

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	H.	0000	O	4000	rpm	0 ~ 8999	H.	****	****	The maximum speed can be set.	
	Low speed	L.	0001	O	250	rpm	0 ~ 499	L.	***	***	The low speed can be set.	
	Thread trimming speed	T.	0002	O	200	rpm	0 ~ 499	T.	***	***	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	N.	0003	O	1700	rpm	0 ~ 2999	n.	****	****	The speed of start tacking can be set.	
	End tacking speed	V.	0004	O	1700	rpm	0 ~ 2999	v.	****	****	The speed of end tacking can be set.	
	Medium speed	M.	0005	O	1700	rpm	0 ~ 8999	m.	****	****	The medium speed can be set.	
	Slow start speed	S.	0006	O	250	rpm	0 ~ 2999	s.	****	****	The slow start speed can be set.	
	No. of slow start stitches	SLN.	0007	O	2	stitches	1 ~ 5	SLn.	*	*	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	SLM.	0008	O	T	-	-	SLn.				The slow start operation mode is selected. This is valid when the [B, SL] key is ON in the normal mode.
									f	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.	
									R	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	SLP.	0009	O	OF	-	-	SLP.	OF	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	SH.	0010	O	OF	-	-	SH.	OF	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	SHM.	0011	O	SH	-	-	SHn.				The one shot SH operation mode is selected. This is valid when one shot SH is [ON].	
								SH	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.		
								SS	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.		
								SA	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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Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
P mode  	CONTINUED FROM PREVIOUS PAGE One shot operation mode										
	SHM.	0011	O	SH	-	-	<i>SHM.</i>	<i>RV</i>	RV	If the automatic operation function is OFF and the one shot signal (SH) is turned ON, the sewing machine will run at the low speed. If the lever connector variable speed command [VC] is input in this state, the sewing machine speed will be approximately in proportion with the voltage. The sewing machine will continue to run at the speed proportional to the variable speed command [VC] even if the one shot signal (SH) is turned OFF in the normal mode. If the automatic operation function is ON and the one shot signal (SH) is turned on, the sewing machine will run at the speed set with the speed setting key ([C], [D] key). The sewing machine will continue to run at the set speed even if the one shot signal (SH) is turned OFF.	
								<i>RH</i>	RH	The sewing machine will run at the maximum speed [H] when the one shot signal (SH) is turned ON. The sewing machine will continue to run at that speed even if the signal is turned OFF.	
								<i>RM</i>	RM	The sewing machine will run at the medium speed [M] when the one shot signal (SH) is turned ON. The sewing machine will continue to run at that speed even if the signal is turned OFF.	
								<i>RL</i>	RL	The sewing machine will run at the low speed [L] when the one shot signal (SH) is turned ON. The sewing machine will continue to run at that speed even if the signal is turned OFF.	
								<i>AV</i>	AV	When the one shot signal (SH) is turned OFF=> (1)ON=>OFF=> (2)ON=>OFF => (3)ON =>OFF, the same operation as the sewing machine speed is set to [RV] above is executed at (1). The sewing machine will stop at (2) and will run at the same conditions as [RV] at (3).(This operation is referred to as alternate operation hereafter.)	
								<i>AH</i>	AH	The alternate operation of [RH] is executed.	
								<i>AM</i>	AM	The alternate operation of [RM] is executed.	
								<i>AL</i>	AL	The alternate operation of [RL] is executed.	
		No. of stitches after PSU input	PSU.	0012	O	0	stitches	0 ~ 99	<i>PSU.</i>	**	**
	No. of stitches after PSD input	PSD.	0013	O	0	stitches	0 ~ 99	<i>PSD.</i>	**	**	After the DOWN position priority stop signal PSD is input, the no. of stitches until stopping can be set.
	Sensor input signal PS1 operation mode	PS1.	0014	O	T	-	-	<i>PS1.</i>			The operation of the sensor input signal PS1 can be set.
								<i>U</i>	U	U	The needle will stop at the UP position. The thread trimming operation is not done. However, after stopping, the thread trimming operation is done when the pedal is heeling or when the thread trimming signal (S2) is turned ON.
								<i>D</i>	D	D	After thread trimming, the needle will stop at the DOWN position. This setting is the same operation as the DOWN position priority stop signal PSD.
								<i>T</i>	T	T	After thread trimming, the needle will stop at the UP position. This setting is the same operation as the UP position priority stop signal PSU.
	No. of stitches after PS1 input	1.	0015	O	0	stitches	0 ~ 9999	<i>1.</i>	****	****	After the sensor input signal PS1 is input, the no. of stitches until stopping can be set.

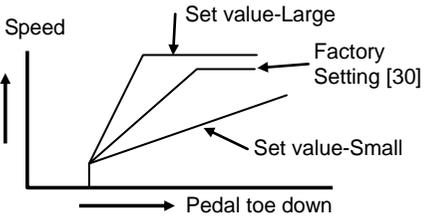
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
P mode  	Sensor input signal PS2 operation mode	PS2.	0016	O	D	-	-	<i>PS2.</i>			The operation of the sensor input signal PS2 can be set.
								<i>U</i>	U	The needle will stop at the UP position. The thread trimming operation is not done. However, after stopping, the thread trimming operation is done when the pedal is heeling or when the thread trimming signal (S2) is turned ON.	
								<i>d</i>	D	After thread trimming, the needle will stop at the DOWN position. This setting is the same operation as the DOWN position priority stop signal PSD.	
								<i>f</i>	T	After thread trimming, the needle will stop at the UP position. This setting is the same operation as the UP position priority stop signal PSU.	
	No. of stitches after PS2 input	2.	0017	O	0	stitches	0 ~ 9999	<i>2.</i>	****	****	After the sensor input signal PS2 is input, the no. of stitches until stopping can be set.
	Restart after PSD,SEN input PSN	PSN.	0018	O	OF	-	-	<i>PSn.</i>	<i>ON</i> <i>OF</i>	ON OF	After detecting the end of the fabric by a sensor with the PSU, PSD and SEN signals and stopping, restarting is possible with the pedal toe down or external run signal (S0, S1) even if the sensor does not detect the fabric (even if PSU, PSD signals are ON).
	Input sensor function valid / invalid	SEN.	0019	O	OF	-	-	<i>SEn.</i>	<i>ON</i> <i>OF</i>	ON OF	Sensor input function "SEN" is valid. [SEN] have to be set on C mode. (as same as the sensor key on control panel)
	Setting stitch amount to stop by "SEN"	SE.	0020	O	0	stitches	0 ~ 99	<i>SE.</i>	**	**	The number of stitch to stop, after the input function "SEN" ON. ("SEN" have to be set "ON")
	Presser foot lift momentary	FUM.	0021	O	OF	-	-	<i>FUN.</i>	<i>ON</i> <i>OF</i>	ON OF	This is the momentary function of the presser foot lifting.
	FUM operation mode	FU.	0022	O	M	-	-	<i>FU.</i>			The operation mode of the presser foot lift momentary mode is selected. This is valid when the presser foot lift momentary FUM is set to [ON].
									<i>n</i>	M	After thread trimming with full heeling or the external thread trimmer signal S2, the presser foot lifting operation is continued.
									<i>C</i>	C	After thread trimming with full heeling or the external thread trimmer signal S2, the presser foot lifting operation is continued while the timer is on, and then the presser foot will lower. The timer time is set with the timer setting FCT.
								<i>A</i>	A	The presser foot lifting operation is activated with full heeling, light heeling, or the external control signal (S2, F) ON. Then, when the full heeling, light heeling or external control signal (S2, F) is turned ON, the presser foot will bring down, and when turned ON again, the presser foot will lift. (Alternate operation.)	
								<i>f</i>	T	The timer operates in the same manner as the [C] setting. However, after the presser foot bring down, the same alternate operation as the [A] setting will occur.	
Time setting for FUM operation mode (FU is set to [C], [T])	FCT.	0023	O	12	sec	1 ~ 99	<i>FCT.</i>	**	**	The timer time for the presser foot output to turn ON and then turn OFF when the mode P FUM operation mode FU is set to [C], [T] can be set.	
Time to motor drive after presser foot lifter bring down	FD.	0024	O	176	msec	0 ~ 998	<i>Fd.</i>	***	***	The time for the motor to start driving after the presser foot output FU is turned OFF when pedal toe down or external run signal (S0, S1) ON during presser foot lifting can be set in 2 millisecond units.	

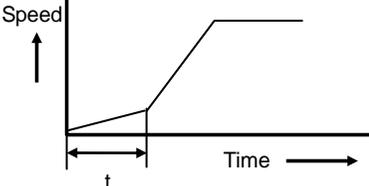
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
P mode  + 	Full wave time of presser foot lifter output	FO.	0025	O	50	X10 msec	-	<i>Fo.</i>			The full wave time of the presser foot lifter output during [FU] operation can be set.
									20	20	Full wave time 200mS
									25	25	Full wave time 250mS
									30	30	Full wave time 300mS
									40	40	Full wave time 400mS
									50	50	Full wave time 500mS
									60	60	Full wave time 600mS
									80	80	Full wave time 800mS
									100	100	Full wave time 1 sec.
		Delay time of presser foot signal S3 input	S3D.	0026	O	10	X10 msec	1 ~ 99	<i>S3d.</i>	**	**
	Presser foot lifting output chopping duty	FUD.	0027	O	MF	-	-	<i>FUD.</i>			The chopping output duty during holding after the presser foot lifting output FU presser foot lifting operation can be set.
									MS	4ms ON/OFF, 50% duty	
									MF	2ms ON/OFF, 50% duty	
									HI	4ms ON, 2ms OFF, 66% duty	
									26	2ms ON, 6ms OFF, 25% duty	
									62	6ms ON, 2ms OFF, 75% duty	
									84	8ms ON, 4ms OFF, 66% duty	
									FL	100% (full wave)	
									LO	2ms ON, 4ms OFF, 33% duty	
	Presser foot lifting output when power is turned ON	PFU.	0028	O	ON	-	-	<i>PFU.</i>	<i>ON</i> <i>OF</i>	ON OF	The presser foot lifting operation begins when power is turned ON. This is valid when the FUM function is set to [ON]. When FU is set to [C] or [T], the presser foot will lift only while the timer is ON.
	Cancel the presser foot lifting with full heeling	FL.	0029	O	OF	-	-	<i>FL.</i>	<i>ON</i> <i>OF</i>	ON OF	The presser foot lifting operation after thread trimming with full heeling or the external thread trimmer signal S2 is prohibited. However, the presser foot lifting is carried out with the presser foot lifting signal F or light heeling.
	Cancel presser foot lifting with light heeling	S3L.	0030	O	OF	-	-	<i>S3L.</i>	<i>ON</i> <i>OF</i>	ON OF	The presser foot lifting operation with light heeling is prohibited. The presser foot operation is carried out with full heeling or the presser foot lifting signal F.
	Cancel of thread trimming operation	S2L.	0031	O	OF	-	-	<i>S2L.</i>	<i>ON</i> <i>OF</i>	ON OF	The thread trimming operation and subsequent presser foot lifting operation with full heeling or external thread trimmer signal S2 is prohibited.

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
P mode ↓ + ↑	Thread trimming protection signal (S6) logical changeover	S6L.	0032	X	LO	-	-	S6L.			The operation can be changed when the thread trimming protection signal (S6) is turned Short/Open.
								H.	HI		The sewing machine will stop when the input signal (S6) is Open.
								Lo	LO		The sewing machine will stop when the input signal (S6) is Short.
	Automatic operation	AT.	0033	O	OF	-	-	AT.	ON OF	ON OF	Automatic operation (standing operation) can be set.
	Thread trimmer cancel	TL.	0034	O	OF	-	-	TL.	ON OF	ON OF	The thread trimming operation with full heeling of the pedal or with the thread trimming signal S2 is not performed, and instead needle UP position stop will occur.
	Auto-stop of preset stitch sewing before trim	TLS.	0035	O	OF	-	-	TL5.	ON OF	ON OF	Auto-stop of preset stitch sewing before thread trimming. And then it is free sewing till thread trimming.
	Reverse run needle lifting after thread trimming	RU.	0036	O	OF	-	-	RU.	ON OF	ON OF	The motor is reverse run after thread trimming, and the needle will stop near the needle bar top dead point.
	RU reverse run angle	R8.	0037	O	30	degree	0 ~ 500	r8.	***	***	The reverse run angle from the UP position after thread trimming can be set for when the reverse run needle lifting after thread trimming RU is set to ON. The setting angle is in two degrees intervals.
	Thread trimming with reverse feed	TB.	0038	O	OF	-	-	Tb.	ON OF	ON OF	The thread is trimmed with reverse feed by driving the backstitch solenoid simultaneously with the thread trimmer solenoid.
	Not used	TBJ.	0039	O	OF	-	-	TbJ.			Not used.
	Full heeling, S2 signal operation mode	S2R.	0040	O	ON	-	-	S2r.			The operation mode of full heeling or external thread trimmer signal S2 is selected. This is valid when cancel of thread trimming operation S2L is set to [OF].
									ON	ON	With full heeling or the external thread trimmer signal S2 after the needle UP position stop, the motor will rotate once to trim the thread. Then the presser foot will lift. When stopped at the needle DOWN position, the motor will make a half-rotation and then the presser foot will lift.
									OF	OF	The needle will remain at the UP position even when full heeling or external thread trimmer signal S2 is turned ON after stopping at the UP position. Only the presser foot lifting operation will operate after this. When full heeling or external thread trimming signal S2 is input after the needle DOWN position stop, motor will make a half-rotation and trim the thread. Only the presser foot lifting operation will operate after this.
Cancel of interlock after full pedal heeling	IL.	0041	O	OF	-	-	IL.			This releases the restart operation prohibit command during thread trimming. [ON]:Restart is possible for a designated time after the pedal toe down or external operation signal (S0, S1) is turned ON immediately after full pedal heeling. This is used with a sewing machine that does not have thread trimming. [OF]:Restart is not possible. Restart is possible if the pedal toe down or external run signal (S0, S1) is turned ON again after a set time is passed.	
								ON	ON		
								OF	OF		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
P mode ↓ + ↑	Thread trimming mode	TR.	0042	O	M1	-	-	rr.			The thread trimming timing for each manufacturer's thread trimming sewing machine can be set. Mitsubishi, Toyota, Seiko, Yakumo, Brother (excluding those noted below)
	<div style="border: 1px solid black; padding: 10px;"> <p style="text-align: center;">Caution</p> <p>When setting for the B1 (Brother) or T2 (Toyota) machines, refer to the following thread trimming timing. Follow the sewing machine adjustment procedures, and adjust the setting.</p> <p style="font-size: small;">Adjust the thread trimming position TM signal's ON starting angle S8, and ON angle E8. (The factory setting is 50 for S8, and 90 for E8.)</p> </div>										
	Thread trimming validity at neutral pedal	POS.	0043	O	OF	-	-	Pos.	ON OF	ON OF	The needle will stop in the UP position after thread trimming, during neutral after pedal toe down or when external run signal (S0, S1) is turned OFF.
									M1		
									PRG		For free setting of the thread trimming.
									NO		Not thread trimming sewing machine
									KA1~ KA8		Not used
									KB1~ KB4		Not used
									B1		Brother, Models: 705, 715, 716
									D1		(DURKOPP ADLER, Model 270)
									J1		JUKI (Lock stitch type)
									J2		JUKI(MH 471/474type) Note: Please check machine rotation direction!
									N1		Not used
									P1		Puff, Models: 463, 900
									P2		Not used
									P3		Not used
									P4		Not used
									T1		Toyota, Model: AD158
									T2		Toyota, Model: AD3110
									K		Chain stitch sewing machine Note: Please check machine rotation direction!
									KA9		Not used
									KB5		Not used
									KB6		Not used
									KAA		Not used
									KAB		Not used
									KAC		Not used
									RK		The thread is trimmed by reverse running the motor at the set angle from the DOWN position with full heeling or the thread trimmer signal S2. The set angle can be adjusted with the reverse run angle K8 from the DOWN position to the UP position. This can be used for blind stitch sewing machine.

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
P mode ↓ + ↑	Operation when power is turned ON during 1 position setting.	P1P.	0044	○	OF	-	-	<i>P 1P.</i>	<i>00</i> <i>0F</i>	ON OF	When 1 position is set with the [A, 1-2] key in the normal mode, the needle will lift to the UP position if not in the UP position when the power is turned ON.
	Operation when power is turned ON during 2 position setting.	P2P.	0045	○	OF	-	-	<i>P 2P.</i>	<i>00</i> <i>0F</i>	ON OF	When 2 position is set with the [A, 1-2] key in the normal mode, the needle will lift to the UP position if not in the UP position when the power is turned ON.
	Needle stop position before fabric	C8.	0046	○	60	degree	0 ~ 360	<i>C8.</i>	***	***	The needle stop position angle can be set just above the fabric looking from the UP position when the input signal is set the [BC] or [BCR]. (The setting angle is in 2 degrees intervals.)
	Reverse run angle from DOWN position to UP position	K8.	0047	○	180	degree	0 ~ 360	<i>t8.</i>	***	***	The reverse run angle from the DOWN position to the UP position can be set when the S0 operation mode [USR] or reverse thread trimming mode operation mode TR[RK] is set in mode P.
	ON angle of virtual TM	E8.	0048	○	90	degree	0 ~ 360	<i>E8.</i>	***	***	The width of virtual signal "TM". N79 :When [TR] = [B1] or [T2], it is possible to use this function.
	ON start angle of virtual TM	S8.	0049	○	50	degree	0 ~ 360	<i>S8.</i>	***	***	The start angle of virtual signal "TM". :When [TR] = [B1] or [T2], it is possible to use this function.
	Setting sensor "SEN" input function	SNM.	0050	○	ON	-	-	<i>S n n.</i>	<i>00</i> <i>0F</i>	ON OF	[ON]:Input "SEN" is always valid. [OF]:Input "SEN" is only valid, when setting pattern is free sewing
	Virtual down Setting	KD.	0051	○	OF	-	-	<i>t d.</i>	<i>00</i> <i>0F</i>	ON OF	Sewing machine run without down signal. The angle between up and down position is set to "K8". The width is set at 60 degree automatically.
	Virtual width of up and down signal	KDU.	0052	○	OF	-	-	<i>t d u.</i>	<i>00</i> <i>0F</i>	ON OF	It set the up and down signal width to 60 degree automatically.
	Not used	PSJ.	0053	○	OF	-	-	<i>P S J.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.
	Needle DOWN position stop angle	D8.	0054	○	28	degree	10 ~ 180	<i>d8.</i>	***	***	The coasting angle at the needle DOWN position stop can be set. (The setting angle is in 2 degrees intervals.)
Needle UP position stop angle	U8.	0055	○	14	degree	10 ~ 180	<i>u8.</i>	***	***	The coasting angle at the needle UP position stop can be set. (The setting angle is in 2 degrees intervals.)	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
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A mode 	Gain high/low selection	GA.	0100	O	L	-	-	GA.			The high/low gain can be set. Set with the following
								H	H		Sewing machine with large inertia.
								L	L		Sewing machine with small inertia.
								LL	LL		This is used when there is a slight vibration when stopping even when the gain is set to [L].
	Pedal curve	PDC.	0101	O	30	-	10 ~ 99	PdC.	**	**	<p>The size of the curve of the speed changes for the pedal toe down amount can be set. The speed change curve will change from small to large according to the small => large of the set value.</p> 
	Acceleration time simple setting	AC.	0102	O	M	-	-	AC.			The time for the sewing machine to reach the high speed after the pedal toe down or external run signal (S1) is input can be set easily.
								H	H		100mS
								M	M		140mS
								L	L		240mS
								-	-		The time set in the next acceleration time ACT is used.
	Acceleration time	ACT.	0103	O	14	X10 msec	6 ~ 99	ACT.	**	**	The acceleration time for the sewing machine to reach the high speed after pedal toe down or external run signal (S1) ON can be set. This is valid when the acceleration time simple setting AC is set to [-].
	Deceleration time simple setting	DC.	0104	O	M	-	-	dC.			The deceleration time for the sewing machine to stop after returning to neutral from pedal toe down or when the external run signal (S1) is turned OFF can be set easily.
							H	H		90mS	
							M	M		160mS	
							L	L		230mS	
							-	-		The time set in the next deceleration time DCT is used.	
Deceleration time	DCT.	0105	O	16	X10 msec	6 ~ 99	dCT.	**	**	The deceleration time for the sewing machine to stop after returning to neutral from pedal toe down or when the external run signal (S1) is turned OFF can be set. This is valid when the deceleration time simple setting DC is set to [-]. Normally use this at 350 milliseconds or less.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
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A mode 	S-character cushion	SC.	0106	O	OF	-	-	SC.	OF	ON OF	<p>The speed change curve is accelerated slowly for the t time after pedal toe down or the external run signal (S1) is turned ON, and then the sewing machine accelerates rapidly and enters the high speed operation. This is effective when carrying out one stitch sewing with the external run signal (S1) when automatic operation function is set in the P mode.</p> 	
	S-character cushion time setting	SCT.	0107	O	7	X10 msec	0 ~ 99	SCT.	**	**	The "t" time can set when S-character cushion is set to [ON].	
	Full heeling S2 signal operation mode when power is turned on or after thread trimming	S2M.	0108	O	FU	-	-	S2M.				The operation mode of the full heeling or S2 signal when the power is turned on or after thread trimming is determined.
									FU	FU	The presser foot lifting operation is entered.	
									U	U	The needle lifting operation is entered.	
									OF	UF	The presser foot lifting operation after needle lifting is entered.	
	Sewing machine shaft/motor shaft speed setting selection	PL.	0109	O	OF	-	-	PL.	OF	ON OF	The speed setting is set so that the normal sewing machine shaft speed is constant, but by the [ON] setting, it is possible to operate at the value which was set by the [MR], [SR] function. This is effective when the motor pulley diameter is small, the V belt slips and the sewing machine speed is unstable.	
	Setting motor pulley diameter	MR.	0110	O	70	mm	20 ~ 349	MR.	***	***	Set the diameter of motor pulley When "PL" is "ON", this function is valid.	
	Setting sewing machine pulley diameter	SR.	0111	O	70	mm	20 ~ 349	SR.	***	***	Set the diameter of sewing machine pulley When "PL" is "ON", this function is valid.	
	No detector mode	NOS.	0112	O	OF	-	-	NOS.	OF	ON OF	Variable operation is possible when the detector has broken by setting to [ON] to invalidate the detector. The positioning stop and thread trimming operations will not be possible.	
	First priority stop => speed control	STM.	0114	O	OF	-	-	STM.	OF	ON OF	When machine will be stopped, first priority become speed control. (Usually first priority to stop is stopped angle.)	
	Brake time	BKT.	0115	O	14	X10 msec	0 ~ 99	BKT.	**	**	The brake time for stopping the sewing machine can be set.	
Weak brake angle	B8.	0116	O	14	X0.1 degree	4 ~ 500	B8.	**	**	Setting the angle to clear weak break. Minimum setting angle is 0.2 degree.		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
A mode 	Reduction of weak brake sound BNR.	0117	O	ON	-	-	<i>bnr.</i>	<i>00</i> <i>0F</i>	ON OF	Reducing the sound (noise) of weak brake.	
	Weak brake force BKS.	0118	O	99	%	1 ~ 99	<i>bts.</i>	**	**	The weak brake force can be set.	
	Weak brake mode BKM.	0119	O	E	-	-	<i>btk.</i>	<i>E</i>			The weak brake force can be set for when stopping the sewing machine when the weak brake [BK] is set to [ON].
									E	E	Brake that allows manual rotation.
									H	H	Strong brake.
Weak brake BK.	0120	O	OF	-	-	<i>bt.</i>	<i>00</i> <i>0F</i>	ON OF	The weak brake validity can be set.		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
B mode 	Display sewing speed S.	0200	○	0	rpm	0 ~ 9999	S.	****	****	Display the round per minute of running sewing machine.	
	Down counter setting count amount N.	0201	○	99	-	0 ~ 9999	n.	****	****	Setting the number of down counter.	
	Down counter display count amount D.	0202	○	99	-	0 ~ 9999	d.	****	****	Display the number of current down counter.	
	Up counter setting count amount P.	0203	○	99	-	0 ~ 9999	P.	****	****	Setting the number of up counter.	
	Up counter display count amount U.	0204	○	0	-	0 ~ 9999	U.	****	****	Display the number of current up counter.	
	Up counter the selection of setting mode CUP.	0205	○	CU	-	-	-	CUP.			Selection of count up condition.
										CU	After thread trimming is finished
										ST	After thread trimming is finished
										PR	The number of trimming times become "N" ("N" have to be set at "PRN")
										IN	When input function "IO1"become ON. ("IO1"have to be set to input signal on the program mode C.)
										OU	When output signal "O1"become ON. ("O1"have to be set to output function on "O1" of the program mode C.)
	Up counter the selection of counter operation USC.	0206	○	ST	-	-	-	USC.			Selection of operation count over. (Up counter)
										ST	Control panel buzzes and running is prohibited after trimming with buzzer sound. And then when Up counter clear key "CCU" is pressed, sewing become possible. (Buzzer will stop after a while.) (Factory setting of Up counter clear key is "P" key on control panel.)
										OF	Sewing is possible to continue without buzzer sound.
										BZ	Sewing is possible to continue with buzzer sound. (Buzzer will stop after a while.)
	Up counter changing sewing pattern UCM.	0207	○	OF	-	-	-	UCM.		ON OF	[ON]:When sewing pattern is changed, it clear "up counter".
	Up counter valid / invalid UPC.	0208	○	OF	-	-	-	UPC.		ON OF	[ON]:The up counter is valid.
Up counter operation after counting over NXU.	0209	○	OF	-	-	-	NXU.			The Up counter operation, after counting over.	
									ON	The display shows the setting number and the counting is stopped.	
									OF	The display shows the setting number and the counting is continued.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
B mode   	Down counter the selection of setting mode CDN.	0210	O	CU	-	-	<i>CDN</i>			Selection of count down condition.	
									<i>CU</i>	CU	After thread trimming is finished
									<i>ST</i>	ST	The number of sewing stitch become "N" ("N" have to be set at "CNU")
									<i>PR</i>	PR	The number of trimming times become "N" ("N" have to be set at "PRN")
									<i>IN</i>	IN	When input function "IO1"become ON. ("IO1"have to be set to input signal on the program mode C.)
									<i>OU</i>	OU	When output signal "O1"become ON. ("O1"have to be set to output function on "O1" of the program mode C.)
	Down counter the selection of counter operation DSC.	0211	O	ST	-	-	<i>DSC</i>			Selection of operation at count over. (Down counter)	
									<i>ST</i>	ST	Control panel buzzes and running is prohibited after thread trimming with buzzer sound. And then when Down counter clear key "CCD" is pressed, buzzer and sewing become possible. (Buzzer will stop after a while.) (Factory setting of Up counter clear key is "P" key on control panel.)
									<i>OF</i>	OF	Sewing is possible to continue without buzzer sound.
									<i>BZ</i>	BZ	Sewing is possible to continue with buzzer sound. (Buzzer will stop after a while.)
	Down counter changing sewing pattern DCM.	0212	O	OF	-	-	<i>DCN</i>	<i>ON</i> <i>OF</i>	ON OF	[ON]:When sewing pattern is changed, it clear "down counter".	
	Down counter valid / invalid DNC.	0213	O	OF	-	-	<i>DNC</i>	<i>ON</i> <i>OF</i>	ON OF	[ON]:The down counter is valid.	
	Down counter operation after counting over NXD.	0214	O	OF				<i>valid</i>			The down counter action, after counting over. (It is valid, when [DSC] is set to "OF", "BZ".
									<i>ON</i>	ON	The display shows "0" and the counting is stopped.
<i>OF</i>									OF	The display shows "-" and the counting is continued.	
Counter condition turning on power switch PCM.	0215	O	OF				<i>PCN</i>			When power switch is turned on.	
								<i>ON</i>	ON	Up counter is clear (zero) and down counter is set the setting number.	
								<i>OF</i>	OF	Both counter keep previous amount.	
Setting Thread trimming times "N" PRN.	0216	O	0	times	0 ~ 99	<i>PRN</i>	**	**	When "CUP" and "CDN" are PR, trimming times "N" is set.		
Setting Number of stitches "N" CNU.	0217	O	1	stitches	1 ~ 99	<i>CNU</i>	**	**	When "CUP" and "CDN" are ST, number of stitch "N" is set.		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
B mode   	Count modification (to use IO1, IO2) CCI.	0218	O	OF	-	-	[[[.			Modification of count amount.
								on	ON	When input function "IO1" is turned on, it becomes count up. When input function "IO2" is turned on, it becomes count down. (Input function can set input signal on program mode "C".)
								of	OF	Modification is prohibited.
	Display condition turning on power switch PMD.	0219	O	OF	-	-	Pnd.			Selection display mode, when power switch is turned on.
								on	ON	When power switch turned on, display shows previous condition. (Keep previous condition)
								of	OF	When power switch turned on, display shows normal mode.
	Reset for Up / Down counter during operation CCM.	0220	O	OF	-	-	[[[.			Reset for Up / Down counter during operation.
								on	ON	Reset for Up / Down counter is valid.
								of	OF	Reset for Up / Down counter is invalid.

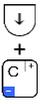
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
C mode  + 	Function selection of input signal IA	IA.	0300	X	PSU	-	-	.AR	***	***	The input functions of each input signal IA can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal IA	IAL.	0301	X	OF	-	-	.AL	ON OF	ON OF	The input logic of each Input signal IA is reversed.
	Alternating operation of input signal IA	IAA.	0302	X	OF	-	-	.ARA	ON OF	ON OF	If each input signal IA performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Function selection of input signal IB	IB.	0303	X	PSD	-	-	.b.	***	***	The input functions of each input signal IB can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal IB	IBL.	0304	X	OF	-	-	.bL.	ON OF	ON OF	The input logic of each Input signal IB is reversed.
	Alternating operation of input signal IB	IBA.	0305	X	OF	-	-	.bAR.	ON OF	ON OF	If each input signal IB performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Function selection of input signal IC	IC.	0306	X	S0	-	-	.c.	***	***	The input functions of each input signal IC can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal IC	ICL.	0307	X	OF	-	-	.cL.	ON OF	ON OF	The input logic of each Input signal IC is reversed.
	Alternating operation of input signal IC	ICA.	0308	X	OF	-	-	.cAR.	ON OF	ON OF	If each input signal IC performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Function selection of input signal ID	ID.	0309	X	TL	-	-	.d.	***	***	The input functions of each input signal ID can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal ID	IDL.	0310	X	OF	-	-	.dL.	ON OF	ON OF	The input logic of each Input signal ID is reversed.
	Alternating operation of input signal ID	IDA.	0311	X	OF	-	-	.dAR.	ON OF	ON OF	If each input signal ID performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Function selection of input signal IE	IE.	0312	X	S7	-	-	.e.	***	***	The input functions of each input signal IE can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal IE	IEL.	0313	X	OF	-	-	.eL.	ON OF	ON OF	The input logic of each Input signal IE is reversed.
	Alternating operation of input signal IE	IEA.	0314	X	OF	-	-	.eAR.	ON OF	ON OF	If each input signal IE performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
Function selection of input signal IF	IF.	0315	X	F	-	-	.f.	***	***	The input functions of each input signal IF can be selected from 80 types of functions. (*1)	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
	Logical conversion function of input signal IF IFL.	0316	X	OF	-	-	IFL.	00 0F	ON OF	The input logic of each Input signal IF is reversed.
C mode 	Operation selection of input signal IF IFM.	0317	X	NO	-	-	IFM.			The operation mode of each input signal IF can be selected.
								no	NO	Normal operation.
								AL	AL	Alternating operation.
								RS	RS	RS F/F (Flip-Flop) operation.
	Set condition of RS F/F operation of input signal IF RFS.	0318	X	IN	-	-	rFS.			Set condition RS F/F of IF When [IFM] is set to [RS], it is valid.
								IN	IN	RS F/F of IF is set by IF
								T	T	After thread trimming operation (stop to up position.)
								R	R	When motor start, RS F/F will be set.
								S	S	When motor stops, RS F/F will be set.
								TR	TR	When sewing start, after thread trimming.
								SB	SB	When start tacking or condensed stitch was finished.
	Reset condition of RS F/F operation of input signal IF RFR.	0319	X	IN	-	-	rFr.			Reset condition RS F/F of IF When [IFM] is set to [RS], it is valid.
								IN	IN	RS F/F of IF is reset by IOG.
								T	T	When thread trimming is done (stop to up position.)
							R	R	When motor start, RS F/F will be reset.	
							S	S	When motor stops, RS F/F will be reset.	
							TR	TR	When sewing start, after trimming.	
							SB	SB	When start condensed stitch was finished.	
							NC	NC	When sewing machine sew the setting stitch after set RS F/F, it will be reset. (R1N, R2N)	
Number of reset needles of RS F/F operation of input IF RFN.	0320	X	3	stitches	0 ~ 99	rFn.	**	**	When [RFR] set [NC], the number of stitch is set by this counter.	
Function selection of input signal IG IG.	0321	X	S1	-	-	IG.	***	***	The input functions of each input signal IG can be selected from 80 types of functions. (*1)	
Logical conversion function of input signal IG IGL.	0322	X	OF	-	-	IGL.	00 0F	ON OF	The input logic of each Input signal IG is reversed.	
Alternating operation of input signal IG IGA.	0323	X	OF	-	-	IGA.	00 0F	ON OF	If each input signal IG performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)	
Function selection of input signal IH IH.	0324	X	S2	-	-	IH.	***	***	The input functions of each input signal IH can be selected from 80 types of functions. (*1)	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
C mode 	Logical conversion function of input signal IH	IHL.	0325	X	OF	-	-			ON OF	The input logic of each Input signal IH is reversed.
	Alternating operation of input signal IH	IHA.	0326	X	OF	-	-			ON OF	If each input signal IH performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Function selection of input signal II	II.	0327	X	S3	-	-		***	***	The input functions of each input signal II can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal II	IIIL.	0328	X	OF	-	-			ON OF	The input logic of each Input signal II is reversed.
	Alternating operation of input signal II	IIA.	0329	X	OF	-	-			ON OF	If each input signal II performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Not used	IJ.	0330	X	NO	-	-		***	***	Not used.
	Not used	IJL.	0331	X	OF	-	-			ON OF	Not used.
	Not used	IJA.	0332	X	OF	-	-			ON OF	Not used.
	Not used	IK.	0333	X	NO	-	-		***	***	Not used.
	Not used	IKL.	0334	X	OF	-	-			ON OF	Not used.
	Not used	IKA.	0335	X	OF	-	-			ON OF	Not used.
	Not used	IL.	0336	X	NO	-	-		***	***	Not used.
	Not used	ILL.	0337	X	OF	-	-			ON OF	Not used.
	Not used	ILA.	0338	X	OF	-	-			ON OF	Not used.
	Function selection of input signal IM	IM.	0339	X	NO	-	-		***	***	The input functions of each input signal IM can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal IM	IML.	0340	X	OF	-	-			ON OF	The input logic of each Input signal IM is reversed.
Alternating operation of input signal IM	IMA.	0341	X	OF	-	-			ON OF	If each input signal IM performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)	
Function selection of input signal IN	IN.	0342	X	NO	-	-		***	***	The input functions of each input signal IN can be selected from 76 types of functions. (*1)	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
	Logical conversion function of input signal IN	INL.	0343	X	OF	-	-	inL.	ON OF	ON OF	The input logic of each Input signal IN is reversed.
C mode ↓ + C ¹	Alternating operation of input signal IN	INA.	0344	X	OF	-	-	inR.	ON OF	ON OF	If each input signal IN performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Function selection of input signal IO	IO.	0345	X	NO	-	-	io.	***	***	The input functions of each input signal IO can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal IO	IOL.	0346	X	OF	-	-	ioL.	ON OF	ON OF	The input logic of each Input signal IO is reversed.
	Alternating operation of input signal IO	IOA.	0347	X	OF	-	-	ioR.	ON OF	ON OF	If each input signal IO performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Function selection of input signal IP	IP.	0348	X	CCU	-	-	ip.	***	***	The input functions of each input signal IP can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal IP	IPL.	0349	X	OF	-	-	ipL.	ON OF	ON OF	The input logic of each Input signal IP is reversed.
	Alternating operation of input signal IP	IPA.	0350	X	OF	-	-	ipR.	ON OF	ON OF	If each input signal IP performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Function selection of input signal IQ	IQ.	0351	X	NO	-	-	iq.	***	***	The input functions of each input signal IQ can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal IQ	IQL.	0352	X	OF	-	-	iqL.	ON OF	ON OF	The input logic of each Input signal IQ is reversed.
	Alternating operation of input signal IQ	IQA.	0353	X	OF	-	-	iqR.	ON OF	ON OF	If each input signal IQ performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Function selection of input signal IR	IR.	0354	X	NO	-	-	ir.	***	***	The input functions of each input signal IR can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal IR	IRL.	0355	X	OF	-	-	irL.	ON OF	ON OF	The input logic of each Input signal IR is reversed.
	Alternating operation of input signal IR	IRA.	0356	X	OF	-	-	irR.	ON OF	ON OF	If each input signal IR performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Function selection of input signal I1	I1.	0357	X	IO1	-	-	i1.	***	***	The input functions of each input signal I1 can be selected from 80 types of functions. (*1)
Logical conversion function of input signal I1	I1L.	0358	X	OF	-	-	i1L.	ON OF	ON OF	The input logic of each Input signal I1 is reversed.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
	Operation selection of input signal I1 I1M.	0359	X	NO	-	-	, I1.			The operation mode of each input signal I1 can be selected.
									NO	Normal operation.
									AL	Alternating operation.
									RS	RS F/F (Flip-Flop) operation.
C mode 	Special setting for input signal " I1" (Neglecting of signal) I1O.	0360	O	OF	-	-	, I1O.	ON OF	ON OF	When sewing machine is running, input signal [I1] is not accepted This function is valid, only [I1M] set [AL] or [RS].
	Special setting for input signal " I1" is ON I1F.	0361	X	OF	-	-	, I1F.	ON OF	ON OF	When [I1M] set [AL] on program mode "C", the alternate operation of input[I1] sets virtual output [OT3] to alternative output.
	AL operation clearness of input signal I1 I1C.	0362	X	OF	-	-	, I1C.	ON OF	ON OF	AL operation of input signal [I1] is cleared by thread trimming operation.
	Delay time of AL operation of input signal I1 I1CT.	0363	O	0	X100 msec	0 ~ 99	I1CT.	**	**	When above setting I1C is valid, these delay timer is set.
	Input signal I1 virtual F/F circuit operation 1 F1P.	0364	X	OF	-	-	F I P.	ON OF	ON OF	The input signal I1 virtual F/F (flip-flop) operation is turned ON when power is turned ON. It is only valid, when [I1M] function is set to "AL" or "RS"
	Input signal I1 virtual F/F circuit operation 2 F1C.	0365	X	OF	-	-	F I C.	ON OF	ON OF	The input signal I1 virtual F/F (flip-flop) operation is turned OFF when the sewing start No. of stitches RLN setting is completed.
	Input signal I1 virtual F/F circuit operation 3 F1S.	0366	X	OF	-	-	F I S.	ON OF	ON OF	The input signal I1 virtual F/F (flip-flop) operation is turned ON when the tacking starts or after thread trimming.
	Set condition of RS F/F for I1 R1S.	0367	X	IN	-	-	, I1S.			Set condition RS F/F of I1 When [I1M] is set to [RS], it is valid.
									IN	RS F/F of I1 is set by I1
									T	After thread trimming operation (stop to up position.)
								R	When motor start, RS F/F will be set.	
								S	When motor stops, RS F/F will be set.	
								TR	When sewing start, after thread trimming.	
	SB	When start tacking or condensed stitch was finished.								
Reset condition of RS F/F for I1 R1R.	0368	X	IN	-	-	, I1R.			Reset condition RS F/F of IF When [I1M] is set to [RS], it is valid.	
								IN	RS F/F of I1 is reset by IOE.	
								T	When thread trimming is done (stop to up position.)	
								R	When motor start, RS F/F will be reset.	
								S	When motor stops, RS F/F will be reset.	
								TR	When sewing start, after trimming.	
								SB	When start condensed stitch was finished.	
								NC	When sewing machine sew the setting stitch after set RS F/F, it will be reset. (R1N, R2N)	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
C mode 	RS F/F reset stitch amount for I1 R1N.	0369	O	3	stitches	0 ~ 99	r 1n.	**	**	When [R1R] set [NC], the number of stitch is set by this counter.	
	Function selection of input signal I2 I2.	0370	X	U	-	-	12.	***	***	The input functions of each input signal I2 can be selected from 80 types of functions. (*1)	
	I2 input logic changeover I2L.	0371	X	OF	-	-	12L.	00 0F	ON OF	The input logic of each Input signal I2 is reversed.	
	Operation selection of input signal I2 I2M.	0372	X	NO	-	-	-	12M.			The operation mode of each input signal I2 can be selected.
									no	NO	Normal operation.
									AL	AL	Alternating operation.
								r S	RS	RS F/F (Flip-Flop) operation.	
	AL operation clearness of input signal I2 I2C.	0373	X	OF	-	-	-	12C.	00 0F	ON OF	AL operation of input signal [I2] is cleared by thread trimming operation.
	Delay time of AL operation of input signal I2 2CT.	0374	O	0	X100 msec	0 ~ 99	0 ~ 99	2CT.	**	**	When above setting I2C is valid, these delay timer is set.
	Set condition of RS F/F for I2 R2S.	0375	X	IN	-	-	-	r 2S.			Set condition RS F/F of I2 When [I2M] is set to [RS], it is valid.
									in	IN	RS F/F of I1 is set by I2
r									T	After thread trimming operation (stop to up position.)	
r									R	When motor start, RS F/F will be set.	
S									S	When motor stops, RS F/F will be set.	
r r									TR	When sewing start, after thread trimming.	
Sb	SB	When start tacking or condensed stitch was finished.									

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
C mode   	Reset condition of RS F/F for I2	R2R.	0376	X	IN	-	-	r2r.		Reset condition RS F/F of IF When [I2M] is set to [RS], it is valid.	
								in	IN	RS F/F of I2 is reset by IOF.	
								f	T	When thread trimming is done (stop to up position.)	
								r	R	When motor start, RS F/F will be reset.	
								s	S	When motor stops, RS F/F will be reset.	
								fr	TR	When sewing start, after trimming.	
								sb	SB	When start condensed stitch was finished.	
								nc	NC	When sewing machine sew the setting stitch after set RS F/F, it will be reset. (R2N)	
	RS F/F reset stitch amount for I2	R2N.	0377	O	3	stitches	0 ~ 99	r2n.	**	**	When [R2R] set [NC], the number of stitch is set by this counter.
	Function selection of input signal I4	I4.	0378	X	NO	-	-	.4	***	***	The input functions of each input signal I4 can be selected from 80 types of functions. (*1)
	Logical conversion function of input signal I2	I4L.	0379	X	OF	-	-	.4L.	OF	ON OF	The input logic of each Input signal I4 is reversed.
	I4 input alternating operation	I4A.	0380	X	OF	-	-	.4R.	OF	ON OF	If each input signal I4 performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
	Function selection of input signal I5	I5.	0381	X	NO	-	-	.5	***	***	The input functions of each input signal I5 can be selected from 80 types of functions. (*1)
Logical conversion function of input signal I5	I5L.	0382	X	OF	-	-	.5L.	OF	ON OF	The input logic of each Input signal I5 is reversed.	
Alternating operation of input signal I5	I5A.	0383	X	OF	-	-	.5R.	OF	ON OF	If each input signal I5 performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)	
Function selection of input signal I6	I6.	0384	X	NO	-	-	.6	***	***	The input functions of each input signal I6 can be selected from 80 types of functions. (*1)	
Logical conversion function of input signal I6	I6L.	0385	X	OF	-	-	.6L.	OF	ON OF	The input logic of each Input signal I6 is reversed.	
Alternating operation of input signal I6	I6A.	0386	X	OF	-	-	.6R.	OF	ON OF	If each input signal I6 performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)	
Function selection of input signal I7	I7.	0387	X	NO	-	-	.7	***	***	The input functions of each input signal I7 can be selected from 80 types of functions. (*1)	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting	Specification	
				GMFY			Digital display			
	Logical conversion function of input signal I7	I7L.	0388	X	OF	-	-		ON OF	The input logic of each Input signal I7 is reversed.
	Alternating operation of input signal I7	I7A.	0389	X	OF	-	-		ON OF	If each input signal I7 performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1) ,stops (turn OFF) at (2) , and will turn ON again at (3). (This is hereafter referred to alternate operation.) (*2)
<p>(*1)</p> <p><i>*Refer to [25.Table of input/output function for signal on C mode]</i> <i>*Refer to [26.The composition figure of input and output customization]</i></p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p>(Lever connector) IG:S1(Variable speed run signal) IH:S2(Thread trimmer signal) I I:S3(Presser foot lifter signal)</p> </div> <div style="text-align: center;"> <p>(Option A connector) IA:PSU(Needle UP position priority stop signal) IB:PSD(Needle DOWN position priority stop signal) IC:S0 (Low speed run signal)</p> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 20px;"> <div style="text-align: center;"> <p>(Sewing machine connector) ID:TL(Thread trimmer cancel signal) IE:S7(Backstitching during run signal)</p> </div> <div style="text-align: center;"> <p>(Option B connector) I1:IO1(Signal output to virtual output 1) I2:U(Needle lift signal) I4:NO(No setting) I5:NO(No setting)</p> </div> </div> <div style="text-align: center; margin-top: 20px;"> <p>(Presser foot lifter connector) IF:F(Presser foot lifter signal)</p> </div> <p>Caution Input signal [I6,I7] are coupling port of input and output by the Software. So these input signal are not at connector.</p> <p>(*2)</p> <p>If each input signal performs OFF => (1)ON => OFF => (2)ON => OFF => (3)ON => OFF the signal will stay ON at (1), stops (turn OFF) at (2), and will turn ON again at (3). (This is hereafter referred to alternate operation.)</p> <div style="text-align: center; margin-top: 20px;"> </div>										
	Function selection of output signal OA	OA.	0390	X	T	-	-		***	The output functions of each output signal OA can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal OA	OAL.	0391	X	OF	-	-		ON OF	The output logic of each output signal OA is reversed.



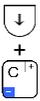
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
C mode  + 	Chopping operation of output signal OA	OAC.	0392	X	OF	-	-			ON OF	Each output is output with full wave immediately after output starts, and then is reduced to half-wave output for each output signal OA. (Chopping control) The full wave output time can be set with the full wave time [PO] function for each output.
	Output signal OA compulsion OFF	OAT.	0393	X	OF	-	-			ON OF	In each output signal OA, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal OA	DA.	0394	X	0	msec.	0 ~ 510		***	***	In each output signal OA the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal OB	OB.	0395	X	W	-	-		***	***	The output functions of each output signal OB can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal OB	OBL.	0396	X	OF	-	-			ON OF	The output logic of each output signal OB is reversed.
	Chopping operation of output signal OB	OBC.	0397	X	OF	-	-			ON OF	Each output is output with full wave immediately after output starts, and then is reduced to half-wave output for each output signal OB. (Chopping control) The full wave output time can be set with the full wave time [PO] function for each output.
	Output signal OB compulsion OFF	OBT.	0398	X	OF	-	-			ON OF	In each output signal OB, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal OB	DB.	0399	X	0	msec.	0 ~ 510		***	***	In each output signal OB the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal OC	OC.	0400	X	B	-	-		***	***	The output functions of each output signal OC can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal OC	OCL.	0401	X	OF	-	-			ON OF	The output logic of each output signal OC is reversed.
	Chopping operation of output signal OC	OCC.	0402	X	OF	-	-			ON OF	Each output is output with full wave immediately after output starts, and then is reduced to half-wave output for each output signal OC. (Chopping control) The full wave output time can be set with the full wave time [PO] function for each output.
	Output signal OC compulsion OFF	OCT.	0403	X	OF	-	-			ON OF	In each output signal OC, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal OC	DC.	0404	X	0	msec.	0 ~ 510		***	***	In each output signal OC the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal OD	OD.	0405	X	L	-	-		***	***	The output functions of each output signal OD can be selected from 58 types of functions. (*3)
Logical conversion function of output signal OD	ODL.	0406	X	OF	-	-			ON OF	The output logic of each output signal OD is reversed.	
Chopping operation of output signal OD	ODC.	0407	X	OF	-	-			ON OF	Each output is output with full wave immediately after output starts, and then is reduced to half-wave output for each output signal OD. (Chopping control) The full wave output time can be set with the full wave time [PO] function for each output.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
	Output signal OD compulsion OFF	ODT.	0408	X	OF	-	-	odf.	OF	ON OF	In each output signal OD, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.	
C mode   	Delay time of output signal OD	DD.	0409	X	0	msec.	0 ~ 510	dd.	***	***	In each output signal OD the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.	
	Function selection of output signal OF	OF.	0410	X	FU	-	-	of.	***	***	The output functions of each output signal OF can be selected from 58 types of functions. (*3)	
	Logical conversion function of output signal OF	OFL.	0411	X	OF	-	-	ofl.	OF	ON OF	The output logic of each output signal OF is reversed.	
	Presser foot lifter output chopping duty	FUD.	0412	X	MF	-	-	FUD.				The chopping output duty during holding after the presser foot lifter output FU lifting operation can be set.
									75	MS	4ms ON/OFF 50% duty	
									7F	MF	2ms ON/OFF 50% duty	
									H1	HI	4ms ON, 2ms OFF, 66% duty	
									26	26	2ms ON, 6ms OFF, 25% duty	
									62	62	6ms ON, 2ms OFF, 75% duty	
									84	84	8ms ON, 4ms OFF, 66% duty	
									FL	FL	100% (full wave)	
	Lo	LO	2ms ON, 4ms OFF 33% duty									
	Presser foot lifter FU full wave output time	FO.	0413	X	50	X10 msec	-	Fo.				The full wave output time of the presser foot lifter output FU can be set.
20									20	200ms		
25									25	250ms		
30									30	300ms		
40									40	400ms		
50									50	500ms		
60									60	600ms		
80									80	800ms		
100	100	1000ms										
Presser foot lifter FU momentary mode	FU.	0414	X	M	-	-	FU.				The operation mode of presser foot lifter momentary FUM is set. This is valid when presser foot lifter momentary FUM is set to [ON] in the P mode.	
								n	M	The presser foot lifter operation is continued after full heeling or after thread trimmer with external thread trimmer signal S2.		
								[C	The presser foot lifter operation is continued during the timer time after full heeling or after thread trimming with external thread trimmer signal S2. Then the presser foot lifter is lowered. The timer can be adjusted with timer setting FCT in the P mode.		
								A	A	The presser foot lifting operation is activated with full heeling, light heeling, or the external control signal (S2, F) ON. Then, when the full heeling, light heeling or external control signal (S2, F) is turned ON, the presser foot will bring down, and when turned ON again, the presser foot will lift. (Alternate operation.)		
								F	T	The timer operates in the same manner as the [C] setting. However, after the presser foot bring down, the same alternate operation as the [A] setting will occur.		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
C mode 	Delay time of output signal OF	DF.	0415	X	0	msec.	0 ~ 510	df.	***	***	In each output signal OF the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal O1	O1.	0416	X	OT1	-	-	o1.	***	***	The output functions of each output signal O1 can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal O1	O1L.	0417	X	OF	-	-	o1L.	ON OF	ON OF	The output logic of each output signal O1 is reversed.
	Chopping operation of output signal O1	O1C.	0418	X	OF	-	-	o1C.	ON OF	ON OF	Each output is output with full wave immediately after output starts, and then is reduced to half-wave output for each output signal O1. (Chopping control) The full wave output time can be set with the full wave time [PO] function for each output.
	Output signal O1 compulsion OFF	O1T.	0419	X	OF	-	-	o1T.	ON OF	ON OF	In each output signal O1, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal O1	D1.	0420	X	0	msec.	0 ~ 510	d1.	***	***	In each output signal O1 the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal O2	O2.	0421	X	NCL	-	-	o2.	***	***	The output functions of each output signal O2 can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal O2	O2L.	0422	X	OF	-	-	o2L.	ON OF	ON OF	The output logic of each output signal O2 is reversed.
	Chopping operation of output signal O2	O2C.	0423	X	OF	-	-	o2C.	ON OF	ON OF	Each output is output with full wave immediately after output starts, and then is reduced to half-wave output for each output signal O2. (Chopping control) The full wave output time can be set with the full wave time [PO] function for each output.
	Output signal O2 compulsion OFF	O2T.	0424	X	OF	-	-	o2T.	ON OF	ON OF	In each output signal O2, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal O2	D2.	0425	X	0	msec.	0 ~ 510	d2.	***	***	In each output signal O2 the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal O3	O3.	0426	X	TF	-	-	o3.	***	***	The output functions of each output signal O3 can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal O3	O3L.	0427	X	OF	-	-	o3L.	ON OF	ON OF	The output logic of each output signal O3 is reversed.
	Chopping operation of output signal O3	O3C.	0428	X	OF	-	-	o3C.	ON OF	ON OF	Each output is output with full wave immediately after output starts, and then is reduced to half-wave output for each output signal O3. (Chopping control) The full wave output time can be set with the full wave time [PO] function for each output.
	Output signal O3 compulsion OFF	O3T.	0429	X	OF	-	-	o3T.	ON OF	ON OF	In each output signal O3, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal O3	D3.	0430	X	0	msec.	0 ~ 510	d3.	***	***	In each output signal O3 the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
Function selection of output signal O4	O4.	0431	X	UPW	-	-	o4.	***	***	The output functions of each output signal O4 can be selected from 58 types of functions. (*3)	
Logical conversion function of output signal O4	O4L.	0432	X	OF	-	-	o4L.	ON OF	ON OF	The output logic of each output signal O4 is reversed.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
C mode 	Output signal O4 compulsion OFF	O4T.	0433	X	OF	-	-	04T.	0F	ON OF	In each output signal O4, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal O4	D4.	0434	X	0	msec.	0 ~ 510	d4.	***	***	In each output signal O4 the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal O5	O5.	0435	X	DNW	-	-	o5.	***	***	The output functions of each output signal O5 can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal O5	O5L.	0436	X	OF	-	-	o5L.	0F	ON OF	The output logic of each output signal O5 is reversed.
	Output signal O5 compulsion OFF	O5T.	0437	X	OF	-	-	o5T.	0F	ON OF	In each output signal O5, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal O5	D5.	0438	X	0	msec.	0 ~ 510	d5.	***	***	In each output signal O5 the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal O6	O6.	0439	X	NO	-	-	o6.	***	***	The output functions of each output signal O6 can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal O6	O6L.	0440	X	OF	-	-	o6L.	0F	ON OF	The output logic of each output signal O6 is reversed.
	Chopping operation of output signal O6	O6C.	0441	X	OF	-	-	o6C.	0F	ON OF	Each output is output with full wave immediately after output starts, and then is reduced to half-wave output for each output signal O6. (Chopping control) The full wave output time can be set with the full wave time [PO] function for each output.
	Output signal O6 compulsion OFF	O6T.	0442	X	OF	-	-	o6T.	0F	ON OF	In each output signal O6, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal O6	D6.	0443	X	0	msec.	0 ~ 510	d6.	***	***	In each output signal O6 the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal O7	O7.	0444	X	NO	-	-	o7.	***	***	The output functions of each output signal O7 can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal O7	O7L.	0445	X	OF	-	-	o7L.	0F	ON OF	The output logic of each output signal O7 is reversed.
	Chopping operation of output signal O7	O7C.	0446	X	OF	-	-	o7C.	0F	ON OF	Each output is output with full wave immediately after output starts, and then is reduced to half-wave output for each output signal O7. (Chopping control) The full wave output time can be set with the full wave time [PO] function for each output.
	Output signal O7 compulsion OFF	O7T.	0447	X	OF	-	-	o7T.	0F	ON OF	In each output signal O7, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal O7	D7.	0448	X	0	msec.	0 ~ 510	d7.	***	***	In each output signal O7 the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
Function selection of output signal OM	OM.	0449	X	NO	-	-	oM.	***	***	The output functions of each output signal OM can be selected from 58 types of functions. (*3)	
Logical conversion function of output signal OM	OML.	0450	X	OF	-	-	oML.	0F	ON OF	The output logic of each output signal OM is reversed.	

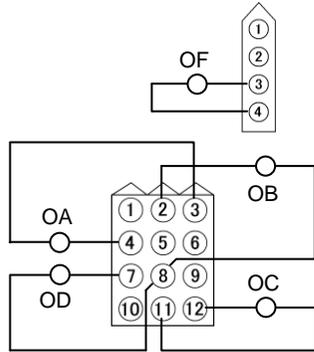
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
C mode 	Output signal OM compulsion OFF	OMT.	0451	X	OF	-	-	<i>onr.</i>	<i>of</i>	ON OF	In each output signal OM, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal OM	DM.	0452	X	0	msec.	0 ~ 510	<i>dn.</i>	***	***	In each output signal OM the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal ON	ON.	0453	X	NO	-	-	<i>on.</i>	***	***	The output functions of each output signal ON can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal ON	ONL.	0454	X	OF	-	-	<i>onL.</i>	<i>of</i>	ON OF	The output logic of each output signal ON is reversed.
	Output signal ON compulsion OFF	ONT.	0455	X	OF	-	-	<i>onr.</i>	<i>of</i>	ON OF	In each output signal ON, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal ON	DN.	0456	X	0	msec.	0 ~ 510	<i>dn.</i>	***	***	In each output signal ON the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal OO	OO.	0457	X	NO	-	-	<i>oo.</i>	***	***	The output functions of each output signal OO can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal OO	OOL.	0458	X	OF	-	-	<i>ooL.</i>	<i>of</i>	ON OF	The output logic of each output signal OO is reversed.
	Output signal OO compulsion OFF	OOT.	0459	X	OF	-	-	<i>oor.</i>	<i>of</i>	ON OF	In each output signal OO, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal OO	DO.	0460	X	0	msec.	0 ~ 510	<i>do.</i>	***	***	In each output signal OO the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal OP	OP.	0461	X	NO	-	-	<i>op.</i>	***	***	The output functions of each output signal OP can be selected from 58 types of functions. (*3)
	Logical conversion function of output signal OP	OPL.	0462	X	OF	-	-	<i>opL.</i>	<i>of</i>	ON OF	The output logic of each output signal OP is reversed.
	Output signal OP compulsion OFF	OPT.	0463	X	OF	-	-	<i>opr.</i>	<i>of</i>	ON OF	In each output signal OP, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.
	Delay time of output signal OP	DP.	0464	X	0	msec.	0 ~ 510	<i>dp.</i>	***	***	In each output signal OP the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.
	Function selection of output signal OQ	OQ.	0465	X	NO	-	-	<i>oq.</i>	***	***	In each output signal OP the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals. (*3)
	Logical conversion function of output signal OQ	OQL.	0466	X	OF	-	-	<i>oqL.</i>	<i>of</i>	ON OF	The output logic of each output signal OQ is reversed.
Output signal OQ compulsion OFF	OQT.	0467	X	OF	-	-	<i>oqr.</i>	<i>of</i>	ON OF	In each output signal OQ, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
C mode 	Delay time of output signal OQ	DQ.	0468	X	0	msec.	0 ~ 510	<i>dq.</i>	***	***	In each output signal OQ the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.	
	Function selection of output signal OR	O.R.	0469	X	NO	-	-	<i>or.</i>	***	***	The output functions of each output signal OR can be selected from 58 types of functions. (*3)	
	Logical conversion function of output signal OR	O.RL.	0470	X	OF	-	-	<i>orL.</i>	<i>ON</i> <i>OF</i>	ON OF	The output logic of each output signal OR is reversed.	
	Output signal OR compulsion OFF	O.RT.	0471	X	OF	-	-	<i>orf.</i>	<i>ON</i> <i>OF</i>	ON OF	In each output signal OR, each output is forcibly turned OFF after the time set in the OFF timer is passed. The OFF timer set time can be set with each output's forced OFF timer [OTT] function.	
	Delay time of output signal OR	DR.	0472	X	0	msec.	0 ~ 510	<i>dr.</i>	***	***	In each output signal OR the delay time to when each output is started can be set. Each delay time can be set in 2msec intervals.	
	Full wave output time for each output	PO.	0473	O	50	X10 msec	-	<i>po.</i>				The full wave output time of each output signal OA~OD, O1~O7 can be set.
									<i>20</i>	20	Set to [20] : 200ms	
									<i>25</i>	25	Set to [25] : 250ms	
									<i>30</i>	30	Set to [30] : 300ms	
									<i>40</i>	40	Set to [40] : 400ms	
									<i>50</i>	50	Set to [50] : 500ms	
									<i>60</i>	60	Set to [60] : 600ms	
									<i>80</i>	80	Set to [80] : 800ms	
	<i>100</i>	100	Set to [100] : 1000ms									
	Output chopping duty except of FU output	POD.	0474	O	MF	-	-	<i>Pod.</i>				Setting output chopping duty, except FU output
<i>MS</i>									MS	Set to [MS] : 2ms ON/OFF 50% duty		
<i>MF</i>									MF	Set to [MF] : 4ms ON/OFF 50% duty		
<i>HI</i>									HI	Set to [HI] : 4ms ON, 2ms OFF, 66% duty		
<i>LO</i>	LO	Set to [LO] : 2ms ON, 4ms OFF 33% duty										
Forced OFF timer setting function for each output	OTT.	0475	O	12	sec	1 ~ 24	<i>off.</i>	**	**	The timer that forcibly turns off output signals OA to OD, O1 to O7 and OM to OR can be set.		
FUM operation mode timer setting function	FCT.	0476	O	12	sec	1 ~ 99	<i>fct.</i>	**	**	The timer from the time when the presser foot lifter output is turned ON to the time when it is turned OFF. (When FUM operation mode FU [C] or [T] is set can be set.)		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting	Specification
				GMFY			Digital display		

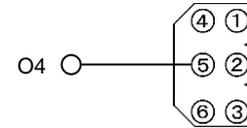
(*3)

*Refer to [25.Table of input/output function for signal on C mode]
 *Refer to [26.The composition figure of input and output customization]

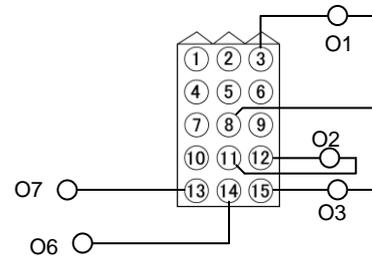


(Presser foot lifter connector)
 OF:FU(Presser foot lifter output)

(Sewing machine connector)
 OA:T(Thread trimmer output)
 OB:W(Wiper output)
 OC:B(Backstitch output)
 OD:L(Thread release output)



(Option A connector)
 O4:UPW(Needle UP position output)



(Option B connector)
 O1:OT1(Virtual output)
 O2:NCL(Needle cooler output)
 O3:TF(TF output)
 O6:NO(No setting)
 O7:NO(No setting)

C mode

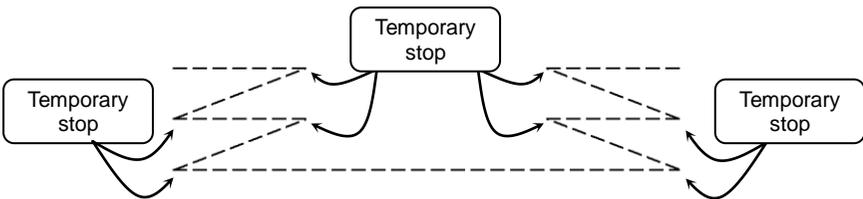
Caution
 Output [O4,O5,O6,O7] are not solenoid output signal.
 Output O5 is not at connector.

Logic [AND] module A1 input function selection	A1.	0477	X	NO	-	-	R L	***	***	Input function selection of the [A1] of the logic [AND] module.
Logic [AND] module A1 setting of Hi /Low logic	A1L.	0478	X	OF	-	-	R IL	OF	ON OF	[A1] logic of the [AND] module is set to opposite.
Logic [AND] module A1 Alternate	A1A.	0479	X	OF	-	-	R IR	OF	ON OF	[A1] of the [AND] module is set to alternative.
Logic [AND] module N1 output function selection	N1.	0480	X	NO	-	-	n L	***	***	Output function selection of the [N1] of the logic [AND] module.
Logic [AND] module N1 setting of Hi /Low logic	N1L.	0481	X	OF	-	-	n IL	OF	ON OF	[N1] logic of the [AND] module is set to opposite.
Logic [AND] module N1 output function selection	N2.	0482	X	NO	-	-	n 2.	***	***	Output function selection of the [N2] of the logic [AND] module.
Logic [AND] module N2 setting of Hi /Low logic	N2L.	0483	X	OF	-	-	n 2L	OF	ON OF	[N2] logic of the [AND] module is set to opposite.
Logic [AND] module A2 input function selection	A2.	0484	X	NO	-	-	R 2.	***	***	Input function selection of the [A2] of the logic [AND] module.
Logic [AND] module A2 setting of Hi /Low logic	A2L.	0485	X	OF	-	-	R 2L	OF	ON OF	[A2] logic of the [AND] module is set to opposite.

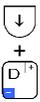
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
C mode 	Logic [AND] module A2 Alternate	A2A.	0486	X	OF	-	-	A2A.	OF	ON OF	[A2] of the [AND] module is set to alternative.
	Logic [AND] module N3 output function selection	N3.	0487	X	NO	-	-	n3.	***	***	Output function selection of the [N3] of the logic [AND] module.
	Logic [AND] module N3 setting of Hi /Low logic	N3L.	0488	X	OF	-	-	n3L.	OF	ON OF	[N3] logic of the [AND] module is set to opposite.
	Logic [AND] module N4 output function selection	N4.	0489	X	NO	-	-	n4.	***	***	Output function selection of the [N4] of the logic [AND] module.
	Logic [AND] module N4 setting of Hi /Low logic	N4L.	0490	X	OF	-	-	n4L.	OF	ON OF	[N4] logic of the [AND] module is set to opposite.
	Logic [AND] module A3 input function selection	A3.	0491	X	NO	-	-	A3.	***	***	Input function selection of the [A3] of the logic [AND] module.
	Logic [AND] module A3 setting of Hi /Low logic	A3L.	0492	X	OF	-	-	A3L.	OF	ON OF	[A3] logic of the [AND] module is set to opposite.
	Logic [AND] module A3 Alternate	A3A.	0493	X	OF	-	-	A3A.	OF	ON OF	[A3] of the [AND] module is set to alternative.
	Logic [AND] module N5 output function selection	N5.	0494	X	NO	-	-	n5.	***	***	Output function selection of the [N5] of the logic [AND] module.
	Logic [AND] module N5 setting of Hi /Low logic	N5L.	0495	X	OF	-	-	n5L.	OF	ON OF	[N5] logic of the [AND] module is set to opposite.
	Logic [AND] module N6 output function selection	N6.	0496	X	NO	-	-	n6.	***	***	Output function selection of the [N6] of the logic [AND] module.
	Logic [AND] module N6 setting of Hi /Low logic	N6L.	0497	X	OF	-	-	n6L.	OF	ON OF	[N6] logic of the [AND] module is set to opposite.
	Logic [OR] module input function selection	OR.	0498	X	NO	-	-	or.	***	***	Input function selection of the [OR] of the logic [OR] module.
	Logic [OR] module setting of Hi /Low logic	ORL.	0499	X	OF	-	-	orL.	OF	ON OF	[OR] logic of the [OR] module is set to opposite.
	Logic [OR] module Alternate	ORA.	0500	X	OF	-	-	orA.	OF	ON OF	[OR] of the [OR] module is set to alternative.
	Logic [OR] module R1 output function selection	R1.	0501	X	NO	-	-	r1.	***	***	Output function selection of the [R1] of the logic [OR] module.
	Logic [OR] module R1 setting of Hi /Low logic	R1L.	0502	X	OF	-	-	r1L.	OF	ON OF	[R1] logic of the [AND] module is set to opposite.
	Logic [OR] module R2 output function selection	R2.	0503	X	NO	-	-	r2.	***	***	Output function selection of the [R2] of the logic [OR] module.
Logic [OR] module R2 setting of Hi /Low logic	R2L.	0504	X	OF	-	-	r2L.	OF	ON OF	[R2] logic of the [AND] module is set to opposite.	
Variable speed command for digital input	CSP.	0505	X	OF	-	-	CSP.	OF	ON OF	Set variable speed command for digital input. (IOC, IOD, IOE, IOF) High speed is set to [H] on program mode "P". (CSP=ON, CSG=OFF)	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
C mode  + 	Thread release + backstitch output LB.	0507	○	OF	-	-	Lb.	00 0F	ON OF	Backstitch output B will turn ON even while thread release output L is ON.
	Virtual output OT1 forced OFF function T1C.	0508	○	OF	-	-	r 1C.	00 0F	ON OF	Virtual outputs OT1 will be turned OFF forcibly after the OFF timer set time has passed. The OFF timer set time can be set with the virtual output OFF timer setting function [T1T].
	Forced OFF timer setting function for virtual output OT1 T1T.	0509	○	99	X10 msec	0 ~ 99	r 1T.	**	**	The timer time for forcibly turning OFF virtual outputs OT1 can be set.
	Virtual output OT2 forced OFF function T2C.	0510	○	OF	-	-	r 2C.	00 0F	ON OF	Virtual outputs OT2 will be turned OFF forcibly after the OFF timer set time has passed. The OFF timer set time can be set with the virtual output OFF timer setting function [T2T].
	Forced OFF timer setting function for virtual output OT2 T2T.	0511	○	99	X10 msec	0 ~ 99	r 2T.	**	**	The timer time for forcibly turning OFF virtual outputs OT2 can be set.
	Virtual output OT3 forced OFF function T3C.	0512	○	OF	-	-	r 3C.	00 0F	ON OF	Virtual outputs OT3 will be turned OFF forcibly after the OFF timer set time has passed. The OFF timer set time can be set with the virtual output OFF timer setting function [T3T].
	Forced OFF timer setting function for virtual output OT3 T3T.	0513	○	99	X10 msec	0 ~ 99	r 3T.	**	**	The timer time for forcibly turning OFF virtual outputs OT3 can be set.
	ON delay time setting function for virtual output OT1 D11.	0514	X	0	X10 msec	0 ~ 99	d 11.	**	**	The delay time (ON delay) to when the virtual output OT1 is started can be set.
	OFF delay time setting function for virtual output OT1 D12.	0515	X	0	X10 msec	0 ~ 99	d 12.	**	**	The delay time (OFF delay) to when the virtual output OT1 is OFF can be set.
	ON delay time setting function for virtual output OT2 D21.	0516	X	0	X10 msec	0 ~ 99	d 21.	**	**	The delay time (ON delay) to when the virtual output OT2 is started can be set.
	OFF delay time setting function for virtual output OT2 D22.	0517	X	0	X10 msec	0 ~ 99	d 22.	**	**	The delay time (OFF delay) to when the virtual output OT2 is OFF can be set.
	ON delay time setting function for virtual output OT3 D31.	0518	X	0	X10 msec	0 ~ 99	d 31.	**	**	The delay time (ON delay) to when the virtual output OT3 is started can be set.
	OFF delay time setting function for virtual output OT3 D32.	0519	X	0	X10 msec	0 ~ 99	d 32.	**	**	The delay time (OFF delay) to when the virtual output OT3 is OFF can be set.
	Feed pulse output (CP) cancel function CPK.	0520	○	ON	-	-	CPk.	00 0F	ON OF	Feed pulse [CP] is invalid. When feed pulse will be used, set this function to "OF". This signal output is from the same pin of "O6".
Setting CP pulse amount CP.	0521	○	32	-	1 ~ 99	CP.	**	**	Setting the number of pulse [CP]. After changing this number, turns on power switch again.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
	Prohibited angle of output CP pulse CPC.	0522	O	OF	-	-	<i>CPC.</i>	<i>00</i> <i>0F</i>	ON OF	The prohibited angle section of pulse generated can be set from UP position. The start prohibited angle can be set with [TS] (G mode). The end prohibited angle can be set with [TE] (G mode).	
C mode 	Panel switch operation prohibit PSW.	0523	O	OF	-	-	<i>PSW.</i>	<i>00</i> <i>0F</i>	ON OF	Panel switch operation ([M], [A,1-2], [B,SL], [C,<==], [D,==>] key operations) during the normal mode, tacking mode and pattern mode will not be possible. However, changeover into each mode will be possible.	
	O4, O5 output cancel during back tack term CKB.	0524	O	OF	-	-	<i>Ckb.</i>	<i>00</i> <i>0F</i>	ON OF	Output signal O4 and O5 are prohibited during back tack term.	
	CP output cancel during back tack term CPB.	0525	O	OF	-	-	<i>CPb.</i>	<i>00</i> <i>0F</i>	ON OF	Output signal "CP" is prohibited during back tack term.	
	Speed setting for the [SPC] output C.	0526	X	1000	rpm	0 ~ 8999	<i>C.</i>	****	****	SPC output is turned ON when reached setting speed [C].	
	Speed setting for the [SPD] output D.	0527	X	2000	rpm	0 ~ 8999	<i>d.</i>	****	****	SPD output is turned ON when reached setting speed [D].	
	Speed setting for the [SPE] output E.	0528	X	3000	rpm	0 ~ 8999	<i>E.</i>	****	****	SPE output is turned ON when reached setting speed [E].	
	F key function on control panel CNF.		0529	O	SE	-	-	<i>CnF.</i>			Selection F key function
									<i>UP</i>	UP	Display Up counter amount
									<i>dn</i>	DN	Display Down counter amount
									<i>SE</i>	SE	Display stitch amount of sensor
							<i>SP</i>	SP	Display routine speed of sewing machine		
	Variable speed pedal changeover PDS.	0530	O	OF	-	-	<i>Pds.</i>	<i>00</i> <i>0F</i>	ON OF	When the changeable velocity pedal etc, are used by the standing sewing machine making, it sets it.	
	Speed instruction VC2 cancellation V2C.	0531	X	OF	-	-	<i>v2C.</i>	<i>00</i> <i>0F</i>	ON OF	Speed instruction VC2 is canceled.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
D mode 	Operation mode during tacking D1.	0600	O	M	-	-	<i>d 1.</i>			The operation mode during tacking is determined.
	<div style="border: 1px solid black; padding: 5px; text-align: center;"> Caution Set the start and end tack type, and number of stitches in the tacking mode before setting the functions in the D mode. </div>									
	<div style="border: 1px solid black; padding: 10px; text-align: center;">  </div>									
								<i>n</i>	M	During start tacking, even if the pedal is returned to neutral or the external run signal (S1) is turned OFF, the stitching will continue to the last tack process, and then will stop. Stitching will continue in the same manner for end tacking, and the needle will be lifted after thread trimming.
								<i>d</i>	D	The tacking speed will change according to the pedal toe down amount only during start tacking. (the maximum speed is the start tacking speed N.) The sewing machine will stop if the pedal is returned to neutral or external signal turned OFF during start tacking.
								<i>n</i>	N	It can be continuous sewing the next straight line stitching without speed down when start tacking is completed. This is valid when the Operation mode during start tack completion D2 is [CON].
								<i>[CST]</i>	CST	The sewing machine will stop for a set time at each tack corner even with pedal toe down or if the external run signal (S1) is ON. The stop time can be adjusted with [CT]. This is used to accurately tack.
								<i>[CSU]</i>	CSU	The sewing machine will stop for a set time at each tack corner even with pedal toe down or if the external run signal (S1) is ON. The sewing machine stops at the UP position irrespective of the position. The stop time can be adjusted with [CT]. This is used to accurately tack.
								<i>[CSD]</i>	CSD	The sewing machine will stop for a set time at each tack corner even with pedal toe down or if the external run signal (S1) is ON. The sewing machine stops at the DOWN position irrespective of the position. The stop time can be adjusted with [CT]. This is used to accurately tack.
		Operation mode during start tack completion D2.	0601	O	CON	-	-	<i>d2.</i>		
							<i>[con]</i>	CON	If the pedal is toed down or the external run signals (S0, S1) are ON when start tacking is completed, the next straight line stitching will begin.	
							<i>[STP]</i>	STP	Even if the pedal is toed down or the external run signals (S1) turned ON when start tacking is completed, the sewing machine will stop. The next straight line stitching will start when the pedal is toed down for neutral again, or when the external run signals (S1) is turned OFF to ON.	
							<i>[TRM]</i>	TRM	The thread is trimmed when start tacking is completed. This is used for continuous tack stitch.	
	Stop time at each corner during start and backtacking CT.	0602	O	5	X10 msec	0 ~ 99	<i>[CT]</i>	**	**	The stop time at each corner during tacking can be set when [CST] in operation mode D1 is set. [CSU],[CSD]
	Tack alignment BM.	0603	O	OF	-	-	<i>b n.</i>			The backstitch solenoid operation timing can be set to align the tacking.
	<div style="border: 1px solid black; padding: 5px; text-align: center;"> Caution If the operation mode during tacking D1 is set to [CST], [CSU] and [CSD], the tacking alignment functions BM, BT1, BT2, BT3 and BT4 will be invalid. </div>									
	No. of stitch compensation for start tacking alignment BT1.	0604	O	0	-	0 ~ F	<i>b f 1.</i>	*	*	By finely adjusting the backstitch solenoid operation timing of start tacking from forward to reverse, the no. of stitches can be compensated. The relation of the setting value and no. of stitch compensation is as shown below.

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification																																					
				GMFY			Digital display																																								
D mode ↓ + D ¹	No. of stitch compensation for start tacking alignment BT2.	0605	O	0	-	0 ~ F	<i>bf2.</i>	*	*	By finely adjusting the backstitch solenoid operation timing of start tacking from reverse to forward, the no. of stitches can be compensated. The relation of the setting value and no. of stitch compensation is as shown below.																																					
	No. of stitch compensation for end tacking alignment BT3.	0606	O	0	-	0 ~ F	<i>bf3.</i>	*	*	By finely adjusting the backstitch solenoid operation timing of end tacking from reverse to forward, the no. of stitches can be compensated. The relation of the setting value and no. of stitch compensation is as shown below.																																					
	No. of stitch compensation for end tacking alignment BT4.	0607	O	0	-	0 ~ F	<i>bf4.</i>	*	*	By finely adjusting the backstitch solenoid operation timing of end tacking from forward to reverse, the no. of stitches can be compensated. The relation of the setting value and no. of stitch compensation is as shown below.																																					
			<table border="1"> <caption>Relation of no. of compensated stitches and setting value</caption> <tr> <td>Setting value</td> <td>9</td> <td>8</td> <td>7</td> <td>6</td> <td>5</td> <td>4</td> <td>3</td> <td>2</td> </tr> <tr> <td>Compensated stitches</td> <td>-2¹/₄</td> <td>-2</td> <td>-1³/₄</td> <td>-1²/₄</td> <td>-1¹/₄</td> <td>-1</td> <td>-³/₄</td> <td>-²/₄</td> </tr> <tr> <td>Setting value</td> <td>1</td> <td>0</td> <td>A</td> <td>B</td> <td>C</td> <td>D</td> <td>E</td> <td>F</td> </tr> <tr> <td>Compensated stitches</td> <td>-¹/₄</td> <td>0</td> <td>+¹/₄</td> <td>+²/₄</td> <td>+³/₄</td> <td>+1</td> <td>+1¹/₄</td> <td>+1²/₄</td> </tr> </table>									Setting value	9	8	7	6	5	4	3	2	Compensated stitches	-2 ¹ / ₄	-2	-1 ³ / ₄	-1 ² / ₄	-1 ¹ / ₄	-1	- ³ / ₄	- ² / ₄	Setting value	1	0	A	B	C	D	E	F	Compensated stitches	- ¹ / ₄	0	+ ¹ / ₄	+ ² / ₄	+ ³ / ₄	+1	+1 ¹ / ₄	+1 ² / ₄
	Setting value	9	8	7	6	5	4	3	2																																						
Compensated stitches	-2 ¹ / ₄	-2	-1 ³ / ₄	-1 ² / ₄	-1 ¹ / ₄	-1	- ³ / ₄	- ² / ₄																																							
Setting value	1	0	A	B	C	D	E	F																																							
Compensated stitches	- ¹ / ₄	0	+ ¹ / ₄	+ ² / ₄	+ ³ / ₄	+1	+1 ¹ / ₄	+1 ² / ₄																																							
No. of tacking stitches (+) 15 stitches function BTP.	0608	O	OF	-	-	-	<i>bfP.</i>	<i>00</i> <i>0F</i>	ON OF	15 stitches are added to the set No. of start and end tacking stitches. For example, if the set No. of start tacking stitches is 4 stitches, the actual No. of start tacking stitches will be 19 stitches (4 + 15).																																					
No. of tacking stitches addition stitches function BTO.	0609	O	0	-	-	0 ~ 99	<i>bf0.</i>	**	**	[BTO] setting stitches are added to the set No. of start and end tacking stitches. For example, if the set No. of start tacking stitches is 4 stitches and [BTO] setting value is 20 stitches, the actual No. of start tacking stitches will be 24 stitches (4 + 20).																																					
Full heeling function immediately after start tacking stop BTT.	0610	O	ON	-	-	-	<i>bfT.</i>	<i>00</i> <i>0F</i>	ON OF	If full heeling is performed immediately after start tacking stops, end tacking will not be performed, and the sewing machine will stop after thread trimming.																																					
Not used. CSJ.	0611	O	OF	-	-	-	<i>CSJ.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.																																					
The speed operation mode when both the medium speed signal and S5V signal is ON SPN.	0612	O	OF	-	-	-	<i>SPn.</i>			When both the medium speed signal (medium speed run signal S5, medium speed command signal SPM) and the end tacking speed run signal S5V is ON, the speed operation mode can be set.																																					
								<i>0n</i>	ON	If both the medium speed signal (S5, SPM) and the end tacking speed run signal (S5V) is ON, the speed will be the start tacking speed N.																																					
								<i>0F</i>	OF	If both the medium speed signal (S5, SPM) and the end tacking speed run signal (S5V) is ON, the speed will be the end tacking speed V.																																					

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
D mode 	Set table types of tacking BTM.	0613	O	6	-	1 ~ 7	bfn.			Determine the type of tacking that can be set with the front and end tacking type ([B], [D] keys) in the tacking setting mode with setting values 1 to 7.
								1	1	Once tacking (V tacking)
								2	2	Double tacking (N tacking)
								3	3	Triple tacking (M tacking)
								4	4	4 repeat tacking (W tacking)
								5	5	5 repeat tacking
								6	6	6 repeat tacking
		7	7 repeat tacking							
	Input signal S7 operation mode during preset stitching S7M.	0614	O	OF	-	-	57n.	of	ON OF	If the backstitch related inputs are turned ON during preset stitching, the backstitch solenoid will turn ON.
	Manual backstitch ON timing 1 S7U.	0615	O	OF	-	-	57u.	of	ON OF	The backstitch solenoid drive timing by the backstitch signal S7 is synchronized with the UP position. (When this function setting is [OF] setting, it will be synchronized with the random position.)
Manual backstitch ON timing 2 S7D.	0616	O	OF	-	-	57d.	of	ON OF	The backstitch solenoid drive timing by the backstitch signal S7 is synchronized with the DOWN position. (When this function setting is [OF] setting, it will be synchronized with the random position.)	
The OFF timing setting of output B when the backstitching signal (S7) is OFF setting. 7BD.	0617	O	OF	-	-	7bd.	of	ON OF	When the manual backstitching signal (S7) is OFF setting, the OFF timing of the backstitching output B will be synchronized with the UP position. (When this function setting is [OF] setting, it will be synchronized with the DOWN position.)	
The maximum tacking stitches (maximum stitches is 99 stitches) BTN.	0618	O	OF	-	-	bfn.			The maximum tacking stitches can be set.	
							on	ON	The No. of maximum tacking stitches will be 99 stitches. The No. of start and end tacking stitches will be the same stitches, the No. of start and end tacking stitches A and D can be set by the 2 figures of [A] and [B] of the operation panel, and the No. of start and end tacking stitches B and C can be set by the 2 figures of [C] and [D] of the operation panel.	
							of	OF	The No. of maximum tacking stitches is 15 stitches.	
No. of end tacking stitches during direct heeling BCC.	0619	O	OF	-	-	bcc.	of	ON OF	The No. of end tacking stitches with direct heeling will be the No. of stitches C + 1 stitch when operation mode D1 is set to [D][M] during tacking.	
Operation mode during thread trimmer cancel signal [TL] setting TLS.	0620	O	OF	-	-	tls.	of	ON OF	The operation mode for when the thread trimmer cancel signal (TL) is input will be set.	
Input signal BTL quick pressing operation BTS.	0621	O	ON	-	-	bts.	of	ON OF	The tacking cancel signal [BTL] operation is set. [ON] The tacking operation is prohibited once after one pushing (OFF-ON-OFF) of the tacking cancel signal [BTL]. [OF] Tacking is prohibited while the tacking cancel signal [BTL] is ON.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
D mode 	Input signal SB and EB quick pressing operation BS.	0622	O	OF	-	-	<i>bs.</i>	<i>00</i> <i>0F</i>	ON OF	The start and end tacking cancel signals SE and EB operations are set. [ON] The start tacking operation is prohibited once after one pushing (OFF-ON-OFF) of the start tacking signal SE. (Same for end tacking cancel signal EB.) [OF] The start tacking operation is prohibited while the start tacking cancel signal SE is ON. (Same for end tacking cancel signal EB.)
	Operation when input signal BTL is ON BTD.	0623	O	OF	-	-	<i>btd.</i>	<i>00</i> <i>0F</i>	ON OF	When the tacking is set to OFF, if tacking cancel signal (BTL) turns ON, the tacking will be permitted. (When this function is set to OFF, the tacking will be prohibited.)
	Operation when input signal SB and EB tacking OFF are set BD.	0624	O	OF	-	-	<i>bd.</i>	<i>00</i> <i>0F</i>	ON OF	If the start tacking validity ([A] key) is set to OFF (-) in the tacking setting mode, start tacking can be validated by turning the start tacking cancel signal SE ON. (Same for end tacking cancel signal EB.)
	End tacking cancel mode with input signal PSU PNE.	0625	O	OF	-	-	<i>pnē.</i>	<i>00</i> <i>0F</i>	ON OF	When end tacking is set, if the needle UP position priority stop signal PSU turns ON during operation, the end tacking will not be executed after stopping at the needle UP position. After thread trimming, the presser foot will lift.
	The buzzer of control panel validity BZ.	0626	O	ON	-	-	<i>bz.</i>	<i>00</i> <i>0F</i>	ON OF	The buzzer of control panel will be validated.

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
E mode 	Error code (The last error code) 1.	0700	O	E--	-	-	1.	E--	E--	The last error code is displayed.
	Error code (The second to last code) 2.	0701	O	E--	-	-	2.	E--	E--	The second to last code is displayed.
	Error code (The third to last code) 3.	0702	O	E--	-	-	3.	E--	E--	The third to last code is displayed.
	Error code (The fourth to last code) 4.	0703	O	E--	-	-	4.	E--	E--	The fourth to last code is displayed.
	Total integration time of power on P.	0704	O	0	X10 hours	0 ~ 9999	P.	****	****	Display total integration time of power on
	Total integration time of motor run M.	0705	O	0	X10 hours	0 ~ 9999	M.	****	****	Display total integration time of motor run
	Input signal IA display IA.	0706	O	-	-	-	IA.	00 FF	ON OF	The input status (ON/OFF) of the input signal IA.
	Input signal IB display IB.	0707	O	-	-	-	IB.	00 FF	ON OF	The input status (ON/OFF) of the input signal IB.
	Input signal IC display IC.	0708	O	-	-	-	IC.	00 FF	ON OF	The input status (ON/OFF) of the input signal IC.
	Input signal ID display ID.	0709	O	-	-	-	ID.	00 FF	ON OF	The input status (ON/OFF) of the input signal ID.
	Input signal IE display IE.	0710	O	-	-	-	IE.	00 FF	ON OF	The input status (ON/OFF) of the input signal IE.
	Input signal IF display IF.	0711	O	-	-	-	IF.	00 FF	ON OF	The input status (ON/OFF) of the input signal IF.
	Input signal IG display IG.	0712	O	-	-	-	IG.	00 FF	ON OF	The input status (ON/OFF) of the input signal IG.
	Input signal IH display IH.	0713	O	-	-	-	IH.	00 FF	ON OF	The input status (ON/OFF) of the input signal IH.
	Input signal II display II.	0714	O	-	-	-	II.	00 FF	ON OF	The input status (ON/OFF) of the input signal II.
	Input signal IJ display IJ.	0715	O	-	-	-	IJ.	00 FF	ON OF	The input status (ON/OFF) of the input signal IJ.
	Input signal IK display IK.	0716	O	-	-	-	IK.	00 FF	ON OF	The input status (ON/OFF) of the input signal IK.
	Input signal IL display IL.	0717	O	-	-	-	IL.	00 FF	ON OF	The input status (ON/OFF) of the input signal IL.
Input signal IP display IP.	0718	O	-	-	-	IP.	00 FF	ON OF	The input status (ON/OFF) of the input signal IP.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
E mode 	Input signal IQ display	IQ.	0719	O	-	-	iq	00 FF	ON OF	The input status (ON/OFF) of the input signal IQ.	
	Input signal IR display	IR.	0720	O	-	-	ir	00 FF	ON OF	The input status (ON/OFF) of the input signal IR.	
	Input signal I1 display	I1.	0721	O	-	-	i1	00 FF	ON OF	The input status (ON/OFF) of the input signal I1.	
	Input signal I2 display	I2.	0722	O	-	-	i2	00 FF	ON OF	The input status (ON/OFF) of the input signal I2.	
	Input signal I4 display	I4.	0723	O	-	-	i4	00 FF	ON OF	The input status (ON/OFF) of the input signal I4.	
	Input signal I5 display	I5.	0724	O	-	-	i5	00 FF	ON OF	The input status (ON/OFF) of the input signal I5.	
	Encoder signal display (A phase)	ECA.	0725	O	-	-	ECa	00 FF	ON OF	The input status (ON/OFF) of the motor encoder A phase is displayed.	
	Encoder signal display (B phase)	ECB.	0726	O	-	-	ECb	00 FF	ON OF	The input status (ON/OFF) of the motor encoder B phase is displayed.	
	Detector signal display (UP signal)	UP.	0731	O	-	-	UP	00 FF	ON OF	The input status (ON/OFF) of the detector UP signal is displayed.	
	Detector signal display (DN signal)	DN.	0732	O	-	-	dn	00 FF	ON OF	The input status (ON/OFF) of the detector DN signal is displayed.	
	Display the angle from down position	DR.	0733	O	-	X2 degree	0 ~ 180	dr	***	***	Display the angle of current position from down position.
	Display the voltage of VC	VC.	0734	O	-	-	0 ~ 3FF	vc	***	***	The numerical value that is equivalent to the variable speed voltage VC with the option B connector is displayed. Display range: 000 ~ 3FF
	Display the voltage of VC2	V2.	0736	O	-	-	0 ~ 3FF	vc2	***	***	The numerical value that is equivalent to the variable speed voltage VC2 with the option B connector is displayed. Display range: 000 ~ 3FF
	Output signal OA display	OAD.	0737	O	-	-	-	oAd	00 FF	ON OF	The output status (ON/OFF) of the output signal OA.
	Output signal OB display	OBD.	0738	O				obd	00 FF	ON OF	The output status (ON/OFF) of the output signal OB.
	Output signal OC display	OCD.	0739	O				ocd	00 FF	ON OF	The output status (ON/OFF) of the output signal OC.
	Output signal OD display	ODD.	0740	O				odd	00 FF	ON OF	The output status (ON/OFF) of the output signal OD.
Output signal OF display	OFD.	0741	O				ofd	00 FF	ON OF	The output status (ON/OFF) of the output signal OF.	
Output signal O1 display	O1D.	0742	O				o1d	00 FF	ON OF	The output status (ON/OFF) of the output signal O1.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
E mode 	Output signal O2 display	O2D.	0743	O			<i>o2d.</i>	<i>o2</i> <i>of</i>	ON OF	The output status (ON/OFF) of the output signal O2.	
	Output signal O3 display	O3D.	0744	O			<i>o3d.</i>	<i>o3</i> <i>of</i>	ON OF	The output status (ON/OFF) of the output signal O3.	
	Output signal O4 display	O4D.	0745	O			<i>o4d.</i>	<i>o4</i> <i>of</i>	ON OF	The output status (ON/OFF) of the output signal O4.	
	Output signal O5 display	O5D.	0746	O			<i>o5d.</i>	<i>o5</i> <i>of</i>	ON OF	The output status (ON/OFF) of the output signal O5.	
	Output signal O6 display	O6D.	0747	O			<i>o6d.</i>	<i>o6</i> <i>of</i>	ON OF	The output status (ON/OFF) of the output signal O6.	
	Output signal O7 display	O7D.	0748	O			<i>o7d.</i>	<i>o7</i> <i>of</i>	ON OF	The output status (ON/OFF) of the output signal O7.	
	Output signal OP display	OPD.	0749	O			<i>opd.</i>	<i>op</i> <i>of</i>	ON OF	The output status (ON/OFF) of the output signal OP.	
	Output signal OQ display	OQD.	0750	O			<i>o9d.</i>	<i>o9</i> <i>of</i>	ON OF	The output status (ON/OFF) of the output signal OQ.	
	Output signal OR display	ORD.	0751	O			<i>ord.</i>	<i>or</i> <i>of</i>	ON OF	The output status (ON/OFF) of the output signal OR.	
	Solenoid output of output signal OA	OAO.	0752	X	-	-	-	<i>o8a.</i>	<i>o8</i> <i>of</i>	ON OF	The output status (ON/OFF) of the solenoid output OA with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.
	Solenoid output of output signal OB	OBO.	0753	X	-			<i>oba.</i>	<i>ob</i> <i>of</i>	ON OF	The output status (ON/OFF) of the solenoid output OB with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.
	Solenoid output of output signal OC	OCO.	0754	X	-			<i>oca.</i>	<i>oc</i> <i>of</i>	ON OF	The output status (ON/OFF) of the solenoid output OC with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.
	Solenoid output of output signal OD	ODO.	0755	X	-			<i>oda.</i>	<i>od</i> <i>of</i>	ON OF	The output status (ON/OFF) of the solenoid output OD with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.
	Solenoid output of output signal OF	OFO.	0756	X	-			<i>ofa.</i>	<i>of</i> <i>of</i>	ON OF	The output status (ON/OFF) of the solenoid output OF with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.
	Solenoid output of output signal O1	O1O.	0757	X	-			<i>o1a.</i>	<i>o1</i> <i>of</i>	ON OF	The output status (ON/OFF) of the solenoid output O1 with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.
Solenoid output of output signal O2	O2O.	0758	X	-			<i>o2a.</i>	<i>o2</i> <i>of</i>	ON OF	The output status (ON/OFF) of the solenoid output O2 with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.	
Solenoid output of output signal O3	O3O.	0759	X	-			<i>o3a.</i>	<i>o3</i> <i>of</i>	ON OF	The output status (ON/OFF) of the solenoid output O3 with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
E mode    	Output for small signal of output signal O4	O4O.	0760	X	-		04o.	0n 0f	ON OF	The output status (ON/OFF) of the solenoid output O4 with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.		
	Solenoid output of output signal O5	O5O.	0761	X	-		05o.	0n 0f	ON OF	The output status (ON/OFF) of the solenoid output O5 with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.		
	Electromagnetic value output of output signal O6	O6O.	0762	X	-		06o.	0n 0f	ON OF	The output status (ON/OFF) of the solenoid output O6 with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.		
	Electromagnetic value output of output signal O7	O7O.	0763	X	-		07o.	0n 0f	ON OF	The output status (ON/OFF) of the solenoid output O7 with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.		
	LED output for G500 type control panel	OPO.	0764	X	-		0Po.	0n 0f	ON OF	The output status (ON/OFF) of the solenoid output OP with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.		
	LED output for G500 type control panel	OQO.	0765	X	-		0Qo.	0n 0f	ON OF	The output status (ON/OFF) of the solenoid output OQ with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.		
	LED output for G500 type control panel	ORO.	0766	X	-		0ro.	0n 0f	ON OF	The output status (ON/OFF) of the solenoid output OR with the [D, ==>] key ON/OFF is changed. Do not turn the O4 to O7 outputs ON/OFF with the [D, ==>] key.		
	Rated output display	WT.	0767	O	**	watt	-	8r.				The motor's rated output value is displayed.
									75	75	Refers to 750W.	
									55	55	Refers to 550W.	
	Voltage display	VL.	0768	O	***	volt	-	uL.				The rated input voltage value in the control box is displayed.
									100	100	Refers to 100V class.	
									200	200	Refers to 200V class.	
	Model display	TP.	0769	O	-	-	-	rP.				The control box model name is displayed.
NFY									MFY	XC-GMFY		
Data version No.	DV.	0770	O	***	-	-	du.	***	***	The data version No. (3-digit alpha-numeral) of the EEPROM is displayed.		
Software version No.	RV.	0771	O	***	-	-	ru.	***	***	The version No. (3-digit alpha-numeral) of the software is displayed.		
Display previous simple setting selected.	T.	0772	O	-	-	-	r.	****	****	Display previous simple setting selected.		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
F mode 	Set No. of stitches A for cutter output (Setting the delay time during chain-off output ON)	COA.	0800	O	0	stitches	0 ~ 99	CoA.	**	**	The No. of stitches A (delay during chain-off output ON) for chain-off output operation can be set. When CTR = ON, the No. of stitches for cutter output OFF can be set.
	Set No. of stitches B for cutter output (Setting the delay time during chain-off output OFF)	COB.	0801	O	0	stitches	0 ~ 99	CoB.	**	**	The No. of stitches B (delay during chain-off output OFF) for chain-off output operation can be set. When CTR = ON, the No. of stitches for cutter output ON can be set.
	Set No. of stitches C for cutter output	COC.	0802	O	0	stitches	0 ~ 99	CoC.	**	**	The No. of stitches C (delay during cutter output ON) during cutter output operation can be set.
	No. of stitches for BT output ON after sensor OFF setting	X.	0803	O	0	stitches	0 ~ 99	X.	**	**	The No. of stitches to be stitched before the output BT for the in-tacking signal is turned ON after the sensor turns OFF can be set.
	No. of stitches for sewing machine stops after BT output ON setting	Y.	0804	O	0	stitches	0 ~ 99	Y.	**	**	The No. of stitches to be stitched before the sewing machine stops after the output BT for the in-tacking signal turns ON can be set.
	No. of stitches for BT output OFF after start of stitching setting	Z.	0805	O	12	stitches	1 ~ 99	Z.	**	**	The No. of stitches to be stitched before the output BT for in-tacking signal is turned OFF after stitching is started can be set.
	Delay time to when SL output turns from OFF to ON	SD.	0806	O	0	msec	0 ~ 508	SD.	***	***	The delay time for the output SL to turn from OFF to ON can be set in 2msec intervals. The cutter output time setting is also possible.
	Delay time to when SL output turns from ON to OFF	ED.	0807	O	0	msec	0 ~ 508	Ed.	***	***	The delay time for the output SL to turn from ON to OFF can be set in 2msec intervals. The chain-off output mesh judgment time setting is also possible.
	No. of set stitches during SL output ON selection mode	SLH.	0808	O	OF	-	-	SLH.			The No. of set stitches for the output SL can be selected from HOF set No. of stitches (during ON setting) or SLN set No. of stitches (during OFF setting).
									ON	ON	Setting HOF function in G mode.
									OF	OF	Setting SLN function in P mode.
	SL output start position setting	SLK.	0809	O	OF	-	-	SLK.	ON OF	ON OF	The output of SL for thread dislocation prevention starts when the needle lift operation (US, U, UF) is completed.
SL output start position during SLS function ON setting	SLT.	0810	O	OF	-	-	SLT.	ON OF	ON OF	When the SL output operation mode SLS is ON while the motor is stopped, the output of SL for thread dislocation prevention will start after the thread is trimmed.	
Speed limit M except tacking and SL on	SLL.	0811	O	OF	-	-	SLL.	ON OF	ON OF	If the output SL turns ON during an operation other than tacking, the speed is limited to that set in the medium speed M.	
SL output operation during motor stopping	SLS.	0812	O	OF	-	-	SLS.	ON OF	ON OF	The output SL is ON even when the motor is stopped.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
F mode 	OT1 output blower output setting	O1B.	0813	O	OF	-	-	o 1b.	ON OF	ON OF	Virtual output OT1 will be set to blower output of cutter function.	
	OT2 output chain-off output setting	O2M.	0814	O	OF	-	-	o 2n.	ON OF	ON OF	Virtual output OT2 can be used as the chain-off output.	
	OT3 output cutter output setting	O3M.	0815	O	OF	-	-	o 3n.	ON OF	ON OF	Virtual output OT3 can be used as the cutter output.	
	Mesh judgment control with I*2 input	I2M.	0816	O	OF	-	-	. 2n.	ON OF	ON OF	The mesh judgment control of cutter specification is added to chain-off output. Refer to the section for details on the IO2, IR2 and IS2 signal function.	
	Setting I*3 signal for manual cutter output	CTY.	0817	O	OF	-	-	[C Y .	ON OF	ON OF	When the IO3, IR3 and IS3 signals are ON, the output is set to the manual cutter output. Refer to the section for details on the IO3, IR3 and IS3 signal function.	
	Status of cutter output photo switch (I*2) signal according to OT3 output	CTM.	0818	O	OF	-	-	[C n .				The change status of the IO2, IR2 signal photo switch that outputs the cutter output by the virtual output OT3 can be selected. Refer to the section for details on the IO2, IR2 signal function. The OT3 output time is SD. It is possible to set it by the function.
									ON	ON	The cutter output by the OT3 is output at both changes (OFF=>ON) (ON=>OFF) of the IO2, IR2 signal photo switch.	
									OF	OF	The cutter output by the OT3 is output at only the (ON=>OFF) change of the IO2, IR2 signal photo switch.	
	Turn OT3 output ON/OFF per set No. of stitches when I*3 signal is ON	CTR.	0819	O	OF	-	-	[C r .	ON OF	ON OF	When the IO3, IR3 and IS3 signals are ON, the virtual output OT3 is turned ON/OFF per set No. of stitches. (When this is turned ON, the cutter specifications by the sensor will be invalidated.) The set No. of stitches can be set with the cutter specifications No. of stitches A (non-stitching chain ON delay) setting COA function, cutter specifications No. of stitches B (non-stitching chain ON delay) setting COB function and the cutter specifications No. of stitches C (non-stitching chain ON delay) setting COC function. Refer to the section for details on the IO3, IR3 and IS3 signal function.	
	Automatic cutter output prohibit during sensor ON	CSC.	0820	O	OF	-	-	[S C .	ON OF	ON OF	The output of the automatic cutter output is prohibited while the sensor is ON.	
Automatic cutter output prohibit during sensor OFF	CEC.	0821	O	OF	-	-	[E C .	ON OF	ON OF	The output of the automatic cutter output is prohibited while the sensor is OFF.		
Cutter output prohibit when sensor is ON while stopped	CTS.	0822	O	OF	-	-	[C S .	ON OF	ON OF	The output of the automatic cutter output is prohibited when the sensor input is ON while the sewing machine is stopped.		
Automatic thread trim setting after cutter sensor is turned off	CAT.	0823	O	OF	-	-	[A T .	ON OF	ON OF	Automatic stops and trim setting, after the cutter sensor is turned off and then the number of stitch "C" set by "COC" function is run.		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
F mode 	Set I*1 input, OP1 output to cutter BT specifications input/output	CTL.	0824	O	OF	-	-			ON OF	The IO1, IR1 and ISI signals and the run output OP1 are set to the cutter BT specifications input/output signals. Refer to the section for details on the IO1, IR1 and IS1 signal function.
	Preset stitching operation after operation signal OFF	NMD.	0825	O	OF	-	-			ON OF	Only the preset No. of stitches is stitched after the operation signal (S1) is turned OFF.
	ROL output mode	RLM.	0826	O	OF	-	-			ON OF	The roller lift output ROL will turn ON when presser foot lifting output FU, back tacking output B, virtual output OT2 are ON, and during tacking and thread trimming.
	No. of stitches setting for auxiliary feeding rear roller	RLN.	0827	O	0	stitches	0 ~ 99		**	**	The roller lower No. of stitches is set for the auxiliary feeding rear roller.
	Not used.	CTG.	0828		OF	-	-			ON OF	Not used.
	Not used.	CGD.	0829		OF	-	-			ON OF	Not used.
	Not used.	EDT.	0830		OF	-	-			ON OF	Not used.
	Not used.	EDS.	0831		0	stitches	0 ~ 99		**	**	Not used.
	Not used.	CAS.	0832		OF	-	-			ON OF	Not used.
Not used.	ESC.	0833		OF	-	-			ON OF	Not used.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
G mode 	Thread trimming mode TR.	0900	O	M1	-	-	TR.	***	***	The thread trimming timing for each manufacturer's thread trimming sewing machine can be set. Same function as the P mode thread trimming mode [TR]. When [PRG] is set, the sewing machine operation and thread trimming timing can be set when combined with the functions [TRM], [LTM] or [LLM].	
	Motor operation mode during thread trimming TRM.	0901	O	LK	-	-	TRM.				The motor operation mode during thread trimming can be set when thread trimming mode TR is set to [PRG].
								Lt	LK	The motor will run for the lockstitch thread trimming sewing machine.	
								rt	RK	The motor will run for reverse thread trimming.	
								LR	KA	Not used.	
								Lb	KB	Not used.	
								UP	UP	Not used.	
	dn	DN	Not used.								
	Thread trimming output (T) output mode LTM.	0902	O	T1	-	-	LTM.				The output timing mode of the thread trimming output (T) can be set when thread trimming mode TR is set to [PRG].The output timing of the thread trimming output [T] can be set. (Lock stitch setting) It becomes effective when the thread trimming mode [TR] sets [PRG]. Refer to "[15] 1. Thread trimming timing when thread trimming mode TR setting is PRG." for details of output timing.
								T1	Please refer to the LTM setting of string swithing off output T which has been described to the technical information.		
								T2	Please refer to the LTM setting of string swithing off output T which has been described to the technical information.		
								T3	Please refer to the LTM setting of string swithing off output T which has been described to the technical information.		
								T4	Please refer to the LTM setting of string swithing off output T which has been described to the technical information.		
								TK	Not used.		
								TS	Not used.		
T7								Please refer to the LTM setting of string swithing off output T which has been described to the technical information.			
Thread release output (L) output mode LLM.	0903	O	L1	-	-	LLM.				The output timing mode of the thread release output (L) can be set when thread trimming mode TR is set to [PRG].The output timing of the thread release output [L] can be set.(Lock stitch setting) It becomes effective when the thread trimming mode [TR] sets [PRG]. Refer to "[15] 1. Thread trimming timing when thread trimming mode TR setting is PRG." for details of output timing.	
							L1	Please refer to the LLM setting of string loosening output L which has been described to the technical information.			
							L2	Please refer to the LLM setting of string loosening output L which has been described to the technical information.			
							L3	Please refer to the LLM setting of string loosening output L which has been described to the technical information.			

**CONTINUED ON THE
NEXT PAGE**

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
G mode 	CONTINUED FROM PREVIOUS PAGE							L4	L4	Please refer to the LLM setting of string loosening output L which has been described to the technical information.	
								L6	LK	Not used.	
								L5	LS	Not used.	
								L7	L7	Please refer to the LLM setting of string loosening output L which has been described to the technical information.	
	Thread trimming output start angle	TS.	0904	O	0	degree	0 ~ 360	r5.	***	***	When the thread trimming mode TR is set to [PRG], the output start angle of the thread trimming output (T) can be set. Set according to the thread trimming output (T) timing chart.
	Thread trimming output angle	TE.	0905	O	90	degree	0 ~ 360	rE.	***	***	When the thread trimming mode TR is set to [PRG], the output end angle of the thread trimming output (T) can be set. Set according to the thread trimming output (T) timing chart.
	Thread release output start angle	LS.	0906	O	0	degree	0 ~ 360	L5.	***	***	When the thread trimming mode TR is set to [PRG], the output start angle of the thread release output (L) can be set. Set according to the thread release output (L) timing chart.
	Thread release output angle	LE.	0907	O	90	degree	0 ~ 360	LE.	***	***	When the thread trimming mode TR is set to [PRG], the output end angle of the thread release output (L) can be set. Set according to the thread release output (L) timing chart.
	Thread trimming output start time	T1.	0908	O	20	msec	0 ~ 998	r1.	***	***	The output start time of the thread trimming output (T) for chain stitch sewing machine can be set. When the thread trimming mode TR is set to [PRG], the output start time of the thread trimming output (T) for lock stitch sewing machine can be set. Set according to the thread trimming output (T) timing chart.
	Thread trimming output time	T2.	0909	O	90	msec	0 ~ 998	r2.	***	***	The output time of the thread trimming output (T) for chain stitch sewing machine can be set. When the thread trimming mode TR is set to [PRG], the output time of the thread trimming output (T) for lock stitch sewing machine can be set. Set according to the thread trimming output (T) timing chart.
Thread release output start time	L1.	0910	O	150	msec	0 ~ 998	L1.	***	***	The output start time of the thread release output (L) for chain stitch sewing machine can be set. The output start time of the thread release output (L) during chain stitching thread trimming timing A can be set. The chain stitching thread trimming timing B is invalid at this time. When the thread trimming mode TR is set to [PRG], the output start time of the thread release output (L) for lock stitch sewing machine can be set. Set according to the thread release output (L) timing chart.	
Thread release output time	L2.	0911	O	70	msec	0 ~ 998	L2.	***	***	The output time of the thread release output (L) for chain stitch sewing machine can be set. The output time of the thread release output (L) during chain stitching thread trimming timing A can be set. The chain stitching thread trimming timing B is invalid at this time. Set according to the thread release output (L) timing chart. When the thread trimming mode TR is set to [PRG], the output time of the thread release output (L) for lock stitch sewing machine can be set. Set according to the thread release output (L) timing chart.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
G mode    	Thread release output start time (Output TF start time) R1.	0912	O	40	msec	0 ~ 508	<i>r 1.</i>	***	***	The output start time of the thread release output (L) during chain stitching thread trimming timing B can be set. The chain stitching thread trimming timing A is invalid at this time. The output start time of the output (TF) can be set. Set according to teach output's timing chart.	
	Thread release output time (TF output time) R2.	0913	O	66	msec	0 ~ 508	<i>r 2.</i>	***	***	The output time of the thread release output (L) during chain stitching thread trimming timing B can be set. The chain stitching thread trimming timing A is invalid at this time. The output time of the output (TF) can be set. Set according to teach output's timing chart.	
	Condensed stitching start time (Stop time before thread trimming) R3.	0914	O	50	msec	0 ~ 508	<i>r 3.</i>	***	***	The time to when the sewing machine begins condensed stitching after the condensed stitching(CH) turn ON during start/end condensed stitching can be set. However, during the end condensed stitching in the chain stitching thread trimming timing B, this time [R3] will be the time for end condensed stitching after the thread release output (L) turns OFF. (If end condensed stitching is not set, the time will be that for the needle to rise from the DOWN to UP position after the thread release output (L) is turned OFF.)	
	Wiper output start time W1.	0915	O	10	msec	0 ~ 998	<i>W 1.</i>	***	***	When the thread trimming mode TR is set to [PRG], the output start time of the wiper output (W) can be set. Set according to the wiper output (W) timing chart.	
	Wiper output time W2.	0916	O	8	X10 msec	0 ~ 999	<i>W 2.</i>	***	***	When the thread trimming mode TR is set to [PRG], the output time of the wiper output (W) can be set. Set according to the wiper output (W) timing chart.	
	Wiper output operation mode WMD.	0917	O	W	-	-	-	<i>WMD.</i>			The output timing mode of the wiper output (W) can be set. The timing that the wiper output W is turned OFF can be set with the thread trimming signal S2. Refer to "[15] 2. Wiper output timing." for details on setting the OFF timing.
									<i>W</i>	W	If the S2 signal turns OFF within the wiper output W set time, the W output will turn OFF after the set time has passed. If the S2 signal turns OFF after the wiper output W set time has passed, the W output will turn OFF after the set time has passed.
									<i>OR</i>	OR	If the S2 signal turns OFF within the wiper output W set time, the W output will turn OFF after the set time has passed. If the S2 signal turns OFF after the wiper output W set time has passed, the W output will turn OFF when the S2 signal turns OFF.
<i>AN</i>									AN	If the S2 signal turns OFF within the wiper output W set time, the W output will turn OFF when the S2 signal turns OFF. If the S2 signal turns OFF after the wiper output W set time passes, the W output will turn OFF after the set time has passed.	
<i>RU</i>									RU	This setting is valid when the reverse run needle setting after thread trimming RU is ON. When the reverse run needle lifting is completed after the thread is trimmed, the W output will turn ON. If the S2 signal turns OFF within the wiper output W set time, the W output will turn OFF after the set time has passed. If the S2 signal turns OFF after the wiper output W set time has passed, the W output will turn OFF after the set time has passed.	
<i>CH</i>	CH	Not used.									
<i>FW</i>	FW	Not used.									

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
G mode  +  + 	Presser foot lifting output start time	F1.	0918	O	140	msec	0 ~ 998	<i>F1.</i>	***	***	When the thread trimming mode TR is set to [PRG], the output start time for the presser foot lifting output (FU) is set. Set according to the presser foot lifting output (FU) timing chart.
	Time to motor drive after presser foot lifter bring down	FD.	0919	O	176	msec	0 ~ 998	<i>Fd.</i>	***	***	The time for the motor to start driving after the presser foot output FU is turned OFF when pedal toe down or external run signal (S0, S1) ON during presser foot lifting can be set in 2 millisecond units.
	Interlock time during thread trimming	IL.	0920	O	140	msec	0 ~ 998	<i>IL.</i>	***	***	The interlock time that prohibits operation during thread trimming can be set. Manual calculation will be used during the [P] mode thread trimming (TR) timing [PRG], [KA3], [KA4], [KB3], [KB4], so the setting is valid. [KA1], [KA2], [KB1], [KB2] are for automatic calculation and cannot be set
	Interlock time during no thread trimming	IT.	0921	O	0	msec	0 ~ 510	<i>IT.</i>	***	***	The interlock time during the no thread trimming timing can be set. This is valid when the [P] mode thread trimming timing [NO] or thread trimming release signal (TL) is turned ON.
	Motor rotation after motor stop before thread trimming	TDS.	0922	O	OF	-	-	<i>TDS.</i>	<i>OF</i>	ON OF	After the motor stops, it will start rotating after the thread trimming output T turns ON and the delay time has passed. The delay time can be set by the [TD] function.
	Motor stop time during lockstitch and R output time during chain stitch	TD.	0923	O	50	msec	0 ~ 508	<i>Td.</i>	***	***	The motor stop time before thread trimming during lock stitch can be set in 2msec intervals. The output R output time during chain stitch can be set in 2msec. When the chain stitch mode is set, it is possible to set to the delay time of the motor "R3".
	Delay setting before reverse run during RU setting	RUS.	0924	O	OF	-	-	<i>RUS.</i>	<i>OF</i>	ON OF	Delay time before reverse run (RU operation) after thread trimming is completed can be set with RT when the thread trimming reverse needle lift RU is set to ON.
	Delay time before reverse run during RU setting	RT.	0925	O	76	msec	0 ~ 508	<i>RT.</i>	<i>OF</i>	ON OF	When reverse needle lift after thread trimming RU is ON and RUS is ON, the delay time before the motor reverse run after thread trimming can be set in 2msec intervals.
	Reverse run needle lifting [RU] after output T, L and W	RUM.	0926	O	OF	-	-	<i>RUM.</i>	<i>OF</i>	ON OF	Change [RU] function for chain stitch type. "OF" is factory setting for lock stitch (Reverse run after T) "ON" is for chain stitch (Reverse run after T, L and W)
	Wiper output OFF trimming with (S1) signal	WS1.	0927	O	OF	-	-	<i>WS1.</i>	<i>OF</i>	ON OF	If the pedal is toed down or external output signal (S1) is turned ON during the wiper output time [W2] (after thread trimming interlock time), the wiper output time [W] will turn OFF. The presser foot lifting output (FU) will also turn OFF simultaneously, and the sewing machine will run after the [FD] time. Use this for the air type wiper. This is effective for standing operation (automatic machine operation).
Operation mode with thread trimming signal to shift the needle stop position and return to the original needle stop position before the thread trimming signal	S2T.	0928	O	OF	-	-	<i>S2T.</i>				If the sewing machine pulley is rotated by hand and set to 1 position while the sewing machine is stopped before thread trimming, if the needle UP position is 2 position, the needle DOWN position will shift. To return to the original stop position after that, fully heel the pedal, or set the operation mode by turning thread trimming signal (S2) ON. The same operation as then next [S2P] setting value ([NO], [TR], [PS]) is executed. The thread trimming operation is executed according to the thread trimming mode TR setting value ([KA1], [KA2], etc.).
								<i>ON</i>	ON		
								<i>OF</i>	OF		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
G mode 	Operation mode with thread trimming signal when shifting the needle stop position before the thread trimming signal S2P.	0929	O	TR	-	-	S2P.			The operation mode started with the full pedal heeling or thread trimming signal (S2) ON when rotating the sewing machine pulley, etc., manually, and leaving the UP position when in 1 position, and leaving the DOWN position when in 2 position.
								Tr	TR	When [KA1] to [KA4] of the thread trimming mode [TR] are set, the thread trimming operation will be performed according to the settings after the needle is lifted. When [KB1] to [KB4] are set, the thread trimming operation will be performed according to the settings after the needle is lowered.
								PS	PS	The presser foot lifting operation will be executed after the needle is lifted. The thread trimming operation will not be executed.
								no	NO	The sewing machine does not rotate or perform thread trimming, and only the presser foot lifting operation is executed.
	Solenoid output OT1 manual/automatic change MAN.	0930	O	ON	-	-	MAN.	ON OF	ON OF	The change of the solenoid output [OT1] manual/automatic output is selected. The solenoid output [OT1] will be set to manual. The solenoid input signal IO1 is validated. The solenoid output [OT1] will be set to automatic. The solenoid input signal IO1 is invalidated.
	Setting of no. of stitches during MAN [OFF] setting HOF.	0931	O	7	stitches	0 ~ 99	HOF.	**	**	This is valid when the solenoid output [OT1] manual/automatic output change is set to automatic. If the pedal is toed down or the external run signal (S00, S1, SH) is turned ON while the solenoid output [OT1] is ON, the OT1 output will turn OFF after the set No. of stitches.
	Weak brake ON simultaneously with wiper output (W) WB.	0932	O	OF	-	-	WB.	ON OF	ON OF	The weak brake will turn ON when the wiper output (W) turns ON.
	Motor rotation operation when LTM function is set to T1, T2 or T3 TD.	0933	O	OF	-	-	TD.	ON OF	ON OF	When the thread trimming output T mode LTM for lockstitch is set to [T1], [T2] or [T3], after the motor stops, it will start again after the thread trimming output T turns ON and the delay time has passed. Set time can be set by the [TD] function.
	Not used C1.	0934	O	0	-	0 ~ 99	C1.	**	**	Not used.
	Not used C2.	0935	O	0	-	0 ~ 99	C2.	**	**	Not used.
	Not used C3.	0936	O	0	-	0 ~ 99	C3.	**	**	Not used.
	Not used T3.	0937	O	0	-	0 ~ 998	T3.	***	***	Not used.
	Not used T4.	0938	O	0	-	0 ~ 998	T4.	***	***	Not used.
	Not used T5.	0939	O	0	-	0 ~ 998	T5.	***	***	Not used.
Not used PET.	0940	O	OF	-	-	PET.	ON OF	ON OF	Not used.	
Not used P9U.	0941	O	OF	-	-	P9U.	ON OF	ON OF	Not used.	
Not used HHC.	0942	O	OF	-	-	HHC.	ON OF	ON OF	Not used.	

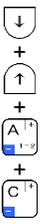
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
G mode 	Not used	PAA.	0943	O	OF	-	-	<i>PAR</i>	<i>ON</i> <i>OF</i>	ON OF	Not used.
	Not used	STL.	0944	O	OF	-	-	<i>SFL</i>	<i>ON</i> <i>OF</i>	ON OF	Not used.
	Not used	L8.	0945	O	0	-	-98 ~ 98	<i>L8.</i>	***	***	Not used.
	Not used	PEK.	0946	O	OF	-	-	<i>PEE.</i>	<i>ON</i> <i>OF</i>	ON OF	Not used.
	Setting A which can be used by step sequence	PPA.	0947	O	OF	-	-	<i>PPA.</i>	<i>ON</i> <i>OF</i>	ON OF	Setting A which can be used by step sequence
	Setting B which can be used by step sequence	PPB.	0948	O	OF	-	-	<i>PPb.</i>	<i>ON</i> <i>OF</i>	ON OF	Setting B which can be used by step sequence
	Setting C which can be used by step sequence	PPC.	0949	O	OF	-	-	<i>PPC.</i>	<i>ON</i> <i>OF</i>	ON OF	Setting C which can be used by step sequence
	Setting D which can be used by step sequence	PPD.	0950	O	OF	-	-	<i>PPd.</i>	<i>ON</i> <i>OF</i>	ON OF	Setting D which can be used by step sequence
	Setting E which can be used by step sequence	PPE.	0951	O	OF	-	-	<i>PPE.</i>	<i>ON</i> <i>OF</i>	ON OF	Setting E which can be used by step sequence
	Setting F which can be used by step sequence	PPF.	0952	O	OF	-	-	<i>PPF.</i>	<i>ON</i> <i>OF</i>	ON OF	Setting F which can be used by step sequence
	Setting G which can be used by step sequence	PPG.	0953	O	OF	-	-	<i>PPG.</i>	<i>ON</i> <i>OF</i>	ON OF	Setting G which can be used by step sequence
Setting H which can be used by step sequence	PPH.	0954	O	OF	-	-	<i>PPH.</i>	<i>ON</i> <i>OF</i>	ON OF	Setting H which can be used by step sequence	

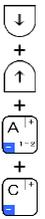
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
H mode 	Upper limit of maximum speed [H]	LHH.	1000	O	90	X100 rpm	0 ~ 99	LHH.	**	**	The upper limit value of the maximum speed [H] in P mode is set. A value that exceeds the value set in this limiter cannot be set for the maximum speed [H].
	Lower limit of maximum speed [H]	LHL.	1001	O	0	X100 rpm	0 ~ 99	LHL.	**	**	The lower limit value of the maximum speed [H] in P mode is set. A value that is lower than the value set in this limiter cannot be set for the maximum speed [H].
	Upper limit of low speed [L]	LLH.	1002	O	5	X100 rpm	0 ~ 99	LLH.	**	**	The upper limit value of the low speed [L] in P mode is set. A value that exceeds the value set in this limiter cannot be set for the low speed [L].
	Lower limit of low speed [L]	LLL.	1003	O	0	X100 rpm	0 ~ 99	LLL.	**	**	The lower limit value of the low speed [L] in P mode is set. A value that is lower than the value set in this limiter cannot be set for the low speed [L].
	Upper limit of thread trimming speed [T]	LTH.	1004	O	5	X100 rpm	0 ~ 99	LTH.	**	**	The upper limit value of the thread trimming speed [T] in P mode is set. A value that exceeds the value set in this limiter cannot be set for the thread trimming speed [T].
	Lower limit of thread trimming speed [T]	LTL.	1005	O	0	X100 rpm	0 ~ 99	LTL.	**	**	The lower limit value of the thread trimming speed [T] in P mode is set. A value that is lower than the value set in this limiter cannot be set for the thread trimming speed [T].
	Upper limit of start/end tacking (condensed stitching) speed	LNH.	1006	O	30	X100 rpm	0 ~ 99	LNH.	**	**	The upper limit value of the start/end tacking (condensed stitching) speed in P mode is set. A value that exceeds the value set in this limiter cannot be set for the start/end tacking (condensed stitching) speed.
	Lower limit of start/end tacking (condensed stitching) speed	LNL.	1007	O	0	X100 rpm	0 ~ 99	LNL.	**	**	The lower limit value of the start/end tacking (condensed stitching) speed in P mode is set. A value that is lower than the value set in this limiter cannot be set for the start/end tacking (condensed stitching) speed.
	Upper limit of medium speed [M]	LMH.	1008	O	90	X100 rpm	0 ~ 99	LMH.	**	**	The upper limit value of the medium speed [M] in P mode is set. A value that exceeds the value set in this limiter cannot be set for the medium speed [M].
	Lower limit of medium speed [M]	LML.	1009	O	0	X100 rpm	0 ~ 99	LML.	**	**	The lower limit value of the medium speed [M] in P mode is set. A value that is lower than the value set in this limiter cannot be set for the medium speed [M].
	Upper limit of slow start speed [S]	LSH.	1010	O	30	X100 rpm	0 ~ 99	LSH.	**	**	The upper limit value of the slow start speed [S] in P mode is set. A value that exceeds the value set in this limiter cannot be set for the slow start speed [S].
Lower limit of slow start speed [S]	LSL.	1011	O	0	X100 rpm	0 ~ 99	LSL.	**	**	The lower limit value of the slow start speed [S] in P mode is set. A value that is lower than the value set in this limiter cannot be set for the slow start speed [S].	

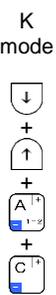
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMF Y			Digital display				
I mode	Save function 1 of the setting data	SAVE1.	-	X	-	-	-	SAVE 1.	-	-	It is possible to save the present data into the "Simple setting table". When this [SAVE] function is set, the setting data will be saved into the [LOAD1] on the program mode [1]. It is possible to load the saved data by the selection of [LOAD1] in the program mode [1].
	Save function 2 of the setting data	SAVE2.	-	X	-	-	-	SAVE 2.	-	-	It is possible to save the present data into the "Simple setting table". When this [SAVE] function is set, the setting data will be saved into the [LOAD2] on the program mode [1]. It is possible to load the saved data by the selection of [LOAD2] in the program mode [1].
	Current data is copied	CCR.	-	O	ON	-	-	CCR.	0F	ON OF	[ON] : All data but user 1 and 2 are copied.
	User 1 data is copied	CU1.	-	O	ON	-	-	CU 1.	0F	ON OF	[ON] : User 1 data is copied.
	User 2 data is copied	CU2.	-	O	ON	-	-	CU 2.	0F	ON OF	[ON] : User 2 data is copied.
<p>The explanation of [CCR], [CU1], and [CU2].</p> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="border: 1px solid black; padding: 5px; width: 20%;"> <p>Control box</p> <p>Current data Teaching data User customize data Backup data Step sequence data</p> <hr/> <p>User 1 data Step sequence data</p> <hr/> <p>User 2 data Step sequence data</p> </div> <div style="text-align: center; width: 40%;"> <p>[CCR] ON / OFF setting (Factory setting : ON)</p> <p>[CU1] ON / OFF setting (Factory setting : ON)</p> <p>[CU2] ON / OFF setting (Factory setting : ON)</p> </div> <div style="border: 1px solid black; padding: 5px; width: 20%;"> <p>XC-G500 Control panel</p> <p>Current data Teaching data User customize data Backup data Step sequence data</p> <hr/> <p>User 1 data Step sequence data</p> <hr/> <p>User 2 data Step sequence data</p> </div> </div> <p>LED corresponding to the setting lights while displaying the value in the control box.</p> <p>[CCR]=ON  [CU1]=ON  [CU2]=ON </p>											

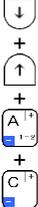
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
J mode    	Simple setting mode for [1],[2],[3] prohibit MAC.	1100	O	OF	-	-	MAC.	OF	ON OF	The simple setting mode (program mode [1]) cannot be entered.
	[P],[G] mode thread trimmer mode TR prohibit TRC.	1101	O	OF	-	-	TRC.	OF	ON OF	The [P] mode thread trimmer mode, TR cannot be entered program mode P will be possible.) The thread trimmer mode [G] cannot be entered.
	Rotation direction changeover prohibit CWC.	1102	O	OF	-	-	CWC.	OF	ON OF	Rotation direction changeover during the normal mode will not be possible.
	1-2 position changeover prohibit 12C.	1103	O	OF	-	-	12C.	OF	ON OF	1-2 position changeover ([A] key operation) during the normal mode will not be possible.
	Slow start changeover prohibit SLC.	1104	O	OF	-	-	SLC.	OF	ON OF	Slow start validity changeover ([B] key operation) during the normal mode will not be possible.
	Speed setting key changeover prohibit SPC.	1105	O	OF	-	-	SPC.	OF	ON OF	Speed setting operation of normal mode ([C] key and [D] key operation) will not be possible.
	Not used JKC.	1106	O	OF	-	-	JKC.	OF	ON OF	Not used.
	Start tacking validity changeover prohibit SBC.	1107	O	OF	-	-	SBC.	OF	ON OF	Start tacking validity changeover ([A] key operation) during the tacking mode will not be possible.
	No. of start tacking stitches changeover prohibit SNC.	1108	O	OF	-	-	SNC.	OF	ON OF	The No. of start tacking stitches setting ([A], [B] key operations) during the tacking mode will not be possible.
	End tacking validity changeover prohibit EBC.	1109	O	OF	-	-	EBC.	OF	ON OF	End tacking validity changeover ([C] key operation) during the tacking mode will not be possible.
	No. of end tacking stitches changeover prohibit ENC.	1110	O	OF	-	-	ENC.	OF	ON OF	The No. of end tacking stitches setting ([C], [D] key operations) during the tacking mode will not be possible.
	Start tacking type changeover prohibit SKC.	1111	O	OF	-	-	SKC.	OF	ON OF	Start tacking type setting ([B] key operation) during the tacking mode will not be possible.
	End tacking type changeover prohibit EKC.	1112	O	OF	-	-	EKC.	OF	ON OF	End tacking type setting ([D] key operation) during the tacking mode will not be possible.
	Pattern stitching validity changeover prohibit TSC.	1113	O	OF	-	-	TSC.	OF	ON OF	Preset stitching validity and back tacking validity changeover operation ([M] key operation) in the pattern mode will not be possible.
	Pattern stitching No. of stitches and times changeover prohibit TNC.	1114	O	OF	-	-	TNC.	OF	ON OF	No. of preset stitching stitches and No. of back tacking times setting operation ([C], [D] key operations) in the pattern mode will not be possible.
	Pattern mode pattern changeover prohibit MDC.	1115	O	OF	-	-	MDC.	OF	ON OF	Preset stitching, back tacking and control switch panel data play mode changeover ([D] key operation) in the pattern mode will not be possible.
	Prohibit the all of key switches on control switch panel BAC.	1116	O	OF	-	-	BAC.	OF	ON OF	Prohibit the [Stop needlework, Learning input relation] key switches on control switch panel.
Prohibit the teaching mode key switches on control switch panel BPC.	1117	O	OF	-	-	BPC.	OF	ON OF	Prohibit the teaching mode key switches on control switch panel (refer to following).         	

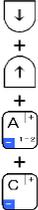
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
J mode    	Prohibit the following key switches on control switch panel	BSC.	1118	O	OF	-	-	b5C.	00 0F	ON OF	Prohibit the following key switches on control switch panel.     	
	Operation prohibition of set value change key	PSW.	1119	O	OF	-	-	P5H.	00 0F	ON OF	Control panel operation ([M], [A], [B], [C], [D] key operations) during the normal mode, tacking mode and pattern mode will not be possible. However, changeover into each mode will be possible.	
	Prohibit the key switches on the control switch panel before thread trimming	BKC.	1120	O	OF	-	-	b5C.	00 0F	ON OF	The key switch operation on the control switch panel will be possible before thread trimming.	
	Prohibit the key switches on the control switch panel before thread trimming	NSV.	1121	O	OF	-	-	n5u.	00 0F	ON OF	The display when the parameter setting key is pushed can be selected. [ON]:The number set last time is displayed. [OF]:The 0th is displayed.	
	It blinks compared with a set value.	CMP.	1122	O	ON	-	-	CNP.	00 0F	ON OF	[ON]:The dot is blinked when differing than the data set with CMS.	
	At the comparison when it compares and it blinks destination.	CMS.	1123	O	BK	-	-	CNS.				It compares it with the shipment setting value.
									b5	BK	It compares it with the BACKUP setting value.	
									S1	S1	It compares it with the SAVE1 setting value.	
								S2	S2	It compares it with the SAVE2 setting value.		
Prohibit "parameter setup (ABCD) key" during the normal mode	PKC.	1124	O	OF	-	-	P5C.	00 0F	ON OF	The parameter setup (ABCD) key is invalidated during the normal mode.		
Not used	NTM.	1125	O	OF			n5n.	00 0F	ON OF	Not used		
Not used	UDC.	1126	O	OF			UdC.	00 0F	ON OF	Not used		

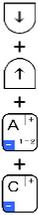
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
K mode 	Operation during 2 - 1 position changeover	P21.	1200	O	OF	-	-	P21	OF	ON OF	When changeover from the 2 position to the 1 position with the [A] key during the normal mode, the needle will rise to the UP position when not in the UP position, when turned ON.	
	Sewing machine speed during solenoid input signal [IO1] setting	IO1.	1201	X	NO	-	-	IO1				The speed for when the signal IO1 output to the virtual output 1 can be selected.
									NO	NO	The speed designation when the IO1 signal is input is invalidated.	
									0	0	The speed will be approximately proportional to the variable speed command VC or VC2 voltage of the lever connector.	
									L	L	The speed will be at the speed set in low speed [L].	
									V	V	The speed will be at the speed set in condensed stitching speed [V].	
									M	M	The speed will be at the speed set in medium speed [M].	
									H	H	The speed will be at the speed set in high speed [H].	
									R0	R0	The sewing machine will run at the variable speed command VC or VC2 command of the lever connector. The sewing machine will stop when the IO1 signal turns OFF.	
	RL	RL	The sewing machine will run at the speed set in low speed [L]. The sewing machine will stop when the IO1 signal turns OFF.									
	RV	RV	The sewing machine will run at the speed set in condensed stitching speed [V]. The sewing machine will stop when the IO1 signal turns OFF.									
	RM	RM	The sewing machine will run at the speed set in medium speed [M]. The sewing machine will stop when the IO1 signal turns OFF.									
	RH	RH	The sewing machine will run at the speed set in high speed [H]. The sewing machine will stop when the IO1 signal turns OFF.									
Speed specification when COR input is ON	COR.	1202	O	L	-	-	COR.			The sewing machine speed for when the correction stitching signal COR is ON.		
								0	0	The speed will be approximately proportional to the variable speed command VC or VC2 voltage of the lever connector.		
								L	L	The speed will be at the speed set in low speed [L].		
								V	V	The speed will be at the speed set in condensed stitching speed [V].		
								M	M	The speed will be at the speed set in medium speed [M].		
								H	H	The speed will be at the speed set in high speed [H].		

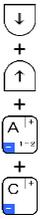
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
K mode 	Speed specification when RND input is ON	RND.	1203	O	L	-	-	<i>rnd.</i>			The sewing machine speed for when the input signal RND is ON.
								<i>0</i>	0	The speed will be approximately proportional to the variable speed command VC or VC2 voltage of the lever connector.	
								<i>L</i>	L	The speed will be at the speed set in low speed [L].	
								<i>V</i>	V	The speed will be at the speed set in condensed stitching speed [V].	
								<i>M</i>	M	The speed will be at the speed set in medium speed [M].	
								<i>H</i>	H	The speed will be at the speed set in high speed [H].	
	Setting the thread trimming key of control switch panel (mark of scissors) valid or invalid, when the preset stitching is active.	NTL.	1204	O	OF	-	-	<i>ntl.</i>	<i>00</i> <i>0F</i>	ON OF	The thread trimming by the control panel scissors switch when preset stitching is ON will be validated (enabled).
	Decelerate per step when Continuous is set with control panel XC-G500-Y	CNM.	1205	O	OF	-	-	<i>cnl.</i>	<i>00</i> <i>0F</i>	ON OF	The speed will decelerate at each step when Continuous is set with the control panel XC-G500-Y.
	DN signal is valid during the virtual DOWN control	KD2.	1206	O	OF	-	-	<i>kd2.</i>	<i>00</i> <i>0F</i>	ON OF	During operation control (virtual DOWN) by only the needle UP position signal UP, the DOWN position signal DN will also be valid. The value set for the reverse run angle K8 from the DOWN position to the UP position in the [B] mode, must be smaller than the angle at which the DN signal turns ON.
	Validity of operation delay when IO1 signal is input	IOD.	1207	O	OF	-	-	<i>iod.</i>	<i>00</i> <i>0F</i>	ON OF	When the signal IO1 (output to the virtual output OT1) is input, the operation delay [S7B.] is validated. This is valid when the function IO1 is [R0], [RL], [RV], [RM], [RH].
Delay to motor drive after B output ON	S7B.	1208	O	5	X10 msec	1 ~ 99	<i>s7b.</i>	**	**	The delay time to motor drive after backstitching output (B) output starts can be set. The factory setting [5] refers to [5 x 10 = 50] msec.	
Delay when S2 signal is U or UF	UFD.	1209	O	OF	-	-	<i>ufd.</i>	<i>00</i> <i>0F</i>	ON OF	The delay time set in the P mode S3D will forcibly be added to the delay time when the A mode S2 signal operation mode S2M is set to U or UF.	
Not used	E8R.	1210	O	OF	-	-	<i>e8r.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.	
Not used	MRA.	1211	O	OF	-	-	<i>mra.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.	
UP position needle lifting at the power is turned ON	PAP.	1212	O	OF	-	-	<i>pap.</i>	<i>00</i> <i>0F</i>	ON OF	If the needle UP position is applied at the power is turned ON when the P1P or P2P setting is [ON], the needle will be lifted. (Sewing machine rotates once again.)	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
K mode 	One stitch operation mode during UCR setting	ST1.	1213	O	OF	-	-	ST1			One stitch operation starts from the needle position when the input signal UCR is input during the sewing machine stopped.
								ON	ON	Regardless of the position switch (1-2), one stitch operation starts to the next UP position when stopped at the needle UP position, or to the next DOWN position when stopped at the needle DOWN position.	
								OF	OF	The sewing machine will rotate to the next position designated with the position switch (1-2).	
	Setting one stitch operation, when "S01" signal is set	IT1.	1214	O	OF	-	-	IT1	ON OF	ON OF	The "I1" signal ON becomes one stitch operation from that position, when No. 6 pin of the option connector "B" (I1 input signal) is set to "S01" function.
	Operation mode during thread trimming protection signal (S6) input/release	S6M.	1215	O	PO	-	-	S6M			The sewing machine stopping state when the thread trimming protection signal (S6) is input during sewing machine operation, and restarting methods after turning (S6) OFF are selected.
									PO	PO	The sewing machine stopping state will follow the settings of the [A] key in the normal mode, and will stop at the UP or DOWN position. If the thread trimming protection signal (S6) is released when the external operation signal (S0, S1, SH) is ON, operation can be resumed when released.
									ES	ES	The sewing machine stopping state will be random. When the thread trimming protection signal (S6) is released, operation will not be possible if the external operation signal (S0, S1, SH) is ON. Turn the operation signal (S0, S1, SH) OFF, and then turn the operation signal (S0, S1, SH) ON to resume operation.
	Thread trimming protection signal (S6) operation mode	S6A.	1216	O	OF	-	-	S6A			If input S6 turns ON during sewing machine operation, all operation states will be canceled, including thread trimming operation, and the sewing machine will stop.
									ON	ON	If signal S6 turns ON in all cases, including thread trimming, all operations will be canceled and the sewing machine will stop.
									OF	OF	If signal S6 turns ON during thread trimming, the thread trimming will be continued and the sewing machine will stop when completed.
	End tacking mode when TR function is set to chain stitch	KTM.	1217	O	OF	-	-	KTM			End tacking operation when thread trimming mode TR in the mode [P] or the thread trimming mode TR in the mode [G] is set to chain stitch.
									ON	ON	The end tacking operation for the lock stitch system will be applied.
								OF	OF	The end tacking operation for the chain stitch system will be applied.	
Lock stitch tacking menu display	KDM.	1218	O	OF	-	-	KDM	ON OF	ON OF	The lock stitch tacking menu is displayed if the end tacking mode KTM is ON when the thread trimming mode TR is set to chain stitch, and the TR function is set to chain stitch.	
U, UF signal needle lift prohibit at position other than set position	UFP.	1219	O	OF	-	-	UFP.	ON OF	ON OF	The needle lifting operation is prohibited when the set position is deviated from and the needle lift signal U, needle lift and presser foot lift signal UF are ON.	
Weak brake validity when UP signal is ON	UPB.	1220	O	OF	-	-	UPB.	ON OF	ON OF	The weak brakes are validated when the needle UP position signal UP is ON. This is valid when the function BK in A mode is [ON].	
Weak brake forced OFF when stopped with ES signal	ESB.	1221	O	OF	-	-	ESB.	ON OF	ON OF	The weak brakes are forcibly turned OFF when stopped with the emergency stop signal ES.	

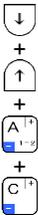
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
K mode 	UP position detection stop	UPS.	1222	O	OF	-	-	UPS.	ON OF	ON OF	Stop control when needle UP position is detected. The stop control of low speed detection control is applied. This is valid when the function NAN in K mode is [ON]. The stop control of high speed positioning is applied.
	Stop status after low speed detection	UP2.	1223	O	OF	-	-	UP2.	ON OF	ON OF	The sewing machine will always rotate once and then stop after the low speed is detected. This is valid when the function NAN is [ON] and UPS is [ON].
	Low speed detection speed	K.	1224	X	280	rpm	0 ~ 2999	L.	****	****	The low speed detection speed can be set.
	Deceleration mode	NAN.	1225	O	OF	-	-	nRn.	ON OF	ON OF	Deceleration is not started when needle position is detected after the run signal is turned OFF, but starts immediately when the run signal turns Off.
	Presser foot lifter operation during emergency stop	ESF.	1226	O	OF	-	-	ESF.	ON OF	ON OF	The presser foot lifter can be operated during emergency stop by the emergency stop signal (ES) is turned ON.
	OP output and OP1 output prohibit at restart	PRC.	1227	O	OF	-	-	PrC.	ON OF	ON OF	The OP output and OP1 output is prohibited when the sewing machine restart. It is reset by the power switch is [ON] again. This is valid when the function PR is [ON] and P1R is [ON].
	S2 signal validity when S6 signal is ON.	TS6.	1228	O	OF	-	-	rS6.	ON OF	ON OF	The thread trimming signal S2 will be valid when the thread trimming safety signal S6 is ON. Note that the motor will not rotate.
	Speed loop stopping control when the machine is overrun with the preset stitching	PNC.	1229	O	OF	-	-	PnC.	ON OF	ON OF	When this function setting is [ON], the stopping control when the sewing machine is overrun with the preset stitching will be the No. of stitches priority stop. (The stop position is loose.) When this function setting is [OF], it will be the needle position priority stop. (It may be one rotation.)
	Input port IL, I1 and I2 software noise filter validity	MFN.	1230	O	OF	-	-	nFn.	ON OF	ON OF	The software noise filter for the input port IL (inside control box signal), input port I1 (option B connector No. 6 pin) and input port I2 (option B connector No. 9 pin) is invalidated.
	All input port software noise filter validity	PFN.	1231	O	OF	-	-	PFn.	ON OF	ON OF	The software noise filters for all input ports are invalidated.
	No. of stitches for noise removal during sensor input setting	SEF.	1232	O	0	stitches	0 ~ 99	SEF.	**	**	The No. of stitches for removing the noise during sensor input can be set.
	Deceleration state during PSU, PSD signal ON	PSM.	1233	O	OF	-	-	PSn.	ON OF	ON OF	The sewing machine will decelerate immediately when the UP position priority stop signal PSU or DOWN position priority stop signal PSD turn ON. Note that during the preset stitching, the stitching will continue at a low speed.
	Low stitching speed validity when the preset stitching is two stitches	2ST.	1234	O	OF	-	-	2St.	ON OF	ON OF	The stitching speed must not be set to the low speed L when tacking or preset stitching is two stitches or less.
	No. of set stitch stitching speed when PSU, PSD, SEN signal is ON	PSS.	1235	O	OF	-	-	PSS.			
ON OF									ON OF		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
K mode 	Speed at PSU, PSD, SEN signal is ON	PSK.	1236	O	OF	-	-	<i>PSk.</i>	<i>ON</i> <i>OF</i>	ON OF	This is the speed for when the UP position priority stop signal PSU, DOWN position priority stop signal PSD or sensor signal SEN is ON. The speed before the PSU, PSD, SEN signal was turned ON is maintained. The speed is set to the variable speed.	
	No. of stitches for removing noise when PSU signal is ON	PUF.	1237	O	0	stitches	0 ~ 99	<i>PUF.</i>	**	**	The No. of stitches for removing noise with the No. of stitches of UP position priority stop signal PSU can be set.	
	No. of stitches for removing noise when PSD signal is ON	PDF.	1238	O	0	stitches	0 ~ 99	<i>PDF.</i>	**	**	The No. of stitches for removing noise with the No. of stitches of DOWN position priority stop signal PSD can be set.	
	Zigzag during continuous tacking	CDR.	1239	O	OF	-	-	<i>CDr.</i>	<i>ON</i> <i>OF</i>	ON OF	When using continuous tacking, and the tacking operation mode D1 in the [D] mode is set to D, the speed will forcibly be set to the medium speed M when the run signal S1 turns OFF. And the thread trimming signal S2 will be validated only at the stitching angle in all continuous tacking modes.	
	No. of stitches of zigzag stitch (sway width) setting	ZNC.	1240	O	0	stitches	0 ~ F	<i>ZnL.</i>	*	*	The No. of stitches of zigzag stitching (sway width) can be set. (No. of stitches of thinning)	
	BCR operation after thread trimming	BRC.	1241	O	OF	-	-	<i>brcL.</i>	<i>ON</i> <i>OF</i>	ON OF	The set angle (reverse run/forward run) signal BCR operation is validated only after thread trimming.	
	Actual No. of USR operations	USN.	1242	O	OF	-	-	<i>USn.</i>	<i>ON</i>			This is the actual No. of reverse run needle lifting operation USR up to the set angle.
									<i>OF</i>	ON OF	ON OF	Can be executed any number of times. Can be executed only once.
	W output mode during S2R=OFF setting	2RW.	1243	O	ON	-	-	<i>2rW.</i>	<i>ON</i> <i>OF</i>	ON OF	If the P mode S2 signal operation mode S2R is set to OF, the wiper output (W) will be output even if the motor is not revolving with full heeling at the needle UP position stop.	
	O1 output prohibit during tacking and thread trimming	BTC.	1244	O	OF	-	-	<i>btcL.</i>	<i>ON</i> <i>OF</i>	ON OF	O1 output is prohibited during tacking and thread trimming.	
	OP output prohibit/permit changeover with input I1 during operation	PR.	1245	O	OF	-	-	<i>Pr.</i>				The operation output OP prohibit/permit changeover is executed when input I1 turns ON during sewing machine operation.
									<i>ON</i> <i>OF</i>	ON OF	ON OF	OP output is prohibited during sewing machine operation. OP output is permitted during sewing machine operation.
	OP1 output prohibit/permit changeover with input I1 during operation	P1R.	1246	O	OF	-	-	<i>P1r.</i>				The operation output OP1 prohibit/permit changeover is executed when input I1 turns ON during sewing machine operation.
									<i>ON</i> <i>OF</i>	ON OF	ON OF	OP1 output is prohibited during sewing machine operation. OP1 output is permitted during sewing machine operation.
B output OFF prohibit mode during thread trimming	TBC.	1247	O	OF	-	-	<i>tbL.</i>	<i>ON</i> <i>OF</i>	ON OF	Turning the backstitch output B OFF at the needle DOWN position during thread trimming is prohibited.		
KS3 output and TF output prohibit during TL input ON	KTL.	1248	O	OF	-	-	<i>ktL.</i>	<i>ON</i> <i>OF</i>	ON OF	The KS3 output and TF output are invalidated when thread trimming cancel signal TL is ON.		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
K mode 	Presser foot operation of F, S2, S3 signal is OFF when FUM function is ON, FU function is M or C.	FLC.	1249	O	OF	-	-	<i>FLC.</i>			The presser foot operation mode when the presser foot output FU stays ON and the full heeling (presser foot lift signal F, thread trimming signal S2, presser foot lift signal S3) is OFF.
								<i>on</i>	ON	The FU output turns OFF (lowers) when the full heeling (F, S2, S3 signals) is OFF.	
								<i>of</i>	OF	The FU output does not turn OFF when the full heeling (F, S2, S3 signals) is OFF.	
	T output, L output protection function	SPT.	1250	O	ON	-	-	<i>SPT.</i>	<i>on</i> <i>of</i>	ON OF	The thread trimming solenoid T and thread release solenoid L are protected. (Solenoid damage prevention)
	Wiper output W ON simultaneously with presser foot lifting output FU	FW.	1251	O	OF	-	-	<i>FW.</i>	<i>on</i> <i>of</i>	ON OF	The wiper output W will turn ON when the presser foot lifting output FU turns ON.
	Input signal check function when power is turned on	PS1.	1252	O	OF	-	-	<i>PS1.</i>			If the input signal is S01, BC, BCR or USR, etc., and is ON when the power is turned ON, the set function will be invalidated. Turn the input signal OFF once and turn ON again, and the set function will be validated.
									<i>on</i>	ON	When main power is turned ON, the system of control box confirm the "ON" "OFF" condition related run signal, excluding one stitch operation signal. If the run signal is "ON", this run signal has to be turned off once to be run.
									<i>of</i>	OF	It is not confirmed about the "S01", "BC", "BCR" and "USR", when main power switch is turned ON.
	Setting program stitch of the control switch panel	B2O.	1253	X	OF	-	-	<i>b2o.</i>			Setting the backstitch (reverse feed) output of control switch panel in each step of program stitching.
									<i>on</i>	ON	Backstitch (reverse feed) output of step set to virtual output "OT1" in program stitching.
									<i>of</i>	OF	Backstitch (reverse feed) output of step set to output. "B" in program stitching.
	Setting "OT1" output while "B" output is ON	TOB.	1254	O	OF	-	-	<i>TOB.</i>			Setting virtual output "OT1" when the backstitch (reverse feed) output "B" is turned ON.
									<i>on</i>	ON	"OT1" output is turned ON when "B" output is turned ON.
									<i>of</i>	OF	"OT1" output is not turned ON even if "B" output is turned ON.
	Special specification setting of limit control.	2SL.	1255	O	OF	-	-	<i>2SL.</i>	<i>on</i> <i>of</i>	ON OF	The speed limit which uses special specification of input signal "SPB" and "SPM". [ON]:The speed limit function by an external input signal is valid. [OF]:The speed limit function by an external input signal is invalidated.
Setting output at FWD input ON	NCK.	1256	O	ON	-	-	<i>nck.</i>			Setting output action when non-stitch feed input "FWD" is turned ON. (Union Special correspondence specification)	
								<i>on</i>	ON	Output "OT3" and "FU" are ON while "FWD" input is ON.	
								<i>of</i>	OF	Output "OT3", "FU" and "NCL" are ON while "FWD" input is ON.	
Needle lift function is invalidated, excluding the needle down position.	UDN.	1257	O	OF	-	-	<i>UDN.</i>	<i>on</i> <i>of</i>	ON OF	Needle lift function is prohibited, excluding the needle down position.	
The set value of full speed	FSL.	1258	O	90	%	1 ~ 98	<i>FSL.</i>	**	**	The value of full speed (standard value) can be set by percentage.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
K mode 	Not used	UPR.	1259	O	OF	-	-	<i>UPr.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.
	Operation gain for the big inertia sewing machine	HWG.	1260	O	OF	-	-	<i>HWG.</i>	<i>00</i> <i>0F</i>	ON OF	Operation gain for the big inertia sewing machine is valid.
	Stop by pedal neutrality under operation PSU, PSD, PS1, PS2	PPS.	1261	X	OF	-	-	<i>PPS.</i>	<i>00</i> <i>0F</i>	ON OF	The sewing machine stops when the pedal is neutralized while counting the number of set stitches when the PSU, PSD, PS1, PS2 signal is turned on. When the pedal is toe down again, the number of stitches of the remainder is sewn. When the heeling or the trimming signal S2 is turned ON while stopping, the trimming operates, and the number of stitches of the remainder is cleared.
	Not used	PCB.	1262	X	OF	-	-	<i>PCb.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.
	Not used	TQT.	1263	O	0	%	0 ~ 99	<i>TQT.</i>	**	**	Not used.
	Not used	E8T.	1264	O	0	X100 msec	0 ~ 99	<i>E8T.</i>	**	**	Not used.
	Not used	WBO.	1265	X	OF	-	-	<i>Wbo.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.
	Not used	R3D.	1266	O	OF	-	-	<i>R3d.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.
	Not used	MEA.	1267	O	OF	-	-	<i>MEa.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.
	Not used	OCS.	1268	O	OF	-	-	<i>OCS.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.
	Step ON/OFF	STP.	1269	O	OF	-	-	<i>STP.</i>	<i>00</i> <i>0F</i>	ON OF	The step sequence is started.
	Number of step execution lines.	STS.	1270	O	1	-	1 ~ 4	<i>STS.</i>	*	*	The execution of the step a main number of lines can be specified.
	Not used	HDS.	1271	O	OF	-	-	<i>HDS.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.
	Not used	1ST.	1272	O	OF	-	-	<i>1ST.</i>	<i>00</i> <i>0F</i>	ON OF	Not used.
The unit of the display time is selected.	TMI.	1273	O	OF	-	-	<i>TMI.</i>	<i>00</i> <i>0F</i>	ON OF	The unit of the display time on "Total integration time of power on.[P.] / "Total integration time of motor run.[M.]" is selected like "x 10hours or x 1min." (OF : x10 hours / ON : x1 min.)	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
Q mode ↓ + A + C	Virtual S1 operation with VC levels	VCS.	1400	X	OF	-	-	υCS	ON OF	ON OF	The virtual operation signal S1 is turned ON when the variable speed voltage VC1 and VC2 exceeded the set voltage level.	
	Setting of VC1 and VC2 where virtual S1 turns ON	VCL.	1401	X	24	-	1 ~ 99	υCL	**	**	The voltage level of the variable speed voltage VC1 and VC2 where virtual run signal S1 turns ON.	
	Input voltage hysteresis during virtual S1 signal ON/OFF by VC and VC2 level	VCD.	1402	X	4	-	0 ~ 99	υCd	**	**	The voltage level hysteresis width for judging the ON/OFF of the virtual S1 signal when VCS turns ON can be set.	
	VC curve reversal mode	V1R.	1403	X	OF	-	-	υ1r.	ON OF	ON OF	The voltage curve of the variable speed voltage VC1 is reversed.	
	VC input 5V/12V changeover mode	V15.	1404	X	OF	-	-	υ15.				The VC1 input range is set to 0~5V.
									ON OF	ON OF	ON OF	VC1 maximum input voltage is set to 5V VC1 maximum input voltage is set to 12V
	VC2 operation mode	VC2.	1405	X	VC	-	-	υC2.				The external analog input VC2 function is set.
									υC	VC	Speed command input	
									υS	VS	The virtual S1 signal turns on with the input voltage, and the sewing machine runs. This also acts as the speed command input.	
									υr	VR	The VC2 input acts as the variable resistor on the control box panel, and the variable resistor is invalidated.	
									bC	BC	During operation with the BC and BCR input, the speed set with the program P mode C8 is invalidated, and the speed is controlled with the VC2 input.	
									LN	LM	The speed control input for reciprocal stroke change.	
									MD	MD	The value set in the program P mode M is invalidated, and the middle speed is controlled with the VC2 input voltage.	
		1	Virtual input IO1 is selected									
	VC2 curve reversal mode	V2R.	1406	X	OF	-	-	υ2r.	ON OF	ON OF	The external analog input VC2 curve is reversed.	
VC2 input 5V/12V changeover mode	V25.	1407	X	ON	-	-	υ25.	ON OF	ON OF	The VC2 input range is set to 0~5V. [ON]VC2 maximum input voltage is set to 5V [OF]VC2 maximum input voltage is set to 12V		
Speed limiter curve inflection point 1 percentage	VL1.	1408	O	67	-	1 ~ 99	υL1	**	**	The inflection point is set when using the reciprocal stroke change specification speed limiter process (VC2 = LM).		
Speed limiter curve inflection point 1 point	VP1.	1409	O	40	-	1 ~ 99	υP1	**	**	Setting inflection point 1		
Speed limiter curve inflection point 2 point	VP2.	1410	O	70	-	1 ~ 99	υP2	**	**	Setting inflection point 2		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
Q mode 	Operation speed limit specification mode 1	FLM.	1411	O	OF	-	-	<i>FLM</i>	<i>00</i> <i>0F</i>	ON OF	Operation speed limit is valid when all the below condition are met. 1. "VC2" operation mode" is set to "LM or LIM, medium speed limit mode during OT1 output ON" is set to "ON". 2. "RFU, operation mode with F input during sewing machine operation is set to ""ON". 3. The presser foot lifting output is ON.	
	Operation speed limit specification mode 2	2LM.	1412	O	OF	-	-	<i>2LM</i>	<i>00</i> <i>0F</i>	ON OF	The speed limit is valid only if the virtual output OT2 is ON when the VC2 operation mode is set to LM or the medium speed limit function LIM is set to ON during OT1 output ON.	
	Speed command value correctly by middle speed digital during speed limit process	LMD.	1413	O	OF	-	-	<i>LMD</i>	<i>00</i> <i>0F</i>	ON OF	The middle speed during the speed limit process is read into the speed command value (speed high speed signal SPH, speed end tacking signal SPB, speed medium speed signal SPM, high speed run signal S4, end tacking speed run signal S5V, medium speed run signal S5) other than the low speed from an external source by the digit.	
	Speed limit with digital speed setting on operation panel	HMD.	1414	O	OF	-	-	<i>HMD</i>	<i>00</i> <i>0F</i>	ON OF	The speed during stitching other than tacking is limited by the digital speed setting (LED.C and D) on operation panel.	
	Ignore detector error	E8C.	1415	O	OF	-	-	<i>E8C.</i>				The sewing machine detector error E8 will be ignored. If a signal is not received from the sewing machine detector within a set time during operation, the detector error E8 will not be displayed. If a signal is not received from the sewing machine detector within a set time during operation, the detector error E8 will be displayed and the sewing machine will stop.
									<i>00</i> <i>0F</i>	ON OF		
	Thread break sensor valid	TH.	1416	O	OF	-	-	<i>TH.</i>	<i>00</i> <i>0F</i>	ON OF	The thread break detector is validated.	
	Operation after thread break sensor detection	TST.	1417	O	TR	-	-	<i>TST.</i>				The operation after the thread break is detected (thread break sensor detection) is set.
									<i>no</i>	NO	The operation continues, and the thread break sensor output THO turns ON.	
									<i>Tr</i>	TR	The sewing machine stops after the thread trimming, and then the thread break sensor output THO turns ON.	
		<i>ST</i>	ST	The sewing machine stops normally, and then the thread break sensor output THO turns ON.								
	Speed to ignore thread break sensor	B.	1418	O	600	rpm	0 ~ 8999	<i>b.</i>	****	****	The speed to ignore the thread break sensor can be set.	
No. of stitches to ignore thread break sensor after starting stitching	THS.	1419	O	7	stitches	0 ~ F	<i>THS.</i>	*	*	Setting the number of stitch that the sensor of thread break detector becomes valid from first stitch.		
Number of stitches for judgment of thread break	THF.	1420	O	0	stitches	0 ~ F	<i>THF.</i>	*	*	The No. of stitches to judge the thread break detection when the thread break sensor input continues for a certain number of stitches can be set.		
Operation mode with F input during sewing machine operation	RFU.	1421	O	OF	-	-	<i>RFU.</i>	<i>00</i> <i>0F</i>	ON OF	The presser foot lifting output will turn ON by turning ON the presser foot lifting signal F during sewing machine operation. Note that the presser foot lifting signal S3 is invalid during sewing machine operation.		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification	
				GMFY			Digital display				
Q mode     	Output of back tacking output (B) during OT1 output ON inhibited	S7C.	1422	O	OF	-	-	S7C.	OF	ON OF	The output of the backstitching output (B) with input S7 is inhibited while the virtual output (OT1) is ON.
	Medium speed (M) limit mode during OT1 output ON	LIM.	1423	O	OF	-	-	LIM.	OF	ON OF	The speed will be limited to that set in medium speed M while virtual output (OT1) is ON.
	Simultaneously ON of OP1 output during OT1 output ON	O1P.	1424	O	OF	-	-	O1P.	OF	ON OF	OP1 output will turn ON simultaneously when virtual output (OT1) is ON.
	Disregard of S3 signal of Lever Unit	LVB.	1425	O	ON	-	-	LVB.	OF	ON OF	When the lever unit run signal S1 is ON, the presser foot lift signal S3 will be ignored even when received.
	1 step heeling setting for the internal lever unit	PD1.	1426	O	OF	-	-	PD1.	OF	ON OF	The heeling operation of the pedal will be 1 step heeling operation.
	Adjustment mode for the internal lever unit	VCSE T.	1427	X	-	-	-	VCSE T.			The neutral of the internal lever unit, toe down, and the heeling position can be adjusted.
	Not used.	MTJ.	1428	O	OF	-	-	MTJ.	OF	ON OF	Not used.
	Not used.	MOA.	1429	O	7	stitches	0 ~ 99	MOA.	**	**	Not used.
	Not used.	MOB.	1430	O	7	stitches	0 ~ 99	MOB.	**	**	Not used.
	Not used.	MOC.	1431	O	7	stitches	0 ~ 99	MOC.	**	**	Not used.
VC assistance ON/OFF	VCA.	1432	O	OF	-	-	VCA.	OF	ON OF	The speed curve to the amount of depressing changes depending on the pedal stepping speed.	
Strength of VC assistance	VCP.	1433	O	50	-	0 ~ 99	VCP.	**	**	The amount of the changes by the depressing speed can be set.	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
R mode  +  + 	RESET	RESET.	-	X	-	-	-	-	-	The EEPROM data is returned to the EEPROM back up state. This is used return the function setting to the factory settings.

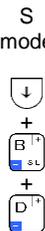
Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
S mode 	KS1, KS2 output run mode	KSM.	1500	O	OF	-	-	ESN			This is the virtual output KS1 and KS2 run mode.	
								on	ON	The KS1 and KS2 output swill turn ON only during normal operation.		
								of	OF	During the one needle stitching, half-stitching (one needle stitching signal S01, needle lift signal U, half-stitching signal UD, backstitching during run signal US, backstitching during run signal UDS, etc.), the outputs KS1 and KS2 will turn ON.		
	Simple sequence start conditions	SQS.	1501	O	NO	-	-	595.				The simple sequence start conditions are set.
									no	NO	The simple sequence will not start.	
									in	IN	When the virtual input IO4 is ON.	
									t	T	When the thread trimming is completed.	
									r	R	When run starts.	
									s	S	When the motor starts. (This includes while stopped during the one needle stitching run.)	
									tr	TR	When stitching starts after thread trimming.	
									sb	SB	When start tacking is completed. (If the start tacking setting is OFF, the operation will be identical to [TR].)	
	go	GO	Normal starting.									
	Simple sequence forced end conditions	SQE.	1502	O	NO	-	-	59E.				The simple sequence forced end conditions are set.
									no	NO	The simple sequence will not forced end.	
									lv	LV	When the virtual input IO5 is ON level.	
in									IN	When the virtual input IO5 is ON.		
t									T	When the thread trimming is completed.		
r									R	When run starts.		
s									S	When the motor starts. (This includes while stopped during the one needle stitching run.)		
tr									TR	When stitching starts after thread trimming.		
sb	SB	When start tacking is completed. (If the start tacking setting is OFF, the operation will be identical to [TR].)										
Simple sequence output KS1 output beginning is time or the number of stitch is selected	NS1.	1503	O	OF	-	-	n5 l.				Selection stitch amount and time till ON for simple sequence output "KS1". (Amount have to be set at "K11")	
								on	ON	Stitch amount is counted till ON		
								of	OF	Time is counted till ON (10 mill-second per each)		
Simple sequence output KS1 output is time or the number of stitch is selected	NE1.	1504	O	OF	-	-	nE l.				Selection stitch amount and time till OFF for simple sequence output "KS1". (Amount have to be set at "K12")	
								on	ON	Stitch amount is counted till OFF		
								of	OF	Time is counted till OFF (10 mill-second per each)		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
	Output beginning standard of simple sequence output KS1 S1S.	1505	O	KS	-	-	S 1S.			The simple sequence output starting point setting [S1S] can be set.
								KS	KS	Linked output. (ON edge of the front output)
								IN	IN	Virtual input ON point. (KS1:IO6, KS2:IO7, KS3:IO8, KS4:IO9)
								T	T	When the thread trimming is completed.
								R	R	When run starts.
								S	S	When the motor starts. (This includes while stopped during the one needle stitching run.)
								TR	TR	When stitching starts after thread trimming.
	Output end standard of simple sequence output KS1 S1E.	1506	O	KS	-	-	S 1E.			The simple sequence output end point setting [S1E] can be set.
								KS	KS	Linked output. (Each output starting point)
								OF	OF	Virtual input OFF point. (KS1:IO6, KS2:IO7, KS3:IO8, KS4:IO9)
								IN	IN	Virtual input ON point. (KS1:IOA, KS2:IOB, KS3:IOC, KS4:IOD)
								T	T	When the thread trimming is completed.
								R	R	When run starts.
Simple sequence output KS2 output beginning is time or the number of stitch is selected NS2.	1507	O	OF	-	-	n S2.			Selection stitch amount and time till ON for simple sequence output "KS2". (Amount have to be set at "K21")	
							ON	ON	Stitch amount is counted till ON	
Simple sequence output KS2 output is time or the number of stitch is selected NE2.	1508	O	OF	-	-	n E2.			Selection stitch amount and time till OFF for simple sequence output "KS2". (Amount have to be set at "K22")	
							OF	OF	Time is counted till OFF (10 mill-second per each)	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
S mode 	Output beginning standard of simple sequence output KS2	S2S.	1509	O	KS	-	-	S2S.			The simple sequence output starting point setting [S2S] can be set.	
								KS	KS	Linked output. (ON edge of the front output)		
								IN	IN	Virtual input ON point. (KS1:IO6, KS2:IO7, KS3:IO8, KS4:IO9)		
								T	T	When the thread trimming is completed.		
								R	R	When run starts.		
								S	S	When the motor starts. (This includes while stopped during the one needle stitching run.)		
								TR	TR	When stitching starts after thread trimming.		
								SB	SB	When start tacking is completed. (If the start tacking setting is OFF, the operation will be identical to [TR].)		
		Output end standard of simple sequence output KS2	S2E.	1510	O	KS	-	-	S2E.			The simple sequence output end point setting [S2E] can be set.
									KS	KS	Linked output. (Each output starting point)	
									OF	OF	Virtual input OFF point. (KS1:IO6, KS2:IO7, KS3:IO8, KS4:IO9)	
									IN	IN	Virtual input ON point. (KS1:IOA, KS2:IOB, KS3:IOC, KS4:IOD)	
									T	T	When the thread trimming is completed.	
									R	R	When run starts.	
								S	S	When the motor starts. (This includes while stopped during the one needle stitching run.)		
								TR	TR	When stitching starts after thread trimming.		
								SB	SB	When start tacking is completed. (If the start tacking setting is OFF, the operation will be identical to [TR].)		
	Simple sequence output KS3 output beginning is time or the number of stitch is selected	NS3.	1511	O	OF	-	-	nS3.			Selection stitch amount and time till ON for simple sequence output "KS3". (Amount have to be set at "K31")	
								ON	ON	Stitch amount is counted till ON		
								OF	OF	Time is counted till ON (10 mill-second per each)		
	Simple sequence output KS3 output is time or the number of stitch is selected	NE3.	1512	O	OF	-	-	nE3.			Selection stitch amount and time till OFF for simple sequence output "KS3". (Amount have to be set at "K32")	
								ON	ON	Stitch amount is counted till OFF		
								OF	OF	Time is counted till OFF (10 mill-second per each)		

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
S mode 	Output beginning standard of simple sequence output KS3	S3S.	1513	O	KS	-	-	S3S.			The simple sequence output starting point setting [S3S] can be set.	
								ES	KS		Linked output. (ON edge of the front output)	
								IN	IN		Virtual input ON point. (KS1:IO6, KS2:IO7, KS3:IO8, KS4:IO9)	
								T	T		When the thread trimming is completed.	
								R	R		When run starts.	
								S	S		When the motor starts. (This includes while stopped during the one needle stitching run.)	
								TR	TR		When stitching starts after thread trimming.	
								SB	SB		When start tacking is completed. (If the start tacking setting is OFF, the operation will be identical to [TR].)	
	Output end standard of simple sequence output KS3	S3E.	1514	O	KS	-	-	S3E.				The simple sequence output end point setting [S3E] can be set.
									ES	KS		Linked output. (Each output starting point)
									OF	OF		Virtual input OFF point. (KS1:IO6, KS2:IO7, KS3:IO8, KS4:IO9)
									IN	IN		Virtual input ON point. (KS1:IOA, KS2:IOB, KS3:IOC, KS4:IOD)
									T	T		When the thread trimming is completed.
									R	R		When run starts.
									S	S		When the motor starts. (This includes while stopped during the one needle stitching run.)
									TR	TR		When stitching starts after thread trimming.
								SB	SB		When start tacking is completed. (If the start tacking setting is OFF, the operation will be identical to [TR].)	
Simple sequence output KS4 output beginning is time or the number of stitch is selected	NS4.	1515	O	OF	-	-	NS4.				Selection stitch amount and time till ON for simple sequence output "KS4". (Amount have to be set at "K21")	
								ON	ON		Stitch amount is counted till ON	
								OF	OF		Time is counted till ON (10 mill-second per each)	
Simple sequence output KS4 output is time or the number of stitch is selected	NE4.	1516	O	OF	-	-	NE4.				Selection stitch amount and time till OFF for simple sequence output "KS4". (Amount have to be set at "K22")	
								ON	ON		Stitch amount is counted till OFF	
								OF	OF		Time is counted till OFF (10 mill-second per each)	

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification
				GMFY			Digital display			
S mode 	Output beginning standard of simple sequence output KS4 S4S.	1517	O	KS	-	-	54S.			The simple sequence output starting point setting [S4S] can be set.
								LS	KS	Linked output. (ON edge of the front output)
								IN	IN	Virtual input ON point. (KS1:IO6, KS2:IO7, KS3:IO8, KS4:IO9)
								T	T	When the thread trimming is completed.
								R	R	When run starts.
								S	S	When the motor starts. (This includes while stopped during the one needle stitching run.)
								TR	TR	When stitching starts after thread trimming.
								SB	SB	When start tacking is completed. (If the start tacking setting is OFF, the operation will be identical to [TR].)
	Output end standard of simple sequence output KS4 S4E.	1518	O	KS	-	-	54E.			The simple sequence output end point setting [S4E] can be set.
								LS	KS	Linked output. (Each output starting point)
								OF	OF	Virtual input OFF point. (KS1:IO6, KS2:IO7, KS3:IO8, KS4:IO9)
								IN	IN	Virtual input ON point. (KS1:IOA, KS2:IOB, KS3:IOC, KS4:IOD)
								T	T	When the thread trimming is completed.
								R	R	When run starts.
								S	S	When the motor starts. (This includes while stopped during the one needle stitching run.)
							TR	TR	When stitching starts after thread trimming.	
							SB	SB	When start tacking is completed. (If the start tacking setting is OFF, the operation will be identical to [TR].)	
KS1 output start [Time]/[No. of Stitches] setting	K11.	1519	O	7	X10 msec stitches	0 ~ 99	t 11.	**	**	The output start time/output start No. of stitches for the simple sequence output KS1 can be set. When using time, the setting value will be (7) x 10 = 70 msec. When using No. of stitches, the setting value will be (7) x 1 = 7 stitches.
KS1 output [Time]/[No. of Stitches] setting	K12.	1520	O	7	X10 msec stitches	0 ~ 99	t 12.	**	**	The output time/output start No. of stitches for the simple sequence output KS1 can be set. When using time, the setting value will be (7) x 10 = 70 msec. When using No. of stitches, the setting value will be (7) x 1 = 7 stitches.
KS2 output start [Time]/[No. of Stitches] setting	K21.	1521	O	7	X10 msec stitches	0 ~ 99	t 21.	**	**	The output start time/output start No. of stitches for the simple sequence output KS2 can be set. When using time, the setting value will be (7) x 10 = 70 msec. When using No. of stitches, the setting value will be (7) x 1 = 7 stitches.
KS2 output [Time]/[No. of Stitches] setting	K22.	1522	O	7	X10 msec stitches	0 ~ 99	t 22.	**	**	The output time/output start No. of stitches for the simple sequence output KS2 can be set. When using time, the setting value will be (7) x 10 = 70 msec. When using No. of stitches, the setting value will be (7) x 1 = 7 stitches.
KS3 output start [Time]/[No. of Stitches] setting	K31.	1523	O	7	X10 msec stitches	0 ~ 99	t 31.	**	**	The output start time/output start No. of stitches for the simple sequence output KS3 can be set. When using time, the setting value will be (7) x 10 = 70 msec. When using No. of stitches, the setting value will be (7) x 1 = 7 stitches.

Mode name	Function name	Direct call number	Operability	Factory setting	Unit	Setting range	Function name	Setting		Specification		
				GMFY			Digital display					
S mode 	KS3 output [Time]/[No. of Stitches] setting	K32.	1524	O	7	X10 msec stitches	0 ~ 99		**	**	The output time/output start No. of stitches for the simple sequence output KS3 can be set. When using time, the setting value will be (7) x 10 = 70 msec. When using No. of stitches, the setting value will be (7) x 1 = 7 stitches.	
	KS4 output start [Time]/[No. of Stitches] setting	K41.	1525	O	7	X10 msec stitches	0 ~ 99		**	**	The output start time/output start No. of stitches for the simple sequence output KS4 can be set. When using time, the setting value will be (7) x 10 = 70 msec. When using No. of stitches, the setting value will be (7) x 1 = 7 stitches.	
	KS4 output [Time]/[No. of Stitches] setting	K42.	1526	O	7	X10 msec stitches	0 ~ 99		**	**	The output time/output start No. of stitches for the simple sequence output KS4 can be set. When using time, the setting value will be (7) x 10 = 70 msec. When using No. of stitches, the setting value will be (7) x 1 = 7 stitches.	
	KS1 output run mode	K1M.	1527	X	ON	-	-					This is the output KS1 run mode for when the simple sequence start conditions [SQS] are set to NO.
										ON	The KS1 output is output each time the start conditions are established.	
										OF	The KS1 output is output only when the start conditions are established after thread trimming.	
	Run prohibit during KS1 output ON	K1D.	1528	O	OF	-	-			ON OF	Running is prohibited while the output KS1 is ON. (This is valid only when the simple sequence start conditions [SQS] are set to NO.)	
	K11, K12 time clear during KS1 output ON	K1C.	1529	O	OF	-	-			ON OF	The K11 and K12 timers will be cleared and the KS1 output will be turned OFF when the sewing machine stops (motor turns OFF) even when the output KS1 timer is continuing. (This is valid only when the simple sequence start conditions [SQS] are set to NO.)	
	K21, K22 time clear during KS2 output ON	K2C.	1530	O	OF	-	-			ON OF	The K21 and K22 timers will be cleared and the KS2 output will be turned OFF when the sewing machine stops (motor turns OFF) even when the output KS2 timer is continuing. (This is valid only when the simple sequence start conditions [SQS] are set to NO.)	
	K31, K32 time clear during KS3 output ON	K3C.	1531	O	OF	-	-			ON OF	The K31 and K32 timers will be cleared and the KS3 output will be turned OFF when the sewing machine stops (motor turns OFF) even when the output KS3 timer is continuing. (This is valid only when the simple sequence start conditions [SQS] are set to NO.)	
	Increase the number of K11 through K42 by ten	KSL.	1532	O	OF	-	-			ON OF	Increase the number of K11, K12, K21, K22, K31, K32, K41, K42 by ten. (ex. 10mS =>100mS, note: Stitch number is not changed.)	
	Sequence output time setting/No. of stitch setting each by ten times setting	KL1.	1533	O	OF	-	-			ON OF	Sequence output [KS1] [KS2] [KS3] [KS4] time setting/No. of stitch setting each by ten times. [ON]Time setting/No. of stitch setting by ten times (([K11][K12]x10,) [OF]Time setting/No. of stitch setting (([K11][K12]))	
	Sequence output time setting/No. of stitch setting each by ten times setting	KL2.	1534	O	OF	-	-			ON OF	Sequence output [KS1] [KS2] [KS3] [KS4] time setting/No. of stitch setting each by ten times. [ON]Time setting/No. of stitch setting by ten times (([K21][K22]x10,) [OF]Time setting/No. of stitch setting (([K21][K22]))	
Sequence output time setting/No. of stitch setting each by ten times setting	KL3.	1535	O	OF	-	-			ON OF	Sequence output [KS1] [KS2] [KS3] [KS4] time setting/No. of stitch setting each by ten times. [ON]Time setting/No. of stitch setting by ten times (([K31][K32]x10,) [OF]Time setting/No. of stitch setting (([K31][K32]))		
Sequence output time setting/No. of stitch setting each by ten times setting	KL4.	1536	O	OF	-	-			ON OF	Sequence output [KS1] [KS2] [KS3] [KS4] time setting/No. of stitch setting each by ten times. [ON]Time setting/No. of stitch setting by ten times (([K41][K42]x10,) [OF]Time setting/No. of stitch setting (([K41][K42]))		