

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. System parameter table:**

H5A: H5AC75-2A/AF **P25A:** H7AC55-2AF **P25B:** H7AC55-2AF (thick material)

No	Project	Content	Applicable models	Setting range	The default value	Level
1	Sewing speed	Set sewing speed	P25A P25B H5A	200~P-80 200~P-80 200~P-80	3700 3000 2000	I
2	Soft-start function	0: No soft-start function 1 9: Soft start stitches	H5A P25A P25B	0~9	1	I
3	Ornamental bartacks	0: Invalid 1: Effective	H5A P25A P25B	0/1	0	I
4	Fixed-length seam sewing speed	Set fixed-length seam sewing speed	P25A P25B H5A	200~4000rpm 200~3500rpm 200~2600rpm	3000 2500 2000	I
5	Simple sewing mode Settings	0: invalid 1: effectively	H5A P25A P25B	0/1	0	I
8	Needle position setting	Intermediate stop when the needle needle position setting 0: Down needle position 1: Up needle position	H5A P25A P25B	0/1	0	I
9	Back stitch speed limitation	can keep needle from breaking while backstitching	H5A P25A P25B	500~1500rpm	800	I
19	Solid after before sewing stop	0: unavailable 1: available	H5A P25A P25B	0/1	0	I
20	Setting of reverse sewing switch function	Reverse sewing switch mode 0: Only reverse sewing 1: Reverse sewing and fill needle 2: Only reverse sewing, standby without operating	H5A P25A P25B	0/1/2	1	I
21	soft start speed 1	speed of the 1 st needle of soft start	P25A P25B H5A	100~3000rpm 100~2000rpm	400	I
22	soft start speed 2	speed of the 2 nd needle of soft start	P25A P25B H5A	100~3000rpm 100~2000rpm	1000	I
23	soft start speed 3	speed of the 3 rd ~9 th needle of soft start	P25A P25B H5A	100~3000rpm 100~2000rpm	1500	I
24	Presser foot soft lowering function	0: unavailable 1: available	H5A P25A P25B	0/1	0	I
25	Presser foot lift function	0: unavailable 1: available	P25A P25B H5A	0/1 0/1	0 1	I
26	Auto lift presser foot function	0: unavailable ; 1: automatic presser foot shear line 2: pause automatic presser foot 3: pause, automatic presser foot shear line	H5A P25A P25B	0/1/2/3	0	I
27	Power on and positioning	0: unavailable 1: available	H5A P25A P25B	0/1	1	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	H5A P25A P25B	0/1	0	I
29	Presser foot soft lowering time	To set presser foot soft lowering time	H5A P25A P25B	50~500ms	300	II
32	Decorative bar-tacking dwell time	To set decorative bar-tacking dwell time	P25A P25B H5A	5~500ms	50 100	I
34	To select standard bar-tacking pedal speed mode	0: Auto bar-tacking speed ; 1: Pedal speed	H5A P25A P25B	0/1	0	II
35	By-piece rate setting	0: No by-piece function 1 20: Plus 1 to by-piece value for each set thread trimming	H5A P25A P25B	0~20	1	I
37	Thread wiping operation time	Thread wiping operation time	H5A P25A P25B	0~800ms	40	II
41	Low speed	The lowest speed of pedal	H5A P25A P25B	100~400rpm	200	I
42	Pedal curve selection	0: normal; 1: Slow acceleration 2: Quick acceleration	H5A P25A P25B	0/1/2	0	I
43	Dial the line that can set	0: unavailable 1: available	H5A P25A P25B	0/1	1	I
44	thread-cutting speed	thread-cutting speed	P25A P25B H5A	100~400rpm	280 200	I
45	Reverse sewing speed limit switch	processing can prevent reverse sewing needle breakage 0: infinite speed 1: have the speed limit	H5A P25A P25B	0/1	0	I
46	pressor foot lifting delays sewing	delay with pressor foot lowered	H5A P25A P25B	0~800ms	200	II
47	Time of presser foot magnet full voltage output	Time of presser foot magnet full voltage output	H5A P25A P25B	0~800ms	150	II
48	Presser foot magnet voltage output duty cycle	Presser foot magnet voltage output duty cycle	H5A P25A P25B	0~100	30	II
49	output duty cycle of pressor foot lifting	output duty cycle of pressor foot lifting	P25A P25B H5A	1~60(s) 1~60(s)	12 15	II
50	output time of total pressure of reverse-sewing	output time of total pressure of reverse-sewing	P25A P25B H5A	0~800ms 0~800ms	150 70	II
51	output duty cycle of reverse-sewing	output duty cycle of reverse-sewing	H5A P25A P25B	0~100	40	II
52	hold time of reverse-sewing	forced shut-down after hold time of reverse-sewing	H5A P25A P25B	1~60(s)	12	II
53	starting reinforcing-sewing speed	starting reinforcing-sewing speed	P25A P25B H5A	100~3000rpm 100~2000rpm	1800 1200 800	I
54	starting reinforcing-sewing compensation 1	parameter of starting reinforcing-sewing stitch compensation	H5A P25A P25B	0~100	30 50	I
55	starting reinforcing-sewing compensation 2	parameter of starting reinforcing-sewing stitch compensation	H5A P25A P25B	0~100	10 15	I
56	ending reinforcing-sewing speed	ending reinforcing-sewing speed	P25A P25B H5A	100~3000rpm 100~2000rpm	1800 1200 800	I
57	ending reinforcing-sewing compensation 1	parameter of ending reinforcing-sewing stitch compensation	H5A P25A P25B	0~100	30 50	I
58	ending reinforcing-sewing compensation 2	parameter of ending reinforcing-sewing stitch compensation	H5A P25A P25B	0~100	10 15	I
59	ending reinforcing-sewing speed	ending reinforcing-sewing speed	P25A P25B H5A	100~3000rpm 100~2000rpm	1800 1200 800	I
60	continuous reinforcing-sewing compensation1	parameter of continuous reinforcing-sewing stitch compensation	H5A P25A P25B	0~100	30 50	I
61	continuous reinforcing-sewing compensation2	parameter of continuous reinforcing-sewing stitch compensation	H5A P25A P25B	0~100	10 15	I
62	Pedal travel upon start	Pedal position upon start Travel relative to medium pedal	H5A P25A P25B	10~50(0.1°)	25	II
63	Pedal travel upon acceleration	Pedal position upon start acceleration Travel relative to medium pedal		10~100(0.1°)	50	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
65	Pedal travel upon presser foot lift	Pedal position upon pedal lift Travel relative to medium pedal		~100~10(0.1°)	-30	II
66	Pedal travel upon presser foot lowering	Pedal travel from presser foot lowering position to neutral position Travel relative to medium pedal		5~50(0.1°)	10	II
67	Pedal travel 1 upon thread trimming	Pedal position upon start trimming without presser foot function Travel relative to medium pedal		~100~10(0.1°)	-30	II
68	Pedal travel 2 upon tread trimming	Pedal position upon start thread trimming with presser foot function Travel relative to medium pedal		~100~10(0.1°)	-60	II
69	Down needle positioning position	To adjust down needle position		H5A P25A P25B	120~240	I
70	Reverse needle lift function	0: unavailable ; 1: available		H5A P25A P25B	0/1	I
71	Reversal of needle lift angle	Reversal of needle lift angle		H5A P25A P25B	0~45°	I
75	Needle position adjustment	Needle position adjustment	H5A P25A P25B	0~240°	0	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	H5A P25A P25B	0~15	0	I
80	highest speed of sewing	highest speed of sewing	P25A P25B H5A	300~5000spm 300~5000spm 300~2600spm	4000 3000 2400	II
83	Aggravating function	0: invalid; 1 l5 strength regulation	H5A P25A P25B	0~15	6	II
85	Suction angle of shear line	To set suction angle of shear line	H5A P25A P25B	150~200	175	II
86	Power angle of shear line	To set power angle of shear line	H5A P25A P25B	200~300	260	II
87	Release angle of shear line	To set release angle of shear line	H5A P25A P25B	300~360	340	II
92	Pedal presser foot lift confirm time	Pedal presser foot lift confirm time	H5A P25A P25B	10~300ms	80	II
93	The neutral position of the pedal	Trimming the neutral position of the pedal	H5A P25A P25B	~15~15(0.1)	0	II