

Bartacking Machine Parameters List

| Para | Function | Range | Value | Description/Note | Zone |
|------|---|------------|-------|--|------|
| U001 | Maximum sewing speed | 400 - 3200 | 3000 | Maximum speed adjustment | M1 |
| U002 | With needle thread clamp, sewing speed of 1 st stitch | 400 - 1500 | 400 | sewing speed adjustment , speed can be set in a unit of 100rpm | M1 |
| U003 | With needle thread clamp, sewing speed of 2 nd stitch | 400 - 3200 | 900 | Sewing speed adjustment , speed can be set in a unit of 100rpm | M1 |
| U004 | With needle thread clamp, sewing speed of 3 rd stitch | 400 - 3200 | 1500 | Sewing speed adjustment , speed can be set in a unit of 100rpm | M1 |
| U005 | With needle thread clamp, sewing speed of 4 th stitch | 400 - 3200 | 2500 | Sewing speed adjustment , speed can be set in a unit of 100rpm | M1 |
| U006 | With needle thread clamp, sewing speed of 5 th stitch | 400 - 3200 | 3000 | Sewing speed adjustment , speed can be set in a unit of 100rpm | M1 |
| U007 | Reserved IO | | | | M2 |
| U008 | Stitches of thread clamp | 1 - 7 | 1 | Number of stitches that needle thread clamp releases is set | M1 |
| U009 | Clamping timing of needle thread clamp can be delayed | - 10 ~ 0 | 0 | Timing is delayed in “-“ direction | M1 |
| U010 | Reserved IO | | | | M2 |
| U011 | Changeover timing of thread tension at the time of thread trimming | - 6 ~ 4 | 0 | Tension and trimming timing adjustment | M1 |
| U012 | Without needle thread clamp, sewing speed of 1 st stitch | 400 - 1500 | 400 | sewing speed adjustment , speed can be set in a unit of 100rpm | M1 |
| U013 | Without needle thread clamp, sewing speed of 2 ND stitch | 400 - 3200 | 900 | sewing speed adjustment , speed can be set in a unit of 100rpm | M1 |
| U014 | Without needle thread clamp, sewing speed of 3 RD stitch | 400 - 3200 | 1500 | sewing speed adjustment , speed can be set in a unit of 100rpm | M1 |
| U015 | Without needle thread clamp, sewing speed of 4 TH stitch | 400 - 3200 | 2500 | sewing speed adjustment , speed can be set in a unit of 100rpm | M1 |
| U016 | Without needle thread clamp, sewing speed of 5 TH stitch | 400 - 3200 | 3000 | sewing speed adjustment , speed can be set in a unit of 100rpm | M1 |
| U017 | Reserved IO | | | | M2 |
| U018 | Changeover timing of 1 st stitch (without needle thread clamp) | - 5 - 2 | - 5 | Active angle = 60 – 4 * U018 | M1 |

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| U019 | Setting whether or not indication or change of pattern No. X/Y scale rate and max. speed limitation is acceptable (Prevention of misapplication) | 0 | 0 | 0 : Operative; 1 : Inoperative Note : in case of setting 1, use of M key is prohibited as well. When changing memory switch. Pressing M key, turn on the power switch. | M1 |
| U020 | Counter operation | 0 / 1 | 0 | 0 : production counter(adding) , 1 : bobbin thread counter (subtracting) | M1 |
| U021 | Selection of pedal | 0 - 3 | 0 | 0 : standard pedal; 1 : standard pedal (2-step stroke); 2 : twinning pedal I 3 : twinning pedal II | M1 |
| U022 | Height of work clamp foot at the time pf 2 step stroke | 50 - 90 | 70 | Effect while parameter 021sets at 2 step stroke | M1 |
| U023 | Setting sewing start at change of pattern X/Y scale rate | 0 / 1 | 0 | 0 : origin ; 1 : sewing start point | M2 |
| U024 | Sewing machine operation can be stopped with panel key (Reset) | 0 / 1 / 2 | 1 | 0 : ineffective; 1 : panel reset key; 2 : external switch | M1 |
| U025 | The Buzzer sound can be prohibited | 0 / 1 / 2 | 2 | 0 : without buzzer sound; 1 : panel operation sound; 2 : panel operation sound and error sound | M1 |
| U026 | Needle thread clamp control can be prohibited (thread clamp switch can be set) | 0 / 1 | 0 | 0 : normal 1 : prohibited | M1 |
| U027 | Feed timing is selected when stitches are not well tightened, set the value in"-_ direction (only effect at exceed 1100rpm) | - 8 - 16 | 12 | Per unit 4 °, setting on excessive "-side may cause needle breaking. Be careful when sewing heavy weight material (only effect at exceed 1100rpm) | M1 |
| U028 | State of work clamp foot after completion of sewing can be selected | 0 / 1 | 0 | 0 : work clamp foot goes up after moving at sewing start 1 : work clamp foot goes up by pedal operation after moving at sewing start | M1 |
| U029 | Execution of origin retrieval every time after completion of sewing can be performed | 0 / 1 / 2 | 0 | 0 : without origin retrieval 1 : with origin retrieval 2 : can set times but must perform | M1 |

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| | | | | with U075 | |
| U030 | Setting of origin retrieval in cycle stitches can be set | 0 / 1 / 2 | 0 | 0 : without origin retrieval 1 : every time 1 pattern is completed 2 : every time 1 cycle is completed | M1 |
| U031 | State of work clamp foot when machine stopped by temporary stop command can be selected | 0 / 1 / 2 | 2 | 0 : work clamp foot goes up 1 : work clamp foot goes up with work clamp foot switch 2 : lift of work clamp foot is prohibited | M1 |
| U032 | Needle bar stop position is set | 0 / 1 | 0 | 0 : up position 1 : upper dead point | M1 |
| U033 | Thread trimming can be prohibited | 0 / 1 | 0 | 0 : normal 1 : thread trimming prohibited | M2 |
| U034 | Reserved IO | | | | M2 |
| U035 | Bobbin winding speed can be set | 800 - 2000 | 1600 | Max. speed limitation has priority, speed can be set in a unit of 100 pm | M1 |
| U036 | Reserved IO | | | | M2 |
| U037 | Reserved IO | | | | M2 |
| U038 | Reserved IO | | | | M2 |
| U039 | Reserved IO | | | | M2 |
| U040 | Reserved IO | | | | M2 |
| U041 | Angle of trimming | 120 – 350 | 180 | | M1 |
| U042 | Height of work clamp foot (only effect for stepping motor type) | 0 - 30 | 0 | " 0 " most height point of work clamp foot | M2 |
| U043 | + X limited range of moving (right side) | -99 - 99 | 20 | Limited by work foot size unit:mm | M2 |
| U044 | - X limited range of moving (right side) | -99 - 99 | -20 | Limited by work foot size unit:mm | M2 |
| U045 | + Y limited range of moving (right side) | -99 - 99 | 10 | Limited by work foot size unit:mm | M2 |
| U046 | - Y limited range of moving (right side) | -99 - 99 | -10 | Limited by work foot size unit:mm | M2 |
| U047 | X/Y Original offset adjustment | -99 - 99 | 0 | Unit:pulse | M2 |
| U048 | Warning of replenish lubricating oil | 0 - 99 | 0 | 1.Set value of limitation of stitches (unit: ten million) 2. Accumulated stitches at normal sewing | M2 |
| U049 | Location of presser foot movement at standard pedal | 50 - 200 | 100 | | M2 |
| U050 | Location of start sewing at standard pedal | 50 - 200 | 185 | | M2 |






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|------|---|------------|-------|---|------|
| U051 | Location2 of presser foot movement at standard pedal | 50 - 200 | 140 | | M2 |
| U052 | Speed of work foot drop down at pedal performed | 100 - 4000 | 2700 | Unit:pps | M2 |
| U053 | Speed of work foot rise up at pedal performed | 100 - 4000 | 2700 | Unit:pps | M2 |
| U054 | Speed of work foot rise up at trimming after sewing ending | 100 - 4000 | 2300 | Unit:pps | M2 |
| U055 | Work foot rise up can be set after sewing completed | 0 / 1 | 0 | 0 : work foot rise up after sewing completed 1 : work foot is not rise up after sewing completed and keep sewing | M2 |
| U056 | Trimming speed can be set (3/4 stepping motor) | 400 – 800 | 400 | Unit:RPM | M2 |
| U057 | Reserved IO | | | | M2 |
| U058 | emergency stop by pedal | 0 / 1 | 1 | 0 : ineffective ; 1 : effective | M2 |
| U059 | Reserved IO | | | | M2 |
| U060 | Reserved IO | | | | M2 |
| U061 | Reserved IO | | | | M2 |
| U062 | The wiper of the delay time in double trimming mode | 100 - 400 | 150 | Unit: ms | M2 |
| U063 | Trimming can be set | 0 / 1 | 0 | 0 : trimming performed 1 : prohibited (trimming is not performed at emergency stop), it is ineffective even U033 set at trimming performed | M2 |
| U064 | Origin can be set after sewing completed | 0 / 1 | 0 | 0 : sewing start point 1 : origin | M1 |
| U065 | Reserved IO | | | | M2 |
| U066 | How many seconds the tension solenoid is power on | 0 - 99 | 60 | Unit:second | M2 |
| U067 | X/Y feed speed (speed from origin to sewing start point) | 100 - 4000 | 2000 | Unit:pps | M2 |
| U068 | X/Y speed of feed forward / backward (one step execution & Reset) | 100 - 4000 | 500 | Unit:pps | M2 |

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|------|--|------------|-------|--|------|
| U069 | Power ON , READY key selected | 0 / 1 | 0 | 0 : power on and press READY key 1 : power ON and READY key performed | M2 |
| U070 | Select lock current of servo motor at UP position | 0 / 1 | 1 | 0 : locked 1 : unlocked | M2 |
| U071 | Reserved IO | | | | M2 |
| U072 | Safety switch | 0 / 1 | 0 | 0 : normally closes 1 : normally opens | M1 |
| U073 | Reserved IO | | | | M2 |
| U074 | Reserved IO | | | | M2 |
| U075 | Times of origin retrieval | 1 - 100 | 100 | Effective at parameter U029 sets " 2 " | M1 |
| U076 | Counter stop automatically , must do with U020、 U100 | 0 / 1 | 1 | 0 : effective 1 : ineffective | M1 |
| U077 | Reserved IO | | | | M2 |
| U078 | Trimmer start speed | 400 - 3000 | 500 | Unit:pps | M2 |
| U079 | Trimmer maximum speed | 900 - 3000 | 1800 | Unit:pps | M2 |
| U080 | Reserved IO | | | | M2 |
| U081 | Speed of 1 st stitch count from the end | 400 – 1600 | 800 | Unit:RPM | M2 |
| U082 | Speed of 2nd stitch count from the end | 400 – 3200 | 1600 | Unit:RPM | M2 |
| U083 | Speed of 3rd stitch count from the end | 400 – 3200 | 2400 | Unit:RPM | M2 |
| U084 | Speed of 4th stitch count from the end | 400 – 3200 | 3000 | Unit:RPM | M2 |
| U085 | Bartacking machine and button machine switch | 0 / 1 | 0 | 0:bartacking machine 1:button machine | M2 |
| U086 | Reserved IO | | | | M2 |
| U087 | Presser foot height compensation value | 0 - 20 | 10 | Only for button machine | M2 |
| U088 | Reserved IO | | | | M2 |

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|------|--------------------------|---------|-------|---|------|
| U089 | Reserved IO | | | | M2 |
| U090 | Reserved IO | | | | M2 |
| U091 | Reserved IO | | | | M2 |
| U092 | Reserved IO | | | | M2 |
| U093 | Reserved IO | | | | M2 |
| U094 | Reserved IO | | | | M2 |
| U095 | Reserved IO | | | | M2 |
| U096 | PUA of servo motor | 0 - 180 | 10 | Needle bar stop position adjustment | M2 |
| U097 | Version of software | | | press   key to find the version M:main board, P:operation panel, T:servo motor, A:Pattern | M2 |
| U098 | Restore factory settings | 0 / 1 | 0 | press   key to select "1" and then press  key can restore factory settings. | M2 |
| U099 | Self-diagnosis mode | | | | M2 |
| U100 | Sewing automatic mode | | | | M2 |