

Table of Program Mode Function

**Caution**  
 Operation validity  
 O mark: The sewing machine can be operated in the function setting state.  
 X mark: The sewing machine cannot be operated in the function setting state.  
 Operate the sewing machine after returning to the normal mode.

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
P mode  	Maximum speed	<b>H.</b>	0000	O	4000	rpm	0 ~ 8999	<b>H.</b>	****	****	The maximum speed can be set.	
	Low speed	<b>L.</b>	0001	O	250	rpm	0 ~ 499	<b>L.</b>	***	***	The low speed can be set.	
	Thread trimming speed	<b>T.</b>	0002	O	200	rpm	0 ~ 499	<b>T.</b>	***	***	The thread trimming speed to reach the needle UP position stop from the needle DOWN position during full heeling or when thread trimmer signal (S2) is turned ON can be set.	
	Start tacking speed	<b>N.</b>	0003	O	1700	rpm	0 ~ 2999	<b>n.</b>	****	****	The speed of start tacking can be set.	
	End tacking speed	<b>V.</b>	0004	O	1700	rpm	0 ~ 2999	<b>v.</b>	****	****	The speed of end tacking can be set.	
	Medium speed	<b>M.</b>	0005	O	1700	rpm	0 ~ 8999	<b>m.</b>	****	****	The medium speed can be set.	
	Slow start speed	<b>S.</b>	0006	O	250	rpm	0 ~ 2999	<b>s.</b>	****	****	The slow start speed can be set.	
	No. of slow start stitches	<b>SLN.</b>	0007	O	2	stitches	1 ~ 5	<b>SLn.</b>	*	*	The No. of slow start stitches can be set. This is valid when the [B, SL] key is ON in the normal mode.	
	Slow start operation mode	<b>SLM.</b>	0008	O	T	-	-	<b>SLn.</b>				The slow start operation mode is selected. This is valid when the [B, SL] key is ON in the normal mode.
									<b>f</b>	T	Slow start operation will begin when the power is turned ON or when the first toe down after thread trimming, or the first external run signal (S0, S1) is turned ON.	
									<b>R</b>	A	Slow start operation will begin when the pedal is toed down or when the external run signal (S0, S1) is turned ON.	
	Slow start when power is turned ON	<b>SLP.</b>	0009	O	OF	-	-	<b>SLP.</b>	<b>OF</b>	ON OF	Slow start operation will begin when the pedal is toed down for the first time after turning the power ON, or when the first external run signal (S0, S1) is turned ON even if the [B, SL] key is turned OFF in the normal mode.	
One shot	<b>SH.</b>	0010	O	OF	-	-	<b>SH.</b>	<b>OF</b>	ON OF	The one shot function can be selected. One shot operation (automatic operation) will begin when the external run signals (S0, S1, S4) is turned ON.		
One shot operation mode	<b>SHM.</b>	0011	O	SH	-	-	<b>SHn.</b>				The one shot SH operation mode is selected. This is valid when one shot SH is [ON].	
								<b>SH</b>	SH	When one of the external run signals (S0, S1, S4) is turned ON the sewing machine will rotate at the commanded speed while ON, and will continue operating even when the signal is turned OFF. However, the speed will be that commanded with the speed setting key ([C, <==], [D, ==>] key) while OFF. Stops with PSD, PSU, ES or SEN signal.		
								<b>SS</b>	SS	When one of the external run signals (S0, S1, S4) is turned ON, the sewing machine will rotate at the speed commanded with each signal even if the signal is turned OFF.		
								<b>SA</b>	SA	The same operation as when [SS] is set is included. When one of the external run signals (S0, S1, S4) is turned (1)OFF=>ON=> (2)OFF=>ON, the sewing machine will stop at (1) and will restart at (2). (Alternate operation).		

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