

WR58LJ facility Integral employ directionsV1.1

1. Safety instruction

Please read the operation manual and related sewing machinery datasheet carefully before correct use.

- 1.1 (1) Power voltage and frequency: please refer to motor and control box nameplate.
- (2) Interference from electromagnetic wave: please keep far away strong magnetic or high radiation environment in order to avoid obstructions and make to misoperation.
- (3) Grounding: to avoid the noise obstructions or leakage of electricity accident (including sewing machine, motor, control box and positioner).
- 1.2 Please make sure power off at least 1min and then can open control box cover, because there are dangerous high voltage.
- 1.3 Please turn off the power while repairing or wearing needle in order to protect operator's safety.
- 1.4  Used where potential dangers exist.

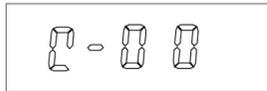
 Used where high voltage and electric danger exist.

- 1.5 Product warranty period of one year on condition that this machine is operated correctly and no man-made damage.

2. Instructions for Operation Box

2.1 key functional specification

No	Keys	Functions
1		Function keys
2		Save button
3		Add key / Minus key
4		Preset sewing
5		needle up and down bit



Left the first display: on behalf of the motor rotation direction

Left third display: the slow start function (0 mark as off; 1 mark as open)

Left fourth display: mark as up and down the needle position function (0 mark as up the needle; 1 mark as down the needle)

2.2 Monitor mode

Standby, press the "S" key + "▲" key into the monitoring status, press ▲ / ▼ key to change monitor serial number, monitor value can not be modified. Specific display content:

show frame numbers	Item Name	unit	show frame numbers	Item Name	unit
JJ	Plan number	piece	U6	Motor initial Angle	limit
U1	speed of motor control	rpm	U7	Master control program version/ Head type	/
U2	Motor Current	0.01A	U8	Head type/ Master control program version	/
U3	Motor Voltage	V	U9	Dsp no	/
U4	Pedal voltage	0.01V	vEr	Operation box version of the program	/
U5	Mechanical Angle with	limit	TYPE	Software no	/

Press the S key to enter to a specific value, press P to exit and return to the standby state.

3. Gearing and adjustment

1. Please press the P key for more than 3 seconds at the default interface.
2. Press the P key for seconds into the parameter.
3. Select the No.75 parameter, run machine at 200rpm speed.
4. Stop sewing machine, after running for several turns.
5. Check the position of the needle, and then turn the hand wheel till the needle's point touches the board (as shown in the right figure, and the value of the No.75 will change at the same time)
Step the pedal again and check that if the needle's point touches the board after the machine stopped, if not, adjust the hand wheel again.
6. Press the S key, and then end the operation.



4. Parameter list of lockstitch sewing machine

No	Project	Content	Setting range	The default value	Level
1	Sewing speed	Set sewing speed	200~3000rpm	2000	I
2	Soft-start function	1 st : Soft start stitches	1~9	1	I
4	Fixed-length seam sewing speed	Set fixed-length seam sewing speed	200~3000rpm	1500	I
21	soft start speed 1	speed of the 1 st needle of soft start	100~3000rpm	400	I
22	soft start speed 2	speed of the 2 nd needle of soft start	100~3000rpm	1000	I
23	soft start speed 3	speed of the 3 rd needle of soft start	100~3000rpm	1500	I
27	Power on and positioning	0: unavailable 1: available	0/1	0	I
28	signal mode for turn/lift switch	Setting of signal mode of turn/lift switch of machine head 0: always open 1: always close 2: forbid a protection	0/1/2	0	I
41	Low speed	The lowest speed of pedal	100~500rpm	200	I
42	Pedal curve selection	Pedal speed adjustment 0: normal 1: Slow acceleration 2: Quick acceleration	0/1/2	0	I
62	Pedal travel upon start	Pedal position upon start Travel relative to medium pedal	10~50(0.1°)	40	II
63	Pedal travel upon acceleration	Pedal position upon start acceleration Travel relative to medium pedal	10~100(0.1°)	55	II
64	Pedal travel at highest rotation speed	Pedal position at highest rotating speed Travel relative to medium pedal	10~150(0.1°)	110	II
67	Pedal travel 1 upon thread trimming	Pedal position upon start trimming without presser foot Travel relative to medium pedal	-100~-10(0.1°)	-30	II
69	Down needle positioning position	To adjust down needle position	0~240°	60	I
75	Needle position adjustment	Needle position adjustment	0~240°	105	I
79	return to factory-set parameter	5: restore the current level factory parameters 8: restore the current level and sewing factory parameter set According to S button, select yes, then press the S key execution	0~15	0	I
80	highest speed of sewing	highest speed of sewing	300~3000	3000	II
83	Aggravating function	Needle wear through cloth when used 0: invalid; 1~15 strength regulation	0~15	0	II
93	The neutral position of the pedal	Trimming the neutral position of the pedal	-15~15(0.1)	0	II

5. Error Code Table

Codes	Contents	Checking and treatment	Codes	Contents	Checking and treatment
E1	Over-current of hardware	Check if it is well earthed Whether the damage to the device driver	E10	Low voltage runtime	Check if it is well earthed. Current detection loop system is working properly
E2	Whether the damage to the device driver	Check if it is well earthed Current detection loop system is working properly	E11	HALLA signal loss	Check the motor signal cord
E3	System voltage is too high	System into line voltage is too high	E12	Motor overload	Check the sewing machine is not jammed. Actual operating excessively frequent acceleration and deceleration
E4	System voltage is too low	System into line voltage is too low	E13	EEPROM error	seek technical support
E5	High voltage runtime	System into line voltage is too high	E14	Current detection of non-normal	seek technical support
E6	Needle stop signal failure	Check if the needle connector is loose	E15	Pedal zero point exceeds the range	Pedal zero point exceeds the setting range
E7	Motor HALL Signal failure	Check the motor connector for poor connection.	E16	OZ circuit of non-normal	seek technical support
E8	Locked rotor failure of motor	Check if the motor wire is well connected, and if it is overloaded	E17	Motor reverse	Check motor phase sequence and signal lines
E9	Over-speed failure	Check if the motor wire connection is correct	E18	motor angle failure	Check motor phase sequence and signal lines Check whether the motor is stuck

Note: If the above according to check the project cannot rule out fault, please seek technical support.