press the button “EXIT” . The screen as ig. 4 will appear.

11.1.14 Press the button “RESET” , to get back to main screen as fig. 6.

On the strings of the program number (4) and the program number (3) the new data will be displayed.

12 DELETE A PROGRAM FROM THE MACHINE MEMORY

12.1.1 Deactivate the “AUTOMATIC” button , press the pedal until the screen as fig. 7 appears.

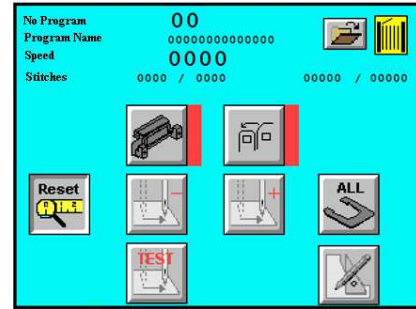



Fig.7

12.1.2 Press the button “SETTING” . The screen as fig. 10 will appear.

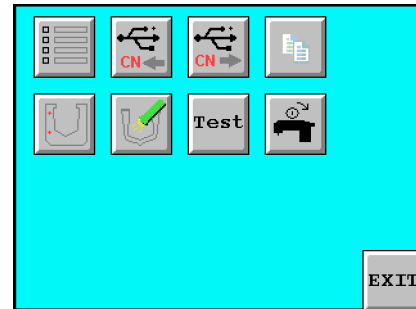


Fig.11

12.1.3 Press the button “CN OUT” . The screen as fig. 12 will appear.




Fig.12

12.1.4 Select the program from the list by using the arrows.

12.1.5 Press the button “DELETE” . The confirming screen will appear.

12.1.6 To cancel the operation press the button “X”, get back to the previous screen.

12.1.7 To confirm the removal press the button “CONFIRM” . The previous screen will appear (Fig 12), check on the program list whether the removal have been made correctly.

12.1.8 Press the button “EXIT” . The screen as fig. 10 will appear.


12.1.9 Press the button “EXIT” . The screen as fig. 4 will appear.

12.1.10 Press the button “RESET”  to get back to the main screen as fig.6.

If “PROGRAM NOT FOUND” will appear on the “warning” (17) string, select an existing program from the program list on the machine memory or on the USB key.

13 PROGRAM TRANSFER FROM THE MACHINE MEMORY TO THE USB KEY

13.1.1 Connect the USB key to the proper device

13.1.2 Deactivate the “AUTOMATIC” button , press the pedal until the screen as fig. 7 appears.

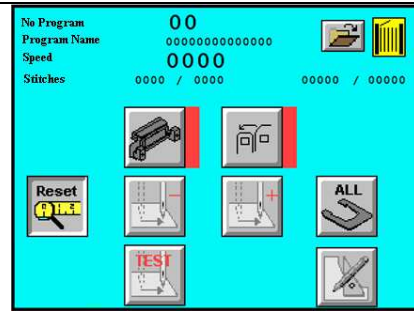



Fig.7

13.1.3 Press the button “SETTING” . The screen as fig. 10 will appear.

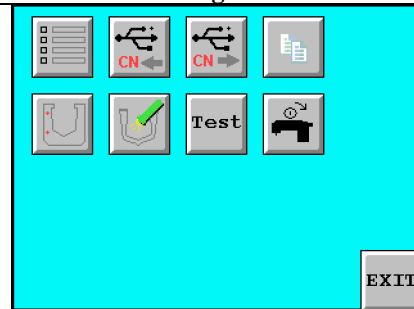



Fig.10

13.1.4 Press the button “CN OUT” . The screen as fig. 12 will appear.

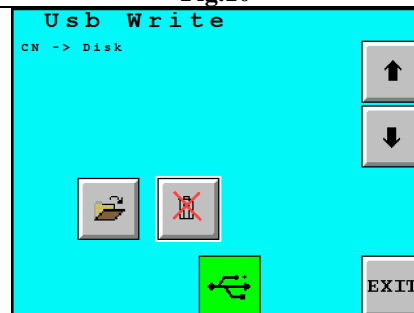




Fig.12

13.1.5 Check that the USB icon  is green (the USB key is displayed correctly), select the program to be saved by using the arrows.

13.1.6 Press the button “FOLDER” 

13.1.7 Wait for the copy to be made. The confirmation screen will appear.

13.1.8 To cancel the operation press the button “X”. Get back to the previous screen.

13.1.9 To confirm the removal press the button “CONFIRM” . The previous screen (Fig 12) will appear, wait for the program list existing in the machine memory to appear again.


13.1.10 Repeat the operations from 13.1.5 to 13.1.9 to save other programs.

13.1.11 Press the button “EXIT” , the screen as fig. 10 will appear.

13.1.12 Press the button “EXIT” , the screen as fig. 4 will appear.

13.1.13 Press the button “RESET” , to get back to the main screen fig. 6.

14 PARAMETERS

14.1.1 Deactivate the “AUTOMATIC” button , press the pedal until the screen as fig. 7 appears.

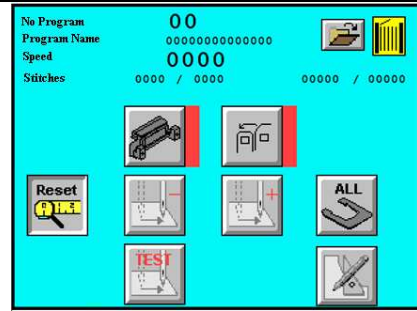



Fig. 7

14.1.2 Press the button “SETTING” , the screen as fig.10 will appear.

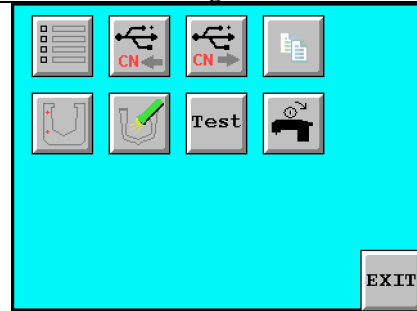



Fig.10

14.1.3 Press the button “PARAMETERS” , the screen as fig. 13 will appear.

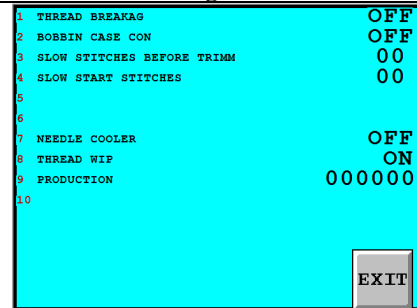


Fig.13


14.1.4 To modify a parameter press on the parameter value.


14.1.5 In case of numerical values a numerical keyboard will appear.


14.1.6 Enter the new value.

14.1.7 Press “ENTER”. Get back to the previous screen (Fig.13).

14.1.8 In case of alphabetical values, the value will change by pressing on it.






14.1.9 Once all the parameters have been set, press the button “EXIT” , the screen as fig. 10 will appear.

14.1.10 Press the button “EXIT” , the screen as fig. 4 will appear.

14.1.11 Press the button “RESET” , to get back to the main screen as fig. 6.

15 THREAD WINDING ON THE BOBBIN

15.1 WITH MECHANICAL WINDER

- 15.1.1 Set the empty bobbin on the proper pin.
- 15.1.2 Wind the thread on the bobbin manually for a few rounds.
- 15.1.3 Hook the full bobbin signal lever.
- 15.1.4 Take off the thread from the needle.
- 15.1.5 Deactivate the “AUTOMATIC” button , press the pedal until the screen as in fig. 7 appears.
- 15.1.6 Press the button “BOBBIN WINDING” , the sewing head starts turning and the bobbin starts to be filled up.
- 15.1.7 When the full bobbin signal lever gets automatically unhooked, press the button “BOBBIN WINDING”  to stop the sewing head.
- 15.1.8 Take out the full bobbin from the pin.
- 15.1.9 Cut the thread.
- 15.1.10 Set the full bobbin in the bobbin case, do the threading following the proper passages.
- 15.1.11 Set the bobbin case inside the proper place located under the sewing head following the correct direction.
- 15.1.12 Do the needle threading.
- 15.1.13 Press the button “EXIT” , the screen as fig. 4 will appear.
- 15.1.14 Press the button “RESET”  to get back to the main screen as fig. 6.

The bobbin winding can be made even when the machine is running by following the operations described on 15.1.1, 15.1.2, 15.1.3 while working normally.

15.2 WITH ELECTRONIC WINDER

- 15.2.1 Set the empty bobbin on the proper pin.
 - 15.2.2 Wind the thread manually on the bobbin for a few rounds.
 - 15.2.3 Press the red button, the bobbin starts turning.
 - 15.2.4 When the thread on the bobbin will stop the full bobbin sensor signal, the bobbin will stop.
- If the thread on the bobbin is too much or not enough, adjust the full bobbin sensor.
- 15.2.5 Execute the operation as described from 15.1.8 to 15.1.11.

16 JIG REPLACEMENT

- 16.1.1 Press button “ALL”  on the main screen (Fig. 6). The jig components releasing screen will appear as fig. 14

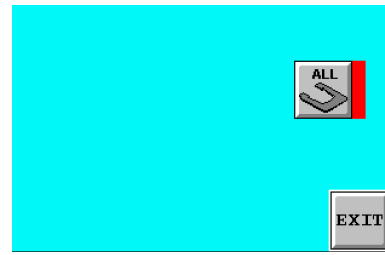


Fig.14

- 16.1.2 Press the button “ALL” , (which becomes green ) , to release the loading clamp, the external sewing clamp, the internal retractable or fixed sewing clamp

- 16.1.3 Take off the loading clamp by pulling it rightward.

- 16.1.4 Take off the external sewing clamp by pulling it backward.

INTERNAL RETRACTABLE SEWING CLAMP:



- 16.1.5 Release the air pipes from the one-way pipe fittings.

- 16.1.6 Take off the internal retractable sewing clamp by pulling it backward.

INTERNAL FIXED SEWING CLAMP

- 16.1.7 Take off the internal fixed sewing clamp by pulling it backward.


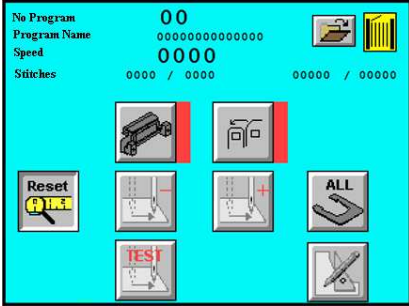

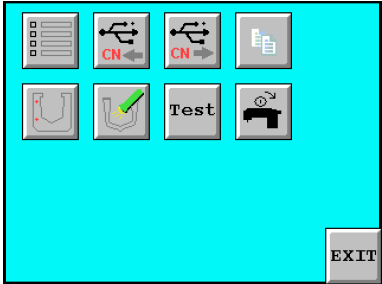

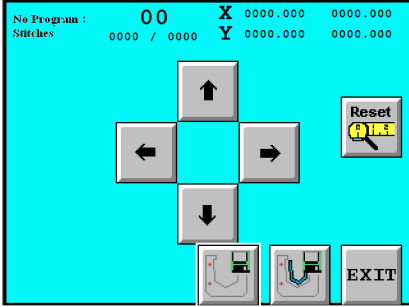


- 16.1.8 Replace all the clamps with the new ones (in case of using the internal retractable sewing clamp it is possible to replace only the blades).

- 16.1.9 Once replaced all the clamps in the proper blocks and, in case of internal retractable sewing clamp, once connected the air pipes to the proper one-way pipe fittings, press the button “ALL”  (which becomes red ) to block the clamps.

- 16.1.10 Check that all the clamps are correctly blocked.

- 16.1.11 Press the button “EXIT”  to get back to the main screen as Fig.6.


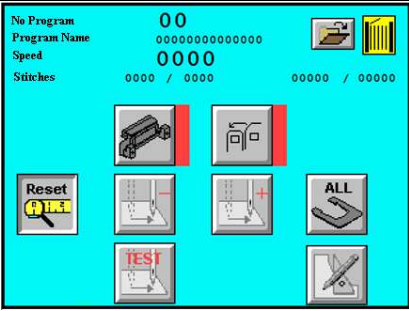

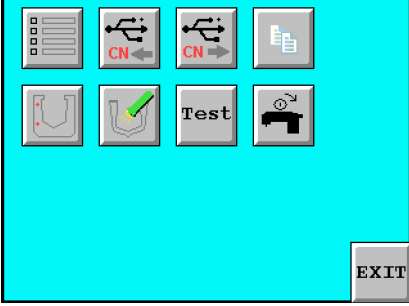

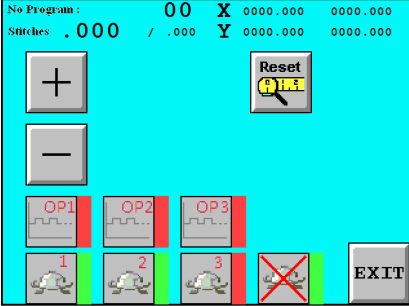

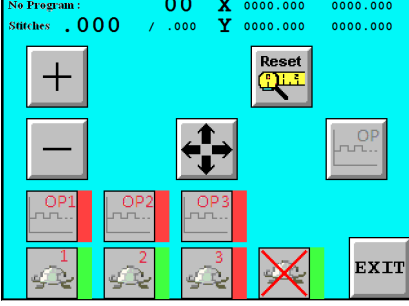
17 LOADING POINT ADJUSTMENT

<p>17.1.1 Deactivate the “AUTOMATIC” button , press the pedal until the screen as fig. 7 appears.</p>	 <p style="text-align: center;">Fig.7</p>
<p>Press the button “SETTING” , the screen as in fig. 10 will appear</p>	 <p style="text-align: center;">Fig.10</p>
<p>17.1.2 Press the button “LOADING POINT” , the screen as fig. 15 will appear.</p>	 <p style="text-align: center;">Fig.15</p>
<p>17.1.3 Press the pedal to make the jig move forward until it reaches the position upon the external loading clamps.</p> <p>17.1.4 Press the pedal to lower the loading clamp upon the external sewing clamp.</p> <p>17.1.5 Check with the proper pins that the loading clamp centring holes match with the external sewing clamp holes.</p> <p>17.1.6 If the centring holes of the two clamps do not match, lift up the loading clamp by hand.</p> <p>17.1.7 Move the sewing clamps by using the direction arrows.</p> <p>17.1.8 Check the centring through the proper pins.</p> <p>17.1.9 Repeat the operation until the loading clamp will be centred with the external sewing clamp.</p> <p>17.1.10 Press the pedal to lift up the loading clamp.</p> <p>17.1.11 Press the pedal to make the loading clamp return back.</p> <p>17.1.12 Press the button “SAVE LOADING POINT” , to save the new loading position and get back to the previous screen (Fig. 10).</p> <p>17.1.13 Press the button “EXIT” , the screen as fig. 4 will appear.</p>	


17.1.14 Press the button “RESET” , to get back to the main screen fig. 6.

18 SEWING PROGRAMS ADJUSTMENTS

Before any adjustment or move of the sewing programs make a copy of the program to be modified or moved.

<p>18.1.1 Deactivate the “AUTOMATIC” button , press the pedal until the screen as fig. 7 appears.</p>	 <p style="text-align: center;">Fig.7</p>
<p>18.1.2 Press the button “SETTING” , the screen as fig. 10 will appear.</p>	 <p style="text-align: center;">Fig.10</p>
<p>18.1.3 Press the button “SEWING PROGRAM ADJUSTMENT” , the screen as fig. 16 will appear</p>	 <p style="text-align: center;">Fig.16</p>
<p>18.1.4 Press the button , the sewing clamps move to the first stitch of the sewing program and the screen as fig. 17 will appear.</p>	 <p style="text-align: center;">Fig.17</p>

18.2 MOVING THE SEWING PROGRAM

18.2.1 Press the button “MODIFY PROGRAM” , the screen as fig. 18

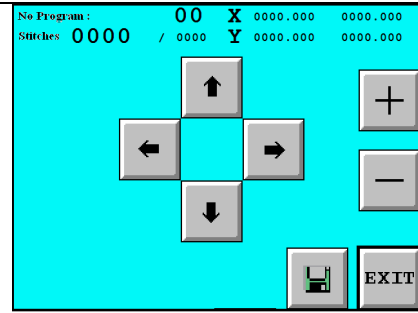




Fig.18

18.2.2 Press the button  up to the last stitch or press on the number of the stitch (check the “stitches” string **Stitches 0000** / 0000 paying attention to the quantity of stitiches of the sewing program), the numerical keyboard will appear.


18.2.3 Enter the quantity of stitiches of the sewing program.

18.2.4 Press “ENTER” to get back to the previous screen (Fig.18).

18.2.5 Press the button  and the sewing clamps will move to the last stitch.

18.2.6 Move to the desired position by using the direction arrows.

18.2.7 Press the button “SAVE”  to get back to the screen as fig. 17.


18.2.8 Press the button “EXIT” , the machine will take back the sewing clamps to their home position. The screen as in fig. 10 will appear.

18.2.9 Press the button “EXIT” , the screen as fig. 4 will appear.

18.2.10 Press the button “RESET”  to get back to the main screen as fig. 6.

BEFORE EXECUTING THE PROGRAM CHECK THE STITCHING PATH THROUGH THE “STITCHING TEST”

18.3 HOW TO MOVE A SEGMENT OF A STITCH ON THE SEWING PROGRAM

18.3.1 Press the button  on the screen as fig. 17 up to the beginning of the segment to be moved.

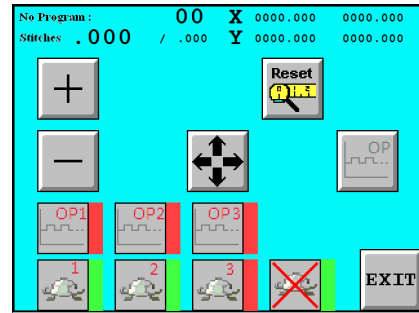



Fig.17

18.2.1 Press the button “MODIFY PROGRAM” , the screen as fig. 18 will appear

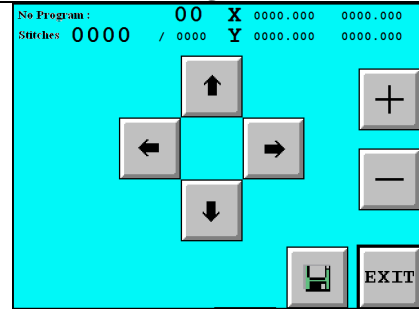




Fig.18

18.3.2 Press the button  up to the end of the segment to be moved.

18.3.3 Move to the desired position using the direction arrows.

18.3.4 Press the button “SAVE”  to save the movement made.

18.3.5 Repeat the operations from 18.3.1 to 18.3.4 to move another stitch or segment.

In case any error occurs during the screen saving (fig. 18) the icon “MODIFY PROGRAM ERROR”  will appear, repeat the modification procedure starting from the original sewing program.

THE MACHINE CANNOT MAKE STITCHES LONGER THAN 12,7 MM

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ORIGINAL INSTRUCTIONS