



TYPICAL

YSC-8571-A1

USER MANUAL

XI'AN TYPICAL INDUSTRIES CO.,LTD.

Notice

This product is used in system of industry sewing machine. For perfect operation and safety, installation and operation must be supervised by professional.

●Work environment

▲ Please use 220V AC in $\pm 10\%$ ranges.

▲ To avoid the false operate. Please keep the product away from the high electromagnetic interference.

▲ Please operate in the area which temperature is $5^{\circ}\text{C}\sim 45^{\circ}\text{C}$.

▲ Please operate in the area which humidity is 80% or less.

▲ Please keep the product away from the flammability and exploder.

●Notice of installation

▲ The control box should be installed correctly follow the instruction in this manual.

▲ Turn off the power and unplug the cord before installation.

▲ The wire must not set to be near the wheel and other movable parts.

▲ To avoid the static interference and current leakage, all grounding must be done.

●Notice of safety

▲ Turn off the power before maintenance and repairs or raising the machine arms, or changing needle, or threading needle.

▲ Please don't open the box except the professional.

▲ When turn on the machine in the first time, use low speed to operate and check the correct rotation direction.

▲ During machine operation, don't touch any moving parts.

▲ All moving parts must use the protective device to avoid the body contact and objects insertion.

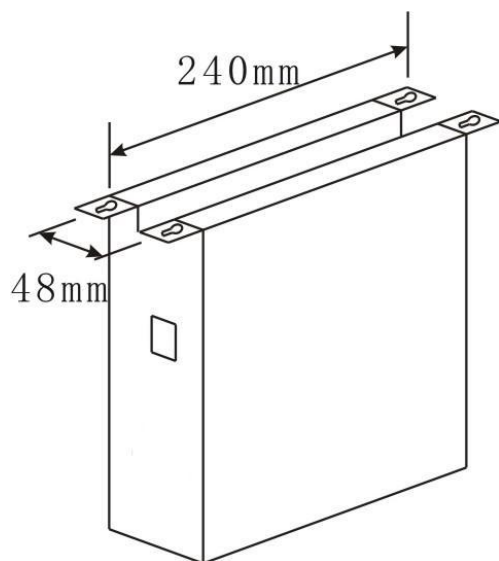
▲ When there is water or other liquid, or caustic material on box or motor, you must stop operation and turn off the power.

▲ All connector shouldn't plug and unplug when power on.

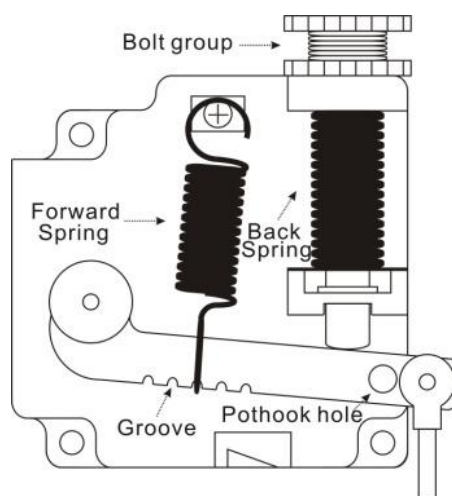
▲ The connector should be plug and unplug in the correct method.

1. Installation and Adjustment

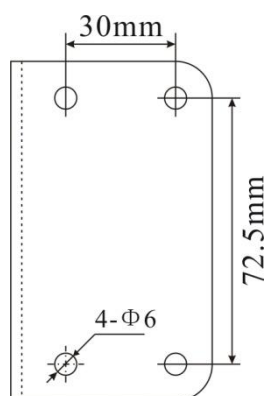
1.1 Control box



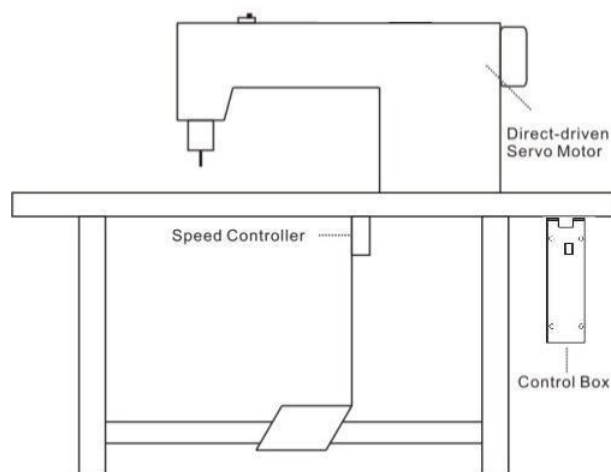
1.2 Speed controller



1.3 Dimension of speed controller bracket



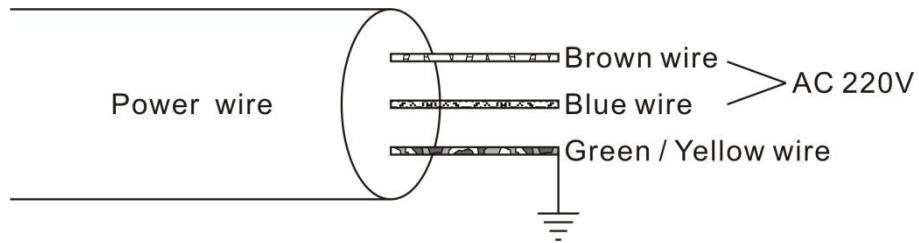
1.4 Installation diagram of system



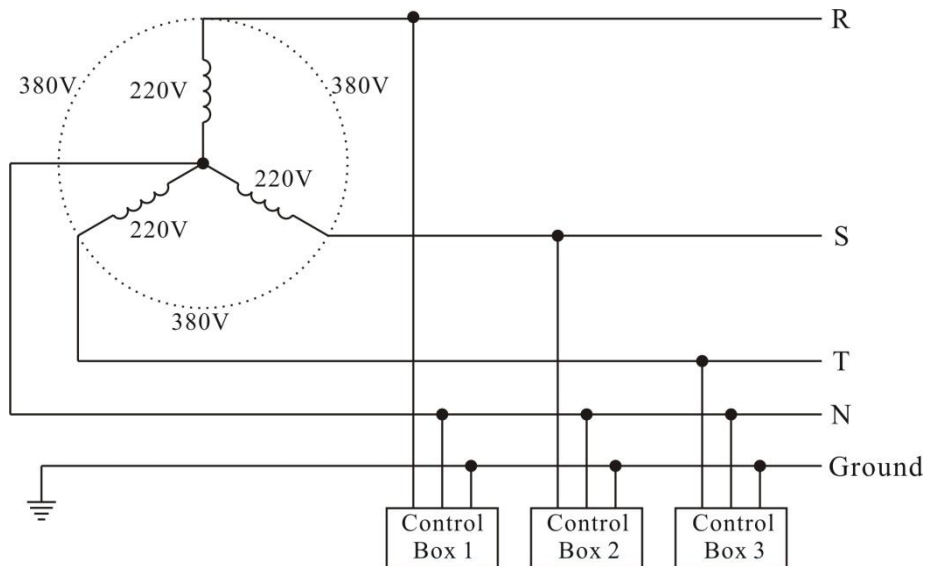
2. Power Connection

2.1 Single phase 220V power connection

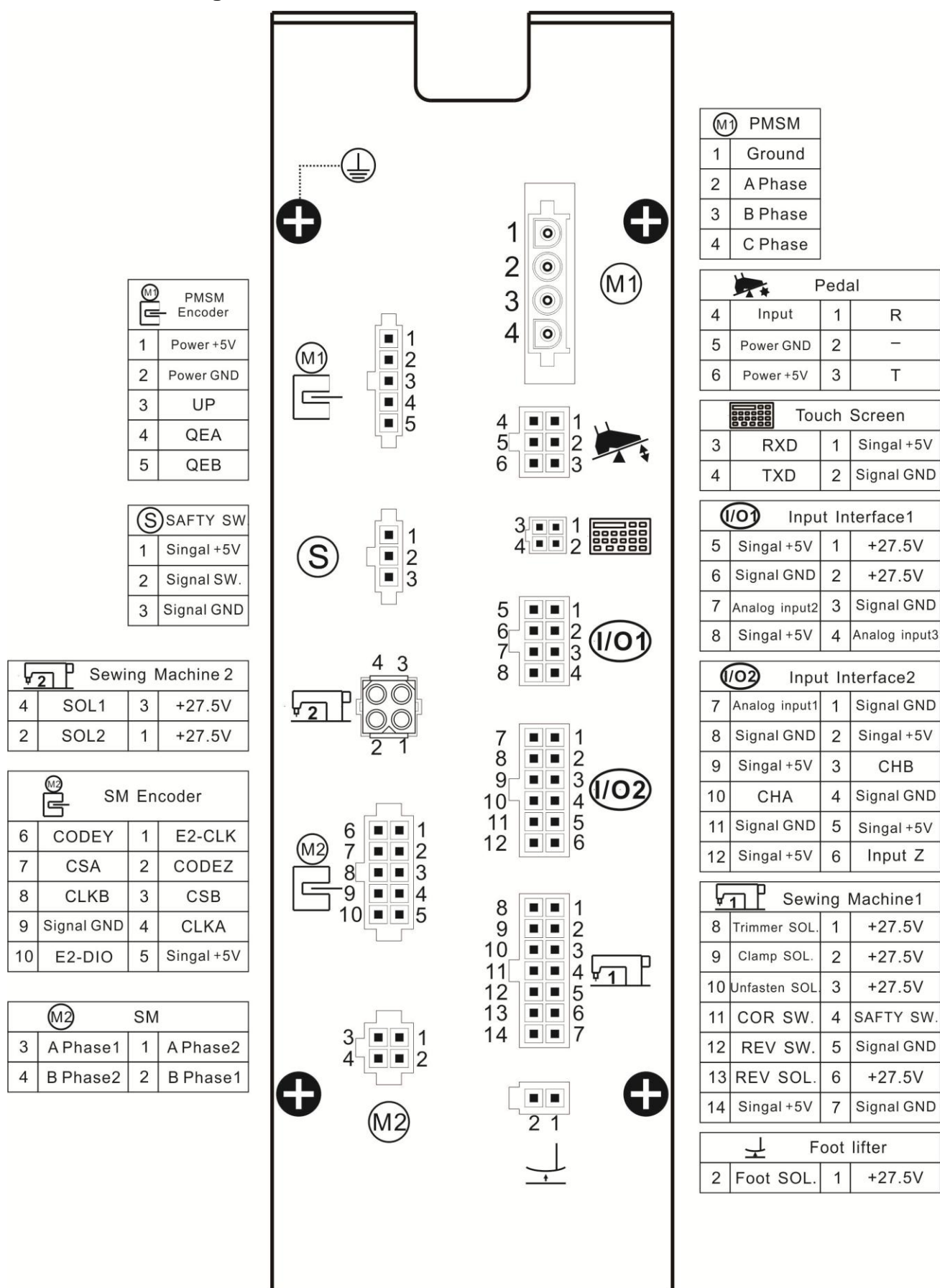
Ground wire (green & yellow) must be grounding.



2.2 Three phase 380V power connection



3. Connector Diagram

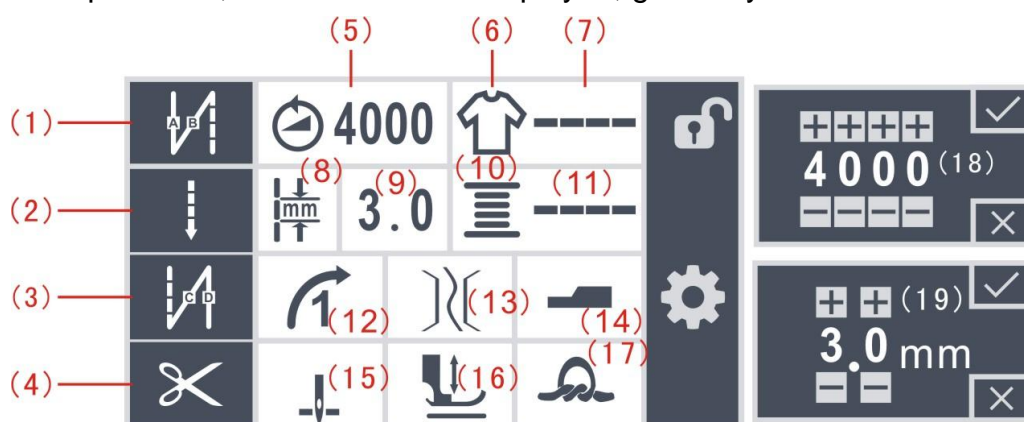


4. Function key

	Lock screen	Switching touch screen lock ON/OFF. The factory default 30 seconds without operating automatic lock screen.
	Setup	Enter setting interface.
	Home	Return to main interface.
	Return	Return to last interface.

















5. Main Interface


















After power on, main interface is displayed, generally sew in this interface.



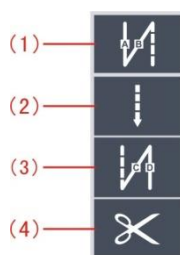
5.1 Description

(1)	Start backtick	ON/OFF start backtick: ON, OFF; If long press, enter setting interface. Note: the start backtick of fixed stitch can be set separately, display the setting status of the next segment in real time.
(2)	Sewing Mode	Sewing mode: Free sewing , Continuous backtick , Fixed stitch ; If long press, enter setting interface (Continuous backtick and Fixed stitch). Note: Fixed stitch icon , the left number is the next segment No., and the right number is the number of stitches of the next segment.




(3)	End backtack	<p>ON/OFF End backtack:  ON,  OFF;</p> <p>If long press, enter setting interface.</p> <p>Note: the end backtack of fixed stitch can be set separately, display the setting status of the next segment in real time.</p>
(4)	Thread trimming	<p>ON/OFF thread trimming:  ON,  OFF;</p> <p>If long press, enter setting interface.</p> <p>The fixed stitch thread trimming can be set separately for each segment, display the setting of the next segment in real time.</p>
(5)	Sewing Speed	<p>Display sewing speed. Press it to enter adjust speed interface (18), press  to save, press  to cancel.</p> <p>Note: Different mode (free sewing/continuous backtack/fixed stitch), respectively, to adjust their speed.</p>
(6)	Piece Counter	<p>ON/OFF piece counter:  ON,  OFF;</p> <p>If long press, enter setting interface.</p>
(7)		If the counter is turned on, display the count.
(8)	Stitches Mode	Change the stitches mode:  Fixed length,  Variable length
(9)	Stitches Length	<p>Fixed length  : display the stitches length (unit: mm), press it to enter adjust length interface (19), press  to save, press  to cancel; If fixed stitch, press it to enter fixed stitch setting interface.</p> <p>Variable length  : display the No. of patterns, press it to enter pattern setting interface.</p>
(10)	Lower thread counter	<p>ON/OFF Lower thread counter:  ON,  OFF</p> <p>If long press, enter setting interface.</p>
(11)		When the counter is turned on, display the remaining count.

(12)	Soft start	ON/OFF soft start:  ON,  OFF If long press, enter setting interface.
(13)	Clamp / Wiper	ON/OFF clamp:  ON,  OFF ON/OFF wiper:  open,  close
(14)	Step	ON/OFF step:  ON,  OFF; If long press, enter setting interface.
(15)	Needle stop position	Change the needle position:  -up,  -down If long press, enter setting interface.
(16)	Foot lifter	Select function of the lifting foot:  : Close the foot lifting;  : foot lifting;  : Automatic foot lifting after stitch stop;  : Automatic foot lifting after thread trimming  : Automatic foot lifting after stitch stop and Automatic foot lifting after thread trimming. If long press, enter setting interface.
(17)	Tie thread	ON/OFF tie thread function:  ON,  OFF If long press, enter setting interface.

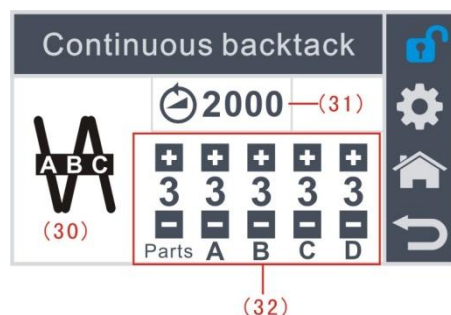
5.2 Sewing mode setting



Sewing mode key(2) select:

Free mode , Continuous backtack , Fixed stitch 

5.2.1 Continuous backtack



When sewing mode is “”, long press key (2).

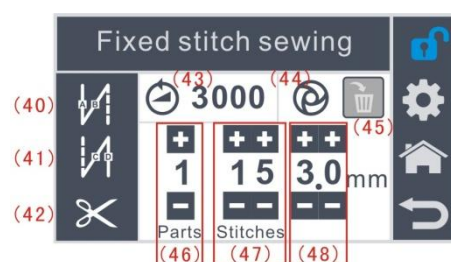
Enter setting interface.

(30) Display the current Continuous Backtack type;

(31) Show the speed of the Continuous Backtack, press it to enter the adjust speed interface (18);

(32) Adjust the No. of segments and the stitches number of every segment.

5.2.2 Fixed stitch



When sewing mode is “”, long press key (2).

Enter setting interface.

(46) Adjust the No. of segments(1~8);

(47) Adjust the stitch number (0~99); If you want to set the total number of segments is N, set the stitch number of segment No.(N+1) to “0”; (45) can erase the number of current segment;

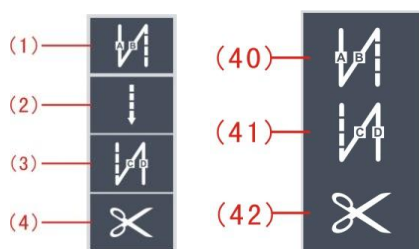
(48) Adjust the stitch length of current segment;

(40) (41) (42) Set start backtack, end backtack, thread trimmer; If long press, enter setting interface;

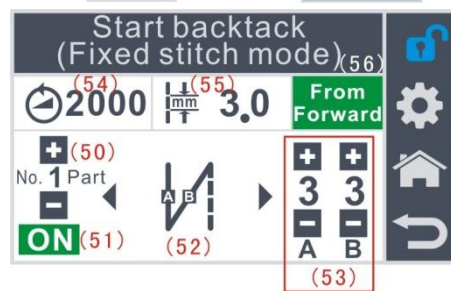
(43) Display the speed of the fixed stitch, press it to enter the adjust speed interface (18);

(44) automatic sewing

5.3 Start backtick



Long press key (1) in main interface or long press key (40) in fixed stitch interface to enter settings interface.



Special in start backtick (Fixed stitch mode), (50) used for adjust the segment No.

(51) ON/OFF

(52)(56)Change the mode:

	1	2	3	4	5
From Forward					
From Back					

Note: When middle sewing is variable length mode, in order to prevent the effect of start backtick from the variable stitch length, we suggest customer setting start backtick with following pattern as the end of forward sewing, so that start backtick will not mix with middle segment:

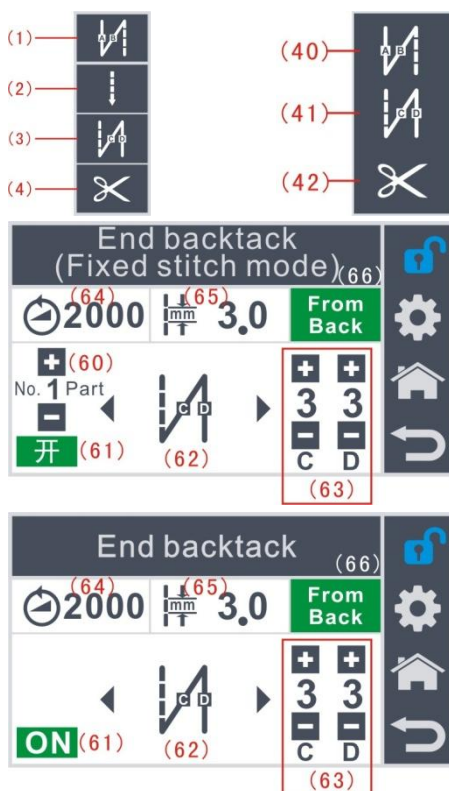
1	2	3	4	5

(53) Set stitches number, "A" is forward stitch, "B" is backward stitch, range is from 1 to 15;

(54)Display start backtick speed, press it, enter adjust speed interface(18);

(55)Display start backtick stitch length, press it, enter adjust stitch length interface(19)

5.4 End backtack



Long press key (3) in main interface or long press key (41) in fixed stitch interface to enter setting interface.

Special in End backtack (Fixed stitch mode), (60) used for adjust the segment No.

(61) ON/OFF; (62)(66)Change the mode:

	1	2	3	4	5
From Back					
From Forward					

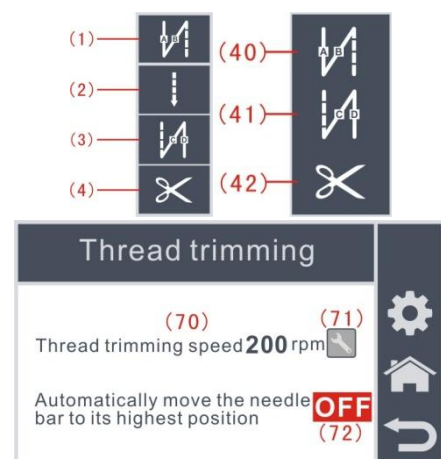
Note: When middle sewing is variable length mode, in order to prevent the effect of end backtack from the variable stitch length, we suggest customer set end backtack with above pattern as from forward, so that end backtack will not mix with middle segment.

(63) Set stitches number, "C" is backward stitch, "D" is forward stitch, range is from 1 to 15;

(64)Display end backtack speed, press it to enter adjust speed interface(18);

(65) Display end backtack stitch length, press it to enter adjust stitch length interface(19)

5.5 Thread trimming



Press key (4) in home interface or key (42) in fixed stitch interface, ON/OFF the thread trimming: ON, OFF

If long press it, enter setting interface.

(70) Display trimming speed;



(71) Press it to enter adjust speed interface(18), set thread trimming speed;

(72) ON/OFF automatically move the needle bar to its highest position.

5.6 Stitch length

5.6.1 Fixed stitches length



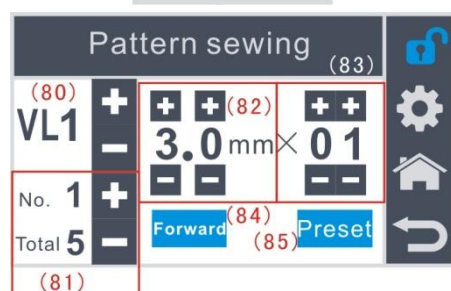
(8) Select fixed stitches length  or variable stitches length ;

(9) Enter adjust fixed stitches length interface(19);

5.6.2 Variable stitches length




(9) Enter set stitches pattern interface;



Factory default 8 kinds (VL1-VL8) stitches patterns consisted of several segment (maximum 15 segments), several stitches (maximum 15 stitches), with a certain stitch length (can be set as forward or backward sewing); customer can change stitch patterns freely, long press preset key (85) to reset default patterns.

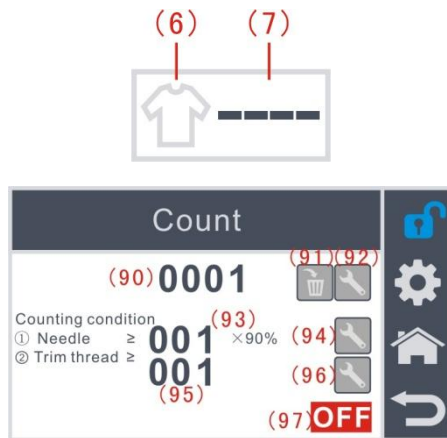
Pattern sample, take factory default of pattern VL1 as an example:

segment	1	2	3	4	5	6
length	3.0	3.0	3.0	3.0	3.0	--
quantity	1	1	1	1	2	--
direction	forward	backward	forward	backward	forward	--
trace	+3.0mm	/-3.0mm	+3.0mm	/-3.0mm	+3.0mm +3.0mm	--
pattern						

(80) Select pattern serial number, range from VL1 to VL8;
 (81) Adjust the segment serial number of the pattern being set, and display total amount of segments according to auto calculation; if customer need set total segment quantity as N, just set stitch quantity of segment N+1(83) as "--"; (in example, segment No. 6 stitch quantity is "--" means total segment quantity is 5);

(82) Adjust stitch length of one segment, (84) adjust forward or backward sewing of one segment;

5.7 Piece Count



Piece count can calculate number of work pieces

approximately. If it match conditions (93) (95), work piece quantity add 1.

The main interface key (6) turn on/off piece count function:

👕 ON, 👕 OFF; long press it, enter setting interface;

(7) is present quantity of work pieces when piece count

function is turn on; (90) is current quantity number, (91)

clean quantity number, (92) amend quantity number;

Two conditions of quantity number add 1:

i:Stitch quantity should bigger than or equal to 0.9 times of

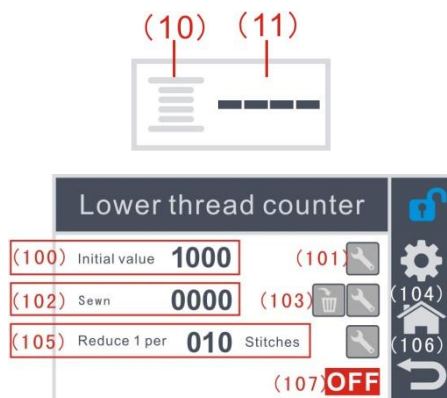
preset stitch quantity (93); ii: trimming times should bigger

than or equal to preset times (95);

(94) amend preset sewing stitch quantity, (96) amend

preset trimming times; (97) Turn on/off piecework function.

5.8 Lower thread counter



The lower thread counter can let you know how much lower thread is remaining.

Every time with several stitches (105), lower thread

remains quantity minus 1. When lower thread remain

quantity ≤ 0 , buzzer buzzing 1 second, icon turns yellow 🟡

at the meantime, alarming. Sewing can be continued until

operate trimming motion at this time. Sewing is not allowed

after trimming. Press 🟡 to remove alarm, icon color back to

🟢, and sewing can be continued and counted as negative

number. After changing bobbin case, press 🟢 again,

bottom line quantity back to original value.

The home interface key (10) turn on/off this function: 🟢

ON, 🟢 OFF; long press to enter settings;

When lower thread counter is ON, (11) is remain

quantity(=preset data-sewing data);

(100) preset quantity; (101) modify preset quantity; (102) is

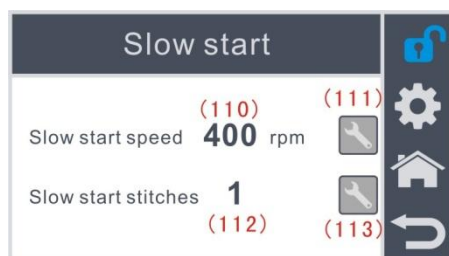
already used; (103) clear quantity already used; (104)

modify quantity already used; (105) is stitch quantity for

lower thread quantity minus 1; (106) modify this stitch

quantity; (107) turn on/off lower thread counter function.

5.9 Soft start



In order to ensure the thread picking and nipping stability of next sewing step after trimming, soft start function can be turn on.

The home interface key (12) switching on/off soft start function; turn on, number is the stitch quantity which operating soft start; turn off; long press to enter settings.

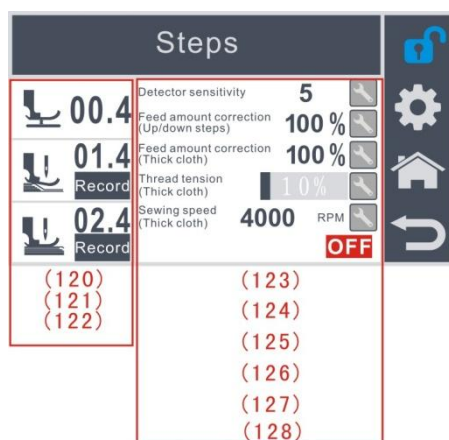
(110) is speed of soft start (200-500 stitch/min);

(111) adjust speed of soft start;

(112) is stitch quantity of soft start (1-5 stitch);

(113) adjust stitch quantity of soft start;

5.10 Step



Taking use of step function can improve feeding on steps, decrease deviation stitch error on thick part.

The main interface key (14) turn on/off step function;

ON OFF. Long press to enter settings. Setting way:

- ① Thickness definition: Sewing thickness means the height of presser foot when feed tooth under needle plate level; (120) present height of presser foot shown at the same time;
- ② Collection of step thickness (121): lifting presser foot to step position (as shown in the chart), press “record” to recording present thickness;
- ③ Collection of thick part thickness (122): lifting presser foot to thick part position (as shown in the chart), press “record” to recording present thickness;
- ④ Adjusting of detector sensitivity: When detecting occasion of stepping is inaccurate, adjusting sensitivity (123), the bigger value the earlier discover step;
- ⑤ Stitch length rate of up step (124) and stitch length rate of thick part (125): Actual feeding length=preset stitch length × stitch length rate;
- ⑥ Upper thread tension of thick part, the bigger value the smaller thread tension;
- ⑦ Limitation of speed when sewing heavy-duty (127);
- ⑧ (128) turn on/off step function.

5.11 Needle positioning



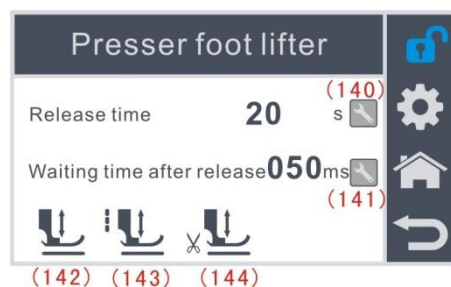
The main interface key (15) switch needle positioning:

upper needle position, -lower needle position; Long press to enter settings;

(130) set whether operating upper needle positioning automatically after starting up;

(131) set whether lifting needle bar to highest point after trimming, it is easy for takeout fabrics.

5.12 Foot lifter



The main interface key (16), switching foot lifting function mode;

Long press it to enter settings.

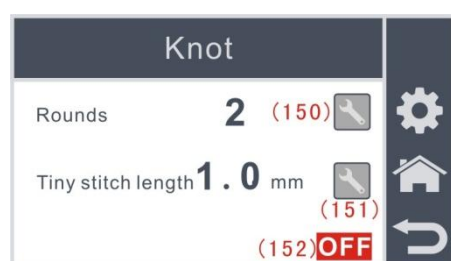
To prevent electromagnet from overheat or burn after long time work, it will be automatic release after presser foot lifted for a while, (140) adjusting automatic release time; After presser foot release for a while, operating sewing motion after ensure presser foot compacted fabrics, (141) adjusting waiting time;

(142) main switch of presser foot function;

(143) switch for auto foot lifting in middle process;

(144) switch for auto foot lifting after trimming.

5.13 Tie thread



When used tie thread, can reduce the bird's nest.

The main interface key (17), turn on/off function; ON
 OFF. Long press it to enter settings.

(150) set rounds, one round include 2 stitches.

(151) set stitch length when tie thread.

6. Setting interface Press setting button to enter settings

6.1 treadle

Set back half treadle function;

- ①Foot lifting position (Factory data)
- ②Trimming position: If there is no need lift presser foot in the middle process, meanwhile trimming is required more sensitive, trimming position can be set. (After trimming, trimming position also can lifting presser foot)
- ③Start position: If there is no need lift presser foot in the middle process, meanwhile trimming is no need sensitive, start position can be set. Back half pedal will not operate any motion.

6.2 Safety switch



To prevent any wrong motion from machine head vibration, motion will be confirm after signal changed for a while, (160) adjusting confirmed time; If there is an alarm after lay down machine head, or there is no alarm after turn over, the signal polarity is not match, (161) adjusting signal polarity; (162) turn on/off turn over switch function.

6.3 Machine head switch

Two machine head switches on machine head are multi-function switch, can be set respectively:

- 0: Reverse sewing
- 1: Change needle up/down
- 2: Correct stitches
- 3: Change needle up/down, reverse when sewing
- 4: Correct stitches, reverse when sewing
- 5: Correct stitches and reverse at the same time
- 6: --
- 7: The same as backpedal to trim position
- 8: Raise/down presser foot
- 9: --
- 10: --
- 11: Second Stitch Length



Specially, when setting as “11: Second Stitch Length” function, (170) adjusting intensive rate, intensive stitch length=preset stitch lengthxintensive rate.

6.4 Correction sewing



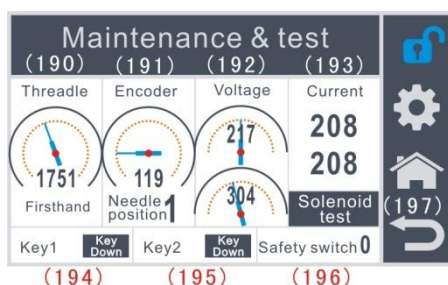
When machine head switch function setting as correct, here is parameters of stitch addition setting:

(180) is sewing speed of correct, also is speed of treadle at the first forward segment;

(181) correct after trimming: stitch adding at stop when turn on; it cannot add stitch before trimming when turn off;

(182) It will be stopped at stop position as preset when turn on; It will be stopped at upper needle position or down needle position which is closer when turn off;

6.5 Maintenance & test



Used for inspect system status of partially input and output, judging whether equipment is in good condition.

(190) treadle testing: step treadle to different position, shows voltage sampling value (about 750-4000) and position: ① start position ② backward first segment: presser foot lifting ③ backward second segment: trimming ④ forward first segment: low speed ⑤ forward second segment: high speed;

(191) Encoder testing: turn hand wheel forward, shows encoder value (0-720) and needle position signal (0/1);

(192) voltage read: respectively AC input 220V voltage values and controller bus-bar voltage (\approx AC input voltage \times 1.4);

(193) Motor for main shaft current reference value: \approx 208;

(194) head button 1 testing: after press, shows: “press”, after release, shows “bounce”;

(195) head button 2 testing: after press, shows: “press”, after release, shows “bounce”;

(196) Safe switch testing:

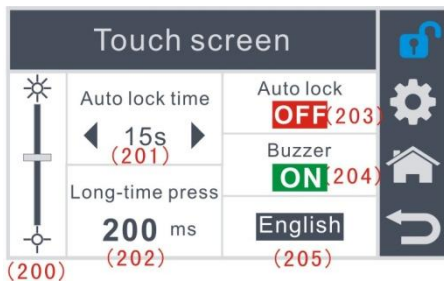
① Under the status that turn over switch function is

turn off, turn over/lay down machine head, data is changing between 0/1;

②Under the status that turn over switch function is turn on, turn over/lay down machine head, machine will execute turn over alarm function;

(197) enter electromagnet testing interface (198): press relevant electromagnet button respectively, relevant electromagnet should execute pull and put motion once;

6.6 Touch screen



Used for set touch screen parameters.

- ① Screen brightness: (200) adjusting screen brightness (adjusting brightness when lock screen);
 - ② Lock screen automatically: (203) after turn on after a while (201) without screen operation, screen locked automatically; lock time can be set as: 15 sec, 30 sec, 1 min, 2 min, 5 min, 10 min, 20 min and 30 min;
 - ③ Buzzer: (204) turn off is mute, turn on is buzzing;
 - ④ Long press to judge the time: (202) press and hold the button, after a while judge as long press motion;
 - ⑤ Language: (205) switch between Chinese and English
-

6.7 About

Display program version information

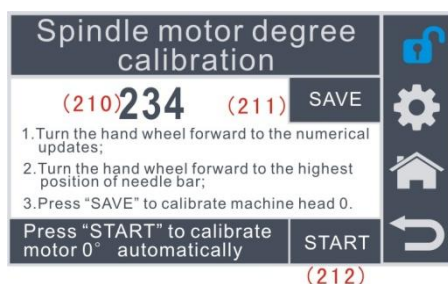
6.8 Advanced settings

Enter “Advanced settings”, password are required sometimes, customer can’t enter advanced settings with wrong password.

7. Advanced settings (★Warning: If set up incorrectly in advanced setting interface, it may cause the machine does not work properly, please operate cautiously.)

7.1 Main motor angle adjustment

Set machine head zero point and main motor zero point.



- ① Setting machine head zero point: Run hand wheel forward till (210) changes, when needle bar in top position, press key (211), this position is set machine head zero point.
- ② Setting motor zero point: Lift up pressure foot, no fabrics, press key (212), setting automatically.

7.2 Zero stitch length adjustment

Stitch length motor installed or position changed, must adjust zero stitch length again.



Enter this interface, stitch length change to zero stitch length position. Put fabrics under press foot for sewing, checking stitch length plus or minus. Stop then adjust zero point stitch length. If stitch length plus, decrease stitch length (221), otherwise, increase stitch length (220).

Sewing and adjusting till stitch length is zero, press key (222), then exit.

7.3 Duty of solenoid

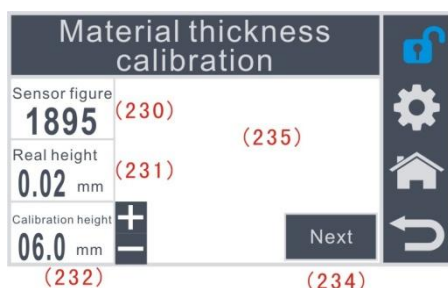
Set solenoid duty: clamp, thread tension, auto foot lifter

7.4 Action degree

Set needle stop position (up & down), thread trimmer act and release angle, thread tension act and release angle.

7.5 Thickness of material calibration

Press foot height detector installed or position changed, must calibrate again.



(230) Display sensor sample values;(231) Display real height by calculating;(232) Setting calibration fixtures height;(235) Text display, tell user how to operate:

- ①Put down press foot, no fabrics, put down feed tooth under needle plate, make sure the lowest position, press key (234);
- ②Put(232)calibrated height fixtures under press foot, press key (234), finish calibration.

7.6 Setting press foot

Setting press foot pulling whole power time, turn on / off auto foot lifter release on time function.

7.7 Change machine head	Change machine head, and press “setting” confirm.
7.8 Stitch length ratio	Setting forward ratio, backward ratio, high speed ratio.
7.9 Factory data reset	
7.10 Password	Setting “advantage setting” interface password and switch.
7.11 Parameter	Enter parameter table; press long can adjust D and O series parameters.

8. ERROR CODE

CODE	Description	Measurement
E101	Voltage is too high	Check power supply voltage
E102	Voltage is too low	Check power supply voltage
E103	Voltage is too high	Check power supply voltage
E104	Voltage is too low	Check power supply voltage
E106	Overload	Check motor cable/machine stuck?/encoder
E107	Communication error	Repair control box
E108	Overload	Check motor cable/machine stuck?/encoder
E109	Motor error	Check motor cable/machine stuck?/encoder
E110	Synchronizer error	Check motor cable/machine stuck?/encoder
E200	No step motor information	Check motor cable
E204	Step motor overtime	Check motor cable/machine stuck?
E205	Step motor no electric angle	Check motor cable
E206	Step motor no mechanical zero point	Check motor cable
E207	Mechanical zero point over range	Check motor cable
E209	Step motor no mechanical zero point	Check motor cable
E213	Step motor over range	Check motor cable
E216	Step motor overload	Check motor cable/machine stuck?
E217	Communication error	Repair control box
E249	No step motor information	Check motor cable

9. Parameter

No.	Range	Description
S01	500~5000rpm	Maximum speed
S02	150~500 rpm	Minimum speed
S03	500~3500 rpm	Speed of Start Backtack
S04	500~3500 rpm	Speed of End Backtack
S05	500~2500 rpm	Speed of Continuous Backtack
S06	500~4500 rpm	Speed of Fixed Stitch
S07	150~300 rpm	Speed of Thread Trimming
S08	200~500 rpm	Speed of Slow Start
T01	1~200ms	Time of wait stepper motor delay when run stepper motor before main motor.
T02	1~10ms	Stepper motor communication time
T03	1~200ms	Timing before the wiper solenoid act.
T04	1~200ms	Timing for the wiper solenoid action.
T05	1~500ms	Timing before the foot lifter solenoid is act.
T06	1~500ms	Timing before the foot lifter solenoid is released.
T07	1~999ms	Timing of the foot lifter solenoid is act with whole output.
T08	1~999ms	Timing of the reverse solenoid is act with whole output.
T09	1~1000ms	Timing of judge the Safety Switch.
T10	1~200ms	The pedal will be greater sensitive when the value is smaller.
A01	0~1	Needle Up/Down: 0 down, 1 up
A02	0~1	Fixed Stitches automatic sewing
A03	0~1	Needle Up/Down of Correct Stitches: 0 - random, 1 - A01
A04	0~11	Input1 function
A05	0~11	Input2 function
A06	0~1	Thread trimming
A07	0~1	Step fixing switch

A08	0~1	Wiper(must set A10 to "0")
A09	0~1	Foot Lifter
A10	0~1	Clamp
A11	0~1	Piece counter
A12	0~1	Lower thread counter
A13	0~1	After trimming, pullback to Needle Top.
A14	0~1	The Foot Lifter will lift automatically when stop,
A15	0~1	The Foot Lifter will lift automatically after trimming.
A16	0~1	In Fix Stitches. If A02 was set to "1", the next segment will sew automatically after the Start Backtack.
A17	0~1	In Fix Stitches. If A02 was set to "1", the End Backtack and thread trimming will do automatically after the last segment.
A18	0~1	The machine will move to Needle Up and stop automatically as power on.
A19	0~2	Function of pedal back -1: 0 - neutral position, 1 – Foot Lifter, 2-thread trimming
A20	--	
A21	0~1	Slow Start
A22	--	
D01	0~359°	Needle Up degree.
D02	0~359°	Needle Down degree.
D03	0~359°	Trimmer act degree.
D04	0~359°	Trimmer release degree.
D05	0~359°	Reverse act degree.
D06	0~359°	Reverse release degree.
D07	0~359°	Clamp act degree.
D08	0~359°	Clamp release degree.
D09	0~359°	Stitch length motor start angle.
D10	0~359°	Stitch length motor finish angle.

D11	0~359°	Reverse forbidden act degree(RVS.SW)
D12	0~359°	Reverse allow act degree(RVS.SW)
O01	1~10	The number of stitches of slow start
O04	0~50%	Upper thread tension adjustment during thick step, output under take up
O05	10~100%	The duty of Foot Lifter SOL
O06	0~1	The foot lifter SOL will be released automatically after the time desired(O07)
O07	5~30s	“The time desired” of O06
O09	10~100%	The duty of RVS SOL
O10	0~1	The RVS SOL will be released automatically after the time desired(O11)
O11	5~30s	“The time desired” of O10
O17	50~150%	Stitch length addition during forwarder sewing.
O18	50~150%	Stitch length addition during back tack.
O23	1~60	The running time of aging test.
O24	1~60	The idle time of aging test.
O25	1~720	The total time of aging test.
O26	0~1	Set to “1/2” active the aging test.
O27	500~3000	Reduction speed of back tack speed
O29	1.0~5.0mm	Stitch length when back tack speed reduction is begin
O31	0~1	Safety switch
O32	0~1	Polarity of safety switch
O33	200~4000rpm	Reduction speed of step sewing speed
O37	0~100	Step thickness
O38	0~100	Thickness of thick part
O39	50~200	Up step compensation rate
O40	50~200	Thick part compensation rate
O41	1~100	With how many stitches bottom line quantity add 1

O42	0~1	Foot Lifter when clamping.
O43	1~9999	Preset data for lower thread counter.
O44	0~9999	Lower thread counter.
O45	1~999	Stitch quantity for piece counter judgment.
O46	1~99	Thread trimming times for piece counter judgment.
O47	0~9999	Piece counter quantity.
O48	10~100%	The duty of clamp SOL.
O49	10~100%	The duty of unfasten SOL.
O51	0~1	Reset parameter to Factory Defaults
O53	10~100%	Output of free sewing when presser foot discharge and at a low speed and without front bar-tacking.
O54	10~100%	Output when presser foot discharge during start with slow start
O55	10~100%	Output when presser foot discharge under other status
O56	0~4095	Pedal input MAX value: value \geq O57
O57	0~4095	Pedal input dividing value of high speed and low speed: O56 \geq value \geq O58
O58	0~4095	Pedal input dividing value of low speed and Balance: O57 \geq value \geq O59
O59	0~4095	Pedal input dividing value of Balance and Foot lifter: O58 \geq value \geq O60
O60	0~4095	Pedal input dividing value of Foot lifter and Trimming: O59 \geq value \geq O61
O61	0~4095	Pedal input MIN value: value \leq O60
O62	0~250	Pedal loop value
O63	0~5	Pedal mode: 0-linear; 1-polyline; 2-curve (slow \rightarrow quick); 3 - curve (quick \rightarrow slow); 4-S curve (slow \rightarrow quick \rightarrow slow); 5-S curve (quick \rightarrow slow \rightarrow quick)
O64	500~5000	The speed of knee of polyline
O65	0~4095	The value of knee of polyline: O56 \geq value \geq O57
O66	1~10ms	The period of Foot Lifter SOL(ms)
O67	1~10ms	The period of RVS SOL(ms)
O68	0~1	Mode of the End Backtack: 0- Stop first, then act RVS SOL; 1-Act RVS SOL when running
O69	0~1	Mode of correct stitches: 0-before trimming only; 1-only if stop

O72	0~10	Add torque when low speed
O73	1~9	Sensitivity of start go up step

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