



USER'S MANUAL PARTS BOOK

Version 03



ISO 9001 Certification of Quality System

FORTUNA

AC Servo Motor series III



- 1) For at most use with easiness, please certainly read this manual before starting use.
- 2) Keep this manual in safe place for reference when the machine breaks down.



SUNSTAR MACHINERY CO., LTD.



1. Thank you for purchasing our product. Based on the rich expertise and experience accumulated in industrial sewing machine production, SUNSTAR will manufacture industrial sewing machines, which deliver more diverse functions, high performance, powerful operation, enhanced durability, and more sophisticated design to meet a number of user's needs.
2. Please read this user's manual thoroughly before using the machine. Make sure to properly use the machine to enjoy its full performance.
3. The specifications of the machine are subject to change, aimed to enhance product performance, without prior notice.
4. This product is designed, manufactured, and sold as an industrial sewing machine. It should not be used for other than industrial purpose.



SUNSTAR MACHINERY CO., LTD.

DAS
Certification

Scope of Quality Approval

The following Company

SUNSTAR ELECTRIC CO., LTD.

The Company has been approved for the following scope of operation:

**Manufacture, Sale and Servicing of Motors and Controllers
for Sewing Machines and Embroidery Machines**

Scope of approval: **NACE 19, Electrical and optical equipment**

Date of Certificate Issue: 26th November 2003

Certificate Valid until: 26th November 2006

Certificate Number: K01-1714

Authorized *D.A. Smiles*

Date 03rd December 2003

DAS CERTIFICATION Ltd.

**Company Number: 3384526
6 Amber Court, Crich Lane,
Belper,
Derbyshire DE56 1 HG
Telephone & Fax: +44 (0) 1773 828586**

DAS
Certification
ISO 9001: 2000
Approval



MANUAL CODE 번호
SIIIK001-04



USER'S MANUAL

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SAFETY INSTRUCTION

Be sure to read and keep in mind the following instructions before you install and use the FORTUNA SERVO MOTOR.

1) Use and Purpose

This product is designed, manufactured, and sold as an industrial sewing machine. It should not be used for other than industrial purpose.

2) Working Environment

① Power Source

- It is desirable that voltage of the power source be kept within the range of $\pm 10\%$ of the rated voltage.
- It is desirable that frequency of the power source be kept within the range of $\pm 10\%$ of the rated frequency. (50/60Hz)
- The SERVO MOTOR can be expected to work normally only in case the foregoing things are kept.

② Electromagnetic Noise

- It is desirable that those equipments causing strong electromagnetic field or high frequency not use the same electrical outlet as this one and stay away from it.

③ Temperature and Humidity

- Keep the ambient temperature above 5 degrees and below 40 degrees Centigrade.
- Never use it outdoors and avoid direct ray of light.
- Keep it away from a hot object like a stove.
- Keep the ambient humidity above 30% and below 95%.

④ Never use it near gases and explosives.

⑤ Do not use it at a spot located 1,000m or higher above sea-level.

⑥ Keep the storage temperature higher than 25 degrees below zero and lower than 55 degrees Centigrade when not in use.

3) Installation

Follow the instruction carefully when installing it.

① Be sure to start installing it after pulling the power plug off the outlet.

② Fix the cable so that it may not move, and do not allow the moving parts like belts to be interfered with. (keep distance of at least 25mm from them.)

③ Be sure to have the Controller, the Motor and the sewing Machine grounded.

④ Be sure that the voltage of power source fits the specification of the Controller before the power is on

⑤ Be sure to use Safety Extra Low Voltage when an extra item or an accessory is fitted into the Controller.

4) Disassembly

① In disassembling it, be sure to wait at least 360 seconds before taking any action after pulling the plug off the power source after turning it off.

② When pulling off the plug from the power source, be sure to hold the plug itself instead of the wire connected to the plug.

5) Service and Maintenance

- ① Make sure that service and maintenance are carried out by a skilled technician.
- ② Never try to operate with the Motor and the Controller open.
- ③ When inserting a thread into or touching the machine, be sure to turn the power off and step down from the platform.
- ④ Be sure to use standard products specified for replacement of parts.

6) Other Safety Instructions

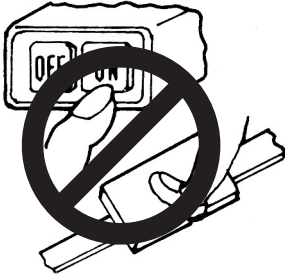
- ① Take care not to let your fingers touch any moving parts including belts.
- ② In case of remodelling or fitting of additional device, be sure to follow safety standards and do not ever try to go ahead based on your own judgments.
- ③ Do not try to operate with the safety device removed.
- ④ Take care not to let water or coffee or something like those admitted into the Controller or the Motor.
- ⑤ Never drop the Controller or the Motor to the ground.

※The instructions presented above are for the safer and more proper operation of the Fortuna Servo Motor. Ignoring such instructions could cause damage to the machine or physical injury of the user. Please follow all the instructions when operating the machine.

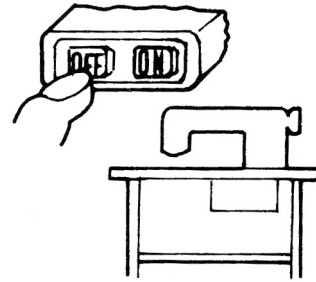
2

PRECAUTIONS BEFORE USE

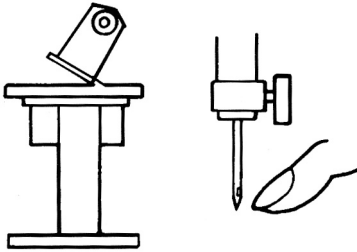
1. Do not turn on the power while stepping on the pedal.



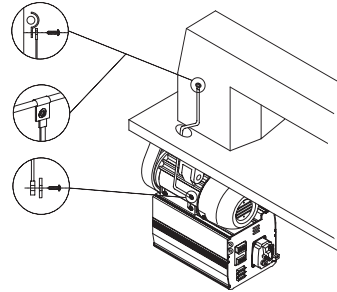
2. Turn off the power when leaving the servomotor overnight.



3. Turn off the power when servicing the servomotor or changing the needle.



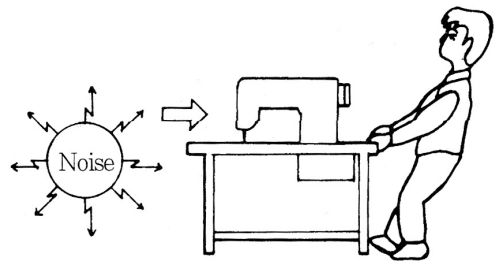
4. Be sure to keep the servomotor securely grounded.



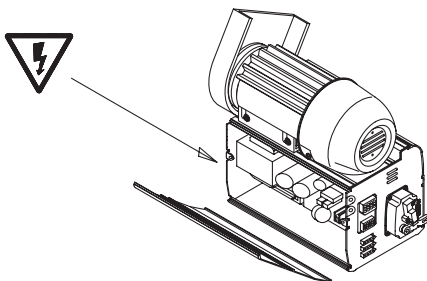
5. Do not connect multiple servomotor power plugs to the same power strip.



6. Install the servomotor away from noise sources, such as high-frequency equipments and welding machines.



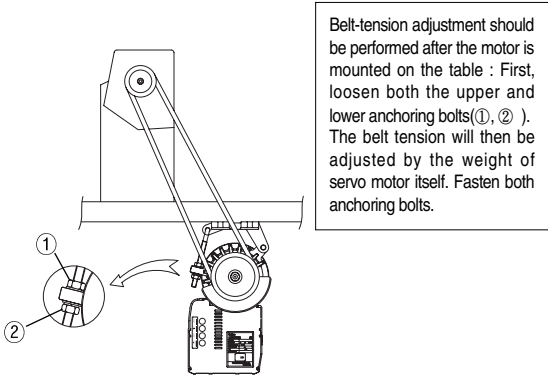
7. Avoid electrical shock when servicing the controller box. (Wait for 6 minutes before opening the cover after turning off the power.)



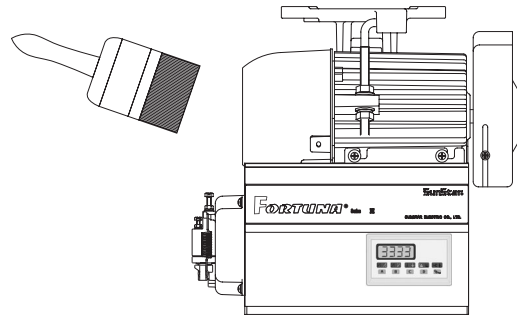
8. When an error message "Er" appears on the digital display, take a note of the "Er" code, and then turn on and off before resuming operation (Contact the local dealer if "Er" message persists on the display)



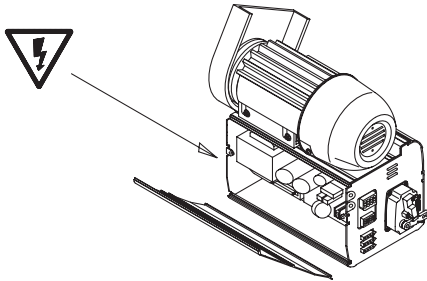
9. Adjust the belt tension to the optimum level.



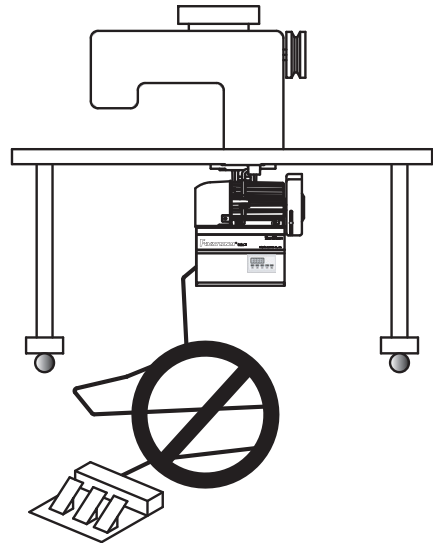
10. Clean it every two or three weeks so that no dirt or a dirty substance may be piled up.



11. When replacing the fuse, use a standard item, opening the cover as shown in the diagram.



12. Make the length of the cable connected with an outside parts like stand-up pedal as short as possible.

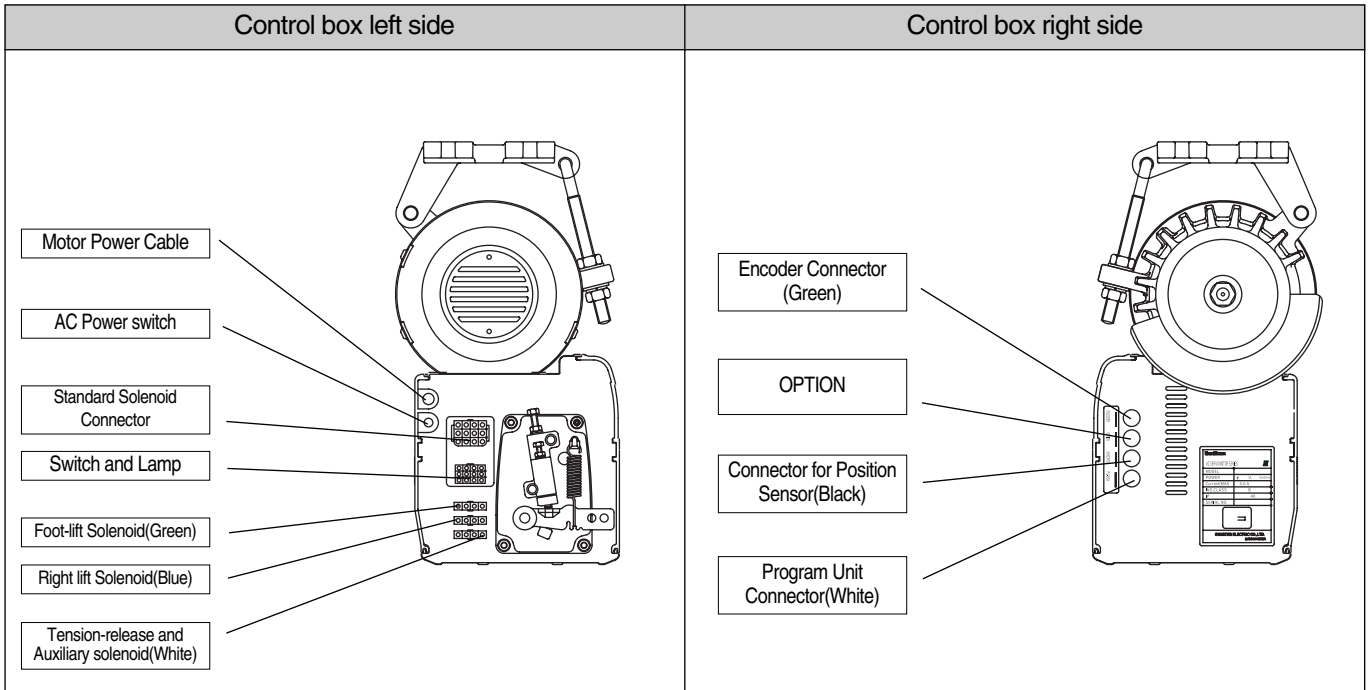


F1	250V/6.3A
F2	250V/6.3A
F3	250V/6.3A
F4	250V/1A

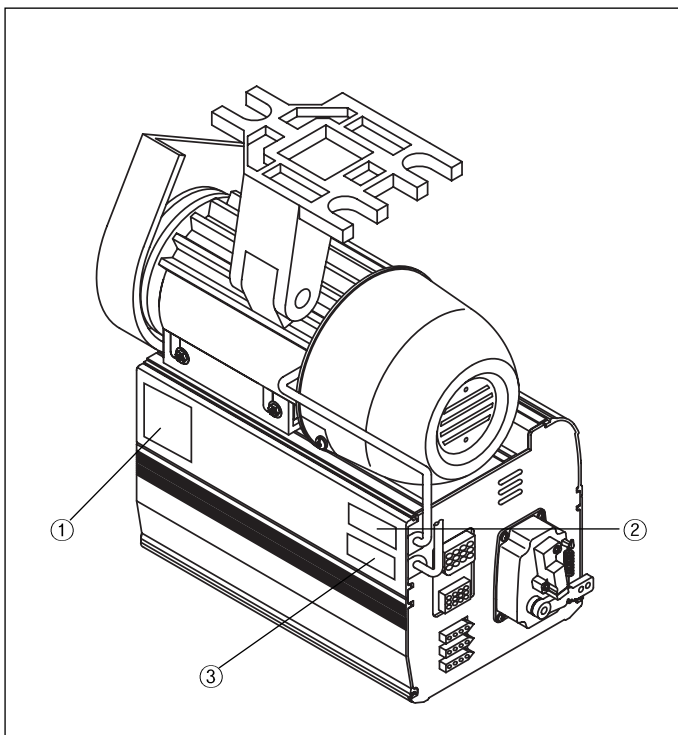
3

LOCATING AND USING PARTS OF THE CONTROLLER BOX

1) Left and right side of control box



2) Rear panel



① Caution



WARNING
경 고



Hazardous voltage will cause injury.
Be sure to wait at least 360 seconds before opening this cover after turn off main switch and unplug power cord.

고압 전류에 의해 감전될 수 있으므로 커버를 열 때는 전원을 내리고 전원 플러그를 뽑고 나서 360초간 기다린 후 여십시오.

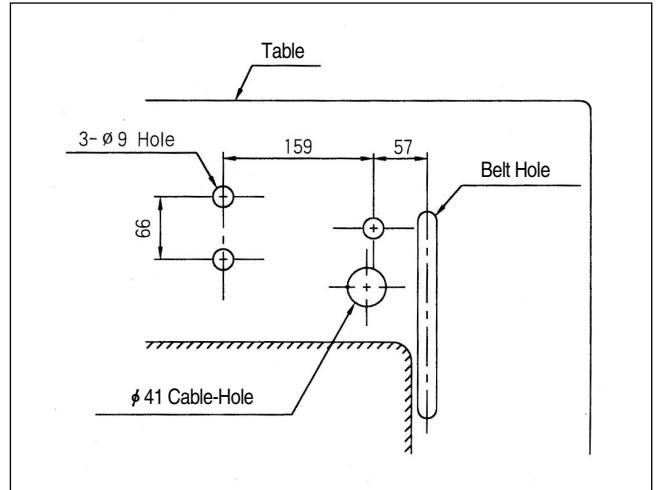
- ② Motor
- ③ AC INPUT

4

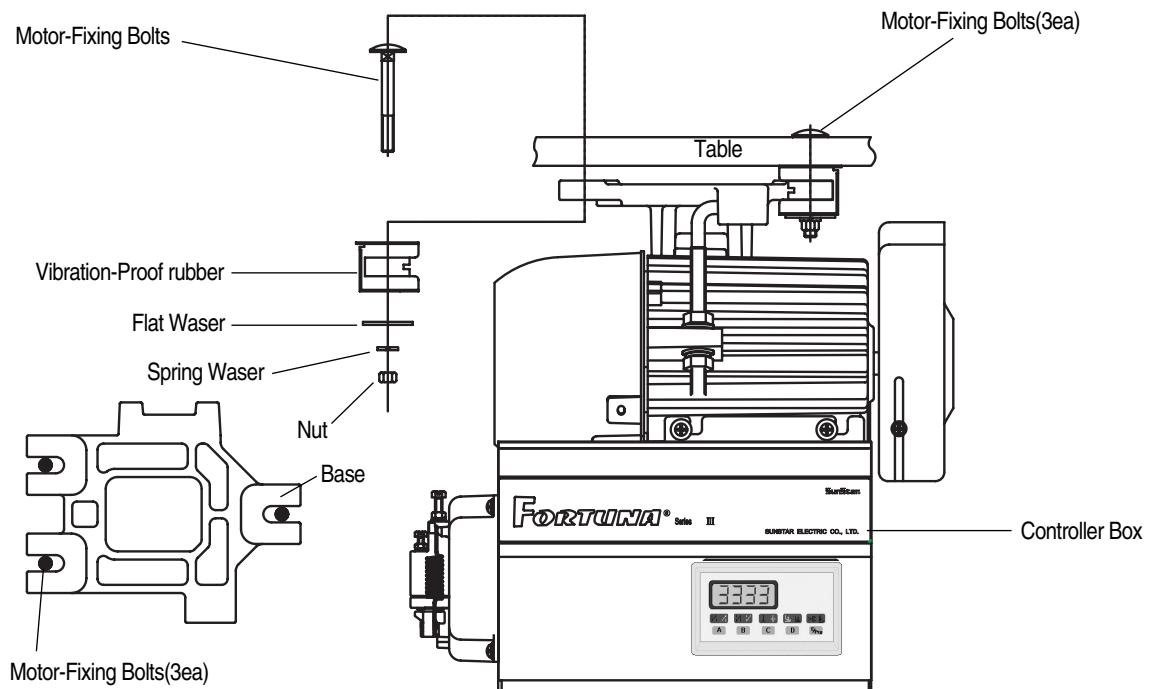
INSTALLATION

1) Mounting your Servo Motor on the table

- ① Make sure that the holes are bored on the table as shown in the figure.



- ② Insert three motor-fixing bolts through the three holes on the table. Attach the motor base padded with vibration-proof rubber, and slide flat and spring washers over the bolt stems, and then fasten the bolts with nuts.

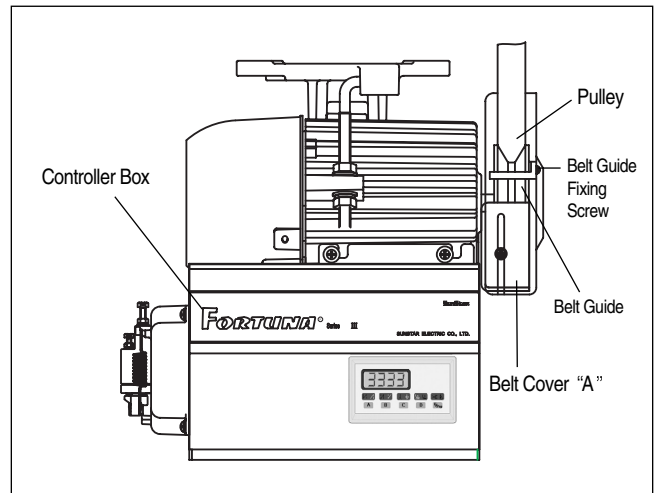


- ③ Make sure that the center of motor pulley is matched to that of the sewing machine before tightening the motor-fixing bolts and nuts.

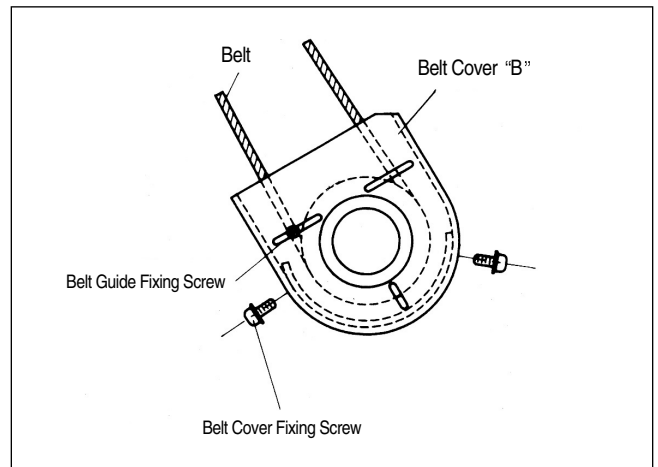
2) Assembling the belt cover and adjusting the belt tension

(1) Belt cover assembling procedure

- ① Upon the completion of the motor mounting, bring the two pulleys of motor and sewing machine closer to each other, by pulling back the sewing machine. You can then mount the belt easily as shown in the figure.

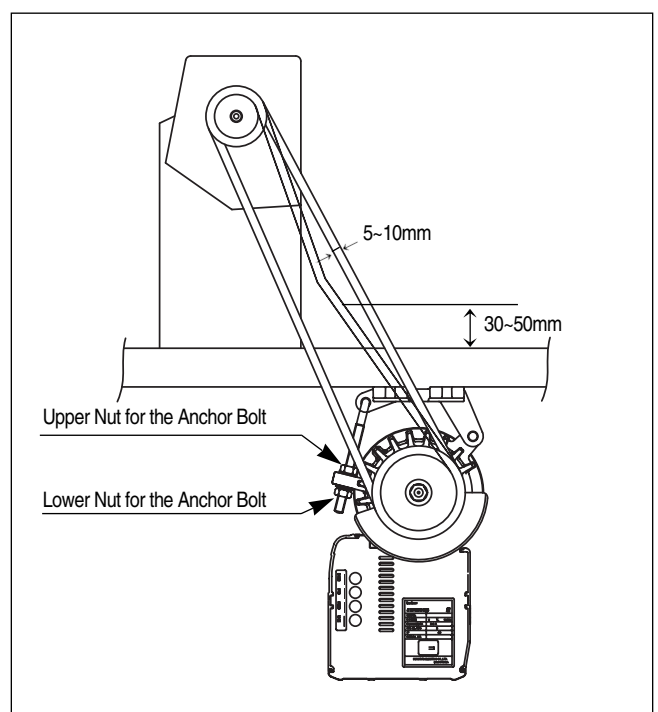


- ② Place the belt cover 'B', making sure that the belt cover does not contact the belt, and then fasten the cover with the fixing screw.



(2) Adjusting the belt tension

- ① Optimum Tension Level : The optimum tension level is achieved when the belt is pushed by 5-10mm when the top surface portion of the belt at about 30-50mm above the tabletop is pressed by a finger with a force of $\sim 1\text{kgm/sec}^2$ or 1 Newton.
- ② Adjusting the Tension Level : If the tension level is out of the optimum range, adjust the tension as follows. First, loosen both the upper and lower nuts for the anchor bolt, letting the belt be stretched by the motor weight itself. Second, tighten the upper nut only to the extent that the motor does not move. Third, fasten the bottom nut tightly so that the motor is securely fixed.

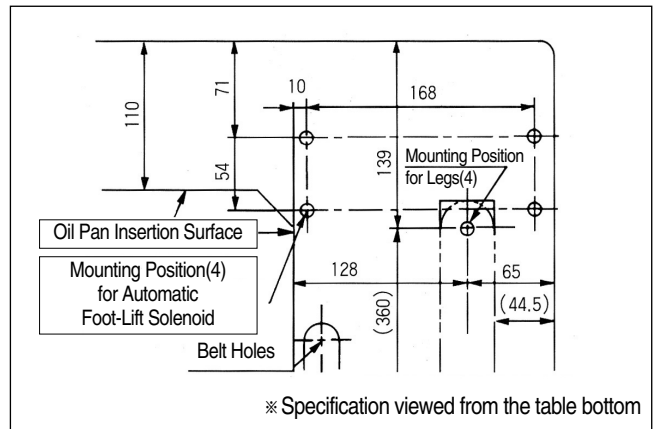


3) Mounting and adjusting the foot-lift solenoid

(1) SunStar KM-235 Model

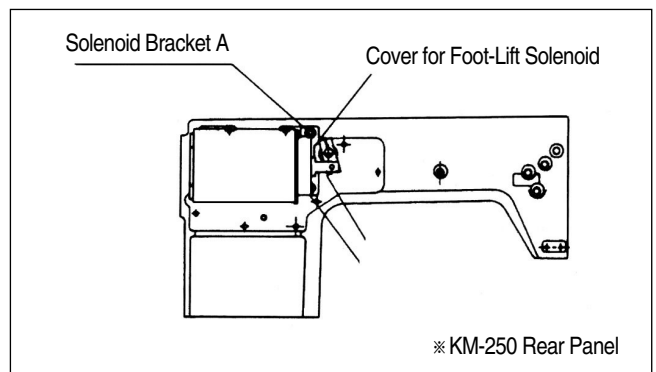
- ① Attach the main power switch first since the power switch is located normally in between the solenoid brackets.
- ② By referring to the figure on the right and the mounting instructions enclosed in the packaging box, locate the insertion surface of the oil pan, and then attach the foot-lift solenoid.

No.	Solenoid No.	Applicable Models
1	SPF-2	KM-235A, B



(2) SunStar KM-250 Model

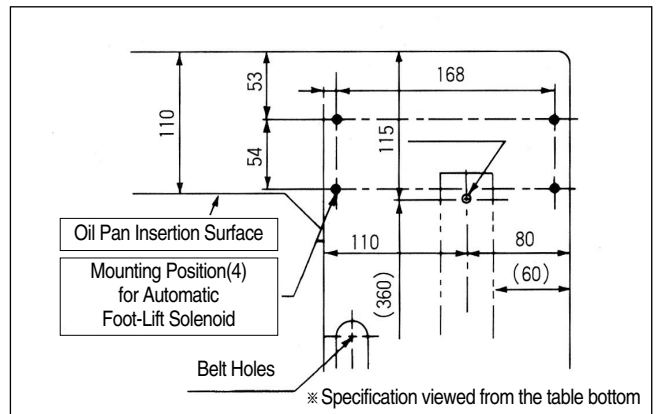
- ① First, assemble a panel for the attachment of presser foot solenoid on the back of KM-250.
- ② Attach the presser foot solenoid to a bracket "A".
- ③ Attach the bracket "A" with the presser foot solenoid to the panel above.
- ④ Attach a crank to a solenoid shaft and then connect it to a sewing machine.
- ⑤ Place a cover on the solenoid.



(3) SunStar Special-specification models

The same mounting procedure for KM-235 model is applicable for other models listed below.

No.	Solenoid No.	Applicable Models
1		KM-750-7, KM-750BL-7
2	SPF-3	KM-790-7, KM-790BL-7
3		KM-857-7, KM-867-7
4	SPF-4	KM-560-7
5	SPF-6	KM-957-7, KM-967-7
6	SPF-8	KM-757-7
7	SPF-9	KM-640BL-7



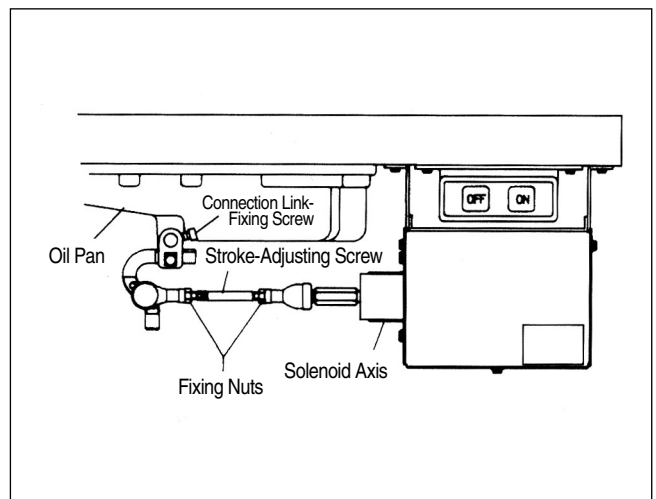
(4) Adjusting the stroke(Gap) of the automatic foot-lift solenoid

① Check point

Check to make sure that the stroke-adjusting screw is located at the center of the solenoid axis, i.e., the solenoid should be assembled in parallel with the bottom surface of the table. If the solenoid is not in parallel, make an adjustment so that the screw is in parallel with the center of the solenoid axis using the connection link-fixing screw.

② Adjusting Procedure

The vertical travel distance of the presser foot can be adjusted by the stroke-adjusting screw. First, Loosen the two fixing screws, and adjust the vertical stroke using the stroke-adjusting screw. loosening and tightening the stroke-adjusting screw will decrease and increase the vertical stroke of the presser foot respectively. After the adjustment, fasten the fixing screw tightly.

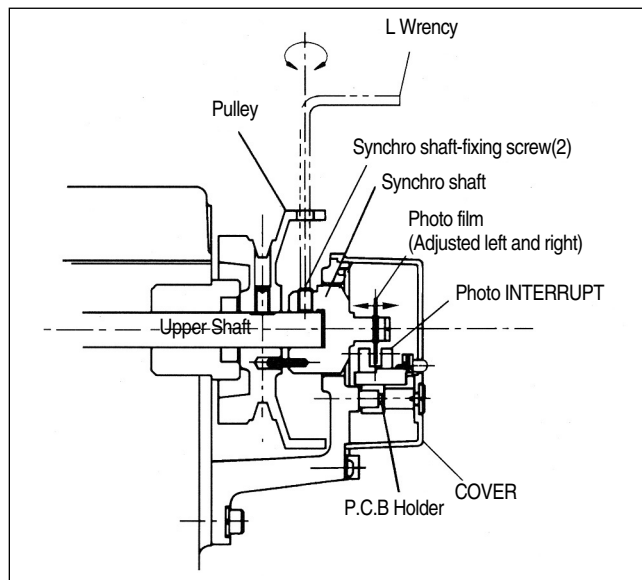


4) Mounting the position sensor (Synchronizer) and setting the film

(1) Mounting the position sensor(Synchronizer)

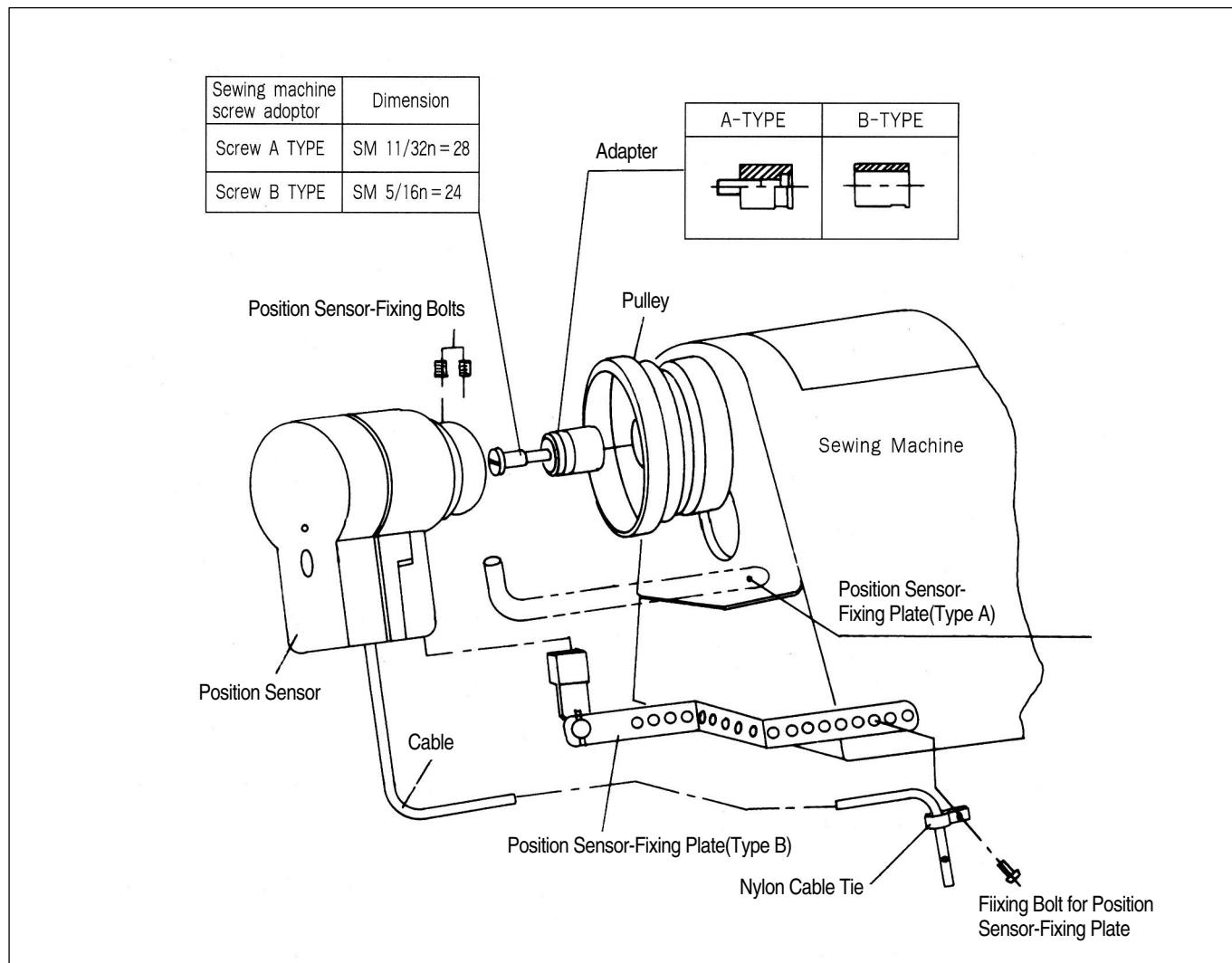
① SunStar thread-cutting sewing machine.

All SunStar thread-cutting sewing machines are equipped with a position sensor. Users, therefore, are required to adjust the film position, if necessary, as shown in the figure.



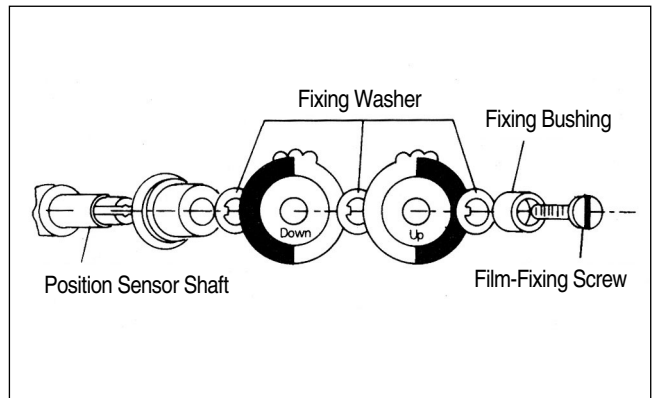
② All other sewing machines(including other manufacturers' brands)

First, attach the position sensor-mounting adapter to the upper shaft of the sewing machine. Second, attach the position sensor-fixing plate to the body of the sewing machine as shown below in the figure. Third, secure the position sensor to the adapter with the fixing screws.

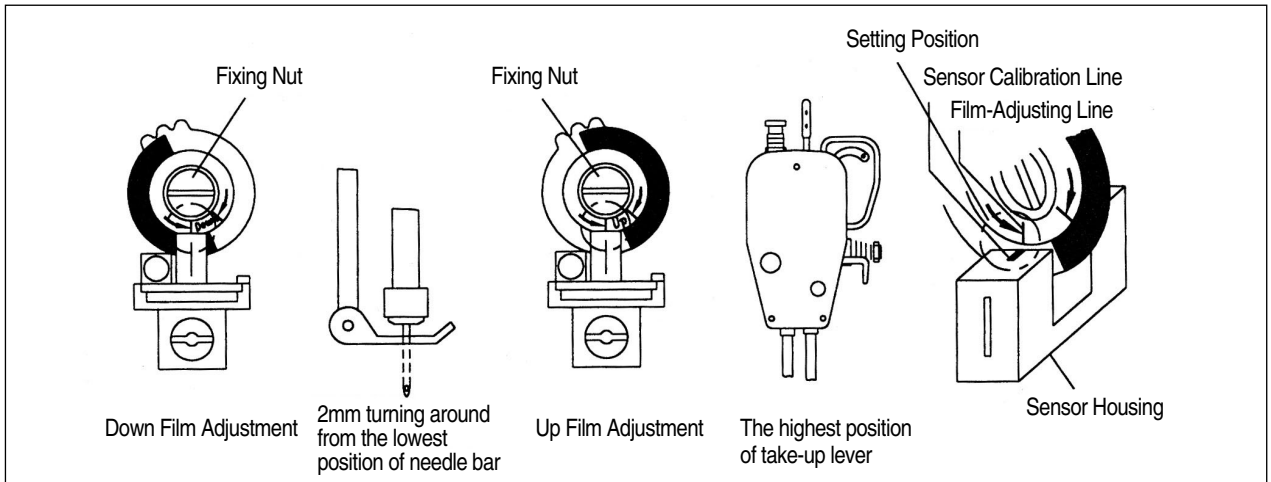


(2) Adjusting the film of the position sensor

① Assemble the films and position sensor in the order as shown in the figure.

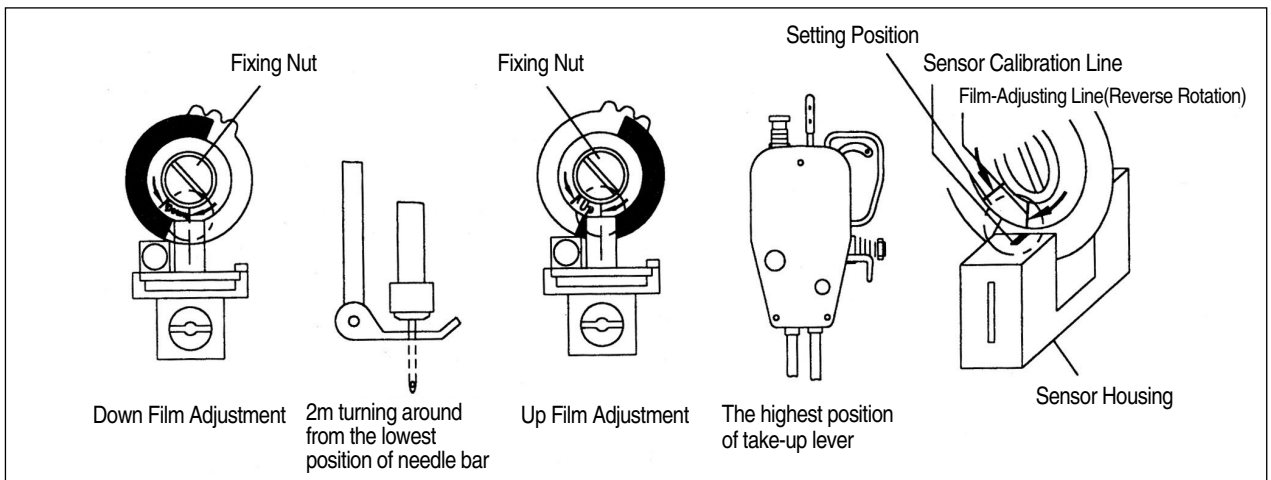


② Upon the completion of the assembling, position the needle shaft tight at the rising point from the lowest needle position by manually rotating the pulley. Loosen the film-fixing screw, and adjust the DOWN film so that the film-adjusting line and the sensor housing calibration line are matched. Tighten the film-fixing screw just to the extent that the film can not be rotated. Likewise, position the thread take-up at the highest position. Loosen the film-fixing screw, and adjust the UP film as shown in the figure, while using caution not to move the DOWN film which is already adjusted earlier. Tighten the adjusted film with the fixing screw.



(3) Adjustment the films of reverse rotation sewing machines

※For reverse-rotation sewing machines, the film-adjusting lines located at right edge of the “UP” and “DOWN” film should be matched to the center line of the sensor.



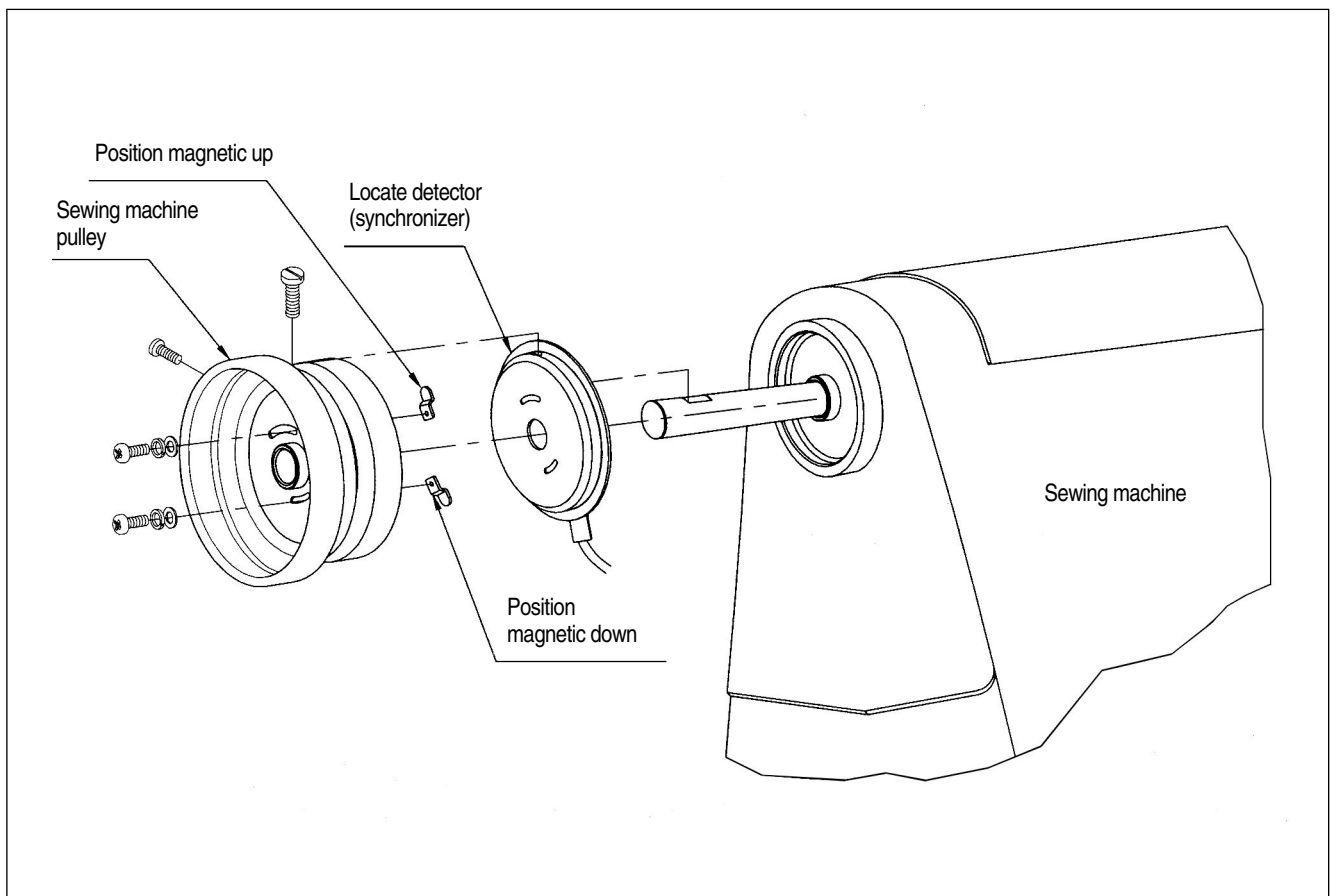
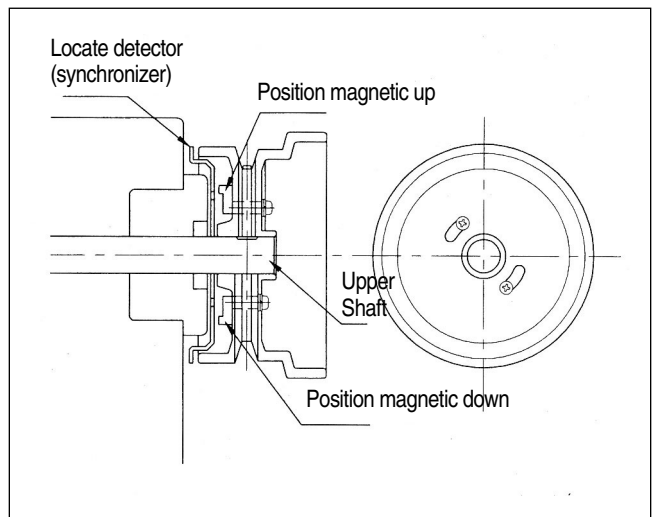
[Caution]
After adjustment the film of the position detector, be sure to rotate the motor for 3~5 seconds by pedalling so that the Controller may remember location of the film.

5) How to equip and adjust a built-in location detector(synchronizer)

(1) How to equip the built-in location detector (synchronizer)

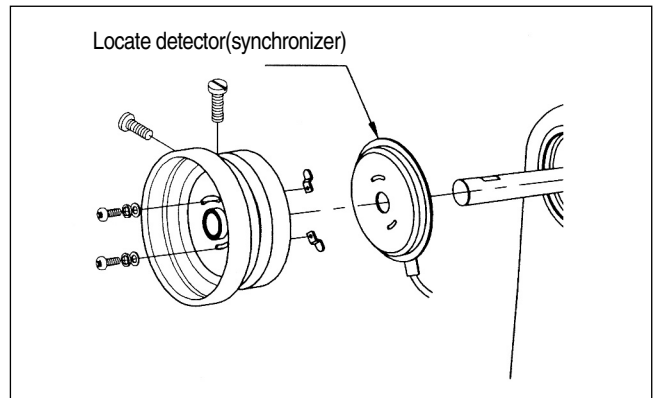
► In case of a SunStar thread trimmer

When a built-in location detector(synchronizer) for the sewing machine with the SunStar thread trimmer is equipped, all that the users need to do is to simply adjust the location of magnetic for detection according to their needs.

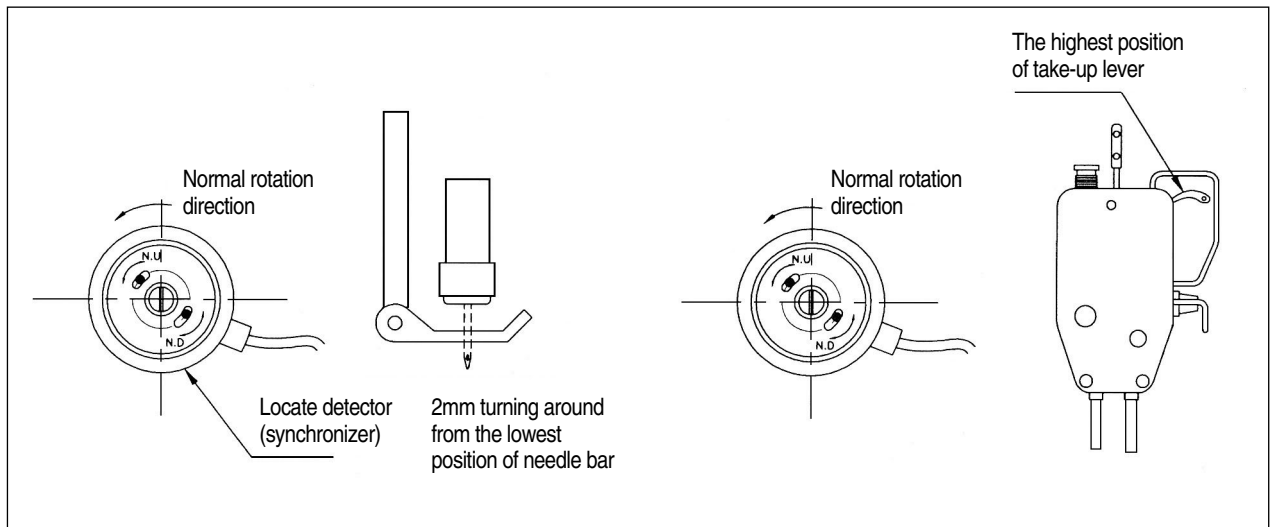


(2) How to adjust the magnet of the location detector

① Assemble the detector in order following the pictures.

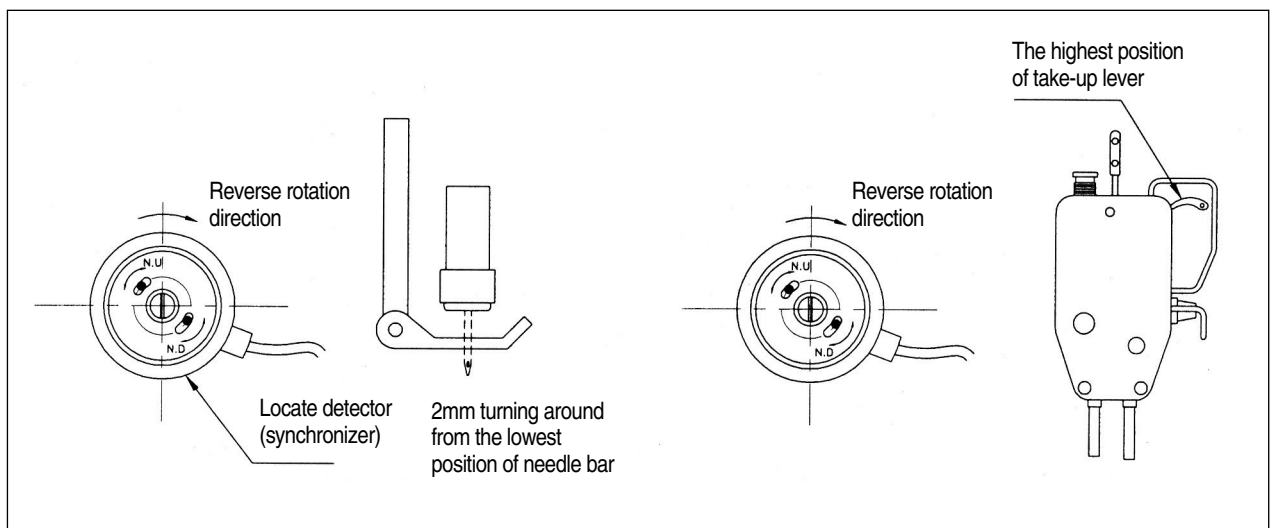


② Once assembling is completed, power the controller on and step on the pedal. At this time, make sure that the needle moves up and down. Stop the needle at a desired location by moving the magnet back and forth along the location where the needle stops.



(3) How to adjust a location detector in case of a reverse rotation sewing machine

※It is the same as that used for the normal rotation direction



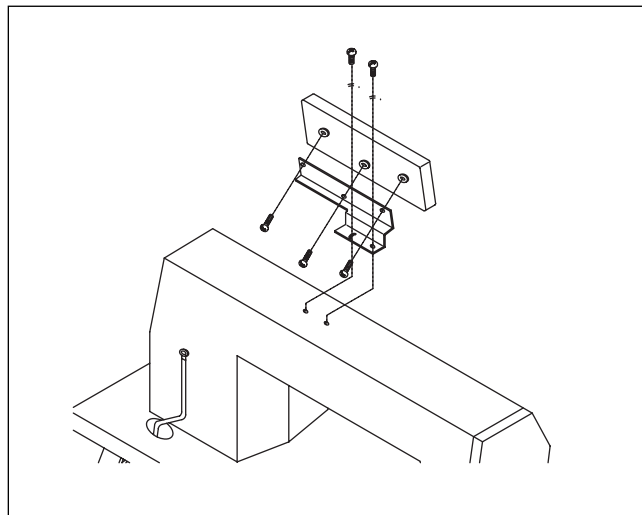
[Note]

After adjusting a location detector, rotate the motor by stepping on the pedal for 3-5 seconds so that a controller can remember the location.

6) Mounting the Program Unit(P/U)

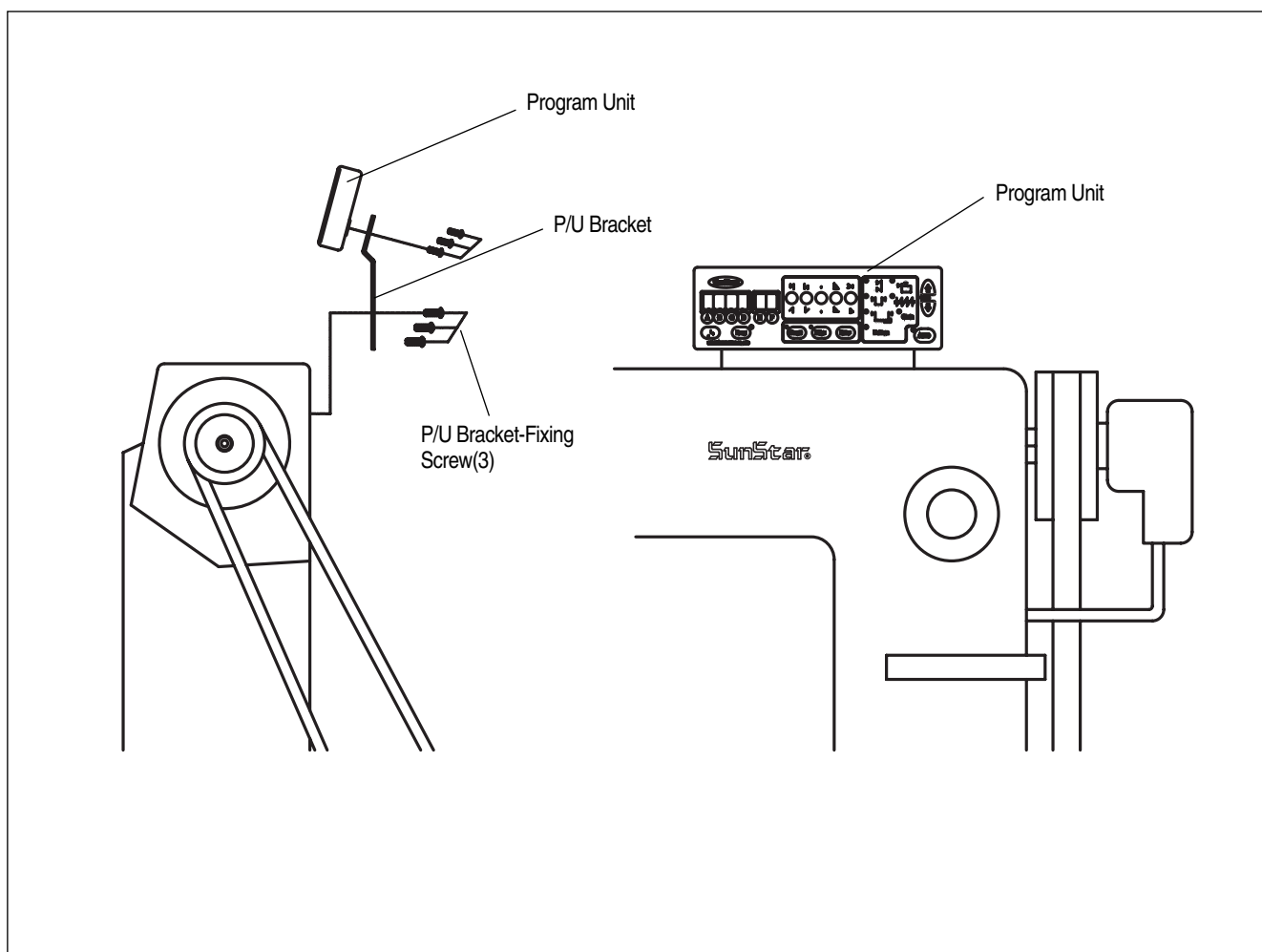
(1) SunStar KM-235 Sewing Machine

First, attach the P/U bracket to the P/U using three fixing screws and a supporting bolt with nut attached on it as shown in the figure. Second, securely attach the P/U to the head of the sewing machine using two fixing screws and washers, keeping a 3~4mm distance between the bottom surface of the nut and the base of the supporting bolt.



(2) Other SunStar thread-machine

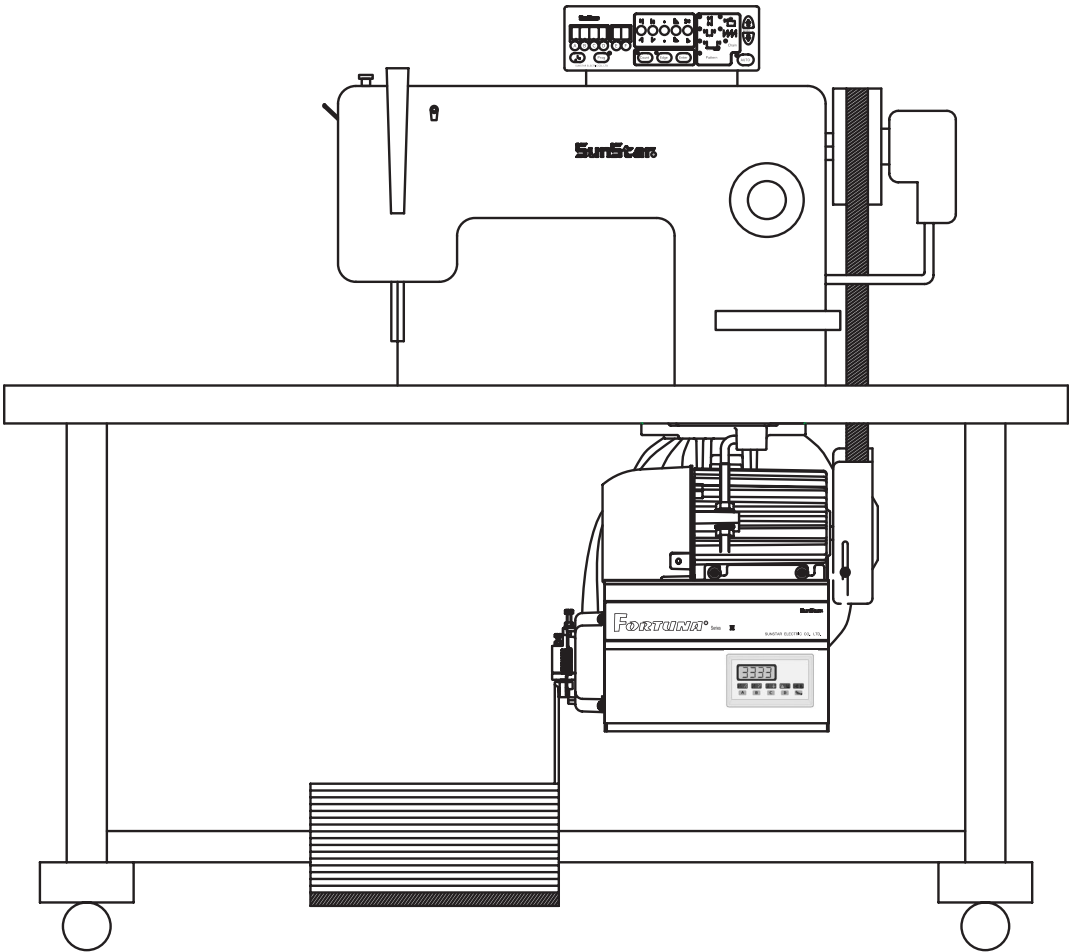
First, attach the P/U bracket to the P/U using the four fixing screws. Second, attach the P/U to the main body of the sewing machine using the three bracket-fixing screws as shown in the figure.



[Caution]

Fix the cable using the cable tie so that cable is not in the way of the belt.

7) An example of installing the SunStar sewing machine

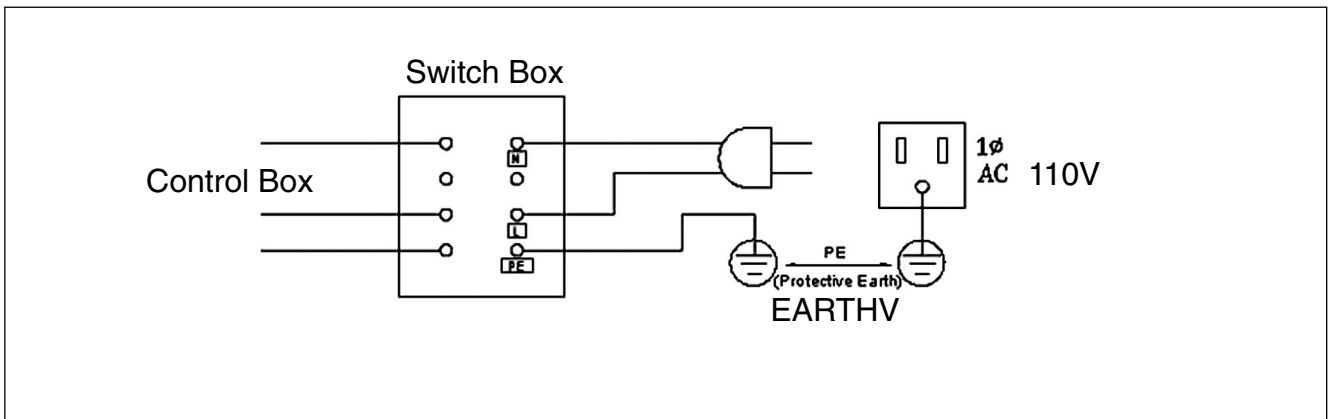


5

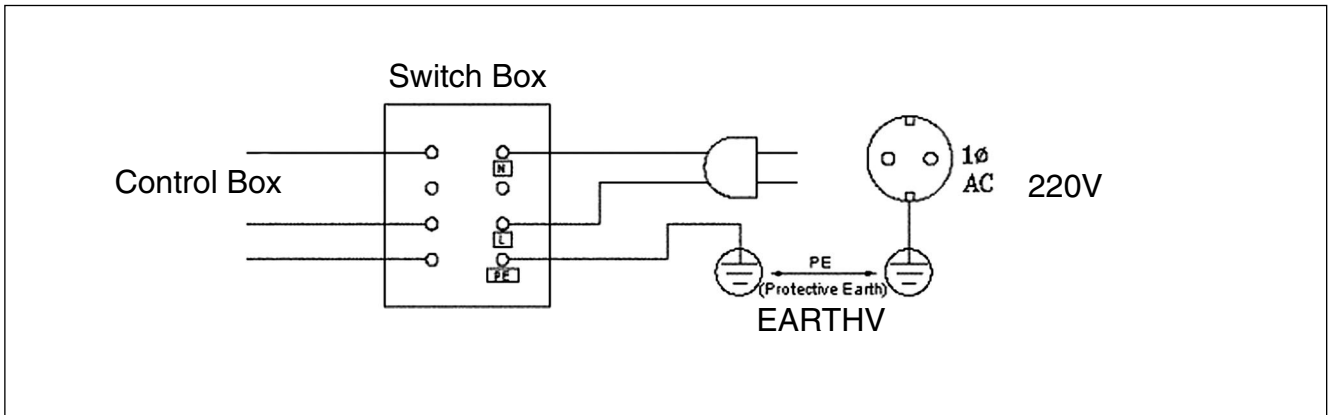
WIRING AND GROUNDING

1) Specification of the power plug

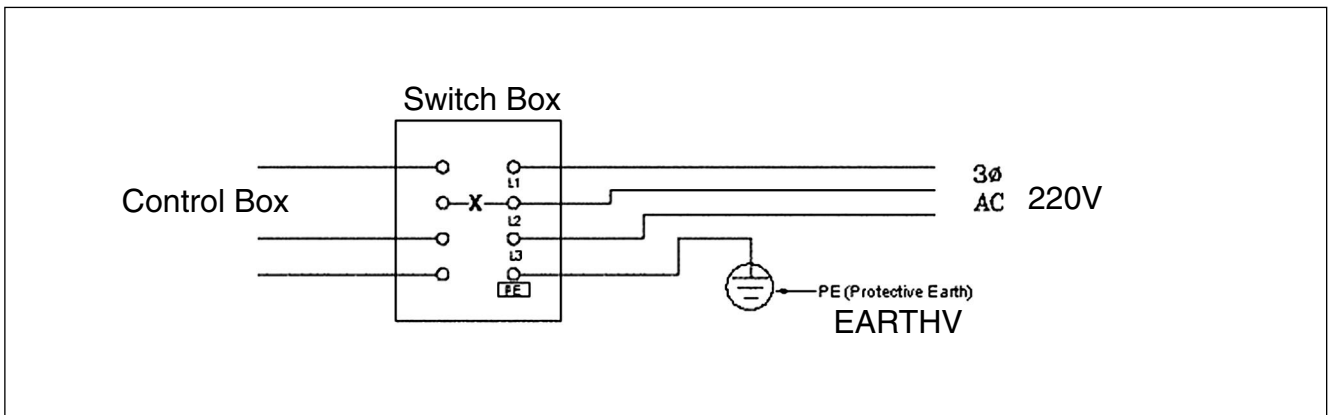
(1) Single phase 100V~120V



(2) Single phase 200V~240V



(3) Three phase 200V~240V



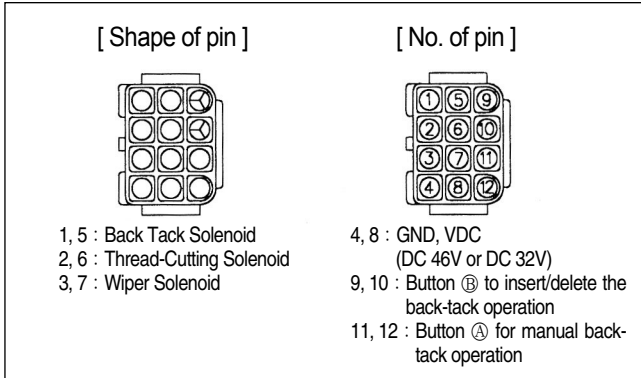
※ Be sure to connect Protective Earth

2) Specification of electric current in wiring of power plug

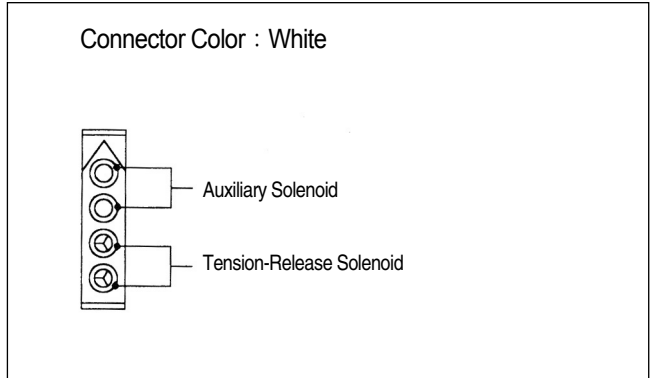
Be sure to use wiring materials which can stand electric current of higher than 15A.

3) Name and description on the outside connector of control box

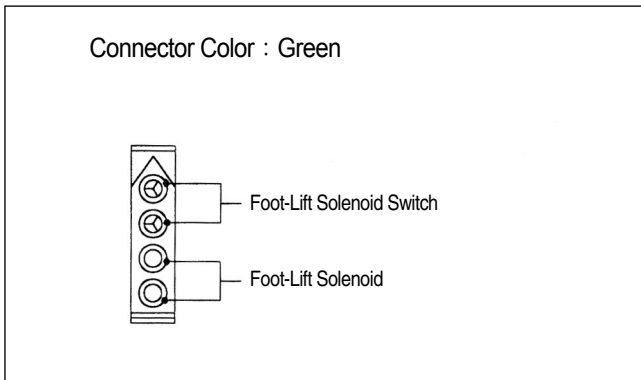
① Standard solenoid connector



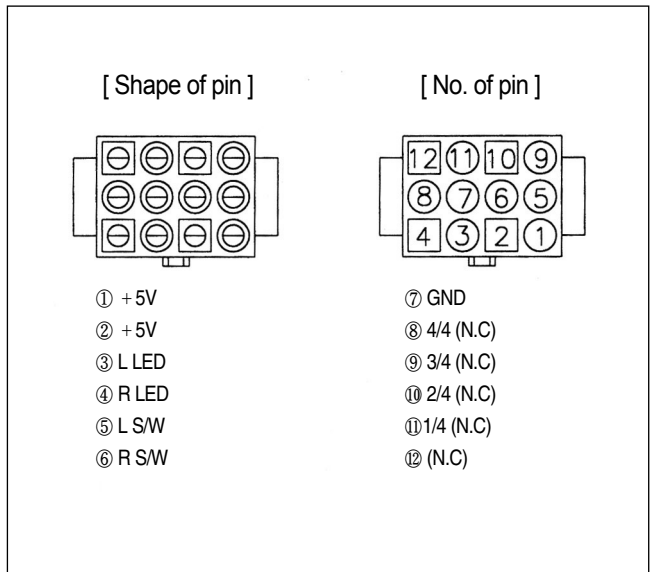
④ Tension-release and auxiliary solenoid



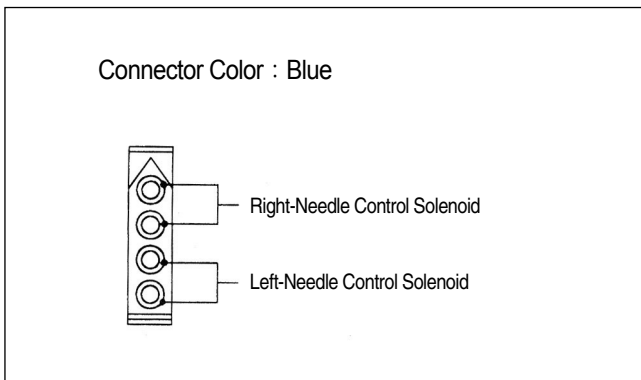
② Foot-lift solenoid



⑤ Switch and lamp(Used in twin-needle sewing machine)



③ Right/Left solenoid(Used in twin-needle sewing machine)



4) How to change the electric voltage supplied for solenoid (The factory installed setting is : J2)

※ This is to make the movement of solenoid smooth in times of fluctuation in the incoming electric voltage.

① Set Value for electric voltage supplied (for 220V series) for Solenoid against the incoming voltage.

For 30V-regular Solenoid

Incoming Voltage	Set Value
Below 210V	J5
210V~230V	J6
Above 230V	J7

For 24V-regular Solenoid

Incoming Voltage	Set Value
Below 180V	J5
180V~190V	J6
Above 190V	J7

② Set Value for electric voltage supplied (for 110V series) for Solenoid against the incoming voltage.

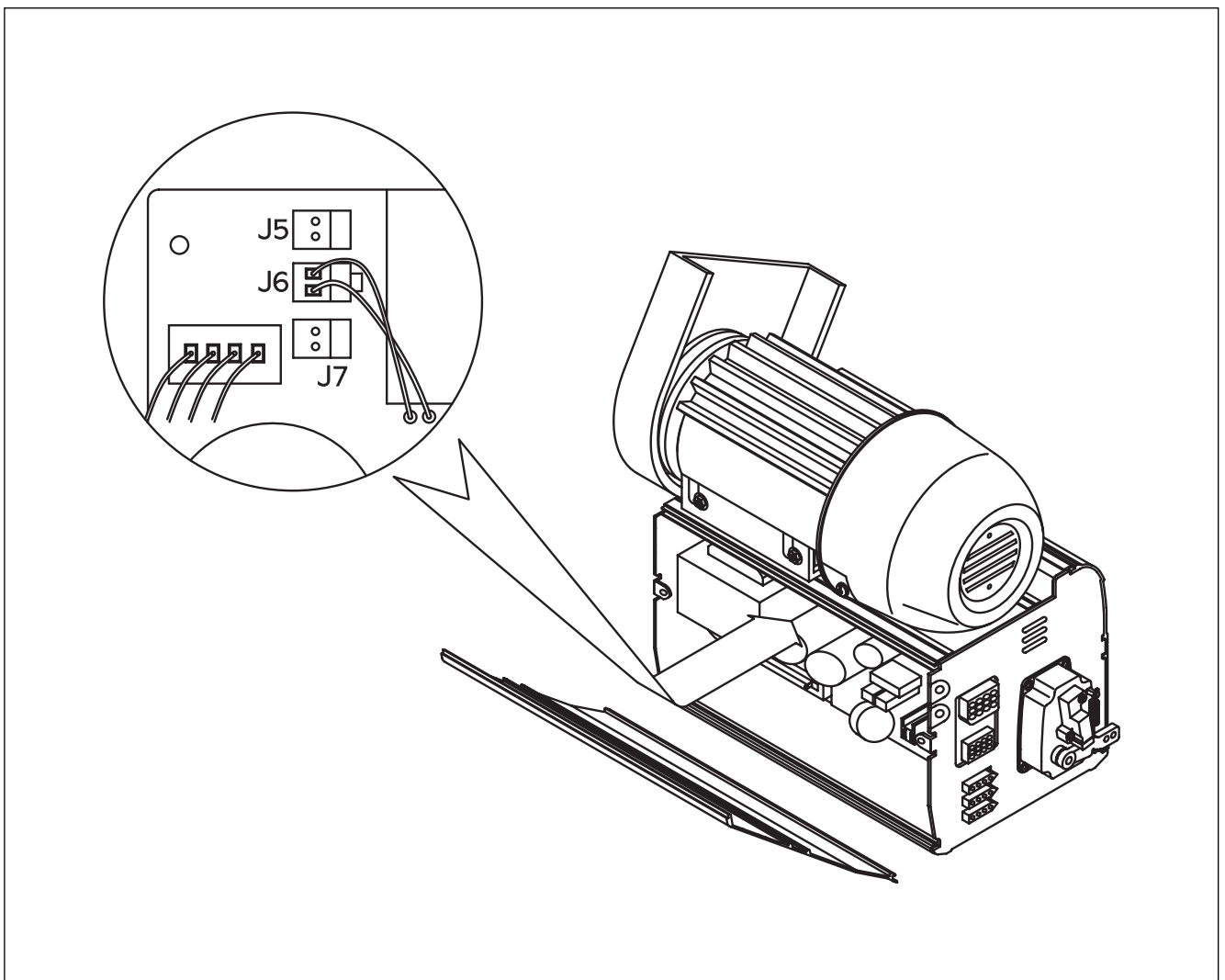
For 30V-regular Solenoid

Incoming Voltage	Set Value
Below 100V	J5
100V~120V	J6
Above 120V	J7

For 24V-regular Solenoid

Incoming Voltage	Set Value
Below 90V	J5
90V~100V	J6
Above 100V	J7

③ Setting of pin



6

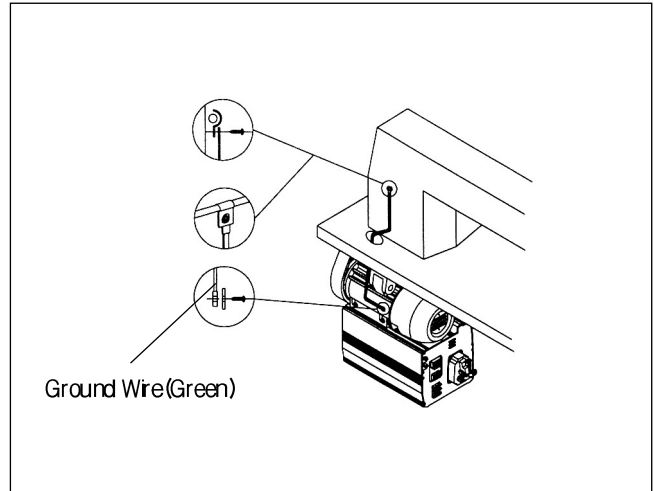
CONNECTION THE EARTH WIRE OF THE SEWING MACHINE AND MOTOR

► Method

Connect the motor and sewing machine using the ground wire (green, green/yellow) as shown in the figure. Make sure that the factory-connected ground wire between the controller box and motor is securely in place.

► Caution

Failure to ground the motor can cause abnormal operations, such as overspeed rotation or unwanted stitching.



7

THINGS TO BE CHECKED AFTER INSTALLATION

1) Before the power is on...

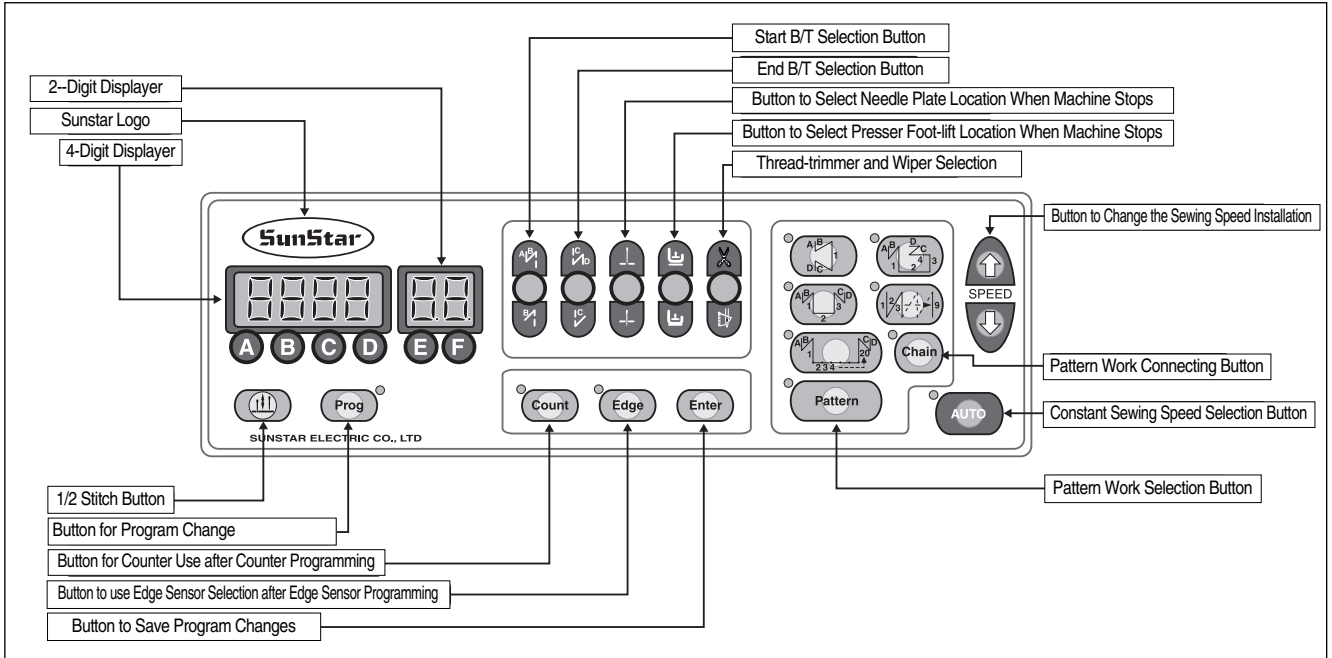
- ① Make sure that the incoming voltage is in accordance with that shown in the name plate of the Control box.
- ② Check whether the following connectors are connected.
 - Connector for incoming AC power source
 - Connector for motor power
 - Connector for motor encoder
 - Connector for pedal
 - Connector for position detector
 - Connector for others (option, knee-lift, program unit etc.)
- ③ Check to see whether the belts are in touch with the wiring.
- ④ Check the tensile strength of the belts.
- ⑤ Check to see the fixing nuts for pulley are tightly fastened.
- ⑥ Check whether the sewing machines are right kinds (Chain Stitch S/M, Lock Stitch S/M)
- ⑦ Check the rated voltage for Solenoid (Refer to “How to change the electric voltage supplied for Solenoid”)

2) After the power is on...

- ① Check whether the lamp for the position detector is on. (Except in the case of built-in position detector)
- ② Check whether the program unit is working.
- ③ Check the direction of rotation of the Sewing Machine.
 - In case the direction of rotation is not right, action shall be taken to change set it right, referring to “the methods of changing the program and the list of changing functions”(N. 65 in Group “A”)
- ④ Check to see whether there are abnormal heat, smell or noise nearby.
 - In case there are, turn the power off and call our regional office.

PROGRAM UNIT PART NAMES AND METHOD OF USE

1) Program unit part names



2) Program Unit Method of Use

(1) 4-Digit Displayer and 2-Digit Displayer Functions and Method of Use

A. 4-Digit Displayer and 2-Digit Displayer Functions

<p>① When you turn the power on, you will see a screen as shown in the figure. The 4-digit displayer shows the start and end B/T sewing and the 2-digit displayer shows the current abbreviation for the letters or numbers shown in the 4-digit displayer (bt: the abbreviation for back tack),</p>	<p style="text-align: center;"><Initializing screen></p>
<p>② The 4-digit displayer shows the error number for each type of error discovered and also shows the programmed value after it has been programmed. The 2-digit displayer shows the number of the parameter specific item's content or name which is shown in the 4-digit displayer.</p>	<p style="text-align: center;"><Example of error detection></p> <p style="text-align: center;"><Example of selection of number 2 item in Group A></p>
<p>[Caution] The 4-digit displayer and 2-digit displayer show the current condition. Therefore the user should always check it before using the machine.</p>	

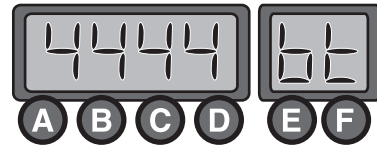
B. Method of Use: 4-Digit Displayer and 2-Digit Displayer

a. Method to change the start and end B/T stitch numbers

In order to change the start B/T stitch numbers which is programmed when you first purchase this machine, you must use the **A**, **B** buttons. If you want to change the end B/T stitch numbers, you must use the **C**, **D** buttons.

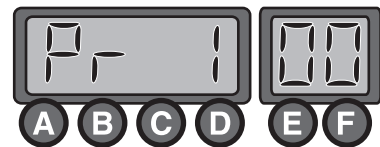
- The program range is from 0 to 9.

(Ex: How the screen looks when changing both start and end B/T stitch numbers to 4).



b. Method to check or change the specifics of the parameter

- 1 Press the **Prog** button and as you press it, also press the **A** button. Then you can either check or change the programming items for the parameter of group A. (A group : **A**, B group : **B**, C group : **C**, D group : **D**)
 ※ Users should turn the machine off to select B, C, or D group. While pressing the **Prog** button, turn the power switch on. The screen will be changed to the initial screen after showing the "PrEn" message. Then, the users can select B, C, or D group by pressing B, C, or D button while holding program **Prog** button.



- 2 You can move to the parameter item you want with the **E** and **F** buttons. The parameter item number will appear in the 2-digit displayer and the wanted value will appear in the 4-digit displayer.

(Ex) Screen showing the maximum speed limit preset in the item 2 of A group)



- 3 After using the **C** (increase) button and **D** (decrease) button to choose the value you want, press the **Enter** (Enter) button and save the value you chose. (Ex: Reducing the maximum sewing speed limit from 4000RPM to 3000RPM).



- 4 After saving, press the **Prog** button and go back to the initial screen.



[Caution]

- Be aware that if you don't press **Enter** after changing the programmed value for the parameter item, the value will not be saved.
- When the B, C, or D group selection is completed, users should turn off the machine first and restart to secure the selected group.
- If the user changes the programmed value from the parameter specifics carelessly, the user may cause break down or physical damage to the machine. The user must therefore be well-trained before changing the parameter group.

(2) Method of Use : 1/2 Stitch Button Function

- 1 When necessary, make 1/2 stitches by pressing the 1/2 stitch () button.

- 2 When the needle plate makes a down stop, shortly press the 1/2 stitch () button once and the needle plate will make an up stop.






And when the needle plate makes an up stop, shortly press the 1/2 stitch () button once and the needle plate will make a down stop.

[Caution]

Be aware that if you are continuously pressing the 1/2 () button, the machine will keep on moving at the 1/2 stitch () speed.

(3) Method of Use: Start B/T Button

This button is used when the user wants to prevent threads from loosening at the end of the sewing work. If the user presses this button in sequence, the location on the lights will change. This button offers the following three functions.






 <p>When sewing starts, B/T sewing does not operate.</p>	 <p>When sewing starts, B/T sewing is operated with the</p>  <p>button.</p>	 <p>When sewing starts, B/T sewing is operated with the</p>  <p>button.</p>
---	---	---

Using the A, B buttons in the 4-digit displayer, the user can program the B/T number of stitches he/she wants.

[Caution]
Be aware that if the start B/T stitch is set to '0' in the 4-digit displayer, the start B/T sewing is impossible.

(4) Method of use: End B/T Button

This button is used when the user wants to prevent threads from loosening at the end of the sewing work. If the user presses this button in sequence, the location on the lights will change. This button offers the following three functions.





 <p>When sewing ends, B/T sewing does not operate.</p>	 <p>When sewing ends, B/T sewing can be operated with the</p>  <p>button.</p>	 <p>When sewing ends, B/T sewing can be operated with the</p>  <p>button.</p>
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Using the C, D buttons in the 4-digit displayer, the user can program the B/T number of stitches he wants.

[Caution]
Be aware that if the end B/T stitch is set to '0' in the 4-digit displayer, the start B/T sewing is impossible.





(5) Method of Use: The Needle Plate Position Selection Button When the Sewing Machine Stops

When the user turns the power on, one of the up stop or down stop lights in the program unit panel needle plate is always left on. The user can change the stop location by pressing the button.

 <p>When machine stops while sewing, the needle plate makes an up stop.</p> 	 <p>When machine stops while sewing, the needle plate makes a down stop.</p> 
--	---

(6) Method of Use: The Presser Foot-lift Location Selection Button When the Sewing Machine Stops




When the user turns the power on, one of the up stop or down stop lights in the program unit panel presser foot-lift is always left on. The user can change the stop location by pressing the button.

 <p>When the machine stops while sewing, the presser foot-lift stops at the top.</p> 	 <p>When the machine stops while sewing, the presser foot-lift stops at the bottom.</p> 
---	---

[Caution]
 If the user uses the automatic up stop function of the presser foot-lift when the sewing machine stops while sewing, it may cause damage to it because it has been left up for an unnecessarily long time. Be aware that to prevent the foot-presser solenoid from being damaged, it is programmed to automatically come down when a certain amount of time passes.


(7) Method of Use: Automatic Thread Trimmer and Wiper Selection Buttons

These buttons offer the function of automatic trimming and wiping after sewing. By pressing these buttons in sequence, the user can use one of the following three functions. The light shows the function that is currently being used.

 <p>Automatic trimmer and wiper do not operate</p>	 <p>Only automatic trimmer function is operate</p>	 <p>Both automatic trimmer and wiper operate</p>
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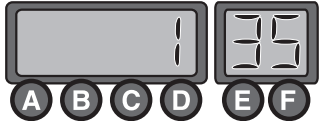
(8) Method of Use: Counter Program Button

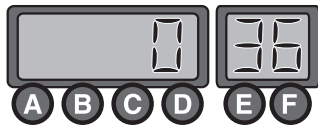
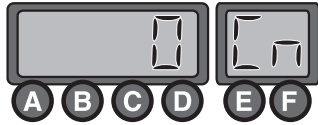

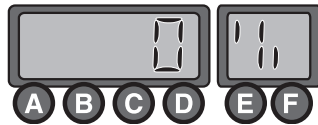

A. Count Function Program Method

<p>After enabling the count function in the parameter specific items, go back to the initial screen. Press the count button. If the light goes on, the user can use the count function.</p>	
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B. Method of Use: Count Specific Functions

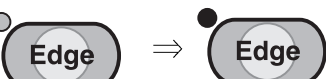
The count button is a button programmed to check the production quantity. In order to operate the functions you want, the user needs to program a few specific items.

<p>① This is a function that checks the production quantity. If you want to use this function, first program the value what you want in the parameter. Ex. B-35 (Item no. 35 in Group B).</p> <ul style="list-style-type: none"> • 0: Program the outer counter switch • 1: Program the automatic count after thread trimming <p>※ The initial value is programmed to be '0.' When there is no outer counter switch the count function does not operate.</p>	
---	---

<p>② Program the parameter B-36 item and you can select the type of production quantity counter.</p> <ul style="list-style-type: none"> • 1: Ascending counter (Up counter) • 0: Descending counter (Down counter) <p>※The initial value is programmed to be "1."</p>	
<p>③ Program the counter function by pressing the counter button. If you press the F button you can check and program the specific information.</p> <ul style="list-style-type: none"> • Cn: Current count quantity • rn: Current remaining quantity • %: Production rate • tn: Quantity of total programmed work (Initial value: 100) <p>※If you press the F button continuously, you can see the specific information mentioned above in order. The user can set up the current count quantity(Cn) and the quantity of total programmed work (tn).</p>	<p><Current work quantity></p>  <p><Remaining work quantity></p>  <p><Production rate></p> 
<p>④ After the total work quantity has been done, you can program items B-37 or B-38</p> <p><B-37 item programmed value></p> <ul style="list-style-type: none"> • 0 : programming that enables sewing when the buzzer rings after work is done. • 1 : programming that enables sewing when the buzzer rings after work is done but only after the user presses the Prog button. • 2 : programming that enables sewing after work is done, even when the buzzer doesn't ring <p><B-38 item programmed value></p> <ul style="list-style-type: none"> • 0 : After count is over, it does not automatically change to the initial programmed value. • 1 : After count is over, it automatically changes to the initial programmed value. 	<p><Total programmed work quantity></p> 
<p>[Caution]</p> <p>If the user programs item B-38 to '0' even after the count is over, it will continue to increase or decrease. Therefore, if the user wants to initialize it, he/she must reset the Cn value.</p>	

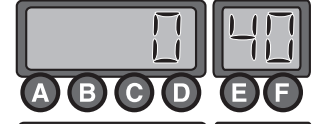
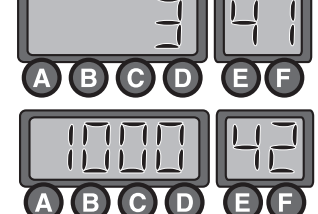
(9) Method of Use: Sewing Material Edge Sensor Selection Button

A. Method of Use: Edge Sensor Function

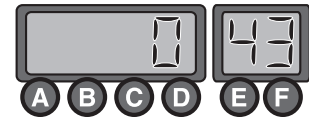
<p>After programming the edge sensing function in the sewing material from the parameter specific items, press the button. If the light goes on, you can start using the edge sensor function.</p>	
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B. Method of Use of Sewing Material Edge Sensor's Specific Functions

The sewing material edge sensor selection button has a function that enables the machine to stop when it senses the end of a sewing material. If you want to operate a particular function, you must program a few specific items.

<p>① User must change item A-40 programmed value according to the characteristic of the installed sensor.</p> <ul style="list-style-type: none"> • 0: When edge sensing, 5V output (Active High) should be the initial value • 1: When edge sensing, 0V output (Active Low) 	
<p>② After sensing, you can set up the movement to item A-41, A-42.</p> <p><Item A-41: the number of stitches it will sew after it senses the edge></p> <ul style="list-style-type: none"> • 0~225: after sensing, the machine will sew as many stitches as it has been programmed to sew. <p><Item A-42: the sewing speed after it senses the edge of material></p> <ul style="list-style-type: none"> • 20~2000RPM: this item sets up the speed of the stitches set to be sewn after it senses the edge. 	

- ③ After sensing the edge of sewing material and the machine has sewn the number of stitches at the programmed speed, the user needs to select item A-43 to change the operation.
- 0 : to stop after sewing the programmed stitch numbers.
 - 1 : to operate automatic thread trimming function after sewing the programmed stitch numbers.



(10) Method of Use: Pattern Work Selection Button

A. Method to Set Up the Pattern Work Function

This function is used when you need to continuously work on a sewing material. If the light goes on after pressing the button, you can use the pattern sewing function.





B. Method of Use of Pattern Sewing Specific Functions



① Cautionary words when using the pattern function

- Before using the pattern function, finish the trimming work and turn on the pattern switch light.
- If the user presses the pattern switch twice when he/she is not using the pattern function, the light will go off and he/she will be able to go back to normal sewing. However, if the pattern mode has not been completely finished, the pattern light will not go off.
- The pattern function sewing speed will be the programmed speed.
- The value set in each pattern mode is not erased when the power is turned off. Therefore, if you want to use the same pattern again, press the same mode again to use it. However, if the program is initialized, all the formerly programmed information will be erased and the user must reset the information again.

② Method of use: function

- first press the  button and select the pattern sewing function.
- Select the pattern you want and the light will go on the pattern you selected.
- If you press the  button, the screen will change and you can use the stitches of each side of the pattern you chose to program the value.

< Method to program the value of each pattern side >

- Method by using the  ,  buttons
 - Inputting directly the number of stitch the user wants by using the buttons C and D. This method is used when the user already knows the length of the stitches he/she is choosing.
- Method using the pedal movement
 - This is a function used when the user does not know the stitch length and sews directly to check the number of stitches for the pattern he/she wishes to program. If the user presses on the pedal after the programming screen comes on, the pedal can program the number of stitches by using the accelerating and decelerating characteristics through the pedal's sensors. The standard for choosing the number of stitches here is slower than the normal sewing speed and the programmed pattern sewing speed.
- Method using the A button and 1/2 stitch button
 - This function is used when the user needs to make small adjustments at the end of the pattern work. It allows the user to check and program the pattern length while he/she sews at a slow speed or sews half stitches.

<Screen showing the programming of stitch numbers for each side>



P : When the AUTO light is off, the machine stops when the pedal is released while sewing.

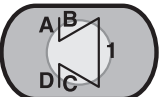
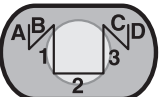
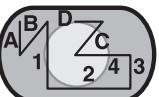
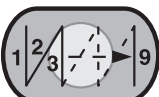
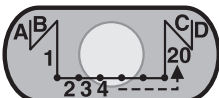
A : When the AUTO light is on, the machine will finish sewing the pattern section even if user releases pedal while sewing.

- d) After programming is finished, press the **Enter** button and save the set up value. Then press the **Prog** button. After the stitch numbers of each side disappear from the screen, you can start sewing with the programmed value in the pattern sewing function.
- e) The pattern sewing speed is constant because it sews at a programmed speed not by the acceleration or deceleration of the pedal. If you press the pedal after pressing the **AUTO** button and see the light blink, sewing will continue until it is finished even if you release the pedal.

[Caution]

- After setting each side of the stitches, the user must press the **Enter** button to save the programmed value.
- When the pattern has more than one side, the pattern work only operates for the number of stitches programmed for each side.

③ Specific items of each pattern

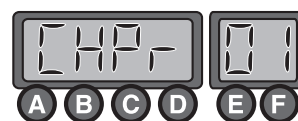
	A convenient pattern for straight sewing at constant speed for a definite length. The sides can be set from 0 to 999 stitches.
	A convenient pattern for repetitive 3-sided sewing. Each side can be set from 0 to 999 stitches.
	A convenient pattern for 4-sided sewing. Each side can be set from 0 to 999 stitches. (Used often in square sewing)
	A convenient pattern when forward/backward sewing is needed continually. forward/backward sewing is possible 9 times. Also each side can be set from 0 to 999 stitches. (This pattern is used for continuous work on back tags of leather belt rings).
	A convenient pattern when the user wants to make many-sided patterns. The user can make patterns of up to 20 sides. Each side can be set from 0~999 stitches.

④ Method of Use : Chain function (pattern linking function)

- First press the **Pattern** button and select the pattern sewing function
- Next, press the **Chain** button.
- If you press the **Prog** button, the screen will change as the figure shows on the right. You can change the number of chains with buttons **E**, **F**.
- If you want to program the number of chains in the pattern you want, use buttons **A**, **B**, **C**, **D**, **E**, **F** to go to the item you want and press the pattern button.
- After programming the chain numbers as explained above, press the **Enter** button and the change of value will be saved. Then press the **Prog** button to come out from the chain programming screen.
- If you operate the programmed sewing work, the pattern with the blinking light is the current work being done and the pattern with the light on continuously is the next programmed pattern.



[Caution]

- After programming the chain function and pressing the **Enter** button, the set up value is saved.
- If you change the pattern program while sewing, it will sew with the new programmed pattern.
- If the last chain pattern is finished, it will automatically go to the first sewing pattern.






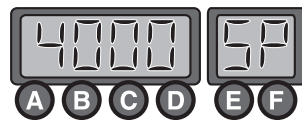
※ If the user presses the **Enter** button when using the pattern sewing function, the **Auto** light will go on and the machine will automatically sew the programmed pattern section even if the user releases the pedal.

(11) Method of Use: Constant Speed Sewing (AUTO) Selection Button





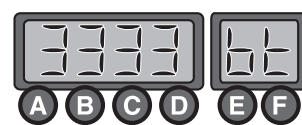
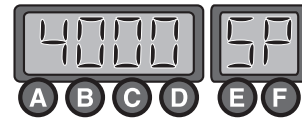
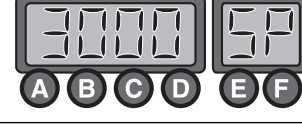


<p>This button is used to choose the sewing speed. It offers two functions according to where the light turns on.</p>	
	<ul style="list-style-type: none"> • When the light is blinking - If the user presses on the pedal, the machine will sew at the programmed sewing speed.
	<ul style="list-style-type: none"> • When the light is off - The machine will sew according to the amount of pressure given to the pedal by the user.
<p>[Caution] This button works in a different way when using the pattern function. Please refer to section 10).</p>	

(12) Method of Use: Sewing Speed Program Changing Button

A. Method to Check Sewing Speed

<p>If you want to check the current programmed sewing speed, you must press the button. If you briefly press the  button  button once, the screen shown on your right will appear briefly and then return to the initial screen.</p> <p>※ The speed on the screen is the limit of the maximum sewing speed.</p>	 
<p>[Caution] The maximum speed and minimum speed limits can be changed by changing the parameter's specific items.</p>	

B. Sewing Speed Changing Method

<p>① When you want to change the sewing speed, you can see the screen that shows the current sewing speed by pressing the  button or  button.</p> <p>② If you see the current speed on the screen, you can change the speed by using the  and  button before going back to the initial screen.</p> <ul style="list-style-type: none"> • When you press the buttons twice in sequence: The sewing speed increases/decreases by 40RPM. • When you keep pressing the button: The sewing speed increases/decreases rapidly. 	  
<p>[Caution] -Be aware that if you don't press the  or  button, the screen will automatically go back to the initial screen. -The maximum speed and minimum speed limits can be changed by changing the parameter's specific items.</p>	

13) Start and End Backtick Stitch Correction Method

- ※ Since backtick stitches may vary according to the type of sewing machine, use the following stitch correction method.
- ※ To adjust the stitch fast and clean, users should check the stitch condition before commencing the correction.

① Classification according to backtick sewing condition

- ※ The backtick sewing condition can be classified as follows (When A: 3 stitches, B: 3 stitches, C: 3 stitches, D: 3 stitches)

A. When one more or less stitch than the set stitch number is sewn

Classification	Sewing condition where few backtick stitches are sewn	Correct backtick sewing condition	Sewing condition where more backtick stitches are sewn
Start backtick Sewing condition	<p>When sides A and B each have one less stitch sewn</p>	<p>When sides A and B each have 3 stitches correctly sewn</p>	<p>When sides A and B each have one more stitch sewn</p>
End backtick Sewing condition	<p>When sides C and D each have one less stitch sewn</p>	<p>When sides C and D each have 3 stitches correctly sewn</p>	<p>When sides C and D each have one more stitch sewn</p>

B. When one more or one less stitch is sewn than the programmed stitch number

Classification	B/T condition where the stitch length comes out shorter	Correct B/T sewing condition	
Start backtick Sewing condition	<p>When the length of the last three stitches in sides A and B have been sewn short.</p>	<p>When sides A and B have 3 stitches correctly sewn.</p>	<p>When sides A and B each have 3 stitches and a half stitch (or less than one stitch) sewn</p>
End backtick Sewing condition	<p>When the length of the first stitch in sides C and D have been sewn short.</p>	<p>When the sides of C and D have 3 stitches correctly sewn</p>	<p>When the sides of C and D each have 3 stitches and a half stitch (or less than one stitch) sewn.</p>

[Caution]

The figures above show each representative sewing condition. And there may be some differences according to the conditions of the sewing machine and it is normal that two types of conditions occur at the same time.

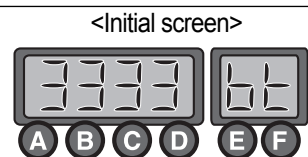
② Start/End B/T stitch number correction method

※ The method to correct B/T stitch numbers may differ according to the user. However it is basically done in the following order.

A. When the machine sews one less or one more stitch than the programmed number of stitches.

Ⓐ First, fully check the B/T sewing condition

: Commence sewing and check the current sewing condition. Refer to the figure above.



Ⓑ If you have checked the sewing condition, first correct the stitch number that differs by one or more stitches to the programmed stitch number.

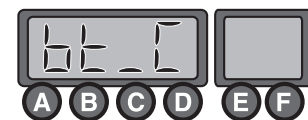
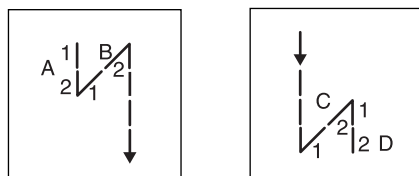
※ Correction method for stitch numbers with more than one stitch difference

- Program range: -6 stitches ~ 6 stitches
- Program unit: 1 stitch
- Method to apply correct stitch number (program using buttons A, B, C and D).

Side A programmed value	3(programmed stitch number) + (3-actual stitch number sewn on side A)
Side B programmed value	3(programmed stitch number) + (3-actual stitch number sewn on side B)
Side C programmed value	3(programmed stitch number) + (3-actual stitch number sewn on side C)
Side D programmed value	3(programmed stitch number) + (3-actual stitch number sewn on side D)

• After programming, press the **Prog** and **(1/2)** buttons simultaneously.

Ex) When there is one less Start or End B/T stitch sewn.



a In the initial screen use buttons **A**, **B**, **C**, **D** to change it from "3 3 3 3" to "4 4 4 4."

b After programming it to "4 4 4 4" press the **Prog** button. Then press the 1/2 stitch **(1/2)** button. You will see the letters "bt-C" and the buzzer will ring three times and the screen will automatically return to the initial screen.

c The changed initial screen will continue to display the wanted B/T programmed value of "3 3 3 3."

d Recommence sewing and check the corrected stitch number

e If the corrected sewing condition continues to show more than one stitch difference, repeat steps (a~d) and make corrections.

※ The example above is an explanation of when one B/T stitch number comes less than one

※ When there is more than one stitch is added or missing, you can correct the stitch number as explained above.

[Caution]

※ The stitch number correction value program range is between -6 stitches to 6 stitches. You cannot see the currently applied correction value on the initial screen. If you want to see the currently applied correction value, press the **Prog** button and then the **AUTO** button and either check the programmed value of each side or check items 30(side A's correction value), 31(side B's correction value), 32(side C's correction value) and 33(side D's correction value) from Group B of the parameter.

※ If each side's corrected value has been corrected to the minimum or maximum value limit (between -6 stitches to 6 stitches) and the sewing condition is still not correct, reduce the B/T sewing speed.

※ Generally, you can correct in the manner mentioned above when there is more than one stitch difference. And you can correct when there is less than one stitch difference with the item mentioned in the next page.

B. When the machine sews less than a stitch more or less than the one programmed.

Ⓐ If there are still problems with the B/T sewing condition even after correcting the stitch numbers for more than one stitch difference based on item "A," refer to figure ①-B and check the sewing condition again.

Ⓑ Look at the sewing condition and make the correction as follows:

- ※ Program range for making stitch corrections for less than one stitch:(Prog+Auto)
 - -6 stitches ~ 6 stitches
 - Program unit: 0.05 stitches (Corrections are done by dividing one stitch into 20 parts).
 - Initial program: A(00.30), B(00.30), C(00.40), D(00.40)
 - Correct stitch number application method (use C and D buttons for programming).

※ When the stitch length comes out short(the third stitch of sides A and B/ the 1st stitch of sides C and D)

Side A program value	■■■■ (Currently programmed corrected value)
	+ (01.00-the length of the 3rd stitch sewn in side A)
Side B program value	■■■■ (Currently programmed corrected value)
	+ (01.00-the length of the 3rd stitch sewn in side B)
Side C program value	■■■■ (Currently programmed corrected value)
	+ (01.00-the length of the 1st stitch sewn in side C)
Side D program value	■■■■ (Currently programmed corrected value)
	+ (01.00-the length of the 1st stitch sewn in side D)

※ <When the stitch comes out less than one stitch longer> (the last stitch of sides A and B/ and the first stitch of sides C and D)

Side A program value	■■■■ (currently programmed correction value)
	- the length of the extra part of the stitch sewn on side A
Side B program value	■■■■ (currently programmed correction value)
	- the length of the extra part of the stitch sewn on side B
Side C program value	■■■■ (currently programmed correction value)
	- the length of the extra part of the stitch sewn on side C
Side D program value	■■■■ (currently programmed correction value)
	- the length of the extra part of the stitch sewn on side D

[Caution] The shadowed part is the currently saved correct value. After programming, press the **Enter** button and save the programmed value.

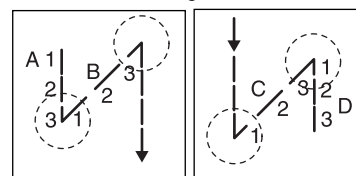
Ex) When the Start/End B/T stitch length is shorter than the programmed stitch length (by around half a stitch).

- a In the initial screen, press the **Prog** button and then also press the **Auto** button.
- b The screen will then go to the stitch number correction screen. Using the **E**, **F** buttons you can change the length of each side (A,B,C and D) in this screen.
- c If you have finished programming the new correction values to sides A, B, C and D, press the **Enter** button and save the corrected value. If you press the **Prog** button, you will return to the initial screen. (A:00.30, B:00.30, C:00.40, D:00.40) → (A:00.50, B:00.50, C:00.75, D:00.75)
- d Commence sewing and check the B/T sewing condition.
- e If the corrected sewing condition still shows differences between the programmed value, the repeat steps (a~d) and continue correction.

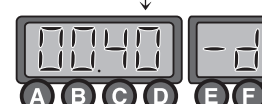
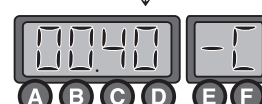
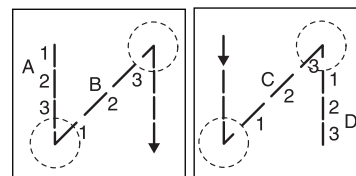
<Initial screen>



<When the stitch length comes out short>







<When the stitch length is less than one stitch>



[Caution]

- ※ If each side's corrected value has been corrected to the minimum or maximum value limit (between -6 stitches to 6 stitches) and the sewing condition is still not correct, reduce the B/T sewing speed.
- ※ Generally, you can correct for when there is more than one stitch difference with item A. However, with item B, you can correct when there is either more or less than one stitch difference.
- ※ Make sure to press the **Enter** button and save the programmed value when you finish programming sides A, B, C and D's new correction value.

(14) Method of Use: Inertia Tuning Function

<p>① The inertia tuning function enables the machine to save the gain value of the motor that matches the loaded inertia. If you simultaneously press buttons  and , you will see the inertia tuning screen. Then, you will see the words "TUNE" blinking.</p>	<p><Inertia tuning initial screen></p>  <p><Initial screen></p> 
<p>② When the screen changes, you must press the pedal until the buzzer rings. If you release the pedal before the buzzer rings the inertia tuning won't be completed. Therefore, you must press on the pedal until the buzzer rings. (When doing inertia tuning, the sewing machine will operate and stop 10 times).</p>	
<p>③ When inertia tuning is completed, the buzzer will ring and it will automatically return to the initial screen.</p>	
<p>[Caution] Inertia tuning can only be carried out when the controller is attached to the sewing machine for the first time and when the sewing machine does not accelerate or decelerate quickly.</p>	

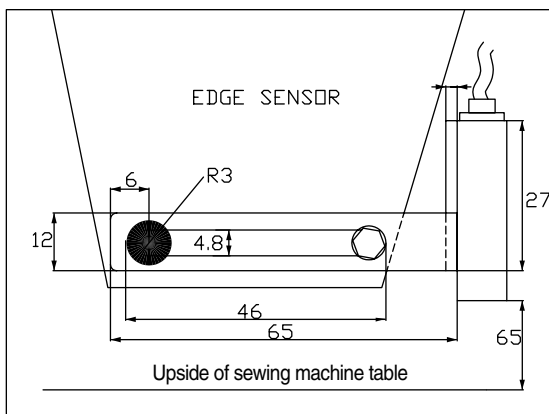
(15) How to Use the Edge Sensor (Fabric Edge Sensor)

A. Applicable Fortuna Model

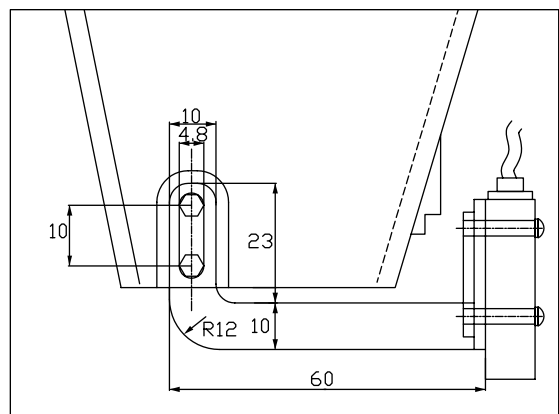
- ① Fortuna Series 3 : Full Function Type (using the switch and lamp connector port)
- ② Fortuna Series 4 : Full Option Type (using the switch and lamp connector port)

B. Installation

- ① Install the edge sensor bracket on the head of the sewing machine as in the figures below.
- ② Attach the edge sensor to the installed edge sensor bracket.

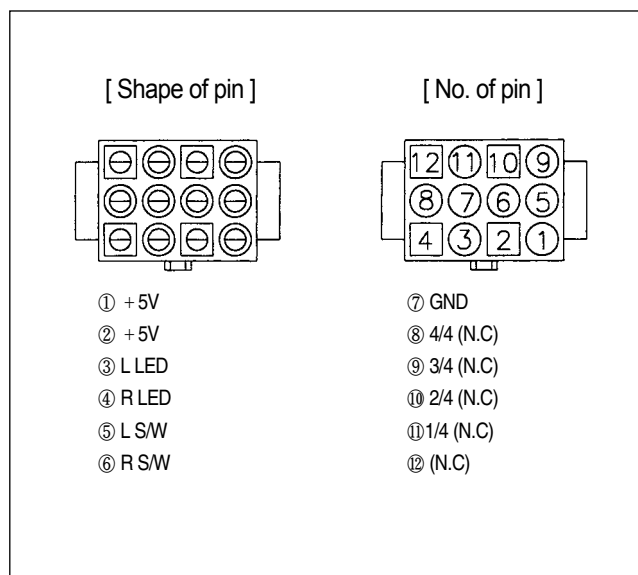


< KM-235,250 >



< KM-750,790 >

- ③ Install the edge sensor box (ass'y), which is connected to the edge sensor, on the table.
- ④ Link the edge sensor connector to the switch and lamp (or option 1) connector.



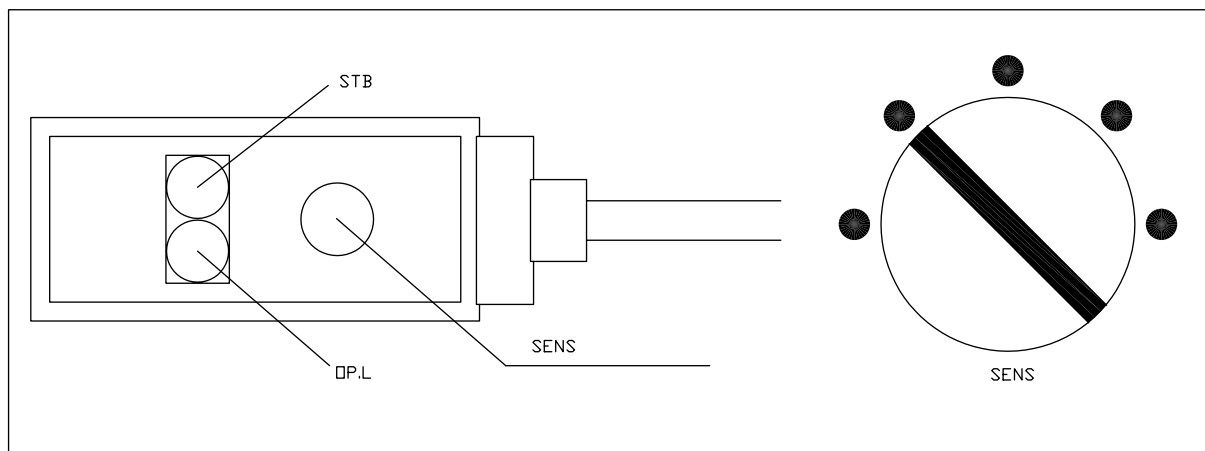
< Fortuna Series 3 >

C. Edge Sensor Program Setting



<p>① Turn the power on while pressing simultaneously. "PrEn" is displayed with a "beep" sound and then disappears.</p>	
<p>② Programs should be modified after trimming is completed.</p>	
<p>③ Press first, and then press simultaneously. Then the program modification mode appears as shown in the right figure.</p>	
<p>④ Use , to set the code number at 52. Use , to change the value from 2, the default value, to 12 and then press to save the new value.</p>	
<p>⑤ When the program setting is done, press to turn off the blinking lamp and use the sewing machine.</p>	

D. Edge Sensor Setting


- ① First make sure that there is no fabric below the sensor, and set the operating mode of the rear side of the sensor at L.ON.
- ② Press on the P/U and check if the LED is blinking.
- ③ Check if the STB (yellow) LED is turned on, when there is a fabric below the sensor.
- ④ If the STB (yellow) LED is not turned on, switch the operating mode to Operating D.ON and begin the setting (depending on types of fabric).
- ⑤ Adjust the volume of SENS to make OPL (red) turned off while fabric is below the sensor, and make OPL (red) turned on when it is removed (it doesn't matter whether the STB LED is turned on or not).
- ⑥ Check whether a signal alarm is issued in line with the presence of fabric under the sensor.




E. Use of the Edge Sensor

<p>① Press  to turn on the lamp.</p>	
<p>② During sewing while the lamp is on, if the sewing needle comes near to the edge of fabric (some 2cm between the needle and the edge of fabric), a “beep” sound is issued and the sewing stops.</p>	
<p>③ Move the pedal to the neutral position and press it again. Then the sewing is resumed according to the number of stitches previously set under Prog Group “A” on the P/U (the number of stitches to be made after sensing the fabric edge) and the sewing speed previously set under No. 42.</p>	
<p>[Note] The default number of stitches to be made after edge sensing is three stitches and can be adjusted to 64 stitches at the maximum depending on user choice. The sewing speed can be set at the range of 24 to 2040spm. The default speed is 200spm. If the pedal is pressed continuously, the sewing machine will repeat the same function as described above.</p>	
<p>④ When a trimming is programmed to be conducted after the low-speed sewing is completed, the backtack sewing will be performed according to the number of backtack stitches defined on the P/U, followed by trimming.</p>	
<p>[Note] a Press  to turn the lamp off in order to change the number of stitches to be made after sensing the fabric edge, while working on pattern. See the below to modify the program. b If the edge sensor detects the fabric edge before the set number of stitches is finished during sewing, the unfinished number of stitches will be ignored. Only the number of stitches to be made after edge sensing will be made, provided that the number of stitches to be made after edge sensing should be bigger than the number of stitches defined for the concerned line of a pattern.</p>	

F. Edge Sensor Deactivation

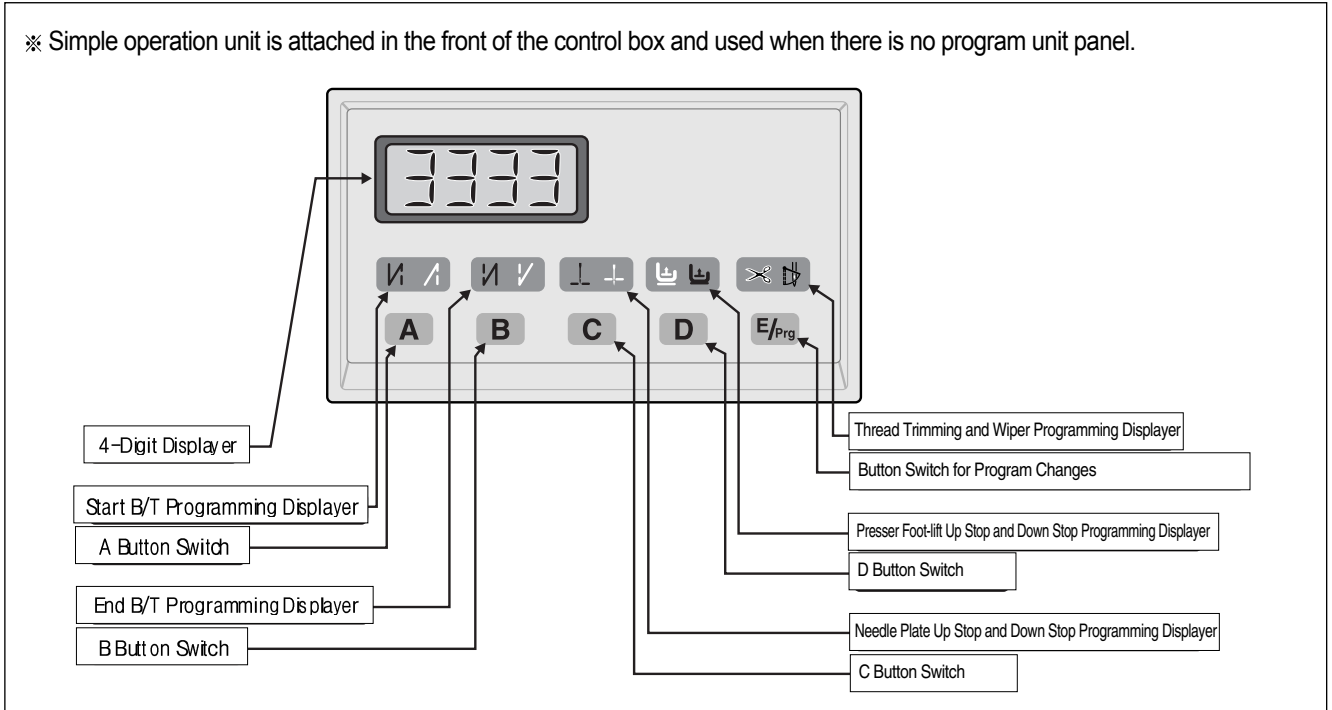
<p>① Press  to turn off the edge sensor. Then the edge sensor is deactivated.</p>
--

G. Edge Sensor Program Modification

<p>① Programs should be modified only after trimming is conducted.</p>																												
<p>② Press Prog first, and then press A simultaneously. Then the program modification mode is displayed as shown in the right figure.</p>																												
<p>③ Use B, F to enter the code number to be modified, and use C, D to enter the desired value. Press Enter to save the new value.</p>																												
<p>④ When the modification is completed, press Prog to turn off the blinking lamp and then use the sewing machine.</p>																												
<p>[Caution] When the sewing machine is initiated, all stored data are returned to the default values.</p>																												
<p>⑤ The edge sensor-related programs are located in Group A, and the code numbers and descriptions are displayed as below.</p>																												
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 10%;">Group</th> <th style="width: 15%;">Code #</th> <th style="width: 15%;">Scope</th> <th style="width: 10%;">Stage</th> <th style="width: 40%;">Description</th> <th style="width: 10%;">Remarks</th> </tr> </thead> <tbody> <tr> <td rowspan="4" style="text-align: center; vertical-align: middle;">A</td> <td style="text-align: center;">40</td> <td style="text-align: center;">0/1</td> <td></td> <td>Select types of fabric sensor</td> <td></td> </tr> <tr> <td style="text-align: center;">41</td> <td style="text-align: center;">0 ~ 64</td> <td style="text-align: center;">1 stitch</td> <td>Set the number of stitches to be made after sensing the fabric edge</td> <td></td> </tr> <tr> <td style="text-align: center;">42</td> <td style="text-align: center;">24 ~ MAX, SPM</td> <td style="text-align: center;">40 spm</td> <td>Set the speed of sewing after sensing the fabric edge</td> <td></td> </tr> <tr> <td style="text-align: center;">43</td> <td style="text-align: center;">0/1</td> <td></td> <td>0 : use of pedal , 1 : constant speed (constant speed : related to A42)</td> <td></td> </tr> </tbody> </table>		Group	Code #	Scope	Stage	Description	Remarks	A	40	0/1		Select types of fabric sensor		41	0 ~ 64	1 stitch	Set the number of stitches to be made after sensing the fabric edge		42	24 ~ MAX, SPM	40 spm	Set the speed of sewing after sensing the fabric edge		43	0/1		0 : use of pedal , 1 : constant speed (constant speed : related to A42)	
Group	Code #	Scope	Stage	Description	Remarks																							
A	40	0/1		Select types of fabric sensor																								
	41	0 ~ 64	1 stitch	Set the number of stitches to be made after sensing the fabric edge																								
	42	24 ~ MAX, SPM	40 spm	Set the speed of sewing after sensing the fabric edge																								
	43	0/1		0 : use of pedal , 1 : constant speed (constant speed : related to A42)																								
<p>※ When using patterns, trimming is automatically conducted after the set number of stitches is made.</p>																												

SIMPLE OPERATION UNIT PART NAMES AND METHOD OF USE

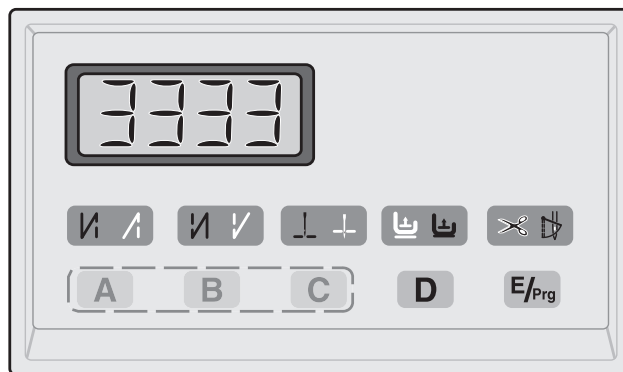
1) Names of Each Part in the Simple Operation Unit



2) Simple Program Unit Method of Use

(1) Initializing

This function is used when the user randomly corrects the programmed value and forgets the initial programmed value.








Turn the power on by simultaneously pressing the buttons , **A** and **B** , **C** .

[Caution]

- When you initialize, you change all the original values that the sewing machine had when it was manufactured in the factory. Initialize only when absolutely necessary.
- When initializing, you must run the motor for more than 5 seconds at the speed of 1000RPM in order to make the synchronizer to work properly.

(2) Programming the Start B/T Sewing Conditions with Button **A**

This button is used when the user wants to prevent threads from loosening at the end of the sewing work. If the user presses this button in sequence, the location on the lights will change as shown in the figures below. This button offers the following three functions.






		
<p>When sewing starts, B/T sewing does not operate.</p>	<p>When sewing starts, B/T sewing can be done with the  button.</p>	<p>When sewing starts, B/T sewing can be done with the  button.</p>

Use the A, B button to program the number of B/T stitches in the 4-digit displayer.

[Caution]
Be aware that if the end B/T stitch number is set to '0' in the 4-digit displayer, the user will be unable to operate start B/T sewing.

(3) Programming the Start B/T Sewing Conditions with Button **B**

This button is used when the user wants to prevent threads from loosening at the end of the sewing work. If the user presses this button in sequence, the location on the lights will change as shown in the figures below. This button offers the following three functions.




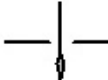
		
<p>When sewing starts, B/T sewing does not operate.</p>	<p>When sewing starts, B/T sewing can be operated with the  button.</p>	<p>When sewing starts, B/T sewing can be operated with the  button.</p>

Use the C, D button to program the number of B/T stitches in the 4-digit displayer.

[Caution]
Be aware that if the end B/T stitch number is set to '0' in the 4-digit displayer, the user will be unable to carry out start B/T sewing.





(4) Programming the Needle Plate Position when Sewing Stops with Button **C**

When you turn the power on, one of needle plate's up stop and down stop lights in the simple operation unit will always be on. If you press the button you can select the stopping location.

 <p>If the machine stops while sewing, the needle plate makes an up stop.</p> 	 <p>If the machine stops while sewing, the needle plate makes a down stop.</p> 
--	--

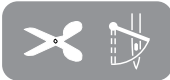


(5) Programming the Presser Foot-lift Location when Sewing Stops with the Button **B**

When you turn the power on, one of presser foot-lift's up stop and down stop lights in the simple operation unit will always be on. If you press the button you can select the stopping location.




 <p>If the machine stops while sewing, the presser foot-lift makes an up stop.</p> 	 <p>If the machine stops while sewing, the presser foot-lift makes a down stop.</p> 
---	---

(6) Programming the Automatic Thread Trimmer and Wiper Movements with the Button **E/PrG**

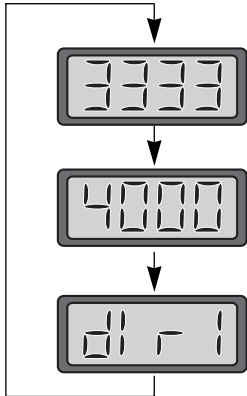
This button programs the automatic trimmer and wiper after sewing. If the user presses this button in sequence, the location on the lights will change as shown in the figures below. This button offers the following three functions.

 <p>Automatic trimmer and wiper are not operating.</p>	 <p>Only the automatic trimmer is operating</p>	 <p>Both the automatic trimmer and wiper are operating</p>
---	--	---









(7) Programming the Start and End B/T Stitches

<p>① Press the appropriate button for 0.5 seconds for the place you wish to program the new B/T stitch value. The light will blink in that place.</p> <ul style="list-style-type: none"> • Programming buttons for number of start B/T stitches : buttons A , B • Programming buttons for number of end B/T stitches : buttons C , D 	<p><Initial Screen></p> 
<p>② If the number is blinking, you can change the programmed value by pressing the appropriate button. (Ex : If you press the A button for 0.5 seconds, the first number in the screen will blink).</p>	<p><When the button A has been pressed for 0.5 seconds></p> 
<p>③ If programming is completed, press the same button for 0.5 seconds once more and you will return to the initial screen. (Ex : Changing the value of A, B, C, D from 3, 3, 3, 3 to 4, 4, 4, 4)</p>	
<p>[Caution] Be aware that if you don't press the button for 0.5 seconds, the screen will not return to the B/T stitch programming screen but will remain in the sewing conditions program change (items 1~4 functions) section.</p>	

(8) Sewing Speed and Rotating Direction Programming Method

<p>① If you press the E/prg button for 0.5 seconds, you will see the screen that enables you to change the sewing speed. If you press the same button again for 0.5 seconds, you will see the screen that enables you to change the rotating direction. If you press the button one more time, you will return to the initial screen. (Initial screen → Speed programming screen → Rotating direction programming screen → Initial screen)</p>	
<p>② If you want to change the sewing speed, press the E/prg button. After seeing the speed programming screen, press buttons A and B to program the speed you want.</p>	
<p>③ If you want to program the rotating direction, press the E/prg button to see the rotating direction programming screen, then press buttons A and B to change the rotation to the direction you want.</p> <ul style="list-style-type: none"> • reverse direction : dir 0 • normal direction : dir 1 	
<p>[Caution] Be aware that if you don't press the button for 0.5 seconds, the screen will not return to the B/T programming screen but will remain in the sewing conditions programming screen (Items 1~4 functions).</p>	

(9) Method to Change Parameter Specific Items

<p>① To change the parameter's detailed items, press the E/prg and A buttons simultaneously and return to the parameter detailed item's initial screen.</p>	<p><parameter specific item initial screen></p> 
<p>② If you see the "PrEn" screen, select a parameter group using buttons A~D.</p> <ul style="list-style-type: none"> • A button : A group, B button : B group • C button : C group, D button : D group 	<p><Initial screen for group A> <Initial screen for group B></p>   <p><Initial screen for group C> <Initial screen for group D></p>  
<p>③ After selecting the group you want, use buttons A and B to select the specific item you want.</p> <ul style="list-style-type: none"> • Ex: Select No. 2 item of Group A (Limiting the maximum sewing speed) 	
<p>④ If you selected the specific item you wanted, press button C. The value you selected will then appear on the screen.</p> <ul style="list-style-type: none"> • Ex : The current maximum sewing speed 400RPM. 	
<p>⑤ Using the buttons A and B, change the current programmed value to another value.</p> <ul style="list-style-type: none"> • Ex : Change the maximum sewing speed from 4000RPM to → 3000RPM 	

⑥ If you completed your selection, press the C to save the value you chose.	
⑦ You can change other specific items of the parameter in the same manner.	
<p>[Caution]</p> <ul style="list-style-type: none"> • Be aware that if you changed the specific items of the parameter and didn't press the C button, the changed value will not be saved. • If you change the parameter specific items carelessly, this may cause breakdown or physical damage to the machine. Therefore, the user must be well-trained before changing items in the parameter group. 	

(10) Start and End B/T Stitch Number Correction Method

<p>① Corrections in the initial screen are the same as those in item (13) of the program unit manual "Correcting method for when the B/T number differs by one stitch"</p> <ol style="list-style-type: none"> Check the present sewing condition. Change the value of the part that needs correction (use A , B , C , D buttons) Save the programmed value (press the E/Prq and B buttons simultaneously). → You will go to the "bt-C" screen. The buzzer will sound three times and you will return to the initial screen 	
<p>② When making corrections of less than one stitch use items 30~33 of parameter Group B and will correct to stage 0.05.</p>	
<p>※ For detailed B/T stitch number correction method, refer to the section (13) of the Program Unit manual.</p>	

(11) Method of Use of the Inertia Tuning Function

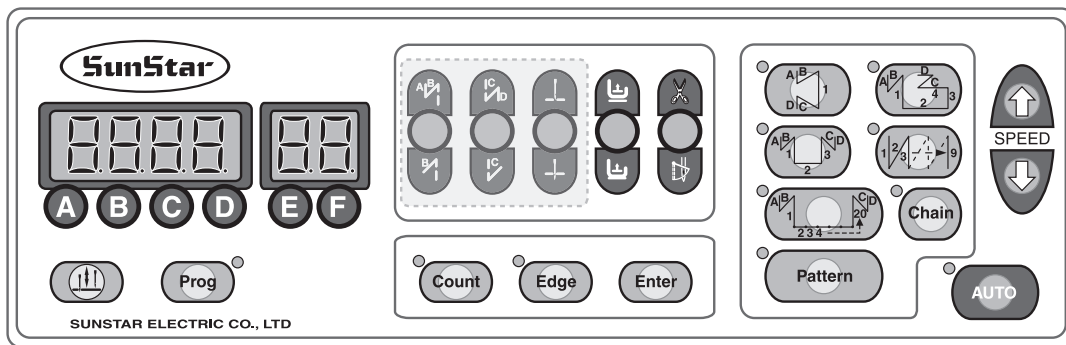
<p>① The inertia tuning function is to find the motor's gain value that match the weights inertia. Press buttons E/Prq and D simultaneously to return to the initial screen of the inertia tuning.</p>	<p><Inertia tuning initial screen></p>
<p>② If the initial screen comes on, press the pedal until you hear the buzzer ring. (During inertia tuning the sewing machine will operate and stop 10 times).</p>	<p><Initial screen></p>
<p>③ If the inertia tuning is completed, the buzzer will ring and the initial screen will come on at the same time.</p>	
<p>[Caution] Inertia tuning is carried out only when the controller is attached to the sewing machine for the first time and when the sewing machine is unable to accelerate or decelerate quickly.</p>	

FORTUNA SERIES 3 FULL FUNCTION SOFTWARE METHOD OF USE

1) Basic Functions of the Fortuna Series 3 Full Function Software

(1) Initializing

This function is used when the user randomly changes the parameter's programmed value, and forgets the original program contents.



Method of initializing: Turn the power on by simultaneously pressing the buttons in the figure above which are the start B/T button + end B/T button + needle plate up/down stop button.

[Caution]

- If you initialize, all the changes made by the user are changed to the original values programmed when the machine was delivered from the factory, therefore only change the value if absolutely necessary.
- After initializing, rotate the machine for 1000RPM or more for approximately 5 seconds. You must make the machine remember the location of the FILM.

(2) Sewing Machine Up/Down Stop Location Automatic Recalling Function

When first purchasing the controller, if the user steps on the pedal for 5 seconds and runs the motor before beginning the sewing work, the machine will automatically remember the sewing machine's up/down stop location. However, when using a synchronizer this step is not necessary.

(3) Method of Use and Functions of the Program Unit and the General Control Box's Simple Operation Box.

When there is a program unit(P/U), use it to program or change all the functions of the machine. When there is no program unit, use the general control box operation panel to program or change all the functions of the machine.

※ For detailed information on the method of use of program units and simple operation panel refer to the explanation in the last section.



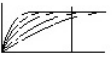
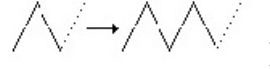
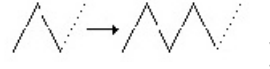
(4) Function Parameter

Parameter group	Functions
① Group A	General functions of the sewing machine
② Group B	All types of output, Full-on Time/PWM Duty, checking input/output operations, sewing machine models and thread trimming sequence programming
③ Group C	Pedal acceleration/deceleration curve, slow starting speed and input/output port change related parameters
④ Group D	All types of gain parameter related motor control

※ If the specific items of the parameter are changed carelessly, they could cause breakdown or damage the machine. Therefore the user must be well-trained before using it.

2) Fortuna Series 3 Full Function Software Specific Parameters

(1) Group A Parameter: General functions of sewing machine

No.	Function	Initial value	Range	Step
1	Minimum speed of pedal (limit of sewing machine's minimum speed)	200spm	20-510	2spm
2	Maximum speed of pedal (limit of sewing machine's maximum speed)	4000spm	40~9960	40spm
3	Thread trimmer speed (Sewing machine speed from beginning to end of thread trimming when using CAM type)	300spm	20-510	2spm
4	Program Unit + 1 stitch speed ( Key's performance speed)	100spm	20-510	2spm
5	Lifting of needle plate with button A, dropping speed ( 's performance speed)	300spm	20-510	2spm
6	Pedal degree of acceleration (Pedal Curve) ( ;When the maximum speed is put in 255 steps)	255	1-255	1
7	Start Back-Tack Speed	1700spm	20-2000	10spm
8	End Back-Tack Speed	1700spm	20-2000	10spm
9	Thread trimming operation time (The A24 used in PNEUMATIC = must be 1) (The Solenoid operation time)	100ms	4~1020	(When doing an aging test, the value is equal to the running time)
10	Tension release operation time (The A24 used in PNEUMATIC = must be 1)	200ms	4~1020	(When doing an aging test, the value is equal to the thread trimming time)
11	Tension release time (In CAM type, the used A24 = must be 0) (In CAM type, the tension release is the value of the moving CAM angle)	255	0-255	
12	Waiting time for the next operation after thread trimming (This is the delaying time to carry out the next operation after thread trimming is finished)	4ms	4~1020	
13	Wiper operation time (Wiper Solenoid operating time)	48ms	4~1020	4ms
14	Waiting time after wiper operation (presser foot-lift etc.)	40ms	4~1020	4ms
15	Automatic presser foot-lift delaying time	100ms	4~1020	4ms
16	Automatic presser foot- lift maintaining time (After programmed time the presser foot-lift is automatically released)	300×0.1sec	5~1000	0.5sec
17	Automatic presser foot-lift drop waiting time for next operation (The delaying time, or the time that the foot-presser lift is maintained, the pedal is started until the presser foot-lift drops and the sewing machine is started)	100ms	4~1020	4ms
18	Selection for automatic foot-presser lift after thread trimming	0	0/1	1=lift selection
19	Selection for pedal thread trimming position	0	0/1/2	0=step backward thread trimming 1=1 step backward thread trimming 2=thread trimming at neutral position
20	The maximum sewing speed for the KM-1060BL-7 presser foot-lift with mutual crossing quantity of 4.8c[7.0][mm]	2000spm	200-2000	10spm
21	Delaying time for complete release of KM-1060BL-7 B/T Solenoid	200ms	4-1020ms	4ms
22	Select to operate 2 start B/T ()	0	0/1	Choose between 1 or 2
23	Select to operate 2 end B/T ()	0	0/1	Choose between 1 or 2

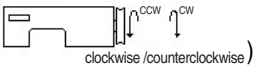
[Caution]

If the specific items of the parameter are changed carelessly, they could cause breakdown or damage the machine. Therefore, the user must be well-trained before using it.

No.	Function	Initial value	Range	Step
24	Selection of thread trimming conditions (selection according to sewing machine type)	0	0/1/2	0=CAM type machine 1= thread trimming after up-stop 2=thread trimming after low-stop
25	Whether or not to use default sequence when A24 = 1 (This is a sequence determined on A9,A10 value)	0	0/1	0=B-55 exclusive sequence is used 1= default sequence is used
26	Selection of B/T Solenoid operation position	0	0/1	0= lower position 1= upper position
27	Setting the maximum sewing speed of the machine according to presser foot-lift height of the KM-1060BL sewing machine.	?	?	program P1xx → P2xx → P3xx in order Less than P1xx:3500[spm] Less than P2xx:3000[spm] Less than P3xx:2500[spm] More than P3xx: A20[spm]
28	Needle bar's automatic stop at the highest position	0	0/1	
29	Pedal analog filtering difference	15	1~200	1
30	When using an angle 2-needle, select the semi-automatic corner operation	0	0/1	1=selection of semi-automatic
31	Speed when selecting a semi-automatic corner (parameter used only when used after selecting number 30)	200spm	20~2000	10spm
32	After selecting the left needle the first sewing stitch (parameter used only when used after selecting number 30)	3 stitches	0~255	1 stitch
33	After selecting the left needle the second sewing stitch (parameter used only when used after selecting number 30)	3 stitches	0~255	1 stitch
34	After selecting the right needle the first sewing stitch (parameter used only when used after selecting number 30)	3 stitches	0~255	1 stitch
35	After selecting the right needle the second sewing stitch (parameter used only when used after selecting number 30)	3 stitches	0~255	1 stitch
36	Maintaining time for the left/right needle solenoid (After the programmed time the solenoid is automatically released)	450×0.1sec	50~1000	0.5sec
37	NOT USED			
38	NOT USED			
39	Stopping function during AUTO mode and while pedal is neutral	1	0/1	0=does not stop 1=stops
40	Selection of type of N-stitch Sensor	0	0 : active high	1 : active low
41	The number of stitches done after the N-stitch Sensor has finished sensing. (After sensing, it will sew the programmed number of stitches and stop)	3 stitches	0~255	1 stitch
42	N-stitch sewing speed	1000spm	20~2000	10spm
43	Selection of One Touch function → replaced by AUTO Key function (Used in the sewing mode that uses the auto function)	0	0/1	1=Auto Mode
44	Selection of One Touch function → replaced by AUTO sewing mode programming (If there is no thread trimming signal when selected, sewing will continue even if user releases pedal)	0	0/1	1=One-Shot Mode
45	One-Shot sewing speed →When using AUTO function, it is programmed with the speed Up/Dn Key	2000spm	40~9960	40spm
46	N-stitch sewing mode selection → a sewing mode that inputs a sensor signal in the edge sensor port and uses it as an edge sensor	0	0/1	1=N-stitch Mode
47	Selection of pre-stitch function (When selected it will perform only the programmed stitches before the actual sewing work starts)	0	0/1	1=selection
48	Pre-stitch number of stitches	3 stitches	0~255	1 stitch
49	Pre-stitch speed	2000spm	20~2000	10spm

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

No.	Function	Initial value	Range	Step
50	Selection of start B/T operating conditions (0 : if pedal is released during back tack, it will stop) (1 : if pedal is released during back tack, the work will still be completed) (2 : it will perform the exact amount of back tack stitches)			0 : B/T stop function selected 1 : B/T work completion 2 : B/T exact stitch performance
51	Selection of end back tack performance condition (It will perform the exact amount of stitches for end back tack)	0	0/1	1= exact stitch performance
52	Back tack initial first stitch speed during back tack exact performance	200spm	20~1000	10spm
53	Change between B/T and switch with buttons A or B during sewing	0	0/1	1= Select with button B
54	Selection of button A function	2		0 : Only B/T operates 1 : Lift and drop needle plate with one movement. 2 : Lift needle plate with one movement. Drop needle plate with two movements 3 : Slow performance when stopped (1/2 stitch speed)
55	Selection of Button B function	0		0 : B/T delete insertion 1 : Lift and drop needle plate with one movement 2 : Slow performance when stopped (1/2 stitch speed) 3 : Only B/T operates
56	Selection of speed during manual back tack during sewing	0	0/1	0 : current sewing speed 1: initial reverse speed
57	NOT USED			
58	Thread Trimming Sequence Selection of SunStar Chain Stitch Machine	1	0/1	1
59	Thread Trimming Sequence Selection of other Company chain Stitch Machine	0	0/1	1
60	Selection of reverse rotation after trimming	0	0/1	1:selection of reverse direction
61	Reverse rotation distance when selecting reverse rotation after thread trimming	20degree	0~250	1degree
62	When machine stops fix pulley (When machine stops fix the motor by force)	0	0/1	1: fix when machine stops
63	Power to fix the A number 62 Pulley	40	10~100	1
64	Distance recovered after fixing A number 62 Pulley and rotating it by force	20degree	10~100	1degree
65	Select the motor rotating direction ()	1	0/1	1 : clockwise 0 : counterclockwise
66	Target speed : If this speed is reached or passed, a signal saying "Target speed has been reached" will appear. (As an interior Port it is allotted and used in the 'C' GROUP-Default is auxiliary)	1000spm	40~9960	40spm
67	Delay start setup	0	0/1	0=normal start 1=Delay start
68	Delay start time duration setup	3	3~250	1 × 100[ms]
69	Setup of needle bar's stop at the lowest position after trimming when the pedal is pressed	0	0/1	0=disabled 1=enabled
70	Setup of the duration of needle bar's stop at the lowest position after trimming when the pedal pressed	100	100~250	1[ms]

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.



(2) Group B Parameter : All types of output, Full-on Time/PWM Duty, checking input/output operations, sewing machine models and thread trimming sequence programming.

※ These are functions not used by general users and must be regulated by an A/S technician.

No.	Function	Initial value	Range	Step
1	Back Tack Solenoid Initial Full On Time	1020ms	4~1020	4ms
2	Presser Foot-Lift Solenoid Initial Full On Time	200ms	4~1020	4ms
3	T/T Solenoid Initial Full On Time	100ms	4~1020	4ms
4	Wiper Solenoid Initial Full On Time	100ms	4~1020	4ms
5	Tension Release Solenoid Initial Full On Time	100ms	4~1020	4ms
6	Left Solenoid Initial Full On Time (For Twin Needle)	100ms	4~1020	4ms
7	Right Solenoid Initial Full On Time (For Twin Needle)	100ms	4~1020	4ms
8	Auxiliary Solenoid Initial Full On Time	100ms	4~1020	4ms
9	Left LED Initial Full On Time (For Twin Needle)	100ms	4~1020	4ms
10	Right LED Initial Full On Time (For Twin Needle)	100ms	4~1020	4ms
11	Needle plate up-stop signal Initial Full On Time	100ms	4~1020	4ms
12	Needle plate down-stop signal Initial Full On Time	100ms	4~1020	4ms
13	Signal notifying motor running Full On Time	100ms	4~1020	4ms
14	Signal notifying target speed achieved Full On Time	100ms	4~1020	4ms
15	Back Tack Solenoid Duty Ratio	50%	0~100	10%
16	Presser Foot-Lift Solenoid Duty Ratio	20%	0~100	10
17	Thread Trimming Solenoid Duty Ratio	100	0~100	10
18	Wiper Solenoid Duty Ratio	100	0~100	10
19	Tension Release Solenoid Duty Ratio	100	0~100	10
20	Left Solenoid Duty Ratio (For Twin Needle)	50	0~100	10
21	Right Solenoid Duty Ratio (For Twin Needle)	50	0~100	10
22	Aux Solenoid Duty Ratio	100	0~100	10
23	Left LED Duty Ratio (For Twin Needle)	100	0~100	10
24	Right LED Duty Ratio (For Twin Needle)	100	0~100	10
25	Signal for up stopping needle Duty Ratio	100	0~100	10
26	Signal for low stopping needle Duty Ratio	100	0~100	10
27	Signal notifying motor running Duty Ratio	100	0~100	10
28	Signal notifying target speed reached Duty Ratio	100	0~100	10
29	NOT USED			
30	Start Back Tack A number of stitches correction value	00.30	6~6	0.05 Stitch
31	Start Back Tack B number of stitches correction value	00.30	6~6	0.05 Stitch
32	End Back Tack C stitch correction value	00.40	6~6	0.05 Stitch
33	End Back Tack D stitch correction value	00.40	6~6	0.05 Stitch
34	Selection for maintaining reverse solenoid movement when thread trimming (C Only B/T)	0	0/1	1=reverse direction maintained
35	Programming count condition (program whether or not automatic counter will be operated)	0	0/1	0=counter used 1=automatic counter after thread trimming
36	When automatically counting, select Up/Down count after thread trimming (thread trimming function must be enabled)	1	0/1	1=Up COUNT 0=DOWN COUNT
37	When count in completed, the next operation is programmed	0	0/1/2	0=buzzer rings, sewing is allowed 1=buzzer rings, sewing is not allowed (If you press the Prog Key, set up is cancelled) 2=No buzzer ring, sewing is allowed
38	When count is completed, select the counter auto clear/preset	0	0/1	1=AUTO CLEAR/PRESET
39	NOT USED			

※ Items No. 30~33 : These are the items that make the number of stitches match when back tack number of stitches do not match.

※ Solenoid Duty Ratio : The power that holds and maintains the solenoid.

Solenoid initial full on time : The time it takes to pull the solenoid to the maximum in the outset.

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

No.	Function	Initial value	Range	Step
40	Checks operation of B/T solenoid (OUTPUT00)	※After matching the number of the solenoid being tested, press the "+1stitch($\frac{1}{-1}$)" key and check the condition of the movement. - Along with the output, it will say "on", or "off"		
41	Checks operation of P/F solenoid (OUTPUT01)			
42	Checks operation of T/T solenoid (OUTPUT02)			
43	Checks operation of W/P solenoid (OUTPUT03)			
44	Checks operation of T/R solenoid (OUTPUT04)			
45	Checks operation of left solenoid (OUTPUT05)			
46	Checks operation of right solenoid (OUTPUT06)			
47	Checks operation of Aux. solenoid (OUTPUT07)			
48	Checks operation of Left LED solenoid (OUTPUT10)			
49	Checks operation of Right LED solenoid (OUTPUT11)			
50	Checks operation of needle when signal notifies up stop (OUTPUT12)			
51	Checks operation of needle when signal notifies down stop (OUTPUT13)			
52	Checks operation of signal notifying motor running (OUTPUT14)			
53	Checks operation signal notifying target speed has been reached (OUTPUT15)			
54	Select [Thread trimming sequence] - The default is set to '0'. If you wish to input another sequence apart from the thread trimming sequence provided in the system input the newly composed sequence number. (Refer to the sequence composition method)			
55	Thread trimming sequence data writing function			
56	Selecting sewing machine model - write the number that fits the sewing machine model provided in the full function manual.. - thread trimming sequence in the pertinent machine is copied. - if you want to correct the thread trimming sequence, change the contents of item B-55. (※ However, be aware that if you initialize the parameter, the newly programmed changes will disappear and the thread trimming sequence will change to that of [SunStar 235/250]).	0	0~127	1 0~ 74 (non-order made) 75~118 (order-made) (Refer to attached material)
57	Independent operation of trimming sequence	0	0/1	0=operation after trimming 1=independent operation
58	Presser foot-lift solenoid slowing down time #1 (Applied only when it is full-on condition)	40ms	2~510ms	2ms
59	Presser foot-lift solenoid slowing down time #2 (Applied only when it is PWM)	30ms	2~510ms	2ms

※ Items No. 40~53 : functions that check if solenoid and other output signals are working properly.

※ Select Item No. 55 and press the Enter key. Along with the buzzer sound you will see the words "Seq 55" appear on the screen. Thread trimming sequence composition permitting condition is now possible. You can program a thread trimming sequence to a maximum of 64 bytes. (For thread trimming sequence program method, refer to attached material).

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

No.	Function	Initial value	Range	Step
60	Checks the signal input INPUT00 (Button A)	Along with the input, it will say "on" or "off"		
61	Checks the signal input INPUT01 (Button B)			
62	Checks the signal input INPUT02 (1/4 stitch Switch)			
63	Checks the signal input INPUT03 (2/4 stitch Switch)			
64	Checks the signal input INPUT04 (3/4 stitch Switch)			
65	Checks the signal input INPUT05 (4/4 stitch Switch)			
66	Checks the signal input INPUT06 (Left Switch)			
67	Checks the signal input INPUT07 (Right Switch)			
68	Checks the signal input INPUT10 (Manual presser foot-lift Switch)			
69	Checks the signal input INPUT11 (Counter Switch)			
70	Checks the signal input INPUT12 (PU 1/2 stitch Button)			
71	Checks the signal input INPUT13 (Safety Switch)			
72	Checks the signal input INPUT14 (Edge Sensor)			
73	Checks the signal input INPUT15 (Thread trimming not allowed)			
74	Checks the signal input INPUT20 (First step for pedal going forward)			
75	Checks the signal input INPUT21 (First step for pedal going backwards)			
76	Checks the signal input INPUT22 (Second step for pedal going backwards)			
77	Checks the solenoid movement voltage		0~64	
78	Checks external volume value		0~64	
79	Checks the pedal analog output		0~64	
80	Checks the synchronizer signal			Increases by each rotation of the sewing machine
81	Checks the signal from encoder A/B			1) increases when sewing machine rotates clockwise 2) decreases when sewing machine rotates in counterclockwise
82	Checks the signal from encoder R/S/T			1) When sewing machine is rotating clockwise 101 → 100 → 110 → 010 → 011 → 001 → 101 2) When sewing machine is rotating counterclockwise 101 → 001 → 011 → 010 → 110 → 100 → 101
83~	NOT USED			
99	NOT USED			

- ※ Items No. 60~76: functions that check individual normal movement.
- ※ Items No. 77~79 : functions that check each analog input normal movement.
- ※ Item No. 80 : function that checks whether the synchronizer signal is working properly.
- ※ Item No. 81 : function that checks whether the encoder A/B is working properly.
- ※ Item No. 82 : function that checks whether the encoder R/S/T is working properly.

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

No.	Function	Initial value	Range	Step
90	Sewing machine pulley size	?	0~9999	1pulse
91	Distance between up-stop ~ low-stop (the standard is the pulley's normal direction rotation)	?	0~9999	1pulse
92	Programming the upper stop location (the standard is the pulley's normal direction rotation) - Not valid for model S-III	?	0~359	1degree
93	Programming the low-stop location (the standard is the pulley's normal direction rotation) - Not valid for model S-III	?	0~359	1degree
94	Index pulse occurring position (the standard is the pulley's normal direction rotation) - Turn the pulley manually and stop it in the position you want.	?	0~359	1degree
95	CAM type thread release solenoid operation position - Turn the pulley manually and stop it in the position you want.	?	0~359	1degree
96	CAM type thread release solenoid release position - Turn the pulley manually and stop it in the position you want.	?	0~359	1degree
97	CAM type thread trimming solenoid operation position - Turn the pulley manually and stop it in the position you want.	?	0~359	1degree
98	CAM type thread trimming solenoid release position - Turn the pulley manually and stop it in the position the user wants	?	0~359	1degree
99	Manual and automatic set up of solenoid operation / release position in CAM type thread trimming	1	0/1	0=manual set up 1=automatic set up

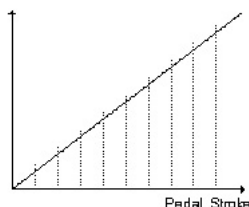
[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

(3) Group C Parameter: Pedal acceleration/deceleration curve, slow starting speed and input/output port change related parameter

※ These are functions not used by general users and must be regulated by an after-sales service engineer.

No.	Function	Initial value	Range	Step
1	1 step section where pedal moves forward	10	0~64	1
2	2 step section where pedal moves forward	15	0~64	1
3	3 step section where pedal moves forward	31	0~64	1
4	4 step section where pedal moves forward	40	0~64	1
5	5 step section where pedal moves forward	52	0~64	1
6	Sewing speed value in the 1 step where pedal moves forward	440spm	40~9960	40spm
7	Sewing speed value in the 2 step where pedal moves forward	920spm	40~9960	40spm
8	Sewing speed value in the 3 step where pedal moves forward	4000spm	40~9960	40spm
9	Sewing speed value in the 4 step where pedal moves forward	5480spm	40~9960	40spm
10	Sewing speed value in the 5 step where pedal moves forward	9960spm	40~9960	40spm
11	Select slow start after thread trimming (After performing thread trimming, start the next sewing work slowly)	0	0/1	1=selection
12	Select slow start after sewing machine stops (After performing sewing machine stops, start the next sewing work slowly)	0	0/1	1=selection
13	When starting slowly, select sewing speed change	0	0/1	1=Use C14~C18 value 0=Use default value
14	The speed of the first stitch when starting slow	400spm	40~9960	40spm
15	The speed of the second stitch when starting slow	400spm	40~9960	40spm
16	The speed of the third stitch when starting slow	640spm	40~9960	40spm
17	The speed of the fourth stitch when starting slow	1000spm	40~9960	40spm
18	The speed of the fifth stitch when starting slow	1680spm	40~9960	40spm
19	Limited maximum motor speed	3000rpm	20~3400	20rpm
20	Synchronizer sensor rotation sensing time	40×0.1sec	5~1275	0.5sec
21	Overload sensing time	30×0.1sec	5~1275	0.5sec
22	Solenoid electric overflow sensing time	100ms	4~1020	4ms
23	Power off sensing time	4ms	4~1020	4ms
24	NOT USED			
25	Bad signal of the Encoder A and B phase detecting number of time	4	1~255	1
26	Back signal of the Encoder R, S and T phase detecting number of time	4	1~255	1
27	Bad signal of the Encoder R, S and T phase detecting number of time	4	1~255	1
28	NOT USED			
29	<ul style="list-style-type: none"> • Automatic scaling to the speed curve selected by each set mode - Mode 0 : Use a curve based on the set values from C-1 to C-10 - Mode 1 : Scaling to the speed set at A-2 - Mode 2 : Scaling to the speed set using the Speed Up/Dn key 	1	1~2	1



※ Items No. 1~5 : Equal division of pedal stroke in 64 steps, The speed curve of the pedal stroke changes according to how many steps are set up for the divided pedal stroke of each forward pedal step. (Used when adjusting pedal sensor)

※ No. 20 : If a synchronizer signal comes, but the next synchronizer signal does not come within the sensing time, an error message will appear .

※ No. 21 : If a speed instruction was sent to the motor but the motor does not reach the value of the speed instruction, an error message will appear.

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

※ This item is operated by the factory only, so general users and A/S technicians should not use it.

No.	Function	Initial value	Step
30	OUTPUT00 (B/T Solenoid) : Low Active	0(Fixed)	※ Output port changing function - write the function number on the output PIN you want to change after referring to the table below
31	OUTPUT01 (P/F Solenoid) : Low Active	1(Fixed)	
32	OUTPUT02 (T/T Solenoid) : Low Active	2	
33	OUTPUT03 (W/P Solenoid) : Low Active	3	
34	OUTPUT04 (T/R Solenoid) : Low Active	4	
35	OUTPUT05 (Left Solenoid) : Low Active	5	
36	OUTPUT06 (Right Solenoid) : Low Active	6	
37	OUTPUT07 (AUX Solenoid) : Low Active	7	
38	OUTPUT10 (Left LED) : High Active	8	
39	OUTPUT11 (Right LED) : High Active	9	
40	OUTPUT12 (Needle upper stop notifying signal) : High Active	10	
41	OUTPUT13 (Needle lower stop notifying signal) : High Active	11	
42	OUTPUT14 (Signal notifying motor is running) : High Active	12	
43	OUTPUT15 (Signal notifying target has been reached) : High Active	13	

★ A : Output PIN function

Function No.	H/W type actual output name	Function No.	H/W type actual output name
0	B/T Solenoid (with duty)	100	inv. B/T Solenoid (with duty)
1	P/F Solenoid (with duty)	101	inv. P/F Solenoid (with duty)
2	T/T Solenoid (with duty)	102	inv. T/T Solenoid (with duty)
3	W/P Solenoid (with duty)	103	inv. W/P Solenoid (with duty)
4	T/R Solenoid (with duty)	104	inv. T/R Solenoid (with duty)
5	Left Solenoid (with duty)	105	inv. Left Solenoid (with duty)
6	Right Solenoid (with duty)	106	inv. Right Solenoid (with duty)
7	AUX Solenoid (with duty)	107	inv. AUX Solenoid (with duty)
8	Left LED (with duty)	108	inv. Left LED (with duty)
9	Right LED (with duty)	109	inv. Right LED (with duty)
10	"Needle Up-stop" notifying signal (with duty)	110	inv. Needle Up-Stopped (with duty)
11	"Needle Down-stop" notifying signal (with duty)	111	inv. Needle Down-Stopped (with duty)
12	"Sewing machine running" notifying signal (with duty)	112	inv. Motor Running (with duty)
13	"Target speed" notifying signal (with duty)	113	inv. Target Speed (with duty)
14	"Trimming" notifying signal (without duty)	114	inv. Trimming (without duty)
15	"End Back Tack" notifying signal (without duty)	115	inv. End Back Tack (without duty)
16	"Emergency stop" notifying signal (without duty) - A signal appears when the motor stops for any error.	116	inv. Emergency Stopped (without duty) - A signal appears when the motor stops for any error
17	Roller Lift Solenoid (without duty)	117	inv. Roller Lift Solenoid (without duty)
18	Hemming Device Output (without duty)	118	inv. Hemming Device Output (without duty)
19	"First step forward pedal" notifying signal (without duty)	119	inv. Pedal Start (without duty)
200	Low signal (without duty)	201	High signal (without duty)

※ If an output signal has been sent twice in the OUTPUT00~OUTPUT15 output pin, the same signal will appear in two different output pins.

Ex) if OUTPUT00 = 0 & OUTPUT03 = 0, then B/T signal is output from both OUTPUT00 & OUTPUT03 pin

※ When setting up other functions apart from the function numbers listed above, the pertinent output pin functions are disregarded.

※ Roller Lift Solenoid = Presser Foot-Lift solenoid + Back Tack solenoid + Roller Lift Switch

43~	NOT USED		
49	NOT USED		

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.



No.	Function	Initial value	Step
50	INPUT00 (Button A)	0	※ Output port changing function - Write the function number on the output PIN you want to change after referring to the table below
51	INPUT01 (Button B)	1	
52	INPUT02 (1/4 stitch Switch)	2	
53	INPUT03 (2/4 stitch Switch)	3	
54	INPUT04 (3/4 stitch Switch)	4	
55	INPUT05 (4/4 stitch Switch)	5	
56	INPUT06 (Left Sol. Switch)	6	
57	INPUT07 (Right Sol. Switch)	7	
58	INPUT10 (Presser Foot-Lift Switch)	8	
59	INPUT11 (Counter Switch)	9	
60	INPUT12 (P/U 1/2 stitch Switch Signal)	10	
61	INPUT13 (Safety Switch Signal)	11	
62	INPUT14 (Edge Sensor Signal)	12	
63	INPUT15 (Thread trimmer not allowed Signal)	13	
64	INPUT20 (Pedal Start Signal)	16	
65	INPUT21 (Pedal Presser Foot-Lift Signal)	17	
66	INPUT22 (Pedal Trim Signal)	18	

★ B : Input PIN function

No.	Actual Hardware Output Name	No.	Actual Hardware Output Name
0	Button A Switch	100	inv Button A Switch
1	Button B Switch	101	inv Button B Switch
2	1/4 stitch Switch	102	inv 1/4 stitch Switch
3	2/4 stitch Switch	103	inv 2/4 stitch Switch
4	3/4 stitch Switch	104	inv 3/4 stitch Switch
5	4/4 stitch Switch	105	inv 4/4 stitch Switch
6	Left Solenoid Switch	106	inv Left Solenoid Switch
7	Right Solenoid Switch	107	inv Right Solenoid Switch
8	Presser Foot-Lift Switch	108	inv Presser Foot-Lift Switch
9	Counter Switch	109	inv Counter Switch
10	Program Unit 1/2 stitch Switch	110	inv Program Unit 1/2 stitch Switch
11	Safety Switch	111	inv Safety Switch
12	Edge Sensor Signal	112	inv Edge Sensor Signal
13	Thread Trimmer Signal	113	inv Trimming Disabled Signal
14	Roller Lift Switch	114	inv Roller Lift Switch
15	N_AUTO Switch	115	inv N_AUTO Switch
16	Pedal Start Signal	116	inv Pedal Start Signal
17	Pedal Presser Foot-Lift Signal	117	inv Pedal Presser Foot-Lift Signal
18	Pedal Thread Trimming Signal	118	inv Pedal Thread Trimming Signal
19	External Signal	119	inv External Signal

※Caution : When any inputs PIN No. INPUT00 ~ INPUT22 are overlapped, it works as the "OR" circuit.

Ex) if INPUT00 = 0 & INPUT01 = 0, then it is recognized as "button A" = INPUT00 + INPUT01.

※ The hardware of input switches and sensors are done with "a point of contact/Active High" input as the standard.

※ When setting up other functions numbers apart from the ones listed above, the pertinent output pin functions are disregarded.

70	Output Signal Level Collective Reverse Function	0	0/1	1=Output signal Collective Reverse, selection
71	Input Signal Level Collective Reverse Function	0	0/1	1=Input signal Collective Reverse, selection
72~	NOT USED			
99	NOT USED			

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

(4) Group D Parameter: All types of gain parameter related motor control

※ These are functions not used by general users and must be regulated by an A/S technician.

No.	Function	Initial Value	Range	Step
1	speed P-gain Kvp	30	0~30	1
2	speed D-gain Kvd	0	0~3000	1
3	location P-gain Kpp	200	0~1000	1
4	location D-gain Kpd	1000	0~5000	1
5	acceleration A accelA	65	1~100	1
6	acceleration B accelB	70	1~100	1
7	acceleration C accelC	30	1~100	1
8	acceleration D accelD	10	1~100	1
9	sewing machine inertia value Inertia	40	0~255	1
10	positioning speed Wpos	220rpm	100~510	2rpm
11	stopping speed Wstop	75rpm	0~255	2rpm
12	Stop delaying time StopDelay	80ms	4~1020	4ms
13	Positioning distance DIST1	110degree	24~255	1degree
14	upper speed instruction unit spd_unit	100spm	1~100	1spm
15	Positioning P-gain Kpp2	270	0~9999	1
16	Positioning D-gain Kpd2	2027	0~9999	1
17	Positioning P-gain Kpp3	200	0~9999	1
18	Positioning D-gain Kpd3	1000	0~9999	1
19~	NOT USED			
99	NOT USED			

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

3) Method of Use and Explanations for Specific Items of the Parameter

(1) Method of Use and Explanations for Specific Items of the Group A Parameter

(General functions of sewing machine)

A. Minimum/maximum sewing speed limit set up method and thread trimming speed set up method

Item No.	Name of function	Method of use and explanation
A-1	Minimum sewing speed limit set up	This item allows user to set up the minimum sewing speed limit or the minimum sewing speed given when the pedal is pressed.(20~510rpm, Initial value : 200rpm)
A-2	Maximum sewing speed limit set up	This item allows user to set up the maximum sewing speed limit or the maximum sewing speed given when the pedal is pressed.(40~9960rpm, Initial value : 4000rpm)
A-3	Thread trimming speed set up	This item allows the user to set up the thread trimming speed when the thread trimming function is operating after sewing

B. Set up method of ½stitch speed by program unit(P/U) and needle plate lift/drop by button A

Item No.	Name of function	Method of use and explanation
A-4	Set up method of stitch speed by program unit (P/U)	This item allows user to set up the stitch speed by program unit (P/U) and hence sets up the stitch operating speed. However, if set up to a rapid speed, many stitches may be sewn after pressing the button.
A-5	Set up the speed of lift/drop of needle plate with button A	This item allows user to set up the speed of lift/drop of the needle plate with button A. However, if set to a rapid speed, many stitches may be sewn after pressing the button.

C. Start B/T sewing speed and end B/T sewing speed set up method

Item No.	Name of function	Method of use and explanation
A-7	Start B/T speed set up	This item allows user to set up the start B/T speed. If the speed is changed, the stitch correction value also has to be set again.
A-8	End B/T speed set up	This item allows user to set up the end B/T speed. If the speed is changed, the stitch correction value also has to be set again.

D. Selection method of thread trimming location with pedal

Item No.	Name of function	Method of use and explanation
A-19	Start B/T speed set up	You can change the thread trimming operation through pedal position by making the following changes to the set up values. <ul style="list-style-type: none"> • 0 : When the pedal position is backward 2 gear, operate thread trimming(Starting set up value). • 1 : When pedal position is backward 1 gear, operate thread trimming • 2 : When pedal position is neutral, operate thread trimming.

E. Edge Sensor method of use Item No.

Item No.	Name of function	Method of use and explanation
A-40	Selection of edge sensor type	The set up method changes according to the set up parts of edge sensor <ul style="list-style-type: none"> • 0 : When edge is sensed and using high output sensor. • 1 : When edge is sensed and using low output sensor.
A-41	Stitches performed after edge sensor sensing	A function that programs the machine to stop after sewing a programmed amount of stitches when edge is sensed.
A-42	Sewing speed of stitches performed after edge sensor sensing	A function that programs the sewing speed after sewing a programmed amount of stitches when edge is sensed.
A-46	Selection of edge sensing sewing mode (select N-stitch mode)	A function that programs the edge sensor to operate normally, even when other sensor signals are inputted in the edge sensor port.

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

F. Pre-stitch function method of use and explanation

Item No.	Name of function	Method of use and explanation
A-47	Selection of pre-stitch function	The pre-stitch function is a function that programs the machine to sew a certain amount of stitches before commencing the actual sewing work.(0 : disable, 1 : enable)
A-48	Set pre-stitching stitch number	This item sets the number of stitches when using the pre-stitch function (0~255 stitches, Initial value : 3 stitches)
A-49	Set pre-stitching speed	This item sets the sewing speed when using the pre-stitch function. (20~2000rpm, Initial value : 2000rpm)

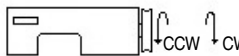
G. Method to select beginning/ending reverse sewing conditions

Item No.	Name of function	Method of use and explanation
A-50	Selection of start B/T conditions (Initial value : 1)	The start B/T function can be one of the following three operations according to their set up value <ul style="list-style-type: none"> • 0 : If user releases pedal during B/T operation, sewing stops. • 1 : If user releases pedal during B/T operation, sewing stops after finishing work. • 2 : The exact amount of stitches is operated, notwithstanding the number of stitch corrections. However, if this function is used, B/T will no operate naturally.
A-51	Selection of end B/T conditions (Initial value : 0)	This item selects whether or not to use the end B/T's exact number of stitches function operation <ul style="list-style-type: none"> • 0 : exact number of stitches function disabled • 1 : exact number of stitches function enabled (If this function is used, reverse sewing will no operate naturally)
A-52	The speed of the first stitch during B/T exact performance	This item selects the speed of the initial reverse stitch when user has selected the exact number of stitches function in the B/T operation(20~1000rpm, Initial value : 200rpm)

H. Method to select buttons A/B functions

Item No.	Name of function	Method of use and explanation
A-54	Selection of button A function (Initial value : 2)	The function of button A can be one of the following four operations according to their set up value. <ul style="list-style-type: none"> • 0 : If user presses A button while sewing, B/T sewing is operated while user keeps on pressing it. • 1 : If user presses the A button while sewing, B/T sewing is operated. If user stops sewing and presses A button once the needle plate is lifted. If user presses it once more, the needle plate is dropped • 2 : If user presses the A button while sewing, B/T sewing is operated while user keeps on pressing it. If user stops sewing and presses A button once, the needle plate is lifted. If user presses it twice consecutively, the needle plate is dropped. • 3 : If user presses A button while sewing, B/T sewing is operated while user keeps on pressing it. When user stops sewing and presses the A button, 1/2 stitch speed is operated.
A-55	Selection of button B function (Initial value : 0)	The function of button B can be one of the following four operations according to their set up value. <ul style="list-style-type: none"> • 0 : This item has the function of inserting/deleting the B/T sewing when user presses the B button. If the user presses the B button where there is no B/T sewing section, B/T sewing is inserted and when it is pressed where there is a B/T sewing section, B/T sewing is deleted. • 1 : If user presses the B button once, the needle plate is lifted and if user presses it once more, it is dropped • 2 : When user stops sewing and presses the B button, 1/2 stitch speed is operated while user presses it. • 3 : When sewing, B/T sewing is operated while user presses B button.

I. Method of use of motor rotating direction selection function

Item No.	Name of function	Method of use and explanation
A-65	Selecting the motor's rotating direction	This item sets up the set up value according to the motor's rotating direction <ul style="list-style-type: none"> • 0 : clockwise rotation • 1 : counterclockwise rotation(Initial value) 

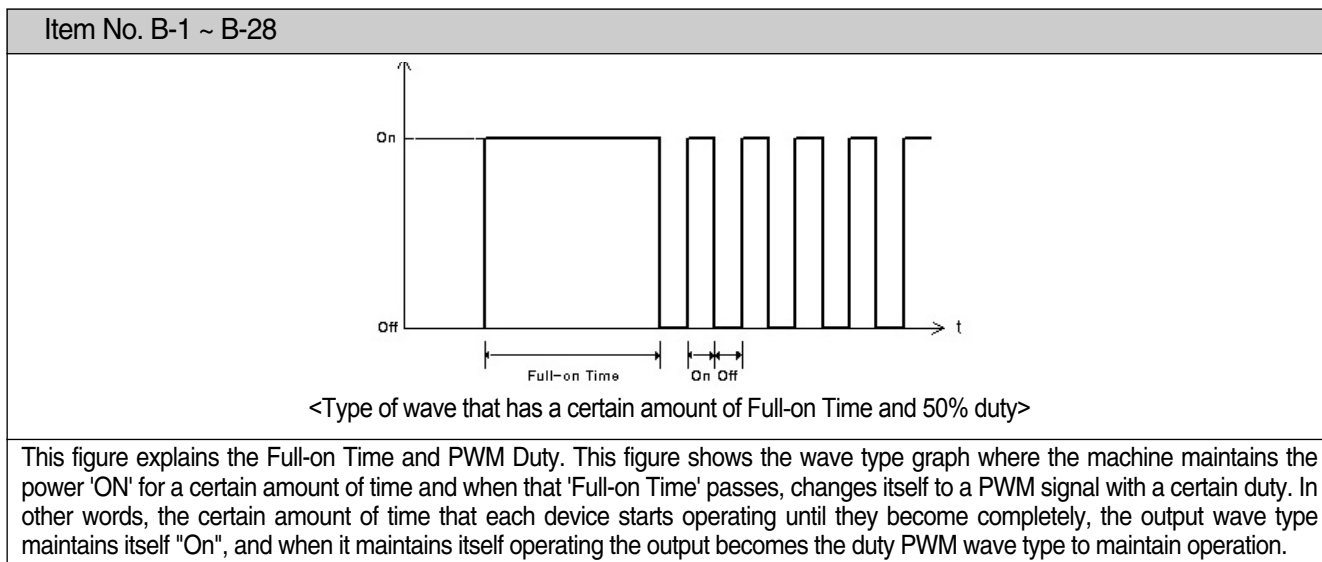
[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

(2) Group B Parameter Specific Method of Use and Explanation (All types of output, Full-on Time/PWM Duty, checking the input/output movements, sewing machine models and thread trimming sequence programming)

※ These are functions not used by general users and should be regulated by an A/S technician.

A. All types of output, Full-on Time/PWM Duty time set up method (all types of solenoids, LED and signals)



B. B/T stitch correction set up method

Item No.	Name of function	Method of use and explanation	
B-30	Start B/T A side stitch correction value	This item has the function of correcting the B/T sewing stitch that has not been shaped well, and you can change the value of sides A, B, C, D. <ul style="list-style-type: none"> • The programmed value in the beginning A : 3, B : 3, C : 4, D : 4 • Program range : 0 ~ 9 	
B-31	Start B/T B side stitch correction value		
B-32	End B/T C side stitch correction value		
B-33	End B/T D side stitch correction value		
<ul style="list-style-type: none"> • If the stitch correction values is changed using the program unit, the item value will automatically change. Reversely, if you change the programmed value of the items above, the stitch correction values will also automatically change. • Detailed correction principles and methods of use are the same as the program unit's stitch correction method. Please refer to the program unit method of use of start/end B/T stitch correction method. 			

C. Counter function method of use

Item No.	Name of function	Method of use and explanation
B-35	Counter condition set up	For detailed method of use and explanation of counter function, refer to the program unit's counter set up button method of use.
B-36	When using automatic counter after trimming, select increasing/decreasing counter	
B-37	After counter operation is over, set up the next operation	
B-38	After counter operation is over, select the automatic erasing operation	

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

(3) Group C Parameter Specifics Method of Use and Explanation

(Pedal acceleration/deceleration curve, slow starting speed, input/output port change related parameter)

※ These are functions not used by general users and should be regulated by an A/S technician.

A. Pedal stroke step by step section and speed set up method

Item No.	Name of function	Beginning value	Method of use and explanation
C-1	pedal forward first step section	10	After dividing the pedal stroke to 64 steps, the pedal stroke's acceleration/deceleration curve changes according to which stroke step is programmed from pedal forward steps 1 through 5.
C-2	pedal forward second step section	15	
C-3	pedal forward third step section	31	
C-4	pedal forward fourth step section	40	
C-5	pedal forward fifth step section	52	
C-6	sewing speed during pedal forward first step	440rpm	The pedal stroke's acceleration/deceleration curve changes according to how the pedal forward step by step sewing speed set up is done.
C-7	sewing speed during pedal forward second step	920rpm	
C-8	sewing speed during pedal forward third step	4000rpm	
C-9	sewing speed during pedal forward fourth step	5480rpm	
C-10	sewing speed during pedal forward fifth step	9960rpm	

B. Slow-start sewing method of use : this function allows to start the sewing slowly and the user can set up the following specific items.

Item No.	Name of function	Method of use and explanation
C-11	Slow Start after thread trimming	These items help you choose at which point you can apply slow start. If you want to apply it after thread trimming set item No. C-11 value to 1. If you want to apply it after when you start sewing after stopping set item No. C-12 to 1. If both these items are set to 0, the slow starting function will not operate.
C-12	Slow Start after sewing machine stops	
C-13	When Slow Starting, change Slow- starting speed	When using the slow start function, this item gives you the option of maintaining the same starting speed or setting up a new speed. If you want to set up a new speed, use items No. C-14~C-18 and set up a new speed.
C-14	When Slow Starting, the operation speed of beginning stitch	When the item No. C-13 set up value is "1", the slow start beginning values (the specific items that change the set up value) are • 1 : 400rpm • 2 : 400rpm • 3 : 640rpm • 4 : 1000rpm • 5 : 1680rpm
C-15	When Slow Starting, the operation speed of second stitch	
C-16	When Slow Starting, the operation speed of third stitch	
C-17	When Slow Starting, the operation speed of fourth stitch	
C-18	When Slow Starting, the operation speed of fifth stitch	

C. Motor maximum speed limit set up method

Item No.	Name of function	Method of use and explanation
C-19	Set up motor maximum speed limit	This function allows you to limit the maximum motor speed, and the starting value is set to 3000 rpm.

[Caution]

If the specific items of the parameter are changed carelessly, they could break down or damage the machine, so the user must be well-trained before using it.

4) Thread Trimming Sequence Function Method of Use (Items no. 54, 55, 56 of Group B)






※ Thread trimming sequence function characteristics

- The thread trimming sequence is a user programming function of PLC control type used for thread trimming or when a special simple repetitive function is required .
- The user composes the thread trimming sequence he wants, and can program the machine or motor's operation during thread trimming.
- When necessary, the user can change it to exclusive mode and can program all types of special operations.
- The program size is 64 bytes, so compose the program within this size limit.
- The program code is composed of the command field and the data field.
- The thread trimming related parameters are items No. 54, 55, 56 from Group B.

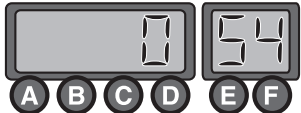
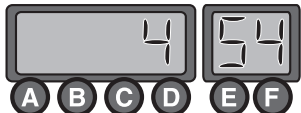
Item No.	Function
B-54	This item that provides the function of thread trimming sequence selection which allows the user to select and use the sequence from item No. B-55
B-55	This item provides the function of allowing the user to compose the thread trimming sequence himself.
B-56	This item provides the function of allowing the user to select other company sewing machine models, and makes automatic changes in the thread trimming sequence that fit the selected sewing machine.

(1) Thread Trimming Sequence Function Related Parameter Method of Use and Explanations



A. Thread Trimming Sequence Data Input Function (Item No. B-55)

<p>① This function allows the user to compose the thread trimming sequence himself. In order to do this, the user must first enter parameter Group B.</p>	
<p>② If the screen changes, go to the specific items and choose item No. 55 from Group B. Then the user will see the letter "Seq" blink. (Use buttons E, F)</p>	
<p>③ If you press the Enter button where it says "Seq 55", you can now choose the thread trimming sequence. In the figure. you can see the command "--80" which indicates the sequence start. The command "01" is a number within the sequence (01~64) of the "--80" command.</p>	
<p>④ If you use buttons E, F to increase the numbers, you can see the sequence that was set up in the start. Their contents are explained below</p> <ul style="list-style-type: none"> • 01 : "--08" ⇒ Sequence starting code • 02 : "--F3" ⇒ General sequence • 03 : "--00" ⇒ Sequence ending code 	
<p>⑤ Now the user can change the sequence function according to his objectives but the remember that the program size cannot exceed 64 bytes. Also you can set up several short sequences and then use the sequences you want by using item No. B-54. When you setting this up, each sequence must always have a starting and ending code. ※Refer to sequence code list</p>	
<p>[Caution]</p> <ul style="list-style-type: none"> • If you don't press the Enter button after changing the parameter item set up value, the set up value will not be saved, so use caution when using it. • If the specific items of the parameter are changed carelessly, they could cause breakdown or damage the machine. Therefore, the user must be well-trained before using it. 	

B. Thread Trimming Sequence Selection Function Method of Use (Item No. B-54)

<p>① This function is used when the user wants to use other sequences apart from the sequences that are basically provided. If you want to use this function, first enter Item No.54 in parameter Group B. Then you will see the screen shown in the figure.</p>	
<p>② The starting value is set to "0". If you change this number to a value in the sequence of Item No. B-55, you can now use the extra programmed sequence. (Use the C, D buttons) (Ex : if you want to use the fourth sequence and change the sequence set up)</p>	
<p>③ The user can use Item No. B-55 to save and use several frequently used sequences whenever he needs them.</p>	
<p>[Caution]</p> <ul style="list-style-type: none"> • If you don't press the Enter button after changing the parameter item set up value, the set up value will not be saved, so use caution when using it. • If the specific items of the parameter are changed carelessly, they could cause breakdown or damage the machine. Therefore, the user must be well-trained before using it. 	

C. Thread Trimming Sequence Automatic Change According to Sewing Machine Model Selection

<p>① This function allows automatic change of thread trimming sequence when user attaches the controller to a sewing machine other than the one being currently used. If you want to use this function, first enter Item No.56 in parameter Group B. You will see then the screen shown in the figure.</p>	
<p>② If you press the Enter button after changing the set up value to fit the new sewing machine model number, the matching thread trimming sequence is duplicated. *Refer to the sewing machine list (Ex : when using the SunStar KM-790BL-7 sewing machine)</p>	
<p>③ The duplicated thread trimming sequence can be check in the Item No. B-55 and if you want to change the contents you can do so using Item No. B-55</p>	
<p>[Caution]</p> <ul style="list-style-type: none"> • If you don't press the Enter button after changing the parameter item set up value, the set up value will not be saved, so use caution when using it. • If the specific items of the parameter are changed carelessly, they could cause breakdown or damage the machine. Therefore, the user must be well-trained before using it. 	









(2) Thread Trimming Sequence Function Related Parameter Method of Use and Explanations (Economic)

A. Changing the Trimming Sequence with the Simplified Operation Panel

When changing the thread trimming sequence by using the simplified operation panel, the method is a bit different from when changing other parameters. Check the following manual and make the changes in a correct manner.



<S- III Simplified Operation Panel>

	How to Operate	Display	Remarks
1	Press E/Prg button and A button simultaneously. Then the screen for changing parameters appears.		• Program Enable
2	Press B button, and it moves to the parameter B group.		• Parameter B-01
3	Use A button and B button to move to the No. 55 trimming sequence of the B group.		• Parameter B-55
4	Press C button when "b-55" is displayed. Then "SEQ" blinks on the screen.		• Sequence
5	Press C button once again, and the screen displays the starting location number of trimming sequence.		• -80" : Trimming sequence start command
6	Press A button and B button to change the location number of the current trimming sequence. ex) When A is pressed, "--80" is changed to "--81".		• The starting location number of trimming sequence has changed from "--80" to "--81".
7	When C button or D button is pressed, the trimming sequence location number increases or decreases. The screen displays the values stored in the concerned sequence location. ex) When C is pressed, the screen displays "--83", the value which is in the second trimming sequence location.		• In case where Model = 88, the "--83" command is stored in the second trimming location.
8	When the trimming sequence change is complete following the above procedure, press E/Prg button to store the sequence.		• Trimming sequence is stored.
9	<p>[Notice]</p> <ul style="list-style-type: none"> • Please make sure that in case of a simplified operation panel, the location value of the current trimming sequence is not shown. • Please make sure that in case of a simplified operation panel, the functions of the buttons A, B, C, D, E are a bit different from those when they are used in other context. • In order to exit the trimming sequence change mode, press "E". Then all the changed values will be stored. • If you want to make several changes, press "E" one time after all changes are made to save the changed values. 		

(3) Basic Structure of Thread Trimming Sequence Program Code

A. The thread trimming sequence program code is basically composed of the command field and data field which comes according to the command field. The size of the program cannot exceed 64 bytes.

Explanation of function		Command field	Data field		
			1st	2nd	3rd
PosStopUp	Needle plate up-stop after sewing given stitch numbers at given speed.	CE H	0~5000[rpm](20rpm)	0~255[stitch]	

B. The table above is an example of the program code structure. If you want to use the function "Needle plate up-stop after sewing given stitches at given speed" you must first select the command code "CE H" and set up the data value according to the command code. In other words, the given sewing speed is the first data and the given stitch numbers is the second data and both of these form the data field. Depending on the command code, there can exist a data field or exist three data in the data field.

(4) Thread Trimming Sequence Program Code List

Category	Explanation	Cmd Field	Data Field		
			1st	2nd	3rd
Output Port Control (Total 40)	B/T Solenoid	On	81H		
	P/F Solenoid	On	82H		
	T/T Solenoid	On	83H		
	W/P Solenoid	On	84H		
	T/R Solenoid	On	85H		
	Left Solenoid	On	86H		
	Right Solenoid	On	87H		
	AUX Solenoid	On	88H		
	Left LED	On	89H		
	Right LED	On	8AH		
	Needle Up Signal	On	8BH		
	Needle Down Signal	On	8CH		
	Motor Runing Signal	On	8DH		
	Reaching Target Speed Signal	On	8EH		
	Motor Trimming Signal	On	8FH		
	Motor End Tacking Signal	On	90H		
	Emergency Stop Signal	On	91H		
	Roller Lift Solenoid	On	92H		
	Hemming Device Output	On	93H		
	Pedal Forward Step1 Signal	On	94H		
	B/T Solenoid	Off	98H		
	P/F Solenoid	Off	99H		
	T/T Solenoid	Off	9AH		
	W/P Solenoid	Off	9BH		
	T/R Solenoid	Off	9CH		
	Left Solenoid	Off	9DH		
	Right Solenoid	Off	9EH		
	AUX Solenoid	Off	9FH		
	Left LED	Off	A0H		
	Right LED	Off	A1H		
	Needle Up Signal	Off	A2H		
	Needle Down Signal	Off	A3H		
	Motor Runing Signal	Off	A4H		
	Reaching Target Speed Signal	Off	A5H		
	Motor Trimming Signal	Off	A6H		
	Motor End Tacking Signal	Off	A7H		
	Emergency Stop Signal	Off	A8H		
	Roller Lift Solenoid	Off	A9H		
	Hemming Device Outout	Off	AAH		
	Pedal Forward Step1 Signal	Off	ABH		
Time Delay	Delay by 1[ms] unit		B0H	0~255[ms] (1ms)	
	Delay by 2[ms] unit		B1H	0~510[ms] (2ms)	
	Delay by 4[ms] unit		B2H	0~1020[ms] (4ms)	
	Delay by 0.5[s] unit		B3H	0~127.5[s] (0.5s)	



Category	Explanation		Cmd Field	Data Field		
				1st	2nd	3rd
Motor Control	On Hold	Motor—Holding Start	C0H			
	Off Hold	Motor—Holding Stop	C1H			
	Set Dir CW	Set CW direction)	C2H			
	Set Dir CCW	Set CCW direction)	C3H			
	Set Speed	Make Motor Run with given Speed	C4H	0~5000 [spm] (20spm)		
	Set SpdByPed	Make Motor Run with Speed given by pedal	C5H			
	Up Stop	Make Stop in Needle Up (stop)	C6H			
	DN Stop	Make Stop in Needle Down (stop)	C7H			
	Up Stop InSpd	Make Up Stop with given Speed (stop)	C8H	0~500 [spm]	(2spm)	
	Dn Stop InSpd	Make Dn Stop with given Speed (stop)	C9H	0~500 [spm]	(2spm)	
	Dacc Up Edge	Decel. in Speed at Up Edge (not stop)	CAH	0~500 [spm]	(2spm)	
	Dacc Dn Edge	Decel. in Speed at Dn Edge (not stop)	CBH	0~500 [spm]	(2spm)	
	Move Up Edge	Move to Up Edge with given Speed (not stop)	COH	0~500 [spm]	(2spm)	
	Move DnEdge	Move to Dn Edge with given Speed (not stop)	CDH	0~500 [spm]	(2spm)	
	Pos Stop Up	Up Stop after sewing given stitch with given Speed	CEH	0~5000 [spm] (20spm)	0~255 [stitch]	
	Pos Stop Dn	Dn Stop after sewing given stitch with given Speed	CFH	0~5000 [spm] (20spm)	0~255 [stitch]	
	Pos Dacc Up	Dacc Dn Edge after sewing given stitch with given Speed	D0H	0~5000 [spm] (20spm)	0~500 [spm] (2spm)	0~255 [stitch]
	Pos Dacc Dn	Dacc Up Edge after sewing given stitch with given Speed	D1H	0~5000 [spm] (20spm)	0~500 [spm] (2spm)	0~255 [stitch]
	L Move Stop	Move given distance with given Speed	D2H	0~ 500 [spm]	(2spm)	0~357 [deg]
	SpdInPos	Make motor given Speed in given Position	D3H	0~5000 [spm] (20spm)	0~357 [deg]	
Random Stop	Stop randomly	D4H				
Position /Speed Check	Wait Pos1	When position already passed, return	E0H	0~357 [deg]		
	Wait Pos2	When position already passed, wait next position and then return	E1H	0~357 [deg]		
	Wait Up Edge	Wait until Up Edge detected.	E2H			
	Wait Dn Edge	Wait until Dn Edge detected	E3H			
	Chk Pos	Check the position passed & branch to the address	E4H	0~357 [deg]	0~64 (address)	
	Chk Up Edge	Check Up Edge detected & branch to the address	E5H	0~64 (address)		
	Chk Dn Edge	Check Dn Edge detected & branch to the address	E6H	0~64 (address)		
	Cl Up Edge	Clear Up Edge FG (mark UpEdge not detected)	E7H			
	Cl Dn Edge	Clear Dn Edge FG (mark DnEdge not detected)	E8H			
	Wait Speed	Wait until motor speed is target speed	E9H	0~5000 [spm] (20spm)		
	Chk Speed	Check if motor speed is target speed & branch to the address	EAH	0~357 [deg]	0~64 (address)	

Category	Explanation		Cmd Field	Data Field		
				1st	2nd	3rd
Input Port Check WaitPort	Wait until the port signal detected	Button A	F0H	0 (Input Port No)		
		Button B		1		
		Switch 1/4 stich		2		
		Switch 2/4 stich		3		
		Switch 3/4 stich		4		
		Switch 4/4 stich		5		
		Left Solenoid Switch		6		
		Right Solenoid Switch		7		
		Pressor Foot Lift Switch		8		
		Counter Switch		9		
		Button 1/2 switch on P/U Box		10		
		Safety Switch		11		
		Edge Sensor		12		
		Trimming Disable Switch		13		
		Roller lift Switch		14		
		N-AUTO Switch		15		
		Pedal Start Input		16		
		Pedal Pressor-Foot Input		17		
		Pedal Thread Trimming Input		18		
	External Input	19				
	BrChkPort (Check the port and branch the given address)	Button A	F1H	0 (Port No)	0~64 (address)	
		Button B		1	0~64	
		Switch 1/4 stich		2	0~64	
		Switch 2/4 stich		3	0~64	
		Switch 3/4 stich		4	0~64	
		Switch 4/4 stich		5	0~64	
		Left Solenoid Switch		6	0~64	
		Right Solenoid Switch		7	0~64	
		t Switch		8	0~64	
		Counter Switch		9	0~64	
		Button 1/2 switch on P/U Box		10	0~64	
		Safety Switch		11	0~64	
		Edge Sensor		12	0~64	
		Trimming Disable Switch		13	0~64	
		Roller lift Switch		14	0~64	
		N-AUTO Switch		15	0~64	
		Pedal Start Input		16	0~64	
		Pedal Pressor-Foot Input		17	0~64	
Pedal Thread Trimming Input		18		0~64		
External Input	19	0~64				
Sequence Control	Branch	Branch to given address	F2H	0~64 (Address)		
	GenSeq	General Trimming Sequence	F3H			
	StartSeq	Start of the sequence	80H			
	EndSeq	End of the sequence	00H			

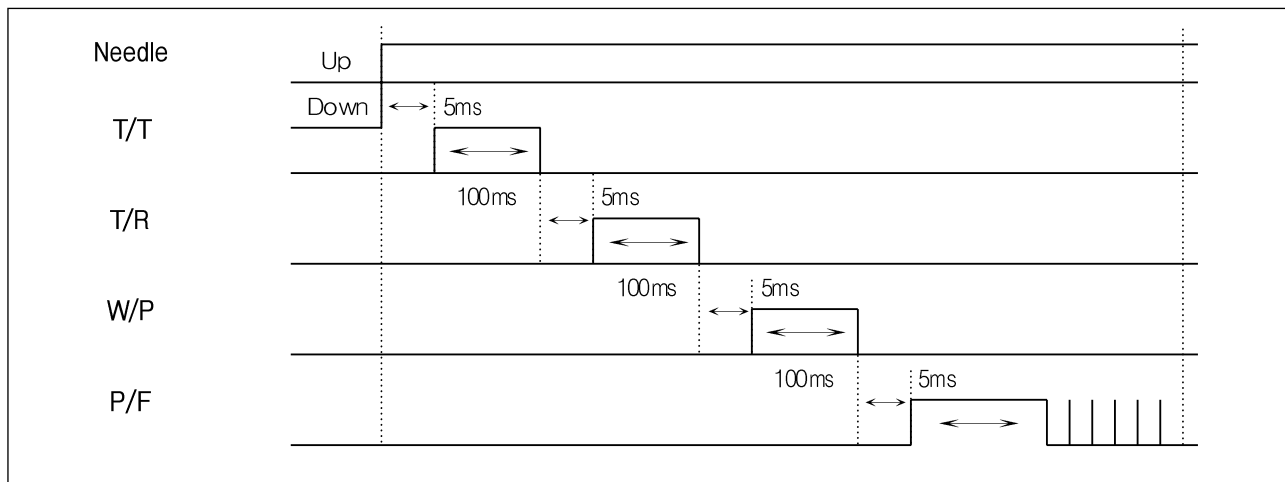
[Caution]

- Every the conditional Branch is made to the appropriate number when it is on "No(False)"
- When making the sequence program, please check and use its function because the wrong sequence program can cause the mechanical trouble and the physical damage.

(5) Examples of the Function of Thread Trimming Sequence

● Yamato Three-needle Trimming

① Timing of Thread Trimming Sequence



② Flow Chart of Tread Trimming Sequence & Program Code

Flow chart	Code number	Comm. field	Data field			Explanation
			1st	2nd	3rd	
START of Sequence	01	--80				Start of Sequence
↓	02	--C8				Stop after moving to needle of upstop at 200spm
Needle Up Stop with 200spm	03		200			
↓	04	--B0				Wait for 5[ms]
wait for 5ms	05		5			
↓	06	--83				Thread Trimming solenoid , On
T/T sol. on	07	--B0				Wait for 100[ms]
↓	08		100			
wait for 100ms	09	--9A				T/T sol.(off)
T/T sol. off	10	--B0				Wait for 5[ms]
↓	11		5			
wait for 5ms	12	--85				T/R sol.(on)
T/R sol. on	13	--B0				Wait for 100[ms]
↓	14		100			
wait for 100ms	15	--9C				T/R sol.(off)
T/R sol. off	16	--B0				Wait for 5[ms]
↓	17		5			
wait for 5ms	18	--84				W/P sol.on(on)
W/P sol. on	19	--B0				Wait for 100[ms]
↓	20		100			
wait for 100ms	21	--9B				Wiper solenoid off
W/P sol. off	22	--B0				Wait for 5[ms]
↓	23		5			
wait for 5ms	24	--00				End of Sequence
End of Sequence						

※ Operates Presser Foot Solenoid by "Letting Up function of Automatic Presser Foot after Trimming" being set to A18=1

※ As every command field is displayed close to "--", it is distinguishable from Data Field

※ All Data Fields are displayed easily enough to distinguish them from others, differently from S-II and there's no necessity of transforming the number and conversing the unit

(6) List of Codes by Machine Model – (able to choose from No. 56 of GROUP “B”)

NO	ORDER NO. (Model Name)		TYPE of Sewing	T/T Solenoid type	Sewing Machine
	GSP Code	Sub Code			
1	S3AC55-□A□-	001	Single needle	CAM	KM-250A-7, KM-235A, KM-250AL-7
2	S3AC55-□A□-	002			KM-250B-7
3	S3AC55-□A□-	003			KM-750-7, KM750BL-7, KM-757BL-7, KM-757-7, KM-650-7'
4	S3AC55-□A□-	004			KM-560-7
5	S3AC55-□A□-	005			KM-957-7
6	S3AC55-□A□-	006			Double
7	S3AC55-□X□-	007	Chain	ELEC. Solenoid	UNION 34700, SIRUBA UTP/UTQ
8	S3AC55-□X□-	008	Stitch	AIR. Solenoid	UNION 34700, YAMATO VC2700, SIRUBA UTP/UTQ
9	S3AC55-□X□-	010			MaierUnitas D1376
10	S3AC55-□X□-	011	Heavy	CAM	PFAFF 563
11	S3AC55-□X□-	013	Chain	ELEC. Solenoid	YAMATO VC2700
12	S3AC55-□X□-	014	Single	CAM	BROTHER DB2-B737, JUKI DDL550N
13	S3AC55-□X□-	016		CAM	DURKOPP 273-140042/E9
14	S3AC55-□X□-	018	Single	CAM	DAE WOO DLS-640
15	S3AC55-□X□-	019		CAM	TOYOTA LS2-AD341-102
16	S3AC55-□X□-	021		ELEC. Solenoid	STROBEL KL170-2-FD
17	S3AC55-□A□-	022	Single	CAM	KM-250AU-7
18	S3AC55-□A□-	052			KM-250BH-7, KM-250BL-7
19	S3AC55-□X□-	024	Chain	AIR. Solenoid	KANSAI RX, DX, WX Series
20	S3AC55-□X□-	025			DURKOPP 271-140042
21	S3AC55-□X□-	026	Chain stitch	ELEC. Solenoid	PEGASUS W500/UT100,400, W600/UT100,400
22	S3AC55-□X□-	030		AIR. Solenoid	PEGASUS W500/UT200, W600/UT200
23	S3AC55-□X□-	031		AIR. Solenoid	KANSAI RX, DX, WX Series
24	S3AC55-□X□-	032		AIR. Solenoid	KINGTEX CT6500-0-56M
25	S3AC55-□A□-	033	Heavy	CAM	KM640BL-7
26	S3AC55-□A□-	034	Heavy	CAM	KM967B-7(Roller HIGH-Post-back-tack)
27	S3AC55-□A□-	036	Heavy	CAM	KM-1060BL-7, KM-1062BL-7
28	S3AC55-□X□-	035	Single	CAM	TYPE of TANAKA
29	S3AC55-□X□-	037	PUNCHING	CAM	Pastel Punching for TANAKA
30	S3AC55-□X□-	038	Heavy	CAM	SEIKO
31	S3AC55-□X□-	040	Chain		PEGASUS W664-01CB M/UT333
32	S3AC55-□X□-	041	Chain		PEGASUS W664-08BB UT312
33	S3AC55-□X□-	042	Chain		PEGASUS EX5214-83BA
34	S3AC55-□X□-	045	Single	CAM	GEMSY
35	S3AC55-□X□-	046	Chain stitch	AIR. Solenoid	DINO Thread Trimming Machine for Kingtex
36	S3AC55-□A□-	048	Heavy	AIR. Solenoid	KM591BL-7
37	S3AC55-□DE-	49A	Chain stitch	AIR. Solenoid	SC-7300 (Table: A-TYPE)
38	S3AC55-□DE-	49B	Chain stitch	AIR. Solenoid	SC-7300 (Table: B-TYPE)
39	S3AC55-□A□-	050	SINGLE	CAM	KM-967-7, KM-967B-7
40	S3AC55-□A□-	051			KM-506-7, KM-530-7
41	S3AC55-□A□-	053			KM-350A-7
42	S3AC55-□A□-	054			KM-350B-7
43	S3AC55-□A□-	055			KM-857-7, KM-890-7
44	S3AC55-□A□-	056			KM-235B
45	S3AC55-□DE-	57A	Chain stitch	AIR. Solenoid	SC-7300 (for tinsel trimming) (Table: A-TYPE)
46	S3AC55-□DE-	57B	Chain stitch	AIR. Solenoid	SC-7300 (fortinsel trimming) (Table: B-TYPE)
47	S3AC55-□DE-	58A	Chain stitch	AIR. Solenoid	SF-7500 (Table: A-TYPE)
48	S3AC55-□DE-	58B	Chain stitch	AIR. Solenoid	SC-7500 (Table: B-TYPE)
49	S3AC55-□A□-	059	SINGLE	CAM	KM-867-7
50	S3AC55-□X□-	060	-	-	Waist Band Device for Homan Sewing Machin
51	S3AC55-□DE-	061	Chain stitch	AIR. Solenoid	SC-7310 (left blade) (Table: A-TYPE)



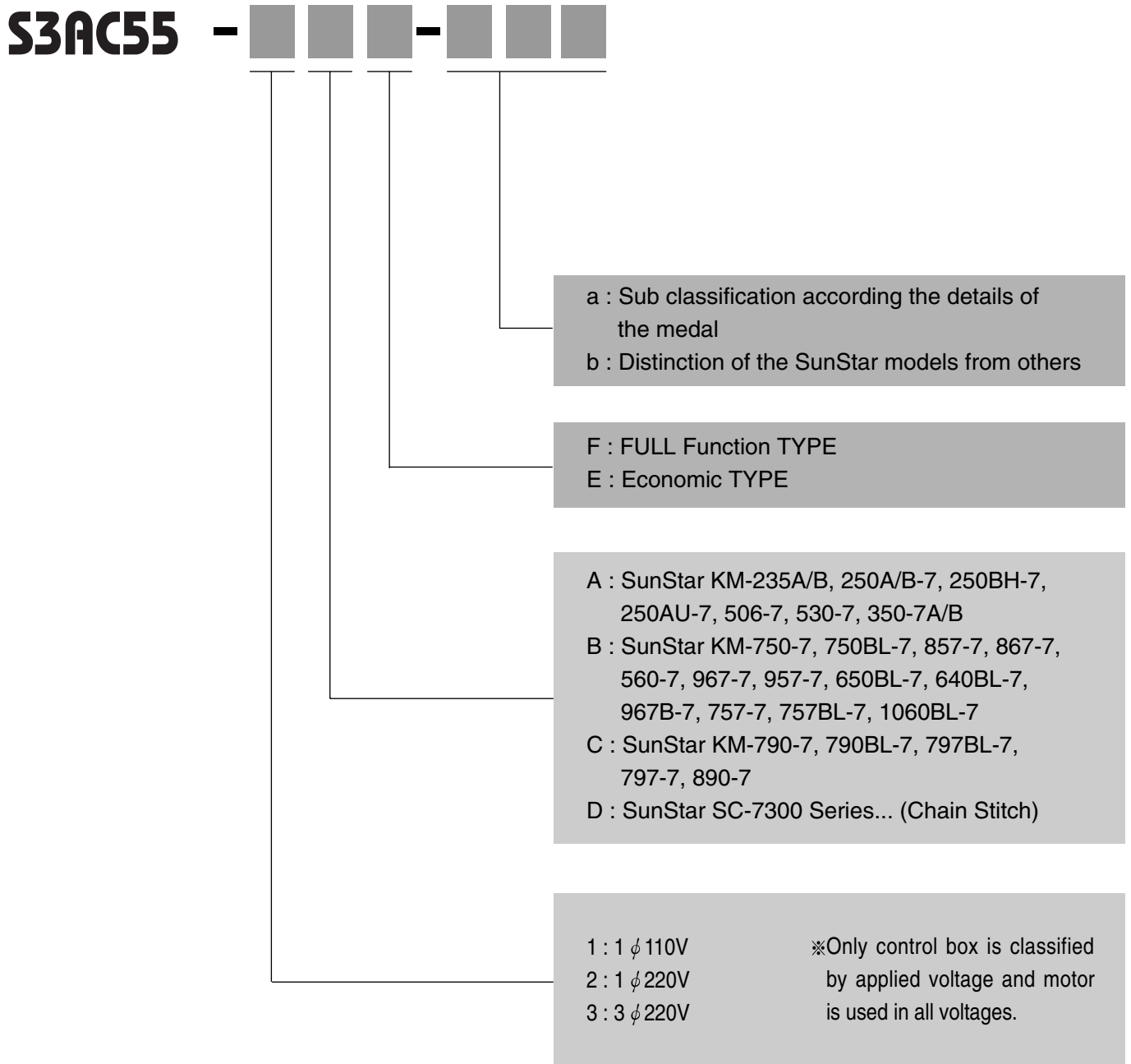
GROUP								PROGRAM UNIT SETTING						SYNCH. TYPE	V Belt SIZE	PULLEY SIZE φ
A						B	C	S.B/T	E.B/T	NEEDLE	P/F	T/T	W/P			
A2	A3	A7	A8	A24	A65	B56	C52									
4000	300	1700	1700	0	1	0/75	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	111
4000	300	1700	1700	0	1	76	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	111
2400	180	800	800	0	1	78	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	80
2400	180	800	800	0	1	78	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	80
2400	180	800	800	0	1	79	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	80
2400	180	800	800	0	1	80	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	80
6000	200	1600	1600	1	0	82	111	OFF	OFF	UP	DOWN	ON	ON	OTHER	36"	111
6000	200	1600	1600	1	0	83	111	OFF	OFF	UP	DOWN	ON	ON	OTHER	36"	111
1720	230	1600	1600	0	0	85	2	OFF	OFF	UP	DOWN	ON	ON	OTHER	NON	111
4000	230	1600	1600	0	1	86	2	ON	ON	DOWN	DOWN	ON	ON	OTHER	NON	111
4000	200	1600	1600	1	0	88	111	OFF	OFF	UP	DOWN	ON	ON	OTHER	36"	111
4000	230	1600	1600	0	1	89	2	ON	ON	DOWN	DOWN	ON	ON	OTHER	42"	111
3000	230	1600	1600	0	1	91	2	ON	ON	DOWN	DOWN	ON	ON	OTHER	42"	111
4000	230	1600	1600	0	1	93	2	ON	ON	DOWN	DOWN	ON	ON	OTHER	42"	111
4000	230	1600	1600	0	1	94	2	ON	ON	DOWN	DOWN	ON	ON	OTHER	42"	111
2480	200	1600	1600	1	0	96	111	OFF	OFF	UP	DOWN	ON	ON	OTHER	43"	111
2600	300	1600	1600	0	1	97	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	111
2800	230	1600	1600	0	1	114	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	111
5400	200	1600	1600	1	0	99	11	OFF	OFF	UP	DOWN	ON	ON	OTHER	40"	111
4800	300	1600	1600	0	0	100	11	OFF	OFF	UP	DOWN	ON	ON	OTHER	43"	111
6000	200	1600	1600	1	0	101	111	OFF	OFF	UP	DOWN	ON	ON	OTHER	36"	111
6000	230	1600	1600	2	0	102	111	OFF	OFF	UP	DOWN	ON	ON	OTHER	36"	111
6000	200	1600	1600	1	0	103	11	OFF	OFF	UP	DOWN	ON	ON	OTHER	40"	111
4480	200	1600	1600	1	0	104	111	OFF	OFF	UP	DOWN	ON	ON	OTHER	38"	111
2000	200	800	800	0	1	105	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	43"	60
3000	180	800	800	0	1	106	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	41"	80
3000	180	800	800	0	1	107	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	44"	90
4000	200	1600	1600	0	1	111	2	ON	ON	DOWN	DOWN	ON	ON	OTHER	44"	90
2000	230	1600	1600	0	1	112	2	ON	ON	DOWN	DOWN	ON	ON	OTHER	44"	80
2400	200	1600	1600	0	1	113	2	ON	ON	DOWN	DOWN	ON	ON	OTHER	55"	80
6000	230	1600	1600	2	0	118	111	OFF	OFF	UP	DOWN	ON	ON	OTHER	36"	111
4000	300	1600	1600	1	1	115	12	ON	ON	DOWN	DOWN	ON	ON	OTHER	36"	111
8000	300	1600	1600	1	0	110	16	OFF	OFF	UP	DOWN	ON	ON	OTHER	36"	111
4000	300	1700	1700	0	1	75	2	ON	ON	DOWN	DOWN	ON	ON	OTHER	42"	111
4480	200	1600	1600	1	0	104	111	OFF	OFF	UP	DOWN	ON	ON	OTHER	42"	111
2000	200	800	800	0	1	105	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	43"	60
4000	200	1600	1600	1	0	88	111	OFF	OFF	UP	DOWN	ON	ON	X	42"	111
4000	200	1600	1600	1	0	88	111	OFF	OFF	UP	DOWN	ON	ON	X	35"	111
2400	180	800	800	0	1	78	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	80
3520	230	1600	1600	0	1	122	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	111
3520	230	1600	1600	0	1	120	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	111
3000	230	1600	1600	0	1	121	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	111
2400	180	800	800	0	1	78	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	55"	80
3520	300	1700	1700	0	1	92	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	42"	111
4000	200	1600	1600	1	0	123	111	OFF	OFF	UP	DOWN	ON	ON	X	42"	111
4000	200	1600	1600	1	0	123	111	OFF	OFF	UP	DOWN	ON	ON	X	35"	111
5000	200	1600	1600	1	0	124	111	OFF	OFF	UP	DOWN	ON	ON	X	42"	111
5000	200	1600	1600	1	0	124	111	OFF	OFF	UP	DOWN	ON	ON	X	35"	111
2400	180	800	800	0	1	78	2	ON	ON	DOWN	DOWN	ON	ON	SUNSTAR	55"	60
4000	300	1700	1700	0	1	0	2	ON	ON	DOWN	DOWN	ON	ON		42"	111
4000	200	1600	1600	1	0	125	111	OFF	OFF	UP	DOWN	ON	ON	X	42"	111

BREAKDOWN AND TROUBLESHOOTING

※ If the machine breaks down while using the servo motor due to an unforeseen change in the machine, the error indicators mentioned below will appear in the displayer of the program unit or simple program unit according to the self-checking function of the machine. The machine will then stop along with the sound of a warning buzzer. When an error indicator appears, follow the solution steps described below and resume work. If the problem is not solved after taking these measures, contact a company branch office.

Order	Error indicator	Cause of breakdown	Troubleshooting
1	SF22 Er	Safety switch error	• Check safety switch cable and connector
2	PU26 Er	Trouble with program unit connection	• Check program unit cable and connector
3	PU27 Er	Trouble with simple program unit connection	• Check the simple program unit cable and connector
4	60 Er	This error sign is seen when the user connects the location sensor while the power is still on	• Turn the power off and on again before using it.
5	61 Er	This error sign is seen when the user the user removes the location sensor while the power is still on	• Turn the power off and on again before using it.
6	126 Er	This error sign is seen when the motor's rotor magnet and stator coil's electric current flow does not match	• Check the condition of the motor's
7	127 Er	This error sign appears when the direction of encoders R S T and the direction of A B do not match.	• Check the encoder cable and the connector
8	128 Er	When there is no signal from encoders R S T	• Check the encoder cable and the connector
9	129 Er	When the motor is overloaded	• Turn the machine manually and check the machine load
10	130 Er	When there is no signal from the location sensor	• Check the location sensor cable and connector
11	131 Er	When there is an electric current overflow in the motor and problems with the connector	• Check the motor cable and the connector
12	133 Er	When the electric current overflow of the IPM stops	• Turn the power off and on again before using it.

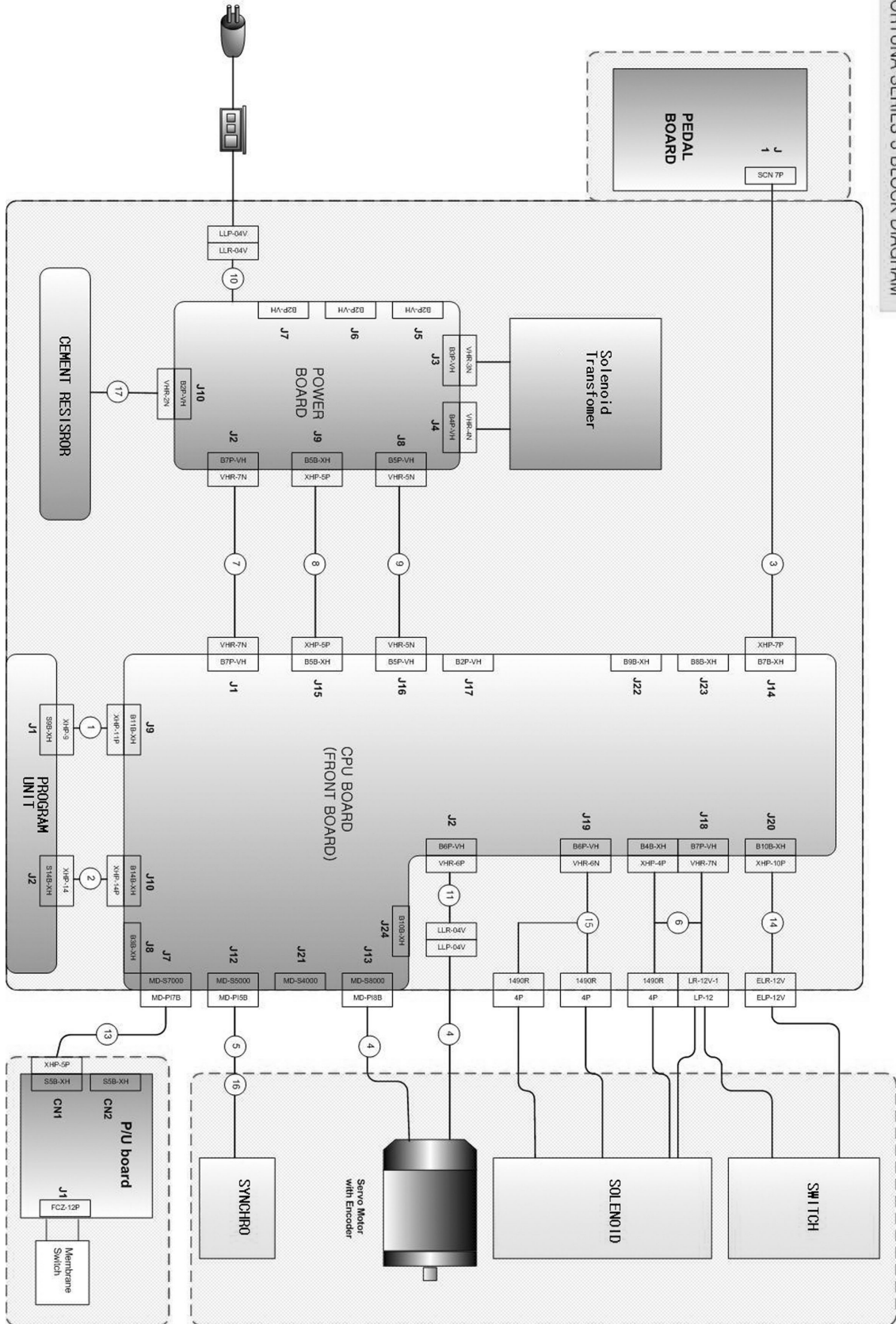
HOW TO PLACE FOR CONTROLLER



ORDER Ex. S3SAC55-2AF refers to SERIES3, 1Phase 220V, FULL FUNCTION CONTROL BOX for normal drop feed.

BLOCK DIAGRAM

FORTUNA SERIES 3 BLOCK DIAGRAM



MANUAL CODE NO.
SIIIK001-04

PARTS BOOK



A	Motor Parts For - - - - -	70
B	Control Box (FULL Function TYPE)	72
C	Control Box (Economic TYPE) - - -	74
D	Pedal/Accessories - - - - -	76
E	Synchronizer - - - - -	78

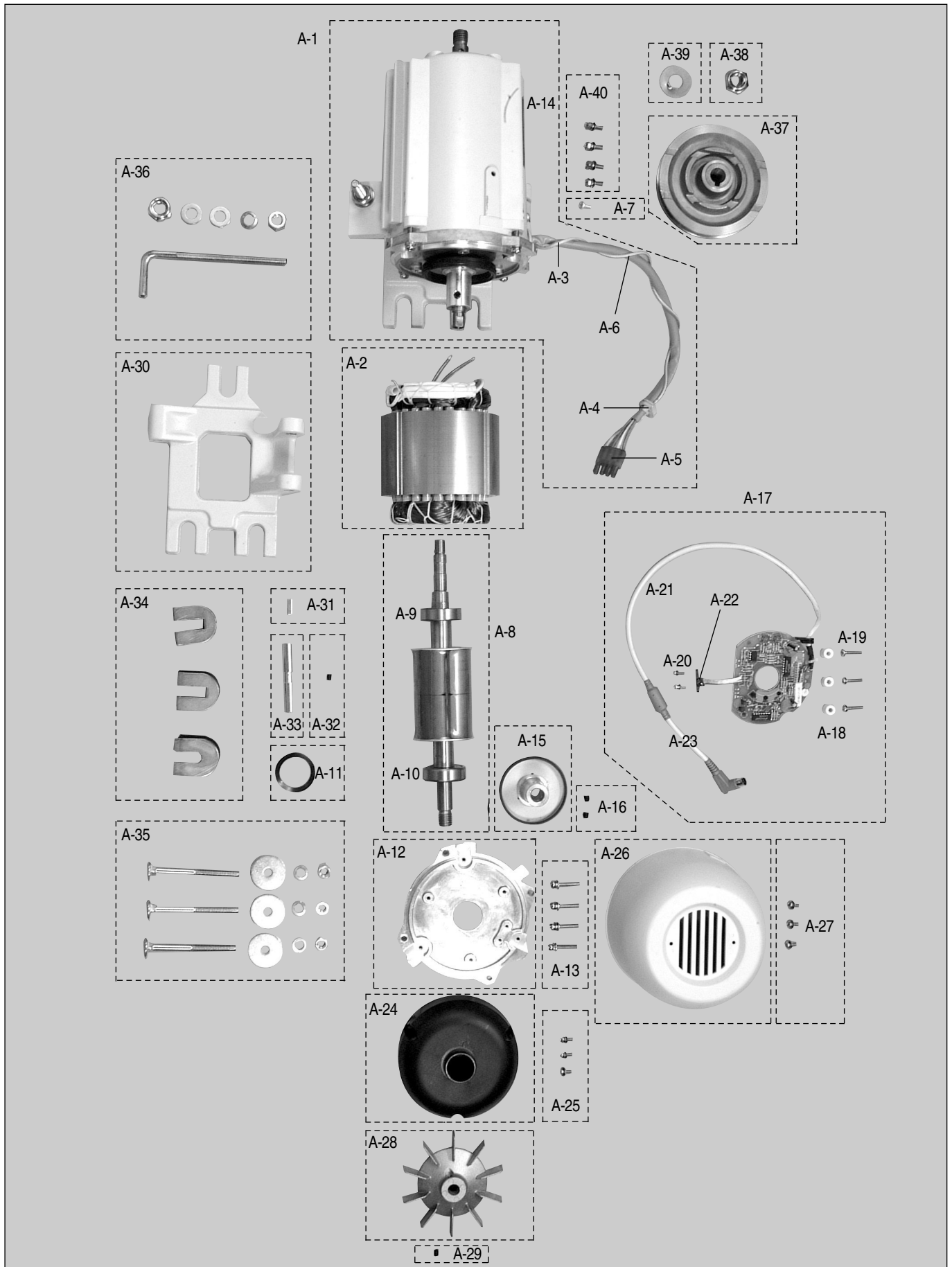
• Remarks •

Please let us get the additional details according to the itemized list below for the better service when ordering spare parts for SunStar motors.

- ※ Order for spare parts for servo motor
- 1) Serial number
- 2) Type of control box & model name
- 3) Electric specification (Phase, Volt)
- 4) Machines' s model name

A

MOTOR PARTS

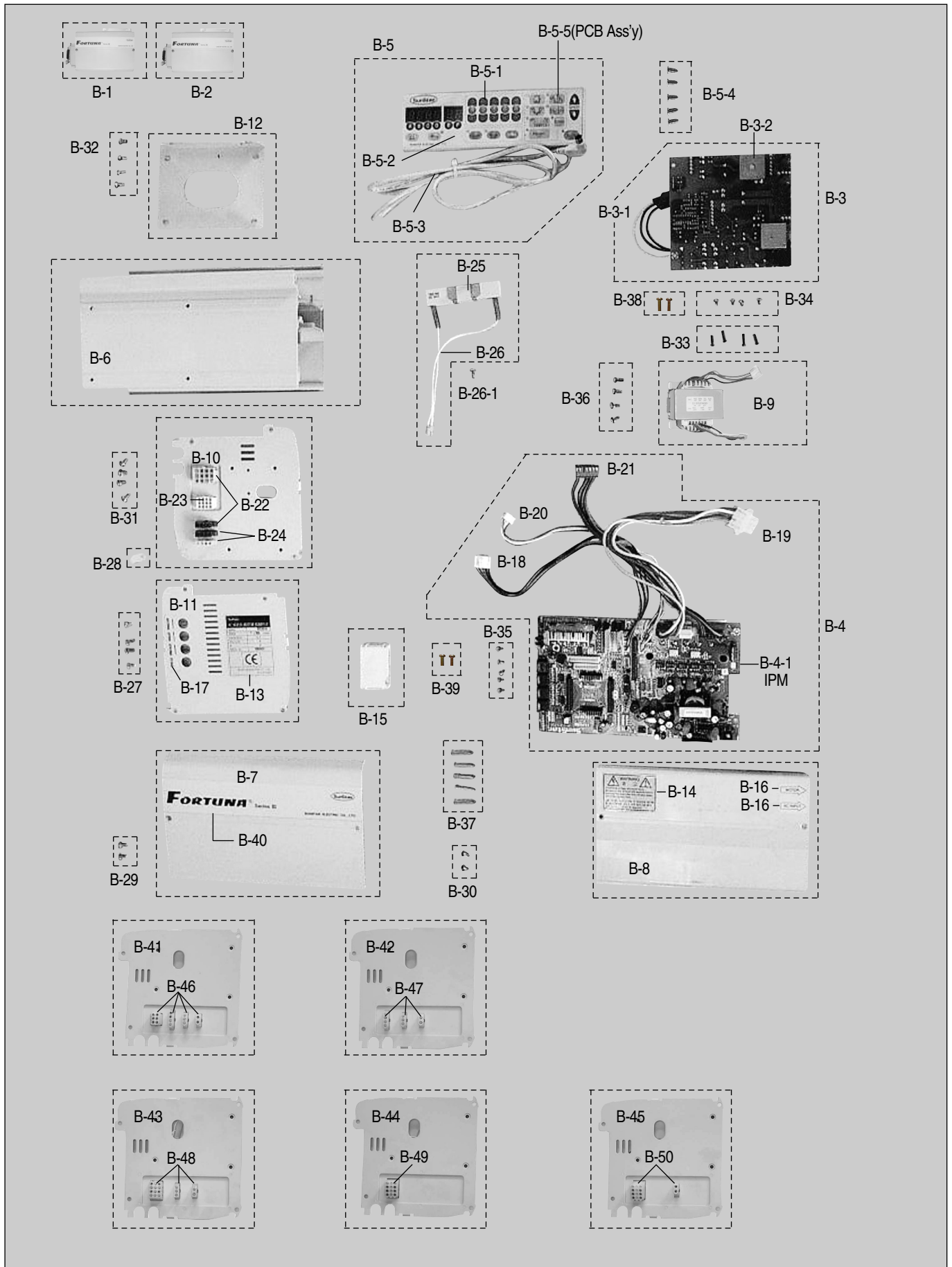




Ref No.	Parts No.	Name of Parts	Q' ty	Assembly No.
A-1	5 5 - 0 0 0 0 - S M 5 E	Motor ass'y	1	
A-2	0 1 - 0 0 0 0 - S M 5 S	Stator Assembly	1	
A-3	0 4 - 0 0 4 R - S M 5 S	Frame Plug	1	
A-4	1 0 - 0 0 1 C - S E 5 5	Cable Guide Rubber A	1	
A-5	0 1 - 0 0 7 B - S M 5 S	Connector (LLP-04)	1	
A-6	1 1 - 0 1 2 B - S E 5 5	S/V Earth Cable	1	
A-7	0 9 - 0 3 1 S - 3 7 0 1	Screw For Fixing Flate	1	
A-8	0 2 - 0 0 0 0 - S M 5 E	Rotor Assembly (SERVO 3)	1	
A-9	0 1 - 0 0 9 A - 1 7 0 1	Bearing (# 6203)	1	
A-10	0 2 - 0 0 6 A - S M 5 S	Bearing (# 6302)	1	
A-11	0 7 - 0 1 4 C - 3 7 0 1	Bearing Bending Spring	1	
A-12	0 4 - 0 0 2 A - S M 5 S	Frame Cover	1	
A-13	0 4 - 0 0 3 S - S M 5 S	Screw For Frame Cover	4(Ass'y)	
A-14	1 0 - 0 0 9 C - S E 5 5	Name Plate	1	
A-15	0 3 - 0 0 0 0 - S M 5 S	F. G Assembly	1	
A-16	0 3 - 0 0 4 S - S M 5 S	Screw For F. G Assembly	2(Ass'y)	
A-17	0 5 - 0 0 0 0 - S E 5 5	Encoder Board	1	
A-18	0 7 - 0 0 1 B - S M 5 S	Stud For Encoder P. C. B	3(Ass'y)	
A-19	1 5 - 1 2 2 S - 1 0 0 0	Screw For Encoder P. C. B	3(Ass'y)	
A-20	0 7 - 0 0 5 S - S M 5 S	Screw For MR Sensor	2	
A-21	1 4 - 0 1 9 C - S C 5 3	MR Sensor Cable Connector (4P)	1	
A-22	1 4 - 0 0 2 B - S C 5 3	MR Sensor Ass'y	1	
A-23	1 1 - 0 1 0 B - S E 5 5	Encoder Cable SE-04	1	
A-24	0 7 - 0 0 2 A - S M 5 S	Encoder Cover	1	
A-25	0 7 - 0 0 4 S - S M 5 S	Screw For Encoder Cover	3(Ass'y)	
A-26	0 8 - 0 0 2 A - S E 5 S	Fan Cover	1	
A-27	0 9 - 0 3 1 S - 3 7 0 1	Screw For Fixing Plate	3(Ass'y)	
A-28	0 8 - 0 0 1 A - S M 5 S	FAN	1	
A-29	0 3 - 0 0 4 S - S M 5 S	Screw For F,G Ass'y	1	
A-30	G P - 0 1 1 8 1 1 - 0 0	Base	1	
A-31	0 2 - 0 1 6 C - 1 7 0 1	Key (Parallel Type)	1	
A-32	0 3 - 0 0 4 S - S M 5 S	Screw For F,G Ass'y	1	
A-33	G P - 0 1 1 8 1 2 - 0 0	Base Shaft	1	
A-34	0 4 - 0 0 2 B - 1 7 0 1	Base Rubber	3(Ass'y)	
A-35	9 1 - 0 0 9 S - 1 7 0 1	Clamp Bolt	1	
A-36	0 4 - 0 0 4 S - 1 7 0 1	Anchor Bolt (SET)	1	
A-37	0 6 - 0 0 1 A - 9 0 0 0	Pulley- ϕ 111	1	
A-38	0 8 - 0 1 7 S - 3 7 0 1	Fixing Nut For Pulley	1	
A-39	0 1 - 0 4 0 W - 1 7 0 1	Fixing Washer For Flywheel	1	
A-40	0 9 - 0 3 9 S - 3 7 0 1	Screw For Holder	4(Ass'y)	

B

CONTROL BOX (FULL Function TYPE)

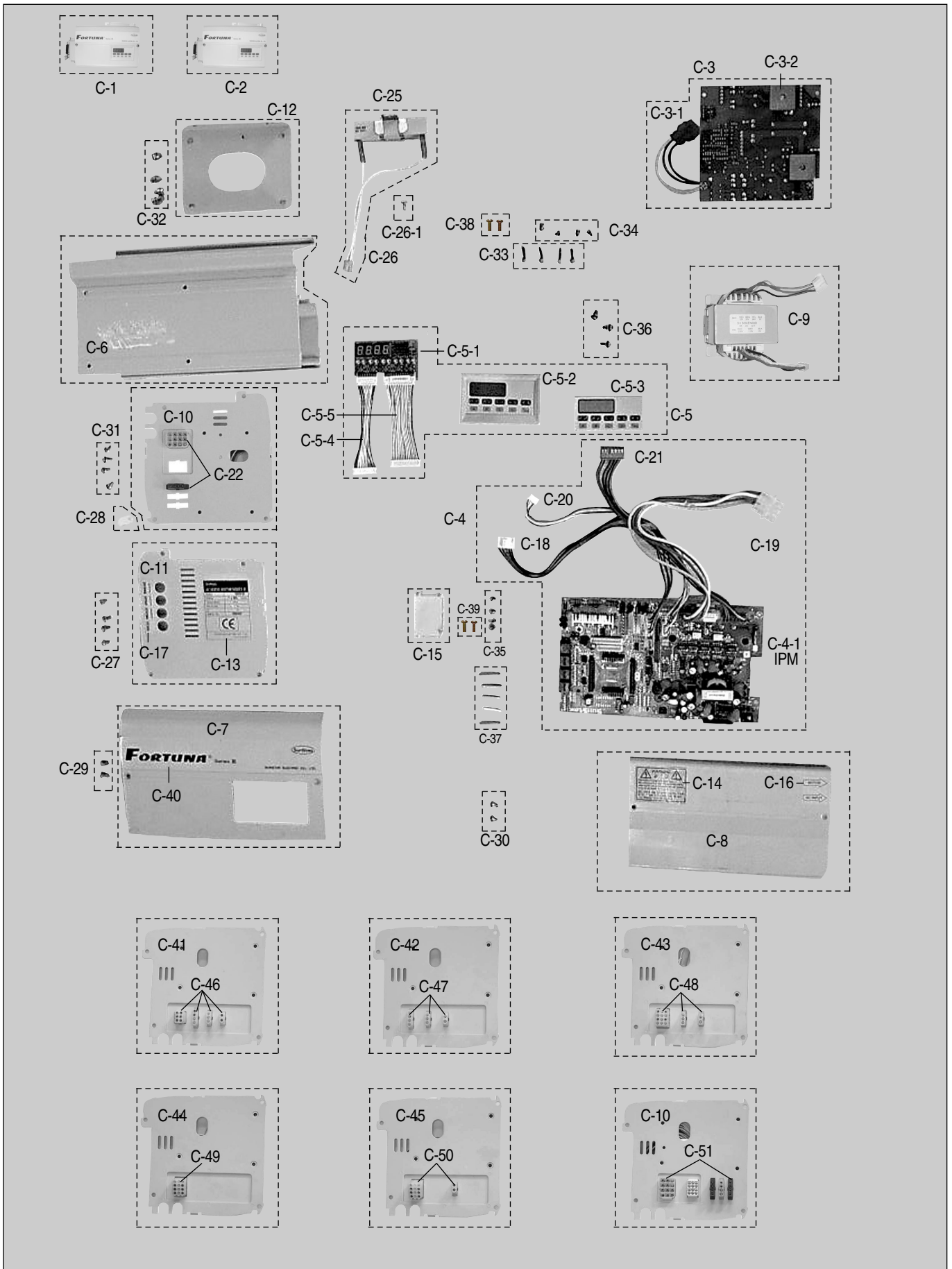




Ref No.	Parts No.	Name of Parts	Q'ty	Assembly No.
B-1	1 0 - 1 0 0 0 - S E 5 5	1- Phase 110V Control Box	1	
B-2	1 0 - 0 0 0 0 - S E 5 5	1- Phase 220V Control Box / 3- Phase 220V Control Box	1	
B-3	0 1 - 0 0 0 0 - S E 5 5	Power Board Ass'y	1(Ass'y)	
B-3-1	1 1 - 0 0 7 B - S E 5 5	Cable For Power Input	1	
B-3-2	0 9 - 0 0 3 A - S C 5 1	Bridge Diode 3510	2	
B-4	0 2 - 0 0 0 0 - S E 5 5	CPU Board Ass'y	1(Ass'y)	
B-4-1	1 0 - 0 0 9 A - S F 5 5	IPM (PM20CSJ060)	1(Ass'y)	
B-5	3 0 - 0 0 0 0 - S E 5 5	S-III P/U B/D Ass'y	1(Ass'y)	
B-5-1	3 0 - 0 0 3 A - S E 5 5	P/U BOX	1	
B-5-2	3 0 - 0 0 2 A - S E 5 5	Membrane Switch	1	
B-5-3	2 0 - 0 1 0 A - S E 5 5	P/U Connector Cable(SE-013)	1	
B-5-4	3 0 - 0 0 1 M - S E 5 5	Screw For P/U Box	5(Ass'y)	
B-5-5	0 4 - 0 0 0 0 - S E 5 5	P/U PCB Ass'y	1	
B-6	1 0 - 1 1 1 A - S E 5 5	Control Box	1	
B-7	1 0 - 1 1 2 A - S E 5 5	Control Box Front Cover	1	
B-8	1 0 - 1 1 3 A - S E 5 5	Control Box Rear Cover	1	
B-9	1 0 - 0 0 8 A - S E 5 5	Solenoid Transformer S3	1	
B-10	1 0 - 0 0 4 A - S E 5 5	Control Box Left Side Cover	1	
B-11	1 0 - 0 0 5 A - S E 5 5	Control Box Right Side Cover	1	
B-12	1 0 - 0 0 7 A - S E 5 5	Control Box Holder	1	
B-13	1 0 - 0 0 9 C - S E 5 5	Name Panel Sticker	1	
B-14	0 1 - 0 0 3 S - B T 0 1	Warning Panel Sticker	1	
B-15	1 0 - 0 0 3 C - S E 5 5	Cable Rubber Guide	1	
B-16	0 1 - 0 2 0 S - S F 5 5	Sticker (MOTOR-INPUT)	1	
B-17	1 0 - 0 1 1 C - S E 5 5	Option Sticker	1	
B-18	1 2 - 0 0 5 B - S E 5 5	Assistance Signal Cable SE-008	1	
B-19	1 1 - 0 0 8 B - S E 5 5	Cable For Motor Output SE-011	1	
B-20	1 1 - 0 0 6 B - S E 5 5	Solenoid Connection Cable SE-009	1	
B-21	1 1 - 0 0 4 B - S E 5 5	Cable For DC Power SE-007	1	
B-22	1 2 - 0 0 3 B - S E 5 5	Solenoid Cable SE-006	1	
B-23	1 2 - 0 1 3 B - S E 5 5	Option Switch Connector Cable SE-014	1	
B-24	1 1 - 0 1 4 B - S E 5 5	Right & Left Switch Connector Cable SE-015	1	
B-25	0 9 - 0 0 7 A - H B 1 0	Cement Resistor (40W160Ω)	1	
B-26	1 1 - 0 1 5 B - S E 5 5	Resistant Connector SE-017	1	
B-26-1	1 0 - 0 0 2 S - S W 6 6	Screw For Pedal P. C. B	1	
B-27	1 0 - 0 0 3 M - P T 0 1	Screw Control Box Cover	4(Ass'y)	
B-29	1 0 - 0 0 3 M - P T 0 1	Screw For B-7	2(Ass'y)	
B-30	1 0 - 0 0 3 M - P T 0 1	Screw For B-8	2(Ass'y)	
B-31	1 0 - 0 0 3 M - P T 0 1	Screw For B-10	4(Ass'y)	
B-32	0 9 - 0 3 9 S - 3 7 0 1	Screw For B-12	4(Ass'y)	
B-33	1 0 - 0 1 2 M - P T 1 0	Stude For B-3	4(Ass'y)	
B-34	1 0 - 0 0 2 S - S W 6 6	Screw For Pedal P. C. B	4(Ass'y)	
B-35	1 0 - 0 0 2 S - S W 6 6	Screw For Pedal P. C. B	5(Ass'y)	
B-36	0 9 - 2 2 6 S - 3 7 0 1	Screw For Solenoid Transformer	4(Ass'y)	
B-37	1 0 - 0 1 2 M - P T 1 0	Stude For B-4	5(Ass'y)	
B-38	0 7 - 0 0 4 S - S M 5 5	Screw For Encoder Cover	2(Ass'y)	
B-39	1 5 - 0 2 2 S - 1 0 0 0	Screw For Encoder Cover	2(Ass'y)	
B-40	1 0 - 0 0 8 C - S E 5 5	Sticker (Main)	1	
B-41	1 0 - 0 2 4 A - S E 5 5	Control Box Left Side Cover - KANSAI	1	
B-42	1 0 - 0 3 4 A - S E 5 5	Control Box Left Side Cover - YAMATO	1	
B-43	1 0 - 0 4 4 A - S E 5 5	Control Box Left Side Cover - SIRUBA	1	
B-44	1 0 - 0 6 4 A - S E 5 5	Control Box Left Side Cover - KINGTEX	1	
B-45	1 0 - 0 4 6 A - S E 5 5	Control Box Left Side Cover - DINO Thread Trimming Machine	1	
B-46	9 1 - 0 3 1 A - S E 5 5	Connector (Other Company Type) - KANSAI	1	
B-47	9 1 - 0 1 3 A - S E 5 5	Connector (Other Company Type) - YAMATO	1	
B-48	9 1 - 0 0 8 A - S E 5 5	Connector (Other Company Type) - SIRUBA	1	
B-49	9 1 - 0 3 2 A - S E 5 5	Connector (Other Company Type) - KINGTEX	1	
B-50	9 1 - 0 4 6 A - S E 5 5	Connector (Other Company Type) - DINO Thread Trimming Machine	1	

C

CONTROL BOX (Economic TYPE)

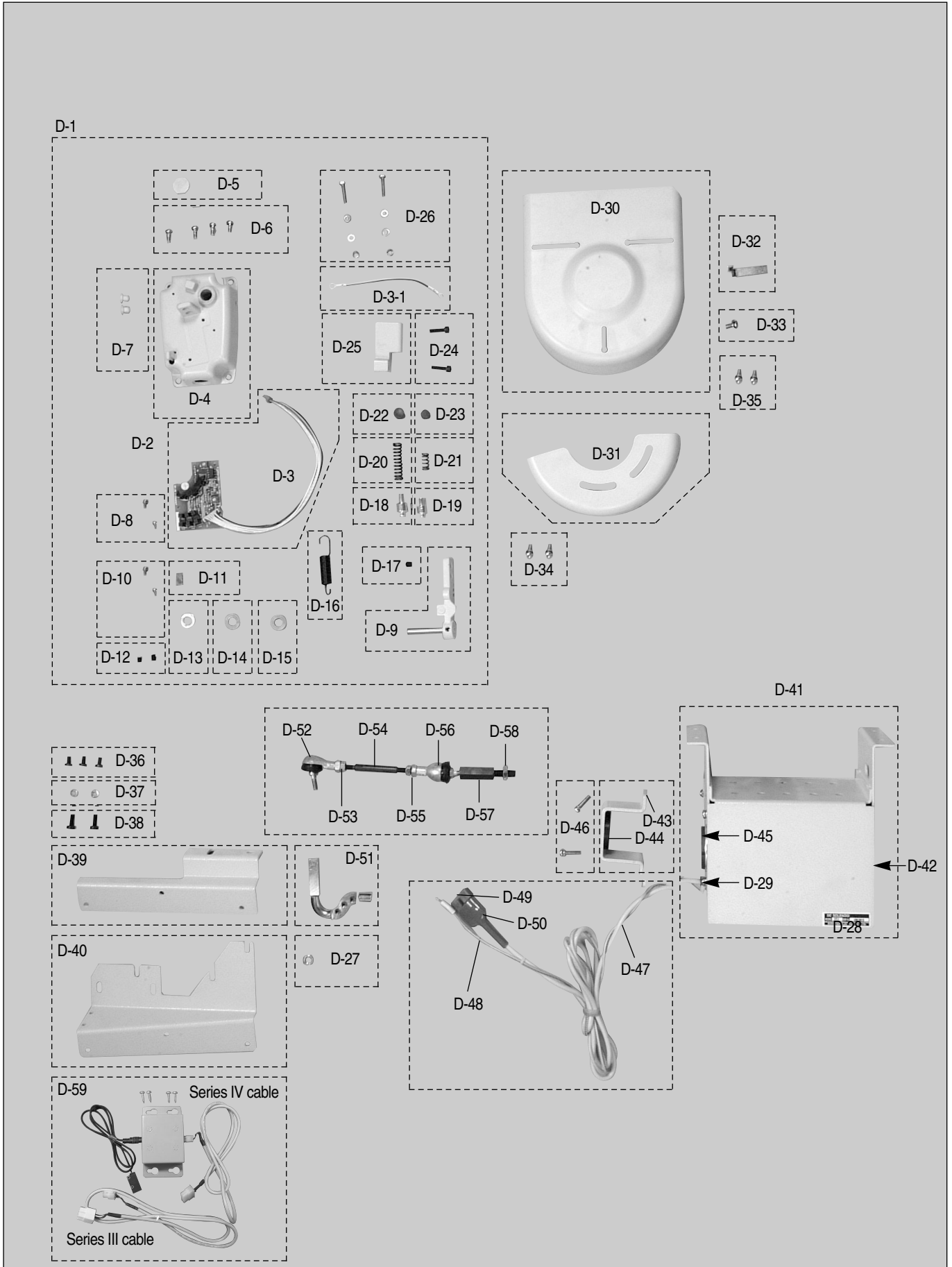




Ref No.	Parts No.	Name of Parts	Q'ty	Assembly No.
C-1	5 0 - 1 0 0 0 - S E 5 5	1- Phase 110V Control Box	1	
C-2	5 0 - 0 0 0 0 - S E 5 5	1- Phase 220V Control Box / 3- Phase 220V Control Box	1	
C-3	0 1 - 0 0 0 0 - S E 5 5	Power Board Ass'y	1(Ass'y)	
C-3-1	1 1 - 0 0 7 B - S E 5 5	Cable For Power Input	1	
C-3-2	0 9 - 0 0 3 A - S C 5 1	Bridge Diode 3510	2	
C-4	0 7 - 0 0 0 0 - S E 5 5	CPU Board Ass'y	1(Ass'y)	
C-4-1	1 0 - 0 0 9 A - S F 5 5	IPM (PM20CSJ060)	1(Ass'y)	
C-5	0 3 - 0 0 0 0 - S E 5 5	S-III OP Board Ass'y	1(Ass'y)	
C-5-1	0 3 - 1 0 0 0 - S E 5 5	S-III OP PCB Ass'y	1	
C-5-2	1 0 - 0 0 6 A - S E 5 5	Control Box Display Panel	1	
C-5-3	1 0 - 0 0 2 B - S E 5 5	Display Panel Membrane	1	
C-5-4	1 1 - 0 0 2 B - S E 5 5	Controller Cable(SE-002)	4(Ass'y)	
C-5-5	1 1 - 0 0 1 B - S E 5 5	Controller Cable(SE-001)	1	
C-6	1 0 - 1 1 1 A - S E 5 5	Control Box	1	
C-7	1 0 - 2 1 2 A - S E 5 5	Control Box Front Cover-Economic Type	1	
C-8	1 0 - 1 1 3 A - S E 5 5	Control Box Rear Cover	1	
C-9	1 0 - 0 0 8 A - S E 5 5	Solenoid Transformer S3	1	
C-10	1 0 - 0 0 4 A - S E 5 5	Control Box Left Side Cover	1	
C-11	1 0 - 0 0 5 A - S E 5 5	Control Box Right Side Cover	1	
C-12	1 0 - 0 0 7 A - S E 5 5	Control Box Holder	1	
C-13	1 0 - 0 0 9 C - S E 5 5	Name Panel Sticker	1	
C-14	1 0 - 0 0 3 S - B T 0 1	Warning Panel Sticker	1	
C-15	1 0 - 0 0 3 C - S E 5 5	Cable Rubber Guide C	1	
C-16	0 1 - 0 2 0 S - S F 5 5	Sticker (MOTOR-INPUT)	1	
C-17	1 0 - 0 1 1 C - S E 5 5	Option Sticker	1	
C-18	1 1 - 0 0 5 B - S E 5 5	Assistance Signal Cable	1	
C-19	1 1 - 0 0 8 B - S E 5 5	Cable For Motor Output SE-011	1	
C-20	1 1 - 0 0 6 B - S E 5 5	Solenoid Connection Cable SE-009	1	
C-21	1 1 - 0 0 4 B - S E 5 5	Cable For DC Power SE-007	1	
C-22	1 2 - 0 0 3 B - S E 5 5	Solenoid Cable SE-006	1	
C-25	0 9 - 0 0 7 A - H B 1 0	Cement Resistor (40W160Ω)	1	
C-26	1 1 - 0 1 5 B - S E 5 5	Resistant Connector SE-017	1	
C-26-1	1 0 - 0 0 2 S - S W 6 6	Screw For Pedal P. C. B	1	
C-27	1 0 - 0 0 3 M - P T 0 1	Screw Control Box Cover	4(Ass'y)	
C-29	1 0 - 0 0 3 M - P T 0 1	Screw For C-7	2(Ass'y)	
C-30	1 0 - 0 0 3 M - P T 0 1	Screw For C-8	2(Ass'y)	
C-31	1 0 - 0 0 3 M - P T 0 1	Screw For C-10	4(Ass'y)	
C-32	0 9 - 0 3 9 S - 3 7 0 1	Screw For C-12	4(Ass'y)	
C-33	1 0 - 0 1 2 M - P T 1 0	Stude For C-3	4(Ass'y)	
C-34	1 0 - 0 0 2 S - S W 6 6	Screw For Pedal P. C. B	5(Ass'y)	
C-35	1 0 - 0 0 2 S - S W 6 6	Screw For Pedal P. C. B	5(Ass'y)	
C-36	0 9 - 2 2 6 S - 3 7 0 1	Screw For Solenoid Transformer	4(Ass'y)	
C-37	1 0 - 0 1 2 M - P T 1 0	Stude For C-4	5(Ass'y)	
C-38	0 7 - 0 0 4 S - S M 5 5	Screw For Encoder Cover	2(Ass'y)	
C-39	1 5 - 0 2 2 S - 1 0 0 0	Screw For Encoder Cover	2(Ass'y)	
C-40	1 0 - 0 0 8 C - S E 5 5	Sticker (Main)	1	
C-41	1 0 - 0 2 4 A - S E 5 5	Control Box Left Side Cover - KANSAI	1	
C-42	1 0 - 0 3 4 A - S E 5 5	Control Box Left Side Cover - YAMATO	1	
C-43	1 0 - 0 4 4 A - S E 5 5	Control Box Left Side Cover - SIRUBA	1	
C-44	1 0 - 0 6 4 A - S E 5 5	Control Box Left Side Cover - KINGTEX	1	
C-45	1 0 - 0 4 6 A - S E 5 5	Control Box Left Side Cover - DINO Thread Trimming Machine	1	
C-46	9 1 - 0 3 1 A - S E 5 5	Connector (Other Company Type) - KANSAI	1	
C-47	9 1 - 0 1 3 A - S E 5 5	Connector (Other Company Type) - YAMATO	1	
C-48	9 1 - 0 0 8 A - S E 5 5	Connector (Other Company Type) - SIRUBA	1	
C-49	9 1 - 0 3 2 A - S E 5 5	Connector (Other Company Type) - KINGTEX	1	
C-50	9 1 - 0 4 6 A - S E 5 5	Connector (Other Company Type) - DINO Thread Trimming Machine	1	
C-51	9 1 - 0 0 1 A - S E 5 5	Connector (Other Company Type)	1	

D

PEDAL/ACCESSORIES



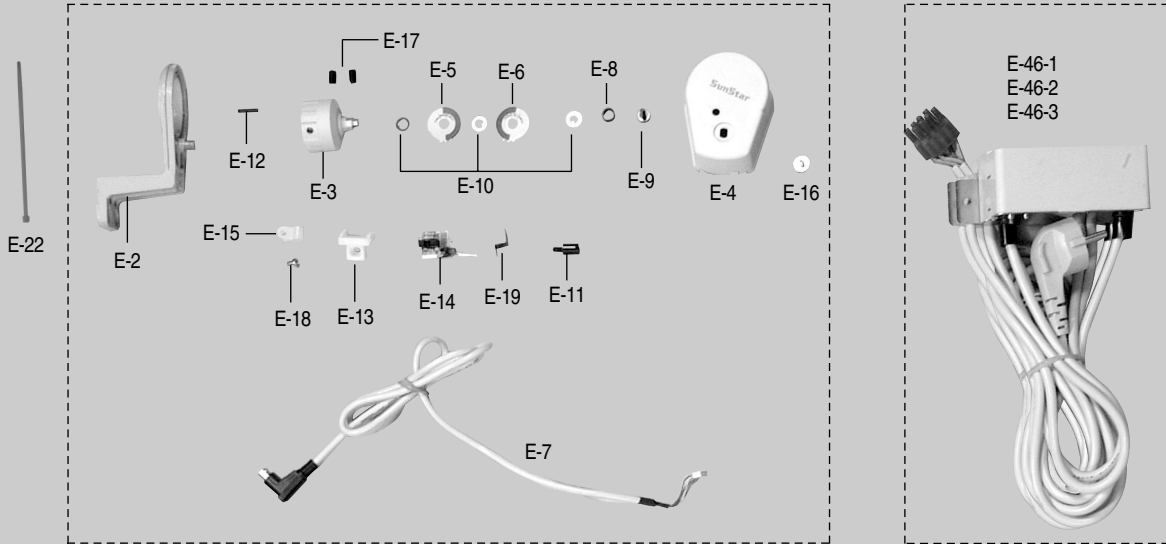


Ref No.	Parts No.	Name of Parts	Q'ty	Assembly No.
D-1	0 6 - 0 0 0 0 - S E 5 5	Pedal Unit Assembly	1(Ass'y)	
D-2	0 6 - 1 0 0 0 - S E 5 5	Pedal B/D Ass'y	1	
D-3	1 2 - 0 0 9 B - S E 5 5	Cable For Pedal Input (SE-003)	1	
D-3-1	1 1 - 0 1 7 B - S E 5 5	Cable For Pedal Grounding	1	
D-4	1 1 - 0 1 1 A - S F 5 5	Pedal Base	1	
D-5	0 6 - 0 0 1 C - S E 5 5	Rubber Cap For Pedal Unit	1	
D-6	0 6 - 0 0 1 M - S E 5 5	Screw (Set) 5X10 CR	4(Ass'y)	
D-7	1 0 - 0 3 3 C - S F 5 5	Rubber Cap For Pedal Base	2(Ass'y)	
D-8	1 0 - 0 2 8 S - S C 5 3	Screw For Pedal P. C. B Set	2	
D-8-1	1 0 - 0 0 2 S - S W 6 6	Screw For P. C. B Set	1	
D-9	1 0 - 1 0 7 A - S C 5 3	Pedal Control Lever	1	
D-10	1 0 - 0 2 6 A - S C 5 3	Pedal Magnet Holder	1	
D-11	1 0 - 0 2 7 C - S C 5 3	Pedal Magnet	1	
D-12	0 3 - 0 0 4 S - S M 5 S	Fixing Bolt For Pedal Magnet & film Base	2(Ass'y)	
D-13	1 0 - 0 2 4 W - S C 5 3	Parallel Washer For Pedal Shaft	1	
D-14	1 1 - 0 1 2 C - 3 7 0 1	Bushing For Pedal Control Lever Shaft	1	
D-15	1 1 - 0 1 2 C - 3 7 0 1	Bushing For Pedal Control Lever Shaft	1	
D-16	1 0 - 0 1 8 G - S C 5 3	Tension Spring For Pedal	1	
D-17	0 3 - 0 0 4 S - S M 5 S	Fixing Bolt For Pedal Control Lever	1	
D-18	1 0 - 0 3 0 P - S C 5 3	Stopper (B) For Pressure Spring	1	
D-19	1 0 - 0 2 9 P - S C 5 3	Stopper (A) For Pressure Spring	1	
D-20	1 0 - 0 1 9 G - S C 5 3	Pressure Spring For Presser Foot	1	
D-21	1 0 - 0 2 0 G - S C 5 3	Pressure Spring For Thread Trimming	1	
D-22	1 0 - 0 2 5 P - S C 5 3	Spring Guide (B)	1	
D-23	1 0 - 0 2 4 P - S C 5 3	Spring Guide (A)	1	
D-24	1 0 - 0 3 1 S - S C 5 3	Screw For Spring Housing	2(Ass'y)	
D-25	1 0 - 0 1 6 A - S C 5 3	Spring Housing	1	
D-26	1 0 - 0 2 1 S - S C 5 3	Pressure Control Screw For Spring(Ass'y)	2(Ass'y)	
D-27	1 8 - 0 1 6 S - 5 6 0 7	Nut For D51	1	
D-28	2 0 - 1 0 6 C - 6 1 0 0	Sticker For auto Knee Lifting Solenoid	1	
D-29	1 8 - 0 2 9 C - 5 6 0 7	Guide Bushing for Cable	1	
D-30	9 1 - 0 0 1 A - 3 7 0 1	Belt Cover (B)	1	
D-31	9 1 - 1 0 1 A - S A 5 3	Belt Cover (New Type) (A)	1	
D-32	9 1 - 0 0 4 C - S A 5 3	S/V Belt Guide	1	
D-33	0 9 - 0 3 1 S - 3 7 0 1	Screw For Belt Guide	1	
D-34	0 7 - 0 0 2 7 S - 3 7 0 1	Screw For Belt Cover (A)	2	
D-35	0 1 - 1 3 5 S - 1 7 0 1	Screw For Belt Cover (B)	2	
D-36	9 1 - 0 2 9 S - 1 0 0 0	Screw For P/U Box	3(Ass'y)	
D-37	0 1 - 0 3 9 W - 1 7 0 1	Spring Washer For P/U box Bracket	2(Ass'y)	
D-38	9 1 - 0 3 0 S - 1 0 0 0	Screw For P/U Box Bracket	2(Ass'y)	
D-39	9 1 - 1 0 0 A - S E 5 5	Bracket For P/U Box	1	
D-40	9 1 - 2 0 0 A - S E 5 5	Bracket For 250 P/U Box	1	
D-41	1 8 - 1 0 7 B - 9 0 0 0	Auto Knee Lifter Solenoid Case	1	
D-42	1 8 - 1 0 8 B - 9 0 0 0	Auto Knee Lifter Solenoid Cover	1	
D-43	1 8 - 1 0 9 B - 9 0 0 0	Fixing Plate For Stroke	1	
D-44	1 8 - 0 2 3 R - 5 6 0 7	Rubber Washer	1	
D-45	1 7 - 0 1 7 C - 3 0 0 0	Stopper Rubber	1	
D-46	0 1 - 1 3 4 C - 1 7 0 1	Screw For D-43	2(Ass'y)	
D-47	1 2 - 0 1 5 M - 2 3 5 0	Cable For Auto Knee Lifting Solenoid	1	
D-48	0 2 - 0 0 1 A - S M 5 C	Earth Cale For Auto Knee Lifting Solenoid	1	
D-49	1 7 - 0 1 6 B - 3 0 0 0	Plug For Auto Knee Lifting Solenoid	1	
D-50	0 8 - 0 1 4 C - 3 7 0 1	Tube For Cable	1	
D-51	2 5 - 0 0 6 A - 3 2 0 0	Knee for Cable	1	
D-52	1 8 - 0 2 1 A - 5 6 0 7	Ball Joing (Right)	1	
D-53	1 8 - 0 1 5 S - 5 6 0 7	Nut (L) for D-54	1	
D-54	1 8 - 0 1 8 B - 5 6 0 7	Ball Joint connecting Rod	1	
D-55	1 8 - 0 1 6 S - 5 6 0 7	Nut (R) For D-54	1	
D-56	1 8 - 0 2 0 A - 5 6 0 7	Ball Joint (Left)	1	
D-57	1 8 - 0 1 1 B - 5 6 0 7	Solenoid Shaft Connecting Rod Solenoid	1	
D-58	1 8 - 0 1 9 S - 5 6 0 7	Nut For D-57	1	
D-59	E A - 0 0 0 0 2 3	Edge Sensor Box (Ass'y)	1	

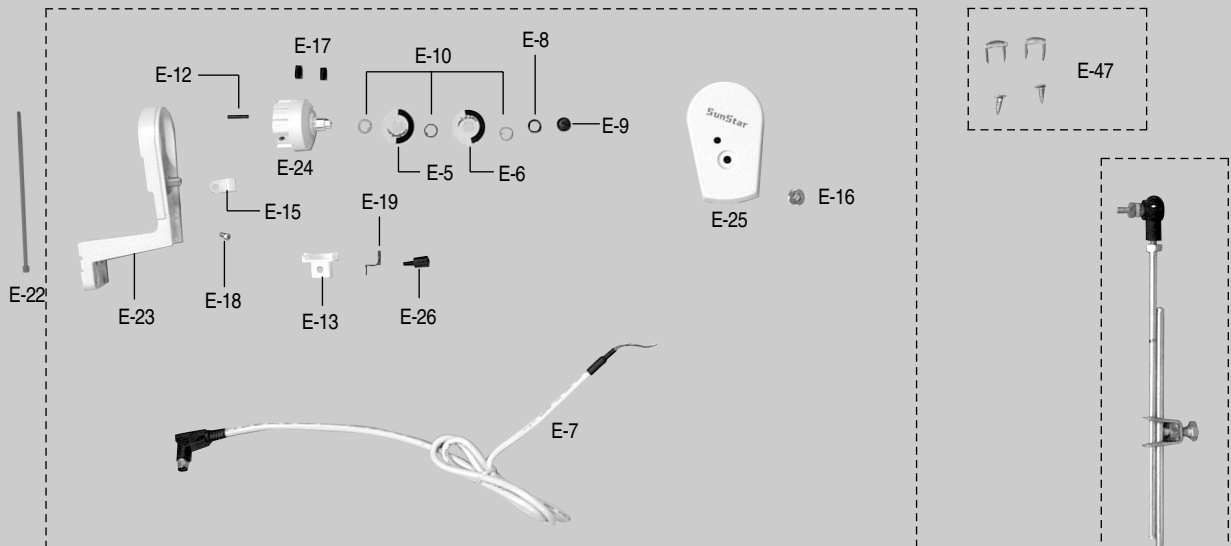
E

SYNCHRONIZER

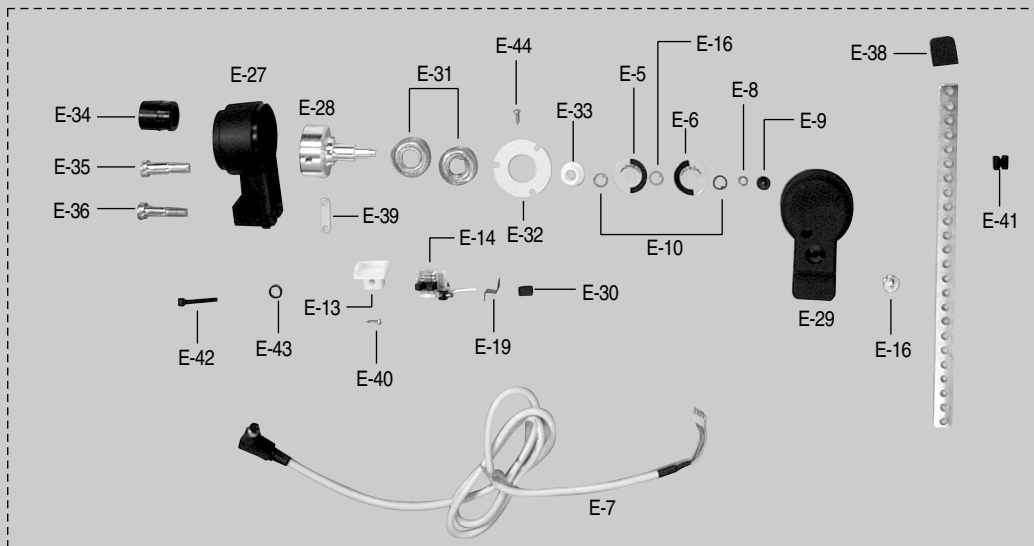
E-1



E-20



E-21





Ref No.	Parts No.	Name of Parts	Q' ty	Assembly No.
E-1	1 1 - 0 0 0 0 - S E 5 5	Synchronizer Assemble (KM-235)	1	
E-2	1 6 - 3 0 1 A - 9 0 0 0	Synchronizer Base (KM-235)	1	
E-3	1 6 - 3 0 2 A - 9 0 0 0	Synchronizer Shaft (KM-235)	1	
E-4	1 6 - 0 0 6 B - S C 5 3	Synchronizer Cover (KM-235)	1	
E-5	1 2 - 0 1 1 S - S C 5 3	Synchronizer Film (UP)	1	
E-6	1 2 - 0 1 2 S - S C 5 3	Synchronizer Film (DOWN)	1	
E-7	1 2 - 0 1 6 B - S E 5 5	Cable For Din Connector	1	
E-8	1 1 - 0 0 6 C - S C 5 3	Fixed Bushing For Synchronizer Film	1	
E-9	1 1 - 0 0 7 S - S C 5 3	Screw For Synchronizer Film	1	
E-10	1 1 - 0 0 8 W - S C 5 3	Washer For Synchronizer Film	3(Ass' y)	
E-11	1 1 - 0 0 9 S - S C 5 3	Screw For Photo Sensor Assembly	1	
E-12	1 1 - 0 2 4 P - 3 7 0 1	Roll Pin (3 *16)	1	
E-13	1 2 - 1 0 5 B - S C 5 3	P.C.B Holder	1	
E-14	1 1 - 2 0 0 A - S E 5 5	P.C.B Assembly	1(Ass' y)	
E-15	0 8 - 0 1 5 C - 3 7 0 1	Clip 4N	1	
E-16	1 6 - 0 0 8 S - 2 0 0 0	Screw For Synchronizer Cover	1	
E-17	1 6 - 0 1 0 S - 2 0 0 0	Screw For Synchronizer Shaft	2(Ass' y)	
E-18	0 9 - 0 4 2 S - 3 7 0 1	Screw For Cable Holder	1	
E-19	1 6 - 0 0 7 B - S C 5 3	P.C.B Holder Plate	1	
E-20	1 2 - 0 0 0 0 - S E 5 5	Synchronizer Assembly (Special Type)	1	
E-21	1 1 - 7 0 0 0 - S E 5 5	Synchronizer Assembly (Other Company Type)	1	
E-22	1 5 - 0 2 6 M - 1 0 0 0	Band Clip For Cable	1	
E-23	1 6 - 3 0 1 A - S C 5 1	Synchronizer Base (Special Type)	1	
E-24	1 6 - 3 0 3 A - 9 0 0 0	Synchronizer Shaft (Special Type)	1	
E-25	1 6 - 0 0 3 B - 5 6 0 0	Synchronizer Cover (560)	1	
E-26	1 1 - 0 0 9 S - S C 5 3	Lock Screw For Photo Sensor Assembly	1	
E-27	0 6 - 0 0 9 B - S C 5 3	Synchronizer Base (Other Company Type)	1	
E-28	0 6 - 3 0 3 A - S C 5 1	Synchronizer Shaft (Other Company Type)	1	
E-29	0 6 - 0 0 8 B - S C 5 3	Synchronizer Cover (Other Company Type)	1	
E-30	1 2 - 1 0 5 C - S C 5 1	Lock Nut For Photo Sensor Assembly	1	
E-31	1 6 - 0 1 5 A - 2 0 0 0	Bearing (6001z)	2	
E-32	1 2 - 1 0 2 C - S C 5 1	Stopper For Bearing	1	
E-33	1 2 - 1 0 3 C - S C 5 1	Stopper Bushing For Bearing	1	
E-34	1 1 - 0 1 1 C - S C 5 3	Connection Bushing For Synchronizer (Other Company Type)	1	
E-35	1 1 - 0 1 2 S - S C 5 3	Screw (A) For E-34 (11/32" n=28)	1	
E-36	1 1 - 0 1 3 S - S C 5 3	Screw (B) For E-34 (5/16" n=24)	1	
E-37	1 1 - 1 0 4 C - S C 5 1	Connection Plate For Synchronizer	1	
E-38	1 1 - 1 0 5 C - S C 5 1	Lock Rubber For Synchronizer	1	
E-39	1 2 - 1 0 1 C - S C 5 1	Fixing Plate For Cable	1	
E-40	1 2 - 1 0 4 C - S C 5 1	Screw For E-39	2(Ass' y)	
E-41	1 6 - 0 1 0 S - 2 0 0 0	Screw For E-34	2	
E-42	1 2 - 1 0 3 S - S C 5 1	Screw For Photo Sensor Assembly (Other Company Type)	1	
E-43	0 9 - 0 4 6 W - 3 7 0 1	Spring Washer For Photo Sensor Assembly (Other Company Type)	1	
E-44	1 2 - 1 0 4 C - S C 5 1	Screw For Bearing Stopper	3(Ass' y)	
E-45	9 1 - 0 0 7 A - 3 7 0 1	Pedal Control Rod Assembly	1(Ass' y)	
E-46-1	9 1 - 2 0 1 A - S E 5 1	Power Source For Switch Box (1~220V)	1(Ass' y)	
E-46-2	9 1 - 2 0 1 A - S E 5 3	Power Source For Switch Box (3~220V)	1(Ass' y)	
E-46-3	9 1 - 1 0 1 A - S E 5 1	Power Source For Switch Box (1~110V)	1(Ass' y)	
E-47	9 1 - 0 0 8 C - 1 7 0 1	Staple	5(Ass' y)	