



WR58LJK Film Type Manual V1.0

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

No	Project	Content	Setting range	default value	Level
1	Sewing speed	Set sewing speed	200~3000rpm	2000	I
2	Soft-start function	0：No soft-start function 1~99：Soft start stitches	0~99	3	I
3	Ornamental bartacks	The function of perfect decorative stitching 0: invalid 1: valid	0/1	1	I
4	Fixed-length seam sewing speed	Set fixed-length seam sewing speed	200~3500rpm	2000	I
5	Sewing mode	0：Free sewing 1：Simple Sewing	0/1	0	I
9	Reverse limited feed speed	It can prevent the back seam from breaking the needle	500~1500rpm	700	I
12	knob speed adjustment function	0: invalid 1: valid	0/1	0	I
14	pressure foot soft down force adjustment	pressure foot soft down force adjustment	0~100	8	I
17	adjust the thread strength	adjust the thread strength	0~100	12	I
18	posterior fixation after the end of anterior fixation	0: invalid 1: valid	0/1	0	I
19	Function of stop after bartack at the start of sewing	0: invalid 1: valid	0/1	0	I
20	The manual switch function of the reverse feed stitching of sewing	0: backseam only 1: backseam plus filling needle 2: manual thread cutting function	0/1/2	0	I
21	Soft-start speed 1	Soft start first stitch speed	100~3000rpm	400	I
22	Soft-start speed 2	Soft start second stitch speed	100~3000rpm	600	I
23	Soft-start speed 3	Soft start the 3rd ~ 9th needle speed	100~3000rpm	600	I
24	Function of soft-down of presser foot	0: invalid 1: valid	0/1	0	I
25	Enable presser foot lift	Pressure foot enable to set 0: invalid 1: valid	0/1	1	I
27	Up –position function	0: invalid 1: valid	0/1	0	I
28	Safety switch signal mode	Head turned up the switch signal pattern set 0:1: normally open normally closed 2: protection is prohibited	0/1/2	0	I
29	The time of soft-down of pressure foot	The longer the time, the slower the foot drop	50~500ms	300	II
30	The bottom line magnification setting	0: invalid 5/10/15/20: baseline multiplier	0/5/10/15/20	0	I
31	Initial baseline setting	Baseline initial value setting	200~4000	1600	I
32	Ornamental bartacks pause time	Set the stop time of decorative stitching	0~500ms	50	I
33	adjust the stopping Angle of decorative stitching	Adjust the stopping Angle of decorative stitching	0~120	100	II
34	Standard bartacks,pedal speed source choice	0: automatic sewing speed 1: pedal speed	0/1	0	II
35	Piece-rate setting	0: no piecework function 1 ~ 20: piecework by multiple +1	0~20	0	I
36	Initial set piece count	Initial value setting of counting number	0~1000	100	I
38	piece selection Settings	0: piece plus 1: piece minus	0/1	0	I
41	Slow speed	Pedal minimum speed	100~400rpm	200	I
42	Pedal curve selection	0: normal 1: slow acceleration 2: fast acceleration	0/1/2	0	I
44	Cutting speed	Cutting speed	100~400rpm	260	I
45	Reverse limited feed speed enable	Prevent reverse stitch breakage 0: infinite speed 1: with speed limit	0/1	0	I
46	Delay Sewing time,when presser foot down	Delay in confirming that the foot has been lowered	0~800ms	50	II
47	Time of presser foot magnet full voltage output	Full pressure output time of lifting foot	0~800ms	150	II
48	Presser foot magnet voltage output duty cycle	Lift pin output duty cycle	0~100	30	II
49	Presser foot magnet lift holding time	After holding pressure foot for a long time, force off	1~60 (s)	12	II
50	Time of reverse feed stitching magnet full voltage output	Full pressure output time of reverse stitching	0~800ms	150	II
51	Reverse feed stitching magnet duty cycle	Backslit output duty ratio	0~100	60	II
52	Reverse feed stitching magnet holding time	Force off the back seam after holding time	1~60 (s)	25	II
53	Speed of bartack at the start of sewing	Front reinforcement joint speed	100~3000rpm	1200	I
54	Bartack at the start of sewing compensation 1	Front stitching stitch compensation parameters	0~100	25	I
55	Bartack at the start of sewing compensation2	Front stitching stitch compensation parameters	0~100	16	I
56	Speed of bartack at the end of sewing	After reinforcement joint speed	100~3000rpm	1200	I
57	Bartack at the end of sewing compensation 1	Stitch compensation parameters for back stitches	0~100	25	I
58	Bartack at the end of sewing compensation 2	Stitch compensation parameters for back stitches	0~100	16	I
59	Overlapped sewing speed	Continuous reinforcement joint speed	100~3000rpm	1200	I
60	Overlapped sewing speed compensation 1	Needle compensation parameters for continuous solid stitches	0~100	25	I
61	Overlapped sewing speed compensation 2	Needle compensation parameters for continuous solid stitches	0~100	16	I
62	Pedal travel upon start	The starting position of the pedal relative to the stroke when the pedal is centered	10~50	45	II
63	Pedal travel upon acceleration	The pedal position at which the acceleration begins, relative to the stroke when the pedal is in neutral	10~100	50	II
64	Pedal travel at highest rotation speed	Run to the highest speed pedal position relative to the middle pedal stroke	10~150	110	II
65	Pedal travel upon presser foot lift	The pedal position of the foot lift, relative to the stroke when the pedal is in the middle	-100~-10	-30	II
66	Pedal travel upon presser foot lowering	The pedal position of the foot release action, relative to the stroke when the pedal is in the middle	5~50	10	II
67	Pedal travel 1 upon thread trimming	When there is no foot lift function, the position of the pedal for cutting line is relative to the stroke when the pedal is in the middle	-100~-10	-30	II
68	Pedal travel 2 upon tread trimming	When the foot is raised, the position of the pedal for cutting the line is relative to the stroke when the pedal is in the middle	-100~-10	-60	II
69	Down needle positioning position	Lower stop needle position adjustment	0~240	80	I
70	Reverse needle lift function	0: invalid 1: valid	0/1	0	I
71	Reversal of needle lift angle	Reverse lift angle	0~90°	45	I
75	Needle position adjustment	Adjust needle position	0~240°	232	I
76	Stop needle position minor adjustment	Stop the needle and fine tune	90~110	100	I
77	Needle bar maximum angle	Upper dead center Angle	270~360	360	I
78	Key switch function selection	0: fixed seam turnover 1: filling needle	0/1	1	I
79	return to factory-set parameter	Special function parameters (keep 2 s effective automatic to 0) 5: restore factory parameters	0~15	0	I
80	highest speed of sewing	Maximum sewing speed	200~3000spm	2200	II
82	Set period of use	0: invalid; 1 ~ 1000 time adjustment	0~1000	0	II
83	Aggravating function/ Machine needle emphasis function	0: invalid; 1 ~ 15 strength adjustment	0~15	0	II
84	Reduce noise	0 ~ 15 noise reduction adjustment	0~15	0	II
85	Cutting magnet pull angle	Scissor suction Angle setting	150~200	60	II
86	Power angle of shear line	Shear force Angle setting	200~300	260	II
87	Cutting magnet release angle	Shear release Angle setting	300~360	340	II
88	Loose magnet pull angle	Loose line suction Angle	200~360	300	II
89	Up dead position angle	Loosen the line release Angle	270~360	320	II
90	Line slack holding time	Loose thread hold time	1~60	11	II
91	Encoder wire number setting	0:600 line; 1:18 0 line	0/1	1	II
92	Pedal presser foot lift confirm time	Step on the back of the pedal to confirm the time when the foot lift command is effective	10~300ms	80	II
93	Dial line / clip line Type selection	Pedal neutral position fine tuning	-15~15(0.1)	0	II
95	Anti - nest function selection	0: clamping wire type 1: anti-bird's nest type	0/1	0	II
101	System acceleration adjustment	The brake speed	0~100	1	II
102	System virtual speed limit	System virtual Settings	0~100	100	II
126	Seam raising enables loose thread	0: off 1: on	0/1	1	II
127	Delay before seam opening and thread loosening	Delay before seam opening and thread loosening	0~2000ms	50	II
128	Time of thread opening and loosening	Time of thread opening and loosening	0~2000ms	100	II
132	Speaker function	Voice selection: 0-no voice, 1-chinese, 2-english, 3-indian, 4-vietnamese, 5-bengali, 6-czech, 7-portuguese, 8-spanish.	0~8	1	II
140	Prevent bird's nest before line delay	Prevent bird's nest before line delay	0~2000ms	50	II
141	Anti - bird's nest tick action time	Anti - bird's nest tick action time	0~2000ms	50	II
142	Anti - bird's nest wire delay	Anti - bird's nest wire delay	0~2000ms	50	II
143	Anti - bird's nest plot ratio	Anti - bird's nest plot ratio	0~2000ms	100	II
144	Anti - nest inhalation action time	Anti - nest inhalation action time	0~2000ms	250	II
145	Anti - nest straight line action time	Anti - nest straight line action time	0~2000ms	50	II
146	Time delay of starting and cutting head	Time delay of starting and cutting head	0~2000ms	900	II
147	operation time of starting and tangential head	Operation time of starting and tangential head	0~2000ms	500	II









If the above parameters are inconsistent with the actual parameters, the actual parameters shall prevail

3 . System Info

Operation panel default mode, press the “P” button and at the same time press the “Rabbit” key enter the system monitoring state through the +-key choose need to look at the project, according to the S button to enter/exit the selected projects such as the need to exit monitoring interface, according to P keys can be.

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	/

4 、Operation box use

Function	Button	Described
motor Angle adjustment		1, motor Angle benchmark (normal sewing mode, long press the T key directly into P75 benchmark tuning parameters of the motor Angle) 2, solid joint parameters shortcuts (this condition is only in the P53 ~ P75 parameters switching) 3, trial teaching function, the function effectively in the long slot mode, can be manually set pin number and foot set pin number)
one piece seam		Needle gap setting 1 set, can be set E period of sewing needle number. 2. When the last stitching is finished, the stitching will be automatically terminated (if selected), such as thread cutting or thread pulling.
four pieces seam		Needle gap setting 1, can be set E, F, G, H period of set of sewing needle number 2, each sewing process, lift the pedal, sewing to immediately stop, continue to step on the pedal, began to perform paragraphs set unfinished pin number. 3. When the last stitching is finished, the stitching will be automatically terminated (if selected), such as thread cutting or thread pulling
several pieces seam		Section of the needle sewing setting 1, can be set of P1 ~ PF a total of 15 pin number 2, each sewing process, lift the pedal, sewing to immediately stop, continue to step on the pedal, began to perform paragraphs set unfinished pin number. 3. When the last stitching is finished, the stitching will be automatically terminated (if selected), such as thread cutting or thread pulling
continuous reinforcing-sewing		1. Press treadle ahead for automatic sewing, to and fro, which is set at D and can reach 15times.(F) 2. Continuous reinforcing-sewing is in trigger mode by default, treadle doesn’ t need to be kept being pressed, and corresponding trigger light of preset sewing is solid lit. 3. Previous ending reinforcing-sewing setting is invalid if this function is valid.
parameter setting		1.For preset sewing. Trigger treadle and the system will automatically conduct sewing at E, F, G, H (P1~PF) sections; the treadle doesn’ t need to be kept being pressed.2. Solid light for continuous reinforcing-sewing mode means that it is trigger mode by default.
Starting reinforcing-sewing		Execute starting reinforcing-sewing 4 times, to and fro.
ending reinforcing-sewing		Execute starting reinforcing-sewing 4 times, to and fro.
press foot mode selection		Set or cancel the function of middle presser foot, after shearing presser foot, middle and after shearing presser foot
thread-cutting		Set or cancel thread-cutting function.
Soft start		set or cancel the pedal soft start function.
Needle position		Set the needle position shortcut keys , Key is effective for needle , The cancel key function is set to stop pin
add-subtract key		Corresponding to the number of stitches plus or minus, parameters up and down adjustment and plus or minus
speed key		Speed down. Keeping pressing to lower speed, the display will automatically switch to speed set. Simple seam, free seam effective.
		Speed up. Keeping pressing to increase speed, the display will automatically switch to speed set.Simple seam, free seam effective.
speaking key		1.Long press the "voice on" button in any state will turn off or turn on the voice function, and voice prompt the selected mode "voice on" and "voice off". 2. In the mode of free sewing, press the voice button to turn on or off the startup language, and the voice prompts "startup language on" and "startup language off"; Shortcuts which troubleshooting tips not to close (parameters, turn off the long by3 s, open the long by 3 s) 3, voice navigation (light into the parameter mode, press this key to broadcast parameters content) 4, fault error repair (an error condition, gently press this key to broadcast to check content)
Restore factory Settings		Under the standby interface, long press the 1.5-second Reset button to restore the factory Settings
parameter setting		Under the sewing setting interface, press the P key to enter the [parameter interface], and then parameters with level I in the parameter list will be displayed. Under the sewing setting interface, long press P to enter the "password input interface". After entering the correct maintenance password, press P to enter the "parameters interface". At this time, parameters of level I and II in the parameter list will be displayed. Password: 7141/1111
Pinnumberset/check choice		1.Implementation of this key, circulating switch display 3 pin number to set the display value upper end:A, B, C, Period of pin number, Light corresponding level; Middle end :E, Period of pin number, Light corresponding level; lower extreme :G, Period of pin number, Light corresponding level; 2. Corresponding to the number of stitches in segment A and D, the range can be set to 0 ~ 15 stitches, and the number of stitches in segment B and C, the range can be set to 1 ~ 15 stitches. Corresponding to the number of stitches in E, F, G and H segments, the range can be set to 0 ~ 99 stitches. 3. For models with clamping function, long press this button to display the clamping force adjustment (the upper, middle and lower three indicator lights are on at the same time, the LCD shows "[7]"), and press this button again to exit

5、Piece and bottom line detection mode:

Under normal sewing mode, press "P+ trigger" to enter "JJ" piecework mode. The value displayed on the interface is the current number of pieces. Press the add or subtract key to modify the value. Press the "P" key to return to sewing mode. Note: 1. Reset the number of counting pieces, which is effective in the monitoring mode, and press the fastening button for 3 seconds. 2, piece function effectively need open P35 parameters: 3, piece need to decreasing functions need to change the number P38 lightning parameters, piece error: PBOB into normal sewing mode, according to the "P + trigger button," into the "DX" bottom line detection mode. The value displayed in the interface is the current baseline length. Note: 1. Reset the number of bottom line, which is effective in the monitoring mode. 3. Bottom line error: LBOB

6、Teaching mode:

Long press the "T" button for 1 second in the mode of fixed-length sewing (section and program sewing) to enter the teaching interface. The available keys in this interface are: T key, two groups of plus and minus keys, and needle filling key. The function is as follows: add or subtract key 12: change the number of teaching segment, the segment value can only be accumulated upward (enter the next teaching segment to automatically save the last needle value), the "-/" key is invalid. Note: when the pedal is pressed to run, the button is invalid; Add or subtract button 34: modify the number of teaching needles, the number of needles can be adjusted when stop running. Stitch repair: manual stitch repair can be made after pressing the button, and the number of stitches can be changed. T key: display the teaching interface to complete the teaching of the preceding number (the segment value overlays the setting of each segment in the original mode). Step on the pedal to cut the thread, and the needle value will be directly returned to the previous fixed-length sewing mode.

7. Error codes

Error Code	Contents	Possible reasons	Checking and treatment
B011 B012 B013 B014	Motor signal error	Motor position sensor signal failure	1.If electric engine plug is well contacted; 2.if electric engine signal detecting device has been broken; 3.if sewing machine handwheel correctly installed.
B021 B022 B023	Motor overload	motor stall motor overload	1.If electric engine plug is well contacted; 2.if machine head or thread-cutting mechanism has been blocked completely; 3.if materials are too thick; 4.Electrical signal detection signal whether the normal.
E101	Hardware drivers fault	Current detection abnormal Driving hardware error	1.Current detection loop system is working properly;2.Whether the damage to the device driver.
E111 E112	Voltage too high	High input voltage Brake circuit fault Voltage detection error	1.System into line voltage is too high; 2.Braking resistance are working properly; 3.System voltage detection circuit are working properly.
E121 E122	Voltage too low	Actual low voltage Voltage detection is wrong	1.If the voltage on the inlet wire is too low 2.Whether the system voltage detection circuit the normal work.
E131	Current circuit fault	Current detection abnormal	Current detection loop system is working properly.
E133	Oz circuit fault	Oz circuit fault	Oz circuit system is working properly.
E151	Magnet circuit error	Over current magnet circuit	1.If machine head magnet suffers short circuit 2. Electromagnet circuit is working properly.
E201	over current	Current detection error	Current detection loop system is working properly Electrical signal is normal.
E211 E212	Abnormal motor operation	Current or voltage detection error	1.If electric engine plug is well contacted; 2.If electric engine signal is matched.
E301	Communication error	Sci circuit error	1.if operation box plug is well contacted; 2.if operation box components are damaged.
E302	Operation inner failure	Sci circuit error	To check whether the operating box is damaged. .
E402	Pedal ID fault	Pedal verification fault	Pedal connection is loosen.
E403	Pedal zero position fault	The pedal zero position over range	The pedal is damaged or it is not under stop state when correction.
E501	Safety switch fault	Safety switch effective	Put down the head or check turned up switch.
P.oFF	Power off Display	Power off	Wait for power supply to resume.

Note:

- Sewing abnormal action (speed electromagnet work abnormal) : in the control interface view model is correct;
- Turn up E501 fault when: sure it is normal to switch detection, temporary use can change the P-28 parameters;
- If the above according to check the project cannot rule out fault, please seek technical support.