ENGLISH

APW-895NE/IP-420

* "CompactFlash(TM)" is the registered trademark of SanDisk Corporation, U.S.A.

TO ENSURE SAFE USE OF YOUR SEWING MACHINE

For the sewing machine, automatic machine and ancillary devices (hereinafter collectively referred to as "machine"), it is inevitable to conduct sewing work near moving parts of the machine. This means that there is always a possibility of unintentionally coming in contact with the moving parts. Operators who actually operate the machine and maintenance personnel who are involved in maintenance and repair of the machine are strongly recommended to carefully read to fully understand the following **SAFETY PRECAUTIONS** before using/maintaining the machine. The content of the **SAFETY PRECAUTIONS** includes items which are not contained in the specifications of your product.
The risk indications are classified into the following three different categories to help understand the meaning of the labels. Be sure to fully understand the following description and strictly observe the instructions.

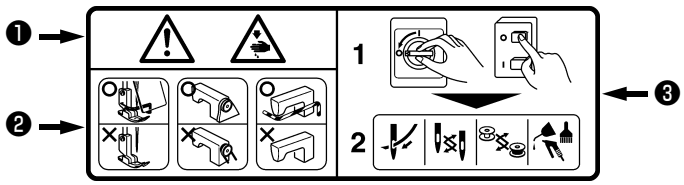
(I) Explanation of risk levels

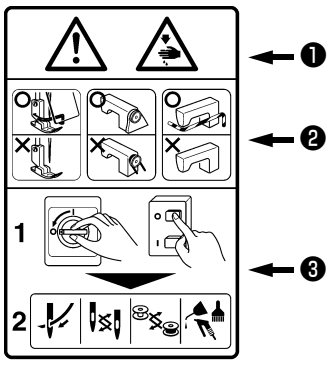
	DANGER : **This indication is given where there is an immediate danger of death or serous injury if the person in charge or any third party mishandles the machine or does not avoid the dangerous situation when operating or maintaining the machine.**
	WARNING : **This indication is given where there is a potentiality for death or serious injury if the person in charge or any third party mishandles the machine or does not avoid the dangerous situation when operating or maintaining the machine.**
	CAUTION : **This indication is given where there is a danger of medium to minor injury if the person in charge or any third party mishandles the machine or does not avoid the dangerous situation when operating or maintaining the machine.**
	Items requiring special attention.

(II) Explanation of pictorial warning indications and warning labels

Pictorial warning indication		**There is a risk of injury if contacting a moving section.**	Pictorial warning indication		**Be aware that holding the sewing machine during operation can hurt your hands.**
		There is a risk of electrical shock if contacting a high-voltage section.			**There is a risk of entanglement in the belt resulting in injury.**
		There is a risk of a burn if contacting a high-temperature section.			**There is a risk of injury if you touch the button carrier.**
		Be aware that eye deficiency can be caused by looking directly at the laser beam.	Indication label		**The correct direction is indicated.**
		There is a risk of contact between your head and the sewing machine.			**Connection of a earth cable is indicated.**

Warning label





❶ • **There is the possibility that slight to serious injury or death may be caused.**
• **There is the possibility that injury may be caused by touching moving part.**

❷ • **To perform sewing work with safety guard.**
• **To perform sewing work with safety cover.**
• **To perform sewing work with safety protection device.**

❸ • **Be sure to turn the power OFF before carrying out "machine-head threading", "needle changing", "bobbin changing" or "oiling and cleaning".**

Electrical-shock danger label

SAFETY PRECAUTIONS

Accident means "to cause personal injury or death or damage to property."

DANGER

1. When it is necessary to open the control box containing electrical parts, be sure to turn the power off and wait for five minutes or more before opening the cover in order to prevent accident leading to electrical shock.

CAUTION

Basic precaution

1. Be sure to read the instruction manual and other explanatory documents supplied with accessories of the machine before using the machine. Carefully keep the instruction manual and the explanatory documents at hand for quick reference.
2. The content of this section includes items which are not contained in the specifications of your product.
3. Be sure to wear safety goggles to protect against accident caused by needle breakage.
4. Those who use a heart pacer have to use the machine after consultation with a medical specialist.

Safety devices and warning labels

1. Be sure to operate the machine after verifying that safety device(s) is correctly installed in place and works normally in order to prevent accident caused by lack of the device(s).
2. If any of the safety devices is removed, be sure to replace it and verify that it works normally in order to prevent accident that can result in personal injury or death.
3. Be sure to keep the warning labels adhered on the machine clearly visible in order to prevent accident that can result in personal injury or death. If any of the labels has stained or come unstuck, be sure to change it with a new one.

Application and modification

1. Never use the machine for any application other than its intended one and in any manner other than that prescribed in the instruction manual in order to prevent accident that can result in personal injury or death. JUKI assumes no responsibility for damages or personal injury or death resulting from the use of the machine for any application other than the intended one.
2. Never modify and alter the machine in order to prevent accident that can result in personal injury or death. JUKI assumes no responsibility for damages or personal injury or death resulting from the machine which has been modified or altered.

Education and training

1. In order to prevent accident resulting from unfamiliarity with the machine, the machine has to be used only by the operator who has been trained/educated by the employer with respect to the machine operation and how to operate the machine with safety to acquire adequate knowledge and operation skill. To ensure the above, the employer has to establish an education/training plan for the operators and educate/train them beforehand.

Items for which the power to the machine has to be turned off

Turning the power off: Turning the power switch off, then removing the power plug from the outlet. This applies to the following.

1. Be sure to immediately turn the power off if any abnormality or failure is found or in the case of power failure in order to protect against accident that can result in personal injury or death.
2. To protect against accident resulting from abrupt start of the machine, be sure to carry out the following operations after turning the power off. For the machine incorporating a clutch motor, in particular, be sure to carry out the following operations after turning the power off and verifying that the machine stops completely.
   2-1. For example, threading the parts such as the needle, looper, spreader etc. which have to be threaded, or changing the bobbin.
   2-2. For example, changing or adjusting all component parts of the machine.
   2-3. For example, when inspecting, repairing or cleaning the machine or leaving the machine.
3. Be sure to remove the power plug by holding the plug section instead of the cord section in order to prevent electrical-shock, earth-leakage or fire accident.
4. Be sure to turn the power off whenever the machine is left unattended between works.
5. Be sure to turn the power off in the case of power failure in order to prevent accident resulting of breakage of electrical components.

PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

Transportation

1. Be sure to lift and move the machine in a safe manner taking the machine weight in consideration. Refer to the text of the instruction manual for the mass of the machine.
2. Be sure to take sufficient safety measures to prevent falling or dropping before lifting or moving the machine in order to protect against accident that can result in personal injury or death.
3. Once the machine has been unpacked, never re-pack it for transportation to protect the machine against breakage resulting from unexpected accident or dropping.

Unpacking

1. Be sure to unpack the machine in the prescribed order in order to prevent accident that can result in personal injury or death. In the case the machine is crated, in particular, be sure to carefully check nails. The nails have to be removed.
2. Be sure to check the machine for the position of its center of gravity and take it out from the package carefully in order to prevent accident that can result in personal injury or death.

Installation

(I) Table and table stand

1. Be sure to use JUKI genuine table and table stand in order to prevent accident that can result in personal injury or death. If it is inevitable to use a table and table stand which are not JUKI genuine ones, select the table and table stand which are able to support the machine weight and reaction force during operation.
2. If casters are fitted to the table stand, be sure to use the casters with a locking mechanism and lock them to secure the machine during the operation, maintenance, inspection and repair in order to prevent accident that can result in personal injury or death.

(II) Cable and wiring

1. Be sure to prevent an extra force from being applied to the cable during the use in order to prevent electrical-shock, earth-leakage or fire accident. In addition, if it is necessary to cable near the operating section such as the V-belt, be sure to provide a space of 30 mm or more between the operating section and the cable.
2. Be sure to avoid starburst connection in order to prevent electrical-shock, earth-leakage or fire accident.
3. Be sure to securely connect the connectors in order to prevent electrical-shock, earth-leakage or fire accident. In addition, be sure to remove the connector while holding its connector section.

(III) Grounding

1. Be sure to have an electrical expert install an appropriate power plug in order to prevent accident caused by earth-leakage or dielectric strength voltage fault. In addition, be sure to connect the power plug to the grounded outlet without exceptions.
2. Be sure to ground the earth cable in order to prevent accident caused by earth leakage.

(IV) Motor

1. Be sure to use the specified rated motor (JUKI genuine product) in order to prevent accident caused by burnout.
2. If a commercially available clutch motor is used with the machine, be sure to select one with an entanglement preventive pulley cover in order to protect against being entangled by the V-belt.

Before operation

1. Be sure to make sure that the connectors and cables are free from damage, dropout and looseness before turning the power on in order to prevent accident resulting in personal injury or death.
2. Never put your hand into the moving sections of the machine in order to prevent accident that can result in personal injury or death.
   In addition, check to be sure that the direction of rotation of the pulley agrees with the arrow shown on pulley.
3. If the table stand with casters is used, be sure to secure the table stand by locking the casters or with adjusters, if provided, in order to protect against accident caused by abrupt start of the machine.

During operation

1. Be sure not to put your fingers, hair or clothing close to the moving sections such as the handwheel, hand pulley and motor or place something near those sections while the machine is in operation in order to prevent accident caused by entanglement that can result in personal injury or death.
2. Be sure not to place your fingers near the surround area of the needle or inside the thread take-up lever cover when turning the power on or while the machine is in operation in order to prevent accident that can result in personal injury or death.
3. The machine runs at a high speed. Never bring your hands near the moving sections such as looper, spreader, needle bar, hook and cloth trimming knife during operation in order to protect your hands against injury. In addition, be sure to turn the power off and check to be sure that the machine completely stops before changing the thread.
4. Be careful not to allow your fingers or any other parts of your body to be caught between the machine and table when removing the machine from or replacing it on the table in order to prevent accident that can result in personal injury or death.

5. Be sure to turn the power off and check to be sure that the machine and motor completely stop before removing the belt cover and V-belt in order to prevent accident caused by abrupt start of the machine or motor.
6. If a servomotor is used with the machine, the motor does not produce noise while the machine is at rest. Be sure not to forget to turn the power off in order to prevent accident caused by abrupt start of the motor.
7. Never use the machine with the cooling opening of the motor power box shielded in order to prevent fire accident by overheat.

Lubrication

1. Be sure to use JUKI genuine oil and JUKI genuine grease to the parts to be lubricated.
2. If the oil adheres on your eye or body, be sure to immediately wash it off in order to prevent inflammation or irritation.
3. If the oil is swallowed unintentionally, be sure to immediately consult a medical doctor in order to prevent diarrhea or vomiting.

Maintenance

1. In prevention of accident caused by unfamiliarity with the machine, repair and adjustment has to be carried out by a service technician who is thoroughly familiar with the machine within the scope defined in the instruction manual. Be sure to use JUKI genuine parts when replacing any of the machine parts. JUKI assumes no responsibility for any accident caused by improper repair or adjustment or the use of any part other than JUKI genuine one.
2. In prevention of accident caused by unfamiliarity with the machine or electrical-shock accident, be sure to ask an electrical technician of your company or JUKI or distributor in your area for repair and maintenance (including wiring) of electrical components.
3. When carrying out repair or maintenance of the machine which uses air-driven parts such as an air cylinder, be sure to remove the air supply pipe to expel air remaining in the machine beforehand, in order to prevent accident caused by abrupt start of the air-driven parts.
4. Be sure to check that screws and nuts are free from looseness after completion of repair, adjustment and part replacement.
5. Be sure to periodically clean up the machine during its duration of use. Be sure to turn the power off and verify that the machine and motor stop completely before cleaning the machine in order to prevent accident caused by abrupt start of the machine or motor.
6. Be sure to turn the power off and verify that the machine and motor stop completely before carrying out maintenance, inspection or repair of the machine. (For the machine with a clutch motor, the motor will keep running for a while by inertia even after turning the power off. So, be careful.)
7. If the machine cannot be normally operated after repair or adjustment, immediately stop operation and contact JUKI or the distributor in your area for repair in order to prevent accident that can result in personal injury or death.
8. If the fuse has blown, be sure to turn the power off and eliminate the cause of blowing of the fuse and replace the blown fuse with a new one in order to prevent accident that can result in personal injury or death.
9. Be sure to periodically clean up the air vent of the fan and inspect the area around the wiring in order to prevent fire accident of the motor.

Operating environment

1. Be sure to use the machine under the environment which is not affected by strong noise source (electromagnetic waves) such as a high-frequency welder in order to prevent accident caused by malfunction of the machine.
2. Never operate the machine in any place where the voltage fluctuates by more than "rated voltage ±10 %" in order to prevent accident caused by malfunction of the machine.
3. Be sure to verify that the air-driven device such as an air cylinder operates at the specified air pressure before using it in order to prevent accident caused by malfunction of the machine.
4. To use the machine with safety, be sure to use it under the environment which satisfies the following conditions:
   Ambient temperature during operation 5°C to 35°C
   Relative humidity during operation 35 % to 85 %
5. Dew condensation can occur if bringing the machine suddenly from a cold environment to a warm one. So, be sure to turn the power on after having waited for a sufficient period of time until there is no sign of water droplet in order to prevent accident caused by breakage or malfunction of the electrical components.
6. Be sure to stop operation when lightning flashes for the sake of safety and remove the power plug in order to prevent accident caused by breakage or malfunction of the electrical components.
7. Depending on the radio wave signal condition, the machine may generate noise in the TV or radio. If this occurs, use the TV or radio with kept well away from the machine.
8. In order to ensure the work environment, local laws and regulations in the country where the sewing machine is installed shall be followed.
   In the case the noise control is necessary, an ear protector or other protective gear should be worn according to the applicable laws and regulations.
9. Disposal of products and packages and treatment of used lubricating oil should be carried out properly according to the relevant laws of the country in which the sewing machine is used.

Precautions to be taken so as to use the APW-895NE more safely

1. To avoid accidents caused by electric shock, never open the motor cover, the main body cover, the control box cover, or the operation panel cover, or touch the components inside the control box or the operation panel while the power switch is ON.

1. Do not look in the laser beam. Do not directly look directly at the beam with an optical apparatus.

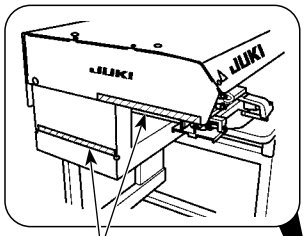
1. To avoid personal injuries, when returning the machine head from the raised state to the home position, return it to the home position after confirming that there is no tool or component under the gas spring.
2. To avoid personal injuries and damage of sewing machine, do not damage with tools or parts the rod section of the gas spring located under the machine head.
3. To avoid personal injuries, immediately replace the gas spring with a new one when the rod section of gas spring does not function properly with a flaw or the like, or it is judged as a defective one. For the judgment standard of defectiveness, refer to the item of "Standard of replacing time of the gas spring".

   [Do not use anything other than JUKI genuine gas spring (Part No. : 40023177).]
4. To avoid personal injuries, do not use with the gas spring removed.
5. Do not put your hand under the needle when you turn ON the power switch or operate the machine.
6. When depressing the foot pedal, the clamp foot moves at high speed. Do not place your hand, fingers, or face within the moving range of the clamp foot with your foot on the pedal.
7. Be sure to turn OFF the power switch before tilting the machine head.
8. To protect against possible danger, never place your fingers, hair or anything near the motor pulley and other driving part while the machine is in operation.
9. If any of the following phenomena should arise, immediately turn OFF the power switch and have a maintenance personnel inspect the machine.

   (1) In the case where needle breakage or thread breakage frequently arises.

   (2) In the case where the machine exhibits irregular behavior.
10. Do not turn off the air supply while the sewing machine is in operation.
11. Do not shift the clamp foot with the sewing table opened.
12. Be sure to connect the FG wire of the power cable to the earth of the main power source.
13. Do not place anything that might generate a high heat/humidity around the electrical box.
14. Use welt patches reinforced with adhesive interlining.
15. Keep your hands away from the corner knife while the machine is in operation.
16. For the machine provided with a stacker (optional), attach the safety pipe for stacker to activate the stacker. Avoid the use of the stacker with the machine or independently with the stacker or safety pipe held opened to ensure safety.
17. Do not quickly repeat ON/OFF of the power switch since erroneous motion such as panel abnormal indication or the like will be caused. Perform the power ON operation after 5 seconds or more from turning OFF the power.
18. Be sure to perform drawing/inserting the power plug socket with the power switch OFF.
19. Be careful of handling this product so as not to pour water or oil, shock by dropping, and the like since this product is a precision instrument.
20. For the work at the position lower than the surface of the wooden table, perform the work paying attention to the overhead table or the like.
21. To protect personal accident, when lifting or transporting the machine, use the heavy machine such as the fork lift or the like.
22. Do not place hands under the binder and clamp foot which drop by their own weight when you operate the emergency stop switch.
23. In a domestic environment this product may cause radio interference, in which case the user may be required to make corrective actions.

Safety devices and warning labels



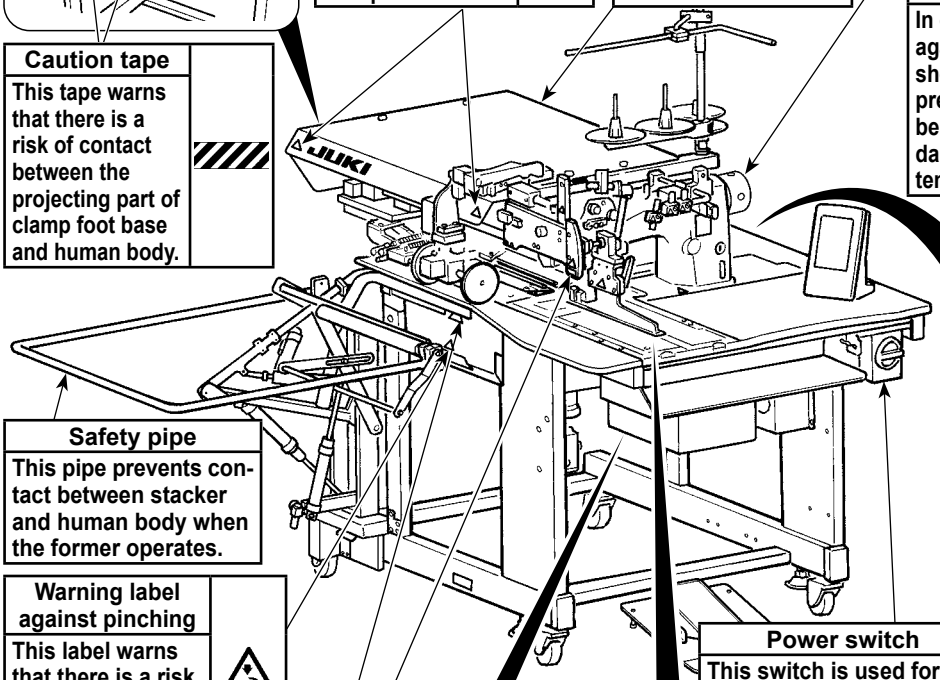
Warning label against pinching
This label warns that there is a risk of contact between human body and clamp foot.

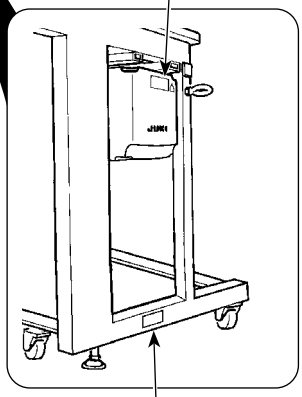
Top cover
This is a cover to prevent contact between work clamp and human body when the work clamp travels forward and backward.

Rotational direction label
This label warns the direction of rotation of sewing machine.

Caution tape
This tape warns that there is a risk of contact between the projecting part of clamp foot base and human body.

Electrical-shock danger label
In order to protect against electrical shock, safety precautions to be taken to avoid danger are written on this label.
(EU type)
(Refer to "Electrical-shock danger label" on page i.)





Safety pipe
This pipe prevents contact between stacker and human body when the former operates.

Warning label against pinching
This label warns that there is a risk of contact between human body and corner knife.

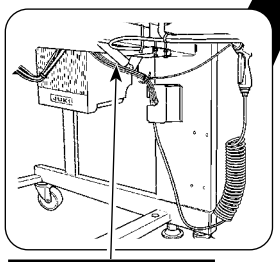
Power switch
This switch is used for disconnecting the power unit of the sewing machine from the power supply. It is also used as the emergency stop switch.

Load-center label
This label indicates the center of gravity of he machine. (Two parts)

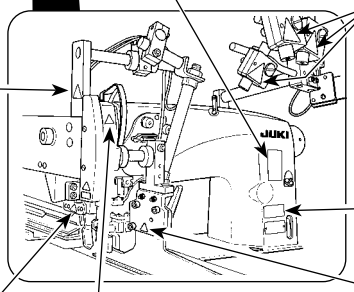
Watch-your-head label
This label warns that there is a risk of contact between the part which protrudes from machine and human body when binder device stays open.

Warning label
The label gives the minimum precautions to be taken when operating the sewing machine.
(Refer to the warning label on page i.)

Laser caution label
This label warns workers not to look straight into laser light.



Warning label against pinching
This label warns that there is a risk of contact with hands/fingers and dart stretcher.



Certification label
Complies with 21 CFR 1040.10 and 1040.11 except for conformance with IEC 60825-1 Ed. 3., as described in Laser Notice No. 56, dated May 8, 2019.

Gas spring
Component to ensure safety when raising/returning the sewing machine from/to its home position.

Warning label against pinching
This label warns that there is a risk of contact between hands/fingers and center knife.

Warning label against pinching
This label warns that fingers or other parts of human body can be pinched in the thread take-up lever.

Warning label against pinching
This label warns that there is a risk of contact between hands/fingers and binder and clamp foot.

CAUTION

In addition, be aware that the safety devices such as the "eye protection cover" and "finger guard" are sometimes omitted in the sketches, illustrations and figures included in the Instruction Manual for the explanation's sake. In the practical use, never remove those safety devices.

EU DECLARATION OF CONFORMITY

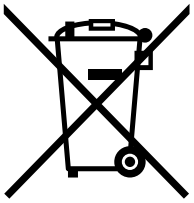
We hereby declare that the sewing unit or sewing system described as

Model	APW-895NE
Description	Industrial Sewing Unit
Function	automatically make stitches and sew

complies with the following applicable regulations :
EU Machinery Directive 2006/42/EC
EU EMC Directive 2014/30/EU
EU RoHS Directive 2011/65/EU

Applied harmonized standards, in particular :
EN ISO12100:2010, EN ISO10821:2005/A1:2009, EN IEC 60204-31:2013, EN IEC 63000:2018

Manufacturer :
JUKI CORPORATION
2-11-1, Tsurumaki, Tama-shi, Tokyo, Japan



European Union Only

Note : Affixing "Recycling Symbol" on certain equipments is required according to EU Directive 2002/96/EC (so-called WEEE Directive) and EN 50419.

(EN)
This equipment is subject to such Directive and is marked with the above recycling symbol. This means that, at the time of disposal, you must not dispose of this equipment as unsorted municipal waste, and must place this equipment to such appropriate collection point as specified under the applicable law.
This is for protection of the environment. (European Union Only)

(DE)
Diese Anlage entspricht den Entsorgungsrichtlinien der EU und ist mit dem o. g. Recyclingsymbol markiert. Dies bedeutet, daß Sie diese Anlage nicht als Restmüll entsorgen dürfen. Sie müssen diese Anlage zu einer entsprechenden Sammelstelle bringen, wie gesetzlich unter Umweltschutzgesichtspunkten vorgeschrieben. (Nur EU).

(FR)
Cet équipement est soumis à la directive suivante et est marqué par le symbole de recyclage ci dessus. Cela signifie qu'au moment de le jeter, il ne faut pas s'en débarrasser comme déchet municipal non triés, mais cet équipement doit être placé dans un point de colecte approprié comme spécifié par la loi en vigueur. Ceci pour la protection de l'environnement. (Union européenne seulement).

(ES)
Este equipo está sujeto a tal Directivo y está marcado con el símbolo de reciclación. Este significa que a la hora de destrucción no debe destruir este equipo como una basura municipal desclasificada, y debe dejarla en tal lugar apropiado de colección como especificado bajo el ley apropiado. Es para protección del medio ambiente.

(IT)
Questa apparecchiatura e soggetta alle Direttive ed e contrassegnata con il sopra indicato simbolo di riciclo. Questo significa che al momento della eliminazione, non e possibile scaricare questa apparecchiatura insieme allo smaltimento rifiuti urbani, ma deve essere smaltita presso il punto dl raccolta stabilito dalla vigente legge. Questo deve essere fatto per la protezione dell'ambiente. (Solo per la Comunita Europea)

(FI)
Tämä laite kuuluu sellaisen direktiivin piiriin ja on merkitty ylläolevalla kierrätysmerkillä. Tätä laitetta ei saa hävitää lajittelematta(ei ole lajittelematonta yhdyskuntajätettä), vaan se on vietävä lajittelupisteesccn, joka on sille laissa osoitettu. Tämä on ympäristön suojelua varten. (Ainoastaan Euroopan Unionin alueella).

(SV)
Den här utrustningen är föremål för EU diraktiv och är märkt med ovan återvinnings symbol. Det betyder att, vid den tidpuhkt utrustningen skall kastas bort, får den ej kastas som osorterad kommnunalt skräp, utan på för den här utrustningen specifiserad plats enligt lagen. Det är för att skydda miljön. (European Union Bara)

(DA)
Dette udstyr er underkastet dette direktiv og er markeret med ovenniævnte genbrugssymbol. Det indebærer at ved bortskaffelse må udstyret ikke bortskaffes med husholdningsaffald, men skal afleveres på godkendt indsamlingssted i henhold til gældende lovgivning. Dette er for at beskytte miljøet.
(Gældende for den Europæiske Union)

(HU)
Ezen terméken „újrahasznosítási” embléma található, ami azt jelenti, hogy selejtezéskor nem szabad közönséges hulladékként kezelni, hanem csak törvényileg elöírt szelektív gyüjtöhelyre kell leadni. Ez környezetünk védelmére szolgál ! (Csak EU országok esetén alkalmazandó !)

(ET)
Antud seade on määratletud keskkonnakaitsealase direktiiviga ja on märgistatud vastava jäätmekäitlemistähistega. See tähendab, et antud seadet ei tohi käsitleda kui olmejäätmeid ja tuleb vastavalt käitlemisseadustele ladustada selleks ettenähtud kogumispunktis. See tagab keskkonnakaitse.
(kehtib ainult Euroopa Liidus)

(NL)
Dit materiaal is onderworpen aan dergelijke richtlijnen en is aangeduid met het bovengenoemde recyclihgssymbool. Dit betekent dat, op het tijdstip van verwijdering, u dit materiaal niet als niet gesorteerd gemeentelijk afval mag wegdoen. Dit materiaal moet aangeboden worden aan een gemeentelijk afval punt zoals die in het kader van de toepasselijke wet wordt gespecificeerd. Dit is voor bescherming van het milieu. (Alleen voor Europese Unie)

(EL)
Ο ΕΞΟΠΛΙΣΜΟΣ ΑΥΤΟΣ ΕΙΝΑΙ ΜΑΡΚΑΡΙΣΜΕΝΟΣ ΜΕ ΤΟ ΣΗΜΑ ΑΝΑΚΥΚΛΩΣΗΣ. ΑΥΤΟ ΣΗΜΑΙΝΕΙ ΟΤΙ ΤΗ ΣΤΙΓΜΗ ΤΗΣ ΑΝΤΙΚΑΤΑΣΤΑΣΗΣ ΤΟΥ, ΔΕΝ ΠΡΕΠΕΙ ΝΑ ΠΕΤΙΕΤΑΙ ΣΤΑ ΚΟΙΝΑ ΑΠΟΡΡΙΜΑΤΑ ΑΛΛΑ ΣΕ ΣΥΓΚΕΚΡΙΜΕΝΟ ΣΗΜΕΙΟ ΣΥΛΛΟΓΗΣ ΟΠΩΣ ΟΡΙΖΕΤΑΙ ΑΠΟ ΤΟ ΝΟΜΟ ΓΙΑ ΤΗΝ ΠΡΟΣΤΑΣΙΑ ΤΟΥ ΠΕΡΙΒΑΛΛΟΝΤΟΣ. (ΟΔΗΓΙΑ ΣΥΜΦΩΝΗ ΜΕ ΤΑ ΣΤΑΝΤΑΡ ΤΗΣ ΕΥΡΩΠΑΙΚΗΣ ΕΝΩΣΗΣ)

(PT)
Este equipamento está sujeito a esta directiva e esta marcado com o símbolo de reciclagem. Isto quer dizer que o produto depois de gasto Não pode ser colocado. Como lixo municipal, tem que ser colocado em sítio apropriado, confoorme é especificado na lei. Isto é para protoger o ambiente. (Só para a União Europeia)

(LT)
Ši įranga atitinka tokią Direktyvą ir yra paženklinta aukščiau pavaizduotu utilizavimo simboliu. Tai reiškia, kad šio įrengimo negalima išmesti kartu su nerūšiuotomis municipalinėmis šiukšlėmis, bet būtina pristatyti į specialias surinkimo vietas, kaip nurodoma galiojančiuose įstatymuose. Tai taikoma aplinkos apsaugai. (Tik Europos Sa junga)

(LV)
Iekārtas iepakojums ir šīs Direktīvas priekšmets un tas ir marķēts ar augstākminēto otrreizējēs izejvielu pārstrādes simbolu. Tas nozīmē, ka nodošanas vai izpakošanas brīdī, iepakojums nedrīkst tikt pieskaitīts pie sadzīves atkritumiem vai iepakojumiem, bet tam ir jābūt apsaimniekotam saskaņā ar attiecīgās valsts likumu par iepakojuma apsaimniekošanu, kurš nepieder pie sadzīves atkritumiem ar mērķi pasargāt apkārtējo vidi no piesārņojuma. (attiecās tikai uz Eiropas Savienību).

(PL)
Zgodnie z prawem Unii Europejskiej niniejszy artykuł jest oznakowany wyżej podanym symbolem recyclingu. Oznacza to, iż artykuł po zakończeniu eksploatacji nie może być traktowany jako odpad komunalny lecz musi być składowany w odpowiednim punkcie segregacji odpadów, zgodnie z obowiązującymi przepisami. Działanie to ma na celu ochronę środowiska (dotyczy obszaru UE).

(SL)
Ta oprema je predmet Direktive in je označena z (zgoraj) priloženim simbolom. To pomeni, da pri odlaganju opreme, s to ne smemo ravnati kot z nesortiranimi komunalnimi odpadki, temveč jo moramo odložiti na primerno zbirališče kot je navedeno v veljavni zakonodaji. Ta poseg je nujen za varstvo okolja.
(samo za članice Evropske Unije)

(CS)
Na toto zařízení se vztahuje příslušná Směrnice a zařízení je označeno symbolem recyklace. To znamená, že v době likvidace nesmí být s tímto zařízením zacházeno jako s netříděným komunálním odpadem, ale musí být umístěno do patřičného sběrného střediska, jak je uloženo příslušným zákonem. Cílem je ochrana životního prostředí. (Platné pouze pro Evropskou Unii)

(SK)
Toto zariadenie podlieha platným smerniciam a je uvádzané na trh s vyššie uvedeným symbolom recyklácie. To znamená, že v čase likvidácie, toto zariadenie nesmie byť likvidované ako netriedený komunálny odpad ale musí byť umiestnené na vhodnom zbernom mieste určenom príslušnou právnou normou. Toto je robené za účelom ochrany životného prostredia. (len pre krajiny EU)

(NO)
Den här utrustningen är föremål för EU diraktiv och är märkt med ovan återvinnings symbol. Det betyder att, vid den tidpuhkt utrustningen skall kastas bort, får den ej kastas som osorterad kommnunalt skräp, utan på för den här utrustningen specifiserad plats enligt lagen. Det är för att skydda miljön. (European Union Bara)

(BG)
Това оборудване попада под разпоредбите на горната Директива на ЕС и е маркирано с горния знак за рециклиране. Това означава, че оборудването не трябва да се изхвърля с несортирания битов боклук, а трябва да се предаде в специален пункт за събиране на отпадък в съответствие със закона. Горното е във връзка с опазване на околната среда. (Само за Европейския съюз)

(RO)
Acest echipament face obiectul Directivei si este marcat cu simbolul de reciclare de mai sus. Aceasta inseamna ca, in momentul in care va dispensati de el, acest echipament nu trebuie tratat ca si gunoi menajer normal, ci trebuie dus la un punct special de colectare, dupa cum se specifica in legile in vigoare. Aceasta se face in scopul protejarii mediului.

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I. CAUTIONS BEFORE OPERATION

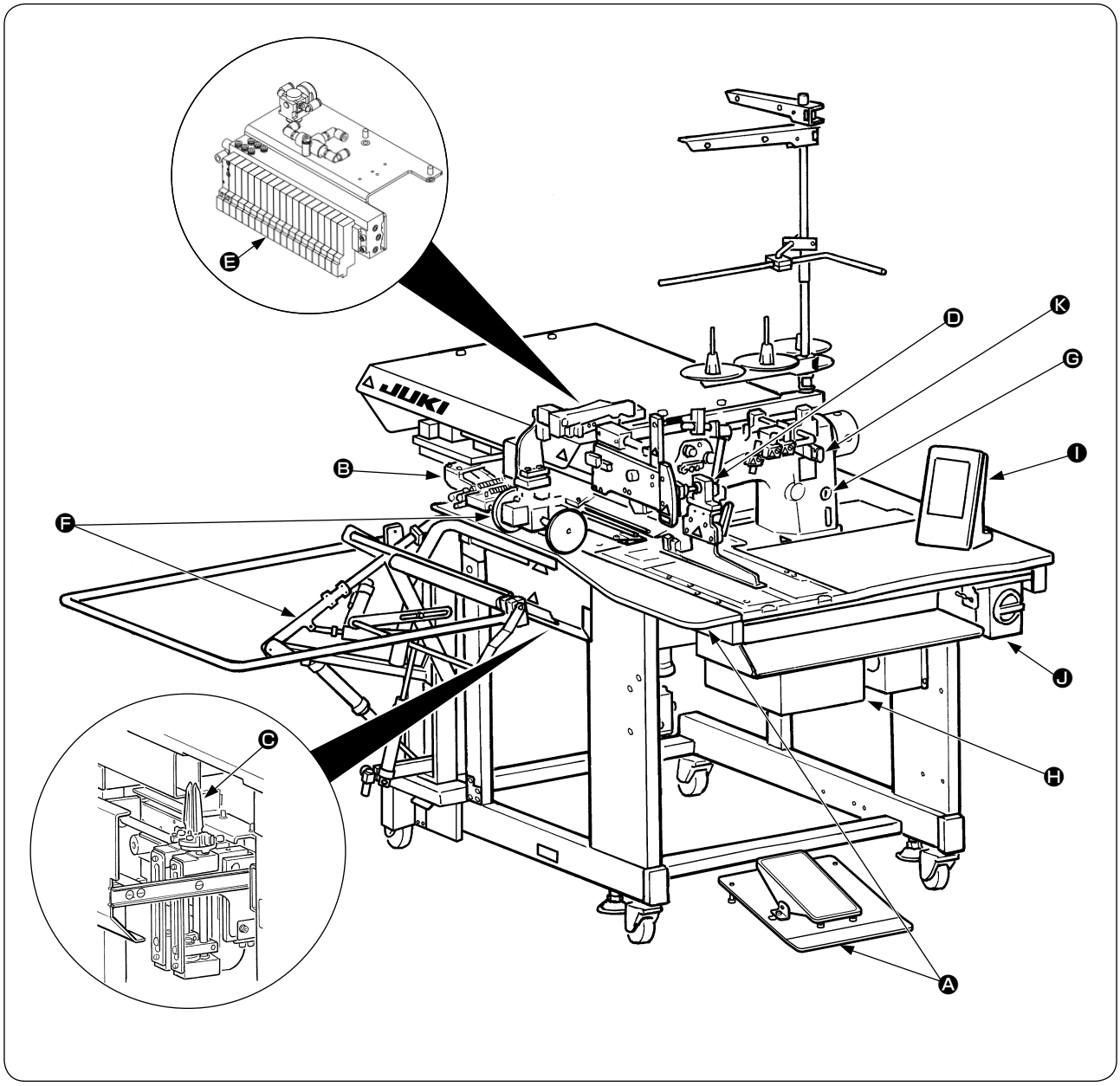
Following items have to be checked every working day before the operation of the machine and before the start of work hours.

1. **Ascertain that the sewing machine is filled with the predetermined amount of oil.**
2. **Never operate the machine unless the lubricating part in the hook has been filled up with oil.**
3. **Ascertain that the pressure gauge indicates the designated air pressure of 0.5 MPa.**

   *** (This is necessary particularly when the compressor is stopped for a lunch break or the like.)**

   If the compressed air pressure is equal to or less than the designated value, troubles such as interference between the parts can occur. It is therefore necessary to carefully check the compressed air pressure.
4. **Check whether the needle thread/bobbin thread need to be replenished.**
5. **To perform sewing immediately after turning ON the power switch, perform trial stitching first, then proceed with sewing of actual products after the test sewing.**

II. CONFIGURATION OF THE MACHINE



The APW-895N consists mainly of the following units.

- Ⓐ Frame and structural components (Framesewing table, covers, foot switch, etc.)
- Ⓑ Clamp foot unit and feed mechanism
- Ⓒ Corner knife unit
- Ⓓ Binder unit (Binder components and its driving components)
- Ⓔ Pneumatic control unit (Pneumatic control devices and pipings)
- Ⓕ Stacker unit (Optional)
- Ⓖ Sewing machine head
- Ⓗ Electric control unit (Control panel)
- Ⓘ Operation panel
- Ⓙ Power switch (Also used as the emergency stop switch)
- Ⓚ Temporary stop switch

With this machine consisting of the aforementioned 11 units, you can do desired welting work simply by setting materials (garment body, interlining piece, welting patch, etc.) in place and operating the switches on the operation panel.

In addition, when temporary stop switch Ⓚ is pressed during operation of the device, the device stops.

III. SPECIFICATIONS

1. MECHANICAL SPECIFICATIONS

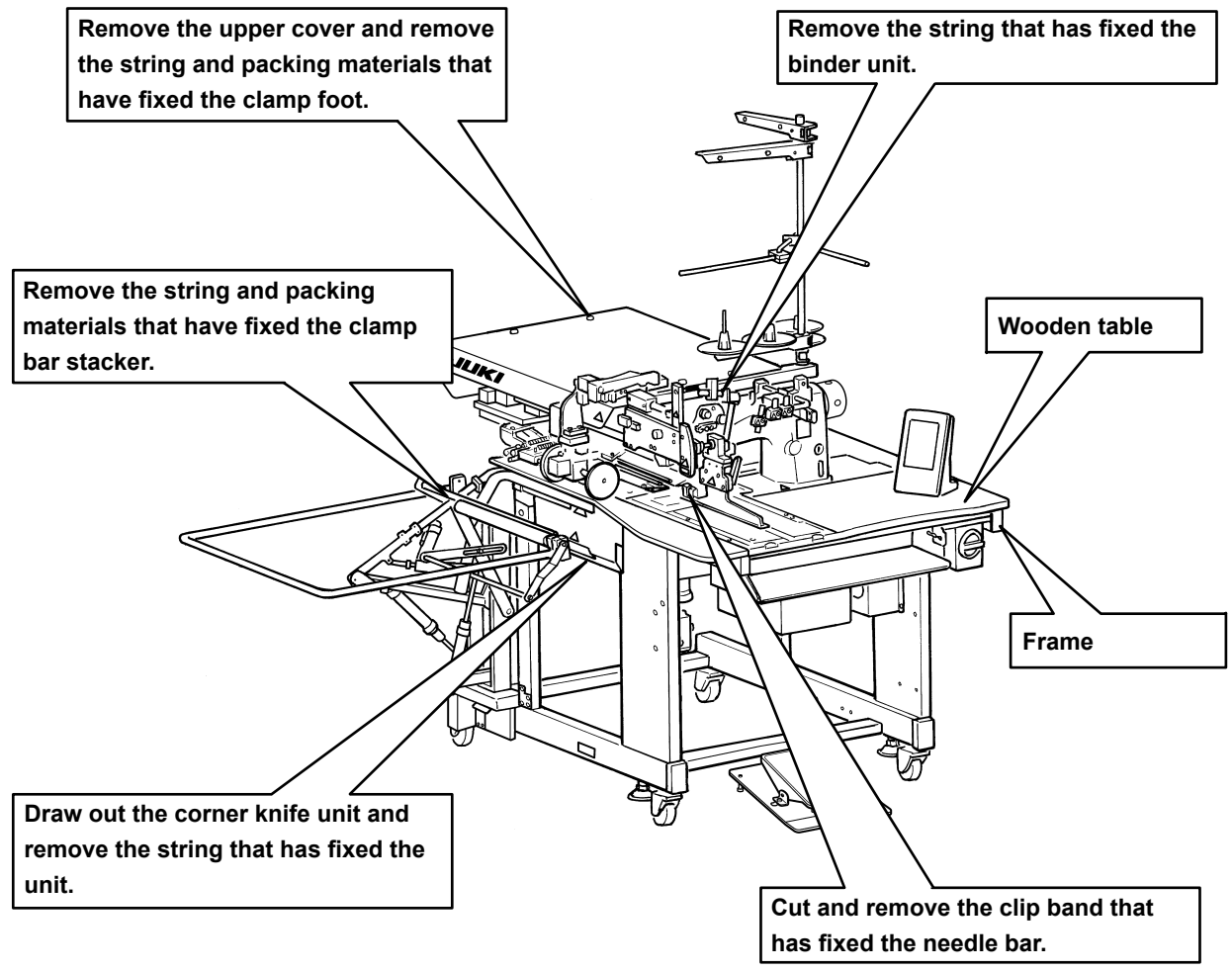
1	Sewing machine	LH-895N model of 2-needle, lockstitch machine with a center knife
2	Sewing speed	3,000 sti/min (max.)
3	Stitch length	Lockstitch : 2.0 to 3.4 mm (standard : 2.5 mm) Condensation stitch : 0.5 to 1.5 mm (standard : 1.0 mm) Back tack stitch : 0.5 to 3.0 mm (standard : 2.0 mm) Condensation/Back tack stitch selectable
4	Types of welt	Parallel double welt Each with flap or without flap
5	Pocket lip length (Welt lenght)	**Possible to set in increments of 1 mm within the range of min. 18 to max. 220 mm** Note that the pocket length is min. 35 mm when using the corner knife.
6	Welting width (Needle gauge)	10, 12 mm
7	Needles	ORGAN DP X 17 #14 to #18 (standard #16)
8	Thread	Spun thread #60 (Recommended)
9	Hook	Full rotary, vertical-axis, self-lubrication hook
10	Thread take-up lever	Slide thread take-up lever
11	Needle bar stroke	33.3mm
12	Cloth feed mechanism	Driven by stepping motor
13	Control	By a micro-computer
14	Safety mechanism	Machine operation is automatically stopped if the cloth feed mechanism error detector, the needle thread breakage detector or any of the various safety devices is actuated.
15	Lubricating oil	JUKI New Defrix Oil No. 1
16	Operating air pressure	0.5 MPa
17	Air consumption	Approx. 40 Nℓ/min
18	Dimensions of machine	Width : 1,095 mm Length : 1,500 mm Height : 1,165 mm (1,800 mm - when including the thread stand)
19	Weight	238.5kg
20	Noise	- Equivalent continuous emission sound pressure level (L_{pA}) at the workstation : A-weighted value of 78.5 dB; (Includes K_{pA} = 2.5 dB); according to ISO 10821- C.6.3 -ISO 11204 GR2 at 3,000 sti/min for the sewing cycle, 4.5s ON. (Pattern : No.1, Jump feed speed of clamp foot : Max speed).

2. ELECTRICAL SPECIFICATIONS

1	The number of independent sewing patterns that can be stored in memory	99 (1 to 99)
2	The number of alternate sewing patterns that can be stored in memory	20 (1 to 20)
3	The number of cycles that can be stored in memory	20 (1 to 20)
4	Input power :	Single phase : 220 to 240V 50/60 Hz Voltage fluctuation : Within + 10% of the rated voltage
5	Power consumption	270VA

IV. INSTALLATION

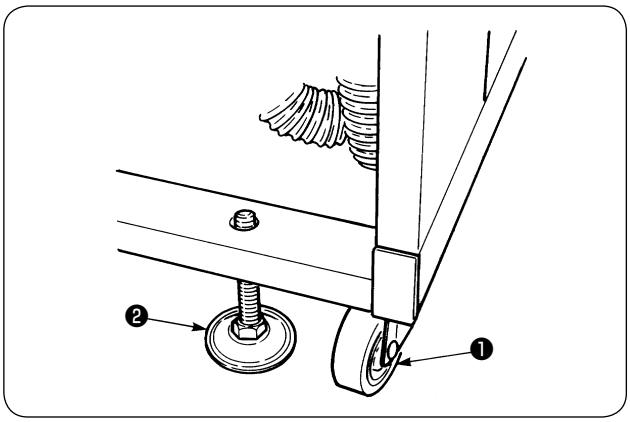
1. REMOVING PACKING MATERIALS



Caution **When lifting the machine, hold the frame without holding the wooden table.**

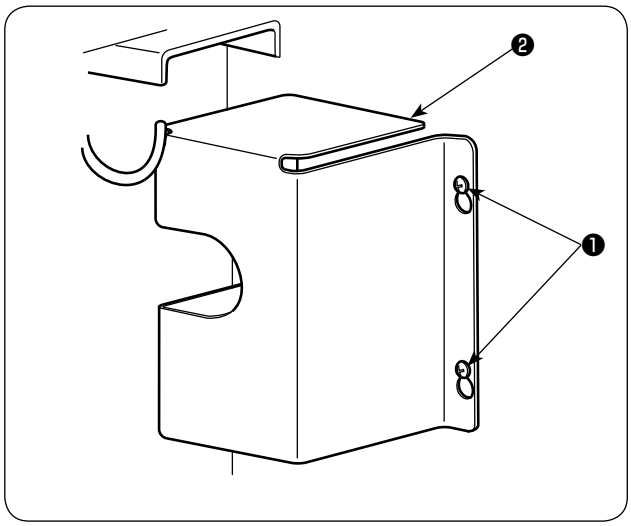
2. SECURING THE MACHINE

CAUTION :
To prevent a fatal accident, lower and fix adjust bolts ❷ (4 places) located at the side of caster ❶ after moving the machine to the level and stabilized place.

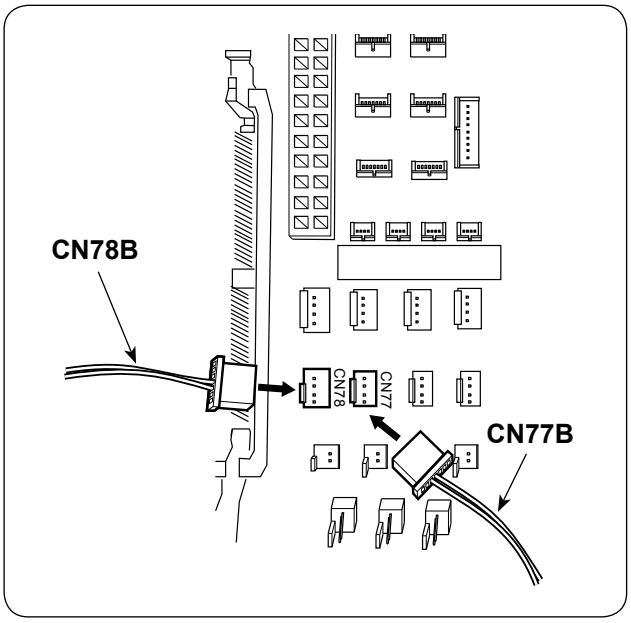


3. CONNECTING THE FOOT PEDAL

CAUTION :
When installing the pedal, perform the work paying attention to the overhead table.

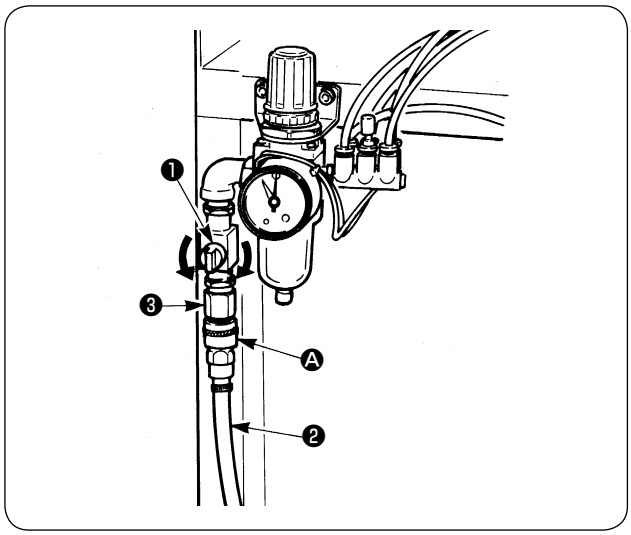


① Loosen four screws ❶ . Detach PCB cover ❷ .



② Insert the pedal connectors respectively into the connectors of junction PCB.
(Connect CN78B to CN78. Connect CN77B to CN77.)

4. CONNECTING THE AIR COUPLER



Connect one end of air coupler Ⓐ supplied with the machine as an accessory to air hose ❷ . Then connect the other end to coupler ❸ on the main unit side.

- **Connect coupler Ⓐ to the main unit with air cock ❶ closed, then carefully open air cock ❶ to allow the compressed air to be supplied.**
- **Make sure that the pressure gauge of the regulator reads 0.5 MPa.**

5. CONNECTING THE POWER PLUG

CAUTION :
To prevent possible accidents caused by leakage or dielectric strength, an appropriate power plug shall be installed by a person who has an expert knowledge of electricity. Be sure to connect the power plug to the receptacle that is well grounded.

Connection of the power plug to the power depends on the specifications of the product. Adjust the power plug to the power specifications to connect.

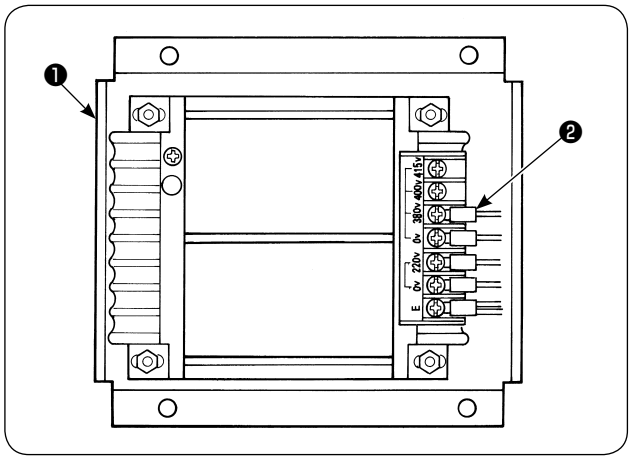
① In case of the product of single-phase, 220 to 240V specifications :
Connect the sky-blue and brown wires of the power cord to the power terminal (AC220 to 240V) and the yellow/green wire to the ground (earth) terminal respectively.

② In case of the product of 3-phase, 200 to 240V specifications :
Connect the red, white and black wires of the power cord to the power terminal (AC200 to 240V) and the yellow/green wire to the ground (earth) terminal respectively.

③ In case of the product with the optional high voltage transformer (with SA-128) :
Connect the black wires (3 pieces) of the power cord to the power terminal (AC380 to 415V) and the yellow/green wire to the ground (earth) terminal respectively.
It is possible to connect to 380/400/415V by setting of the input tap of transformer (standard setting at the time of delivery : 380V).

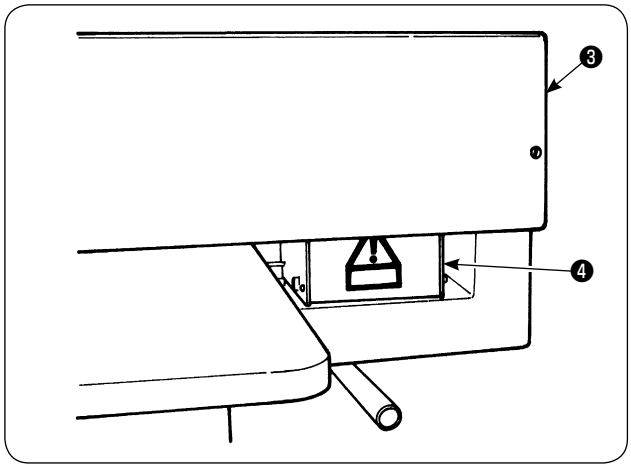
This product performs operation by the single-phase connection for 3-phasse 380/400/415V.

[Caution when changing the power source of the high voltage optional transformer]



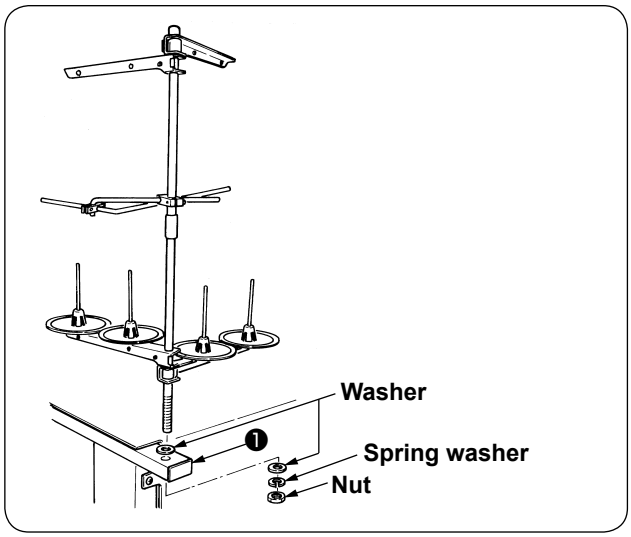
When using high voltage optional transformer ❶ with the input voltage of 400V or 415V, it is necessary to replace input power source cord ❷ of high voltage optional transformer ❶ . Change power source input cord ❷ (sky blue) that is connected to 380V to the connection of 400V or 415V.

To prevent accidents, perform the work after leaving the sewing machine alone more than 4 minutes in the state that the power switch is turned OFF and the power cord is drawn out.



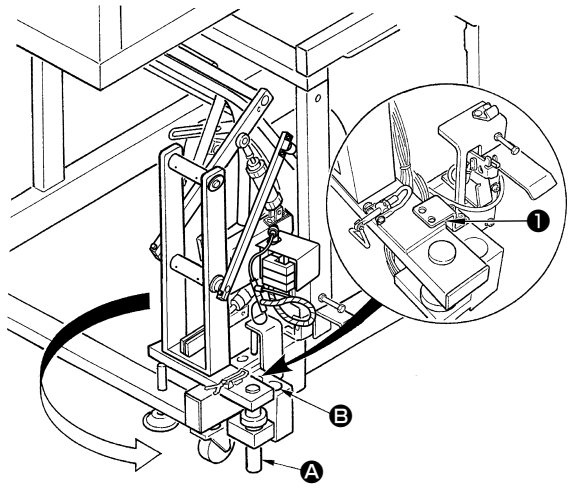
High voltage optional transformer ❶ is set on the rear side of the table.
When performing changeover of voltage, remove transformer box ❹ after removing top cover ❸ .

6. ASSEMBLING THE THREAD STAND AND ATTACHING IT TO THE MACHINE



Putting nut and washer between main unit frame ❶ and fix the thread stand as illustrated in the left-hand figure.

7. INSTALLING SP-46N (CLAMP BAR STACKER) (OPTIONAL PART NO. : 40149301)

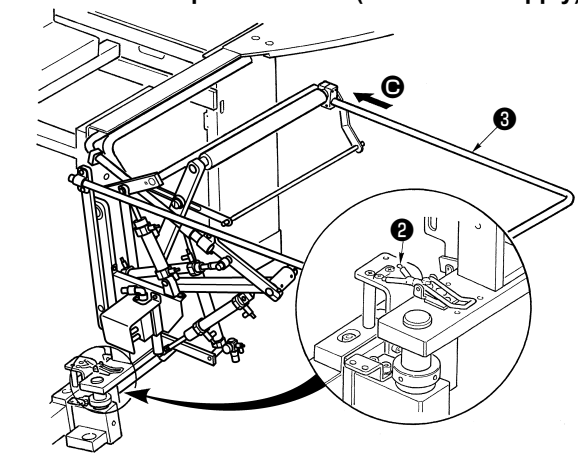


Clamp bar stacker is delivered in the state that it is fixed in the frame at the time of delivery with the clamp bar stacker mounted. It is necessary to change the installing position to the normal using position.

① Remove stacker fixing plate ❶ .
② Turn the whole stacker in the direction of the arrow and take it out from inside of the frame.
③ Change stacker turning shaft Ⓐ section to stacker base hole Ⓑ.

At this time, take care to prevent the stacker cord, the air piping, etc. from being caught. In addition, insert the stacker rotating shaft into the hole in the stacker base until the bottom of the base is reached.

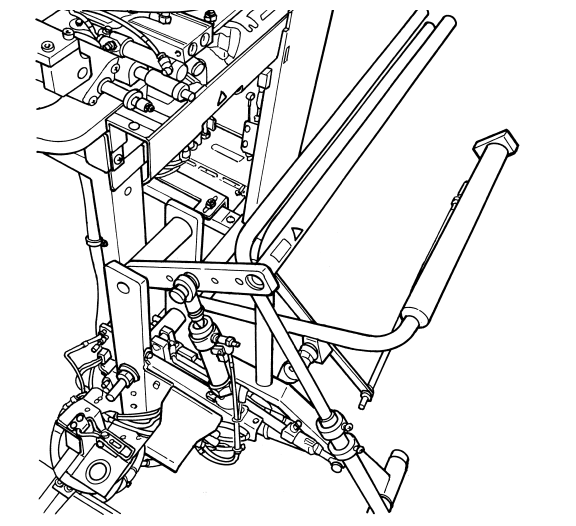
Stacker in the operation state (with the air supply)



④ Lock the whole stacker with hinge ❷ .
⑤ Insert safety bar ❸ in direction Ⓒ as illustrated in the figure. Fix the safety bar at the position where it is in parallel with the floor surface.

At this time, confirm that air is being supplied.

Stacker in the setup state (without the air supply)



In the case of power interruption due to a power failure, etc., the folding operation of the stacker can get out of order. Be aware that this can give rise to a risk that the hand is caught in the stacker. Do not put hands in the area surrounded by the safety bar.

If the aforementioned situation occurs, stop the air supply to bring the stacker back to the state shown in the left figure "Stacker in the setup state (without the air supply)". Then, start supplying the air after checking to make sure that the stacker is in the setup state.

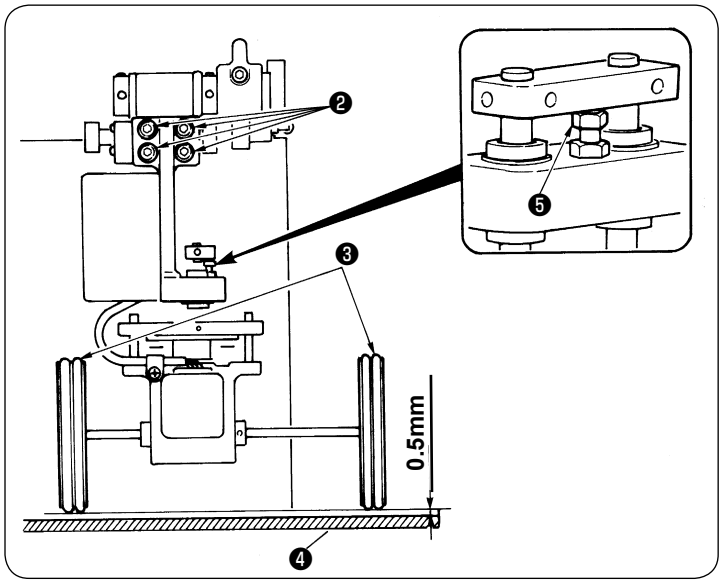
8. INSTALLING SP-47N (ROLLER STACKER) (OPTIONAL PART NO. : 40149302)

(1) Adjusting the position

In the case of using the SP-47N (roller stacker) with the APW-895NE, a sub table will be separately necessary.

Place an order for the sub table with the part number 40185763.

* 40185763 … Part number of the set parts consisting of the sub table and setscrews.

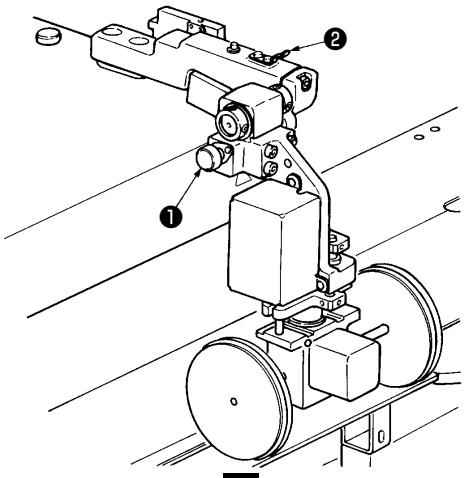


① Confirming parallelism
Make sure that stacker table ❹ and rubber roller ❸ are installed parallel with each other.
If not, loosen four setscrews ❷ to adjust.

② Confirming the clearance
Make sure that the clearance between stacker table ❹ and rubber roller ❸ is approximately 0.5 mm.
If it is not approximately 0.5 mm, loosen nut ❺ to adjust.

(2) Maintenance

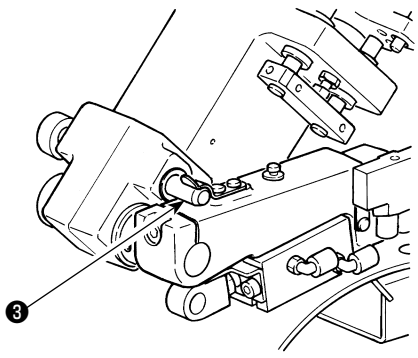
(Working state)



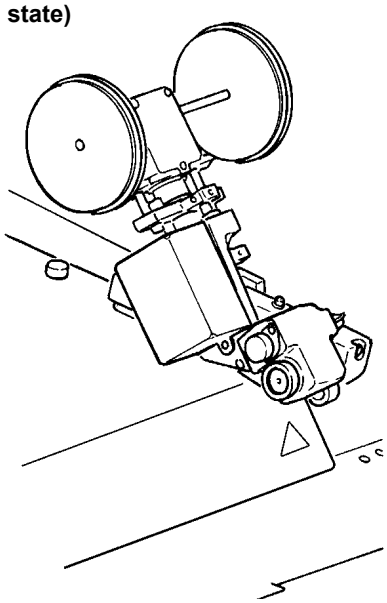
When the roller stacker is not used or adjusting the corner knife, the roller stacker can be turned upward with the procedure below.

Pull release lever ❶ . Lift up the roller section to thrust pin ❸ into fixing spring ❷ , then bring them into locked state (see Fig. 1). This puts the sewing machine in standby state.

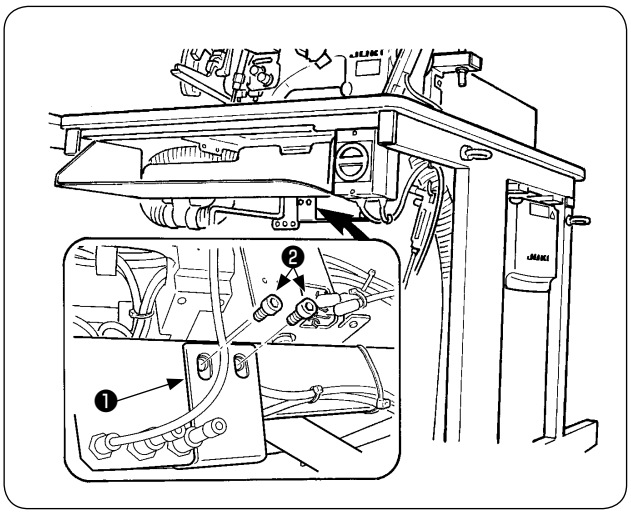
Fig. 1



(Waiting state)



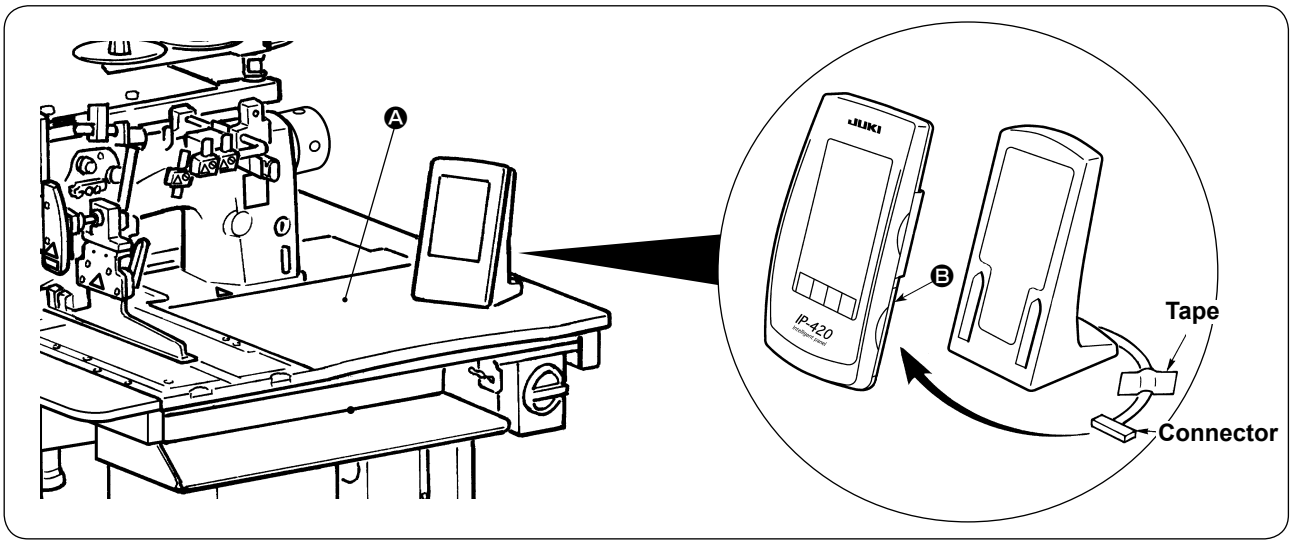
9. REMOVING THE HEAD FIXING PLATE



Remove fixing screws ❷ of head fixing plate ❶ .

Be sure to fix the machine and the frame when performing re-transportation.

10. INSTALLING OPERATION PANEL IP-420



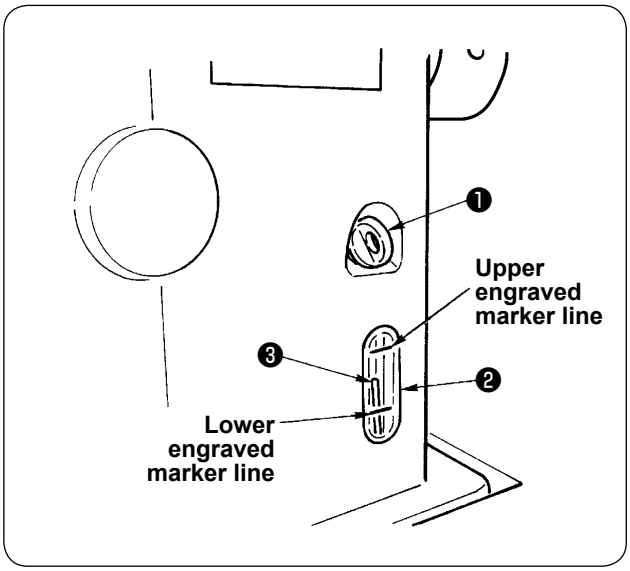
As shown in the figure above, open the lid on the right-hand section Ⓑ of IP-420 and connect the connector which is fixed with tape to the right-hand top surface Ⓐ of the table.

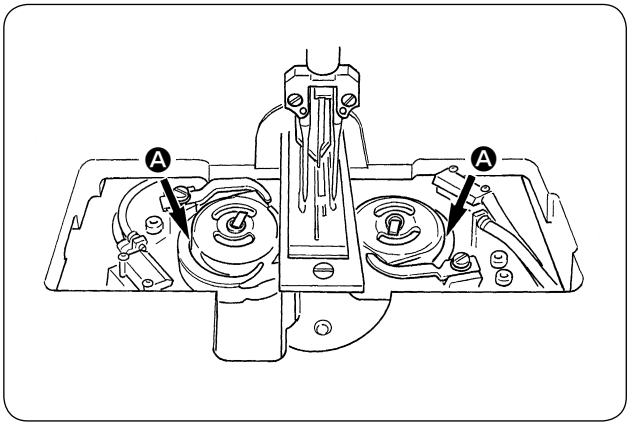
To prevent malfunction due to static electricity, install operation panel IP-420 on the panel base to use and do not change the position of the panel base.

11. LUBRICATING THE OIL TANK

CAUTION :

1. To prevent accidents caused by abrupt start of the sewing machine, do not connect the power plug until lubrication has been completed.
2. To prevent inflammation or rash, immediately wash the part when oil has stuck to your eyes or body.
3. If oil has been swallowed, diarrhea or vomiting may occur. Put oil to the place where children cannot reach.





Fill the oil tank with the oil for hook lubrication before operating the sewing machine.

① Remove oil cap ❶ and fill the oil tank with JUKI MACHINE OIL No. 1 (Part No. : MD-FRX1600C0) using the oiler supplied with the machine as accessories.

To prevent entering of dust, be sure to attach the cap for use.

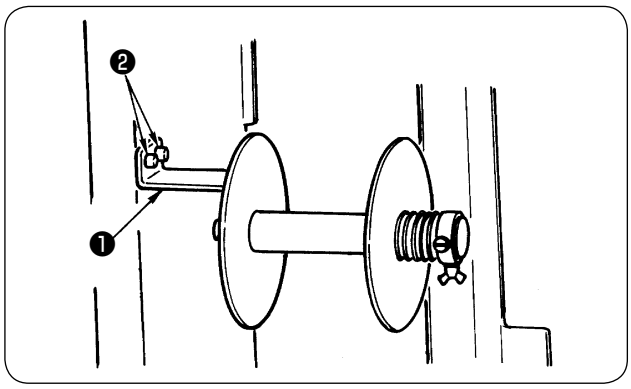
② Fill the oil tank with the oil until the top end of oil amount indicating rod ❸ comes between the upper engraved marker line and the lower engraved marker line of oil amount indicating window ❷ .
When oil amount is excessively large, oil leaks from the air hole or adequate lubrication cannot be performed. So, be careful.

③ When operating the sewing machine and the top of oil amount indicating rod ❸ has lowered up to oil amount indicating window ❷ , start lubricating.

- **At the time of initial filling, fill the oil tank with oil of 200cc as the standard and confirm that the oil amount indicating rod is working.**
- **When operating a newly installed machine or a machine which has not been used for a relatively long period of time, make the machine run at 2,000 sti/min or less for the purpose of break-in. In addition, use the machine after applying oil to races Ⓐ of the right/left hooks.**
- **For the oil for hook, purchase JUKI MACHINE OIL No. 1 (Part No. : MD-FRX1600C0).**
- **Be sure to fill the oil tank with clean oil.**
- **Never fill the oil tank with dirty oil.**

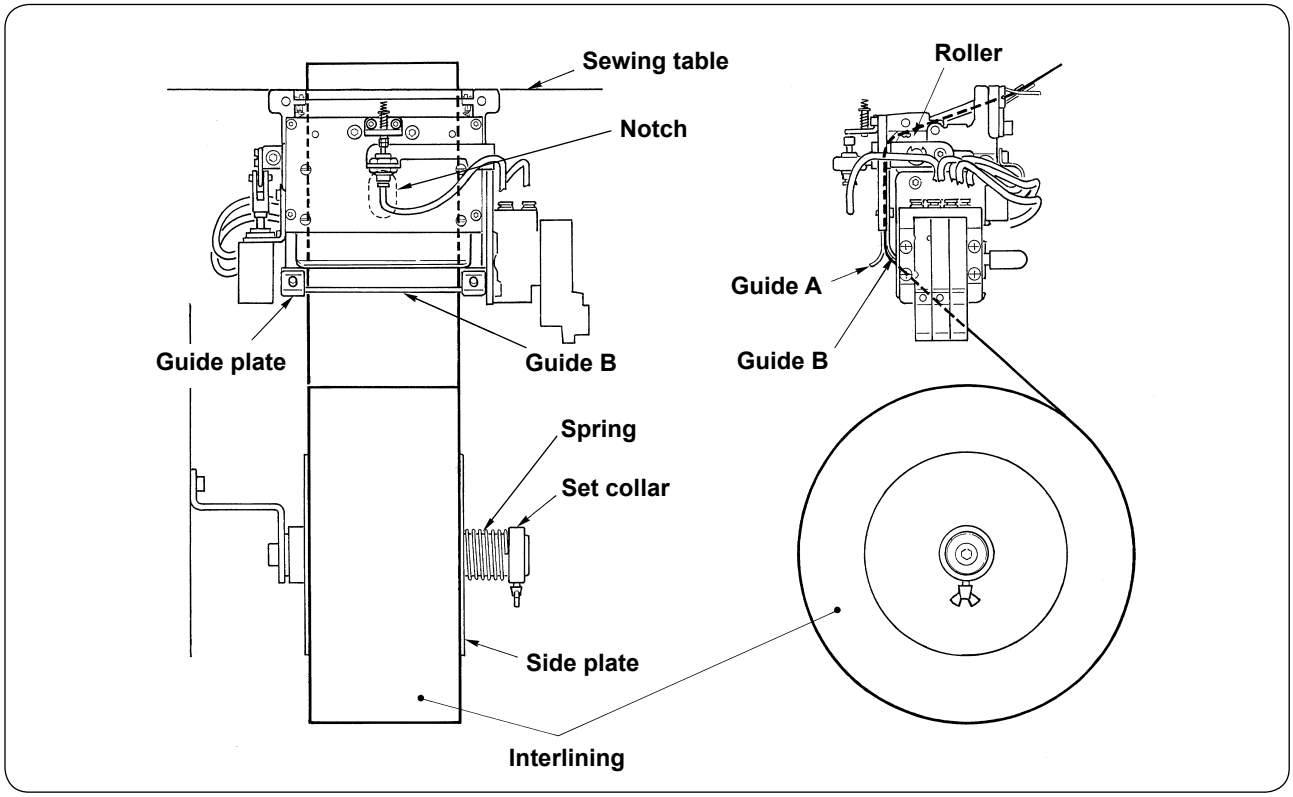
12. INSTALLING SA-120N (INTERLINING SUPPLYING DEVICE) (OPTIONAL PART NO. : 40149798)

CAUTION :
Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



*** It cannot be used for the long and wide type.**

① Fix interlining installing plate ❶ to the machine frame with two screws ❷ .



② Set interlining as shown in the figure above.
The roll core that can be used is 40 to 70 mm wide and 200 mm in roller diameter (max.).

③ Pass the interlining between guide B and guide A and roller, and route it up above the table.

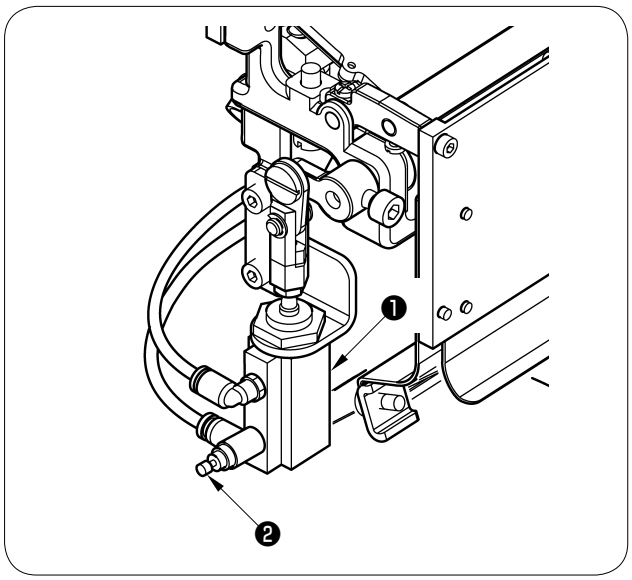
Reference **Feed the interlining up to the roller section using the notch of the guide plate.**

④ Adjust the lateral position of two guides, two guide pins and side plate (on the right) to allow the interlining to be fed straight up above the sewing table.

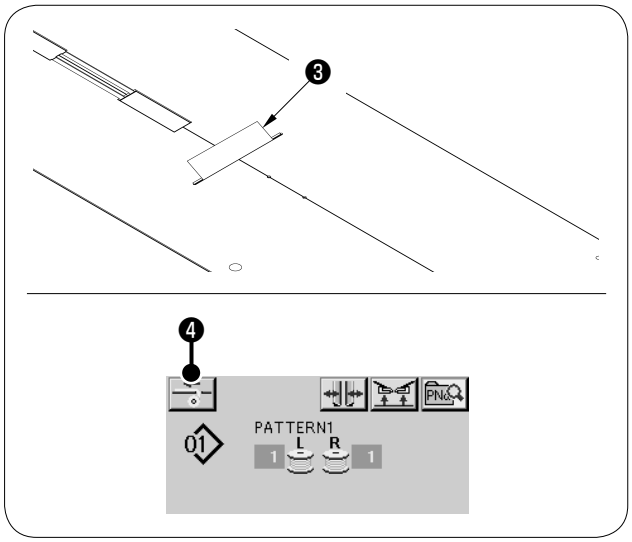
⑤ Position the set collar on the left-hand side to allow the side plate to lightly hold the interlining by spring. Then fix the set collar there.

13. ADJUSTMENT OF SA-120N (INTERLINING SUPPLYING DEVICE) (OPTIONAL PART NO. : 40149798)

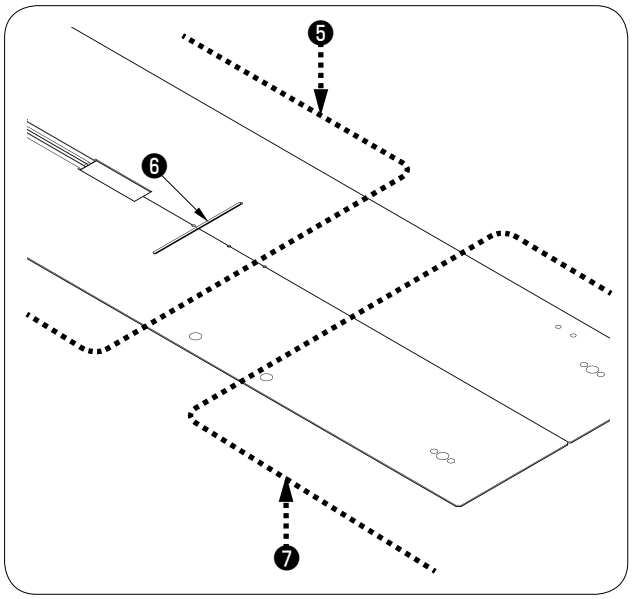
CAUTION :
Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



① Adjustment of the interlining feeding amount is performed with memory switch (U003). However, perform further fine adjustment with the speed controller ❷ of the interlining feeding cylinder ❶ .
(When tightening the speed controller ❷ , the amount is decreased and when loosening it, the amount is increased.)



② When a new interlining ❸ is mounted, press interlining supply button ❹ , perform feeding of the trial sewing several times and use the device after confirming the feeding amount and the parallel feeding of the interlining.



(Caution when operating)
When using the interlining supplying device with rear reference ❺ , the interlining at the sewing start remains long since it is away from interlining outlet ❻ . So, use the device with front reference ❼ .

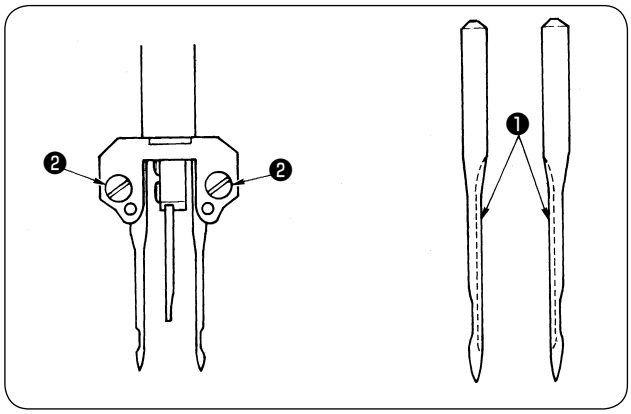
For handling the sewing tables, refer to "V-2.(2) Cautions to be taken when the sewing tables are removed" p. 16.

V. PREPARATION OF THE SEWING MACHINE

1. HOW TO OPERATE THE SEWING MACHINE HEAD

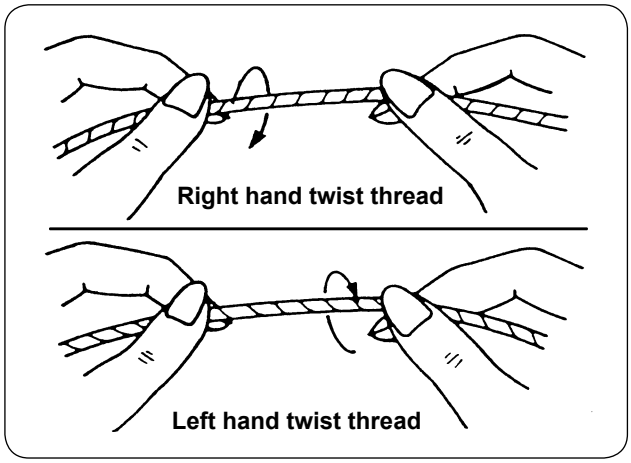
(1) How to attach the needles

CAUTION :
- **Turn OFF the power before starting the work so as to prevents accidents caused by abrupt start of the sewing machine.**
- **When replacing the needle, be careful not to allow your fingers to touch the blade section of the center knife.**



Needles used are DP X 17 #14 to #18 (standard #16). Use the specified needle.
Insert left- and right-hand sides needles as far as they will go pointing their long grooves ❶ at each other and tighten needle clamp screws ❷ .

(2) Thread used

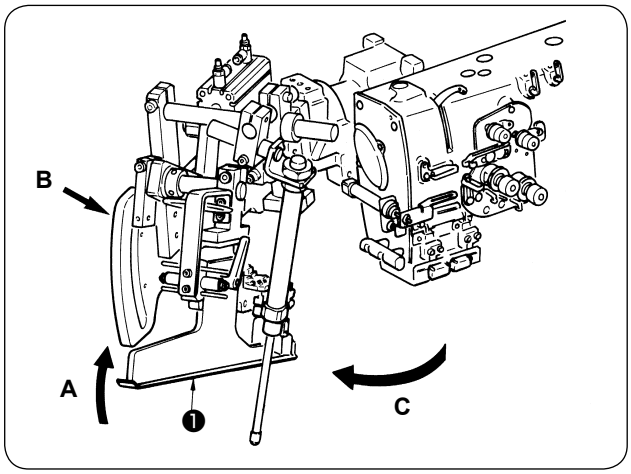


- Use the left hand twist thread for the needle thread.
- Either twist thread will do for the bobbin thread.

Use a new thread which is uniformly twisted.

(3) How to pass the needle thread

CAUTION :
Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

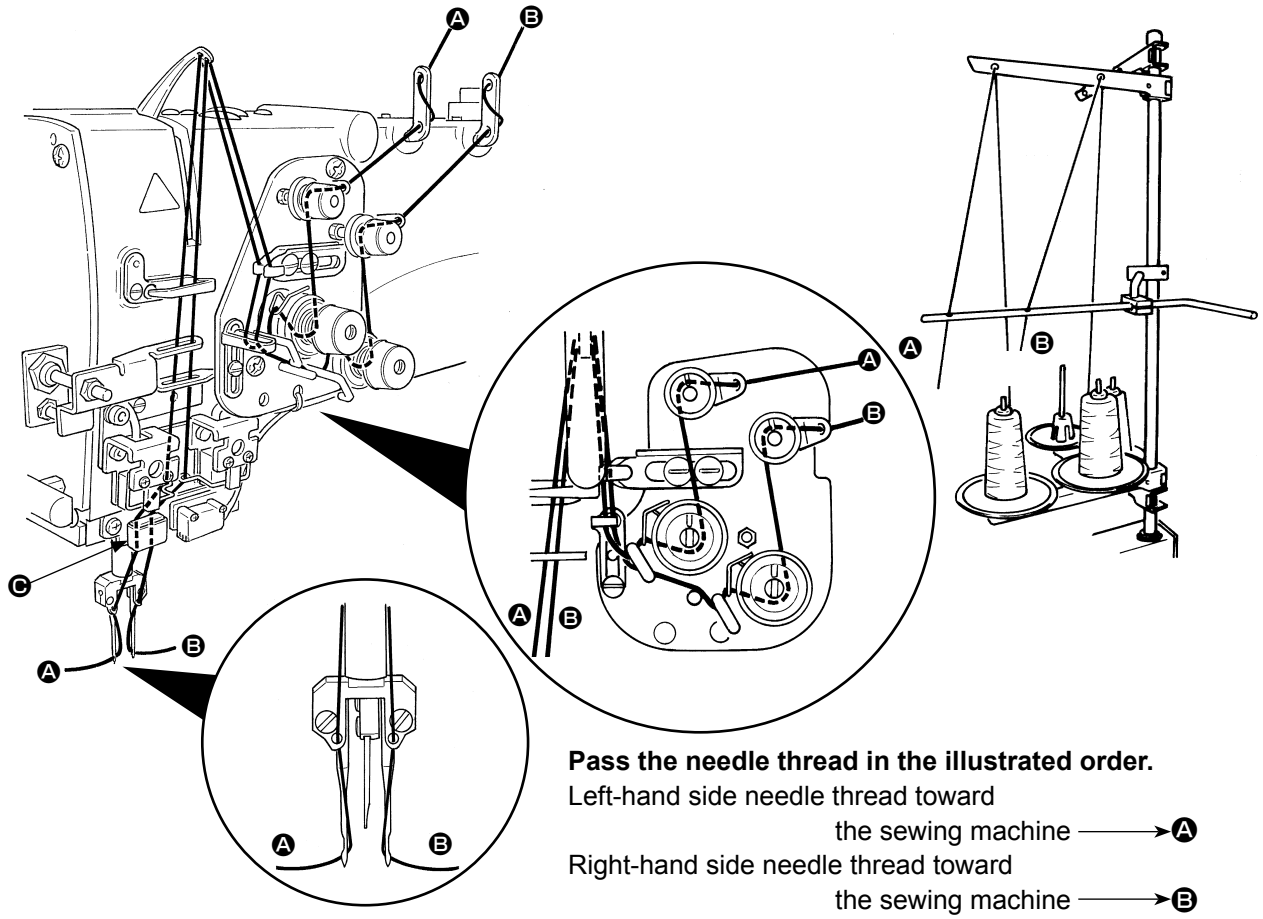


① Lift binder ❶ in the direction **A**, Hold section **B** by hand and turn the whole binder in the direction **C**.

Be sure to press section B since welting width may become improper when the binder is pressed and turned in the direction C.

Binder is locked with the ball plunger. Rather strongly turn the binder in the direction C to release the lock.

② Then pass needle thread in the order as shown in the figure below.



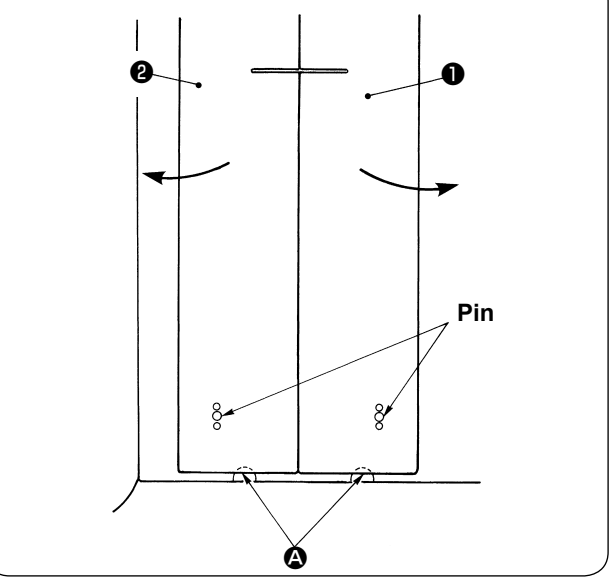
Pass the needle thread in the illustrated order.
Left-hand side needle thread toward the sewing machine ⟶ Ⓐ
Right-hand side needle thread toward the sewing machine ⟶ Ⓑ

Periodically replace thread guide felt Ⓒ. Sewing trouble due to rough motion of thread during sewing can be prevented.

2. HOW TO REMOVE THE SEWING TABLE

CAUTION :
Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

(1) When replacing the bobbin thread



① Move the clamp foot to the rear end of its stroke.
② Insert your fingers into notches Ⓐ in the bottom of right- and left-hand sewing tables ❶ and ❷ , and push up the sewing tables.
③ Move the tables in the direction of the arrow keeping the above state, and you can see the bobbin case.

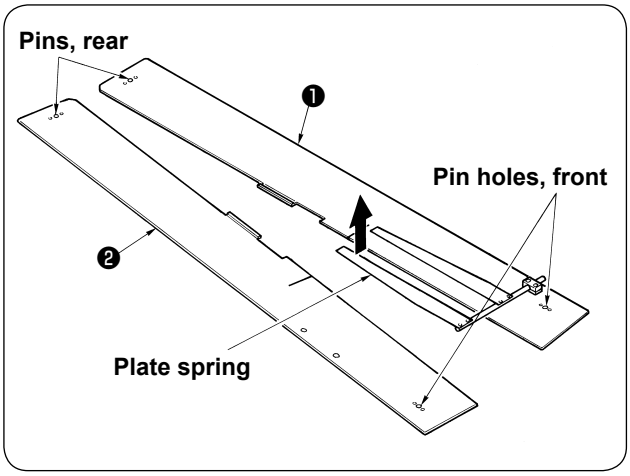
At this time, move the sewing tables so as not to allow the sewing tables to come in contact with the needles.

④ After replacing the bobbin thread, return the sewing tables in place by following the above-mentioned steps of procedure in the reverse order. Now, firmly set the sewing tables on the throat plates and the pins.

(2) Cautions to be taken when the sewing tables are removed

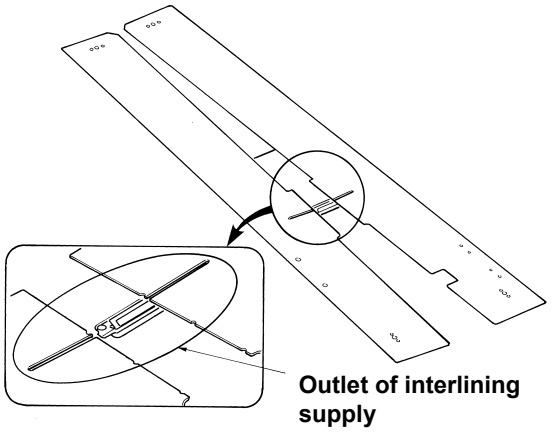
CAUTION :
Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

When you remove the sewing tables ❶ and ❷ , be sure to accurately set them by following the points below.



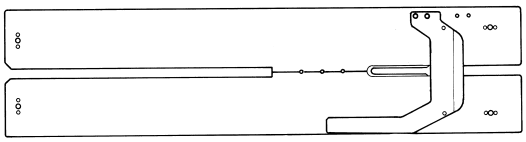
① Securely fit the pins, rear (left) (right) over the pin holes.
② Securely fit pin holes, front (left) (right) over the pins.

1. In case of the machine provided with SA-120N (automatic interlining supplying device), return the sewing tables to their home positions while lifting the sewing tables ❶ and ❷ so that the plate spring section is not bent.

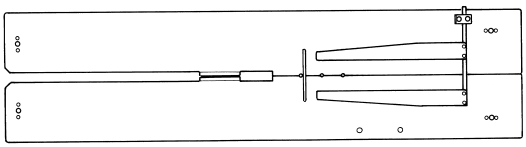


2. In case of removing the sewing tables ❶ and ❷ with the types below, take care not to bend pocket bag clamping device and interlining clamping device.

① Pocket bag clamping device (standard)

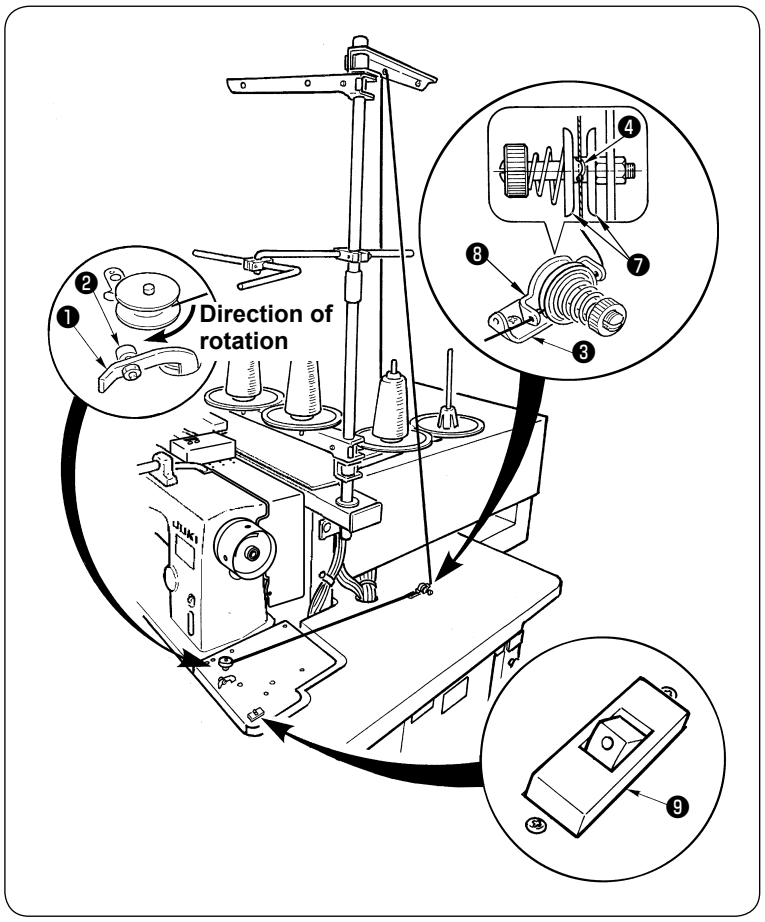


② Pocket bag clamping device (for interlining supply)



3. HOW TO WIND THE BOBBINS

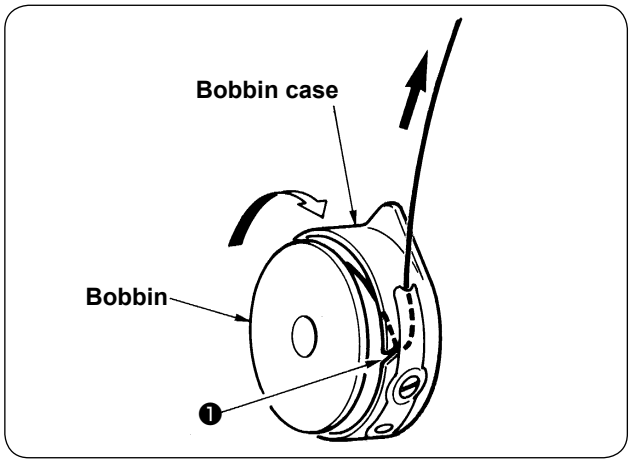
CAUTION :
To prevent damage, avoid contact with bobbins while the machine is in operation.



① Put bobbin into the thread winder shaft until it will go no further.
② Pass thread through thread guide plate ❽ , open thread tension disk ❼ and put the thread into the slit of thread tension rod ❹ .
③ Pass thread in the order as shown in the figure, and wind the thread onto bobbin by four or five turns. (The direction of the arrow corresponds to the direction of rotation of the bobbin.)
④ Press bobbin thread guide ❶ and the bobbin rotates.
⑤ The thread winder will automatically stop as soon as it has wound up the bobbin to a predetermined amount.

1. **If you want to wind a bobbin, start winding it from recess ❺ as illustrated in the figure above. If you start to wind a bobbin from portion ❻ , the detection of run-out of bobbin thread will fail to be performed normally.**
2. **To ensure the appropriate remaining amount of bobbin thread, it is important to wind the bobbin uniformly. Be sure to check that the bobbin is uniformly wound particularly at the start of bobbin winding.**
   If the bobbin fails to be uniformly wound with thread, properly adjust the lateral position of tension post socket ❸ .
3. **It is most suitable to wind the bobbin with thread to approximately 80% of the outer diameter of the bobbin. The winding amount can be adjusted with winding amount adjustment screw ❷ .**
4. **Do not press lever ❶ except when winding bobbin thread. Motor continues to run and trouble will be caused.**

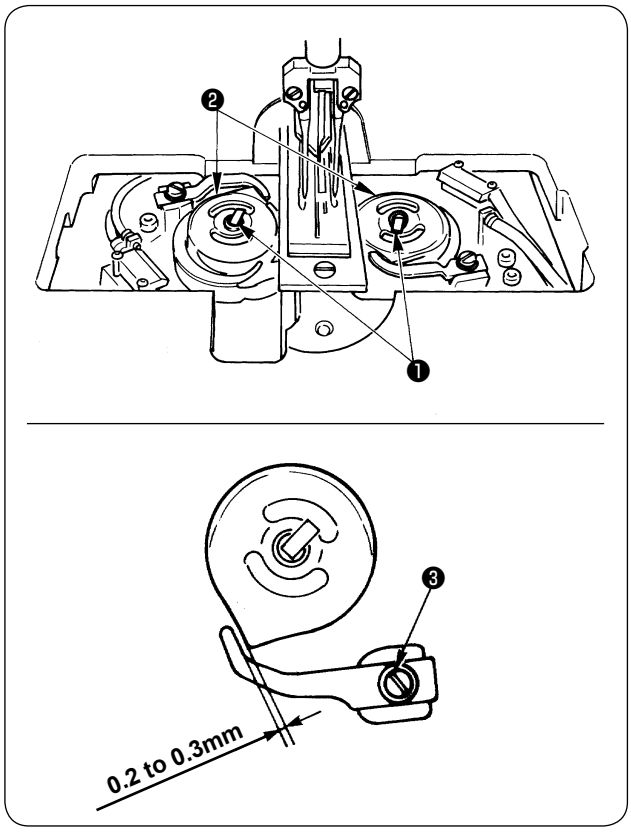
4. HOW TO THREAD THE BOBBIN CASE



① Hold in hand a bobbin in the way that it spins clockwise and put it into the bobbin case.
② Pass the thread through slot ❶ in the bobbin case.
③ Pull the thread to pass it under the tension spring.

5. HOW TO INSTALL THE BOBBIN CASE

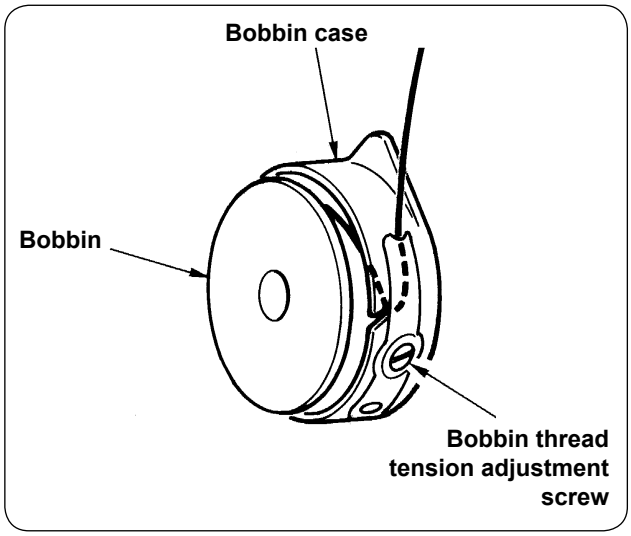
CAUTION :
Turn OFF the power before starting the work so as to prevent accident caused by abrupt start of the sewing machine.



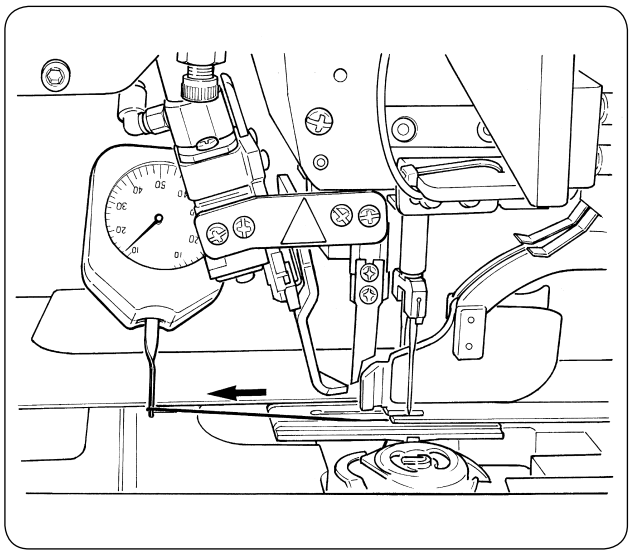
① Raise hook levers ❶ and take out the bobbin cases together with the bobbins.
② When fitting, fit the bobbin cases into the hook driving shaft and tilt levers ❶ .

When bobbin cases, left and right, ❷ are replaced, make sure that the clearance between the opener which is extremely receded and the bobbin case is 0.2 to 0.3 mm. If the clearance is not 0.2 to 0.3 mm, loosen setscrew ❸ and adjust it.

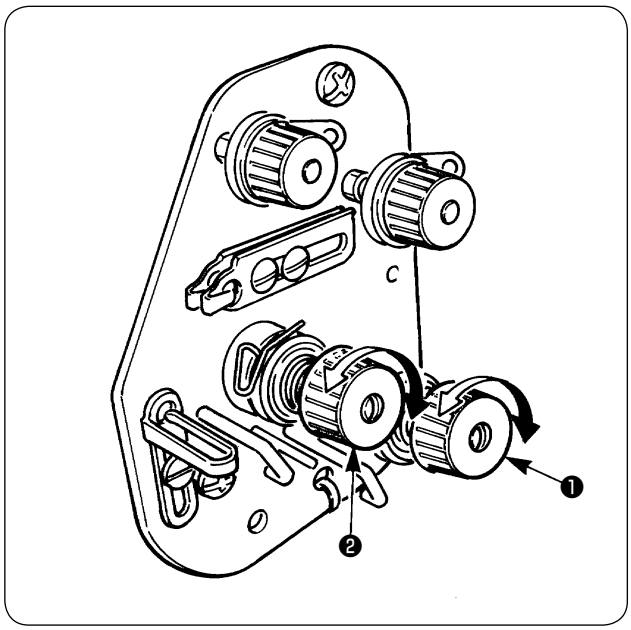
6. HOW TO ADJUST THE THREAD TENSION



① Adjusting bobbin thread tension
Turn bobbin thread tension adjustment screw clockwise to increase the bobbin thread tension or turn the screw counterclockwise to decrease it.

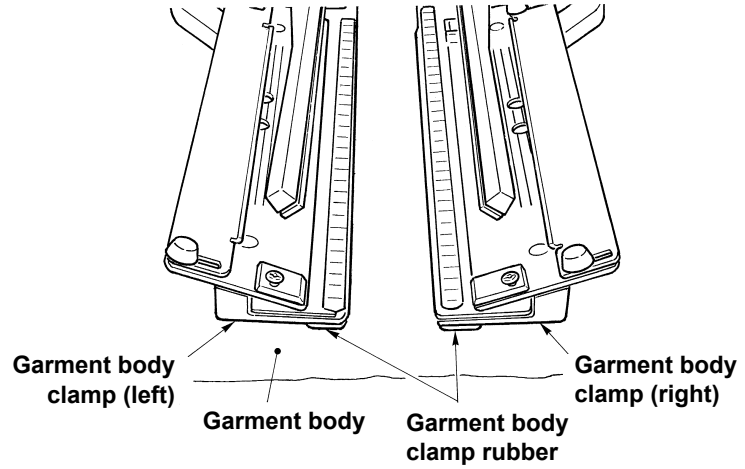


As shown in the left-hand figure, standard bobbin thread tension is 0.25 to 0.35N when measuring with the tension gauge.



② Adjusting needle thread tension
First, adjust the right- and left-hands bobbin thread tension.
Then in accordance with the bobbin thread tension obtained, adjust the right- and left-hand sides needle threads tension appropriately by turning thread tension adjustments nuts ❶ and ❷ respectively. Turning the nuts clockwise will increase the thread tension or turning them counterclockwise to decrease it.

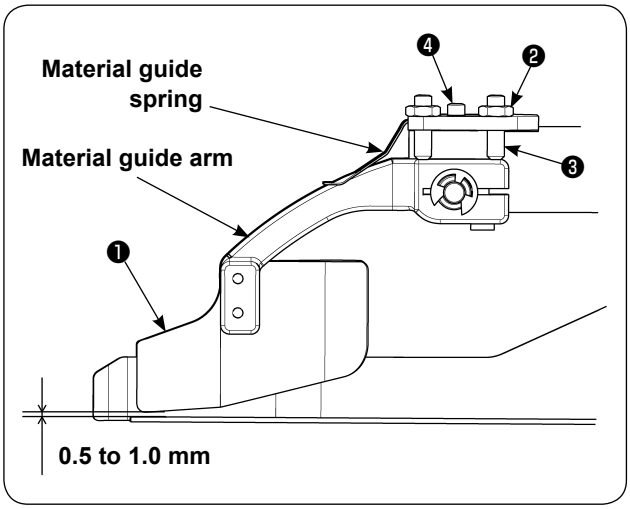
7. SETTING THE MATERIAL TO BE SEWN



Use a garment body that is larger than the garment body clamp rubber piece adhered under the right and left garment body clamps.
If a garment body of which size is smaller than the garment body clamp rubber piece, the rubber piece can come off or the machine can malfunction.
If it is necessary to use a small material, mount a shim type gauge (optional) on the machine.

8. ADJUSTING THE MATERIAL GUIDE

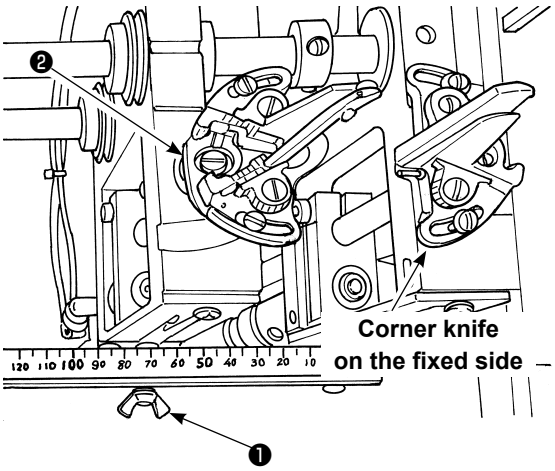
Material guide functions to stabilize the welt patch at the edge of the machine needle.
Adjust the height and the presser pressure of material guide ❶ in accordance with the thickness of material.

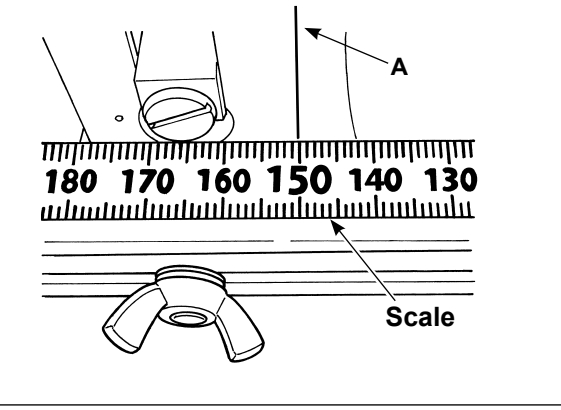


① The height of material guide can be adjusted by loosening nut ❷ and screw ❸ .
(Clearance between material guide and welt patch scale has been adjusted to 0.5 to 1.0 mm at the time of delivery.)

② Presser pressure can be adjusted with spring pressure adjust screw ❹ .
(Adjust the pressure so that there is no excessive resistance when the material passes.)

9. ADJUSTING THE CUTTING WIDTH OF CORNER KNIVES





Loosen setscrew ❶ . Adjust the cutting width of corner knives by aligning ridge line A of the corner knife on the moving side with the scale mark corresponding to the cutting width you want to select. Then, tighten the setscrew.

1. After the adjustment, check to make sure that corner knife ❷ on the moving side does not fluctuate laterally.
2. When drawing out the corner knives, move corner knife ❷ on the moving side to its initial position before releasing the toggle clamp.
If the corner knives are drawn out while the corner knife on the moving side does not rest at its initial position, corner knife ❷ and the table can come in contact with each other, resulting in breakage of the corner knife.

VI. HOW TO USE THE OPERATION PANEL

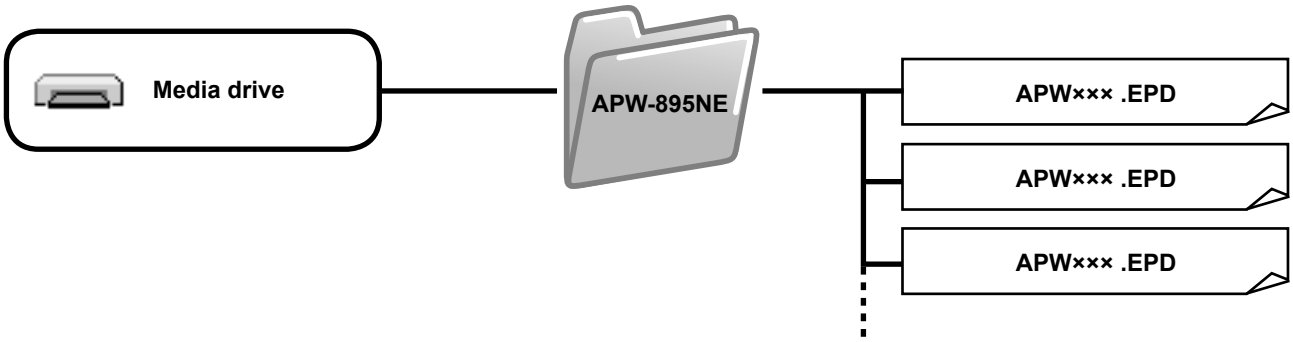
1. PREFACE

1) How to use the data (EPD data) for a certain unit of the APW-895NE for other unit of the APW-895NE

To use the EPD data on the APW-895NE, read the data into the IP-420.
Insert the relevant medium into the IP-420. Select pattern number xxx from EPD data.

2) Folder structure of the media

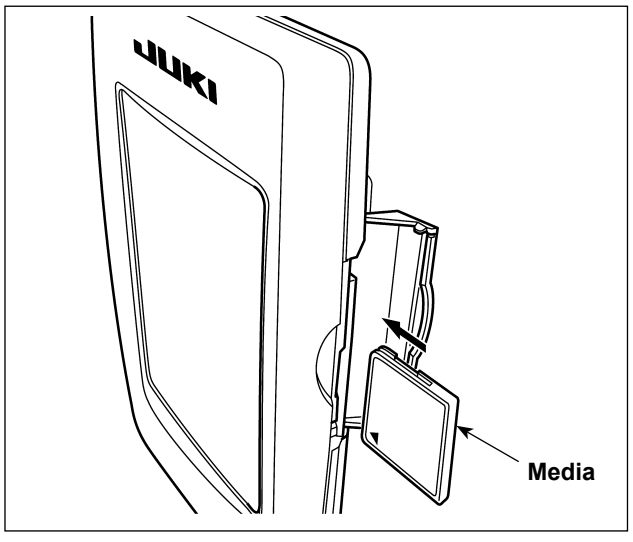
Store each file in the directories below of the media.



Data that are not stored in the directories above cannot be read. So, be careful.

3) CompactFlash (TM)

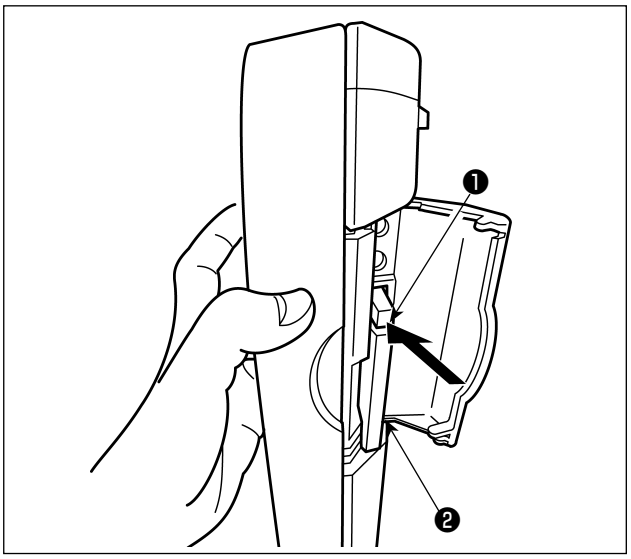
■ Inserting the CompactFlash (TM)



1) Turn the label side of the CompactFlash(TM) to this side (place the notch of the edge to the rear.) and insert the part that has a small hole into the panel.
2) After completion of setting of the media, close the cover. By closing the cover, it is possible to access. If the media and the cover come in contact with each other and the cover is not closed, check the following matters.
   - Check that the media is securely pressed until it goes no further.
   - Check that the inserting direction of the media is proper.

1. **When the inserting direction is wrong, panel or media may be damaged.**
2. **Do not insert any item other than the CompactFlash (TM).**
3. **The media slot in the IP-420 accommodates to the CompactFlash (TM) of 2 GB or less.**
4. **The media slot in the IP-420 supports the FAT16 which is the format of the CompactFlash (TM). FAT32 is not supported.**
5. **Be sure to use the CompactFlash (TM) which is formatted with IP-420. For the formatting procedure of the CompactFlash (TM), see "VI-16. PERFORMING FORMATTING OF THE MEDIA" p. 90.**

■ **Removing the CompactFlash (TM)**



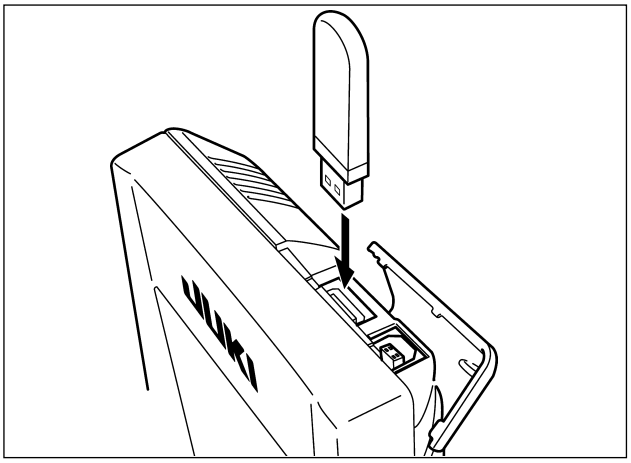
1) Hold the panel by hand, open the cover, and press the media ❷ removing lever ❶ . The media is eject.

When the lever ❶ is strongly pressed, the media ❷ may be broken by protruding and falling.

2) When the media ❷ is drawn out as it is, removing is completed.

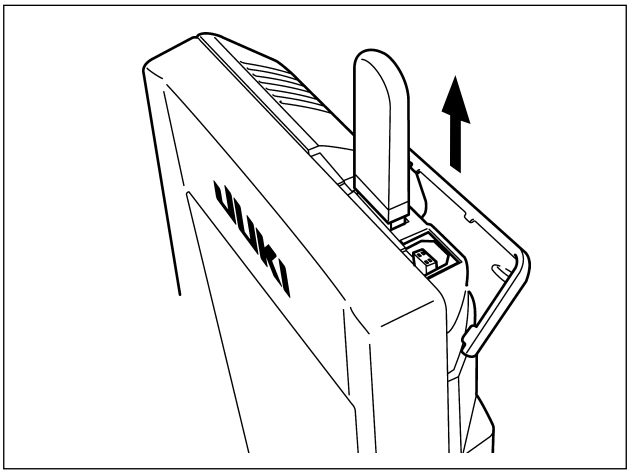
4) USB port

■ **Inserting a device into the USB port**



Slide the top cover and insert the USB device into the USB port. Then, copy data to be used from the USB device onto the main body.
After completion of copying the data, remove the USB device.

■ **Disconnecting a device from the USB port**



Remove the USB device. Put the cover back in place.

Cautions when using the media

- **Do not wet or touch it with wet hands. Fire or electric shock will be caused.**
- **Do not bend, or apply strong force or shock to it.**
- **Never perform disassembling or remodeling of it.**
- **Do not put the metal to the contact part of it. Data may be disappeared.**
- **Avoid storing or using it in the places below.**

  Place of high temperature or humidity / Place of dew condensation /
  Place with much dust / Place where static electricity or electrical noise is likely to occur

① Precautions to be taken when handling USB devices

- Do not leave the USB device or USB cable connected to the USB port while the sewing machine is in operation. The machine vibration can damage the port section resulting in loss of data stored on the USB device or breakage of the USB device or sewing machine.
- Do not insert/remove a USB device during reading/writing a program or sewing data.
  It may cause data breakage or malfunction.
- When the storage space of a USB device is partitioned, only one partition is accessible.
- Some type of the USB device may not be properly recognized by this sewing machine.
- JUKI does not compensate for loss of data stored on the USB device caused by using it with this sewing machine.
- When the panel displays the communication screen or pattern data list, the USB drive is not recognized even if you insert a medium into the slot.
- For USB devices and media such as CF(TM) cards, only one device/medium should be basically connected/inserted to/into the sewing machine. When two or more devices/media are connected/inserted, the machine will only recognize one of them. Refer to the USB specifications.
- Insert the USB connector into the USB terminal on the IP panel until it will go no further.
- Do not turn the power OFF while the data on the USB flash drive is being accessed.

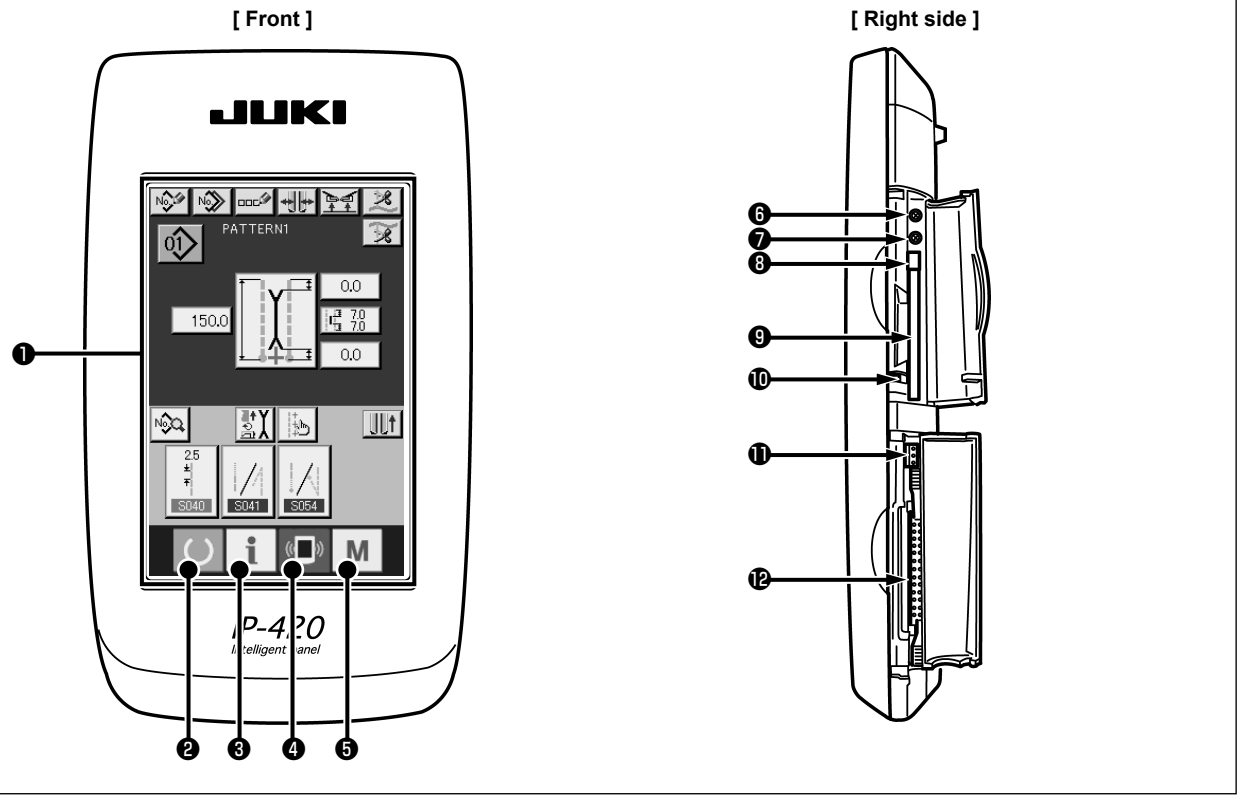
② USB specifications

- Conform to USB 1.1 standard
- Applicable devices *1 _____ Storage devices such as USB memory, USB hub, FDD and card reader
- Not-applicable devices ____ CD drive, DVD drive, MO drive, tape drive, etc.
- Format supported _____ FD (floppy disk) FAT 12
  Others (USB memory, etc.), FAT 12, FAT 16, FAT 32
- Applicable medium size ___ FD (floppy disk) 1.44MB, 720kB
  Others (USB memory, etc.), 4.1MB ~ (2TB)
- Recognition of drives _____ For external devices such as a USB device, the device which is recognized first is accessed. However, when a medium is connected to the built-in media slot, the access to that medium will be given the highest priority. (Example : If a medium is inserted into the media slot even when the USB memory has already been connected to the USB port, the medium will be accessed.)
- Restriction on connection __ Max. 10 devices (When the number of storage devices connected to the sewing machine has exceeded the maximum number, the 11th storage device and beyond will not be recognized unless they are once disconnected and re-connected.)
- Consumption current _____ The rated consumption current of the applicable USB devices is 500 mA at the maximum.

*1 : JUKI does not guarantee operation of all applicable devices. Some device may not operate due to a compatibility problem.

2. BASIC OPERATION OF THE OPERATION PANEL (IP-420)

(1) Configuration of IP-420



Symbol	Name	Description
❶	TOUCH PANEL, LCD display section	
❷	READY key	Change-over of the data input screen and the sewing screen is performed.
❸	INFORMATION key	Change-over of the data input screen and the information screen is performed.
❹	COMMUNICATION key	Change-over of the data input screen and the communication screen is performed.
❺	MODE CHANGEOVER key	Change-over of the data input screen and the mode change-over screen which performs various details setting.
❻	Contrast control	
❼	Brightness control	
❽	CompactFlash (TM) eject button	
❾	CompactFlash (TM) slot	
❿	Cover detection switch	
⓫	Connector for external switch	
⓬	Connector for control-box connection	

Caution

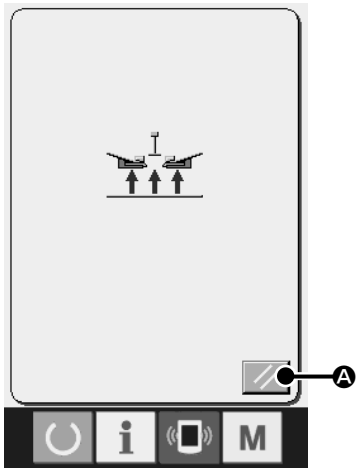
1. **Lightly press the target key on the touch panel with a fingertip to operate the IP-420. If you operate with any means other than your fingertip, the IP-420 can malfunction or the glass surface of the touch panel can be scratched or break.**
2. **When READY key is pressed first after turning ON the power, origin retrieval of the clamp foot is performed. At this time, the clamp foot moves. So, be careful.**

(2) Buttons used in common

Buttons that perform common operation in the respective screens of IP-420 are as described below.

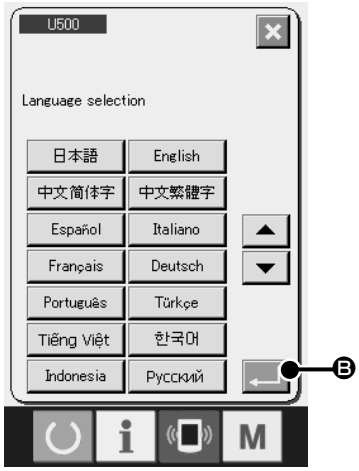
Pictograph	Name	Description
	CANCEL button	Pop-up screen is closed. In case of the data change screen, the data during changing can be cancelled.
	ENTER button	Data changed are determined.
	UP SCROLL button	This button scrolls button or display upward.
	DOWN SCROLL button	This button scrolls button or display downward.
	RESET button	This button releases error and the like.
	NUMBER INPUT button	Ten keys are displayed and input of number can be performed.
	CHARACTER INPUT button	Character input screen is displayed.

(3) Basic operation



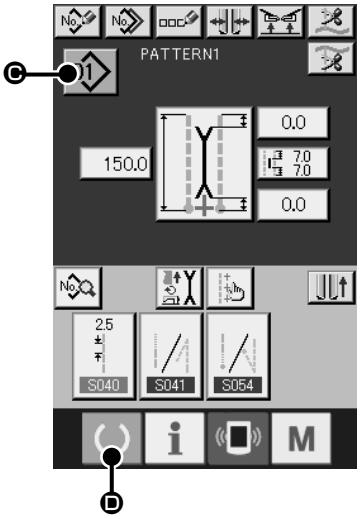
① **Turn ON the power switch.**
First, turn ON the power switch.
Reset pop-up screen is displayed after displaying WELCOME screen. Press RESET button Ⓐ.

When RESET button is pressed, the binder goes up. So, be careful.



Next, language selection pop-up screen is displayed. After selecting the language you desire to display, press ENTER button Ⓑ. Then the independent sewing input screen (screen A) of the figure below is displayed.

When ending the selection screen with CANCEL button or ENTER button without performing the language selection, the language selection screen is displayed whenever the power is turned ON.

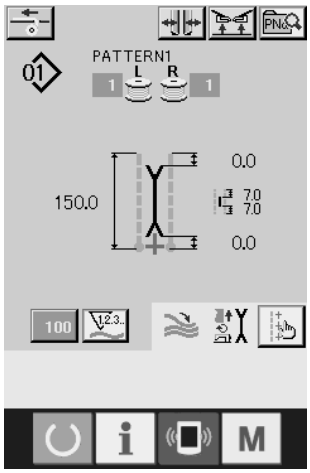


The independent sewing input screen (screen A)

② **Select pattern No. you desire to sew.**

When PATTERN NO. button 01 Ⓒ is pressed, the pattern No. can be selected. For the selecting procedure of pattern No., see **"VI-6.(1) Performing the selection of pattern" p. 40**.
At the time of your purchase, pattern Nos. 1 to 10 have been registered. Change the sewing data in accordance with the sewing types for use. (The number to which the pattern has not been registered is not displayed.)

For the detailed explanation of input screen, see "VI-3. EXPLANATION OF THE BASIC SCREEN" p. 29.

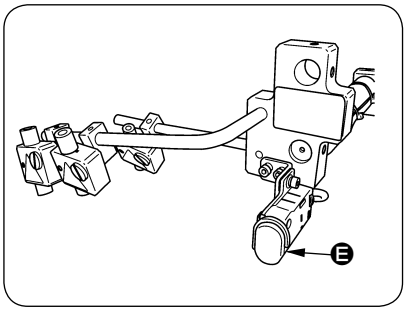


Sewing screen (screen B)

③ **Start sewing**

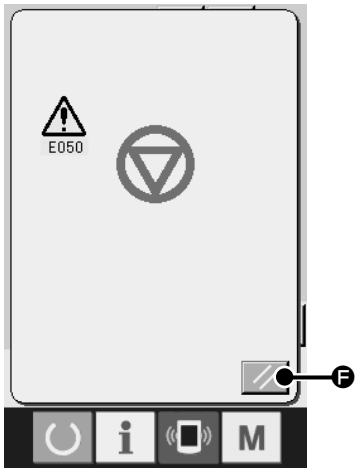
When READY key Ⓓ is pressed in the independent sewing input screen (screen A), the green sewing screen (screen B) is displayed and the sewing operation is started by the pedal operation.

For the detailed explanation of input screen, see "VI-3. EXPLANATION OF THE BASIC SCREEN" p. 29.



④ **To stop the device during operation**

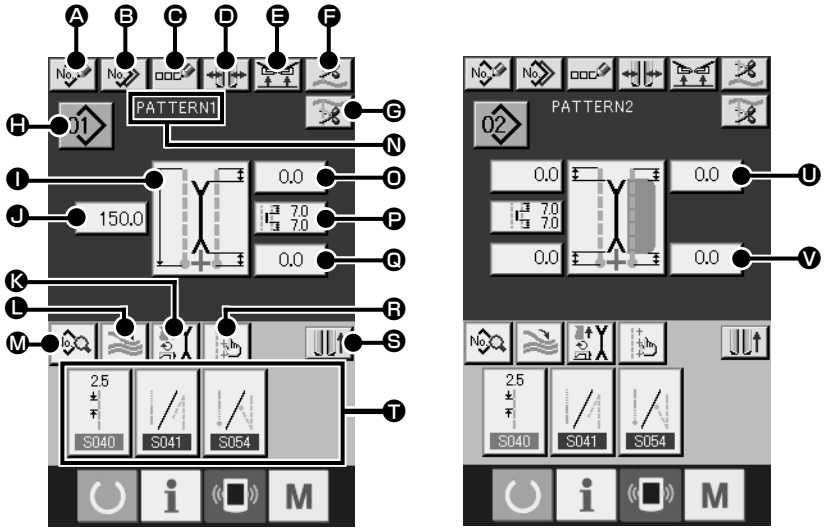
When temporary stop switch Ⓔ is pressed during sewing, the device can be stopped.



At this time, the error screen is displayed to inform that stop switch is pressed. When RESET button Ⓕ is pressed, the error is released and the screen returns to the input screen.

3. EXPLANATION OF THE BASIC SCREEN

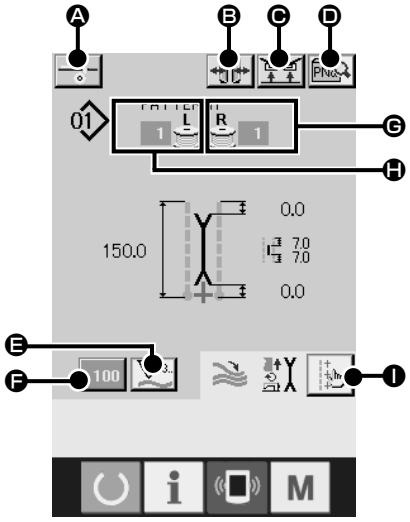
(1) Input screen (Independent sewing mode)



Symbol	Name of button	Description
Ⓐ	NEW CREATION button	Independent sewing pattern new creation screen is displayed and new register of the pattern data can be performed.
Ⓑ	COPY button	Independent sewing copy source pattern list screen is displayed and the pattern can be copied.
Ⓒ	CHARACTER INPUT button	Character input screen is displayed and the name can be inputted to the pattern data.
Ⓓ	TYPE OF WELT CHANGE-OVER button	Type of welt change-over screen is displayed, and change-over of type of welt and adjustment of parallelism of the binder can be performed.
Ⓔ	CLAMP UP PROHIBITION AT SEWING END button	When this button is pressed, the clamp is returned in the lowered state at sewing end. It is convenient to use this button at the time of adjusting the marking light or trial sewing.
Ⓕ	NEEDLE THREAD TRIMMING button	When this button is pressed, needle thread trimming knife comes down and the needle thread trimming operating screen is displayed.
Ⓖ	BOBBIN THREAD TRIMMING button	Bobbin thread trimming knife opens while this button is pressed.
Ⓗ	PATTERN NO. LIST button	Pattern No. list screen is displayed and the pattern data can be selected.
Ⓘ	SEWING MODE CHANGE-OVER button	Sewing mode S003 is selected.
Ⓙ	L SIZE LENGTH SETTING button	In case of L size sewing, sewing length S004 is set.
Ⓚ	MOTION MODE SETTING button	With/without S001 of motion of sewing machine motor, center knife and corner knife.
Ⓛ	STACKER MOTION/STOP CHANGE-OVER button	This button selects motion/stop S069 and S070 of stacker.
Ⓜ	SEWING DATA DISPLAY button	Sewing pattern edit screen is displayed. Detailed sewing data that are not displayed in the input screen can be selected and edited.
Ⓝ	PATTERN NAME display	Names that are inputted in pattern Nos. are displayed.
Ⓞ	CORNER KNIFE MOTION POSITION AT SEWING START SETTING button	Cutting position S019 of corner knife at sewing start is set.
Ⓟ	CENTER KNIFE SETTING button	Center knife data edit screen is displayed, and center knife cutting position of sewing start S017 and sewing end S018 is set.
Ⓠ	CORNER KNIFE MOTION POSITION AT SEWING END SETTING button	Cutting position S020 of corner knife at sewing end is set.
Ⓡ	MARKING LIGHT SETTING button	Sewing baseline can be selected by changing K052 to the conventional operation mode. (It should be noted, however, the marking light can only be adjusted manually.)
Ⓢ	CLAMP FOOT MOVE button	Clamp foot is moved to the front or to the back.
Ⓣ	SEWING DATA SHORTCUT button	Shortcut buttons (max. 4 items) of the sewing data that are set in customizing in the sewing screen are displayed.
Ⓤ	FLAP DROP DATA AT SEWING START SETTING button	Flap concealed stitching data at sewing start S008 or S010 is set.
Ⓥ	FLAP DROP DATA AT SEWING END SETTING button	Flap concealed stitching data at sewing end S009 or S011 is set.

* It is possible to customize display/non-display of the respective buttons.
For the details, refer to **"VI-12. CUSTOMIZING THE DATA INPUT SCREEN" p. 73**.

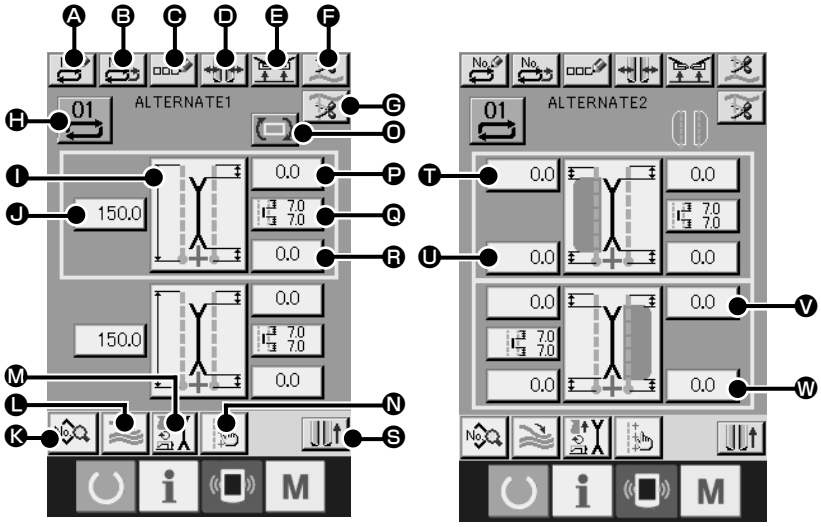
(2) Sewing screen (Independent sewing mode)



Symbol	Name of button	Description
Ⓐ	INTERLINING SUPPLY button	When this button is pressed, interlining is supplied. * This is displayed when “With” of SA120 , automatic interlining supplying device is set with the optional setting.
Ⓑ	TYPE OF WELT CHANGE-OVER button	Type of welt change-over screen is displayed and change-over of type of welt and adjustment of parallelism of the binder can be performed.
Ⓒ	CLAMP UP PROHIBITION AT SEWING END button	When this button is held pressed, the clamp is returned in the lowered state at sewing end. It is convenient to use this button at the time of adjustment of marking light or trial sewing.
Ⓓ	DIRECT PATTERN LIST button	Direct pattern list screen is displayed and selection of the sewing data can be performed.
Ⓔ	COUNTER CHANGE-OVER button	When this button is pressed, the display of sewing counter and number of pcs. counter is changed over. * This button is displayed only when both sewing counter and number of pcs. counter are ON.
Ⓕ	COUNTER VALUE CHANGE button	This button changes the counter value which is displayed at present.
Ⓖ	BOBBIN THREAD (RIGHT) REMAINING AMOUNT VALUE	This button detects reflecting light from bobbin and informs that bobbin thread remaining amount is running out. When one stitching completes, the counter value is subtracted, and the count-up screen is displayed when “0” is reached. * This button is displayed only when the reflecting light from bobbin is detected.
Ⓗ	BOBBIN THREAD (LEFT) REMAINING AMOUNT VALUE	This button detects reflecting light from bobbin and informs that bobbin thread remaining amount is running out. When one stitching completes, the counter value is subtracted and the count-up screen is displayed when “0” is reached. * This button is displayed only when the reflecting light from bobbin is detected.
Ⓘ	MARKING LIGHT SETTING button	Sewing baseline can be selected by changing K052 to the conventional operation mode. (It should be noted, however, the marking light can only be adjusted manually.)

* It is possible to customize display/non-display of the respective buttons.
  For the details, refer to **"VI-12. CUSTOMIZING THE DATA INPUT SCREEN" p. 73**.

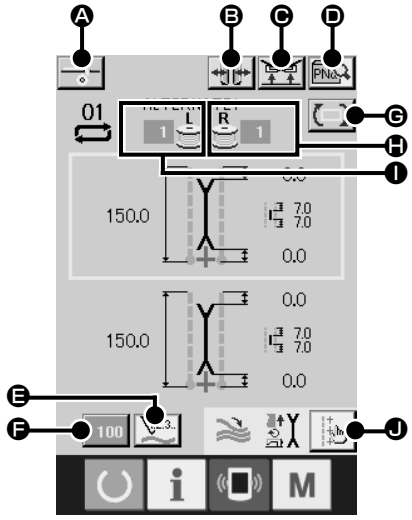
(3) Input screen (Alternate sewing mode)



Symbol	Name of button	Description
Ⓐ	NEW CREATION button	Alternate sewing data new creation screen is displayed and new register of data can be performed.
Ⓑ	COPY button	Alternate sewing data copy source No. list is displayed and alternate sewing data can be copied.
Ⓒ	CHARACTER INPUT button	Character input screen is displayed and name input can be performed n the alternate sewing data.
Ⓓ	TYPE OF WELT CHANGE-OVER button	Type of welt change-over screen is displayed ,and change-over of type of welt and adjustment of parallelism of the binder can be performed.
Ⓔ	CLAMP UP PROHIBITION AT SEWING END button	When this button is held pressed, clamp is returned in the lowered state at the time of sewing end. It is convenient to use this button at the time of adjusting marking light or trial sewing.
Ⓕ	NEEDLE THREAD TRIMMING button	Needle thread trimming knife comes down and needle thread trimming in motion screen is displayed.
Ⓖ	BOBBIN THREAD TRIMMING button	Bobbin thread trimming knife opens while this button is pressed.
Ⓗ	ALTERNATE SEWING DATA NO. LIST button	Alternate sewing data No. list screen is displayed and alternate sewing data can be selected.
Ⓘ	SEWING MODE CHANGE-OVER button	Sewing mode S003 is selected.
Ⓙ	L SIZE LENGTH SETTING button	In case of L size sewing, sewing length S004 is set.
Ⓚ	SEWING DATA DISPLAY button	Sewing pattern edit screen is displayed. This button selects detailed sewing data that are not displayed in the input screen and can edit the data.
Ⓛ	STACKER MOTION/STOP CHANGE-OVER button	This button selects motion/stop S069 and S070 of stacker.
Ⓜ	MOTION MODE SETTING button	With/without motion S001 of sewing machine motor, center knife and corner knife.
Ⓝ	MARKING LIGHT SETTING button	Sewing baseline can be selected by changing K052 to the conventional operation mode. (It should be noted, however, the marking light can only be adjusted manually.)
Ⓞ	NEXT SEWING DATA CHANGE-OVER button	Sewing pattern to be sewn next which is enclosed with yellow frame is changed over. * This is not displayed when flap priority sewing selection S002 is ON.
Ⓟ	CORNER KNIFE MOTION POSITION AT SEWING START SETTING button	Cutting position S019 of corner knife at sewing start is set.
Ⓠ	CENTER KNIFE SETTING button	Center knife data edit screen is displayed and center knife cutting position of sewing start S017 and sewing end S018 .
Ⓡ	CORNER KNIFE MOTION POSITION AT SEWING END SETTING button	Cutting position S020 of corner knife at sewing end is set.
Ⓢ	CLAMP FOOT MOVE button	Clamp foot is moved to the front or to the back.
Ⓣ, Ⓥ	FLAP CONCEALED STITCHING DATA AT SEWING START SETTING button	Flap concealed stitching data at sewing start S008 or S010 is set.
Ⓤ, Ⓦ	FLAP CONCEALED STITCHING DATA AT SEWING END SETTING button	Flap concealed stitching data at sewing end S009 or S011 is set.

* It is possible to customize display/non-display of the respective buttons.
For the details, refer to **"VI-12. CUSTOMIZING THE DATA INPUT SCREEN" p. 73**.

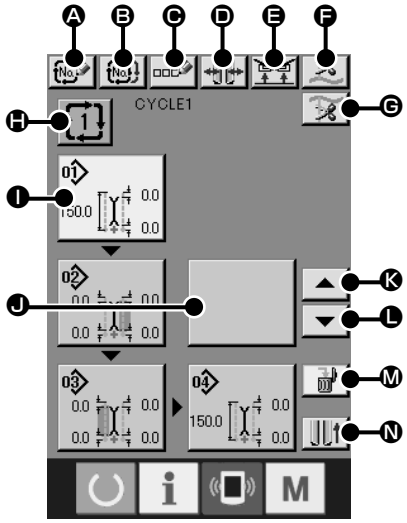
(4) Sewing screen (Alternate sewing mode)



Symbol	Name of button	Description
Ⓐ	INTERLINING SUPPLYING button	When this button is pressed, interlining is supplied. * This is displayed when “With” of SA120 , automatic interlining supplying device is set with the optional setting.
Ⓑ	TYPE OF WELT CHANGE-OVER button	Type of welt change-over screen is displayed, and change-over of type of welt and adjustment of parallelism of the binder can be performed.
Ⓒ	CLAMP UP PROHIBITION AT SEWING END button	When this button is held pressed, the clamp is returned in the lowered state at the time of sewing end. It is convenient to use this button at the time of adjustment of marking light and trial sewing.
Ⓓ	DIRECT PATTERN LIST button	Direct pattern list screen is displayed and selection of the sewing data can be performed.
Ⓔ	COUNTER CHANGE-OVER button	When this button is pressed, display of sewing counter and number of pcs. counter is changed over. This button is displayed only when both sewing counter and number of pcs. counter are ON.
Ⓕ	COUNTER VALUE CHANGE button	Counter value which is displayed at present is changed.
Ⓖ	NEXT SEWING DATA CHANGE-OVER button	Sewing pattern to be sewn next which is enclosed with yellow frame is changed over. * This is not displayed when flap priority sewing selection S002 is ON.
Ⓗ	BOBBIN THREAD (RIGHT) REMAINING AMOUNT VALUE	This button detects reflecting light from bobbin and informs that bobbin thread remaining amount is running out. When one stitching completes, the counter value is subtracted, and the count-up screen is displayed when “0” is reached. * This button is displayed only when the reflecting light from bobbin is detected.
Ⓘ	BOBBIN THREAD (LEFT) REMAINING AMOU’NT VALUE	This button detects reflecting light from bobbin and informs that bobbin thread remaining amount is running out. When one stitching completes, the counter value is subtracted, and the count-up screen is displayed when “0” is reached. * This button is displayed only when the reflecting light from bobbin is detected.
Ⓙ	MARKING LIGHT SETTING button	Sewing baseline can be selected by changing K052 to the conventional operation mode. (It should be noted, however, the marking light can only be adjusted manually.)

* It is possible to customize display/non-display of the respective buttons.
For the details, refer to **"VI-12. CUSTOMIZING THE DATA INPUT SCREEN" p. 73**.

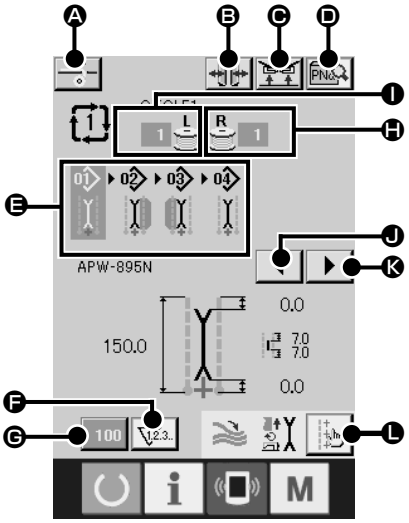
(5) Input screen (Cycle sewing mode)



Symbol	Name of button	Description
Ⓐ	NEW CREATION button	Cycle sewing data No. new creation screen is displayed and new register of cycle sewing data can be performed.
Ⓑ	COPY button	Cycle sewing data copy source No. list screen is displayed and cycle sewing data can be copied.
Ⓒ	CHARACTER INPUT button	Character input screen is displayed and name can be inputted to the cycle sewing data.
Ⓓ	TYPE OF WELT CHANGE-OVER button	Type of welt change-over screen is displayed and change-over of type of welt, and adjustment of parallelism of the binder can be performed.
Ⓔ	CLAMP UP PROHIBITION AT SEWING END button	When this button is held pressed, the clamp is returned in the lowered state at the time of sewing end. It is convenient to use at the time of adjustment of marking light and trial sewing.
Ⓕ	NEEDLE THREAD TRIMMING button	Needle thread trimming knife comes down and the needle thread trimming in motion screen is displayed.
Ⓖ	BOBBIN THREAD TRIMMING button	While this button is held pressed, bobbin thread trimming knife opens.
Ⓗ	CYCLE SEWING DATA NO. LIST button	Cycle sewing data No. list screen is displayed and the cycle sewing data can be selected.
Ⓘ	PATTERN DATA EDIT button	Edit of pattern data which have been registered to cycle sewing data can be performed. * For the editing procedure, refer to **"3-(1) Input screen (Independent sewing mode)" p. 29**.
Ⓙ	PATTERN DATA EDIT button (blank)	When this blank button is pressed, the pattern list screen to register the pattern data to the cycle sewing data is displayed, and it is possible to select and register the pattern data.
Ⓚ	CYCLE RETURN button	Pattern data to be sewn next which is displayed with white emphasis is moved forward by one. In case of first pattern, it moves to the last pattern.
Ⓛ	CYCLE FEED button	Pattern data to be sewn next which is displayed with white emphasis is moved backward by one. In case of the last pattern, it moves to the first pattern.
Ⓜ	PATTERN DATA DELETION button	Pattern data which is displayed with white emphasis is deleted from register.
Ⓝ	CLAMP FOOT MOVE button	Clamp foot is moved to the front or to the back.

* It is possible to customize display/non-display of the respective buttons.
  For the details, refer to **"VI-12. CUSTOMIZING THE DATA INPUT SCREEN" p. 73**.

(6) Sewing screen (Cycle sewing mode)

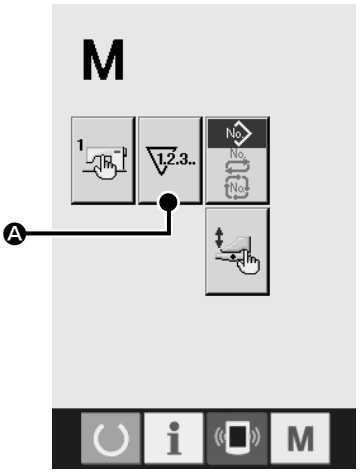


Symbol	Name of button	Description
Ⓐ	INTERLINING SUPPLYING button	When this button is pressed, interlining is supplied. * This is displayed when “With” of SA120 , automatic interlining supplying device is set with optional setting.
Ⓑ	TYPE OF WELT CHANGE-OVER button	Type of welt change-over screen is displayed, and change-over of type of welt and adjustment of parallelism of the binder can be performed.
Ⓒ	CLAMP UP PROHIBITION AT SEWING END button	When this button is held pressed, the clamp is returned in the lowered state at the time of sewing end. It is convenient to use this button at the time of adjustment of marking light and trial sewing.
Ⓓ	DIRECT PATTERN LIST button	Direct pattern list screen is displayed and selection of the sewing data can be performed.
Ⓔ	CYCLE DATA display	All pattern data that have been registered to the cycle sewing data are displayed.
Ⓕ	COUNTER CHANGE-OVER button	When this button is pressed, display of sewing counter and number of pcs. counter is changed over. This button is displayed only when both sewing counter and number of pcs. counter are ON.
Ⓖ	COUNTER VALUE CHANGE button	Counter value which is displayed at present is changed.
Ⓗ	BOBBIN THREAD (RIGHT) REMAINING AMOUNT	This button detects light from bobbin and informs that bobbing thread remaining amount is running out. When one stitching completes, the counter value is subtracted, and the counter-up screen is displayed when “0” is reached. * This button is displayed only when the reflecting light from bobbin is detected.
Ⓘ	BOBBIN THREAD (LEFT) REMAINING AMOUNT	This button detects reflecting light from bobbin and informs that bobbin thread remaining amount is running out. When one stitching completes, the counter value is subtracted, and the counter-up screen is displayed when “0” is reached. * This button is displayed only when the reflecting light from bobbin is detected.
Ⓙ	LEFT SCROLL button	Pattern data to be sewn next is moved forward by one. In case of the first pattern, it moves to the last pattern.
Ⓚ	RIGHT SCROLL button	Pattern data to be sewn next is moved backward by one. In case of the last pattern, it moves to the first pattern.
Ⓛ	MARKING LIGHT SETTING button	Sewing baseline can be selected by changing K052 to the conventional operation mode. (It should be noted, however, the marking light can only be adjusted manually.)

* It is possible to customize display/non-display of the respective buttons.
  For the details, refer to **"VI-12. CUSTOMIZING THE DATA INPUT SCREEN" p. 73**.

4. USING THE COUNTER

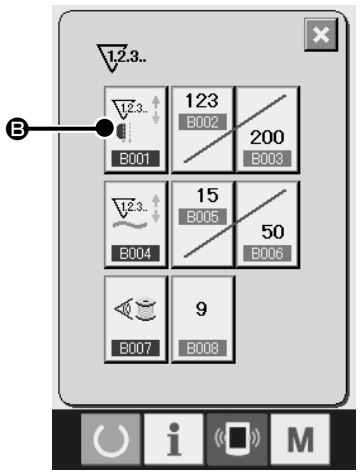
(1) Setting procedure of the counter



① **Display the counter setting screen.**

Press MODE CHANGEOVER key M from the input screen and COUNTER SETTING button Ⓐ is displayed on the screen.

Press this button and “COUNTER SETTING screen (screen A)” is displayed.



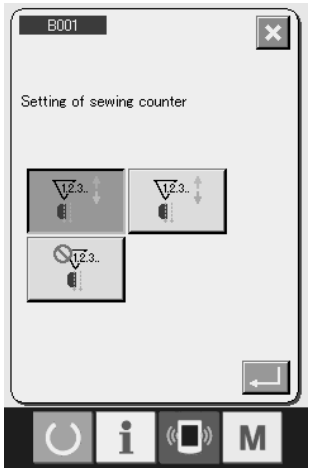
Counter setting screen (Screen A)

② **Select the kind of counter.**

There are three kinds of counters with this sewing machine, sewing counter, number of pcs. counter and bobbin thread remaining amount adjustment counter.

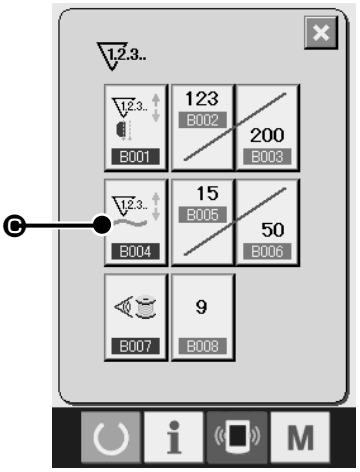
Important **It should be noted, however, the remaining bobbin thread adjustment counter cannot be used with the APW-895NE.**

Press sewing counter button Ⓑ in “counter setting screen (screen A)”, and “sewing counter setting screen (screen B)” is displayed. Then the kind of counter can be set.



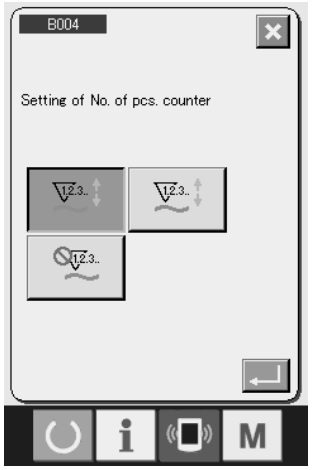
Sewing counter setting screen (Screen B)

[Sewing counter]	
	UP counter : Every time one sewing is performed, the existing value is counter up. When the existing value is equal to the set value, the count-up screen is displayed.
	DOWN counter : Every time one sewing is performed, the existing value is counted down. When the existing value is reached to “0”, the count-up screen is displayed.
	Counter unused : Sewing counter is set to the prohibition.



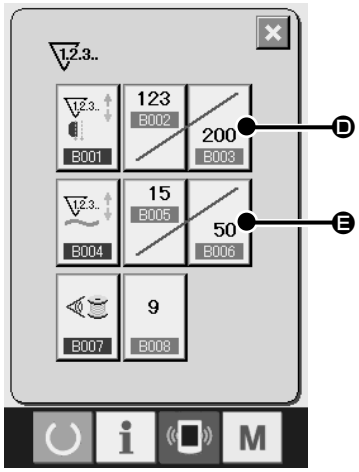
Counter setting screen (Screen A)

Press NUMBER OF PCS. COUNTER button Ⓒ In “Counter setting screen (screen A)”, and “number of pcs. setting screen (screen C)” is displayed. Then the kind of counter can be set.



Number of pcs. counter (Screen C)

[Number of pcs. counter]	
	UP counter : Every time one of finished products is sewn, the existing value is counted up. * In case of independent sewing : 1 time of sewing In case of alternate sewing : 2 times of sewing In case of cycle sewing : 1 time of cycle sewing The number given in each case above is regarded as one of finished products. When the existing value is equal to the set value, the count-up screen is displayed.
	DOWN counter : Every time one of finished products is sewn, the existing value is counted down. When the existing value is reached to “0”, the count-up screen is displayed.
	Counter unused : Number of pcs. counter is set to the prohibition.



③ **Changing the target value of the counter**

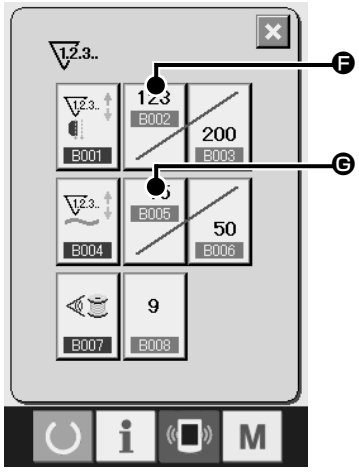
In case of the sewing counter, press button

Ⓓ, and in case of the number of pcs. counter, press button

Ⓔ, and " Numerical setting pop-up screen (screen D)" Is displayed. Then the target value of counter can be set.

Numerical setting pop-up screen (screen D)

Here, input the target value of counter. When "0" is inputted to the target value of counter, only the existing value is displayed during sewing and the count-up screen is not displayed.

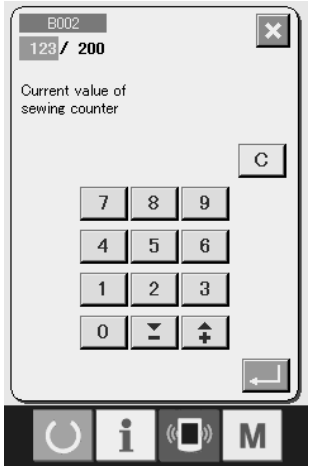


④ **Change the existing value of counter**

In case of the sewing counter, press button

Ⓕ and in case of the number of pcs. counter, press

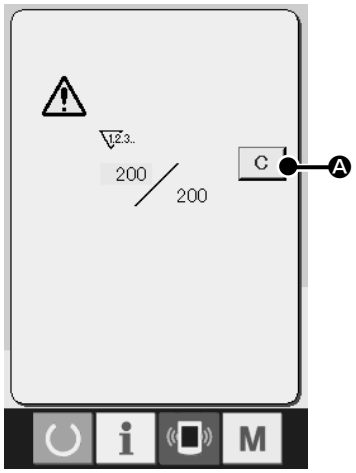
Ⓖ, and " Numerical setting pop-up screen (screen E)" is displayed. Then the existing value of counter can be set.



Numerical setting pop-up screen (screen E)

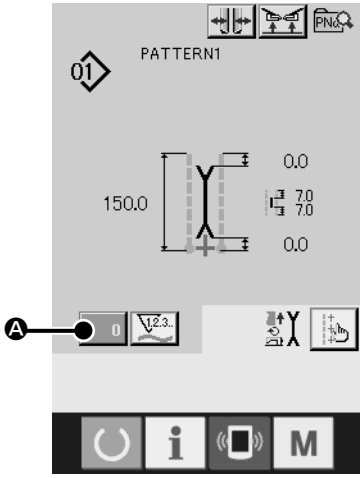
Here, input the existing value of counter.

(2) Releasing procedure of count-up

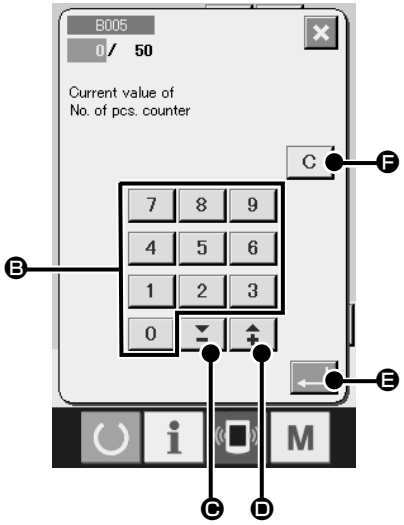


During the sewing work, the count-up condition is reached the count-up screen is displayed and the buzzer sounds. Press CLEAR button [C] Ⓐ to reset the counter, and the screen returns to the sewing screen. And, counting starts again.

(3) Counter value changing procedure during sewing



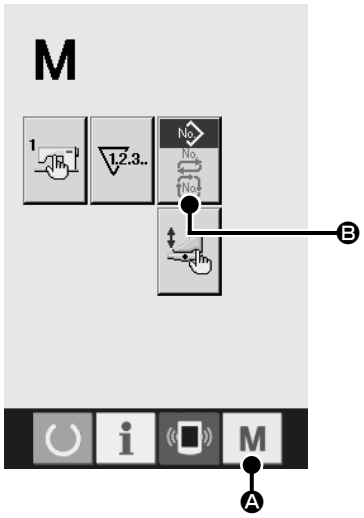
① **Display the counter value change screen**
When you desire to change the counter value during the sewing work, press COUNTER VALUE CHANGE button [0] Ⓐ on the sewing screen. Counter value change screen is displayed.



② **Change the counter value**
Change the counter value with TEN keys [0] to [9] Ⓑ or ▼▲ button [▼] Ⓒ ([▲] Ⓓ).

③ **Determine the counter value**
Press ENTER button [↵] Ⓔ and the data is determined. When you desire to clear the counter value, press CLEAR button [C] Ⓕ.

5. CHANGING THE SEWING MODE

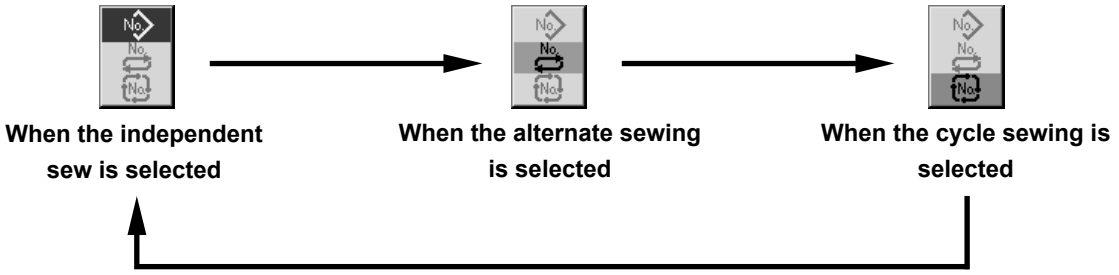


① **Display the sewing mode selection screen**

Press SEWING MODE CHANGEOVER key M Ⓐ and the mode change-over screen is displayed.

② **Select the sewing mode**

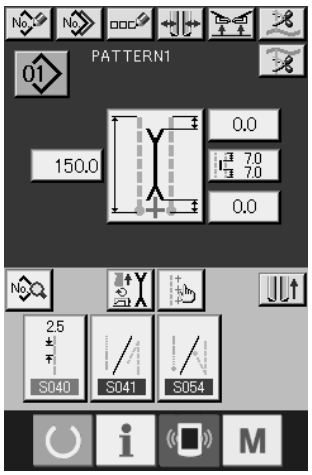
Press MODE SELECTION button Ⓑ and the indication of button is changed.



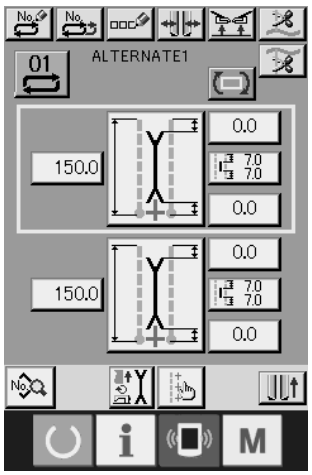
When the independent sew is selected → **When the alternate sewing is selected** → **When the cycle sewing is selected** → (back to the independent sew)

③ **Determine the sewing mode.**

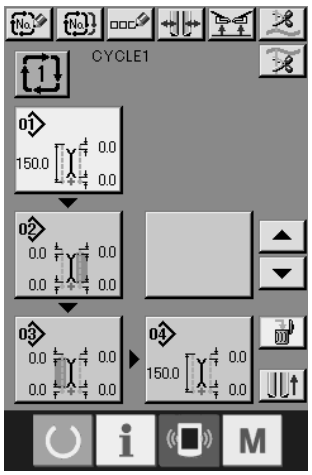
Press MODE CHANGEOVER key M Ⓐ and the data input screen of the selected sewing mode is displayed.



Independent sewing input screen



Alternate sewing input screen



Cycle sewing input screen

6. USING THE SEWING PATTERN

(1) Performing the selection of pattern

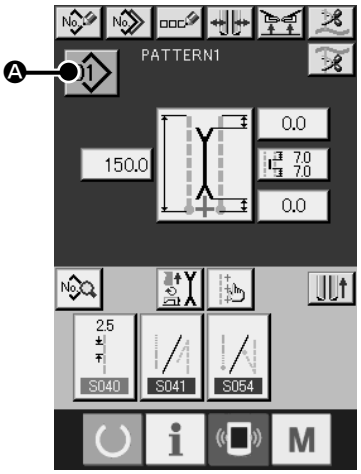
① **Display the input screen**

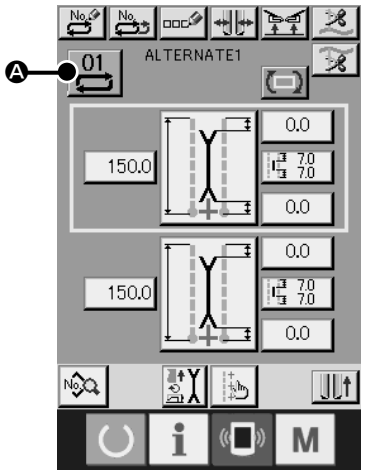
When the input screen of independent sewing mode, alternate sewing mode and cycle sewing mode is displayed, the selection of pattern can be selected.

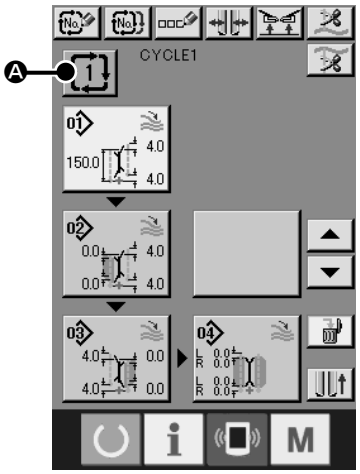
By customizing the sewing screen, the selection of pattern can be performed from the sewing screen as well.

② **Call the pattern list screen**

Press PATTERN LIST button , or Ⓐ and the pattern list screen is displayed.

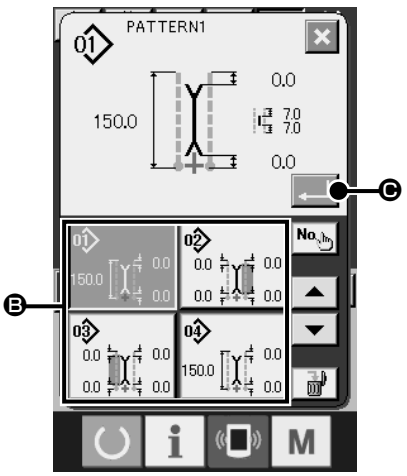


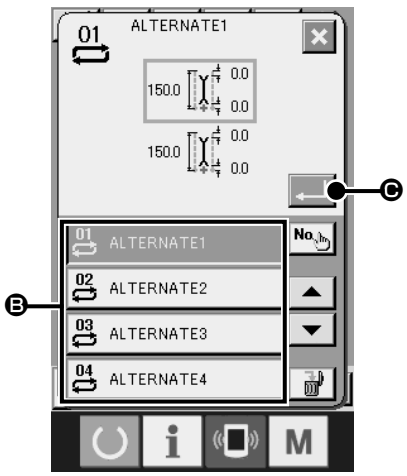


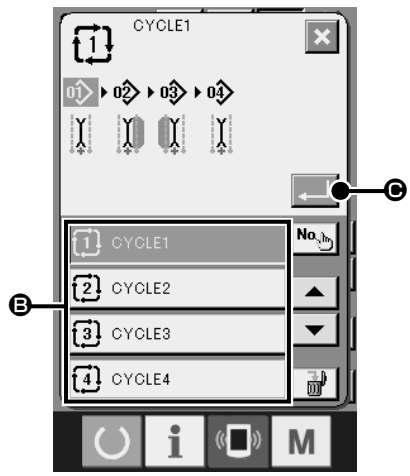


③ **Select the pattern**

Press pattern data you desire to select Ⓑ.







④ **Determine the pattern**

When ENTER button Ⓒ is pressed, the pattern is selected and the screen returns to the input screen.

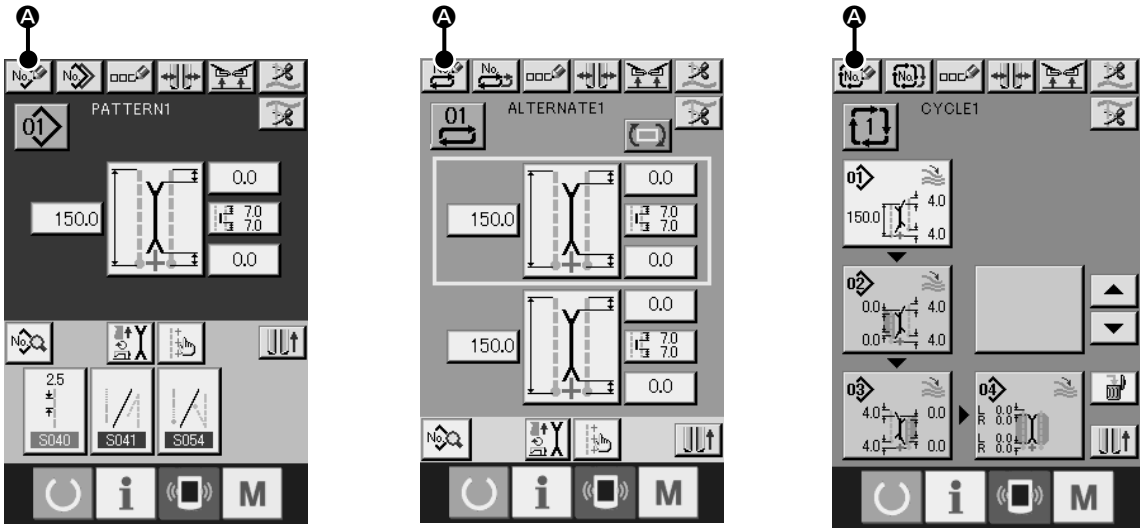
(2) Performing the new creation of pattern

① **Display the input screen**

When the input screen of independent sewing mode, alternate sewing mode and cycle sewing mode is displayed, the new creation of pattern can be performed.

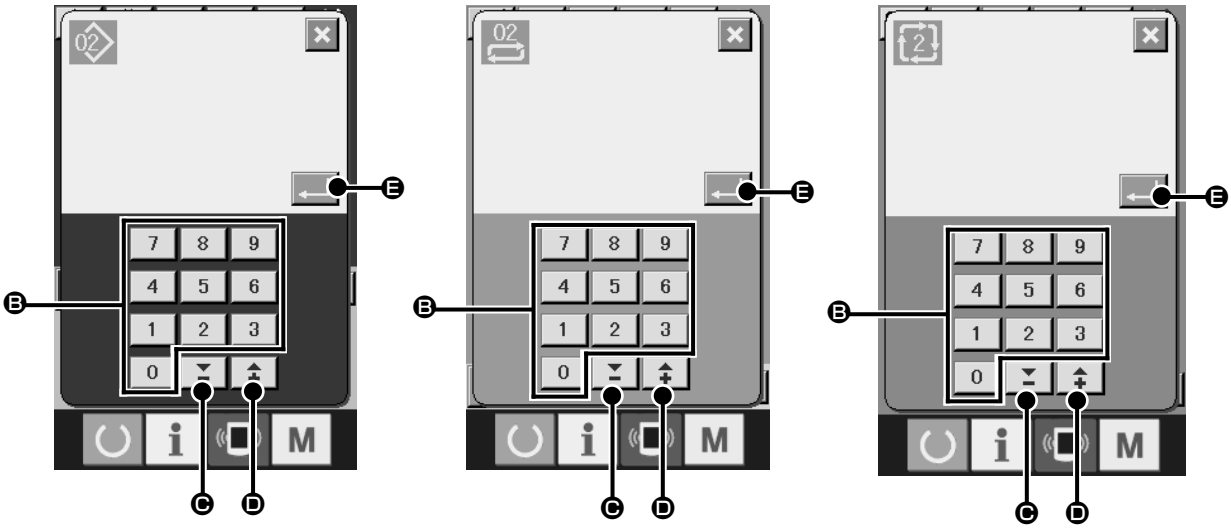
② **Call the sewing pattern new creation screen**

Press NEW CREATION button , , or Ⓐ, and the pattern new creation screen is displayed.



③ **Input the pattern No.**

Input pattern No. you desire to newly create with ten keys 0 to 9 Ⓑ. It is possible to retrieve pattern No. which has not been registered yet with ▼▲ button Ⓒ and Ⓓ.



④ **Determine the pattern No.**

When ENTER button Ⓔ is pressed, the pattern No. to newly create is determined and the screen returns to the input screen.

(3) Copying the pattern

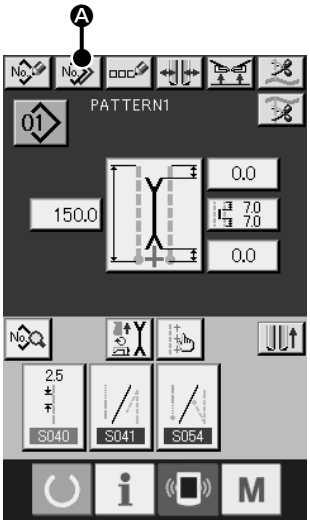
The pattern which has been already registered can be copied to the sewing pattern which has not registered yet. Copying of overwriting of pattern is prohibited. So, when you desire to overwrite, perform it after erasing the pattern once.

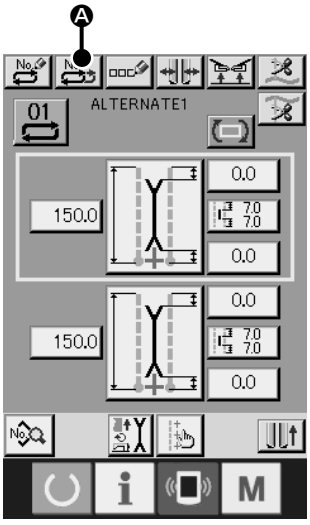
→ For the erasing procedure, see **"VI-6.(4) Erasing the pattern" p. 44**.

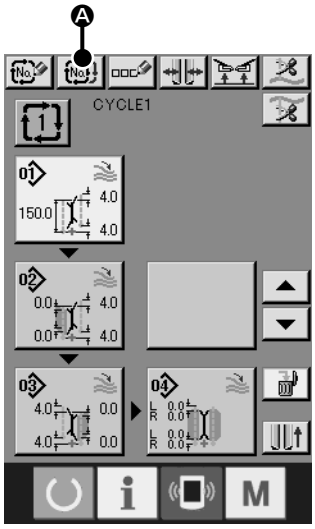
When performing copying the pattern No. which has been already registered, copy disapproved error (E401) is displayed.

① **Display the input screen**

When the input screen of independent sewing mode, alternate sewing mode and the cycle sewing mode is displayed, it is possible to copy.







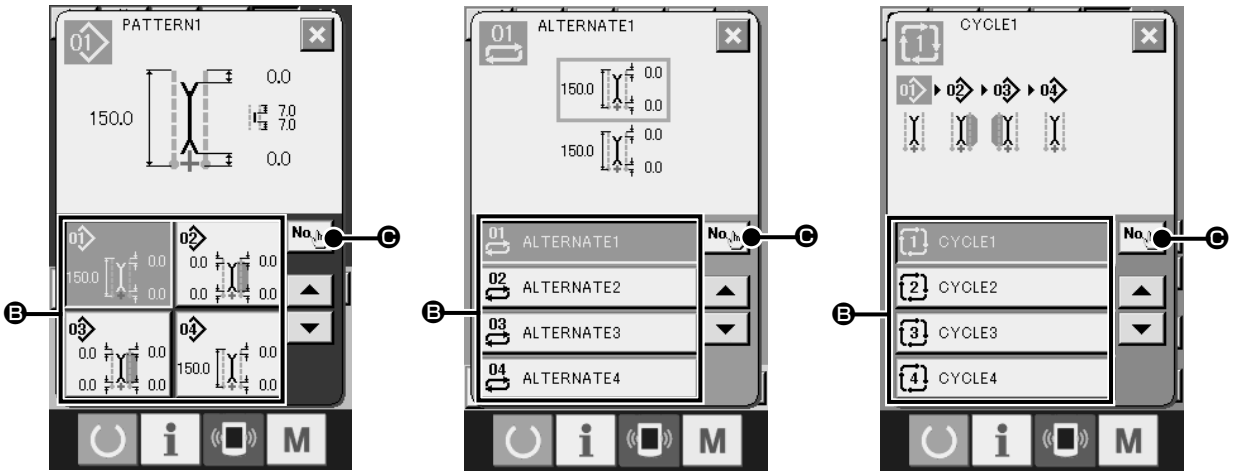
② **Call the pattern No. list screen of the copy source**

Press PATTERN COPY button , , or Ⓐ, and the copy source pattern list screen is displayed.

③ **Select the pattern of copy source**

Select the pattern of copy source from PATTERN LIST button Ⓑ.

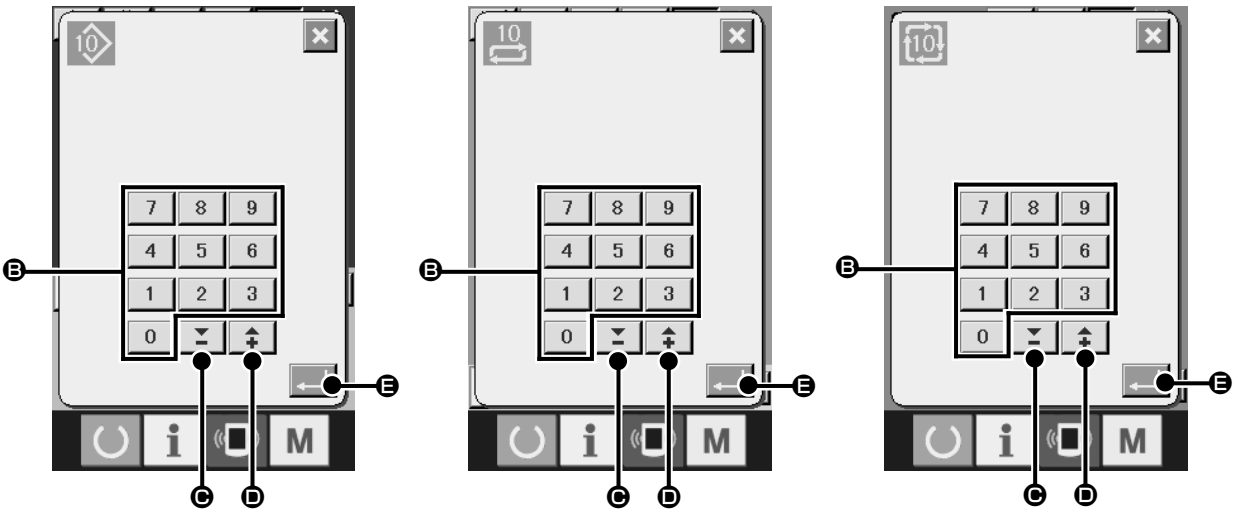
Next, press COPY DESTINATION NO. INPUT button [No.] Ⓒ and the copy destination input screen (screen B) is displayed.



Copy destination No. input screen (screen A)

④ **Input the pattern No. of copy destination**

Input the pattern No. of copy destination with ten keys [0] to [9] Ⓑ. It is possible to retrieve the pat-6tern No. which has not been used yet with ▼▲ buttons ([▼] Ⓒ and [▲] Ⓓ).



Copy destination No. input screen (screen B)

⑤ **Start copying**

When ENTER button [↵] Ⓔ is pressed, copying starts. The pattern No. which has been copied is in the selection state and returns to the copy source pattern list screen (screen A).

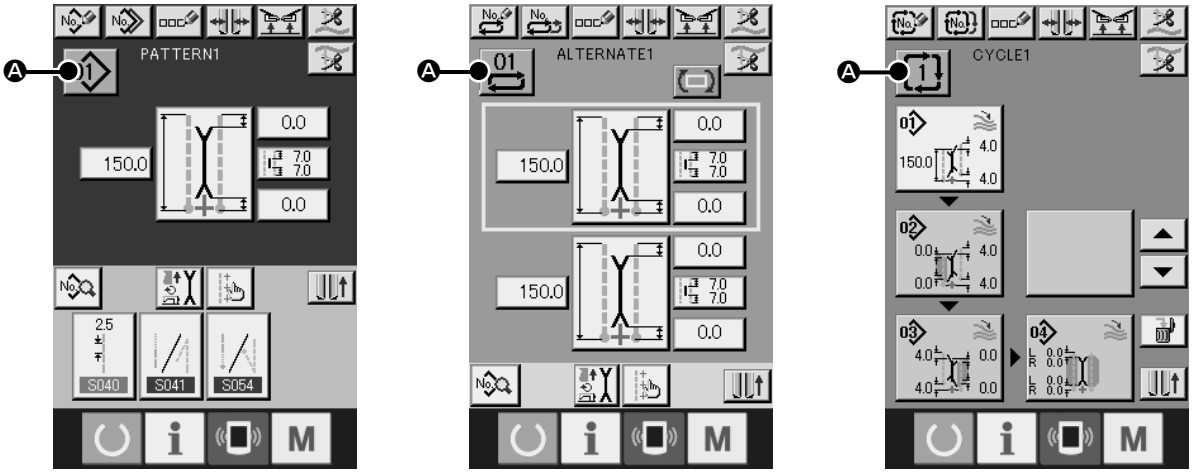
(4) Erasing the pattern

① **Display the input screen**

When the input screen of independent sewing mode, alternate sewing mode and cycle sewing mode is displayed, it is possible to erase the pattern.

② **Call the pattern list screen**

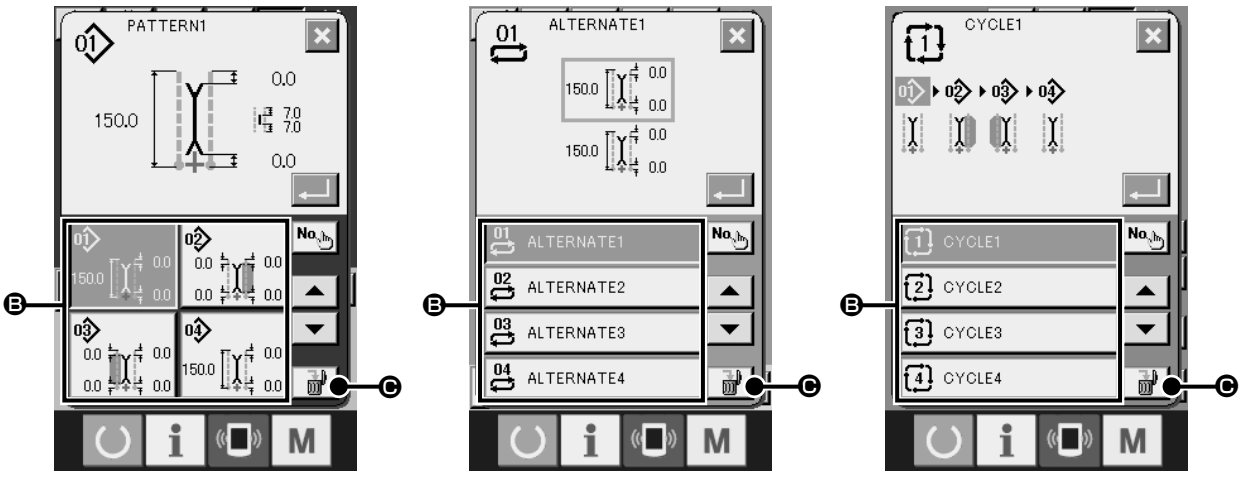
Press PATTERN LIST button , or Ⓐ and the pattern No. list screen (screen A) is displayed.



③ **Select the pattern to be erased**

Select the pattern to be erased from pattern list button Ⓑ.

Next, press ERASE button Ⓒ and the pattern erase confirmation screen is displayed.



Pattern No. list screen (screen A)

④ **Determine the pattern to be erased**

Press ENTER button in the pattern erase confirmation screen and the pattern is erased.

When CANCEL button is pressed, the screen returns to the original screen A without erasing the pattern.

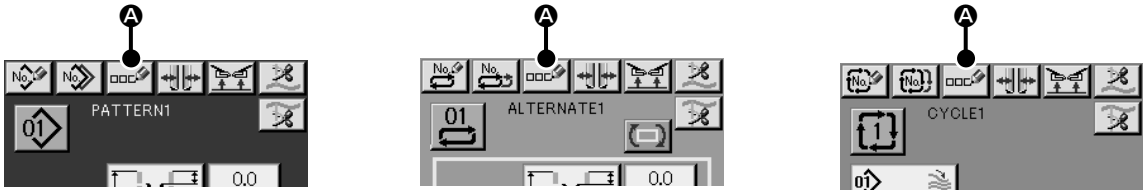
(5) Naming the pattern

① **Display the input screen**

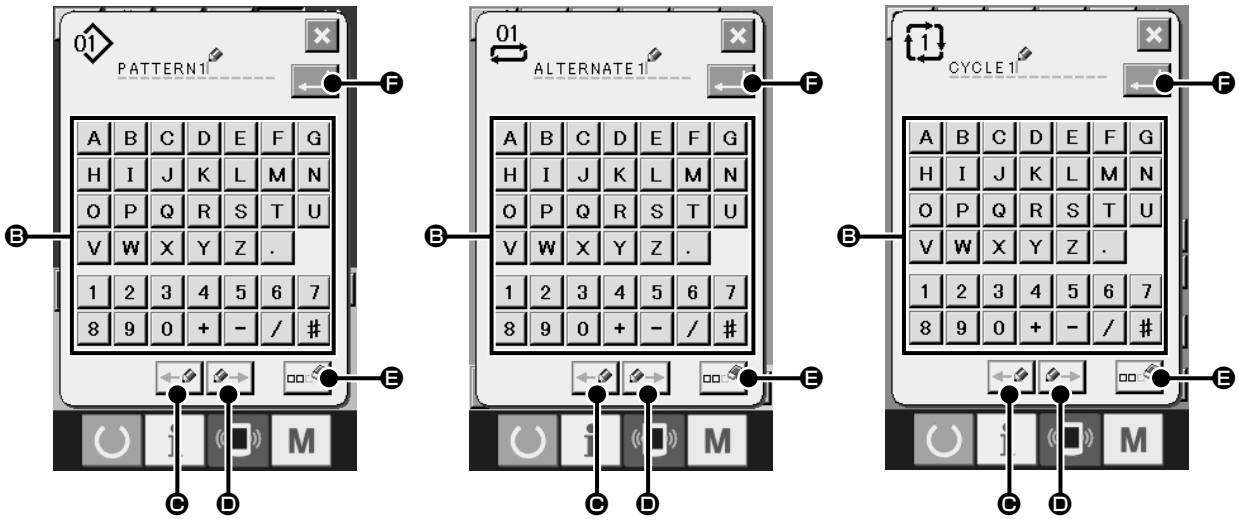
When the input screen of independent sewing mode, alternate sewing mode and cycle sewing mode is displayed, it is possible to input the name to the pattern data.

② **Call the character input screen**

Press CHARACTER INPUT button Ⓐ and the character input screen (screen B) is displayed.



Data input screen (screen A)



Character input screen (screen B)

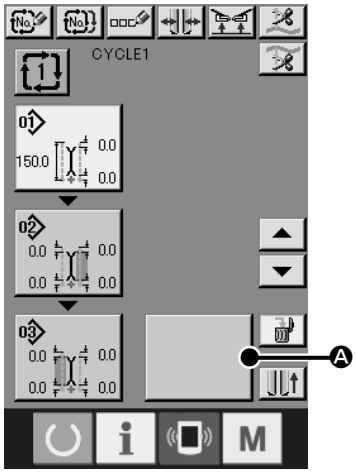
③ **Input the character**

It is possible to input the character by pressing CHARACTER button Ⓑ you desire to input. As many as 14 characters of characters (A to Z and 0 to 9) and symbols (+ , - , / , # , . and ,) can be inputted. Cursor can be moved with CURSOR LEFT MOVE button Ⓒ and CURSOR RIGHT MOVE button Ⓓ. When you desire to erase the inputted character adjust the cursor to the position of the character you desire to erase and press ERASE button Ⓔ.

④ **End the character input**

Press ENTER button Ⓕ to end the character input. After the end, the inputted character is displayed at the upper part of the input screen.

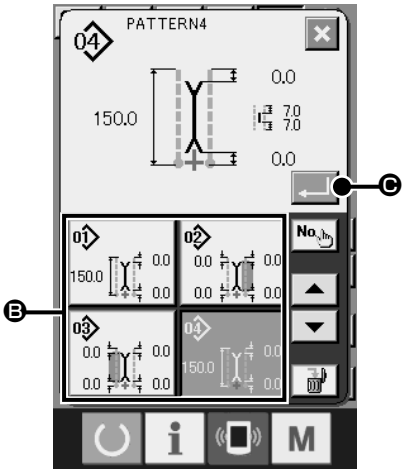
(6) Editing procedure of the cycle sewing data



Cycle sewing input screen (Screen C)

① **Display the cycle sewing input screen**

When the input screen of cycle sewing ode is displayed, it is possible to edit the cycle sewing data.



Pattern list screen (Screen B)

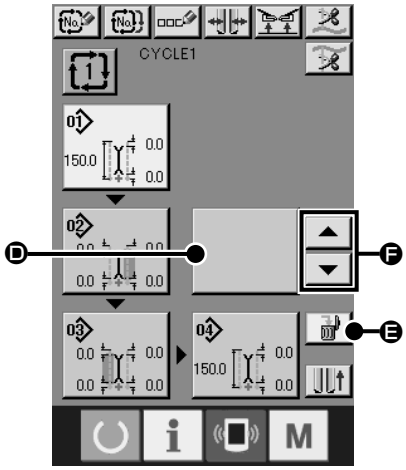
② **Register the pattern data**

Press BLANK button Ⓐ and the pattern list screen (screen B) is displayed.

Select the pattern data you desire to register from PATTERN LIST button Ⓑ and press ENTER button Ⓒ. Then the selected pattern data is registered to the blank section.

When the first pattern data is registered, BLANK button Ⓓ is displayed in the second place. Repeat the operation of ② in case of need.

As many as 6 pattern data can be registered to the cycle sewing data.

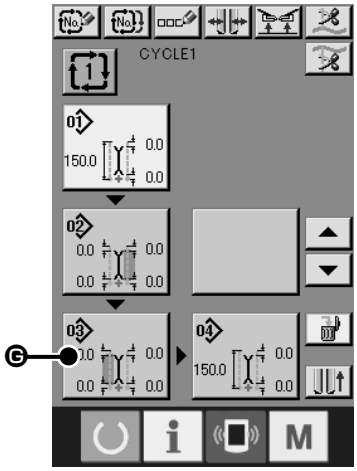


Cycle sewing input screen (Screen C)

③ **Erase the registered pattern data**

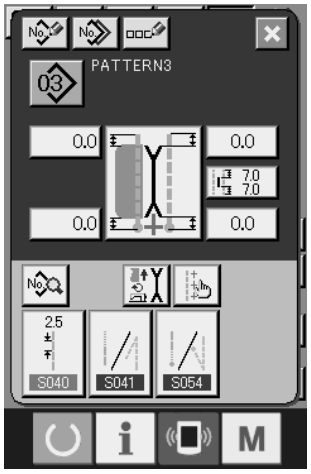
Press ERASE button Ⓔ and the pattern data which is displayed with white emphasis is erased. Select the pattern data you desire to erase with UP/DOWN SCROLL buttons and Ⓕ and erase it.

The pattern data which is displayed with white emphasis is the pattern data to be sewn next. So, move it in accordance with the sewing work.



④ **Edit the registered pattern data**

Press PATTERN DATA button Ⓖ you desire to edit and the pattern data edit screen (screen D) is displayed in pop-up. Refer to **"VI-3.(1) Input screen (Independent sewing mode)" p. 29**.



Pattern data edit screen (Screen D)

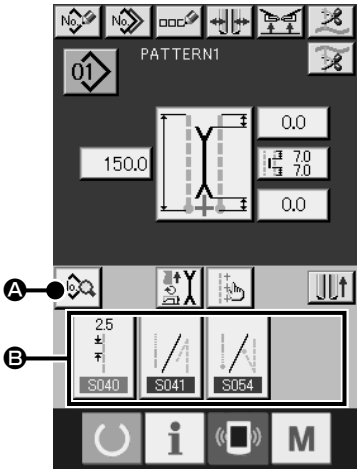
7. CHANGING THE SEWING DATA

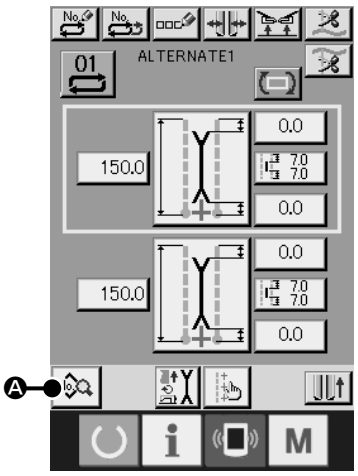
(1) Changing procedure of the sewing data

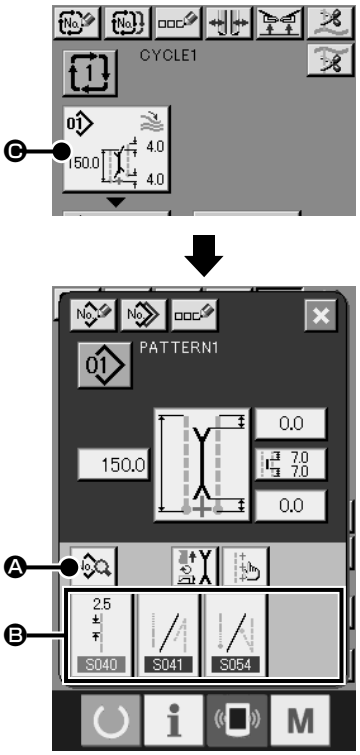
① **Display the input screen**

When the input screen of independent sewing mode, alternate sewing mode and cycle sewing mode is displayed it is possible to change the swing data.

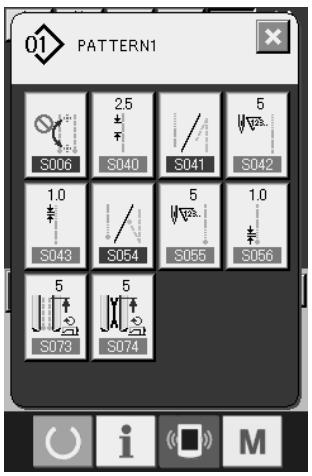
The sewing data which are frequently used can be registered to SEWING DATA SHORTCUT button Ⓑ in the input screen and be set directly. In addition, the detailed sewing data can be set by pressing Ⓐ.







1. **When changing the sewing data of cycle sewing mode, press PATTERN DATA EDIT button Ⓒ and it is possible to change.**
2. **In case of alternate sewing mode, SEWING DATA SHORTCUT button Ⓑ is not displayed.**
3. **For SEWING DATA SHORTCUT button Ⓑ, refer to "VI-12. CUSTOMIZING THE DATA INPUT SCREEN" p. 73.**
4. **For the details of sewing data, refer to " ① Items that are displayed in the data input screen of VI-7-(2) Sewing data list" p. 49.**



Sewing data list screen (Screen A)

② **Select the sewing data to be changed**

Press Ⓐ and the sewing data list screen (screen A) is displayed. Then select the data you desire to change.

Data items which are not used due to the shape are not displayed. So, be careful.

(2) Sewing data list

① Items that are displayed in the data input screen

No.	Item	Setting range / Edit unit	Initial value	
S001	**Motion mode change-over** With/without of motion of sewing machine motor, center knife and corner knife is selected. Cloth feed mode Cloth feed, sewing machine thread trimming and center knife mode Cloth feed, sewing machine thread trimming Cloth feed, sewing machine thread trimming, center knife and corner knife mode	- - -		
S003	**Sewing mode change-over** Sewing mode is selected. * In case of alternate sewing, flap priority sewing is set with S002 . L size sewing Left flap sewing Right flap sewing Flap priority sewing	- - -		○
S004	**L size setting** In case of L size sewing, the sewing length is set. * It is possible to set only when setting L size sewing S003 . * For the long and wide type, it is possible to set up to 250 mm. (However, it is possible to set up to 300 mm without corner knife.) 	18.0 to 220.0 / 0.1mm	150.0mm	※
S005	**Marking light irradiation position change-over** Sewing start irradiation/sewing end irradiation/center irradiation is selected. Sewing start irradiation Sewing end irradiation Center irradiation	- - -		
S008	**Flap concealed stitching data (Left sewing start)** Position of sewing start of left-hand flap is adjusted. * It is possible to set only when S003 is set to flap sewing. 	–9.9 to 9.9 / 0.1mm	0.0mm	※ △
S009	**Flap concealed stitching data (Left sewing end)** Position of sewing end of left-hand flap is adjusted. * It is possible to set only when S003 is set to flap sewing. 	–9.9 to 9.9 / 0.1mm	0.0mm	※ △
S010	**Flap concealed stitching data (Right sewing start)** Position of sewing start of right-hand flap is adjusted. * It is possible to set only when S003 is set to flap sewing. 	–9.9 to 9.9 / 0.1mm	0.0mm	※ △

※ . . . . Item that is not displayed due to other setting state

○ . . . . For the APW-895NE, S003 left (right) flap sewing and flap priority sewing cannot be used.

△ . . . . The item which is not used in the standard condition of the APW-895NE.

No.	Item	Setting range / Edit unit	Initial value	
S011	**Flap concealed stitching data (Right sewing end)** Position of sewing end of right-hand flap is adjusted. * It is possible to set only when S003 is set to flap sewing. 	–9.9 to 9.9 / 0.1mm	0.0mm	※ △
S017 S018	**Center knife actuating position setting** Cutting position of center knife at sewing start/sewing end is set. * Be sure to adjust with every gauge so that the position meets the top of letter V of corner knife. Sewing start center knife position Sewing end center knife position	0.0 to 25.0 / 0.1mm * APW-895L only Max. 30.0	7.0mm	
S019	**Corner knife actuating position at sewing start** Cutting position of corner knife at sewing start is set. 	–9.9 to 9.9 / 0.1mm	0.0mm	
S020	**Corner knife actuating position at sewing end** Cutting position of corner knife at sewing end is set. 	–9.9 to 9.9 / 0.1mm	0.0mm	
S030 S031 S032	**Marking light setting** Marking light irradiation position in each case of sewing start irradiation/ sewing end irradiation/center irradiation is set. When set value 0.0n mm, the sewing position is the same as the marking light irradiation position. Use this function when irradiating the marking light to the position that is different from the sewing position. Sewing start irradiation Sewing end irradiation Center irradiation	–100.0 to 100.0 * Sewing start irradiation : –80.0 to 100.0 / 0.1mm	0.0mm	
S069	**Roller stacker stop/motion change-over** Stop/motion of roller stacker is selected. * It is displayed only when SP047 is set to roller stacker mounting. Stop Motion	- - -		※
S070	**Clamp bar stacker stop/motion change-over** Stop/motion of clamp bar stacker is selected. * It is displayed only when SP046 is set to clamp bar stacker mounting. Stop Motion	- - -		※

※ . . . Item that is not displayed due to other setting state

△ . . . . The item which is not used in the standard condition of the APW-895NE.

② Items that are displayed in the sewing data list screen

No.	Item	Setting range / Edit unit	Initial value	
S002	**Flap priority sewing selection** Flap priority sewing mode is selected. * It is possible to set only when alternate sewing mode is set. Flap priority sewing prohibited Flap priority sewing mode	- - -		※ △
S006	**Selection of automatic changeover of marking light irradiation position** When S005 is sewing start irradiation or sewing end irradiation, the marking irradiation position is automatically changed over after end of sewing. * This function does not move at the time of alternate sewing mode and cycle sewing mode. Stop Motion	- - -		※
S012	**Flap forced stop data** When flap sewing end is not detected, the machine stops after sewing as long as the set length from rear reference position. * It is possible to set only when S003 is set to flap sewing. 	0.0 to 10.0 / 0.1mm	5.0mm	※ △
S040	**Lockstitch pitch** Sewing pitch of lockstitch section is set. 	2.0 to 3.4 / 0.1mm	2.5mm	
S041	**Selection of condensation/back tack at sewing start** Condensation/back tack at sewing start is selected. Condensation Back tack	- - -		
S042	**Number of condensation stitches at sewing start** Number of condensation stitches at sewing start is set. * It is possible to set only when S041 is set to selection of condensation. 	3 to 19 / 1 stitch	5 stitches	※
S043	**Condensation pitch at sewing start** Condensation sewing pitch at sewing start is set. * It is possible to set only when S041 is set to selection of condensation. 	0.5 to 1.5 / 0.1mm	1.0mm	※
S044	**First stitch pitch of condensation sewing at sewing start** First stitch pitch of condensation sewing at sewing start is set. * It is possible to set only when S041 is set to selection of condensation. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 1.5 / 0.1mm	1.0mm	※

※ . . . Item that is not displayed due to other setting state

△ . . . . The item which is not used in the standard condition of the APW-895NE.

No.	Item	Setting range / Edit unit	Initial value	
S045	**Second stitch pitch of condensation sewing at sewing start** Second stitch pitch of condensation sewing at sewing start is set. * It is possible to set only when S041 is set to selection of condensation. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 1.5 / 0.1mm	1.0mm	※
S046	**Third stitch pitch of condensation sewing at sewing start** Third stitch pitch of condensation sewing at sewing start is set. * It is possible to set only when S041 is set to selection of condensation. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 1.5 / 0.1mm	1.0mm	※
S047	**Number of back tack stitches at sewing start** Number of back tack stitches at sewing start is set. * It is possible to set only when S041 is set to selection of back tack. 	1 to 12 / 1 stitch	3 stitches	※
S048	**Back tack pitch at sewing start** Back tack sewing pitch at sewing start is set. * It is possible to set only when S041 is set to selection of back tack. 	0.5 to 3.0 / 0.1mm	2.0mm	※
S049	**Back tack tie stitch pitch at sewing start** Back tack tie stitch at sewing start is set. * It is possible to set only when S041 is set to selection of back tack. 	–2.0 to 2.0 / 0.1mm	–1.5mm	※
S050	**First stitch pitch of return of back tack at sewing start** First stitch pitch of return section of back tack sewing at sewing start is set. * It is possible to set only when S041 is set to selection of back tack. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 3.0 / 0.1mm	2.0mm	※
S051	**Second stitch pitch of return of back tack at sewing start** Second stitch pitch of return section of back tack sewing at sewing start is set. * It is possible to set only when S041 is set to selection of back tack. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 3.0 / 0.1mm	2.0mm	※

※ . . . Item that is not displayed due to other setting state

No.	Item	Setting range / Edit unit	Initial value	
S052	**Third stitch pitch of return of back tack at sewing start** Third stitch pitch of return section of back tack sewing at sewing start is set. * It is possible to set only when S041 is set to selection of back tack. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 3.0 / 0.1mm	2.0mm	※
S053	**Compensation of turning of back tack stitches at the sewing start** This key is used to set a compensation value of the turning of back tack stitches at the sewing start. * It is possible to set only when S041 is set to selection of back tack. * It is possible to set only when K061 compensates with pattern data. 	–2.0 to 2.0 / 0.1mm	1.0mm	※
S054	**Selection of condensation/back tack at sewing end** Selection of condensation/back tack at sewing end is performed. Condensation Back tack	- - -		
S055	**Number of condensation stitches at sewing end** Number of condensation stitches at sewing end is set. * It is possible to set only when S054 is set to selection of condensation. 	3 to 19 / 1 stitch	5 stitches	※
S056	**Condensation pitch at sewing end** Condensation sewing pitch at sewing end is set. * It is possible to set only when S054 is set to selection of condensation. 	0.5 to 1.5 / 0.1mm	1.0mm	※
S057	**The last stitch pitch of condensation** The last stitch pitch of condensation sewing at sewing end is set. * It is possible to set only when S054 is set to selection of condensation. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 1.5 / 0.1mm	1.0mm	※
S058	**Pitch of one stitch before the last stitch of condensation** Pitch of one stitch before the last stitch of condensation sewing at sewing end is set. * It is possible to set only when S054 is set to selection of condensation. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 1.5 / 0.1mm	1.0mm	※

※ . . . Item that is not displayed due to other setting state

No.	Item	Setting range / Edit unit	Initial value	
S059	**Pitch of two stitches before the last stitch of condensation** Pitch of two stitches before the last stitch of condensation sewing at sewing end is set. * It is possible to set only when S054 is set to selection of condensation. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 1.5 / 0.1mm	1.0mm	※
S060	**Number of back tack stitches at sewing end** Number of back tack stitches at sewing end is set. * It is possible to set only when S054 is set to selection of back tack. 	1 to 12 / 1 stitch	3 stitches	※
S061	**Back tack pitch at sewing end** Back tack sewing pitch at sewing end is set. * It is possible to set only when S054 is set to selection of back tack. 	0.5 to 3.0 / 0.1mm	2.0mm	※
S063	**First stitch pitch of return of back tack at sewing end** First stitch pitch of return section of back tack sewing at sewing end is set. * It is possible to set only when S054 is set to selection of back tack. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 3.0 / 0.1mm	2.0mm	※
S064	**Second stitch pitch of return of back tack sewing at sewing end** Second stitch pitch of return section of back tack sewing at sewing end is set. * It is possible to set only when S054 is set to selection of back tack. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 3.0 / 0.1mm	2.0mm	※
S065	**Third stitch pitch of return of back tack sewing at sewing end** Third stitch pitch of return section of back tack sewing at sewing end is set. * It is possible to set only when S054 is set to selection of back tack. * It is possible to set only when U024 is set to selection of condensation/ back tack detailed setting. 	0.1 to 3.0 / 0.1mm	2.0mm	※
S067	**The last stitch pitch of back tack at sewing end** The last stitch pitch of back tack at sewing end is set. * It is possible to set only when S054 is set to selection of back tack. 	–2.0 to 2.0 / 0.1mm	–1.5mm	※

※ . . . Item that is not displayed due to other setting state

No.	Item	Setting range / Edit unit	Initial value	
S068	**Compensation of back tack return at sewing end** Compensation value of back tack return at sewing end is set. * It is possible to set only when S054 is set to selection of back tack. * It is possible to set only when K061 compensates with pattern data. 	–2.0 to 2.0 / 0.1mm	1.0mm	※
S071	**Stacking position** After moving clamp foot as far as the set distance from the position of corner knife, stacker is actuated. (+ : rear side, - : front side) * Range of actuating amount is limited by the position of clamp foot at the time of sewing end. * Use SP046 clamp bar stacker or SP047 roller stacker. In addition, it is possible to set only when S069 roller stacker motion setting or S070 clamp bar stacker motion setting is performed. 	0 to 500mm / 1mm	0mm	※
S072	**Stacker timer 1** Roller rotation time is set. When material sensor has detected without material before setting time, rotation stops. * SP047 roller stacker option is used and it is possible to set only when S069 roller stacker motion is set. 	0.0 to 9.9 / 0.1 sec.	0.5 sec.	※
S073	**Jump feed speed up to the position of sewing start** Jump feed speed up to the position of sewing start is set. 	3 to 8 / 1	5	
S074	**Jump feed speed up to the position of corner knife** Jump feed speed up to the position of corner knife is set. 	3 to 6 / 1	5	
S075	**Dart stretcher device stop/motion change-over** Stop/motion of dart stretcher device is selected. * It is possible to set only when SA117 dart stretcher option is used. Stop Motion	- - -		※
S076	**Automatic interlining supplying device stop/motion change-over** Stop/motion of automatic interlining supplying device is selected. * It is possible to set only when SA120 automatic interlining supplying option is used. * Regarding the interlining supplying, when the pattern is not used, be careful not to make the interlining come out from the top surface of the table. When using next, press once the feeding button on the panel and perform the feeding motion to cut. Stop Motion	- - -		※

※ . . . Item that is not displayed due to other setting state

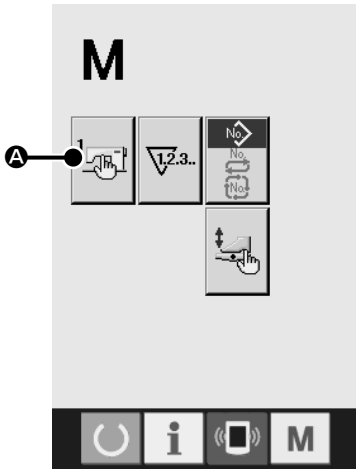
No.	Item	Setting range / Edit unit	Initial value	
S077	**Flap length** Length of flap is set. It is possible to set only when S076 automatic interlining supplying device is selected to motion and S003 sewing mode changeover is selected to flap sewing. * This setting is set to determine the interlining feeding length of automatic interlining supplying device. Sewing length is determined by the detection of flap sensor. 	37.0 to 220.0 / 0.1mm	150.0mm	※ △
S078	**Sewing speed under the high-speed mode** Number of revolutions at lockstitch section is set. * It is possible to set only when K059 sewing speed setting selection is set to pattern data selection. 	1000 to 3000 / 100sti/min	2500sti/min	※
S079	**Sewing speed under the low-speed mode** Number of revolutions at condensation and back tack sewing sections is set. * It is limited by S078 sewing speed under the high-speed mode. * It is possible to set only when K059 sewing speed setting selection is set to the selection of pattern data. * In case of back tack sewing, the upper limit of number of revolutions of the actual low speed is limited to 1,500 sti/min. 	1000 to 2500 / 100sti/min	1500sti/min	※

※ . . . Item that is not displayed due to other setting state

△ . . . . The item which is not used in the standard condition of the APW-895NE.

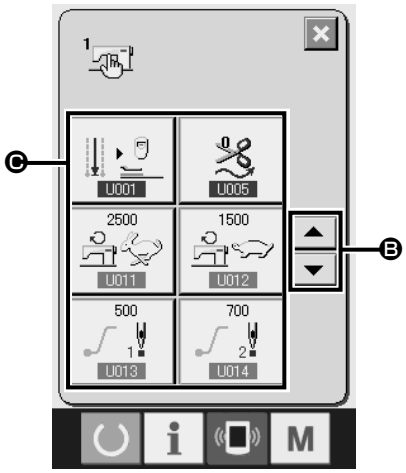
8. CHANGING THE MEMORY SWITCH DATA

(1) Changing procedure of the memory switch data



① **Display the memory switch data list screen**

Press MODE CHANGE-OVER key M and the memory switch button Ⓐ is displayed. When this button is pressed, the memory switch data list (screen A) is displayed.



Memory switch data list screen (Screen A)

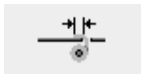
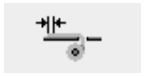
② **Select the memory switch button you desire to change**

Press UP/DOWN SCROLL button ▲ or ▼ Ⓑ and select DATA ITEM button Ⓒ you desire to change.

(2) Memory switch data list

① **Level 1**

Memory switch data (level 1) are the motion data that the sewing machine has in common and the data that operate on all sewing patterns in common.

No.	Item	Setting range / Edit unit	Initial value	
U001	**Change-over of the position of clamp foot after sewing end** Position of clamp foot after sewing end is selected from Stop at front end/Return to medium/Clamp return/Stop at rear end. Stop at front end Return to medium Clamp return Stop at rear end	- - -		
U002	**Front end motion start waiting time** Waiting time up to the start of front end motion of clamp foot is set. * It is possible to set only when U001 is set to the stop at front end. 	0.50 to 9.99 / 0.01 sec.	3.00 sec.	※
U003	**Number of times of feeding of automatic interlining supplying at sewing start** Number of times of feeding of automatic interlining supplying device at sewing start is set. * It is possible to set only when SA120 automatic interlining supplying option is used. 	2 to 9 / 1	3	※
U004	**Feeding length of automatic interlining supplying at sewing end** Feeding length of automatic interlining supplying device at sewing end is set. * It is possible to set only when SA120 automatic interlining supplying device is used. 	0 to 99.9 / 0.1mm	0mm	※
U005	**Thread trimming timing** Thread trimming timing after sewing is selected from Standard/Medium/Longest and length of thread at sewing end is adjusted. Standard 0 Medium 1 Longest 2 * When SA125 Zipper attachment is mounted and the setting is set to standard value "0", needle thread may not be cut.	- - -		
U007	**Stacker timer 2** Waiting time from the start of clamp motion to hold material on the stacker base to release the material presser is set. * It is possible to set only when SP046 clamp bar stacker option is used.	0.00 to 9.99 / 0.01 sec.	0.70 sec.	※

※ . . . Item that is not displayed due to other setting state

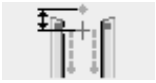
No.	Item	Setting range / Edit unit	Initial value	
U008	**Stacker timer 3** Motion time of material sweeping bar is set. * It is possible to set only when SP046 clamp bar stacker option is used.	0.00 to 9.99 / 0.01 sec.	0.70 sec.	※
U009	**Stacker timer 4** Time to advance timing to release the sewing product by lifting clamp foot is set. When clamping a short sewing product, the amount to drop by tare is adjusted. * It is possible to set only when SP046 clamp bar stacker option is used.	0.00 to 9.99 / 0.01 sec.	0.00 sec.	※
U011	**Sewing speed under the high-speed mode** Number of revolutions of lockstitch section is set. * It is possible to set only when K059 sewing speed setting selection is set to memory switch.	1000 to 3000 / 100sti/min	2500sti/min	※
U012	**Sewing speed under the low-speed mode** Number of revolutions of condensation and back tack sewing sections is set. * It is limited by U011 sewing speed under the high-speed mode. * It is possible to set only when K059 sewing speed setting selection is set to memory switch. * In case of back tack sewing, the upper limit of number of revolutions of the actual low speed is limited to 1,500 sti/min.	1000 to 2500 / 100sti/min	1500sti/min	※
U013	**Soft start, first stitch** Number of revolutions of first stitch at sewing start is limited.	500 to 2500 / 100sti/min	1500sti/min	
U014	**Soft start, second stitch** Number of revolutions of second stitch at sewing start is limited.	500 to 2500 / 100sti/min	2500sti/min	
U015	**Soft start, third stitch** Number of revolutions of third stitch at sewing start is limited.	500 to 2500 / 100sti/min	2500sti/min	
U016	**Return speed of clamp foot** Return speed of clamp foot is set.	3 to 9 / 1	7	
U017	**Thread breakage detection** With/without thread breakage detection is selected. With thread breakage detection Without thread breakage detection	- - -		

※ . . . Item that is not displayed due to other setting state

No.	Item	Setting range / Edit unit	Initial value	
U018	**Flap presser motion mode** Motion order of flap presser is selected. From right From left Right/Left at the same time Side where flap is put * When right and left are simultaneously actuated with customizing of pedal setting, this parameter is neglected and the right and left are simultaneously actuated.	- - -		△
U019	**Clamp foot down order change-over** Lowering order of clamp foot is selected. From right From left Right/left at the same time * When right and left are simultaneously actuated with customizing of pedal setting, this parameter is neglected and the right and left are simultaneously actuated.	- - -		
U020	**Folding plate motion mode** "Return/No return" of folding plate when corner knife projects is selected. Return No return	- - -		
U021	**Binder pressure reduction rise prohibition** Pressure reduction rise of the binder at the time of jump feed is prohibited. Pressure reduction rise is prohibited Pressure reduction rise	- - -		
U022	**Standing pedal continuous depressing timer effective/ineffective change-over** Effective/ineffective of U023 standing pedal continuous depressing timer is selected. * It is possible to set only when K054 one-shot pedal is set. Ineffective Effective	- - -		※
U023	**Standing pedal continuous depressing timer** When performing sewing product setting work with the standing pedal depressed, the time interval when the respective devices operate in order is set. * It is possible to set only when K054 one-shot pedal is set. 	0.1 to 2.0 / 0.1 sec.	0.5 sec.	※
U024	**Condensation/back tack detailed setting** Detailed setting "Perform/Not perform" of pitch of condensation/back tack section is selected. Perform Not perform	- - -		

※ . . . Item that is not displayed due to other setting state

△ . . . . The item which is not used in the standard condition of the APW-895NE.

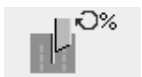
No.	Item	Setting range / Edit unit	Initial value	
U025	**Flap stopper position** In case of flap sewing, sewing start irradiation position of marking light (distance from needle)is set * Setting is only the irradiation position of marking light. Actual sewing position is the flap end position detected by the flap sensor. 	80.0 to 280.0 / 0.1mm	80.0mm	△
U028	**Stacker timer 5** Sets the waiting time of the stacker from the start of material grasping operation to the release of the material This setting is available when SP048 "Grasping stacker (optional)" is used. 	0.00 - 9.99/ 0.01 sec	1.00 sec	
U029	**Stacker timer 6** Sets the duration of operating the oscillating arm This setting is available when SP048 "Grasping stacker (optional)" is used. 	0.00 - 9.99/ 0.01 sec	1.50 sec	
U033	**Setting the corner-knife fixing distance** The distance provided between the corner knife on the moving side and that on the fixed side is set. In the case "Mount" is set for the item K053 "Setting of solenoid valve for separately-driving the corner knife", the clamp foot travels so that the sewing starting position aligns with the position of the corner knife on the moving side.	35.0 to 220.0 / 0.1mm	100.0mm	
U245	**Number of stitches of grease-up** Number of stitches of sewing machine motion after replenishing grease is indicated. * When pressing CLEAR button, number of stitches is cleared to “0”. Be sure to clear after replenishing grease. 	- - -	- - -	
U500	**Language selection** Language to be indicated in the panel is selected. 日本語 Japanese　English English 中文简体字 Chinese (traditional)　中文繁體字 Chinese (simplified) Español Spanish　Italiano Italian Français French　Deutsch German Português Portuguese　Türkçe Portuguese Tiếng Việt Vietnamese　한국어 Korean Indonesia Indonesian　Русский Russian	- - -	No selection	

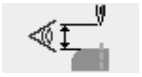
※ . . . Item that is not displayed due to other setting state

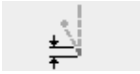
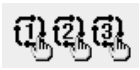
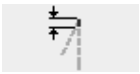
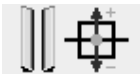
△ . . . . The item which is not used in the standard condition of the APW-895NE.

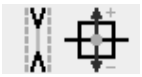
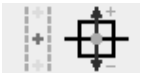
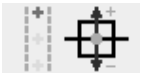
② **Level 2**

Memory switch data (level 2) are the motion data that the sewing machine has in common and the data that operate on all sewing patterns in common. The data are for the maintenance personnel and possible to edit by pressing the mode switch as long as 6 seconds.

No.	Item	Setting range / Edit unit	Initial value
K051	**Marking light mounting** Mounting/Non-mounting of marking light is selected. When “Non mounting” is selected, marking light does not work. Non mounting Mounting	- - -	
K052	**Sewing position selection** Mode that surely ends sewing at rear reference position, mode that surely starts sewing from front reference position or the conventional motion mode that changes sewing position according to the setting of S005 is selected. * Front reference position : 80 mm from needle Rear reference position : 300 mm from needle (For the long and wide type, it is 330 mm. However, when K058 is set, it is 380 mm.) Conventional motion mode Sewing position fixed mode (Rear reference) Sewing position fixed mode (Front reference)	- - -	
K053	**Setting of solenoid valve for corner knife separate drive** Mounting/non mounting of solenoid valve for corner knife separate drive is set. Non mounting Mounting	- - -	
K054	**Pedal operation mode change-over** Mode to be used for foot pedal is set. 7-step pedal mode 1-shot pedal mode	- - -	
K055	**Excess rate of center knife cutting** Excess rate in terms of the speed of revolution of center knife can be set. 	300 to 500 / 1%	350%

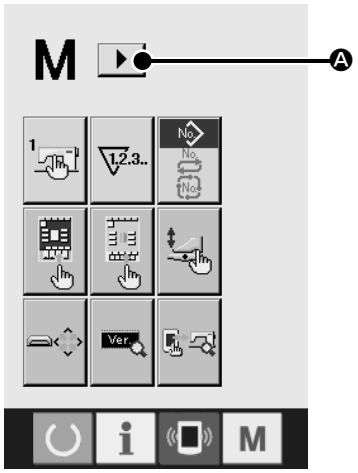
No.	Item	Setting range / Edit unit	Initial value
K056	**Setting of intermittent feed prohibition** Perform/not perform intermittent feed sewing is selected. * When performing intermittent sewing, the max. sewing speed of sewing machine is limited 1,500 sti/min. Perform intermittent feed sewing Not perform intermittent feed sewing	- - -	
K057	**Change-over of flap concealed stitching data edit reference** Making the flap concealed stitching data that is set from panel the compensation value from the flap detecting end or the distance from detecting sensor to sewing start is selected. Flap detecting end compensation  Sensor compensation	- - -	
K058	**L size data range enlargement** Enlarging/not enlarging L size data range to max. 220 mm + 15 mm is set. In case of the long and wide type, the size is enlarged to 250 mm + 50 mm. * When performing sewing longer than 250 mm with M004 the long and wide type, the corner knife does not work. * In case of M004 the long and wide type, corner knife does not work when a flap cloth is put in the area of +50 mm even when it is less than 250 mm. Not enlarging Enlarging	- - -	
K059	**Selection of sewing speed of sewing machine setting** It is selected that either memory switch or pattern data performs setting of sewing speed of sewing machine. Memory switch Pattern data	- - -	
K060	**Selection of reflecting tape check mode** ON/OFF of reflecting tape check mode is set. When ON is set, the clamp foot is automatically comes lowered with the first clamp foot advance motion after turning ON the power and deterioration check of reflecting tape is performed. * Clamp foot is automatically lowered. Be sure to use this function only in case of shim type. OFF ON	- - -	
K061	**Selection of back tack return compensation setting** It is selected that either memory switch or pattern data performs setting of back tack return compensation. Memory switch Pattern data	- - -	

No.	Item	Setting range / Edit unit	Initial value
K062	**Back tack return at sewing end compensation** Back tack return at sewing end compensation is set. * It is possible to set only when K061 is set to the memory switch selection. 	−2.0 to 2.0 / 0.1mm	1.0mm
K063	**Selection of mode change-over button display in the pattern list screen** Mode change-over button is displayed in the pattern list screen and data of different mode can be selected. Non-display Display	- - -	
K066	**Cycle sewing coupling function** Odd-numbered pattern can be coupled to even-numbered pattern and as many as 12 steps can be sewn. Only combination of 1 and 2, 3 and 4, 5 and 6, 7 and 8, 9 and 10, 11 and 12, 13 and 14, 15 and 16, 17 and 18, and 19 and 20 can be coupled. Coupling function OFF Coupling function ON	- - -	
K069	**Center knife lowering time** Center knife lowering time is set. 	10 to 100 / 1	40
K070	**Center knife one-shot motion prohibition setting** With/without one-shot motion to properly cut the cutting position of center knife on the side of the end of sewing is selected. With one-shot motion One-shot motion prohibited	- - -	
K071	**Compensation of turning of back tack stitches at the sewing start** This key is used to set a compensation value of the turning of back tack stitches at the sewing start. * It is possible to set only when K061 compensates with pattern data. 	–2.0 to 2.0 / 0.1mm	1.0mm
K080	**Clamp foot motor origin compensation** Origin of clamp foot motor is compensated. 	−10.0 to 10.0 / 0.1mm	0.0mm

No.	Item	Setting range / Edit unit	Initial value
K081	**Corner knife motor origin compensation** Origin of corner knife motor is compensated. 	−5.0 to 5.0 / 0.1mm	0.0mm
K082	**Marking light origin compensation (just under)** Origin of marking light motor is compensated. Origin is in the state that it irradiates light just under and located at the position of 230 mm from needle. * In case of M004 Long and wide type, light irradiation position is at the position of 246 mm from the needle. 	−500 to 500 / 1 pulse	0 pulse
K083	**Marking light origin compensation (needle side)** Position of needle side from origin of marking light motor is compensated. Light irradiation position is 80 mm from needle. * In case of M004 Long and wide type, light irradiation position is at the position of 96 mm from the needle. 	−500 to 500 / 1 pulse	0 pulse
K084	**Marking light origin compensation (operator side)** Position of operator side from origin of marking light motor is compensated. Light irradiation position is 380 mm from needle. * In case of M004 Long and wide type, light irradiation position is at the position of 396 mm from the needle. 	−500 to 500 / 1 pulse	0 pulse
K085	**Back tack motor origin compensation** Origin of back tack motor is compensated. 	−30 to 30 / 1 pulse	0 pulse

9. PERFORMING OPTIONAL SETTING

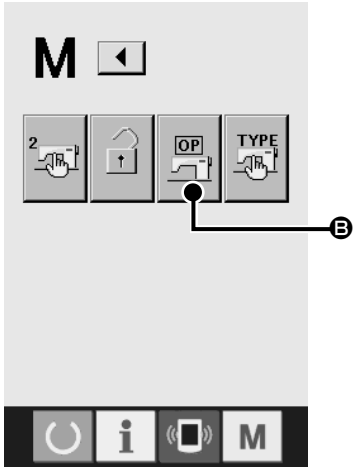
(1) Changing procedure of the optional setting



① **Displaying the 2nd screen of the operation-mode changeover screen.**

When you keep operation-mode changeover key M held pressed for six seconds, right-scroll button ▶ Ⓐ is displayed on the screen.

When you press this button, the 2nd screen (screen A) of the operation-mode changeover screen is displayed.

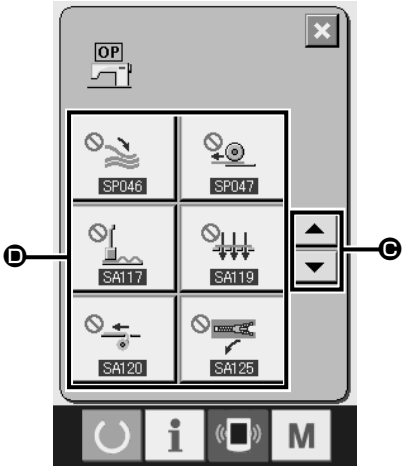


Second screen of the mode changeover screen (Screen A)

② **Displaying the option setting list screen**

Option setting button OP Ⓑ is displayed on the screen.

When you press this button, option setting list screen (screen B) is displayed.



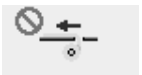
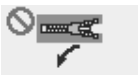
Optional setting list screen (Screen B)

③ **Selecting the option setting you want to change**

Press up/down scroll buttons ▲ ▼ Ⓒ to select the data item button Ⓓ you want to change.

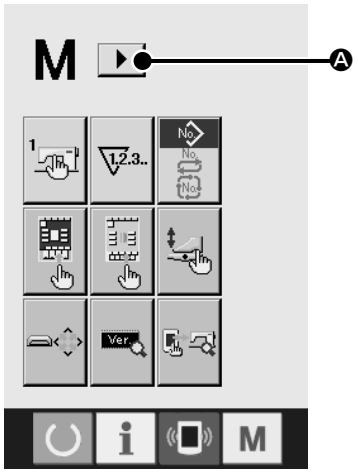
(2) Optional setting list

By setting the optional mounted state, it is possible to perform the respective optional operations.

No.	Item	Setting range / Edit unit	Initial value
SP046	**Clamp bar stacker mounting/not mounting is set** Not mounting Mounting	- - -	 Not mounting
SP047	**Roller stacker mounting/not mounting is set.** Not mounting Mounting	- - -	 Not mounting
SP048	**Sets mount/unmount of the grasping stacker device mount/unmount** Unmount Mount	- - -	 Unmount
SA117	**Dart stretcher mounting/not mounting is set.** * However, in case of dart stretcher mounting, M001 Gauge size setting is limited to 8 to 12 mm. * In case of M004 the long and wide type, the dart stretcher does not work. Not mounting Mounting	- - -	 Mounting
SA119	**Vacuum device mounting/not mounting is set.** * In case of M004 the long and wide type, the vacuum device does not work. Not mounting Mounting	- - -	 Not mounting
SA120	**Automatic interlining supplying device mounting/not mounting is set.** * In case of M004 the long and wide type, the automatic interlining supplying device does not work.  Not mounting Mounting	- - -	 Not mounting
SA125	**Zipper attachment mounting/not mounting is set.** * However, in case of zipper attachment mounting, M001 Gauge size setting is limited to 16 to 20 mm. * In case of M004 the long and wide type, the zipper attachment does not work. Not mounting Mounting	- - -	 Not mounting

10. CHANGING THE DEVICE SETTING

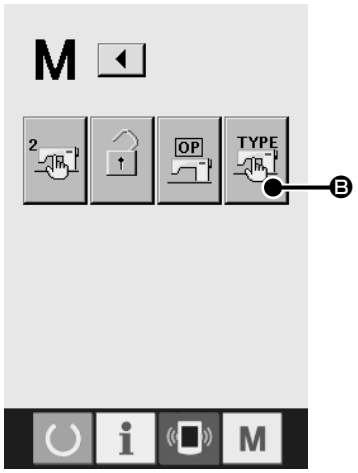
(1) Changing procedure of the device setting



① **Displaying the 2nd screen of the operation-mode changeover screen.**

When you keep operation-mode changeover key M held pressed for six seconds, right-scroll button ▶ Ⓐ is displayed on the screen.

When you press this button, the 2nd screen (screen A) of the operation-mode changeover screen is displayed.

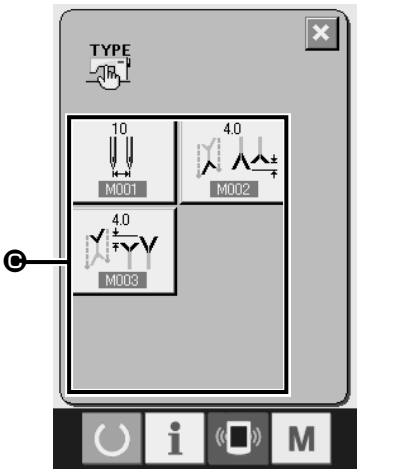


Second screen of the mode changeover screen (Screen A)

② **Displaying the device setting list screen**

Device setting button TYPE Ⓑ is displayed on the screen.

When you press this button, the device setting list screen is displayed.



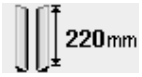
Device setting list screen (Screen B)

③ **Selecting the device setting you want to change**

Select the data item button Ⓒ you want to change.

(2) Device setting list

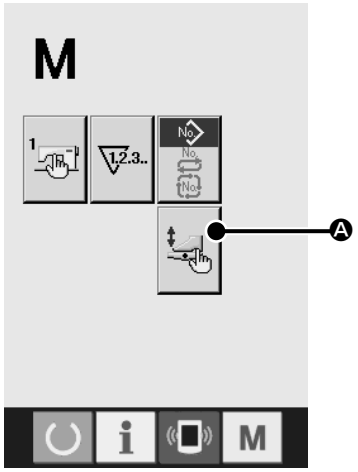
By setting the type of device, it is possible to operate according to the type.

No.	Item	Setting range / Edit unit	Initial value
M001	**Gauge size** Gauge size of sewing machine is set. * For M004 the long and wide type, the range is enlarged to 22 to 32 mm. * Corner knife motion is changed according to the set value of gauge size. * When SA117 Dart stretcher device is mounted, the range is limited to 8 to 12 mm and SA125 Zipper attachment is mounted, 16 to 20 mm. 	8 to 20 (22 to 32) / 2 mm	10 mm
M004	**Long and wide type selection** It is set when using the long and wide type.  Standard : Standard clamp mounting, Sewing size 220 mm Long and wide type : Clamp foot for long and wide type mounting, Sewing size 250 mm **The type has been set according to the mounted clamp foot type at the time of delivery. Do not select any other than the mounted clamp foot type since interference occurs.**	- - -	

11. CUSTOMIZING THE PEDAL OPERATION

Operation functions of “Binder down”, “Flap presser down”, etc. in terms of the number of the respective depressing steps of the pedal can be optionally registered in accordance with the using conditions.
In addition, the customized pedal operation data can have as many as 5 kinds. Select and use them.

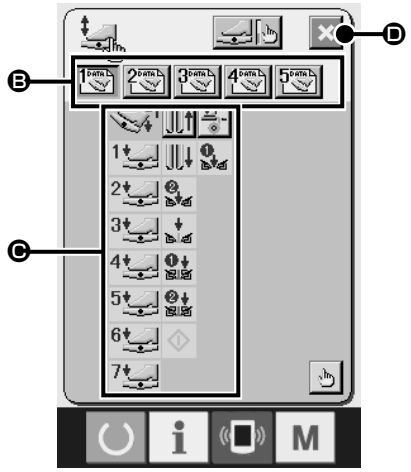
(1) Method to select and use the customized data



① **Display the pedal customizing screen**

Press MODE CHANGEOVER key M and PEDAL CUSTOMIZING button Ⓐ is displayed on the screen.

Press this button and the pedal customizing screen (screen A) is displayed.

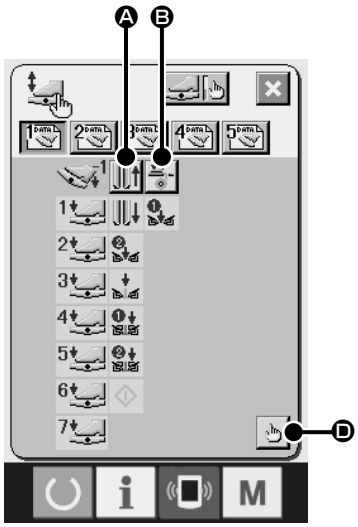


Pedal customizing screen (Screen A)

② Select from button Ⓑ 5 kinds of pedal operation that are registered as customized. At this time, the contents of selected pedal operation data are displayed at Ⓒ.

③ When SCREEN END button Ⓓ is pressed, the selected pedal operation data is determined and the screen returns to the original screen.

(2) Customizing the pedal operation data

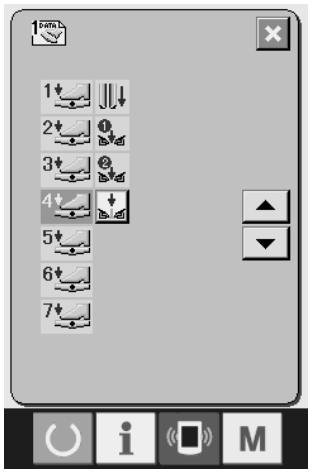


① Press button Ⓐ, and set whether to make the clamp foot recede or not with the pedal depressed to the reverse step.

Display	Description
	To make clamp foot recede
	Not to make clamp foot recede

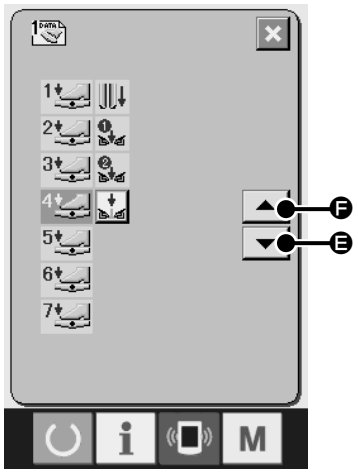
② Press button Ⓑ, and set whether or not the interlining presser actuate with the pedal depressed to the reverse step.

Display	Description
	To actuate
	Not to actuate



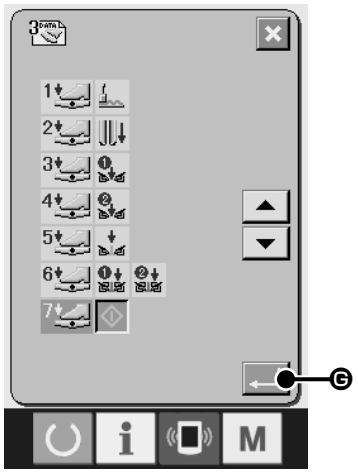
Pedal motion function setting screen (Screen A)

③ When button Ⓓ is pressed, the pedal operation function setting screen (screen A) is displayed. On this screen, the operation function corresponding to the number of times of depress on the pedal can be set.



④ The below-stated functions can be registered to the number of times of depress on the pedal in sequence from the single depress. Functions that can be registered are in the state of button as , and displayed in order. When the displayed button is depressed, the button is highlighted and registered. The number of times of depress on the pedal is proceeded to the next one with ▲▼ button Ⓔ.

The display is returned to the previous state by returning the number of times of depress on the pedal to the previous one with Ⓕ.



When functions are registered up to the last, ENTER button is displayed. Press it to determine the registered data.

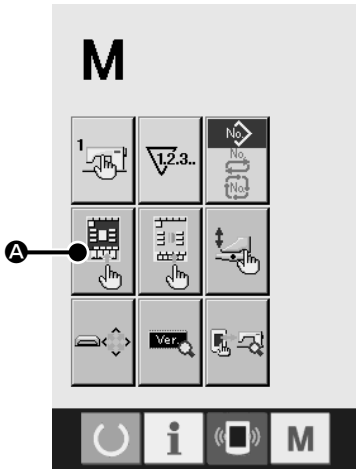
Ⓖ

* It is possible to clear and register the number of pedal steps.
* For the NE type model, the flap presser is not installed. It is necessary, however, to set the operation of the flap presser when setting the pedal.
  In this case, the operation function of the flap presser is set, but the operation is skipped when the sewing machine operates.

Display	Description	Display	Description
	Dart stretcher (optional)		Binder down
	Vacuum suction		Flap presser one side down
	Clamp foot one side down		Flap presser remaining side down
	Clamp foot remaining side down		Machine start

12. CUSTOMIZING THE DATA INPUT SCREEN

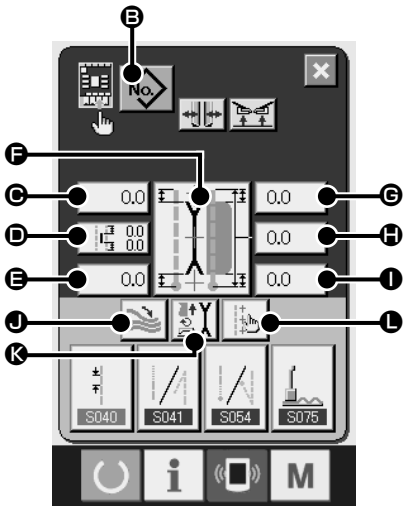
Buttons displayed in the data input screen can be customized in accordance with the customers' using conditions.



① **Display the customizing screen of the input screen**

Keep pressing MODE CHANGEOVER key M for three seconds, and CUSTOMIZE button Ⓐ is displayed on the screen.

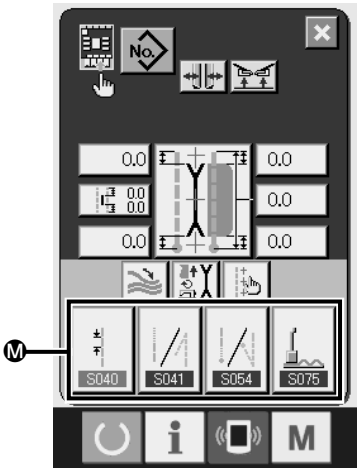
When this button is pressed, the customizing screen of the input screen is displayed.



② **Select the conditions of buttons**

Every time the buttons from Ⓑ to Ⓛ are pressed, display/non display of the buttons can be changed over. Customize and use the buttons in accordance with the customers' using conditions.

Symbol	Display	Non display	Description	Initial state
Ⓑ			Pattern list button	
Ⓒ	0.0	0.0	Flap concealed stitching data (Left sewing start)	0.0
Ⓓ			Center knife motion position setting	
Ⓔ	0.0	0.0	Flap concealed stitching data (Left sewing end)	0.0
Ⓕ			Sewing mode change-over	
Ⓖ	0.0	0.0	Corner knife motion position at sewing start	0.0
Ⓗ	0.0	0.0	L size setting	0.0
Ⓘ	0.0	0.0	Corner knife motion position at sewing end	0.0
Ⓙ			Stacker stop/motion change-over	
Ⓚ			Motion mode change-over	
Ⓛ			Marking light setting	



③ **Register the sewing data to SEWING DATA CUSTOMIZING button**

Up to 4 sewing data can be registered to SEWING DATA CUSTOMIZE buttons Ⓜ.

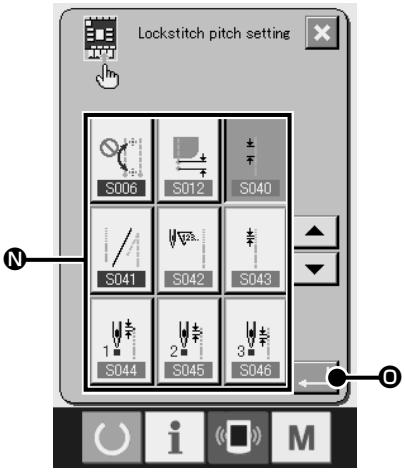
Register and use the sewing data that are frequently used.

When pressing CUSTOMIZING button Ⓜ you desire to register, the sewing data list (screen A) is displayed.

④ **Select the sewing data to be registered**

Select the sewing data you desire to register with SEWING DATA button Ⓝ.

When the selected button is pressed twice, the selection is released.



Sewing data list screen (Screen A)

⑤ **Register the data to the customizing button**

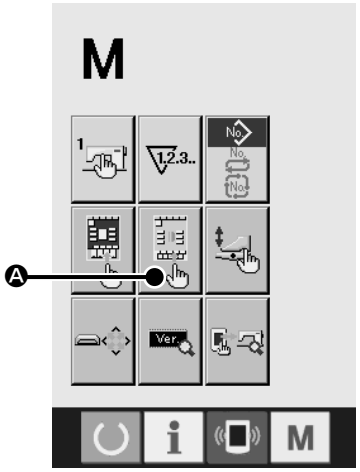
When ENTER button Ⓞ is pressed, register to the customizing button ends, and the screen returns to the customizing screen of the input screen. The registered sewing data is displayed on CUSTOMIZING button Ⓜ.

The data below have been registered in order from the left at the time of your purchase.

a.	S040	Lockstitch pitchy
b.	S041	Condensation/back tack at sewing start selection
c.	S054	Condensation/back tack at sewing end selection
d.	S075	Dart stretcher stop/motion change-over

13. PERFORMING THE CUSTOMIZING SETTING OF THE SEWING SCREEN

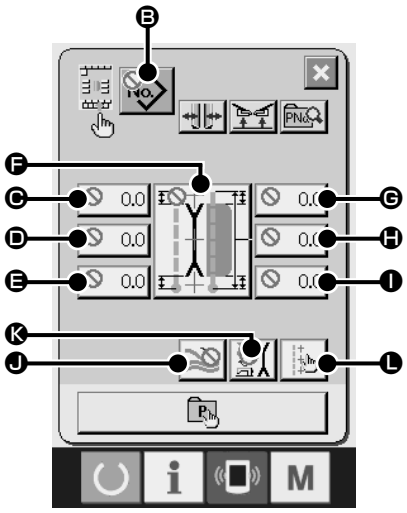
Buttons displayed in the data input screen can be customized in accordance with the customers' using conditions.



① **Display the customizing screen of the sewing screen**

Keep pressing MODE CHANGEOVER key M for three seconds and SEWING SCREEN CUSTOMIZING button Ⓐ is displayed on the screen.

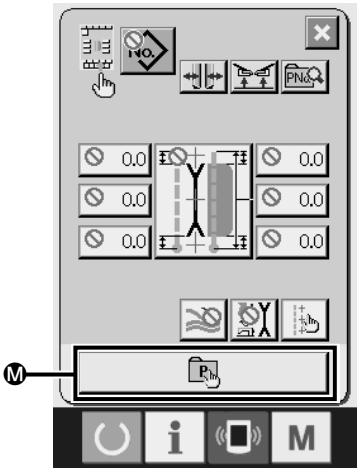
Press this button and the customizing screen of sewing screen is displayed.



② **Set the conditions of buttons**

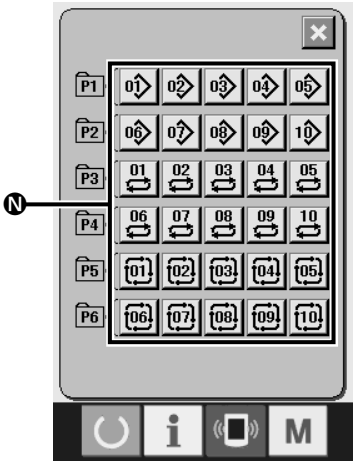
Every time the buttons from Ⓑ to Ⓛ are pressed, button display/non display can be changed over. Customize and use the buttons in accordance with the customers' using conditions.

Symbol	Display	Non display	Description	Initial state
Ⓑ			Pattern list button	
Ⓒ	0.0	0.0	Flap concealed stitching data (Left sewing start)	0.0
Ⓓ			Center knife motion position setting	
Ⓔ	0.0	0.0	Flap concealed stitching data (Left sewing end)	0.0
Ⓕ			Sewing mode change-over	
Ⓖ	0.0	0.0	Corner knife motion position at sewing start	0.0
Ⓗ	0.0	0.0	L size setting	0.0
Ⓘ	0.0	0.0	Corner knife motion position at sewing end	0.0
Ⓙ			Stacker stop/motion change-over	
Ⓚ			Motion mode change-over	
Ⓛ			Marking light setting	



③ **Register the direct pattern.**

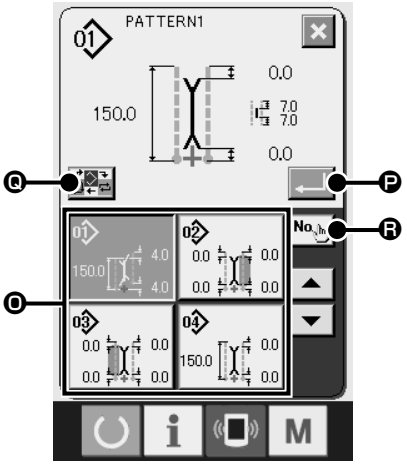
When DIRECT PATTERN REGISTER button Ⓜ is pressed, the direct pattern register list screen (screen A) is displayed.



Direct pattern list screen (Screen A)

In the direct pattern list screen, the pattern data of independent sewing/alternate sewing/cycle sewing can be freely registered up to 30.

Register and use the pattern data that are frequently used. Press PATTERN LIST button Ⓝ and the direct pattern selection screen (screen B) is displayed.



Direct pattern selection screen (Screen B)

Select the pattern you desire to register with PATTERN SELECTION button Ⓞ.

In addition, the ten keys are displayed by pressing NO. INPUT button Ⓡ and the pattern you desire to register can be selected by inputting the ten keys.

When the selected button is pressed again, the selection is released.

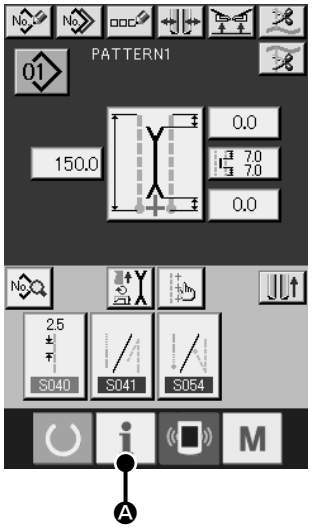
When ENTER button Ⓟ is pressed, register to the direct button is completed and the screen returns to the direct pattern list screen (screen A).

When MODE CHANGEOVER button Ⓠ is pressed, the sewing mode is changed over to independent sewing → alternate sewing → cycle sewing.

The direct buttons have not been registered at the time of your purchase.

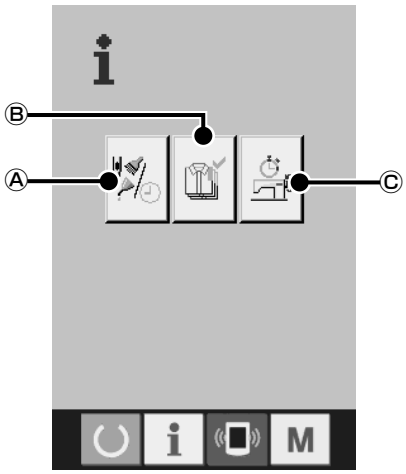
14. USING THE INFORMATION

There are three functions below, in the information function.



① **Display the information screen**

Press INFORMATION key Ⓐ of the switch seat section in the input screen and the information screen (screen A) is displayed.



Information screen (screen A)

Ⓐ **Maintenance inspection information**

Oil replacement (grease-up) time, needle replacement time, cleaning time, etc. are specified, and when the specified time has passed, the warning notice can be performed.

See **"VI-14.(1) Observing the maintenance inspection information" p. 78**.

Ⓑ **Production control information**

By means of function to display target production and actual production, the target achieving consciousness of a line or a group is enhanced and also the progress can be confirmed in one glance.

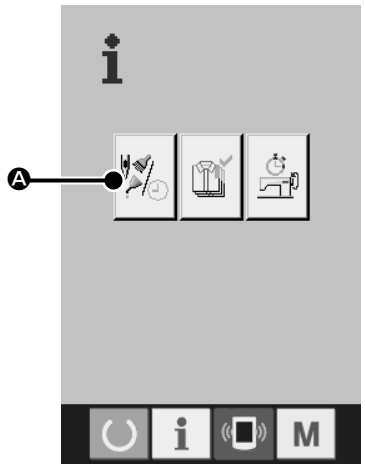
See **"VI-14.(3) Observing the production control information" p. 80** and **"VI-14.(4) Performing setting of the production control information" p. 82**.

Ⓒ **Operation measurement information**

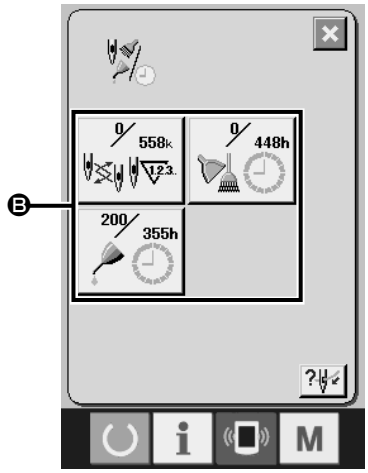
Information on machine operating situation, machine operating rate, pitch time, machine time, and machine speed can be displayed.

See **"VI-14.(5) Observing the operation measurement information" p. 84**.

(1) Observing the maintenance inspection information

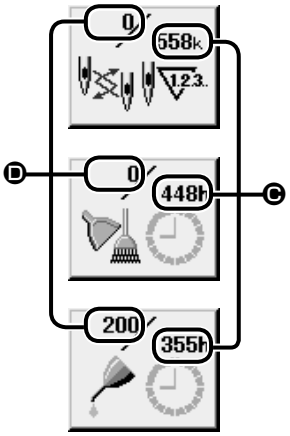


① **Display the maintenance information screen**
Press MAINTENANCE INSPECTION INFORMATION SCREEN DISPLAY button Ⓐ of the information screen.

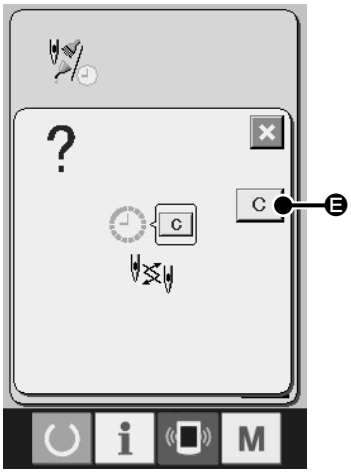


Three items of the information below are displayed in the maintenance inspection information screen.

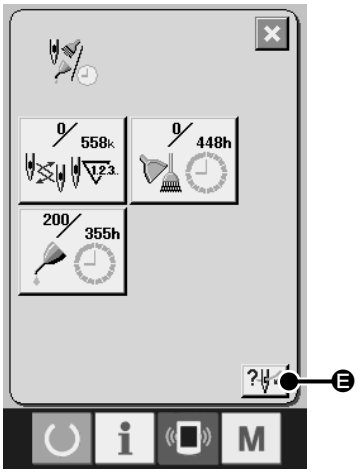
- Needle replacement (1,000 stitches) :
- Cleaning time (hour) :
- Oil replacement time (hour) :



Interval Ⓒ to inform the inspection and remaining time Ⓓ up to replacement are displayed in the respective item buttons Ⓑ.
Also, the remaining time up to the replacement can be cleared.



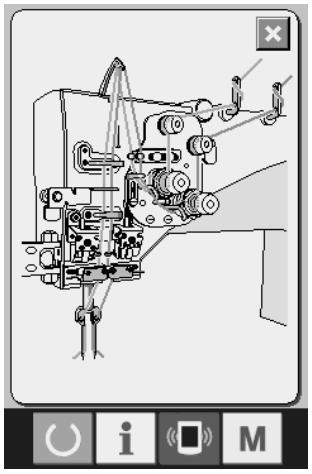
② **Perform CLEAR of the remaining time up to the replacement**
Press ITEM button Ⓑ you desire to clear and the replacement time clear screen is displayed.
Press CLEAR button C Ⓔ, and the remaining time up to the replacement is cleared.



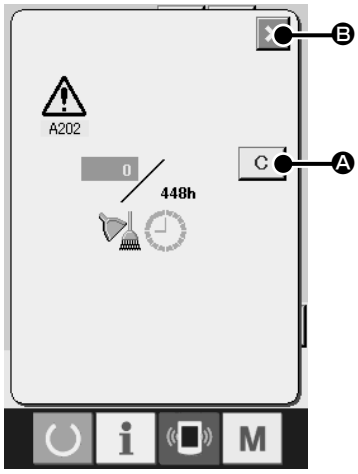
③ **Display the threading diagram**

Press THREADING button Ⓔ displayed in the maintenance inspection information screen and the needle thread threading screen is displayed.

See when performing threading.



(2) Releasing procedure of the warning



When the specified inspection time is reached, the warning screen is displayed. In case of clearing the inspection time, press CLEAR button C Ⓐ. The inspection time is cleared and the pop-up is closed. If not, press CANCEL button Ⓑ and close the pop-up. Every time one sewing is completed, the warning screen is displayed until the inspection time is cleared.

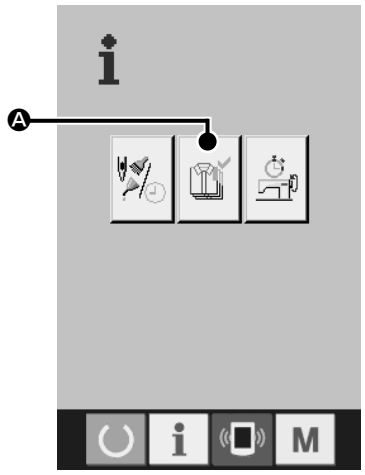
Warning Nos. of the respective items are as follows.

- Needle replacement : A201
- Cleaning time : A202
- Oil replacement time : A203

(3) Observing the production control information

It is possible to designate the start, display the number of pieces of production from the start to the existing time, display the number of pieces of production target, etc. in the production control screen. There are two kinds of display ways for the production control screen.

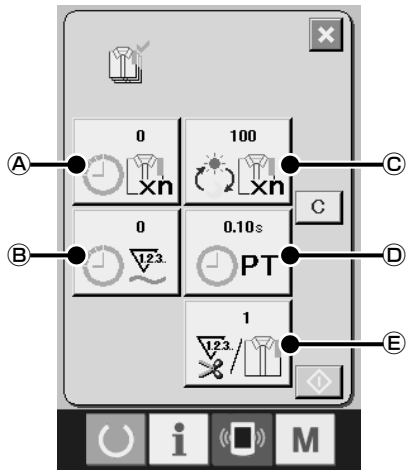
[In case of displaying from the information screen]



① **Display the production control screen**

Press PRODUCTION CONTROL SCREEN DISPLAY button

Ⓐ in the information screen. The production control screen is displayed.



The production control screen is displayed.

Ⓐ : Existing target value
Number of pieces of the target of sewn products at the present time is automatically displayed.

Ⓑ : Actual results value
Number of pieces of the sewn products is automatically displayed.

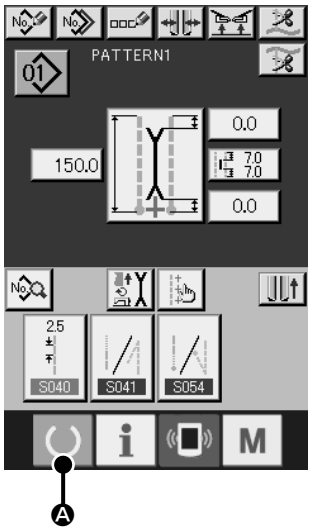
Ⓒ : Final target value
Number of pieces of the final target of sewn products is displayed.

Ⓓ : Pitch time
Time (second) required for one process is displayed.

Ⓔ : Number of times of thread trimming
Number of times of thread trimming per process is displayed.

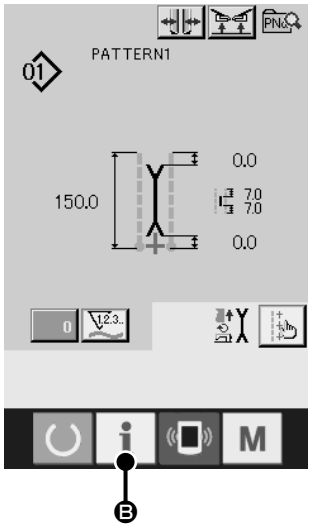
Refer to "VI-14.(4) Performing setting of the production control information" p. 82, and input Ⓒ number of pieces, Ⓓ time (unit : second) and Ⓔ number of times.

[In case of displaying from the sewing screen]



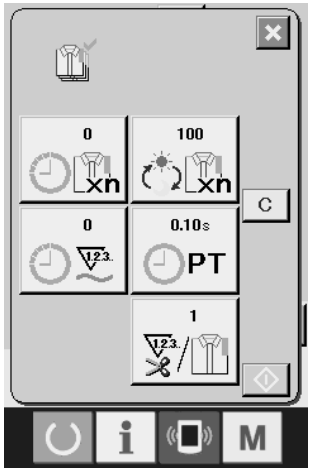
① **Display the sewing screen**

Press READY key Ⓐ in the input screen and the sewing screen is displayed.



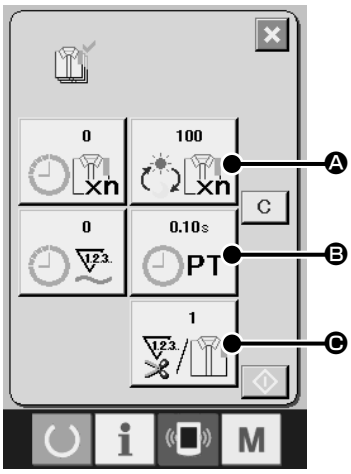
② **Display the production control screen**

Press INFORMATION key Ⓑ in the sewing screen and the production control screen is displayed.

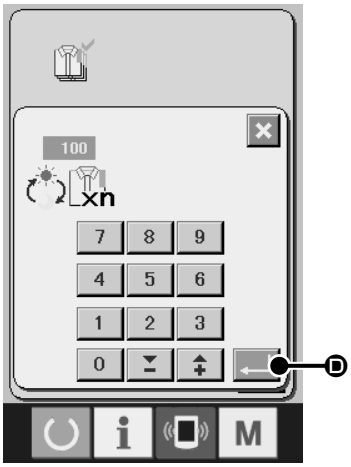


The contents of display and the functions are common to “In case of displaying from the information screen”.

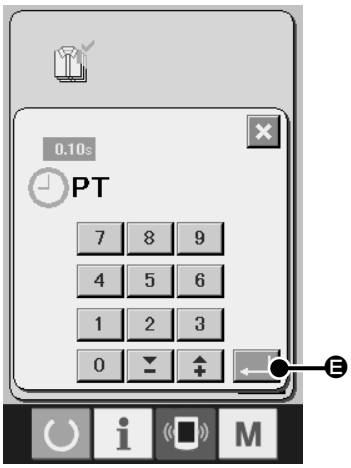
(4) Performing setting of the production control information



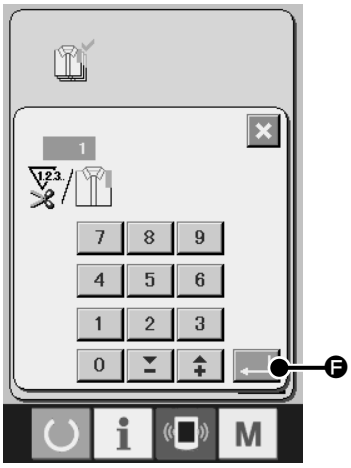
① **Display the production control screen**
Refer to **"VI-14.(3) Observing the production control information" p. 80** and display the production control screen.



② **Input the final target value**
First, input the number of pieces of the target of production in the process to which sewing is performed from now on.
When FINAL TARGET VALUE button Ⓐ of item ① is pressed, the final target value input screen is displayed.
Input the value you desire with ten keys or UP/DOWN buttons.
After the input, press ENTER button Ⓓ.

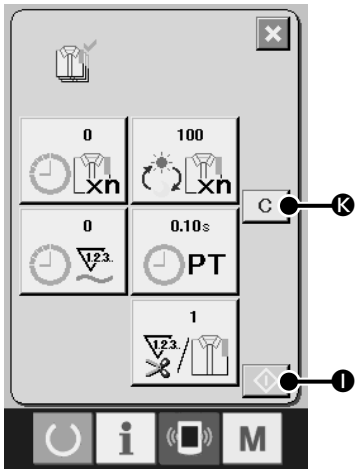


③ **Input the pitch time**
Next, input the pitch time required for one process.
When PITCH TIME button Ⓑ of item ① is pressed, the pitch time input screen is displayed.
Input the value you desire with ten keys or UP/DOWN buttons.
After the input, press ENTER button Ⓔ.



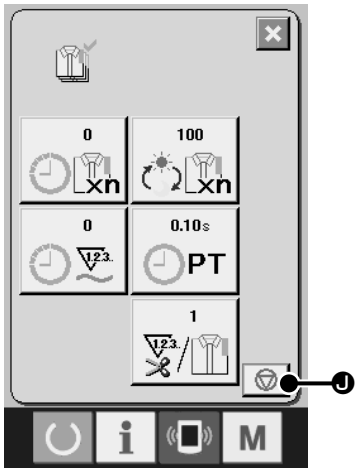
④ **Input the number of times of thread trimming**
Next, input the number of times of thread trimming per process.
When NUMBER OF TIMES OF THREAD TRIMMING button Ⓒ of item ① is pressed, the number of times of thread trimming input screen is displayed.
Input the value you desire with ten keys or UP/DOWN buttons.
After the input, press ENTER button Ⓕ.

* When the input value is “0”, count of the number of times of thread trimming is not performed. Use this function by connecting the external switch.



⑤ **Start the count of number of pieces of production**

Press START button ❶ and the count of number of pieces of production is started.

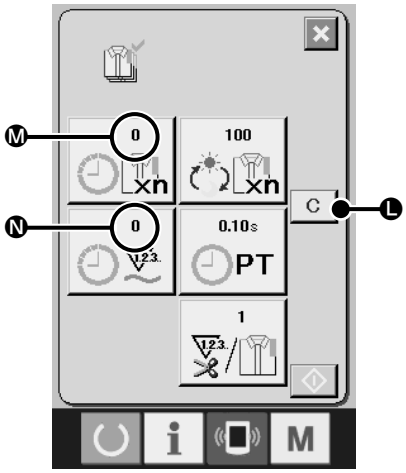


⑥ **Stop the count**

Display the production control screen referring to **"VI-14.(3) Observing the production control information" p. 80**.

When the count is being performed, STOP button ❷ is displayed. When STOP button ❷ is pressed, the count is stopped.

After the stop, START button ❶ is displayed at the position of STOP button. When continuing the count, press START button ❶ again. The counted value is not cleared until CLEAR button C ❹ is pressed.

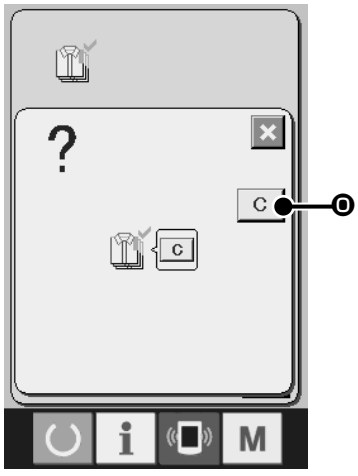


⑦ **Clear the counted value**

When clearing the counted value, set the count to the stop state and press CLEAR button C ❸.

The value to be cleared is the present target value ❼ and actual results value ❽.

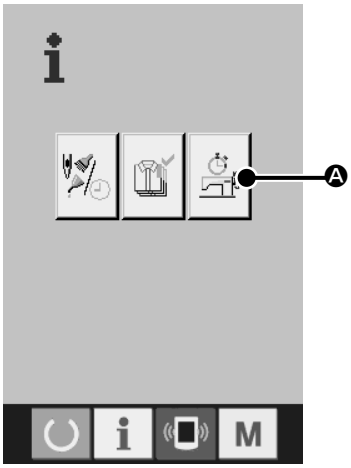
* CLEAR button is displayed only in case of stop state.



When CLEAR button C ❸ is pressed, the clear confirmation screen is displayed.

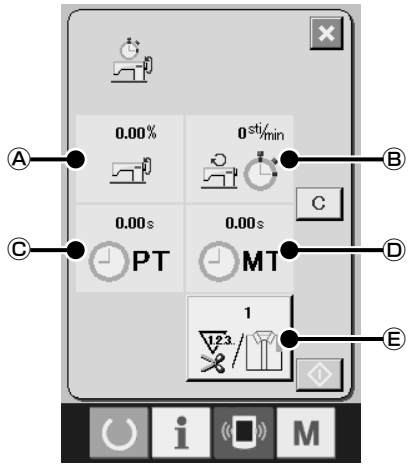
When CLEAR button C ❺ is pressed in the clear confirmation screen, the counted value is cleared.

(5) Observing the operation measurement information



① **Display the operation measurement screen**

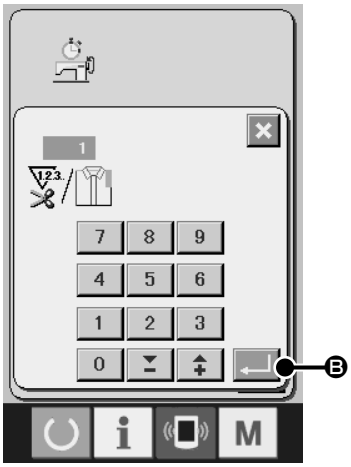
Press OPERATION MEASUREMENT SCREEN DISPLAY button Ⓐ in the information screen. The operation measurement screen (screen A) is displayed.



Operation measurement screen (Screen A)

Information on the following 5 items is displayed in the operation measurement screen.

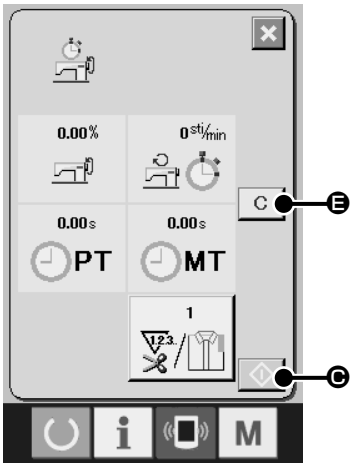
Ⓐ : This item automatically displays the operation rate from the time of starting the measurement.
Ⓑ : This item automatically displays the mean machine speed from the time of starting the measurement.
Ⓒ : This item automatically displays the mean pitch time from the time of starting the measurement.
Ⓓ : This item automatically displays the mean machine time from the time of starting the measurement.
Ⓔ : This item displays the number of times of thread trimming per process.
Input the number of times referring to item ② below.



② **Input the number of times of thread trimming**

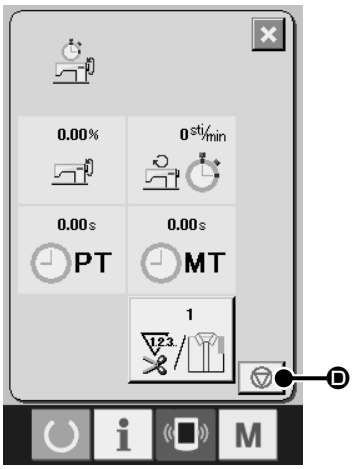
Next, input the number of times of thread trimming per process.
Press NUMBER OF TIMES OF THREAD TRIMMING button Ⓔ and the number of times of thread trimming input screen is displayed.
Input the value you desire with ten keys or UP/DOWN buttons.
After the input, press ENTER button Ⓑ.

* When the input value is “0”, count of the number of times of thread trimming is not performed. Use this function by connecting the external switch.



③ **Start the measurement**

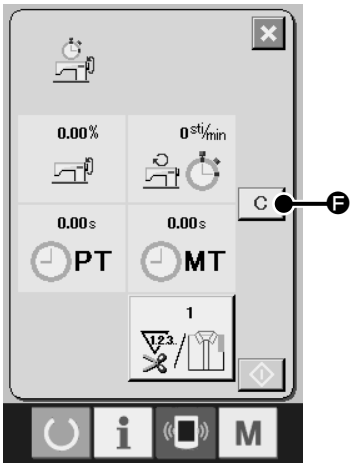
Press START button [◇] ⓒ, and the measurement of each data is started.



④ **Stop the count**

Display the operation measurement screen referring to Items ① and ② of **"VI-14.(5) Observing the operation measurement information" p. 84**.

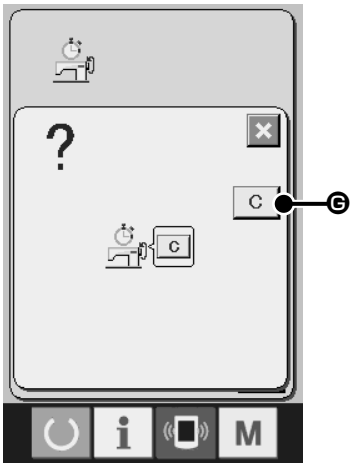
When the measurement is being performed, STOP button [▽] ⓓ is displayed. When STOP button [▽] ⓓ is pressed, the measurement is stopped. [◇] ⓒ is displayed at the position of STOP button. In case of continuing the measurement, press again START button [◇] ⓒ. The measured value is not cleared until CLEAR button [C] ⓔ is pressed.



⑤ **Clear the counted value**

When clearing the counted value, set the count to the stop state and press CLEAR button [C] ⓕ.

* CLEAR button is displayed only in case of stop state.



When CLEAR button [C] ⓕ is pressed, the clear confirmation screen is displayed.

When CLEAR button [C] ⓖ is pressed in the clear confirmation screen, the counted value is cleared.

15. USING THE COMMUNICATION FUNCTION

Communication function can download the sewing data created with other sewing machine . In addition, the function can upload the aforementioned data to the media or personal computer.
As the means of communication, a media slot and USB are prepared.

(1) Handling possible data

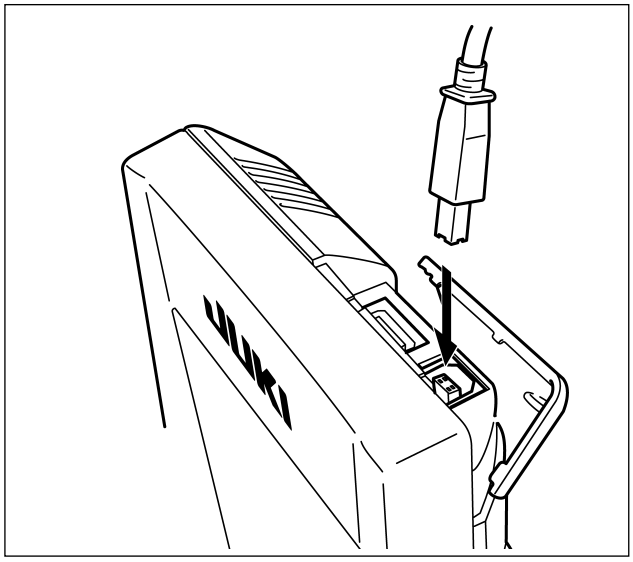
Data name		Extension	Description of data
Sewing data		APW ××× .EPD	Sewing data created by the sewing machine exclusive for APW

××× : File No.

(2) Performing communication by using the media

For handling way of the media, read **"VI-1. PREFACE" p. 22**.

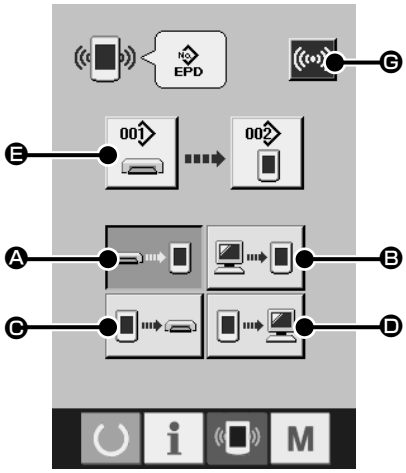
(3) Performing communication by using USB



Data can be sent/received to/from a personal computer or the like, by means of a USB cable.

If the contact part becomes dirty, failure of contact will be caused. Do not touch by hand, and control so that dust, oil or other foreign material does not adhere to it. In addition, the inside element is damaged by static electricity or the like. So, be very careful when handling.

(4) Take-in of the data



Communication screen (screen A)

① **Display the communication screen**

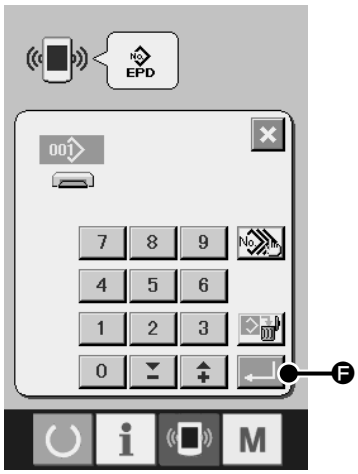
When COMMUNICATION key of switch seat section is pressed in the input screen, the communication screen (screen A) is displayed.

② **Select the communication procedure**

There are four communication procedures as described below.

Ⓐ Writing data from media to panel
Ⓑ Writing data from personal computer (server) to panel
Ⓒ Writing data from panel to media
Ⓓ Writing data from panel to personal computer (server)

Select the button of communication procedure you desire.



③ **Select the data No.**

When Ⓔ is pressed, the writing file selection screen is displayed.

Input the file No. of the data you desire to write. For the file No., input APW×××. of the file name and the numerals of the part ××× of EPD. Designation of the pattern No. of writing destination can be performed in the same way. When the writing destination is the panel, pattern Nos. which have not been registered are displayed.

④ **Determine the data No.**

When ENTER button Ⓕ is pressed, the data No. selection screen is closed and the screen returns to the communication screen (screen A).

⑤ **Start communication**

When COMMUNICATION START button Ⓖ is pressed, the data communication starts.

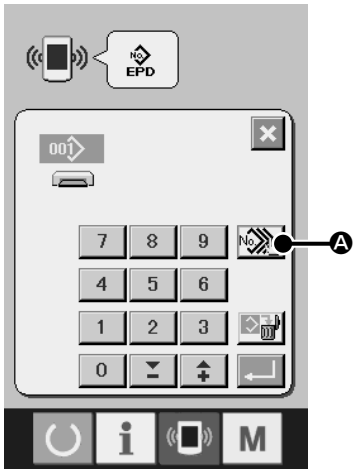
The during communication is displayed during communication and the screen returns to the communication screen after the end of communication.

Do not open the cover during reading the data. Data may not be read in.

(5) Take-in of plural data together

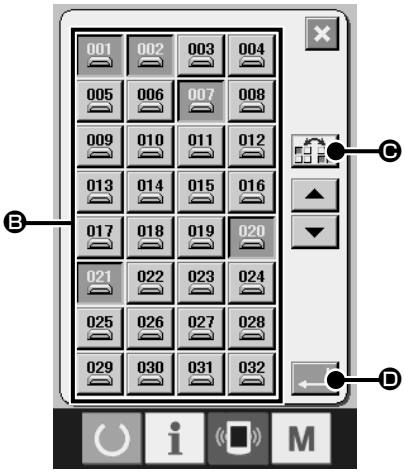
It is possible for the sewing data to select plural data to be written and write all together. Pattern No. of writing destination is the same No. of the selected data No.

No.99 and after of the media cannot perform the plural selection.



① **Display the writing file selection screen**

Press PLURAL SELECTION button Ⓐ and the data No. plural selection screen is displayed.

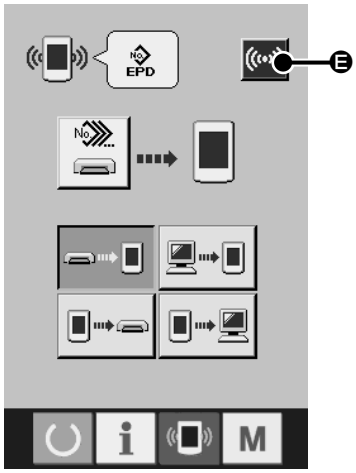


② **Perform the selection of data No.**

List of the file No. of the existing data is displayed. Press FILE No. buttons Ⓑ you desire to write. It is possible to reverse the selection state of the button with REVERSE button Ⓒ.

③ **Determine the data No.**

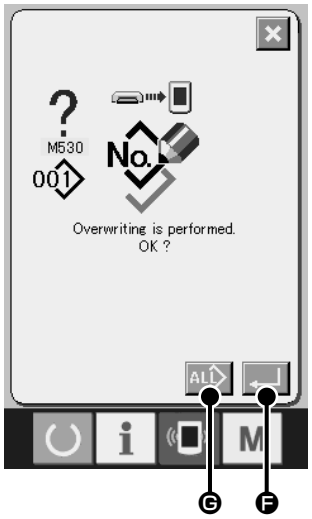
When ENTER button Ⓓ is pressed, the data No. plural selection screen is closed and the selection of data ends.



④ **Start the communication**

Press COMMUNICATION START button Ⓔ and the data communication starts.

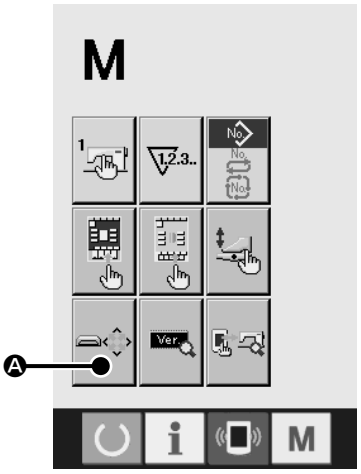
Data No. during communication, total number of writing data and number of data that have finished the data communication are displayed in the during communication screen.



* When performing writing to the pattern No. that already exists, the overwriting confirmation screen is displayed before writing. When performing overwriting, press ENTER button Ⓕ.
When performing overwriting to all without displaying the overwriting confirmation screen, press OVERWRITING button Ⓖ in all cases.

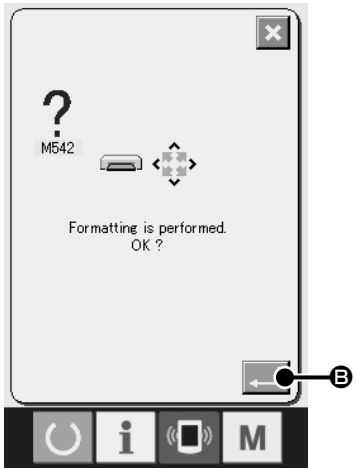
16. PERFORMING FORMATTING OF THE MEDIA

When re-formatting the media, be sure to perform it with IP-420. The media that have been formatted with the personal computer cannot be read with IP-420.



① **Display the media format screen**

Keep pressing MODE CHANGEOVER key M for three seconds and MEDIA FORMAT button Ⓐ is displayed on the screen. When this button is pressed, the media format screen is displayed.



② **Start formatting of the media**

Set the media you desire to format to the media slot, press ENTER button Ⓑ after closing the cover and formatting starts. Store the necessary data in the media to other media before formatting. When formatting is performed, the inside data are erased.

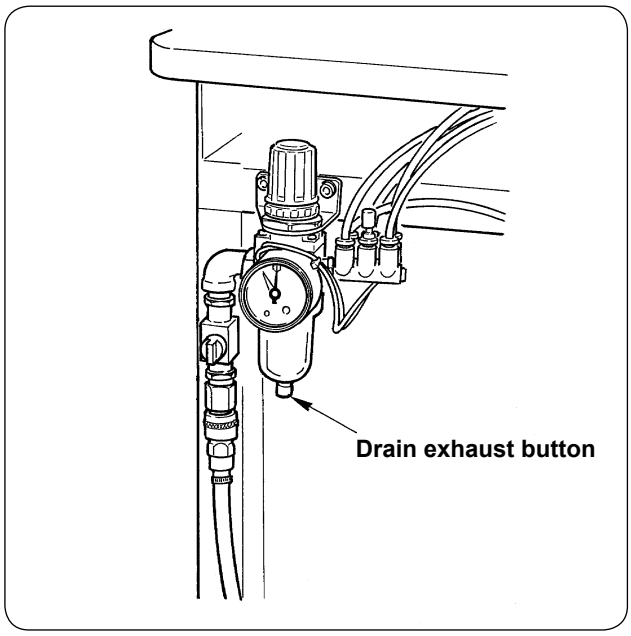
VII. MAINTENANCE

1. INSPECTION

Be sure to periodically execute the maintenance and inspection to keep the performance of this machine.
Be sure to periodically execute the work since machine trouble may be caused unless the maintenance and inspection are performed.

(1) Maintenance and inspection of the pneumatic device

CAUTION :
To prevent accidents caused by abrupt start of the sewing machine, do not place hand(s), foot, face or tools on the machine moving part.



- Discharge the drain of filter every day.
  Press the drain exhaust button located at the bottom of filter to exhaust the drain.

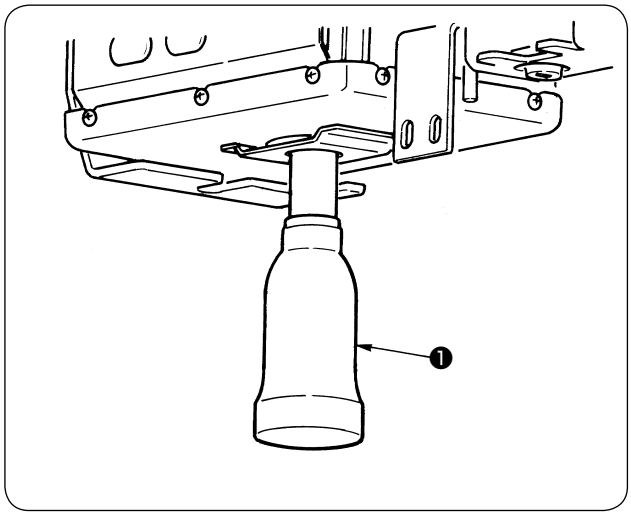
(2) Maintenance and inspection related to the sewing machine

CAUTION :
To prevent accidents caused by abrupt start of the sewing machine, start the work after turning OFF the power.

- When dust adheres to the small places of the machine such as clamp foot or the like, normal operation is disturbed. Be sure to perform cleaning before the work. In addition, be sure to clean the thread waste in the hook cover once a week.
- Check the sharpness of center knife and corner knife before the work, and try to replace it in good time.
- For the lubrication of the sewing machine, be sure to use the designated oil JUKI MACHINE OIL No. 1 (MDFRX1600C0).
- Periodically replace the thread guide felt. (Refer to **"V-1.(3) How to pass the needle thread" p. 14**).

(3) With regard to the waste oil of the hook oil

CAUTION :
To prevent accidents caused by abrupt start of the sewing machine, start the work after turning OFF the power.

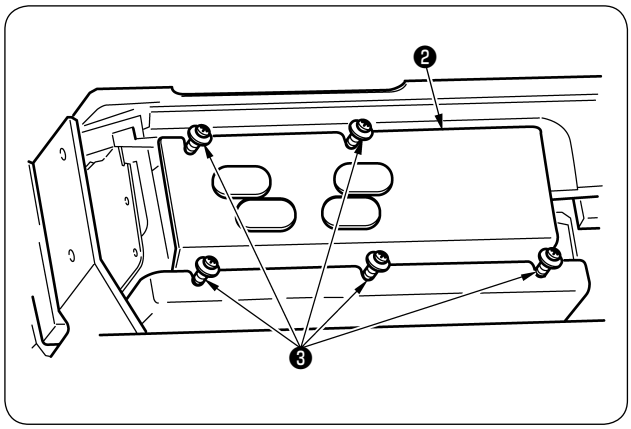


Turn and remove the oil can, and drain the waste oil when the waste oil gathered in approximately half of oil can ❶ located on the machine bed cover.

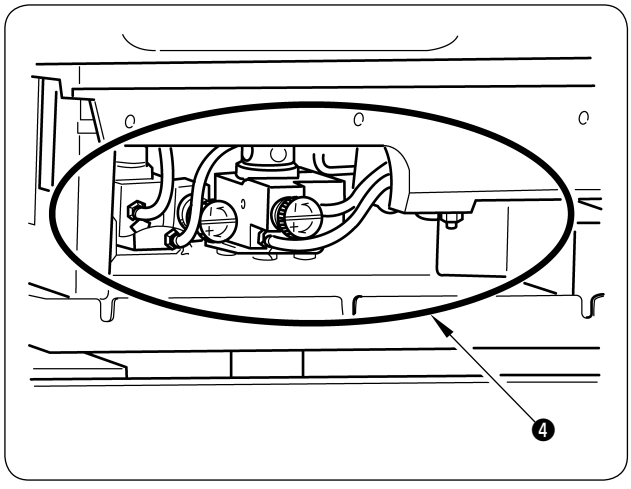
(4) With regard to the cleaning of the hook shaft base

CAUTION :
To prevent accidents caused by abrupt start of the sewing machine, start the work after turning OFF the power.

Periodically clean the waste cloth or the like gathered in the hook oil cover.



- Raise the machine head and remove oil cover ❷ after loosening setscrews ❸ (5 places).



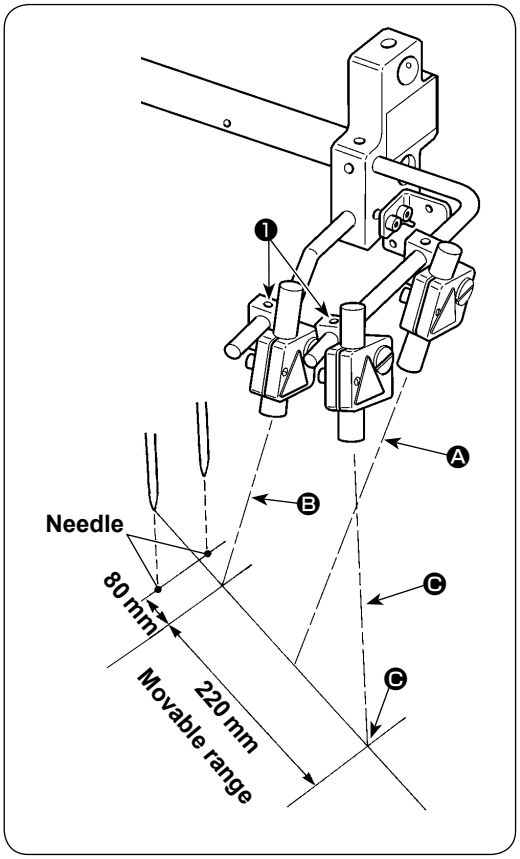
- Clean the inside of hook oil cover ❹ .

2. MARKING LIGHT

WARNING :
1. If the laser light directly enters the eye, eyesight trouble may be caused. Do not look into the laser inlet/outlet.
2. Never perform installing/removing of the marking lamp with the power turning ON. In addition, do not use the light other than marking.

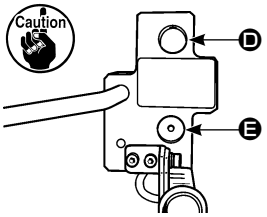
DANGER:
Use of controls or adjustments or performance of procedures other than those specified here in may result in hazardous radiation exposure.

(1) Fixed marking (standard)



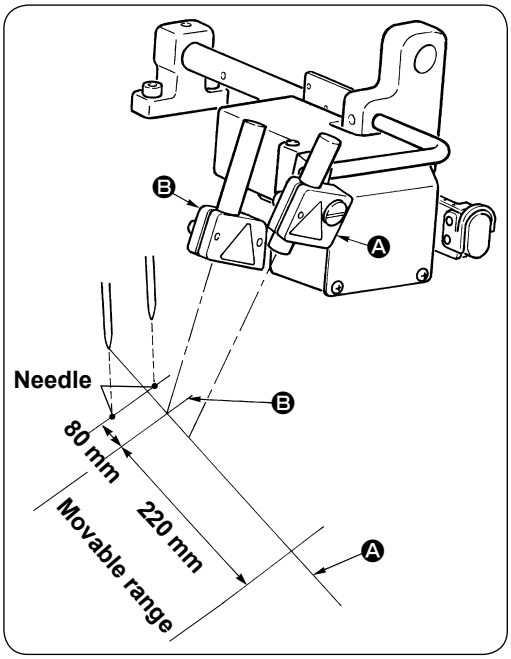
1) The light of marking light on the front side observed from the operator side is used for longitudinal line reference setting Ⓐ and that in the rear side is used for lateral line reference setting Ⓑ and Ⓒ.

2) Horizontal line irradiating position of the marking light is determined depending on the sewing specification. Loosen screws ❶ and adjust angles of marking lights Ⓑ and Ⓒ.

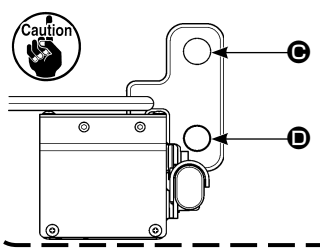


- **Use installing hole Ⓔ on the bottom side up to gauge size 8 to 16 mm. In case of 18 mm or more, use installing hole Ⓓ on the top side.**

(2) Movable marking (optional)

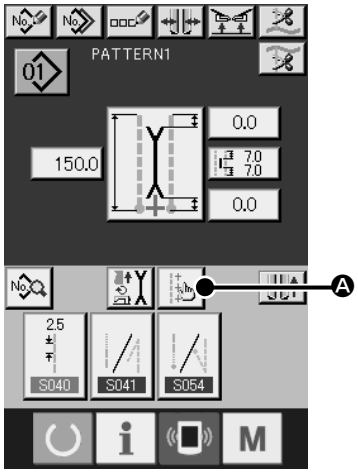


The light of marking light on the front side observed from the operator side is used for longitudinal line reference setting (fixed) Ⓐ and that in the rear side is used for lateral line reference setting (moving according to the sewing type) Ⓑ.



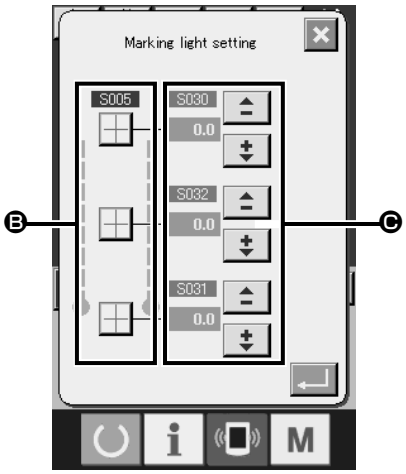
- **Use installing hole Ⓓ on the bottom side up to gauge size 8 to 16 mm. In case of 18 mm or more, use installing hole Ⓒ on the top side.**
- **After changing the top or the bottom installing position, be sure to perform the adjustment of marking light motor origin.**

(3) Adjusting the marking light irradiation position



1) Press button Ⓐ in the input screen and the marking light setting screen is displayed. Then the irradiation position of marking light can be adjusted.

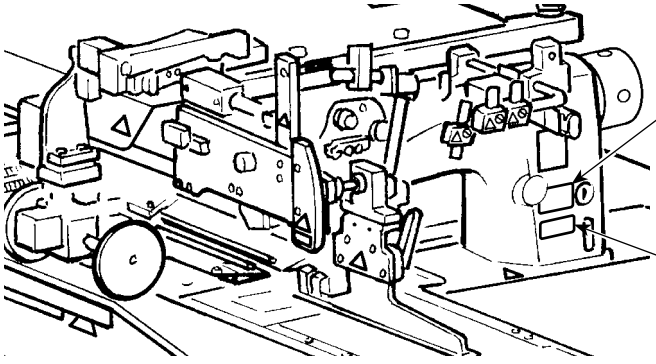
2) Lateral line irradiation position of marking light is determined by the sewing type, and the irradiation position is automatically moved by Ⓑ S005 change-over of sewing start irradiation/sewing end irradiation/center irradiation" and " S004 L size setting". When the compensation value of Ⓒ is 0.0 mm, the marking light irradiates the sewing position.



3) When you desire to move the marking light irradiation position in terms of the sewing position, set each compensation value of Ⓒ for use.

S030 : Sewing start irradiation position compensation
S031 : Sewing end irradiation position compensation
S032 : Center irradiation position compensation

Laser specifications	
Lateral line reference laser	Longitudinal line reference laser
Class 2 laser product	Class 2M laser product
Maximum output : 1.0mW	Maximum output : 3.5mW
Wave length : 650nm	Wave length : 650nm
Safety standard	
JIS C 6802 : 2014	
IEC 60825-1 : 2014 Ed.3	



Laser specification label
Safety class of the laser equipment is indicated on this label.
Indicated safety class: 2M

Laser specification label
Complies with 21 CFR 1040.10 and 1040.11 except for conformance with IEC 60825-1 Ed. 3., as described in Laser Notice No. 56, dated May 8, 2019.

3. REPLENISHING GREASE TO THE DESIGNATED PLACE

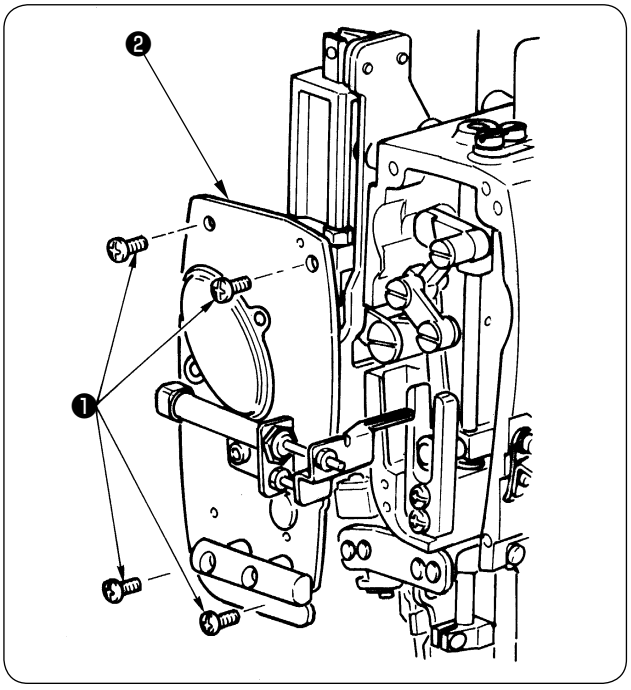
* When “Grease-up warning E220” or “Grease-up error E221” is displayed, or when the machine has been used for one year, be sure to perform replenishing of grease.

When turning ON the power after the sewing machine has operated up to 40 million stitches, “grease-up warning E220” informing of the time of grease replenishment is displayed on the panel. When pressing RESET button [//] to leave the error screen, the machine can continue operating. However, the error has not been released and the error is displayed every time the power is turned ON. After performing replenishment of grease which is explained later, call “Memory switch U245 ” and set the number of stitches of operation to “0” with CLEAR button [C] .

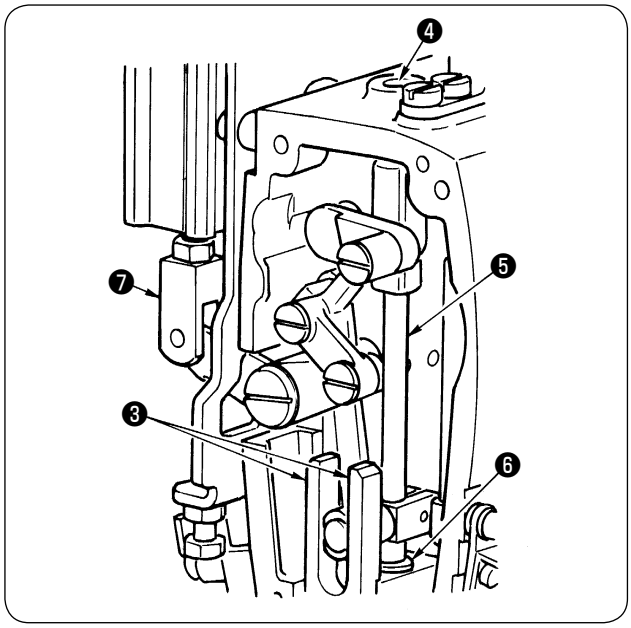
When the machine has been continuously used up to 48 million stitches, “grease-up error E221” is displayed on the panel. In this case, even when RESET button [//] is pressed and the error screen is released, the sewing after that cannot be performed. Be sure to call “Memory switch U245 ” and set the number of stitches of to “0” with CLEAR button [C] after performing replenishment of grease which is explained later.

1. **“Grease-up warning E220” and “Grease-up error E221” are displayed again unless memory switch U245 is cleared to “0” after replenishing grease.**
2. **Be sure to use the grease tube (Part No. : 40006323) supplied with the machine as accessories for replenishing grease to the designated place which is explained later. If any grease other than the designated one is replenished, Component breakage will be caused.**
3. **Keep the used grease tube in a safe place.**

CAUTION :
To prevent accidents caused by abrupt start of the sewing machine, start the work after turning OFF the power.

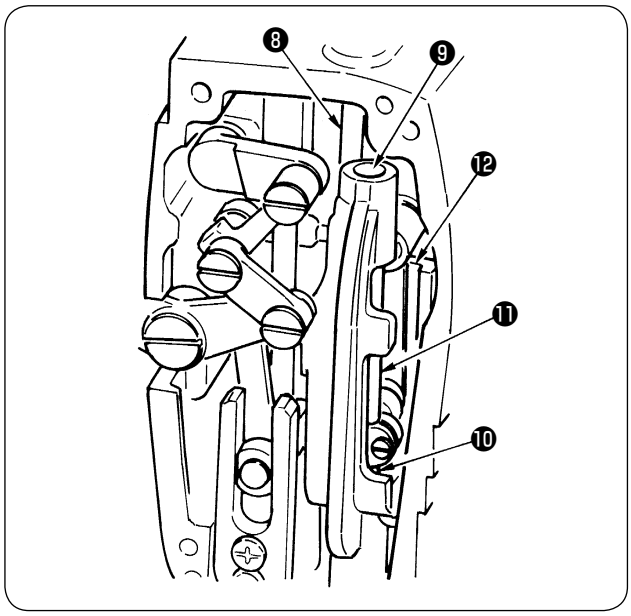


① Remove four setscrews ❶ and take out face plate ❷ .



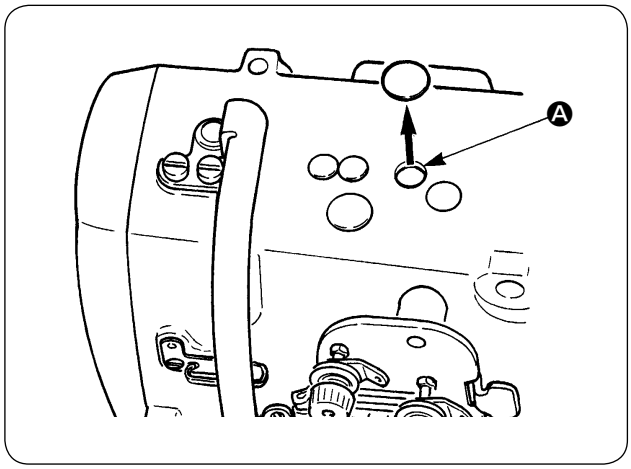
② Replenishment of grease to the center knife section

- Apply grease to both planes of guides ❸ , knife bar metal, upper ❹ , and knife bar metal, lower ❻ .
- Knife bar ❺ moves up and down by moving cylinder joint ❼ up and down in the state that air is not supplied. Apply grease to the metal so as to infiltrate the inside.



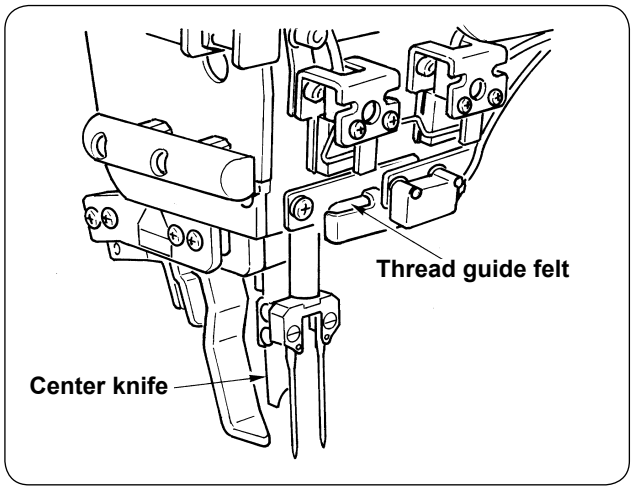
③ Replenishment of grease to the needle bar section

Apply grease to thread take-up lever ❽ , needle bar upper section ❾ , needle bar lower section ❿ , needle bar ⓫ and needle bar ⓬ .



④ Remove the rubber cap and apply new grease to the inside of the hole after removing old grease adhered to the inside of hole Ⓐ. Then cover the hole with the rubber cap.

4. CONSUMABLE REPLACEMENT COMPONENTS

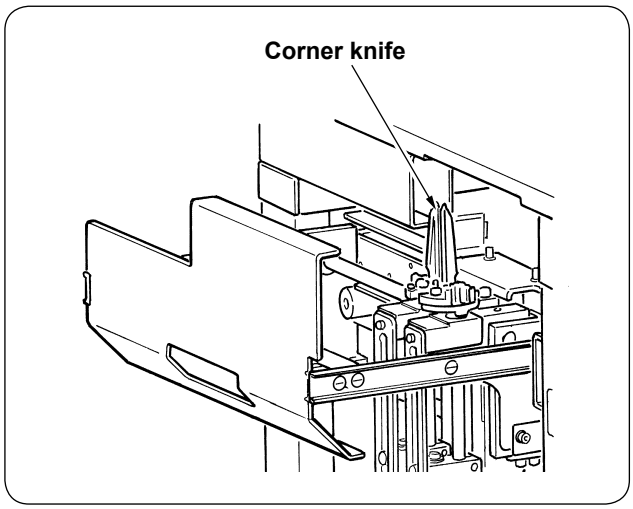


The components below are the consumable ones. Periodically replace them.

• Thread guide felt (Part No. : 40034444)

The part where thread passes is worn out and rough motion of thread is apt to occur unless it is periodically replaced.

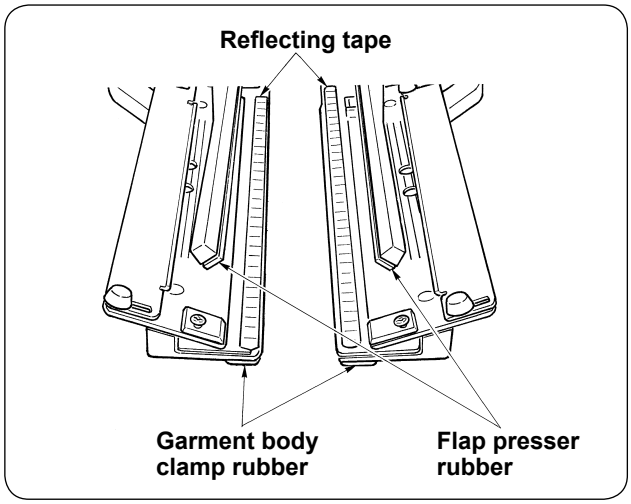
• Center knife (Part No. : 40026155)



• Corner knife

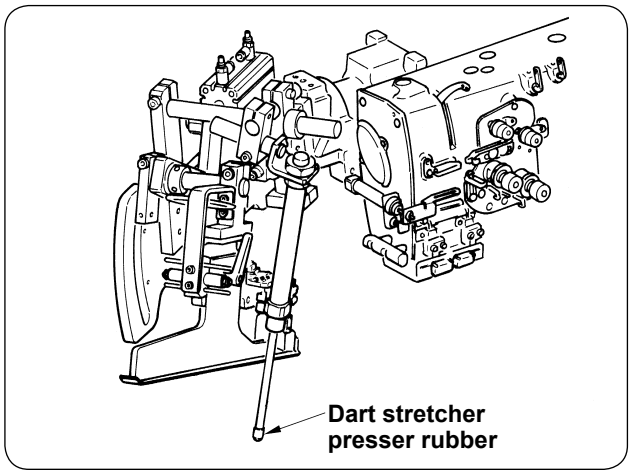
Gauge size	Part No.
8 to 14mm	16607301, 16607400
16 to 20mm	16607509, 16607608
22 to 26mm	16607707, 16607806
28 to 32mm	16607905, 16608002

Sharpness is deteriorated and sewing quality is influenced unless it is periodically replaced.



• Garment body clamp rubber

	Part No.
Standard	40034825
Long and wide type	40040827



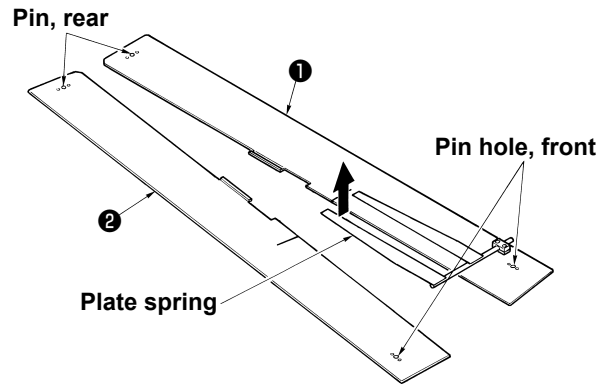
• Dart stretcher presser rubber
(Part No. : 40034733)

Pressing of material is deteriorated and sewing quality is influenced unless it is periodically replaced.

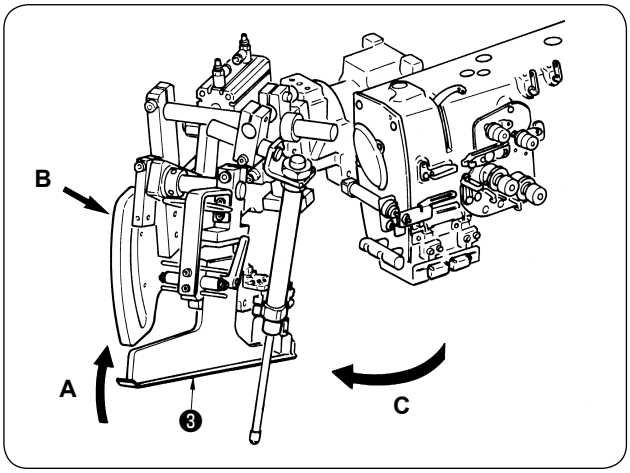
5. TILTING THE MACHINE

CAUTION :

- **Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**
- **When tilting/raising the machine, be careful not to allow your hands, fingers or any other part of your body to be caught in the related parts.**



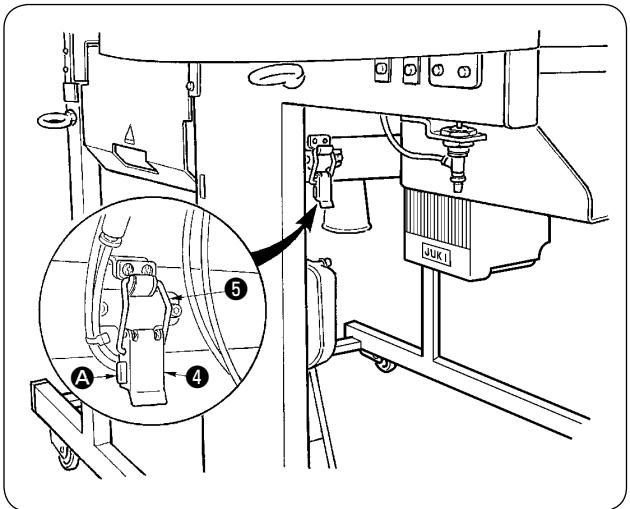
① Remove sewing tables ❶ and ❷ .



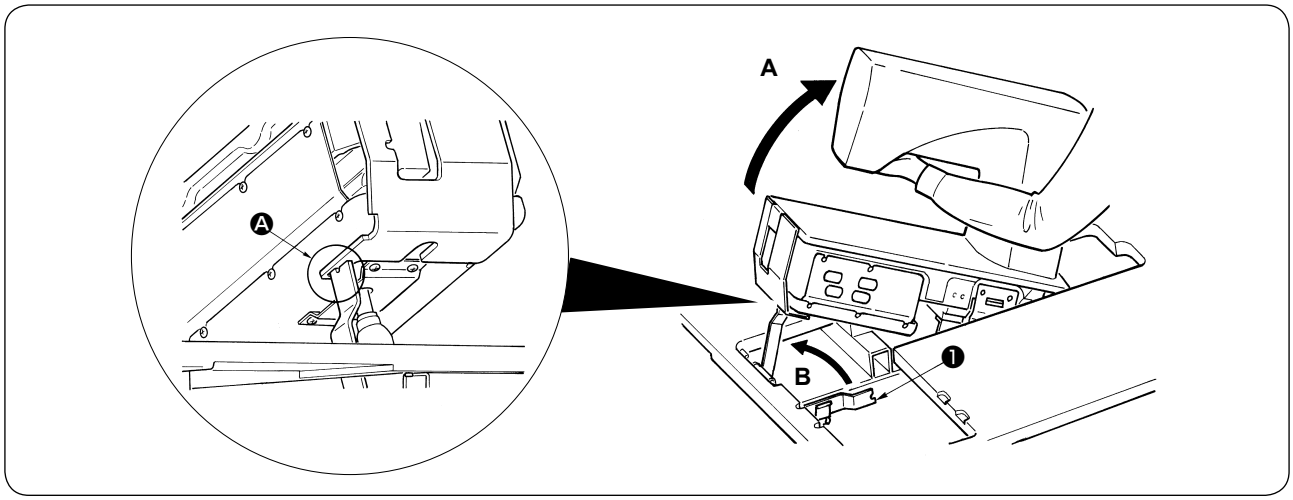
② Turn the binder unit.
Lift binder ❸ in the direction **A**, support section **B** by hand and turn the whole binder in the direction **C**.

Reference

Binder is locked with ball plunger. Turn it rather strongly in the direction of C to release the lock.



③ Release machine fixing hinge.
Pressing section Ⓐ, release machine fixing hinge ❹ , and remove hinge hook ❺ .



CAUTION :

1. **For turning the sewing machine head, be sure to perform with two persons or more.**
2. **To avoid personal injuries, when returning the machine head from the raised state to the home position, return it to the home position after confirming that there is no tool or component under the gas spring.**
3. **To avoid personal injuries and damage of sewing machine, do not damage with tools or parts the rod section of the gas spring located under the machine head.**
4. **To avoid personal injuries, immediately replace the gas spring with a new one when the rod section of gas spring does not function properly with a flaw or the like, or it is judged as a defective one. [Do not use anything other than JUKI genuine gas spring (Part No. : 40023177).]**
5. **To avoid personal injuries, do not use with the gas spring removed.**

④ Turn the sewing machine.

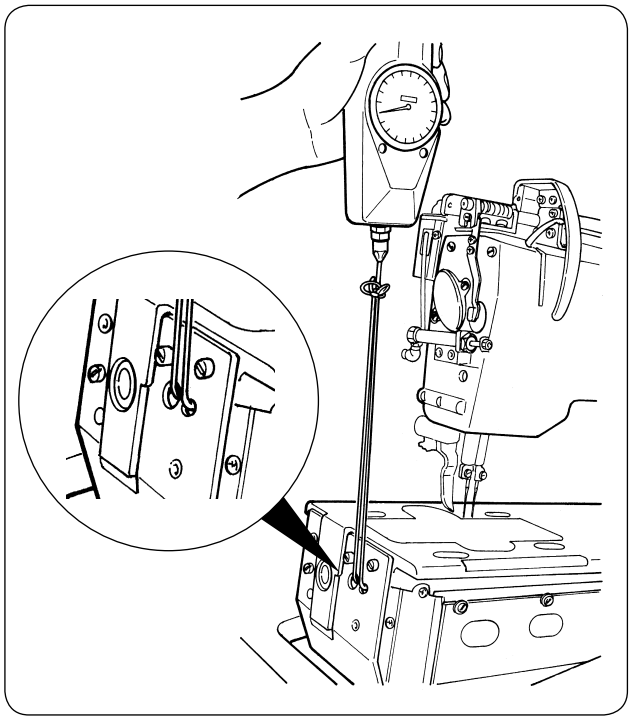
- Hold the bottom side of the machine arm and lift the whole sewing machine in the direction **A**.
- Lift the sewing machine fixing plate ❶ in the direction **B**, put the point of the sewing machine fixing plate ❶ to the hole of the machine bed, and fix the sewing machine. (Refer to Ⓐ.)

⑤ When returning the sewing machine, set the sewing machine by reversing the procedure.

6. STANDARD OF REPLACING TIME OF THE GAS SPRING

CAUTION :

- **Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**
- **When tilting/raising the machine, be careful not to allow your hands, fingers or any other part of your body to be caught in the related parts.**



Gas spring is one of the consumables. Gas inside the gas spring will be gone naturally even when the frequency of use is low and the spring cannot display the thrust to secure the safety.

In case a force of 130N or more is necessary when passing strings through the front end of machine bed and lifting the sewing machine as shown in the left-hand figure, quickly replace the spring with JUKI genuine gas spring (Part No. : 40023177).

Gas spring is a component that can be used with ease. However, there is a flaw on the rod section or a section that is weak in the side load when the gas spring is fully stretched. Be very careful when performing maintenance or cleaning of the sewing machine.

7. ADJUSTING THE CORNER KNIFE

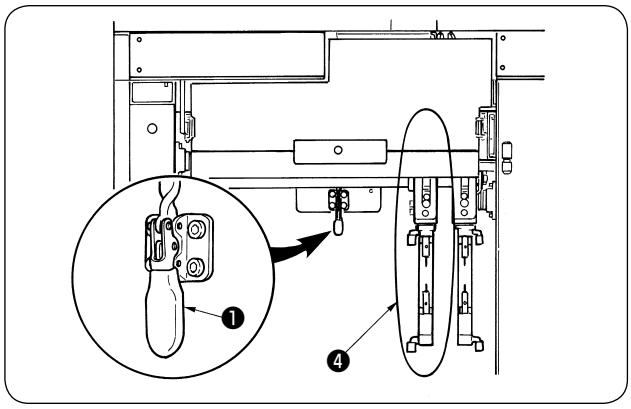
CAUTION :

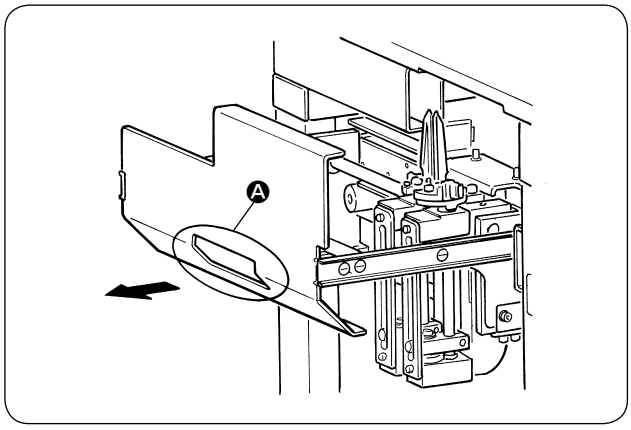
1. Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

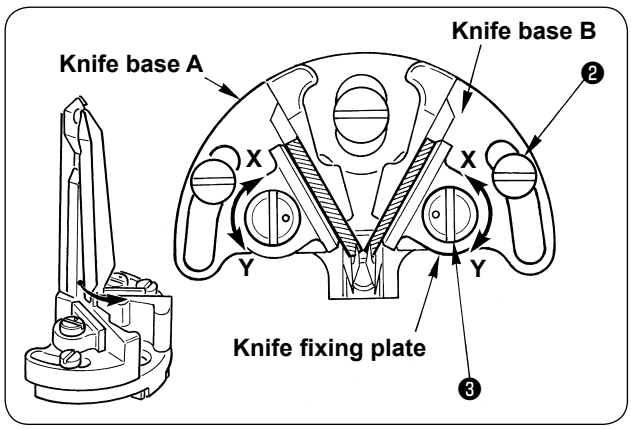
2. Do not touch your fingers or hands to the blade section of knife. so as to prevent fatal accidents.

3. Perform the adjustment work by the maintenance engineers who are familiar with the sewing machine and trained for the safety so as to prevent accidents caused by unfamiliarity or wrong adjustment.

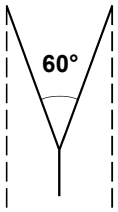
4. Be careful not to slip your hand since the adjustment work is performed with a screwdriver.







Reference **The angle of inclination of the corner knife of this model of machine has been factory-adjusted to approximately 60° at the time of delivery so that the blade tip of the knife does not easily come in contact with the rising part of the welting patch.**



① Release toggle clamp ❶ .

Caution **When drawing out the corner knives, move corner knife ❹ on the moving side to its initial position before releasing the toggle clamp. If the corner knives are drawn out while the corner knife on the moving side does not rest at its initial position, corner knife and the table can come in contact with each other, resulting in breakage of the corner knife.**

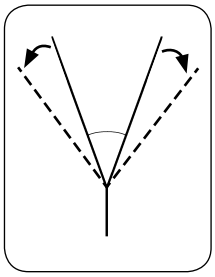
② Hold section Ⓐ and draw out the drawer in the direction of the arrow.

Reference **Draw it out. until it goes no further.**

③ Adjustment procedure

[Adjusting the open angle of knife]

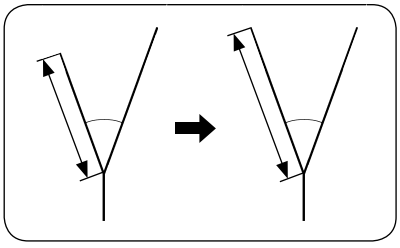
1) Loosen angle adjustment screws ❷ , adjust knife bases A and B, and fix the screws.



Reference **Direction of rotation to loosen left/right knives is different from each other.**

[Adjusting the cutting length of knife]

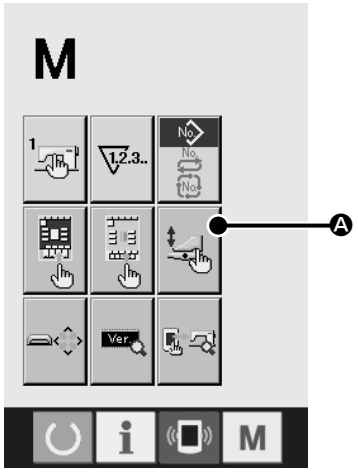
1) Turn eccentric pin ❸ in the direction of the arrow mark **Y** with a flat-blade screwdriver or the like and loosen the knife.
2) Tilt the knife and adjust the cutting length.
3) Turn eccentric pin ❸ in the direction of the arrow mark **X** with a flat-blade screwdriver or the like and fix the knife.



④ After the adjustment, return the drawer to its home position and fix it with toggle clamp ❶ .

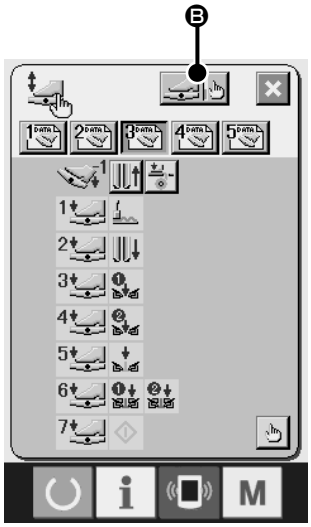
Caution **When returning the drawer, return corner knife on the moving side ❹ to the initial position.**

8. HOW TO ADJUST THE FOOT PEDAL

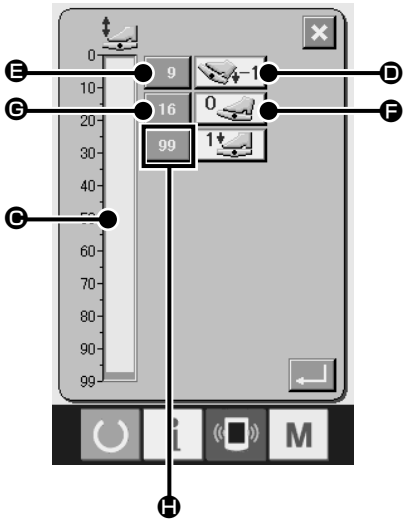


① **Display the pedal customizing screen**

Keep pressing MODE CHANGE-OVER key M for three seconds and PEDAL CUSTOMIZING button Ⓐ displayed on the screen changes the color from green to light blue.
Press this button and the pedal customizing screen of maintenance personnel level is displayed.

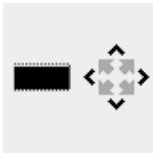
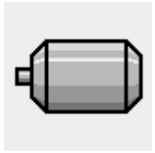
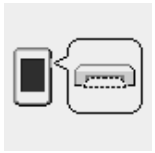
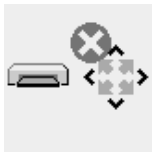


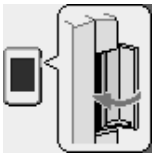
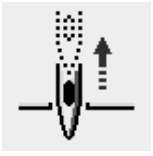
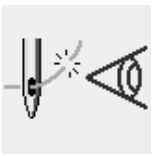
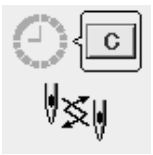
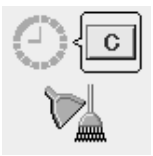
② When foot pedal adjustment button Ⓑ is pressed, the foot pedal adjustment screen is displayed. Set the value for the foot pedal operation on this screen.

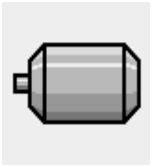
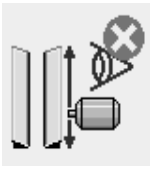


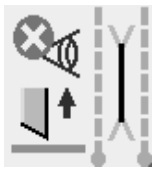
③ Pedal sensor voltage value in the present pedal depressing state is displayed in the range of 0 to 99 in the volume bar indication Ⓒ. First, press PEDAL DEPRESSED TO REVERSE STEP INPUT button Ⓓ with the foot pedal depressed to the reverse step. Voltage value of this time is inputted to Ⓔ. Next, press FREE INPUT button Ⓕ with the foot pedal free. Voltage value of this time is inputted to Ⓖ. Finally, press front-part depress input button Ⓗ with the front part of the pedal held depressed. Then, the voltage in the aforementioned state is input to Ⓘ.

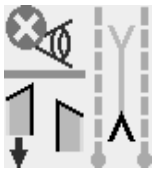
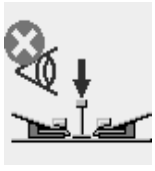
9. ERROR CODE LIST

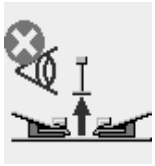
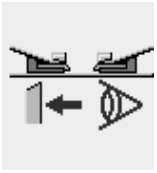
Error code		Description of error	How to recover
E001		**Initialization of EEP-ROM of MAIN CPU**	Turn OFF the power.
E007		**Machine-lock** Main shaft of the sewing machine does not rotate due to some trouble.	Turn OFF the power.
E010		**Pattern No. error** Pattern No. designated with ten-key is not registered when pattern No. is selected.	Possible to re-start after reset.
E011		**External media not inserted** Media is not inserted.	Possible to re-start after reset.
E012		**Read error** Data read from media cannot be performed.	Possible to re-start after reset.
E013		**Write error** Data write from media cannot be performed.	Possible to re-start after reset.
E015		**Format error** Formatting of media cannot be performed.	Possible to re-start after reset.
E016		**External media capacity over** Capacity of media is short.	Possible to re-start after reset.
E022		**File No. error** Designated file is not in server or media.	Possible to re-start after reset.
E024		**Pattern data size over** Memory size is over.	Possible to re-start after reset.

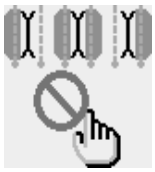
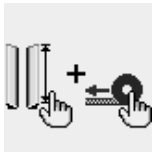
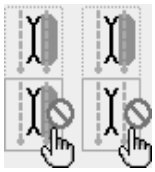
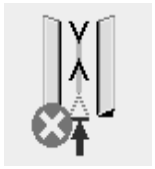
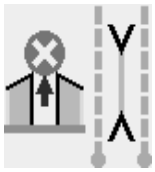
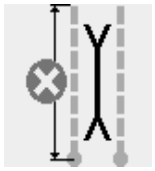
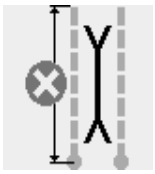
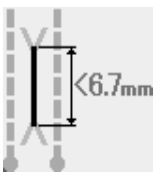
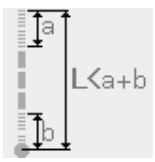
Error code		Description of error	How to recover
E027		**Read error** Data read from server cannot be performed.	Possible to re-start after reset.
E028		**Write error** Data write from server cannot be performed.	Possible to re-start after reset.
E029		**Lid of media slot is open.**	Possible to re-start after reset.
E030		**Needle bar upper position failure** Needle bar is out of needle UP position.	Possible to re-start after reset.
E031		**Air pressure drop** Air pressure is low.	Possible to re-start after reset.
E032		**File interchanging error** File cannot be read.	Possible to re-start after reset.
E045		**Pattern data error** Pattern data is corrupted.	Possible to re-start after reset.
E050		**Stop switch** When stop switch is pressed.	Possible to re-start after reset.
E052		**Thread breakage detection error** When thread breakage is detected.	Possible to re-start after reset.
A201		**Needle replacing time warning** When number of stitches of operation is reached to number of stitches of needle replacement that is set from the panel.	Possible to re-start after reset.
A202		**Cleaning time warning** When operation time of the sewing machine is reached to the cleaning time that is set from the panel.	Possible to re-start after reset.

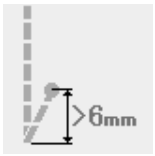
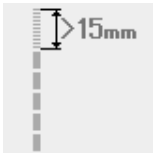
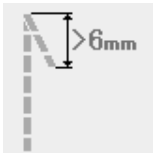
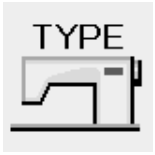
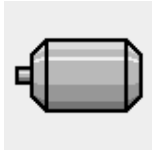
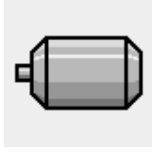
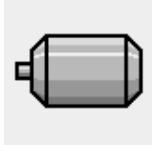
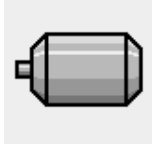
Error code		Description of error	How to recover
A203		**Oil replacement time warning** When operation time of the sewing machine is reached to the oil replacement time that is set from the panel.	Possible to re-start after reset.
E220		**Grease-up warning** When number of stitches of operation is reached to 40 million stitches.	Possible to re-start after reset.
E221		**Grease-up error** When number of stitches of operation is reached to 48 million stitches, a sewing impossible state occurs. * After applying grease, it is possible to release when clearing memory switch U245 Number of stitches of grease-up.	Possible to re-start after reset.
E303		**Semilunar plate sensor error** Detection of upper dead point of the sewing machine cannot be performed.	Turn OFF the power.
E349		**Step-out detection sensor does not react.** For the emergency procedure, it is possible to continually use by re-starting with the reset button. However, check the sensor and be sure to replace it when it is defective.	Possible to re-start after reset.
E366		**Center knife does not lower.**	Possible to re-start after reset.
E367		**Corner knife cannot be entered.** In case of M004 the long and wide type, corner knife cannot be entered when the corner knife opening amount exceeds 250 mm.	Possible to re-start after reset.
E368		**Zipper has run out.**	Possible to re-start after reset.
E369		**Roller stacker lower end sensor does not detect.**	Possible to re-start after reset.
E370		**Roller stacker lower end sensor is gone past.**	Possible to re-start after reset.

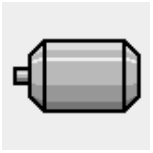
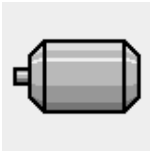
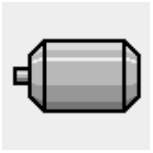
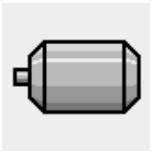
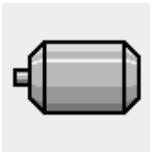
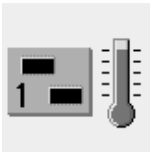
Error code		Description of error	How to recover
E371		**Clamp bar stacker material presser sensor is gone past.**	Possible to re-start after reset.
E372		**Clamp bar stacker material sweeper origin sensor is gone past.**	Possible to re-start after reset.
E373		**Reflecting tape on right-hand side is deteriorated.**	Possible to re-start after reset.
E374		**Reflecting tape on leftt-hand side is deteriorated.**	Possible to re-start after reset.
E376		**Pedal continuous depressing error**	Possible to re-start after reset.
E377		**Center knife upper detection sensor cannot detect.**	Possible to re-start after reset.
E378		**Clamp bar stacker open detection**	Possible to re-start after reset.
E379		**Roller stacker lift sensor cannot detect.**	Possible to re-start after reset.
E380		**Flap sensor cannot receive light**	Possible to re-start after reset.
E381		**Flap rear end cannot be detected (forced stop).** Error is displayed after end of sewing.	Possible to re-start after reset.

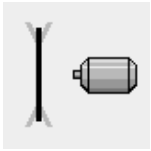
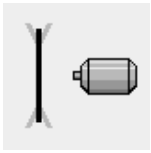
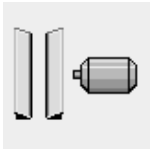
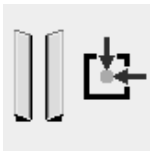
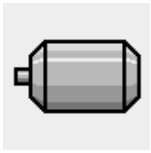
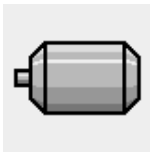
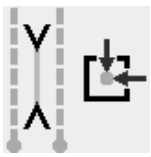
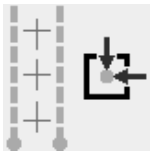
Error code		Description of error	How to recover
E382		**Flap dust detection error**	Possible to re-start after reset.
E383		**Flap front end cannot be detected.**	Possible to re-start after reset.
E386		**Corner knife fixing side bottom detection error**	Possible to re-start after reset.
E387		**Corner knife fixing side top detection error**	Possible to re-start after reset.
E388		**Corner knife moving side bottom detection error**	Possible to re-start after reset.
E389		**Corner knife moving side top detection error**	Possible to re-start after reset.
E390		**Material sensor error** Material remains after end of stacker operation.	Automatic recovery by sensor input
E391		**ST material presser lift detection error**	Automatic recovery by sensor input
E392		**ST material sweeper origin detection error**	Automatic recovery by sensor input
E393		**Binder bottom detection error**	Automatic recovery by sensor input

Error code		Description of error	How to recover
E394		**Binder top detection error**	Automatic recovery by sensor input
E398		**Corner knife drawer detection error**	Possible to re-start after reset.
E399		**Binder open detection error**	Possible to re-start after reset.
E401		**Copy disapproved** When trying to perform overwriting copy on the pattern No. which has been already registered	Possible to recover with CANCEL button
E402		**Erasing disapproved** When trying to delete the pattern used in the cycle sewing	Possible to recover with CANCEL button
E403		**New creation disapproved** When the registered pattern is selected to the new creation pattern No.	Possible to recover with CANCEL button
E404		**Data of designated No. does not exist.** When data of designated No. does not exist in media or server	Possible to recover with CANCEL button
E435	- - -	**Erasing disapproved** When trying to erase pattern registered to direct pattern.	Possible to re-start after reset.
E484		**Zipper attaching data cannot be sewn.**	Possible to re-start after reset.
E485		**Data other than zipper attaching data cannot be sewn.**	Possible to re-start after reset.

Error code		Description of error	How to recover
E486		**Flap sewing data cannot be sewn.**	Possible to re-start after reset.
E487		**Both long presser and endless zipper are simultaneously selected.**	Possible to re-start after reset.
E488	- - -	**The gauge size exceeds the input range.**	Possible to re-start after reset.
E489		**Combination data other than right/left flap sewing is set at the time of flap priority setting of alternate sewing mode.**	Possible to re-start after reset.
E490		**It is not possible to feed up to corner knife position.** When flap is put on this side in case of the long type	Possible to re-start after reset.
E491		**Corner knife length is too short.** When knife cannot be entered since the interval of corner knife is short.	Possible to re-start after reset.
E492		**L size length is too short.** When sewing cannot be performed since the inputted L size length is too short	Possible to re-start after reset.
E493		**L size length is too long.** When sewing cannot be performed since the inputted L size length is too long.	Possible to re-start after reset.
E494		**Center knife length error** When center knife length is smaller than knife size of 6.7 mm	Possible to re-start after reset.
E495		**Length at sewing start/sewing end over** When sewing length is shorter than the total of length of each condensation (back tack) at sewing start and sewing end	Possible to re-start after reset.

Error code		Description of error	How to recover
E496		**Condensation at sewing end length over** When condensation pitch X number of stitches exceeds 15.0 mm	Possible to re-start after reset.
E497		**Back tack at sewing end length over** When back tack pitch X number of stitches exceeds 6.0 mm	Possible to re-start after reset.
E498		**Condensation at sewing start length over** When condensation pitch X number of stitches exceeds 15.0 mm	Possible to re-start after reset.
E499		**Back tack at sewing end length over** When back tack pitch X number of stitches exceeds 6.0 mm	Possible to re-start after reset.
E702		**CPU runaway detection** When program abnormality has occurred in CPU	Turn OFF the power.
E703		**Panel is connected to the sewing machine which is not supposed (Machine type error)** When the machine type between panel and sewing machine is different in the initial communication	Possible to re-start after reset.
E704		**Inconsistency of system version** When system software version is inconsistent in the initial communication	Turn OFF the power.
E730		**Main shaft motor is defective or lacking for phases.** When encoder of sewing machine motor is abnormal	Turn OFF the power.
E731		**Main motor hole sensor is defective or position sensor is defective.** When hole sensor of sewing machine motor or position sensor is defective	Turn OFF the power.
E733		**Reverse rotation of main shaft motor** When the sewing machine motor rotates in the reverse direction	Turn OFF the power.
E802		**Power momentary cut detection** When input power is momentarily cut	Turn OFF the power.

Error code		Description of error	How to recover
E811		**Overvoltage of power error** When input power is more than the specified value	Turn OFF the power.
E813		**Low voltage of power error** When input power is less than the specified value	Turn OFF the power.
E901		**Main shaft motor IPM abnormality** When SERVO CONTTROL circuit board is abnormal	Turn OFF the power.
E903		**Stepping motor power (50V) abnormality** When stepping motor power of SERVO CONTROL circuit board fluctuates more than ± 15%	Turn OFF the power.
E904		**Solenoid power (33V) abnormality** When solenoid power of SERVO CONTROL circuit board fluctuates more than ± 15%	Turn OFF the power.
E905		**Heat sink temperature for SERVO CONTROL circuit board abnormality** Turn ON the power again after taking time.	Turn OFF the power.
E915		**Communication abnormality between operation panel and MAIN CPU** When abnormality occurs in data communication	Turn OFF the power.
E916		**Communication abnormality between MAIN CPU and main shaft CPU** When abnormality occurs in data communication	Turn OFF the power.
E917		**Communication abnormality between operation panel and personal computer** When abnormality occurs in data communication	Possible to re-start after reset.
E918		**MAIN circuit board heat sink temperature abnormality** Turn ON the power again after taking time.	Turn OFF the power.
E943		**Defective EEP-ROM of MAIN CPU** When data writing to EEP-ROM cannot be performed	Turn OFF the power.

Error code		Description of error	How to recover
E983		**Center knife motor lock detection**	Turn OFF the power.
E984		**Center knife motor abnormality**	Turn OFF the power.
E985		**Clamp foot motor step-out error**	Possible to re-start after reset.
E986		**Clamp foot stepping motor origin retrieval error**	Possible to re-start after reset.
E987		**Back tack motor origin retrieval error**	Possible to re-start after reset.
E988		**Pocket bag flap detecting motor origin-retrieval error**	Possible to re-start after reset.
E992		**Corner knife motor origin-retrieval error**	Possible to re-start after reset.
E998		**Corner knife stepping motor origin retrieval error**	Possible to re-start after reset.
E999		**Marking light motor origin retrieval error**	Possible to re-start after reset.

10. INPUT NUMBER TABLE

Name	Connecting connector No.
Air pressure detection	MAIN CN-30
Origin sensor on marking light fine adjustment side	MAIN CN-36-6
Corner knife motor origin sensor	MAIN CN-37-7
Back tack motor origin sensor	MAIN CN-38-6
Thread breakage detection (left)	INTA CN62A-2
Thread breakage detection (right)	INTA CN63A-2
Material sensor	INTA CN65A-3
Clamp foot step-out detection	INTA CN66A-3
Binder open detection	INTA CN68A-1
Binder up detection	INTA CN71A-3
Marking light origin sensor	INTA CN75A-2
Clamp foot origin detection	INTA CN77A-2
Center knife lift detection	INTA CN79A-1
Flap sensor (left)	INTB CN60B-2
Flap sensor (right)	INTB CN61B-2
Corner knife drawer detection switch	INTB CN62B-2
Bobbin thread remaining amount detection (left)	INTB CN64B-2
Bobbin thread remaining amount detection (right)	INTB CN64B-5
Start switch	INTB CN65B-3
Temporary stop switch	INTB CN69B-1
Pedal volume sensor	INTB CN76B-2
Corner knife fixing side bottom detection	INTB CN79B-1
Corner knife fixing side top detection	INTB CN80B-1
Corner knife moving side bottom detection	INTB CN81B-1
Corner knife moving side top detection	INTB CN82B-1
Roller lift detection	INTB CN83A-19
Stacker open detection	INTB CN83B-13
Stacker origin	INTB CN83B-15

中　文

APW-895NE/IP-420

＊「CompactFlash(TM)」是美国 SanDisk 公司的注册商标。

为了安全地使用缝纫机

由于缝制作业的具体情况，有时不得不靠近机器转动的零部件进行操作而有可能接触到转动零部件，因此实际操作机器的操作员和维修保养的维修人员，必须在事前仔细阅读 有关安全的注意事项 ，充分理解内容之后再进行操作。此 有关安全的注意事项 中记述的内容有的不是用户购买的商品规格的内容。

另外，为了能让用户充分地理解使用说明书以及产品的警报标签，特将警报表示分为如下种类。请充分了解这些内容，并遵守指示的要求。

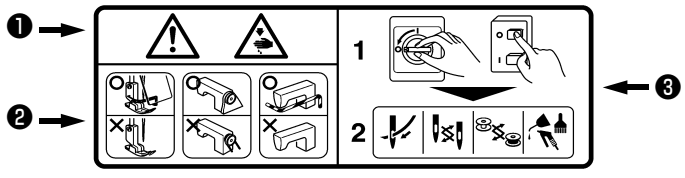
（Ⅰ）危险等级的说明

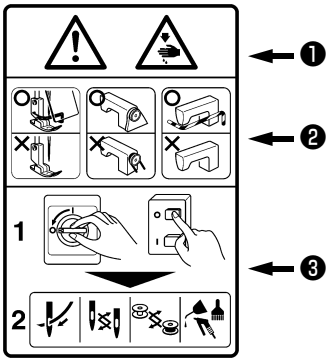
⚠危险	操作或维修保养机器时，如果当事人、第 3 者操作错误或没有避免该情况，有发生死亡或造成重伤的危险。
⚠警告	操作或维修保养机器时，如果当事人、第 3 者操作错误或没有避免该情况，有发生死亡或造成重伤的潜在可能。
⚠注意	操作或维修保养机器时，如果当事人、第 3 者操作错误或没有避免该情况，有造成中轻伤的可能。

（Ⅱ）警告图标表示和指示标签的说明

警告图标表示		有接触转动部，造成负伤的危险。	警告图标表示		作业时拿缝纫机的话，有让手受伤的危险。
		有接触高电压部，造成触电的危险。			有卷入皮带，造成负伤的危险。
		有接触高温部，造成烫伤的危险。			触摸了纽扣传送器，有受伤的危险。
		如果直接目视激光的话，有伤害眼睛的危险。	指示标签		指示正确的转动方向。
		有头部接触到缝纫机的危险。			指示地线的连接。

警告标签





❶ ・有发生中轻度伤害、重伤、死亡的危险。
・触摸了活动部分的话，有发生负伤的危险。

❷ ・应安装安全防护器，然后再进行缝制。
・应安装安全护罩，然后再进行缝制。
・应安装保护装置，然后再进行缝制。

❸ ・必须切断电源之后，再进行「穿线」、「换针」、「更换梭心」以及「加油、清扫」的操作。

触电危险标签

有关安全的注意事项

事故：是指给与人身以及财产带来损害。

⚠危险

1. 需要打开电气箱时，为了防止触电事故，请关闭电源，经过 5 分钟以上的时间之后再打开电气箱盖。

⚠注意

基本注意事项

1. 使用之前，请您一定阅读使用说明书以及附属的所有说明资料。
   另外，请您妥善保管本使用说明书，以便随时可以立即查阅。
2. 本注意事项中有部分内容可能不是您所购买的机器规格的内容。
3. 为了防止断针造成的事故，请戴上安全防护眼镜进行操作。
4. 使用心脏起搏器的人，请一定与专门医生咨询之后再使用。

安全装置、警告标签

1. 为了防止由于没有安装安全装置而造成的事故，操作本机器时，请确认安全装置是否正确地安装到规定位置之后再进行操作。
2. 为了防止人身事故，卸下了安全装置后，请一定再安装到原来的位置，并确认功能是否正常。
3. 为了防止人身事故，请把警告标签时常地粘贴到可以明显看到的机器上。如果脱落或发生污损，请立即更换成新的标签。

用途、改装

1. 为了防止人身事故，请不要将本机器使用于本来的用途和使用说明书规定的使用方法以外的用处。如果使用于规定用途以外时，本公司一概不负任何责任。
2. 为了防止人身事故，请不要改装机器。对于因改装而发生的事故，本公司一概不负任何责任。

教育培训

1. 为了防止由于不熟练而造成的事故，雇用单位应就有关本机器的操作和安全注意事项，对操作人员进行教育，而且只让具有专业知识和操作技能的操作人员使用本机器。同时，雇用单位一定事前编制操作人员的教育培训计划，并切实地实施。

必须关闭电源的事项

关闭电源：是指关闭电源开关之后，并且把电源插头从电源插座上拔下来。以下相同。

1. 为了防止人身事故，当确认了异常、故障后以及停电时，请立即关闭电源。
2. 为了防止因机器突然起动造成的事故，在如下情况时，请一定关闭电源之后再进行操作。特别是使用离合马达时，关闭电源后，一定确认了缝纫机完全停止转动之后再进行操作。
   2-1. 例如，向机针、弯针、分线器等需要穿线的零件进行穿线或更换梭心时。
   2-2. 例如，更换或调整组成机器的所有零部件时。
   2-3. 例如，检查、修理、清扫机器时，或离开机器时。
3. 为了防止触电、漏电、火灾事故，拔电源插头时，一定要手持插头拔电线，而不能拉着电线拔。
4. 不使用缝纫机闲放时，一定要关闭电源。
5. 为了防止因电气零部件的损坏造成的事故，停电后请一定关闭电源。

在各使用阶段的注意事项

搬　运

1. 为了防止人身事故，抬起缝纫机移动时，请一定根据机器的重量采用确保安全的方法进行搬运。另外，有关机器重量，请确认使用说明书的说明。
2. 为了防止人身事故，抬起缝纫机移动时，请采取确保安全的措施防止翻倒、掉落。
3. 为了防止不可预想的事故、掉落事故、机器损坏，请不要再次包装已经开箱的机器进行搬运。

开　箱

1. 为了防止人身事故，开箱时请按照从上方开始的顺序进行开箱。木框包装时，请一定要小心不要被钉子扎破。请把钉子从木板上拔下来。
2. 为了防止人身事故，取出机器时，请一定首先确认机器的重心位置然后小心地取出。

安　装

（Ⅰ）机台、台脚

1. 为了防止人身事故，请一定使用纯正的机台、台脚。不得以使用非纯正的零件时，请一定使用可以充分承受机器重量、运转时的反作用力的机台、台脚。
2. 为了防止人身事故，在台脚上安装脚轮时，请使用具有充分强度的带锁定装置的脚轮，操作机器时、维修保养、检查、修理时进行锁定不要机器晃动。

（Ⅱ）电缆、布线

1. 为了防止触电、漏电、火灾事故，使用电缆时请不要向电缆施加过大的力量。另外，在 V 形皮带等转动零部件附近布设电缆时，已经让电缆距离它们 30㎜ 以上。
2. 为了防止触电、漏电、火灾事故，请不要进行分岔布线。
3. 为了防止触电、漏电、火灾事故，请一定牢固地固定连接器。另外，拔连接器时，请一定手持连接器拔线。

（Ⅲ）接地

1. 为了防止因漏电、绝缘耐压而造成的事故，一定请具有电气专门知识的人安装电源插头。另外，请一定把电源插头连接到接地的电源插座上。
2. 为了防止因漏电造成的事故，请一定把地线接地。

（Ⅳ）马达

1. 为了防止马达烧毁而造成的事故，请一定使用规定的额定马达（纯正品）。
2. 使用市场出售的离合马达时，因被卷入 V 形皮带而造成的事故，请一定选用安装有防止卷入功能的皮带护罩的离合马达。

操 作 前

1. 为了防止人身事故，接通电源之前，请一定确认连接器、电缆等确实没有损伤、脱落、松动。
2. 为了防止人身事故，请不要把手伸到活动的部位。另外，请确认皮带轮的转动方向是否与箭头标记一致。
3. 使用带脚轮的机台脚时，为了防止突然的起动造成的事故，请一定锁定脚轮，带有调节器时，请调节台脚把脚固定好。

操 作 中

1. 为了防止卷入而造成的事故，操作机器时，请注意不要让手指、头发、衣服靠近皮带轮、手动飞轮、马达等转动部位，也不要把物品放到上面。
2. 为了防止人身事故，接通电源时或机器操作中，请不要把手指靠近机针，也不要把手指伸到挑线杆护罩里。
3. 缝纫机以高速在进行转动。为了防止弄伤手，操作中绝对不能让手靠近弯针、分线器、针杆、旋梭、布切刀等活动部位。另外，更换缝纫机机线时，请关闭电源，确认了缝纫机和马达均完全停止之后再进行更换。
4. 为了防止人身事故，从机台上拆卸缝纫机时，或者返回安装到原来的位置时，请注意不要夹到手指。
5. 为了防止因突然的起动造成的事故，拆卸皮带护罩以及 V 形皮带时，请一定关闭电源，确认了缝纫机和马达均完全停止之后再进行拆卸。
6. 使用伺服马达时，机器停止时马达不发出声音。为了防止因突然的起动造成的事故，请注意不要忘记关闭电源。
7. 为了防止因过热造成的火灾事故，使用时请不要堵住马达电源箱的冷却口。

加　油

1. 请使用 JUKI 纯正的机油和 JUKI 纯正的润滑脂向规定部位进行加油和涂抹润滑脂。
2. 为了防止炎症和脓肿，眼睛、身体上粘附了油时，请立即进行清洗。
3. 为了防止腹泻、呕吐，如果误饮了机油，请立即让医生治疗。

维修保养

1. 为了防止因不熟练而造成的事故，有关修理、调整，请一定让熟悉机器的维修保养技术人员按照使用说明书的说明进行修理和调整。另外，更换零部件时，请一定使用本公司的纯正零部件。对于不适当的修理和调整以及使用非纯正零部件造成的事故，本公司一概不负任何责任。
2. 为了防止因不熟练而造成的事故以及防止触电事故，请一定让具有电气专门知识的人或委托本公司、代理店的技术人员进行有关电气的修理和维修（包括布线）。
3. 为了防止因突然的起动造成的事故，修理和维修保养使用气缸等高压空气的机器时，请一定卸下空气供给源的管子，排放出残留的空气之后再进行修理和维修保养。
4. 为了防止人身事故，修理调整和更换零部件后，请一定确认螺丝螺母等没有松动。
5. 机器的使用期间中，请一定定期地进行清扫。此时，为了防止因突然的起动而造成的事故，请一定关闭电源，确认了缝纫机和马达均完全停止之后再进行清扫。
6. 进行维修保养、检查、修理时，请一定关闭电源，确认了缝纫机和马达均完全停止之后再进行操作。（离合马达时，请注意关闭电源后马达由于惯性仍然回继续转动一定时间。）
7. 为了防止人身事故，经过修理调整，机器不能正常操作时，请立即停止操作，与本公司或代理店联系，委托有关技术人员修理。
8. 为了防止人身事故，保险丝熔断后，请一定切断电源，排除了保险丝熔断的原因之后，更换相同规格的新保险丝。
9. 为了防止马达的火灾事故，请定期地进行风扇通气口的清扫和配线四周的检查。

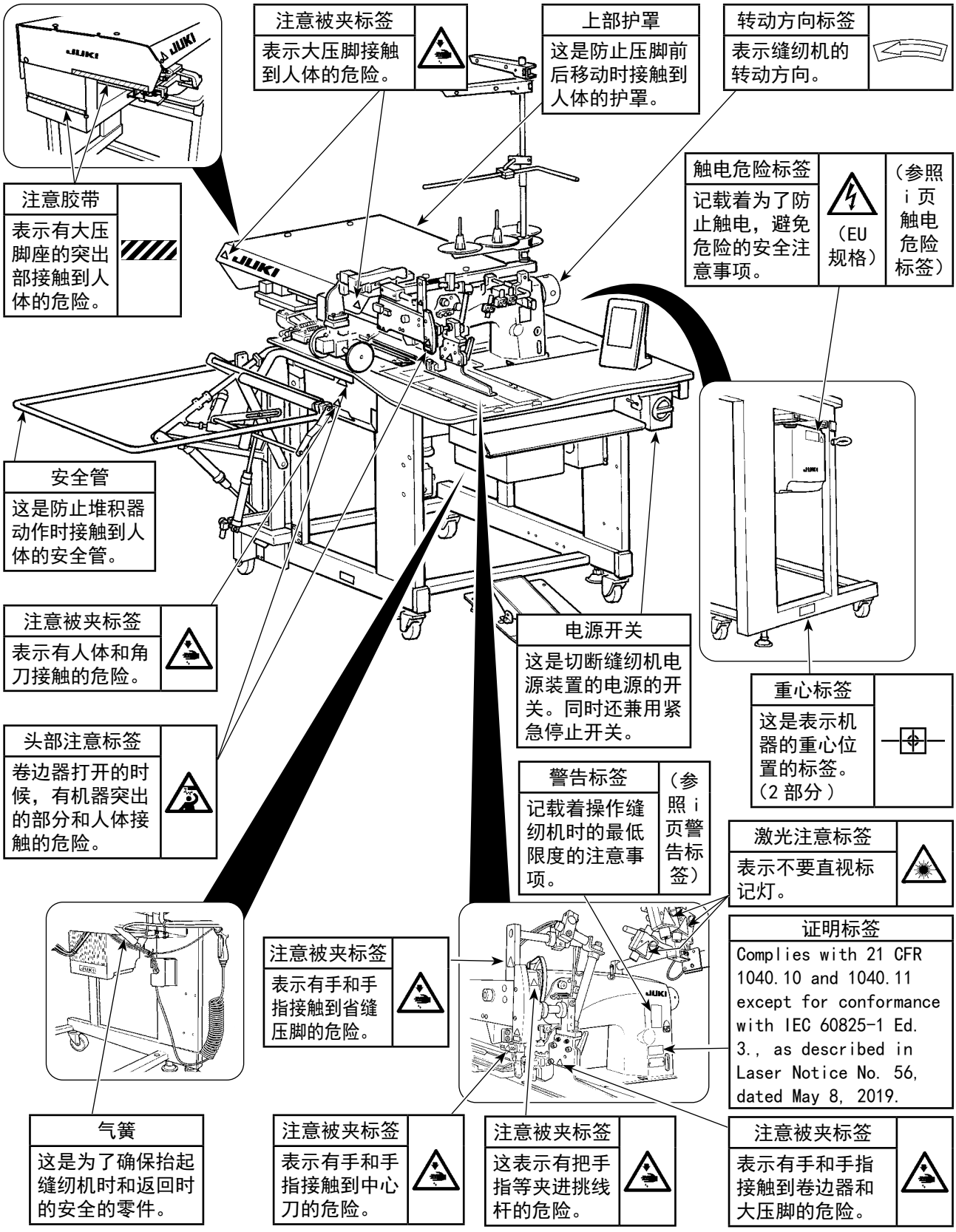
使用环境

1. 为了防止因误动作造成的事故，请在没有高频电焊机等强噪音源（电磁波）影响的环境下使用缝纫机。
2. 为了防止因误动作造成的事故，在超过额定电压 ±10%的地方，请不要使用缝纫机。
3. 为了防止因误动作造成的事故，对于使用气缸等高压空气的装置，请确认了压力符合规定之后再进行使用。
4. 为了安全地使用缝纫机，请一定在下列环境下进行使用。
   动作时的周围温度　5℃～ 35℃
   动作时的相对湿度　35%～ 85%
5. 为了防止因电气零部件的损坏和误动作造成的事故，从寒冷的环境急速地变到温暖的地方后容易产生结露现象，请等待水滴完全干燥之后再接通电源。
6. 为了防止因电气零部件的损坏和误动作造成的事故，打雷时为了安全，请停止操作，并拔下电源插头。
7. 有的电波状态下，可能会给予附近的电视机、收音机带来噪音。此时，请在稍稍离开缝纫机的地方使用电视机、收音机。
8. 为了确保作业环境，请遵守各国的有关法令。
   需要对应噪音时，请穿戴有关法令规定的防音防护用具等。
9. 有关产品、包装的废弃，使用完的润滑油等的处理，请按照各国的法律法规进行适当的处理。

为了安全地使用 APW-895N 缝纫机的注意事项

危险	1. 为了防止触电事故，在接通电源的状态下，请不要触摸马达、主机护罩、电气箱以及操作盘内的零件。
警告	1. 请不要用眼睛窥视激光光线。另外，也不要用光学器具直接看光线。
注意	1. 为了防止对人身的伤害，从抬起了缝纫机的状态把缝纫机机头返回到原来的位置时，请确认了气动弹簧下面没有放置工具和零部件之后再把缝纫机机头返回到原来的位置。 2. 为了防止对人身的伤害和缝纫机的损坏，请用工具和部件防护气簧的杆部以免弄上机头。 3. 为了防止对人身造成的伤害，气簧的杆由于损伤等原因动作变坏，或断定不良时，请立即更换有关部件。有关不良的判断基准，请参照「气簧的大致更换时期」项的内容。 [请不要使用 JUKI 纯正的气动弹簧（ 货号 ： 40023177）以外的零件。] 4. 为了防止发生人身伤害事故，卸下气簧的状态下请不要使用缝纫机。 5. 打开电源开关时以及缝纫机运转中请不要把手伸到机针下面。 6. 踩踏板之后，大压脚高速移动，因此在把脚放到踏板上时，请不要把手、手指、脸等放到大压脚的移动范围内。 7. 放倒缝纫机机头时，请一定关掉电源开关。 8. 缝纫机运转中非常危险，请不要让手指、头发靠近马达皮带轮附近和其他驱动部，也不要把物体放到机器上面。 9. 以下的情况时，请立即关闭电源开关，让维修人员进行检查。 (1) 经常发生断针、断线时。 (2) 与平常的动作不同时。 10. 缝纫机运转中，请不要关闭空气管。 11. 打开缝制机台的状态下，请不要移动大压脚。 12. 请把电源电缆的 FG 线连接到主电源的地线上。 13. 请不要把发生高热高湿的物体放到电气箱的附近。 14. 请使用粘贴着芯布的口袋布。 15. 缝纫机运转中请不要让手靠近切刀附近。 16. 安装堆积器（ 选购品 ）的机器，请安装了堆积器用安全管之后再让堆积器动作。在打开堆积器或安全管的状态下让堆积器动作或让堆积器单独动作的话非常危险，请不要进行这种操作。 17. 操作盘异常显示等会造成机器错误动作，因此请不要过快地反复打开关闭电源开关。请在电源关闭后经过 5 秒钟以上之后再打开电源。 18. 请一定在电源开关关闭的状态下插拔电源插头。 19. 因为本产品属于精密机器，所以操作时请充分注意，不要把水、油溅到机器上面，也不要让机器掉落给与机器冲击。 20. 在比木制机台面低的位置操作时，请注意不要让头碰到机台等。 21. 为了防止人身事故，抬机器或移动机器时，请使用叉车等大型机器。 22. 操作紧急停止开关时，卷边器和大压脚会因自重掉落，因此请不要把手伸到卷边器和大压脚的下面。 23. 在家庭环境下使用此机器的话，有可能发生电波干扰的现象。此时，请使用人采取适当的措施解决电波干扰问题。

关于安全装置和警告标签



⚠ 注意

另外，在使用说明书中为了突出说明的重点，有的地方省略显示了「眼睛防护罩」、「手指防护器」等安全装置，请了解。
但是实际使用时，请绝对不要卸下这些安全装置。

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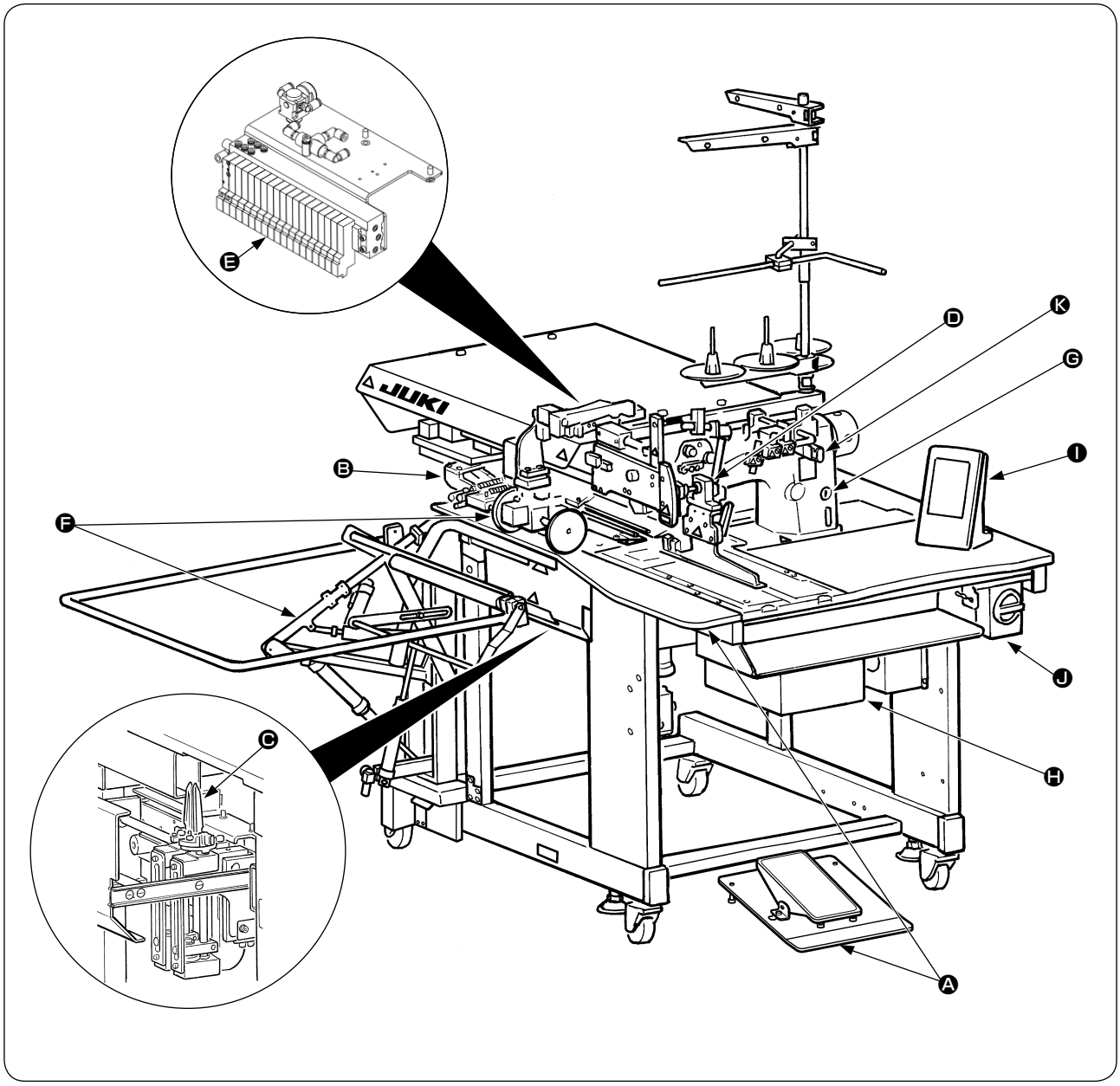
Ⅰ. 运转前的注意事项

运转前和每日开始工作前，请一定确认以下项目。

1. 请确认是否向缝纫机加入了规定量的缝纫机油。
2. 在没有向旋梭加油部加入机油的状态，请绝对不要运转缝纫机。
3. 请确认空气压力表的读数是否为 0.5MPa。
   ※（特别是中午午休等停止了空气压缩机后，请一定进行确认。）
   空气压力在规定值以下时，有发生零件碰撞等危险，请加以注意。
4. 请确认缝纫机的上线、底线是否需要补充。
5. 打开电源开关开始缝制时，请一定进行试缝之后再正式缝制产品。

II. 各部的名称



本缝纫机由以下 11 个部分构成，

- Ⓐ 主机构造机构部（主机机架、缝制机台、各种护罩、脚踏开关等）
- Ⓑ 大压脚装置、缝制送料部
- Ⓒ 角切刀装置部
- Ⓓ 滚边器装置部（滚边器机构和滚边器驱动机构等）
- Ⓔ 空气控制机器部（空气压缩机和空气配管等）
- Ⓕ 堆积器装置部（选购品）
- Ⓖ 缝纫机部
- Ⓗ 控制装置（控制盘）
- Ⓘ 操作盘部
- Ⓙ 电源开关（兼用紧急停止开关）
- Ⓚ 中途停止开关

只要把布料（衣片、芯布、袋盖布等）放到规定位置，脚踩踏板就可以自动地缝制袋盖。
另外，机器动作中，按了中途停止开关 Ⓚ 之后，机器就停止。

III. 规格

1. 机器规格

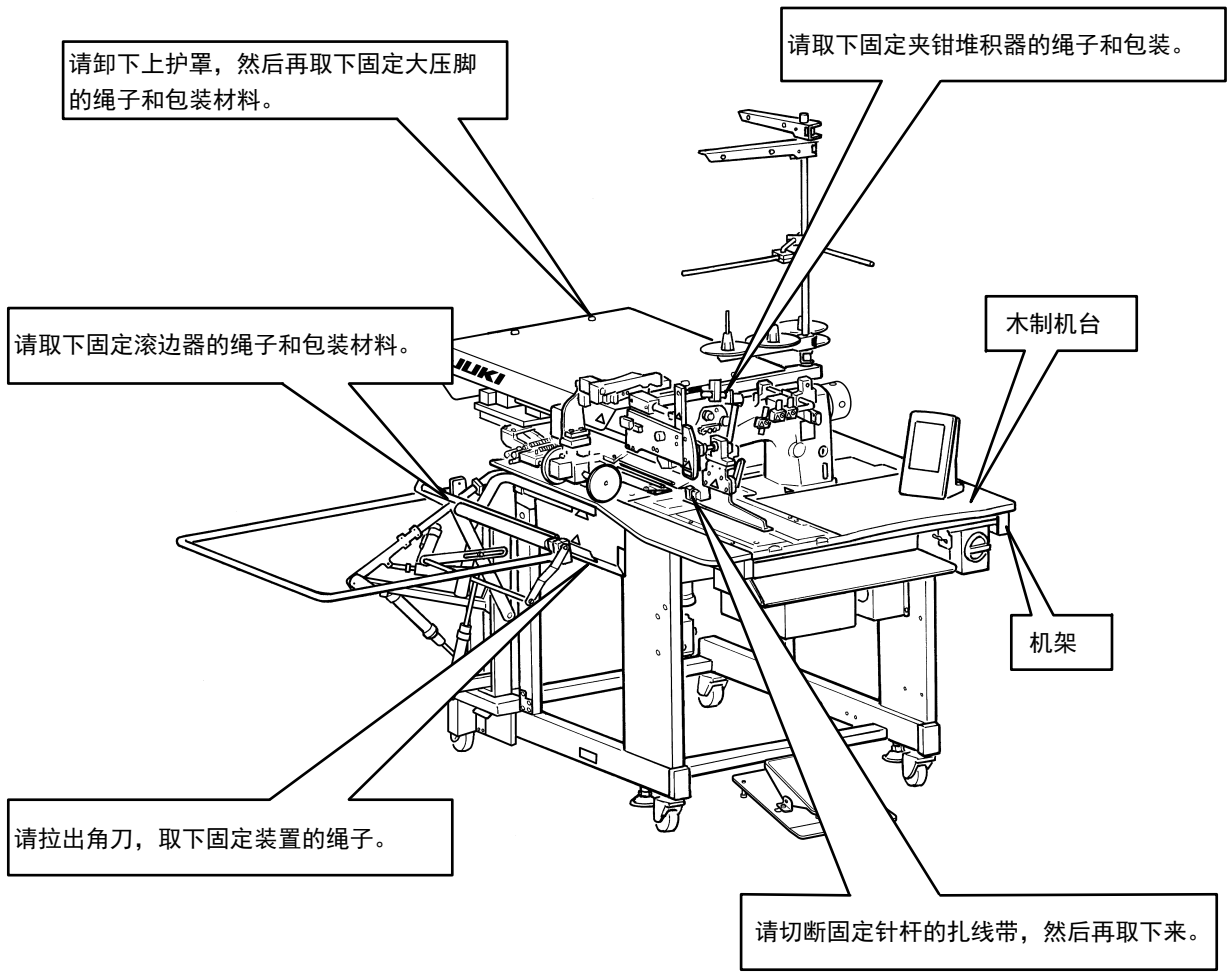
1	使用缝纫机	LH-895N 双针平缝带中切刀缝纫机
2	缝纫速度	最高 3,000sti/min
3	缝迹长度	平缝 : 2.0 — 3.4mm(标准 2.5mm) 缩缝 : 0.5 — 1.5mm(标准 1.0mm) 触键倒缝 : 0.5 — 3.0mm(标准 2.0mm) 可以变换缩缝、触键倒缝。
4	开袋种类	平型双袋　均有带袋盖和无袋盖
5	袋口尺寸 (袋盖长度)	**标准规格 : 在最小 18 ～最大 220mm 的范围可以以 1mm 单位进行设定。** 但是，使用角刀时为最小 35mm。
6	袋盖宽度(针幅)	10、12mm
7	使用机针	风琴牌　DP × 17 # 14 — # 18(标准# 16)
8	使用机线	缝纫机线　# 60(推荐)
9	使用选梭	全转动自动加油水平旋梭
10	挑线杆	滑动挑线杆
11	针杆行程	33.3mm
12	送布机构	脉冲马达驱动
13	控制	微电脑控制
14	安全功能	检测送布机构异常、断线检测等时自动停机
15	润滑油	JUKI New Defrix Oil No.1
16	使用空气压力	0.5MPa
17	空气消费量	约 40 N ℓ /min.
18	机器尺寸	宽 : 1,095mm (1,580mm…包括堆积器) 长 : 1,500mm 高 : 1,165mm (1,800mm…包括线架)
19	机器质量	238.5kg

2. 电气规格

1	记忆单独缝制图案数	99（1 ～ 99）
2	记忆交替缝制图案数	20（1 ～ 20）
3	记忆循环数	20（1 ～ 20）
4	输入电源	单相　220 — 240V　50/60Hz 电源电压变动　额定 ±10% 以内
5	消费电力	270VA

IV. 安装

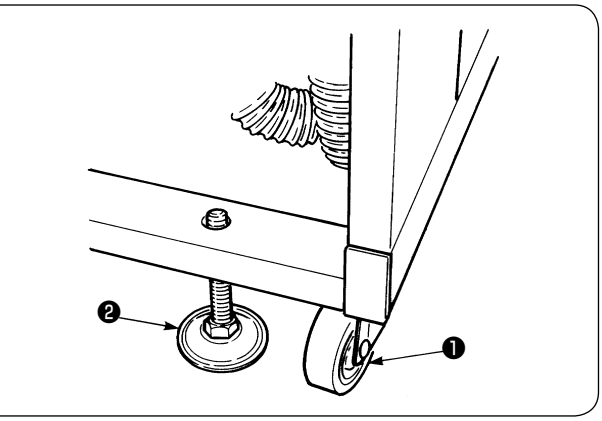
1. 包装材料的拆卸



注意 抬机器时，请不要手持木制机台，而应手持机架。

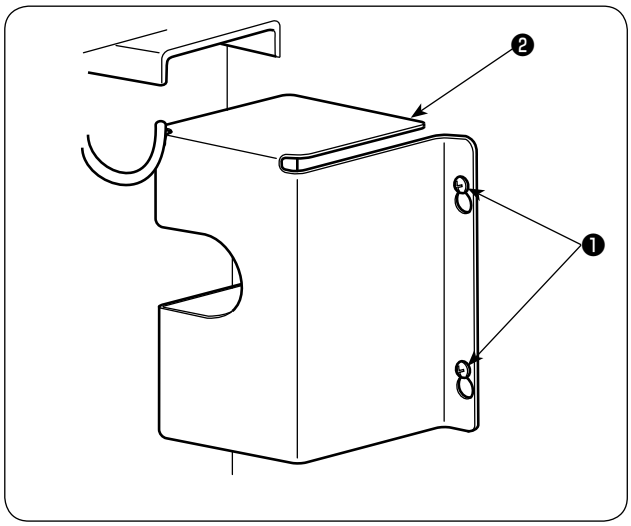
2. 固定主机

⚠注意 为了防止发生人身事故，将本机水平地移动到稳定的地点后，请放下脚轮❶横向的调节螺栓❷（4 处）进行固定。

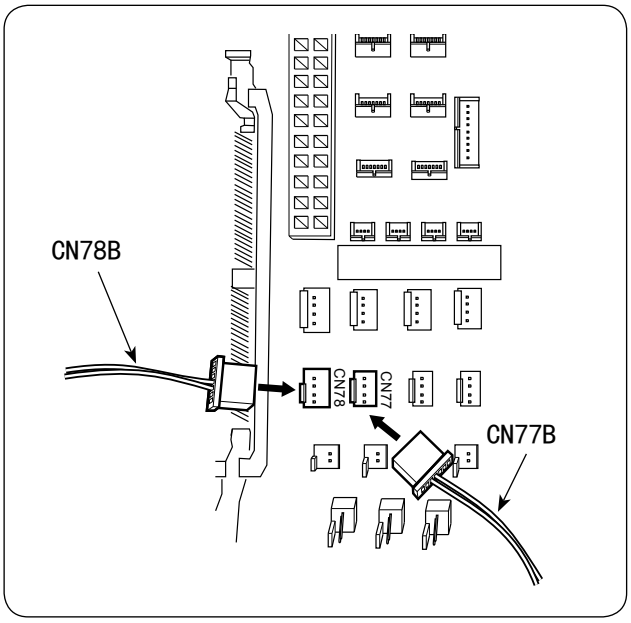


3. 连接脚踏板

⚠注意 安装时，请注意不要让头碰到上面的机台。

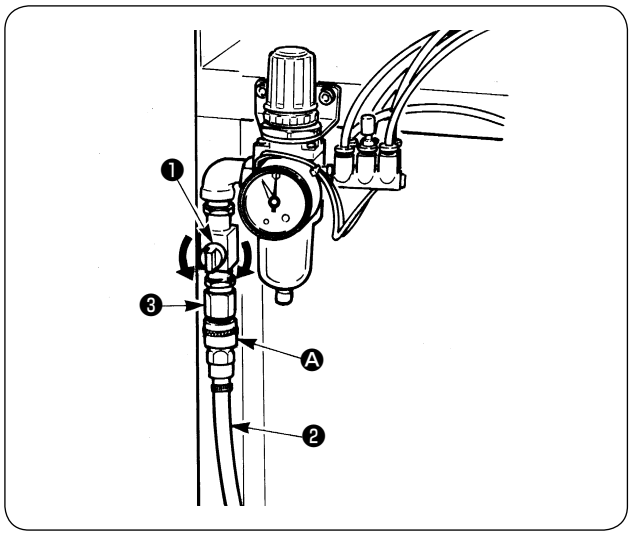


① 松开 4 根螺丝❶，拆下基板罩子❷。



② 在中继基板中插入踏板连接器。
（让 CN78B 连接 CN78，让 CN77B 连接 CN77。）

4. 压缩空气连接器的连接



请把附属品里面的空气连接器 Ⓐ 连接到空气软管❷后，再连接到主机侧的连接器❸。

注意
- 请关闭空气栓❶进行了连接器 Ⓐ 的连接后，慢慢地打开空气栓❶，供给空气。
- 请确认调节器的压力表读数是否是 0.5MPa。

5. 电源插头的连接

⚠注意 为了防止漏电、超过绝缘耐压造成的事故，安装电源插头时，请让具有电气专门知识的人安装适合的插头。另外，电源插头必须连接到接地的插座上。

产品的规格不同电源的连接方法也不同。请根据电源规格进行连接。

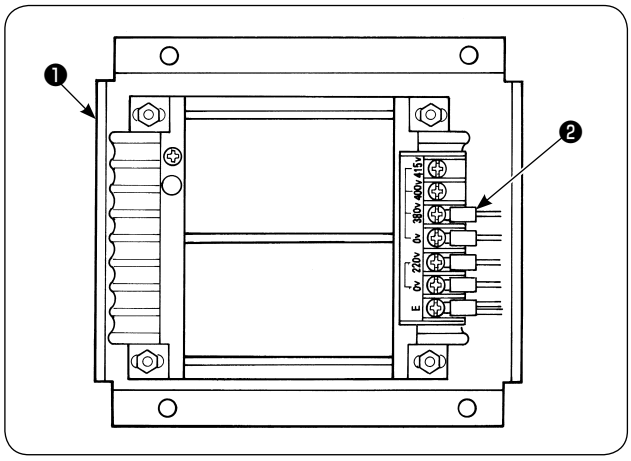
① 单相 220 ～ 240V 规格的产品时
请把电源线的天蓝色和褐色的电线连接到电源端子（AC220 ～ 240V），把黄 / 绿色电线连接到接地（地线）端子。

② 三相 200 ～ 240V 规格的产品时
请把电源线的红色、白色和黑色电线连接到电源端子（AC200 ～ 240V），把黄 / 绿色电线连接到接地（地线）端子。

③ 带选购品高压变压器的产品时（带 SA-128）
请分别把电源线的黑色电线（3 根）连接到电源端子（AC380 ～ 415V）上，把黄色 / 绿色电线连接到设置（地线）端子上。
设定变压器的输入抽头，可以连接 380/400/415V（标准出货设定为 380V）的电源。

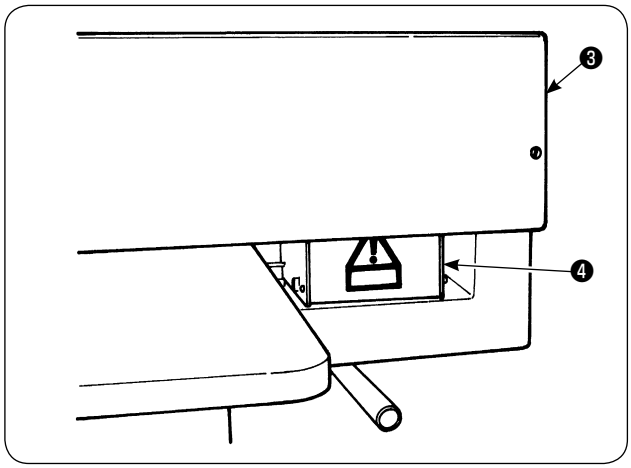
注意 对于三相 380/400/415V 电源，本产品采用单相连接的运转方式。

[变更高压电选项变压器的电源时注意事项]



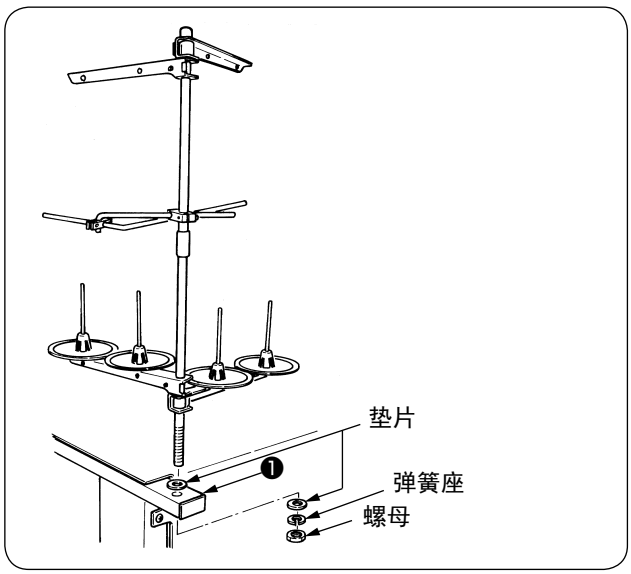
输入电压为 400V、415V 的情况下，使用高压电选项变压器❶时，必须更换高压电选项变压器❶的输入电源线❷。请把连接 380V 的输入电源线❷（天蓝色）更换为连接 400V 或 415V 的输入电源线。

注意 为了防止事故的发生，操作时，请关掉（OFF）电源开关，然后拔掉电源线，待缝纫机放置 4 分钟以上之后再进行操作。



高压电选项变压器❶设置在机台后侧。
进行电压变换时，请卸下上部护罩❸之后再拆卸变压器箱❹。

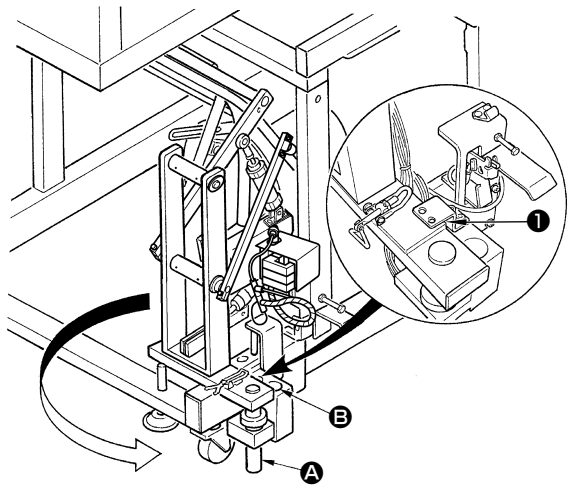
6. 线架的组装和往主机的安装



请按照左图所示那样，请用螺母和垫片把线架固定到主机机架❶上。

中文

7. SP-46N（夹杆堆积器）的安装（选项 货号 : 40149301）

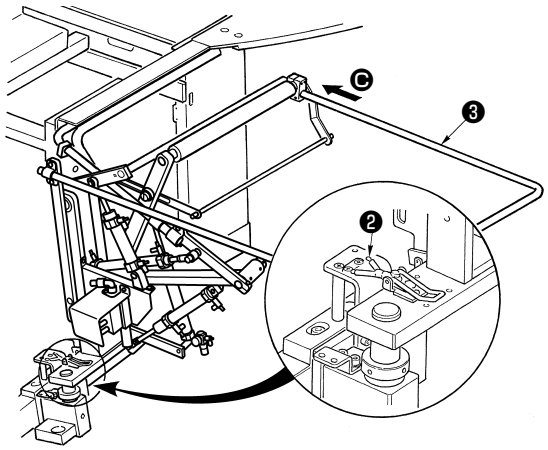


参考 安装了夹杆堆积器出货时，是固定到机架内的状态出货的，因此必须变更安装到通常的使用位置。

① 卸下堆积器固定板❶。
② 向箭头方向转动整个堆积器，从机架里取出来。
③ 把堆积器旋转轴 Ⓐ 更换到堆积器座孔 Ⓑ。

注意 此时，请注意不要夹到堆积器电线和空气配管等。
另外，请把堆积器旋转轴插入到堆积器座孔的根部为止。

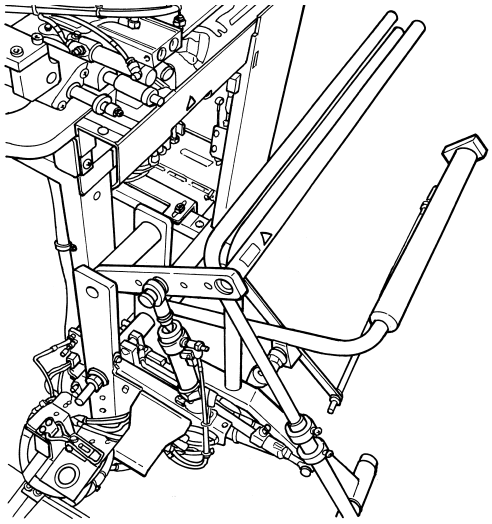
作业时的情况（供给空气）



④ 用铰链❷锁定整个堆积器。
⑤ 请向 Ⓒ 方向放入安全杆❸，在与地面基本平行的位置进行固定。

参考 此时，请确认空气是否进入到里面。

安装设定时的情况（没有供给空气）



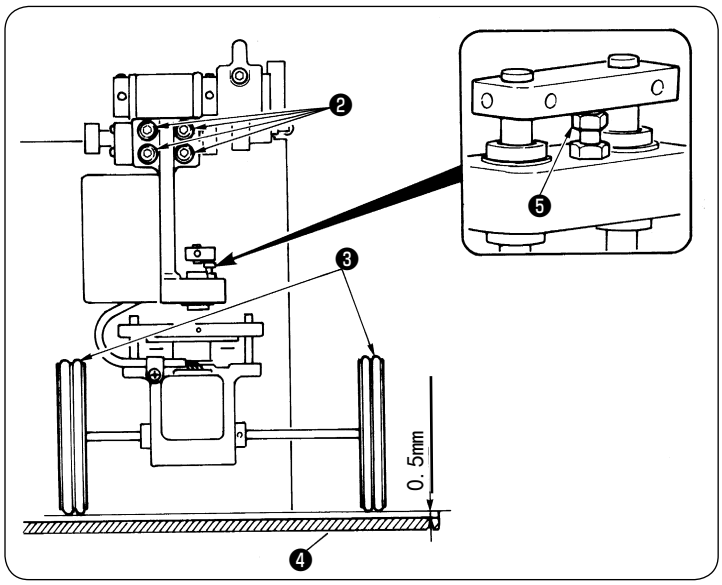
注意 因停电等原因切断电源时，有可能堆积器的折入顺序混乱以及有夹手的危险。请加以注意。
请不要把手伸进安全杆围圈的范围之内。

参考 如果出现了上述情况时，请切断空气的供给，返回到左图「安装设置时的情况（没有供给空气）」的状态。
请确认了已经返回到此状态后，再供给空气。

8. SP-47N（辊式堆积器）的安装（选项 货号 : 40149302）

(1) 位置调整

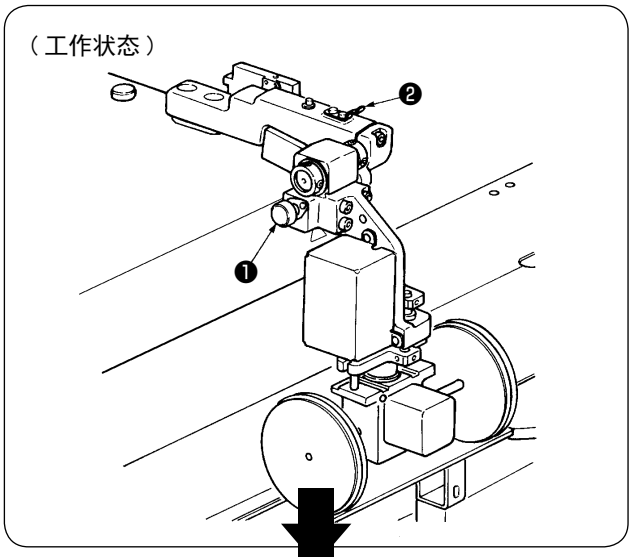
在 APW-895NE 上使用 SP-47N（辊堆垛机）时，需要另行准备次动作台。
请按照 40185763 安排。
※ 4018576・・・次工作台和固定螺丝的成套产品编号

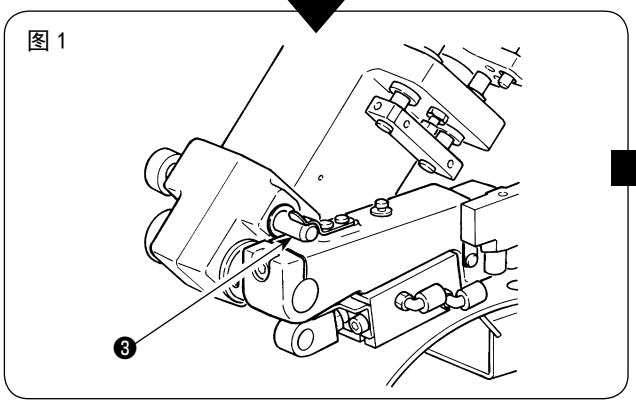


① 确认平行
请确认堆积器机台❹和橡胶辊❸是否平行地安装。
如果安装得不平行时，请拧松 4 个固定螺丝❷进行调整。

② 确认间隙
请确认堆积器机台❹和橡胶辊❸的间隙是否大约是 0.5㎜。如果不是大约 0.5㎜时，请拧松螺母❺进行调整。

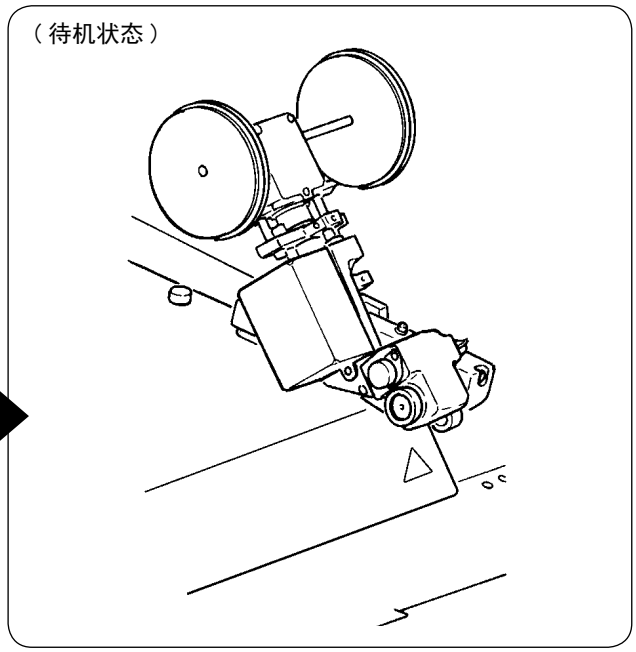
(2) 维修



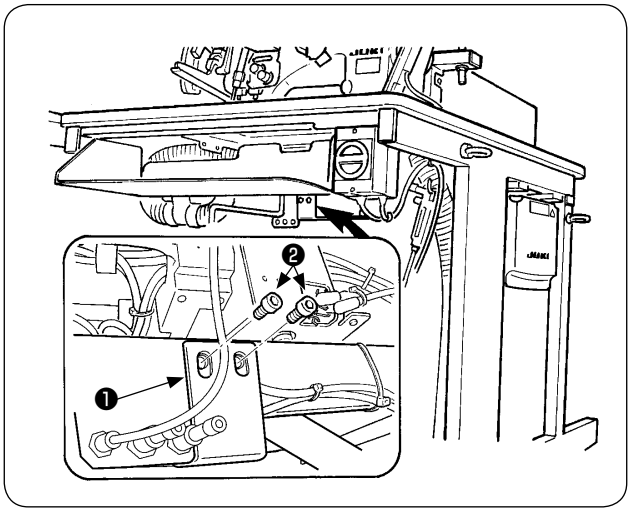


不使用辊式堆积器时，或者调整角刀时，辊式堆积器可以按照以下的要领退避到上方。

拉动解除操作杆❶，向上抬起滚子，然后把销子❸插入固定弹簧❷，进行锁定（参照图 1），这样就可以变成待机状态。



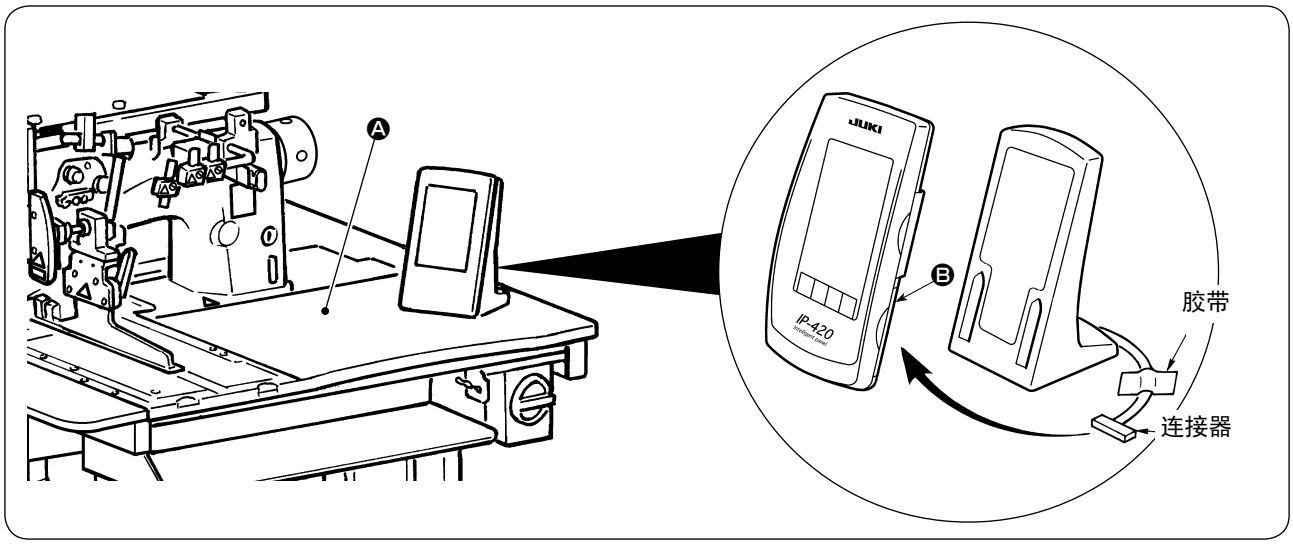
9. 机头固定板的拆卸



请卸下机头固定板❶的固定螺丝❷。

注意 以后运输时请一定固定缝纫机和机架。

10. 操作盘 IP-420 的安装



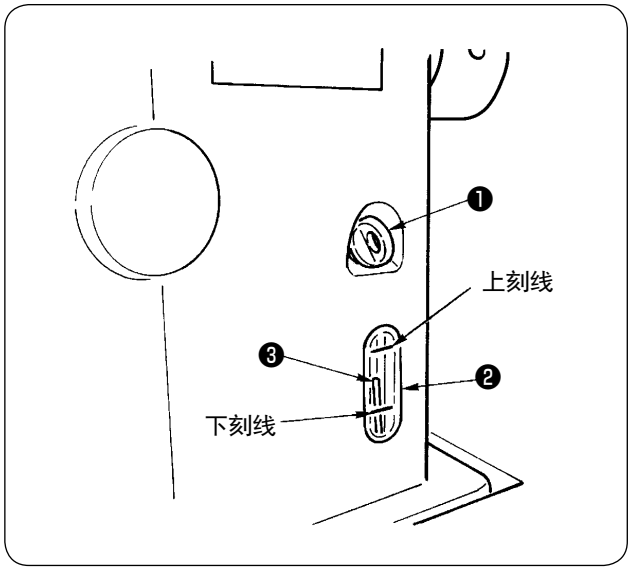
如图所示，打开 IP-420 右侧 Ⓑ 部的盖子，连接用胶带固定在机台右上方 Ⓐ 的连接器。

注意 为了防止操作盘 IP-420 因静电而发生误动作，安装到操作盘座使用时，请不要变更操作盘座的位置。

11. 往油槽加油

⚠注意

1. 为了防止缝纫机的突然起动造成事故，加油完了之前，请不要连接电源插头。
2. 为了防止炎症、斑疹，油粘附到眼睛、身体上之后，请立即进行清洗。
3. 误饮油之后，有可能发生泻肚、呕吐。请放到小孩拿不到的地方。



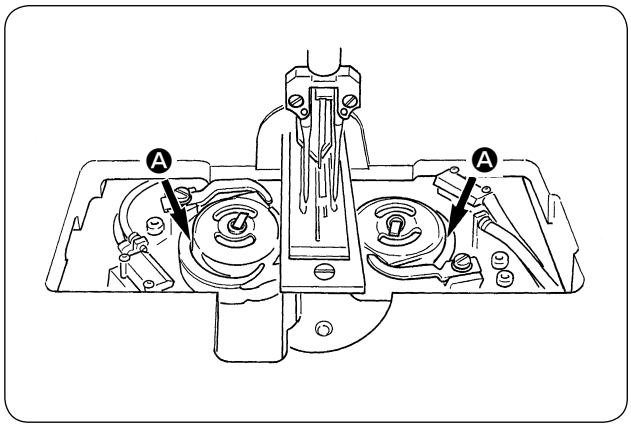
运转缝纫机之前，请向油槽里加入旋梭加油用的油。

① 卸下加油口盖❶，使用复述的油壶，加入 JUKI MACHINE OIL No. 1（货号 : MDFRX1600C0）。

注意 为了防止灰尘侵入，请一定安装上盖子之后再使用。

② 请把油加到油量标尺❸的前端来到油量指示窗❷的上刻线和下刻线之间。
加油过多的话，会从油槽的气孔处漏油，而不能适当地加油，请注意。

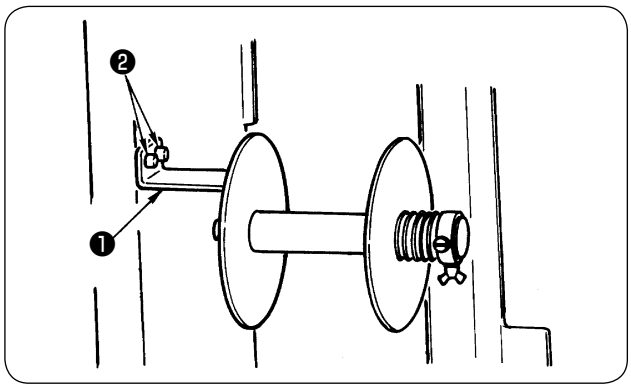
③ 使用缝纫机时，如果油量标尺❸的前端到达油量指示窗❷的下刻线之后，请立即加油。



注意
- 初期加油时，请加入大约 200cc，确认油量标尺是否动作。
- 使用新缝纫机或者较长时间没有使用缝纫机时，请先进行 2000sti/min 以下的磨合运转之后再使用。另外，请向旋梭左右的滑槽面 Ⓐ 加油之后再使用。
- 请购买 JUKI MACHINE OIL No. 1（货号 : MDFRX1600C0）旋梭油。
- 请一定加清洁的油。
- 请绝对不要加入脏污的机油。

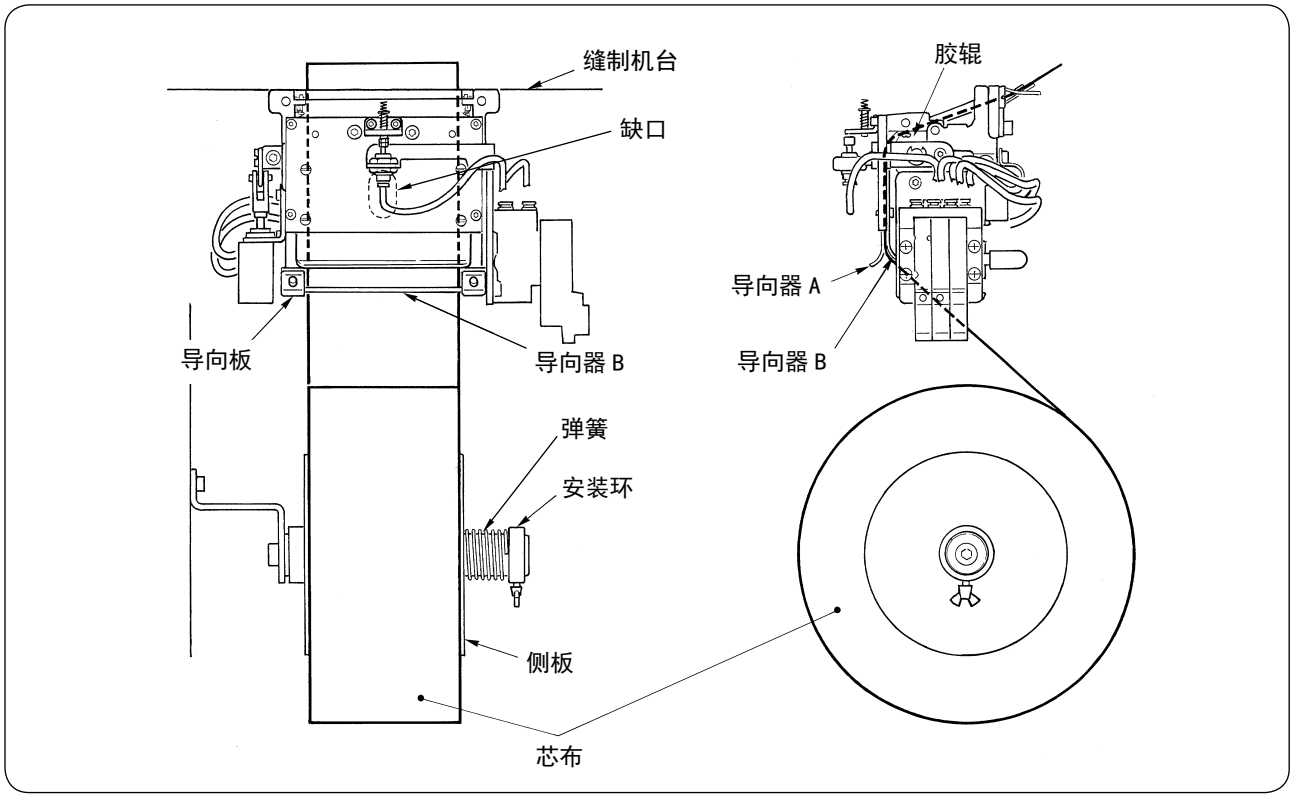
12. SA-120N（芯布供给装置）的安装（选项 货号 : 40149798）

⚠注意 为了防止突然的起动造成事故，请关掉电源之后再进行操作。



＊ 长尺寸宽幅规格时不能使用。

① 用 2 个螺丝❷把芯布安装板❶固定到机壳上。



② 请如图所示那样安放芯布。
可以使用的芯卷是宽度 40 ～ 70㎜、卷直径最大 200㎜。

③ 芯布的通道是穿过导向器 B 和导向器 A 之间，再穿过胶辊，然后拉到机台上面。

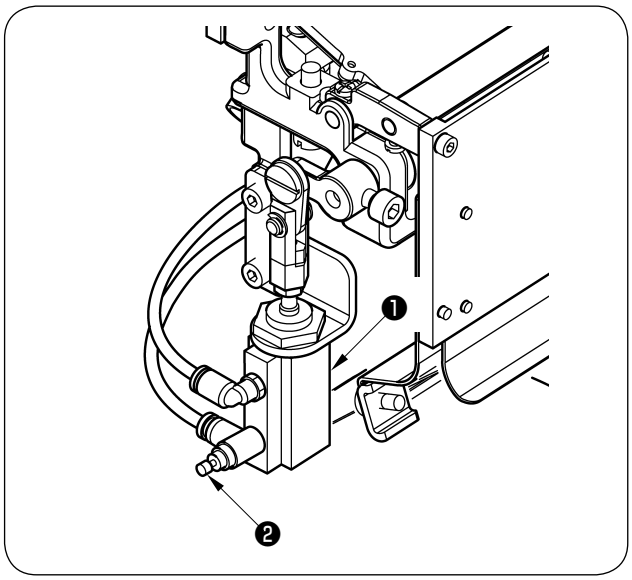
参考 芯布利用导向板的缺口，一直连接到胶辊。

④ 请调整导向器（2 个）、导向销（2 个）以及侧板（右侧）的左右位置，让芯布直向来到缝制机台上。

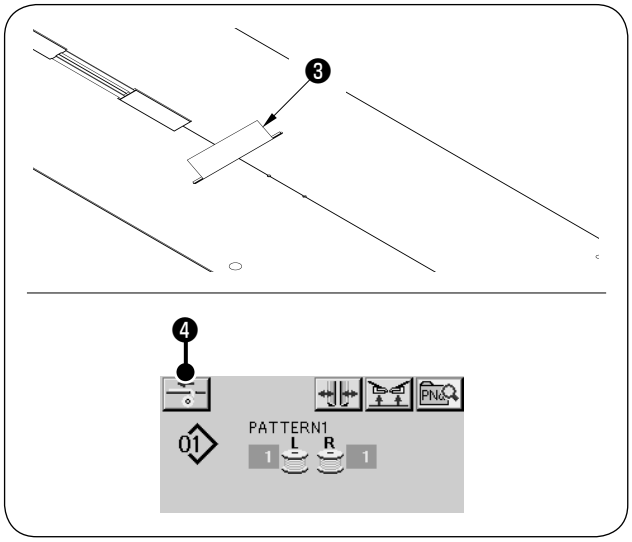
⑤ 左侧的安装环的位置，请固定到弹簧在侧板轻轻地压芯布的位置。

13. SA-120N（芯布供给装置）的调整（选项 货号 : 40149798）

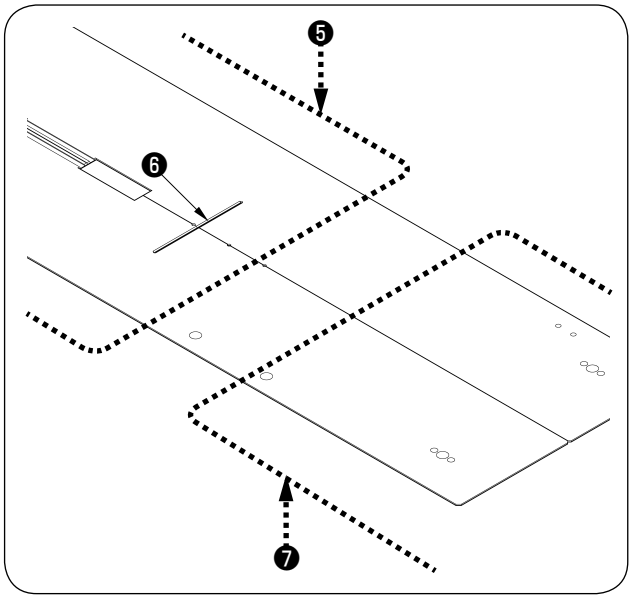
⚠注意 为了防止突然的起动造成事故，请关掉电源之后再进行操作。



① 芯布拉出量的调整用存储器开关（ U003 ）来进行调整，但是更加细微的调整请用芯布拉出缸筒❶的速度控制器❷来进行微调。
（拧紧的话变少，拧松的话变多。）



② 安放了新的芯布❸后，请按芯布供给按钮❹，进行几次空送，确认了拉出量和芯布是否可以平行地拉出后再使用。



（使用时的注意事项）
在后基准❺使用芯布供给装置的话，因为离开了芯布出口❻，开始缝制的芯布留布过长，所以请在前基准❼使用芯布供给装置。

注意 有关缝制机台的使用方法，请参照 "V-2. (2) 卸下了缝制机台后的注意事项 " p. 16。

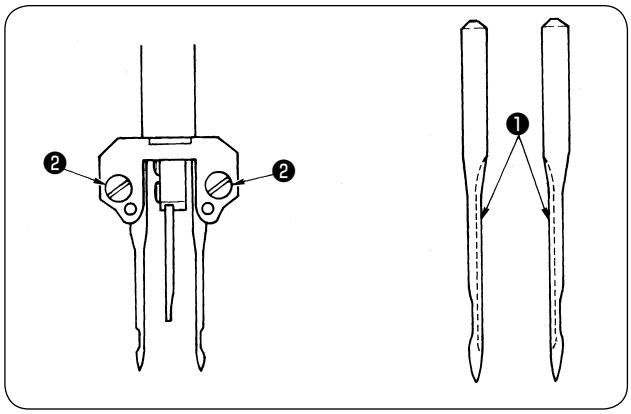
V. 缝纫机的准备

1. 缝纫机机头的使用

(1) 机针的安装方法

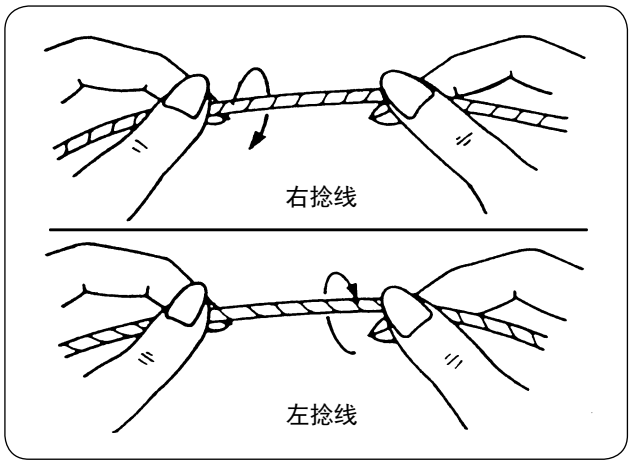
⚠注意

- 为了防止突然的起动造成事故，请关掉电源之后再进行操作。
- 更换机针时，请注意手指不要碰到中心刀的刀刃。



使用机针是 DP×17 #14 ～ 18（标准 #16）。请使用指定的机针。
左右机针均让长槽❶朝向内侧，并插入到顶到机针安装孔的最里面，然后请用机针固定螺丝❷拧紧固定。

(2) 使用机线



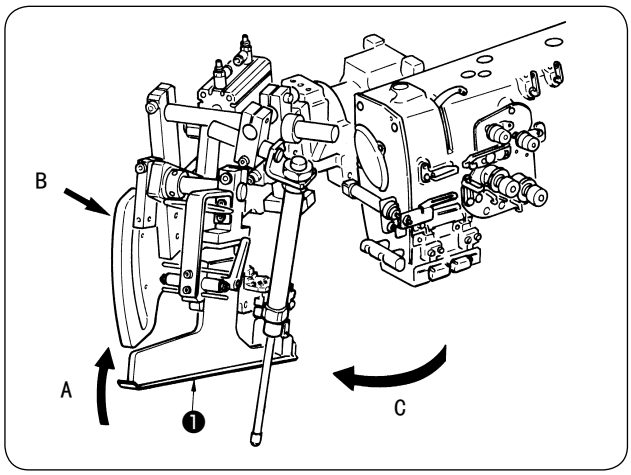
- 上线请使用左捻线。
- 底线左捻线和右捻线均可以使用。

注意 使用的机线，请使用拧得整齐的新线。

(3) 上线的穿线方法

⚠注意

为了防止突然的起动造成事故，请关掉电源之后再进行操作。

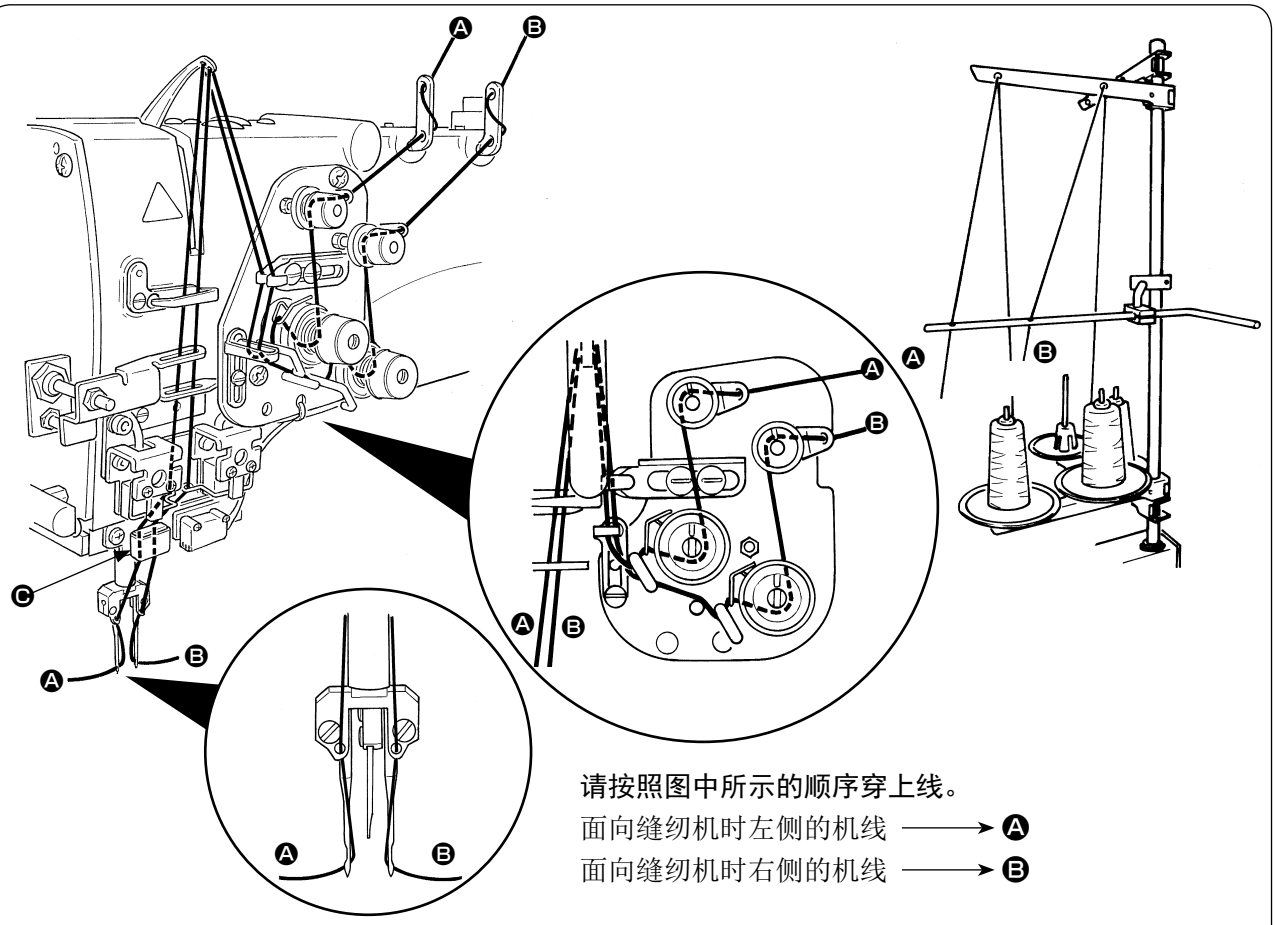


① 向 A 方向拿起滚边器❶之后，再用手托着 B 部，让整个滚边器向 C 方向旋转。

注意 按滚边器，向 C 方向旋转之后，有可能袋盖宽度发生变动，因此请一定按 B 部。

参考 滚边器被球塞锁定着，用力向 C 方向转动就可以解除锁定。

② 然后，请按照下图所示的顺序穿上线。



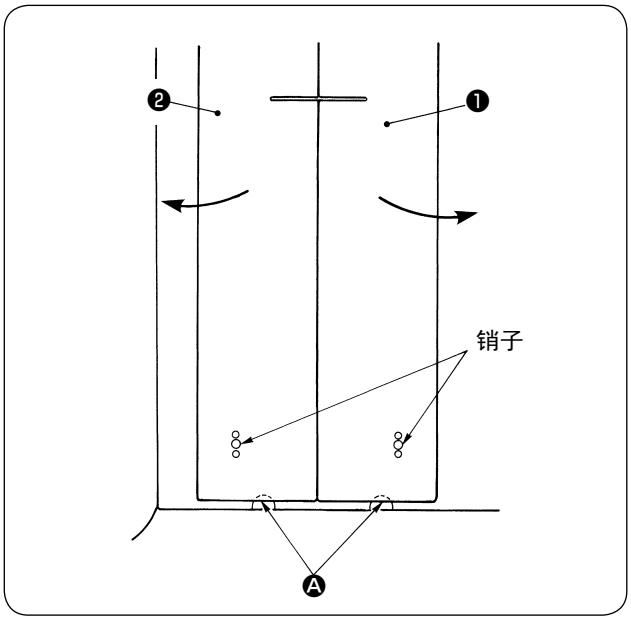
请按照图中所示的顺序穿上线。
面向缝纫机时左侧的机线 ⟶ Ⓐ
面向缝纫机时右侧的机线 ⟶ Ⓑ

注意 请定期地更换线导线毛毡 Ⓒ。可以防止缝制中由于机线乱跳而发生的缝制不良。

2. 缝制机台的拆卸方法

⚠注意 为了防止突然的起动造成事故，请关掉电源之后再进行操作。

(1) 更换底线时



① 请把大压脚移动到后退端。
② 用手指从机台侧面缺口 Ⓐ 抬起左、右缝制机台❶、❷。
③ 在此状态下，向箭头方向移动之后就可以看到梭壳。

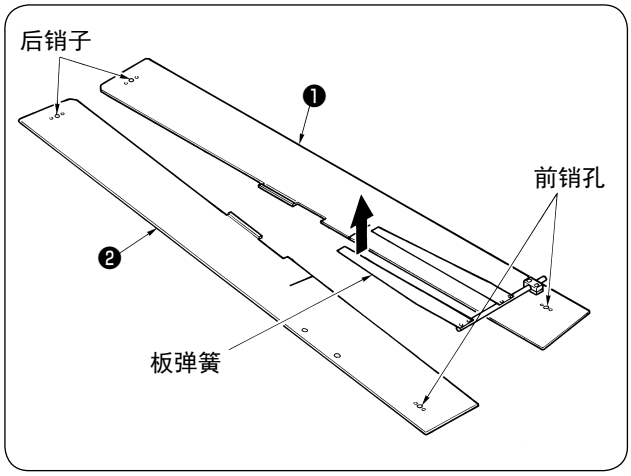
注意 此时，请注意移动时不要让缝制机台碰到机针。

④ 更换了底线之后，请按照相反的顺序把缝制机台确实地安放到针板和销子上。

(2) 卸下了缝制机台后的注意事项

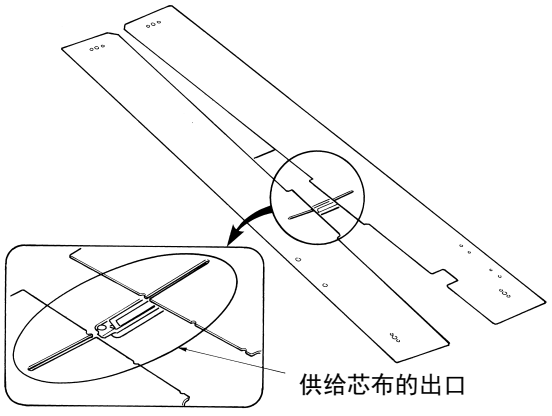
⚠注意	为了防止突然的起动造成事故，请关掉电源之后再进行操作。

卸下了缝制机台❶、❷后，请按照以下的要领确实地安装。



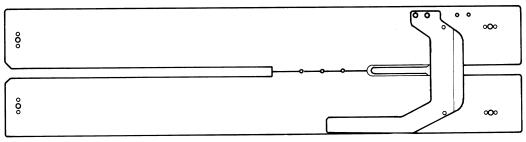
① 把后销子（左）（右）确实地安装到销孔。
② 把前销孔（左）（右）确实地安装到销子上。

1. 对于带有 SA-120N（芯布自动供给装置）的缝纫机，请注意不要让板弹簧弯曲向上抬起，把缝制机台❶、❷返回到原来的位置。

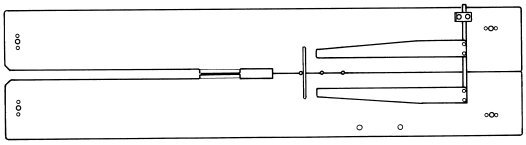


2. 对于以下的规格拆卸缝制机台❶、❷时，请注意不要弄弯袋布压脚和芯布压脚。

①袋布压脚（标准）

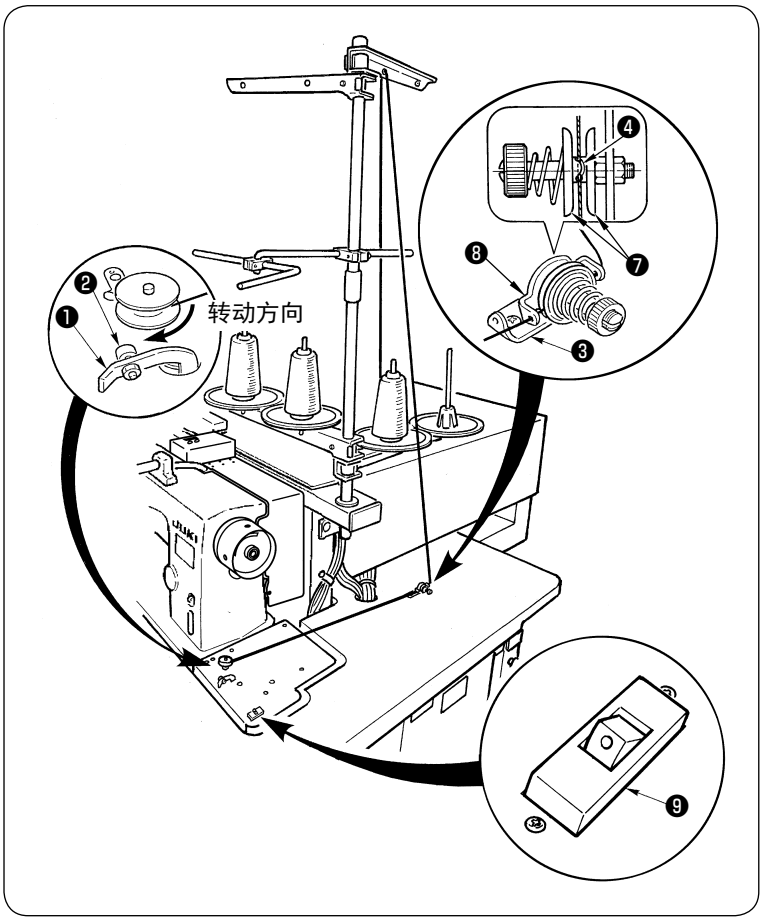


②袋布压脚（供给芯布用）



3. 底线的卷绕方法

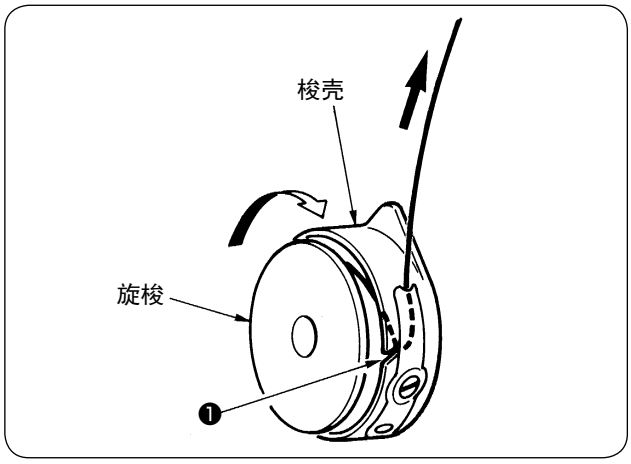
⚠注意 为了防止受伤，运转中请不要触摸。



① 把旋梭插入到绕线轴的最里面。
② 把机线穿过导线板❽，打开线张力盘❼，然后放入线张力杆❹的狭条里。
③ 按照图的顺序穿线，并在旋梭上卷绕 4 ～ 5 圈。（箭头方向是旋梭转动方向。）
④ 按了旋梭导线器❶之后，旋梭转动。
⑤ 卷绕完规定量的线之后，自动停止绕线。

1. 开始向旋梭卷绕线时，请从上图所示的槽❺开始卷绕。从❻开始卷绕后，底线用完的检测有可能发生误动作。
2. 为了稳定地确保底线的残量，旋梭上的线必须均匀地卷绕。特别是要注意开始卷绕的部分。如果线卷绕得不均匀的话，请调整线张力座❸的左右位置。
3. 底线最适合的卷绕量是卷绕旋梭外径的 80％左右。可以用卷绕量调节螺丝❷调节卷绕量。
4. 不卷绕机线时请不要按拨杆❶。有可能会发生马达转动不止的故障。

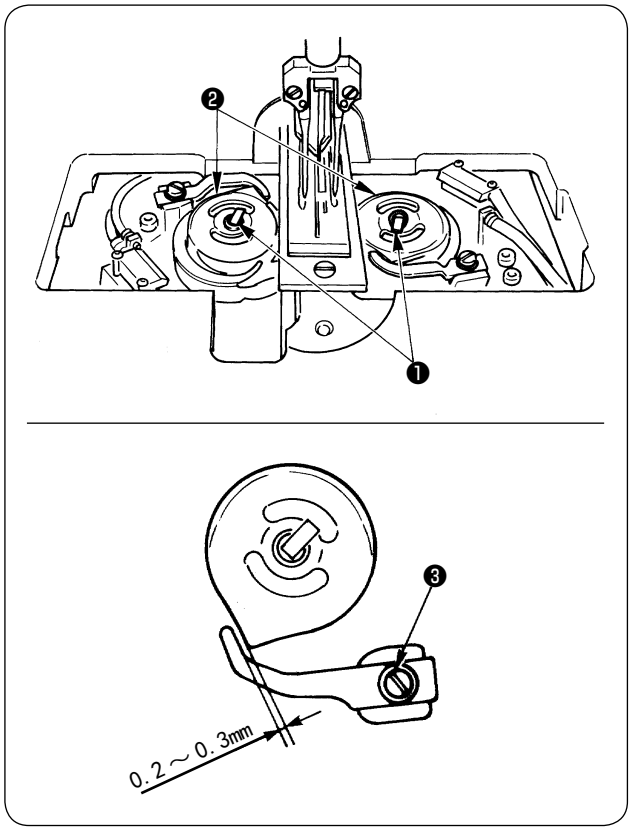
4. 梭壳的穿线方法



① 手拿旋梭，在线右卷的状态下放入梭壳里。
② 把线放入梭壳穿线槽❶。
③ 然后把线从线张力弹簧下面穿过。

5. 梭壳的安装

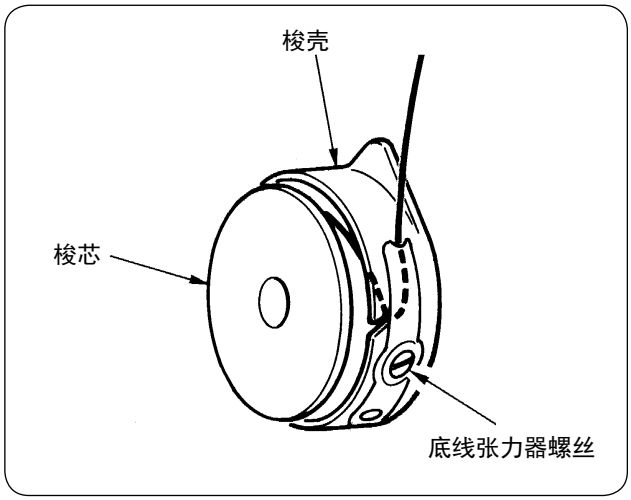
⚠注意 为了防止突然的起动造成事故，请关掉电源之后再进行操作。



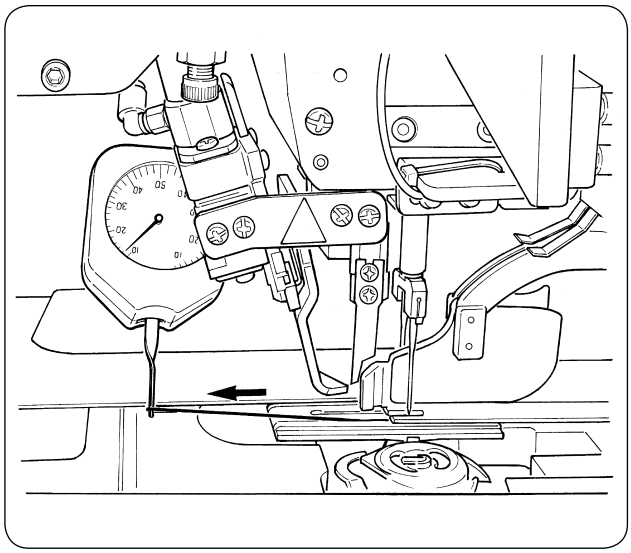
① 请拔起旋梭拨杆❶，把梭壳和旋梭一起取出来。
② 放入时，请正确地插入旋梭轴，然后放倒拨杆❶。

注意 左右更换梭壳❷时，请一定确认开放器在最后退位置时和梭壳的间隙量是否为 0.2～0.3mm。如果间隙量不是 0.2～0.3mm 的话，请拧松固定螺丝❸进行调整。

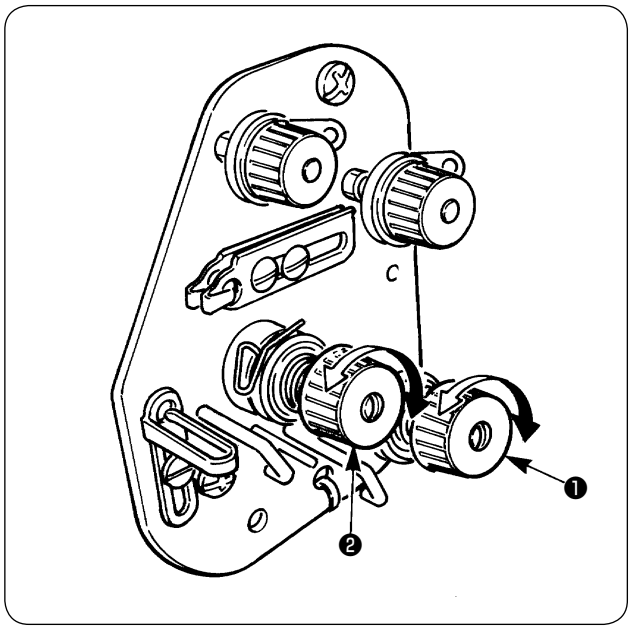
6. 线张力器的取下方法



① 底线张力的调整
向右转动底线张力器螺丝张力变强，向左转动则张力变弱。

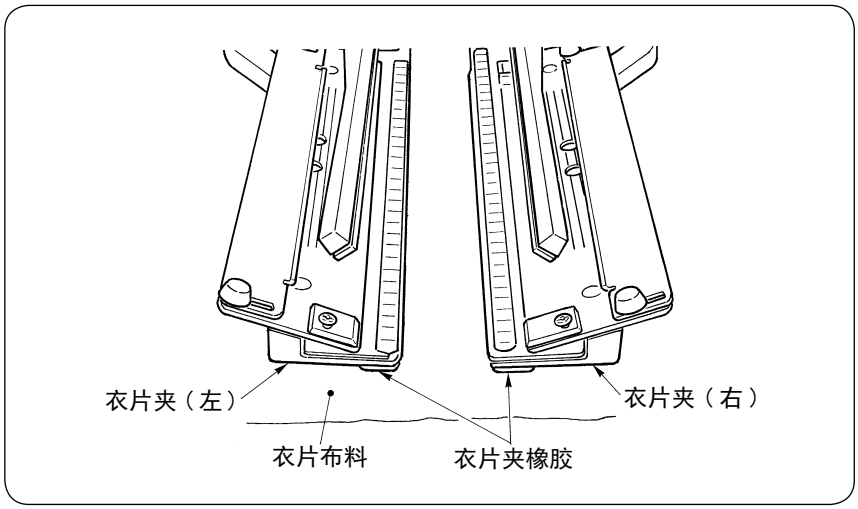


如左图所示那样，使用张力计进行测定时，底线的标准张力应为 0.25 ～ 0.35N。



② 上线张力的调整
首先调整右、左的底线张力。
根据右、左的底线张力，需要调整时右线张力器调整线张力器螺母❶，左线张力器调整线张力器螺母❷。向右转动线张力变强，向左转动则线张力变弱。

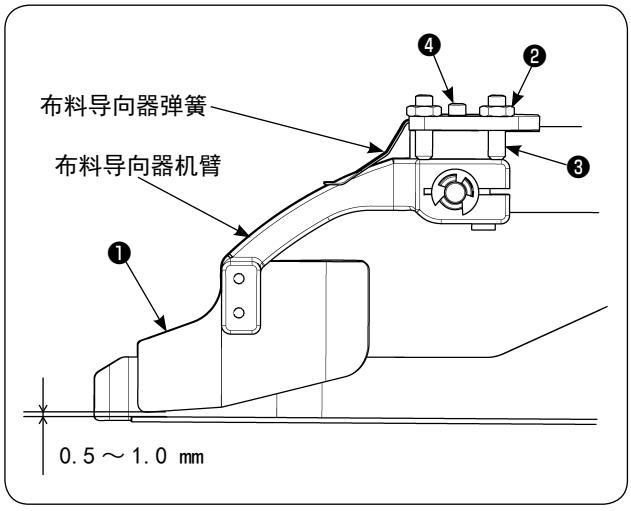
7. 缝制布料的安放



缝制的衣片布料请根据左右衣片夹下的衣片夹橡胶的大小，使用较大的布料。
用比衣片夹小的布料缝制的话，会发生橡胶脱落的故障。
缝制小布料时，请安装衬板规格（选购品）。

8. 布料导向器的调整

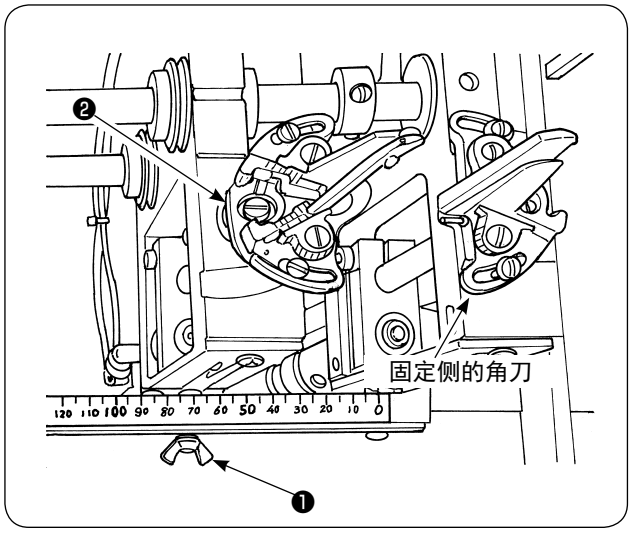
布料导向器具有缝制袋盖布时稳定缝纫机机针的作用。
请根据布料的厚度，调整布料导向器❶的高度和压脚压力。

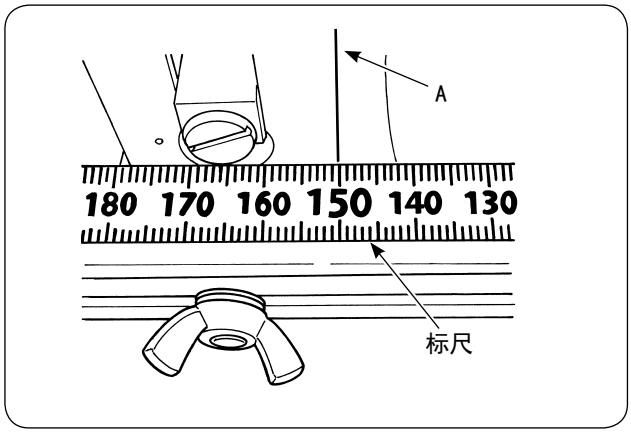


① 拧松螺母❷，然后用螺丝❸调整布料导向器的高度。
（有关布料导向器和袋布直尺的间隙，出货时调整为 0.5 ～ 1.0㎜）

② 压脚压力可以用弹簧压力调整螺丝❹进行调整。
（请调整成布料通过时没有阻挡阻力）

9. 调节角刀裁剪宽度





关于角刀宽度的调节，请松开固定螺丝❶，对准棱线 A 与希望设定的宽度的标尺格线，拧紧固定螺丝。

注意

1. 在调节之后，请确认移动一侧的角刀❷不会左右移动。
2. 在拉出时，请在解除肘夹之前，让移动一侧的角刀❷回到初始位置。
   如果在不位于初始位置的状态下拉出，角刀❷与工作台会接触，有可能造成角刀折损。

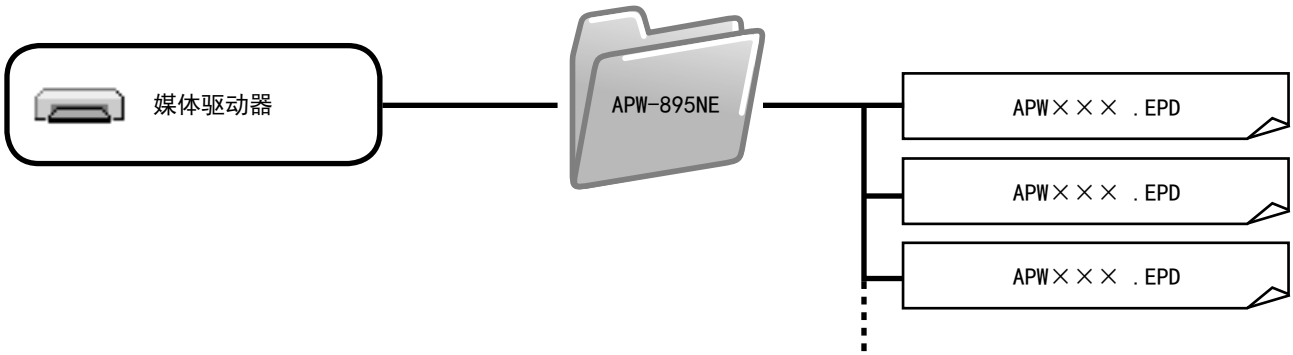
中文

VI. 操作盘的使用方法

1. 前言

1) **如果要将 APW-895NE 的数据（EPD 数据）用于别的 APW-895NE，**
在 APW-895NE 上使用 EPD 数据时，可以读取 IP-420 上相同的数据。
把媒体插进 IP-420，就可以从 EPD 数据中选择花样图案 No.xxx。

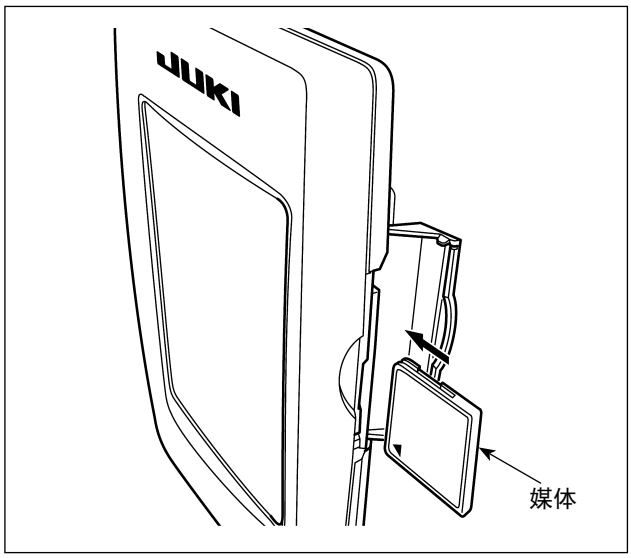
2) **媒体的文件夹构成**
请把各文件保存到媒体内的以下目录里。



注意 没有保存到上述的目录中的数据不能读取，请注意。

3) **关于 CompactFlash(TM)**

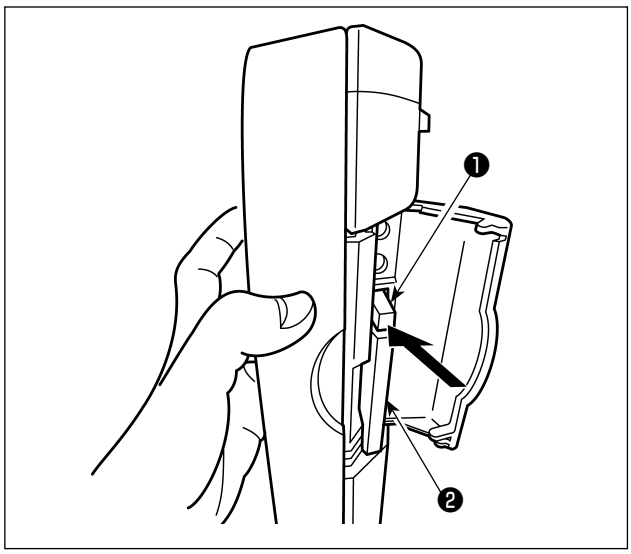
■ **CompactFlash(TM) 的插入方法**



1) 请把 CompactFlash (TM) 的标签正面朝向面前，（把边缘有缺口的部分朝向里侧）把有小孔的一头插入到操作盘里面。
2) 插完了媒体之后，请关闭护盖。关上了护盖之后，就可以进行存取。如果媒体和护盖相碰不能关闭护盖时，请确认以下事项。
   - 是否把媒体完全插进去了吗？
   - 媒体的插入方向是否正确？

注意
1. 媒体的插入方向弄错的话，有可能损坏操作盘和媒体。
2. 请不要插入 CompactFlash (TM) 以外的媒体。
3. IP-420 的插口可以对应 2GB 以下的 CompactFlash(TM)。
4. IP-420 的插口可以对应 FAT16 格式化的 CompactFlash(TM)。不对应 FAT32。
5. 请一定使用用 IP-420 格式化的 CompactFlash (TM)。有关 CompactFlash (TM) 的格式化方法，请参阅 "VI-16. 进行媒体的格式化时 " p.90。

■ CompactFlash(TM) 的取出方法



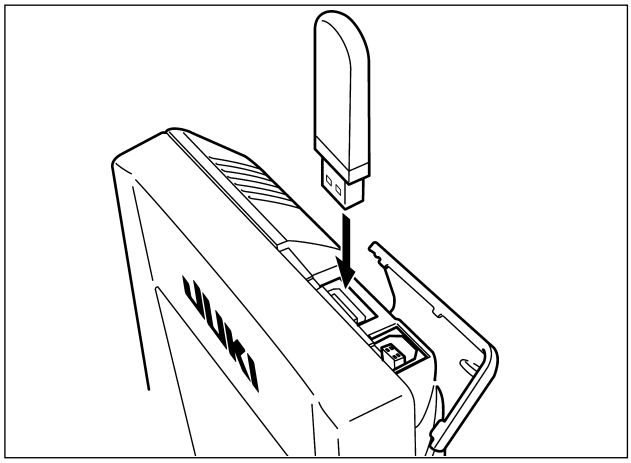
1） 请手拿面板，打开护盖，按下拨杆❶取出媒体。媒体❷即可以弹出来。

注意 用过大的力量按拨杆❶的话，媒体有可能飞弹出来，掉落到地上，而损坏媒体。

2） 取出弹出的媒体❷，这样就取出了媒体。

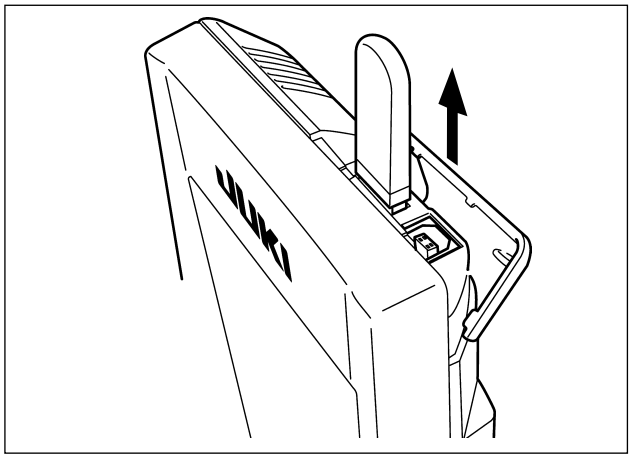
4） 关于 USB

■ USB 插入方法



请滑动上方的护罩，然后插入 USB 机器，把使用的数据复制到机器主体。
复制后，请取下 USB 机器。

■ USB 取出方法



请取下 USB 机器，然后安装上护罩。

⚠注意	使用记忆媒体时的注意事项 ： ・请不要弄湿媒体，也不要用潮湿的手去触摸媒体。有发生火灾或触电的危险。 ・请不要弯曲媒体，也不要给与媒体强力的冲击。 ・请绝对不要拆卸媒体，也不要改造媒体。 ・请不要用金属触击端子部。数据有可能消失。 ・请不要在以下的地点保管和使用媒体。 高温潮湿的地方　　结露的地方 灰尘多的地方　　容易产生静电、电气噪声的地方

① 有关使用 USB 的注意事项

- 缝制时，请不要在 USB 插口上连接着 USB 机器、USB 电缆进行运转。振动有时会造成连接器损坏，也有可能丢失 USB 的数据或发生 USB 机器、缝纫机的故障。
- 读取写入程序或缝制数据时，请不要插拔 USB 插头。
  有发生数据损坏或机器误动作的危险。
- 在 USB 机器的保存领域里划分分区后，可以仅与一个分区通讯。
- 有的 USB 机器可能本机不能正确地识别。
- 使用本机时，如果 USB 机器内的数据消失，本公司一律不予赔偿损失。
- 通讯画面、图案数据一览被显示上，插上媒体也不能识别驱动器。
- USB、CompactFlash(TM) 等的媒体原则上仅可以连接 1 台。如果连接了数台机器，只能识别 1 台。有关详细内容，查阅 USB 的规格。
- 请把 USB 连接器确实地深深插进 IP 操作盘的 USB 端子的里面。
- 在与 USB 上的数据进行存取的中途，请不要关闭 (OFF) 电源。

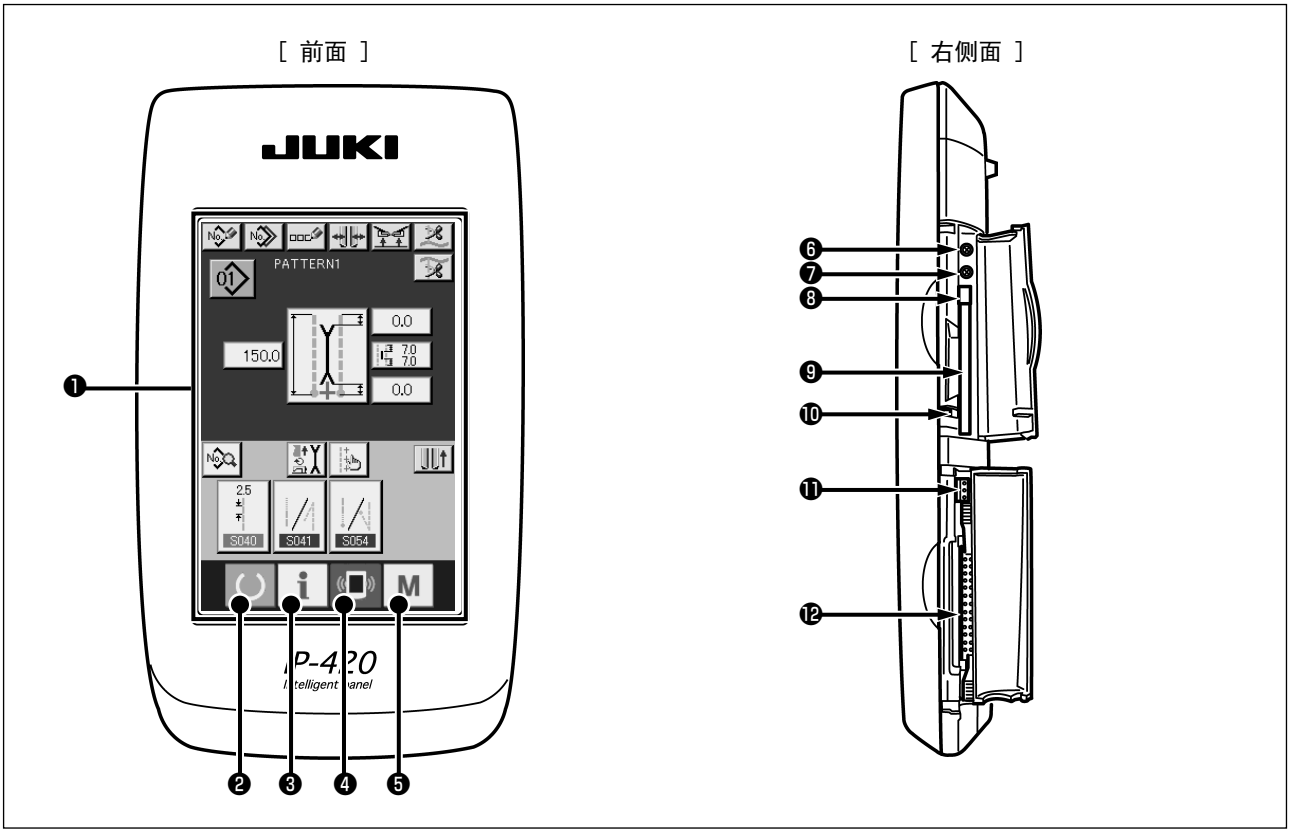
② USB 的规格

- 对应 USB 1.1 规格
- 对应机器 ※1 _____ USB 存储器、USB 集线器、FDD、读卡器的等记忆装置
- 不对应机器 _____ CD、DVD、MO、磁带驱动器等
- 对应格式 _____ FD(软盘)FAT12
  其他 (USB 存储器等)FAT12・FAT16・FAT32
- 对应媒体尺寸 ____ FD(软盘)1.44MB・720kB
  其他 (USB 存储器等)4.1MB ～ (2TB)
- 驱动器的识别 ____ 与 USB 机器等外部媒体通讯时，仅和最初识别的媒体通讯。但是向内装媒体插口插入了媒体时，向该媒体的通讯为最优先。（例：插入了 USB 存储器后，如果向媒体插口插入媒体则仅向媒体插口通讯。）
- 连接的限制 _____ 最多 10 装置（连接了超过最大限数时，超过限数的记忆媒体取下，不重新连接的话，就不能识别。）
- 消费电流 _____ 可以连接的 USB 机器的额定消费电流为最大 500mA。

※1 不能保证所有的对应机器的动作。由于不相匹配等问题，有的机器不能动作。

2. 操作盘（IP-420）的基本操作

(1) IP-420 各部的名称



符号	名称	说明
❶	触摸操作盘液晶显示部	
❷	准备完了键	进行数据失入画面和缝制画面的变换。
❸	信息键	进行数据输入画面和信息画面的变换。
❹	通讯键	进行数据输入画面和通讯画面的变换。
❺	模式变换键	进行数据输入画面和进行各种详细设定画面的模式变换画面的变换。
❻	对比度调节旋钮	
❼	亮度调节旋钮	
❽	CompactFlash(TM) 取出按键	
❾	CompactFlash(TM) 插口	
❿	盖子检测开关	
⓫	外部开关输入用连接器	
⓬	电气机器连接用连接器	

注意

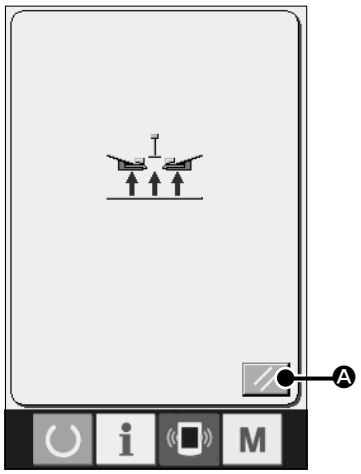
1. 操作触摸操作盘时，请用指尖按画面。用手指以外操作的话，有发生误动作或对画面表面的玻璃造成损伤的危险。
2. 打开电源后，第一次按下准备完了键时，进行大压角马达的原点检索。
   此时，大压脚可以移动，请注意。

(2) 通用的按钮

在 IP-420 的各画面上通用操作的按钮如下所示。

图标	名称	说明
	取消按钮	关闭凸起画面。 变更数据画面时，取消变更中的数据。
	确定按钮	确定变更的数据。
	上滚动按钮	向上方滚动按钮或显示。
	下滚动按钮	向下方滚动按钮或显示。
	复位按钮	解除异常错误等。
No.	数字输入按钮	显示十数字键，可以进行数字的输入。
	文字输入按钮	显示文字输入画面。

(3) 基本操作

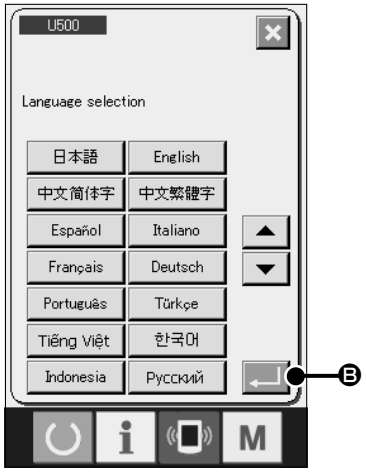


① **打开电源开关**

请首先打开电源开关。

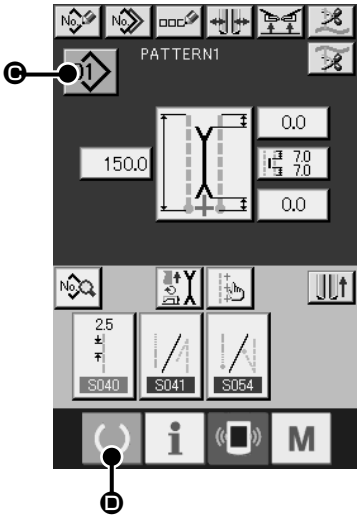
欢迎画面显示后，复位凸起画面显示出来。请按复位按钮 Ⓐ。

注意 **按了复位按钮之后，滚边器上升，因此请注意安全。**



接着，语言选择凸起画面被显示。选择了想显示的语言，按确定按钮 Ⓑ 之后，下图的单独缝制输入画面（画面 A）被显示。

重要 **不选择语言用取消按钮 或确定（回车）按钮 结束选择画面的话，每次打开电源之后均会显示语言选择画面。**



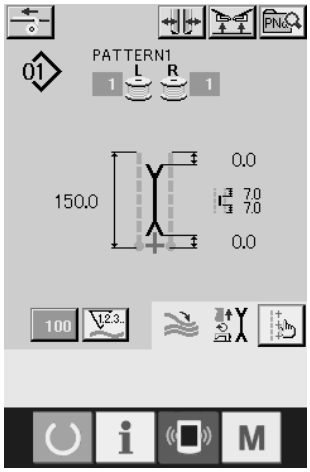
单独缝制输入画面（画面 A）

② 选择想缝制的图案 No.

按了图案 No. 按钮 01 Ⓒ 之后，可以选择图案 No.。有关图案 No. 的选择方法，请参阅 "VI-6.(1) 选择图案时 " p.40。

购买时，图案 No.1 ～ 10 被登记着，因此请根据缝制规格的情况变更缝制数据之后使用。（没有登记的图案号码不显示。）

参考 有关本画面的详细说明，请参阅 "VI-3. 基本画面的说明 " p.29。

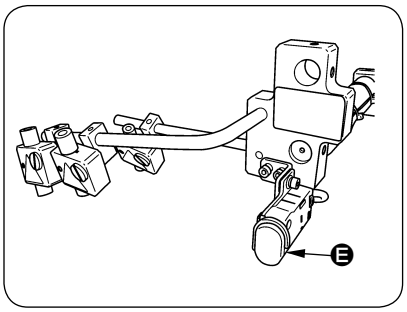


缝制画面（画面 B）

③ 开始缝制

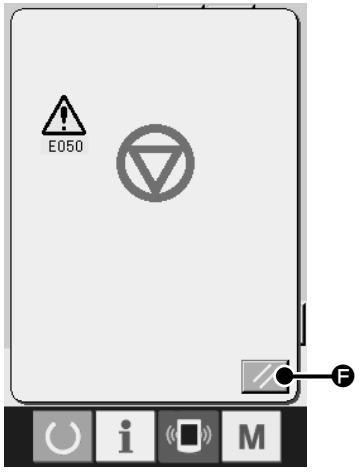
在单独缝制输入画面（画面 A）按了准备完了键 Ⓓ 之后，绿色的缝制画面（画面 B）被显示出来，一踩踏板就可以开始缝制。

参考 有关本画面的详细说明，请参阅 "VI-3. 基本画面的说明 " p.29。



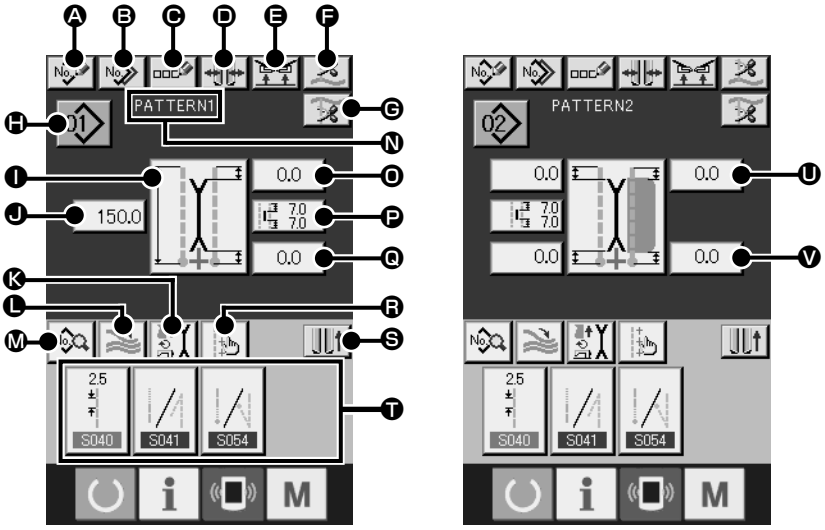
④ 操作中途停止装置时

缝制中按了中途停止开关 Ⓔ 之后，可以让装置停止。



此时，错误画面被显示出来，通知停止开关被按。按了复位按钮 Ⓕ 之后，错误被解除，然后返回到输入画面。

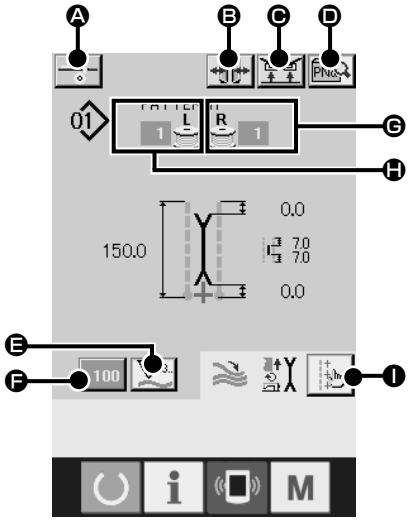
(1) 输入画面（单独缝制模式）



符号	按钮名称	内容
Ⓐ	新编制按钮	显示单独缝制图案新编制画面，可以新登记图案数据。
Ⓑ	复制按钮	显示单独缝制复制原图案一览画面，可以复制图案数据。
Ⓒ	文字输入按钮	显示文字输入画面，可以向图案数据输入名称。
Ⓓ	袋盖种类变换按钮	显示袋盖种类变换画面，可以变换袋盖种类和平行调整滚边器。
Ⓔ	禁止缝制结束时压脚上升按钮	按下按钮的状态，缝制结束时下降压脚然后返回。 调整标记光、试缝时使用的话，非常方便。
Ⓕ	切上线按钮	按了按钮之后，上线切刀下降，显示切上线动作画面。
Ⓖ	切底线按钮	按下按钮期间，底线切刀张开。
Ⓗ	图案 No. 一览按钮	显示图案 No. 一览画面，可以选择图案数据。
Ⓘ	缝制模式变换按钮	选择缝制模式 S003 。
Ⓙ	L 尺寸长度设定按钮	缝制 L 尺寸时，设定缝制长度 S004 。
Ⓚ	动作模式设定按钮	选择有无缝纫机马达、中心切刀、角切刀的动作 S001 。
Ⓛ	动作 / 停止堆积器的变换按钮	选择堆积器的动作 / 停止 S069 , S070 。
Ⓜ	显示缝制数据按钮	显示缝制图案编辑画面。选择在输入画面上没有显示的详细缝制数据，可以进行编辑。
Ⓝ	显示图案名称	显示图案 No. 上输入的名称。
Ⓞ	开始缝制时角刀动作位置设定按钮	设定开始缝制时角刀的切断位置 S019 。
Ⓟ	中心切刀设定按钮	显示中心切刀数据编辑画面，设定开始缝制 S017 、结束缝制 S018 的中心切刀切断位置。
Ⓠ	结束缝制时角刀动作位置设定按钮	设定结束缝制时角刀的切断位置 S020 。
Ⓡ	标记光设定按钮	可以通过让 K052 变更为以前的动作模式，选择缝纫标准。 （但是，光标记的调节是手动调节。）
Ⓢ	大压脚移动按钮	让大压脚前进或者后退。
Ⓣ	缝制数据快捷按钮	显示缝制画面随机设定的缝制数据的快捷按钮（最大 4 个项目）。
Ⓤ	开始缝制落袋盖数据设定按钮	设定开始缝制时落袋盖数据 S008 或 S010 。
Ⓥ	结束缝制落袋盖数据设定按钮	设定结束缝制时落袋盖数据 S009 或 S011 。

＊ 可以随机设定各按钮的显示 / 不显示。
详细内容请参照 "VI-12. **管理数据输入画面时** " p. 73。

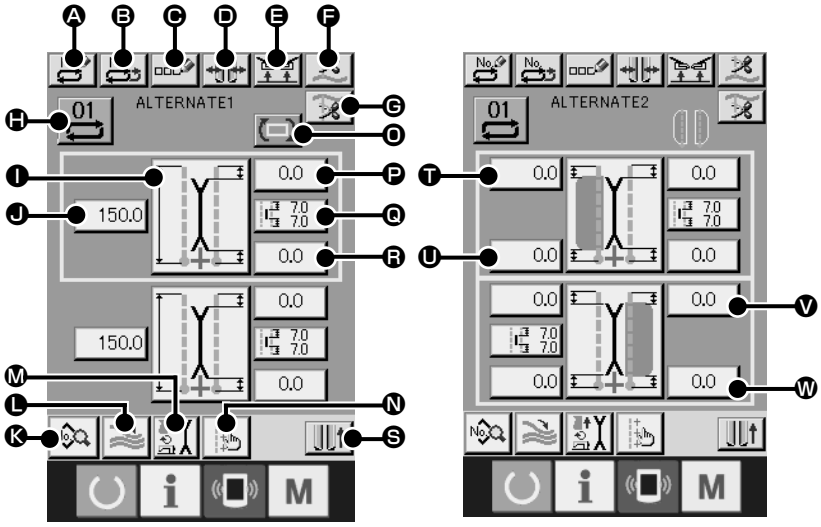
(2) 缝制画面（单独缝制模式）



符号	按钮名称	内容
Ⓐ	供给芯布按钮	按了按钮之后，供给芯布。 ＊ 选项设定时，设定为〝有〞 SA120 芯布自动供给装置时显示。
Ⓑ	袋盖种类变换按钮	显示袋盖种类变换画面，可以变换袋盖种类和平行调整滚边器。
Ⓒ	缝制结束时禁止压脚上升按钮	按下压脚后，结束缝制时下降压脚然后返回。 调整标记光、试缝时使用的话，非常方便。
Ⓓ	直接图案一览按键	显示出直接图案一览画面，可以选择缝制数据。
Ⓔ	计数器变换按钮	按了按钮之后，变换缝制计数器和件数计数器的显示。 ＊ 仅缝制计数器、件数计数器两方都ＯＮ时显示按钮。
Ⓕ	计数器值变更按钮	变更现在显示着的计数器值。
Ⓖ	底线（右）残量值	检测从梭芯照射的反射光，通知底线残量变少。计数器值每 1 缝制减 1，达到 0 之后，显示计数器画面。 ＊ 仅检测出梭芯的反射光时显示。
Ⓗ	底线（左）残量值	检测从梭芯照射的反射光，通知底线残量变少。计数器值每 1 缝制减 1，达到 0 之后，显示计数器画面。 ＊ 仅检测出梭芯的反射光时显示。
Ⓘ	标记光设定按钮	可以通过让 K052 变更为以前的动作模式，选择缝纫标准。 （但是，光标记的调节是手动调节。）

＊　可以随机设定各按钮的显示 / 不显示。
详细内容请参照 "VI-12. **管理数据输入画面时** " p. 73。

(3) 输入画面（交替缝制模式）

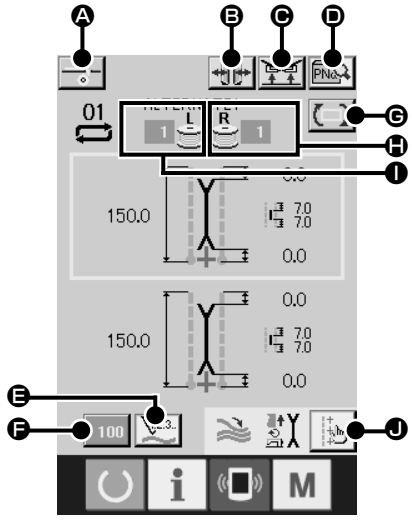


符号	按钮名称	内容
Ⓐ	新编制按钮	显示交替缝制数据新编制画面，可以进行数据的新登记。
Ⓑ	复制按钮	显示交替缝制数据复制原 No. 一览画面，可以复制交替缝制数据。
Ⓒ	文字输入按钮	显示文字输入画面，可以向交替缝制数据输入名称。
Ⓓ	袋盖种类变换按钮	显示袋盖种类变换画面，可以变换袋盖种类和平行调整滚边器。
Ⓔ	结束缝制时禁止压脚上升按钮	按下按钮后，结束缝制时下降压脚然后返回。 调整标记光、试缝时使用的话，非常方便。
Ⓕ	切上线按钮	上线切刀下降，显示切上线动作中画面。
Ⓖ	切底线按钮	按下按钮期间，底线切刀张开。
Ⓗ	交替缝制数据 No. 一览按钮	显示交替缝制数据 No. 一览画面，可以选择交替缝制数据。
Ⓘ	缝制模式变换按钮	选择缝制模式 S003 。
Ⓙ	设定 L 尺寸长度按钮	缝制 L 尺寸时，设定缝制长度 S004 。
Ⓚ	显示缝制数据按钮	显示缝制图案编辑画面。选择在输入画面上没有显示的详细缝制数据，可以进行编辑。
Ⓛ	堆积器动作 / 停止的变换按钮	选择堆积器的动作 / 停止 S069 , S070 。
Ⓜ	设定动作模式按钮	选择有无缝纫机马达、中心切刀、角刀的动作 S001 。
Ⓝ	设定标记光按钮	可以通过让 K052 变更为以前的动作模式，选择缝纫标准。 （但是，光标记的调节是手动调节。）
Ⓞ	下一缝制数据变换按钮	变换黄色框包围的下一缝制图案。 ＊ 选择袋盖优先缝制 S002 ON 时不显示。
Ⓟ	设定开始缝制角刀动作位置按钮	设定开始缝制角刀的切断位置 S019 。
Ⓠ	设定中心切刀按钮	显示中心切刀数据编辑画面，设定开始缝制 S017 、结束缝制 S018 的中心刀切断位置。
Ⓡ	设定结束缝制角刀动作位置按钮	设定结束缝制角刀的切断位置 S020 。
Ⓢ	移动大压脚按钮	让大压脚前进或后退。
Ⓣ、Ⓥ	设定开始缝制袋盖下落数据按钮	设定开始缝制袋盖下落数据 S008 或 S010 。
Ⓤ、Ⓦ	设定开始缝制袋盖下落数据按钮	设定开始缝制袋盖下落数据 S009 或 S011 。

＊ 可以随机设定各按钮的显示 / 不显示。

详细内容请参照 "VI-12. **管理数据输入画面时** " p. 73。

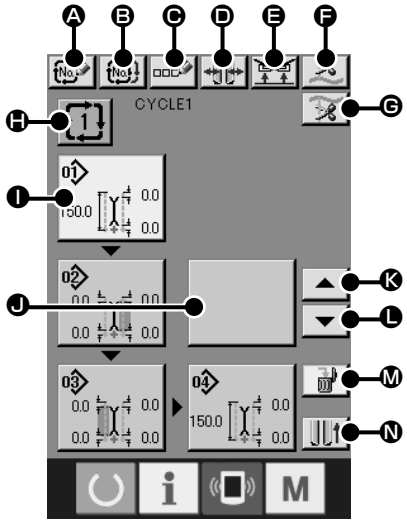
(4) 缝制画面（交替缝制模式）



符号	按钮名称	内容
Ⓐ	供给芯布按钮	按下按钮之后供给芯布。 ＊ 选项设定时，设定为〝有〞 SA120 芯布自动供给装置时显示。
Ⓑ	变换袋盖种类按钮	显示袋盖种类变换画面，可以变换袋盖种类和平行调整滚边器。
Ⓒ	结束缝制时禁止压脚上升按钮	按下压脚后，结束缝制时下降压脚然后返回。 调整标记光、试缝时使用的话，非常方便。
Ⓓ	直接图案一览按键	显示出直接图案一览画面，可以选择缝制数据。
Ⓔ	变换计数器按钮	按了按钮之后，变换缝制计数器和件数计数器的显示。仅缝制计数器、件数计数器两方都 ON 时显示按钮。
Ⓕ	变更计数器值按钮	变更现在显示着的计数器值。
Ⓖ	变换下一缝制数据按钮	变换黄色框包围的下一缝制图案。 ＊ 选择袋盖优先缝制 S002 ON 时不显示。
Ⓗ	底线（右）残量值	检测从梭芯照射的反射光，通知底线残量变少。计数器值每 1 缝制减 1，达到 0 之后，显示计数器画面。 ＊ 仅检测出梭芯的反射光时显示。
Ⓘ	底线（左）残量值	检测从梭芯照射的反射光，通知底线残量变少。计数器值每 1 缝制减 1，达到 0 之后，显示计数器画面。 ＊ 仅检测出梭芯的反射光时显示。
Ⓙ	设定标记光按钮	可以通过让 K052 变更为以前的动作模式，选择缝纫标准。 （但是，光标记的调节是手动调节。）

＊ 可以随机设定各按钮的显示 / 不显示。
详细内容请参照 "VI-12. **管理数据输入画面时** " p. 73。

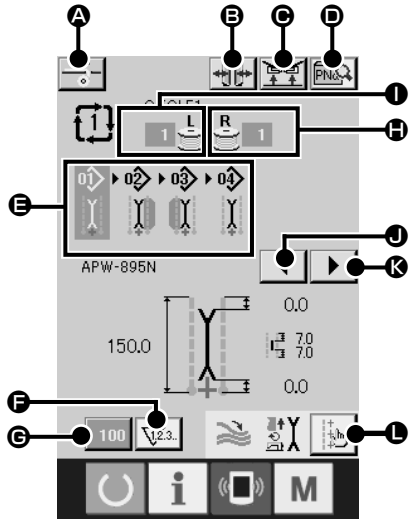
(5) 输入画面（循环缝制模式）



符号	按钮名称	内容
Ⓐ	新编制按钮	显示循环缝制数据新编制画面，可以进行循环缝制数据的新登记。
Ⓑ	复制按钮	显示循环缝制数据复制原 No. 一览画面，可以复制循环缝制数据。
Ⓒ	文字输入按钮	显示文字输入画面，可以向循环缝制数据输入名称。
Ⓓ	袋盖种类变换按钮	显示袋盖种类变换画面，可以变换袋盖种类和平行调整滚边器。
Ⓔ	结束缝制时禁止压脚上升按钮	按下按钮后，结束缝制时下降压脚然后返回。 调整标记光、试缝时使用的话，非常方便。
Ⓕ	切上线按钮	上线切刀下降，显示切上线动作中画面。
Ⓖ	切底线按钮	按下按钮期间，底线切刀张开。
Ⓗ	循环缝制数据 No. 一览按钮	显示循环缝制数据 No. 一览画面，可以选择循环缝制数据。
Ⓘ	编辑图案数据按钮	可以编辑循环缝制数据里登记的图案数据。 ＊ 编辑方法请参照 "3-(1) **输入画面（单独缝制模式）**" p. 29。
Ⓙ	编辑图案数据按钮（空白）	按了空白按钮之后，显示出向循环缝制数据登记用的图案一览画面，可以选择然后进行登记。
Ⓚ	循环后移按钮	向前 1 个移动白色强调显示的下一缝制图案数据。第 1 个图案时向最后的图案移动。
Ⓛ	循环前移按钮	向后 1 个移动白色强调显示的下一缝制图案数据。最后的图案时向第 1 个图案移动。
Ⓜ	删除图案数据按钮	从登记数据中删除白色强调显示的图案数据。
Ⓝ	移动大压脚按钮	让大压脚前进或后退。

＊ 可以随机设定各按钮的显示 / 不显示。
详细内容请参照 "VI-12. **管理数据输入画面时** " p. 73。

(6) 缝制画面（循环缝制模式）

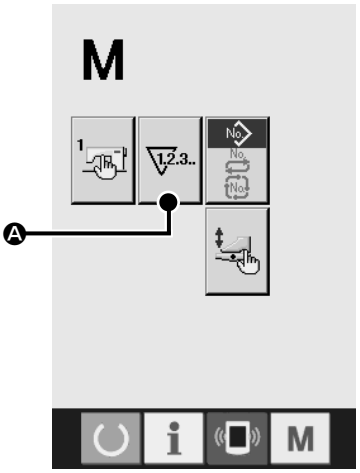


符号	按钮名称	内容
Ⓐ	供给芯布按钮	按下按钮之后供给芯布。 ＊ 选项设定时，设定为〝有〞 SA120 芯布自动供给装置时显示。
Ⓑ	变换袋盖种类按钮	显示袋盖种类变换画面，可以变换袋盖种类和平行调整滚边器。
Ⓒ	结束缝制时禁止压脚上升按钮	按下压脚后，结束缝制时下降压脚然后返回。 调整标记光、试缝时使用的话，非常方便。
Ⓓ	直接图案一览按键	显示出直接图案一览画面，可以选择缝制数据。
Ⓔ	显示循环数据	显示循环缝制数据里登记的全部图案数据。
Ⓕ	变换计数器按钮	按了按钮之后，变换缝制计数器和件数计数器的显示。仅缝制计数器、件数计数器两方都 ON 时显示按钮。
Ⓖ	变更计数器值按钮	变更现在显示着的计数器值。
Ⓗ	底线（右）残量值	检测从梭芯照射的反射光，通知底线残量变少。计数器值每 1 缝制减 1，达到 0 之后，显示计数器画面。 ＊ 仅检测出梭芯的反射光时显示。
Ⓘ	底线（左）残量值	检测从梭芯照射的反射光，通知底线残量变少。计数器值每 1 缝制减 1，达到 0 之后，显示计数器画面。 ＊ 仅检测出梭芯的反射光时显示。
Ⓙ	左滚动按钮	向前 1 个移动下一缝制图案数据。第 1 个图案时向最后的图案移动。
Ⓚ	右滚动按钮	向后 1 个移动下一缝制图案数据。最后的图案时向第 1 个图案移动。
Ⓛ	设定标记光按钮	可以通过让 K052 变更为以前的动作模式，选择缝纫标准。 （但是，光标记的调节是手动调节。）

＊ 可以随机设定各按钮的显示 / 不显示。
详细内容请参照 "VI-12. **管理数据输入画面时** " p. 73。

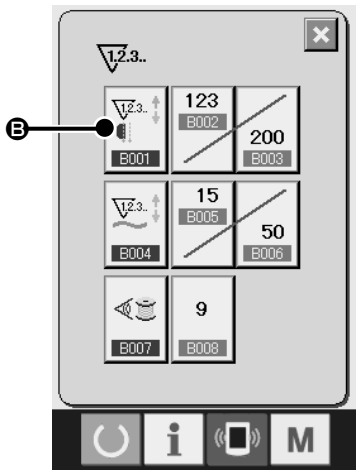
4. 使用计数器时

(1) 计数器的设定方法



① **显示设定计数器画面**

在输入画面按了模式变换键 M 之后，画面上计数器设定按钮 Ⓐ 显示出来。按了此按钮之后，″设定计数器画面（画面 A）显示出来。



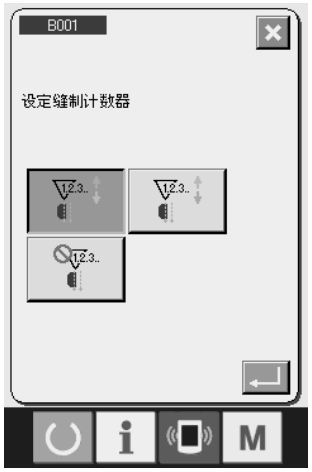
设定计数器设定画面
（画面 A）

② **选择计数器种类**

本缝纫机上安装有缝制计数器、件数计数器、底线残量调整计数器 3 种计数器。

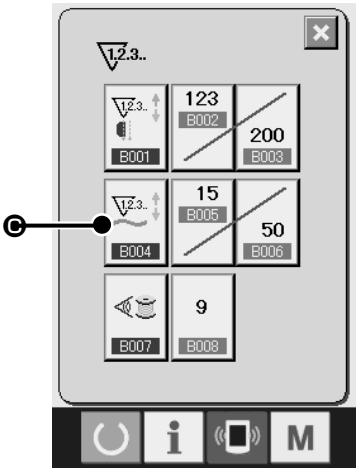
重要 **但是，在 APW-895NE 上，无法使用下丝残量调节计数器。**

在″设定计数器画面（画面 A）″上按了缝制计数器按钮 Ⓑ 之后，″设定缝制计数器画面（画面 B）显示出来，可以设定计数器的种类。



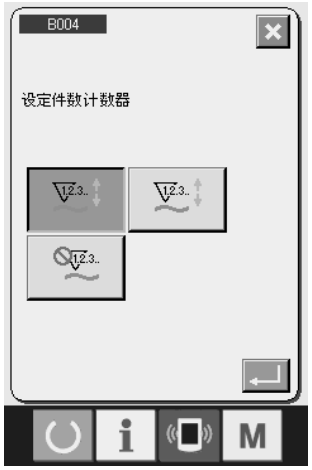
设定缝制计数器画面
（画面 B）

【 缝制计数器 】	
	加数计数器 ： 每进行 1 缝制，对现在值进行加算计数。现在值和设定值相等之后，显示计数器画面。
	减数计数器 ： 每进行 1 缝制，对现在值进行减算计数。现在等于 0 之后，显示计数器画面。
	未使用计数器 ： 设定为禁止使用的缝制计数器。



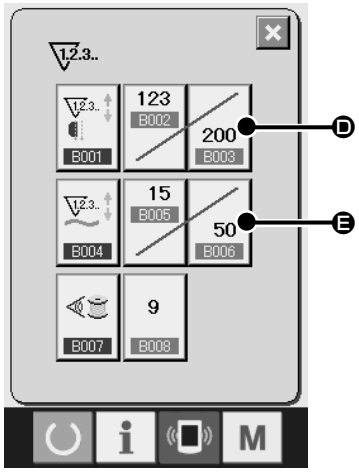
设定计数器画面（画面 A）

在″设定计数器画面（画面 A)″，按了件数计数器按钮 Ⓒ之后，″设定件数计数器画面（画面 C)″被显示出来，可以设定计数器种类。



设定件数计数器（画面 C）

【 件数计数器 】	
	加数计数器 ： 每进行 1 缝制，对现在值进行加算计数。 ＊ 单独缝制时为 1 缝制 交替缝制时为 2 缝制 循环缝制时为 1 循环缝制 作为 1 件计算。 现在值和设定值相等之后，显示计数器画面。
	减数计数器 ： 每进行 1 缝制，对现在值进行减算计数。现在等于 0 之后，显示计数器画面。
	未使用计数器 ： 设定为禁止使用的件数计数器。



③ 变更计数器目标值

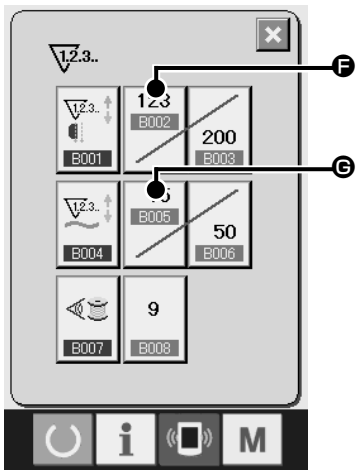
缝制计数器时按了按钮

Ⓓ，件数计算器时按了按钮

Ⓔ 之后，设置设定凸起画面（画面 D）被显示，可以设定计数器目标值。

数值设定凸起画面（画面 D）

在这里，请输入计数器目标值。向计数器目标值输入 0 之后，缝制中仅显示现在值，不显示计数器加数画面。



④ 变更计数器现在值

缝制计数器时按按钮

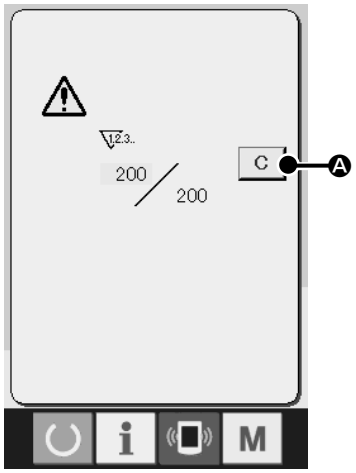
Ⓕ，件数计数器时按按钮

Ⓖ 之后，数值设定凸起画面（画面 E）被显示出来，可以设定计数器现在值。

数值设定凸起画面（画面 E）

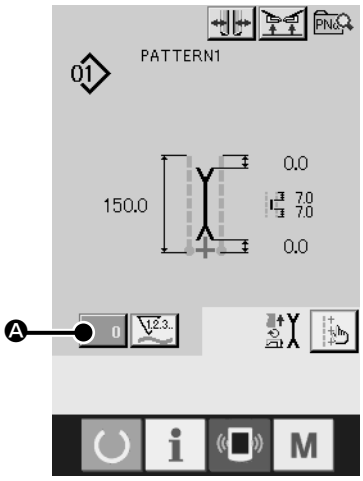
在这里，请输入计数器现在值。

(2) 计数的解除方法



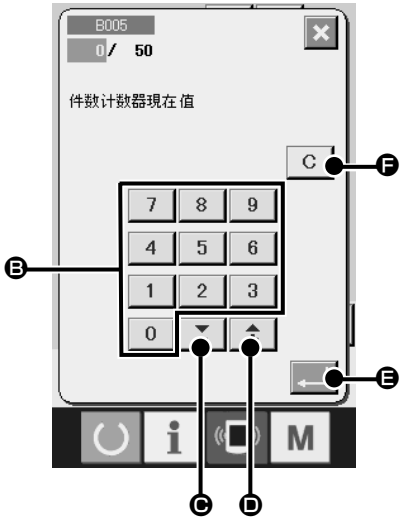
在缝制中，达到了计数条件之后，显示计数画面，蜂鸣器鸣响。按了清除按钮 C Ⓐ 之后，复位计数器，返回缝制画面。然后重新开始计数。

(3) 变更缝制中的计数器值的方法



① **显示变更计数器值画面**

在缝制中想修正计数器值时，请按缝制画面上的变更计数器值按钮 0 Ⓐ。变更计数器值画面被显示出来。



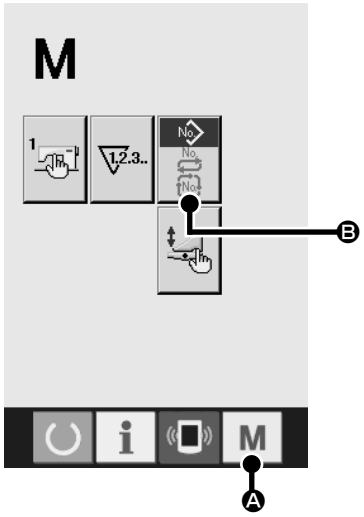
② **变更计数器值**

请用十数字键 0 ～ 9 Ⓑ 或者用▼▲按钮 Ⓒ（ Ⓓ）变更计数器值。

③ **确认计数器值**

按了确定按钮 Ⓔ 之后，确定数据。想清除计数器值时，请按清除按钮 C Ⓕ。

5. 变更缝制模式时

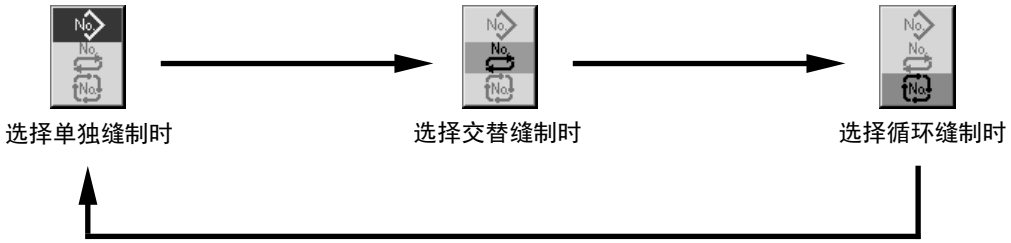


① 显示选择缝制模式画面

按了模式变换键 M Ⓐ 之后，模式变换画面被显示出来。

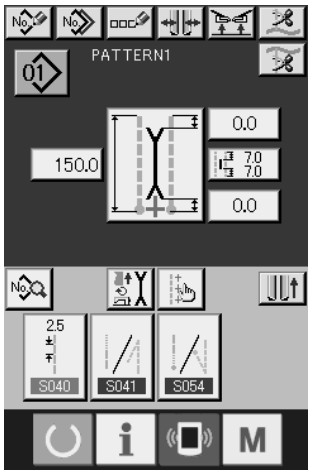
② 选择缝制模式

按了选择模式按钮 Ⓑ 之后，按钮的显示变换。

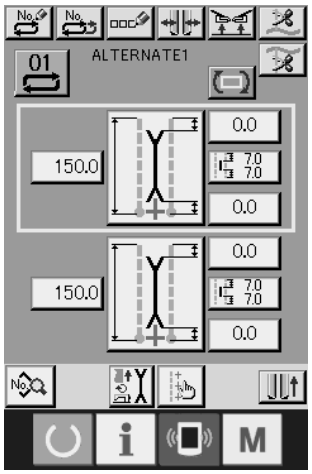


③ 确定缝制模式

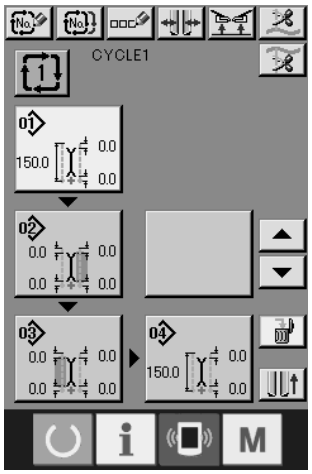
按了模式变换键 M Ⓐ 之后，显示出选择的缝制模式的输入数据画面。



交替缝制输入画面



单独缝制输入画面



循环缝制输入画面

6. 使用缝制图案时

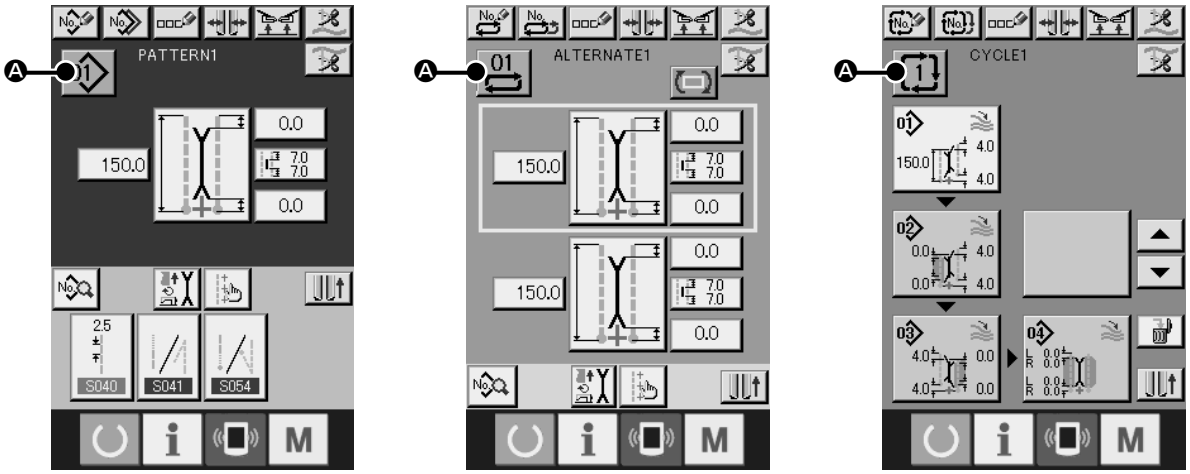
(1) 选择图案时

① 显示输入画面

显示出单独缝制模式、交替缝制模式、循环缝制模式的输入画面之后，便可以选择图案。
随机地显示缝制画面，也可以从缝制画面选择图案。

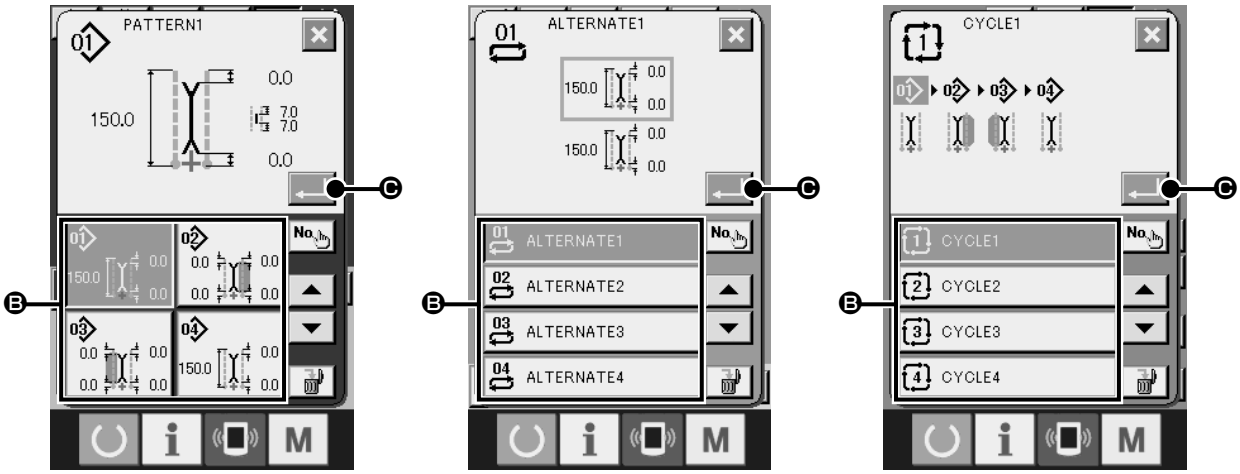
② 叫出图案一览画面

按了图案一览按钮 Ⓐ 之后，图案一览画面被显示出来。



③ 选择图案

请按想选择的图案数据 Ⓑ。



④ 确定图案

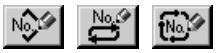
按了确定按钮 Ⓒ 之后，图案被选择，返回到输入画面。

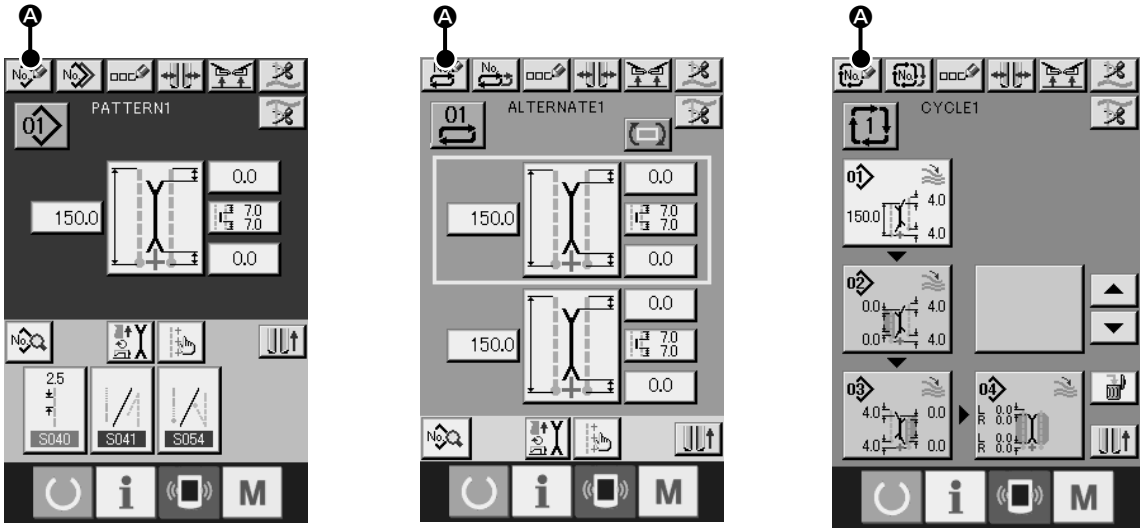
(2) 新编制图案时

① 显示输入输入画面

显示出单独缝制模式、交替缝制模式、循环缝制模式的输入画面之后，便可以新编制图案。

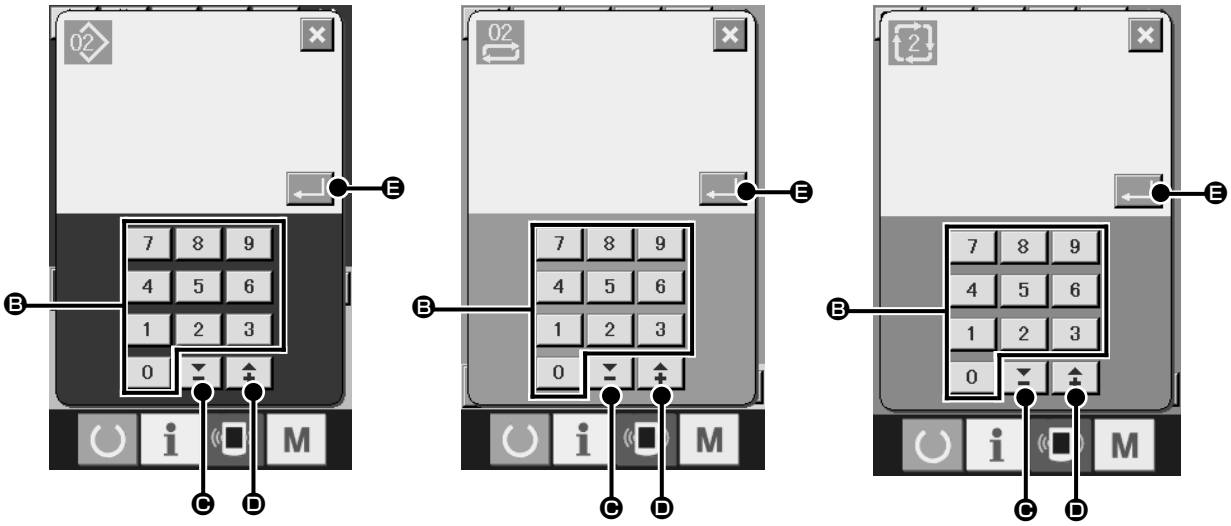
② 叫出新编制缝制图案画面

按了新编制按钮  Ⓐ 之后，新编制图案画面被显示出来。



③ 输入图案 No.

请用十数字键 0 ～ 9 Ⓑ 输入想新编制的图案 No.。也可以用▼▲按钮 Ⓒ・Ⓓ 检索未登记的缝制图案 No.。



④ 确定图案 No.

按了确定按钮 Ⓔ 之后，确定新编制的图案 No.，然后返回输入画面。

(3) 复制图案时

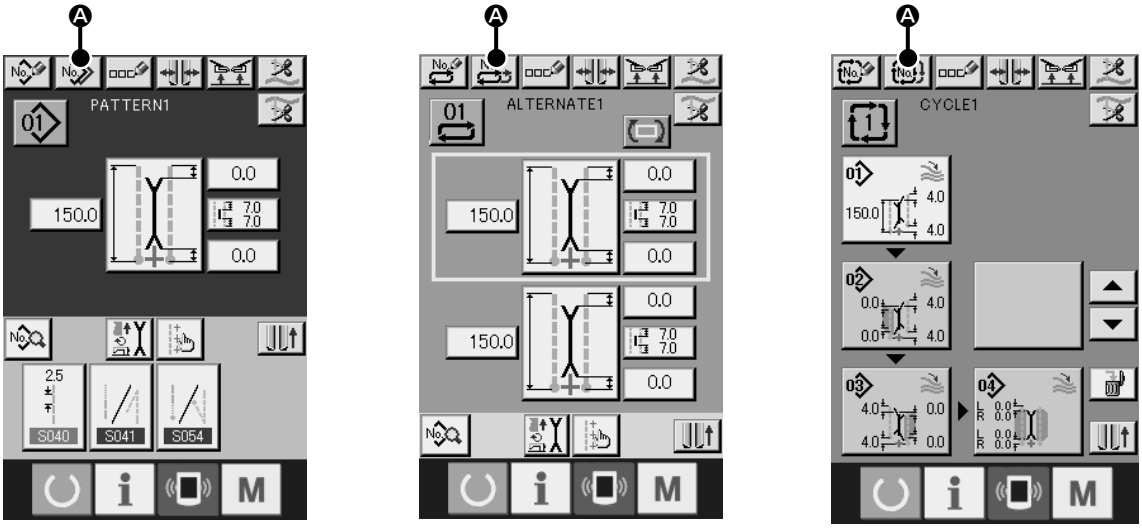
可以把已经登记的图案复制到为登记的缝制图案里。因为禁止图案改写复制，所以想改写时，请事先删除该图案。

→ 有关图案的删除方法请参阅 "VI-6.(4) 删除图案时 " p.44。

注意 想要向已经登记完了的图案 No. 复制时，不能复制错误（E401）会显示出来。

① 显示输入画面

显示出单独缝制模式、交替缝制模式、循环缝制模式的输入画面之后，便可以复制图案。



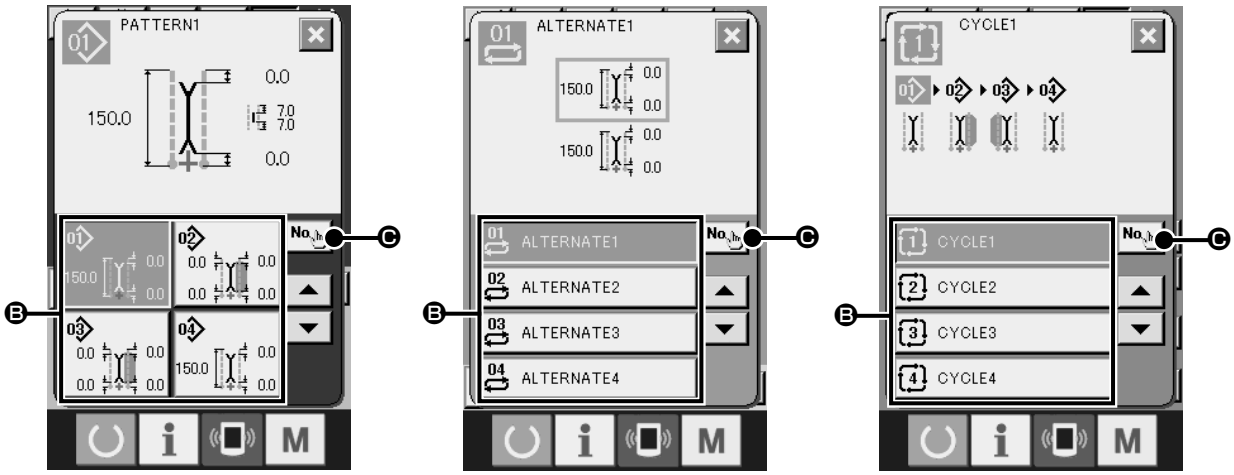
② 叫出复制原图案 No. 一览画面

按了复制图案按钮 Ⓐ 之后，复制原图案一览画面被显示出来。

③ 选择复制原图案

请从图案一览按钮 Ⓑ 中选择复制原图案。

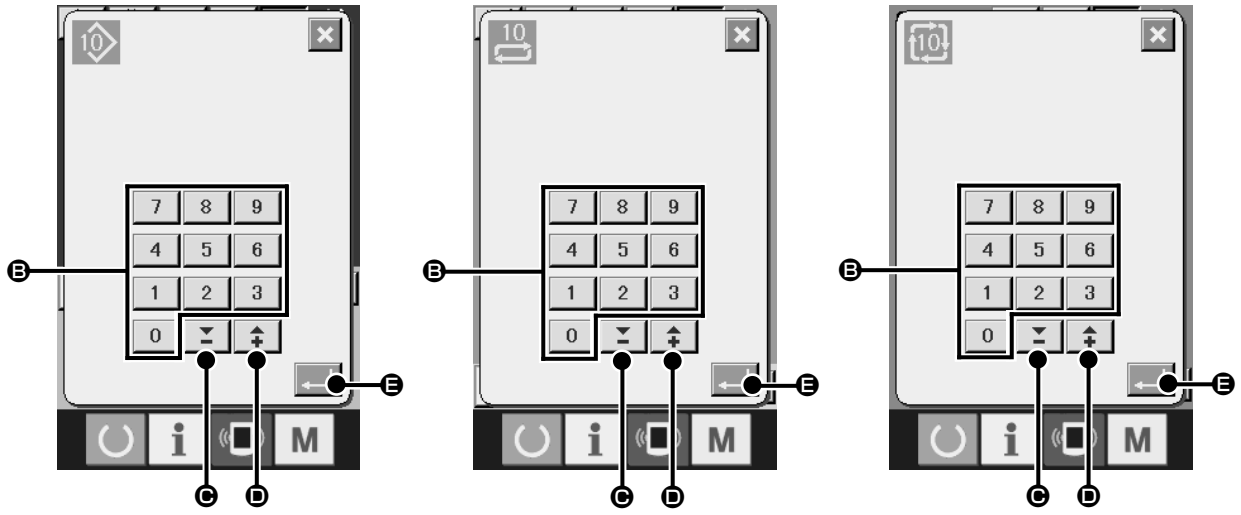
接着，按了复制原图案 No. 输入按钮 [No.] Ⓒ 之后，复制原图案 No. 输入画面（画面 B）被显示出来。



复制原图案一览画面（画面 A）

④ 输入复制处的图案 No.

请用十数字键 [0] ～ [9] Ⓑ 输入复制原图案 No.。也可以用▼▲按钮（ [▼] Ⓒ・[▲] Ⓓ）检索未使用的图案。



复制原图案 No. 输入画面（画面 B）

⑤ 开始复制

按了确定按钮 [↵] Ⓔ 之后开始复制。被复制的图案 No. 在选择状态将返回复制原图案一览画面（画面 A）。

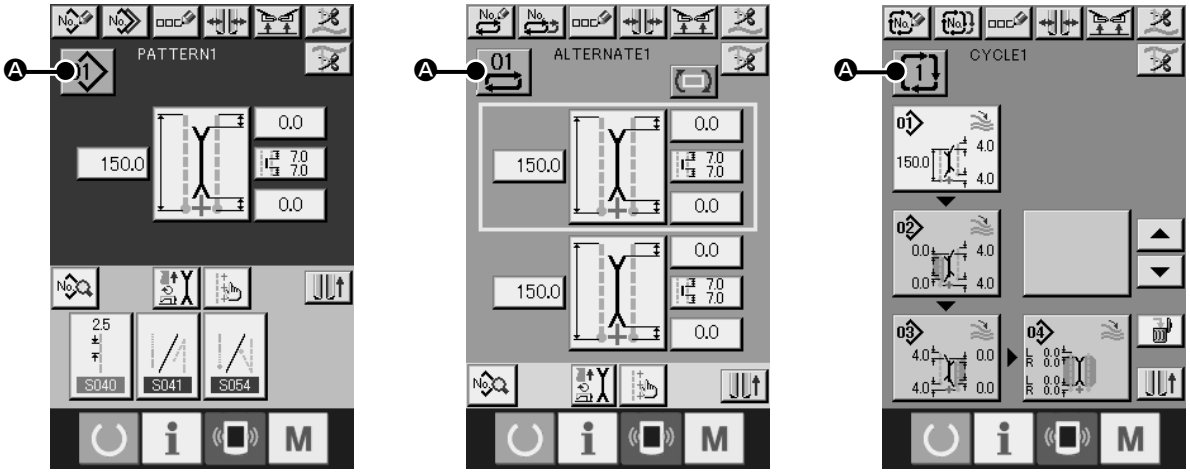
(4) 删除图案时

① 显示输入画面

显示出单独缝制模式、交替缝制模式、循环缝制模式的输入画面之后，便可以删除图案。

② 叫出图案一览画面

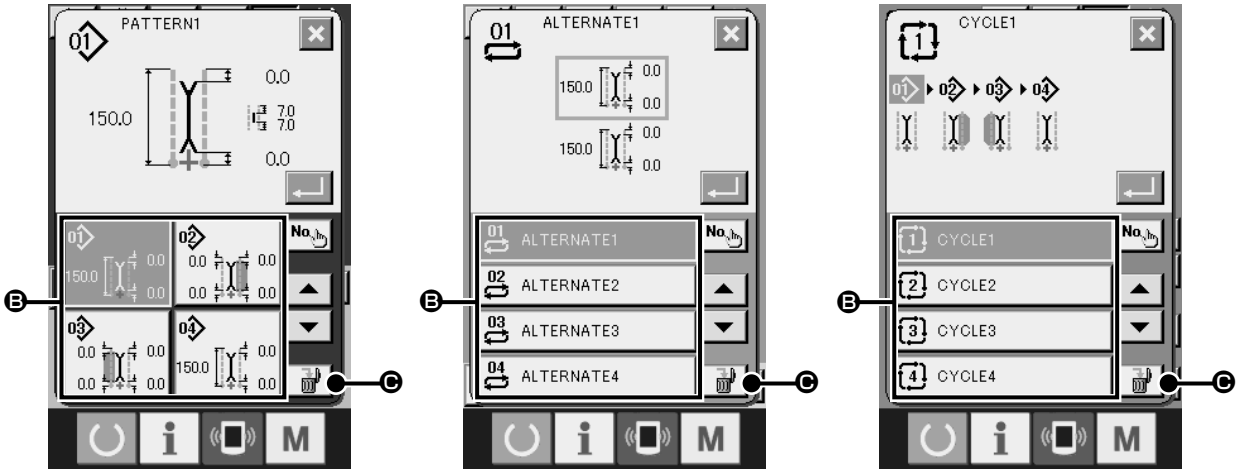
按了图案一览按钮 Ⓐ 之后，图案 No. 一览画面（画面 A）被显示出来。



③ 选择删除的图案

请从图案一览按钮 Ⓑ 中选择删除的图案。

接着，选择了删除按钮 Ⓒ 之后，确认图案删除画面被显示出来。



图案 No. 一览画面（画面 A）

④ 确定删除的图案

在确认图案删除画面上，按了确定按钮 之后，图案被删除。

如果按取消按钮 的话，则不删除返回到原来的画面 A。

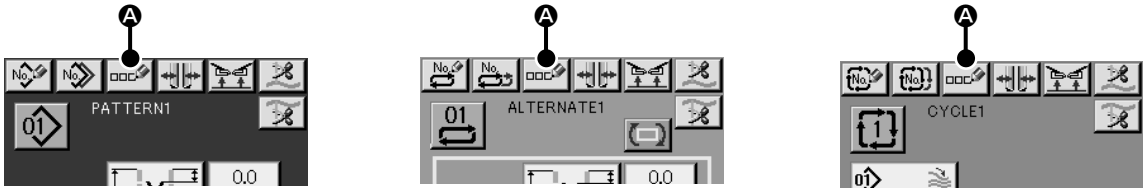
(5) 给图案起名称

① 显示输入画面

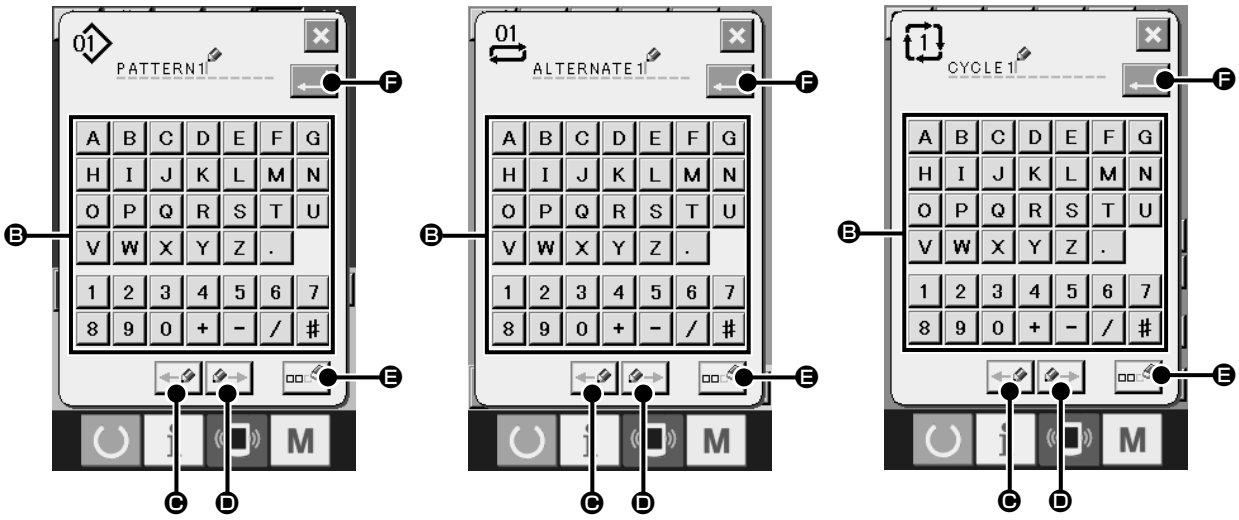
显示出单独缝制模式、交替缝制模式、循环缝制模式的输入画面之后，便可以向图案数据输入名称。

② 叫出输入文字画面

按了输入文字按钮 Ⓐ 之后，输入文字画面（画面 B）被显示出来。



输入数据画面（画面 A）



输入文字画面（画面 B）

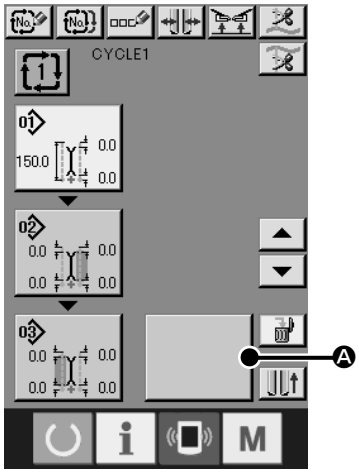
③ 输入文字

按想输入的文字按钮 Ⓑ，就可以输入文字。最多可以输入 14 个字（ A ～ Z 、 0 ～ 9 ）、符号（ + 、 - 、 / 、 # 、 . 、 , ）。用游标左移动按钮 Ⓒ、游标右移动按钮 Ⓓ 可以移动游标。想删除输入的文字时，请把游标对准想删除的文字位置，然后按删除按钮 Ⓔ。

④ 结束输入文字

按确定按钮 Ⓕ 之后，结束输入文字。结束后，在输入画面上部输入的文字被显示出来。

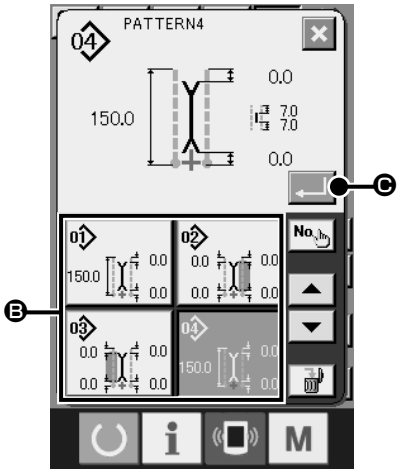
(6) 循环缝制数据的编辑方法



循环缝制输入画面（画面 C）

① 显示循环缝制输入画面

显示了循环缝制模式的输入画面之后，可以编辑循环缝制数据。



图案一览画面（画面 B）

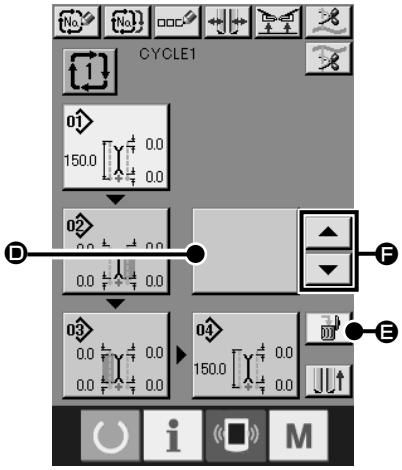
② 登记图案数据

按空白按钮 Ⓐ 之后，图案一览画面（画面 B）被显示出来。

从图案一览按钮 Ⓑ 选择想登记的图案数据，按确定按钮 Ⓒ 之后，在空白部选择的图案数据被登记。

第 1 个图案数据被登记之后，第 2 个空白按钮 Ⓓ 被显示出来。如果需要，请反复进行②的操作。

参考 循环缝制数据，最多可以登记 6 个图案数据。



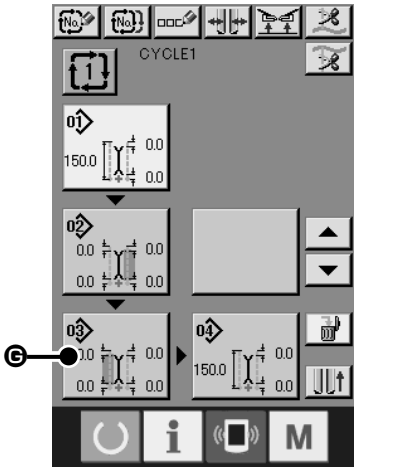
输入循环缝制画面（画面 C）

③ 删除登记的图案数据

按了删除按钮 Ⓔ 之后，白色强调显示的图案数据被删除。

请用上下滚动按钮 Ⓕ 选择想删除的图案数据，然后删除。

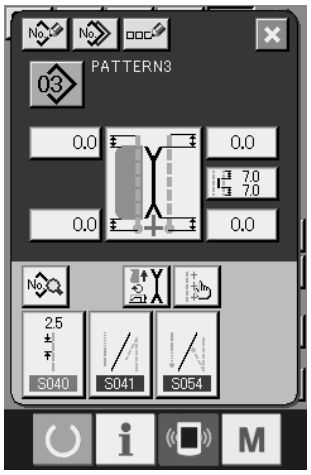
参考 白色想掉显示的图案数据，有可能是下一缝制的图案数据，请根据缝制作业进行移动。



④ 编辑被登记的图案数据

按了想编辑的图案数据按钮 Ⓖ 之后，编辑图案数据画面（画面 D）用凸起画面显示。

→ 请参照 "VI-3.(1) 输入画面（单独缝制模式）" p. 29。



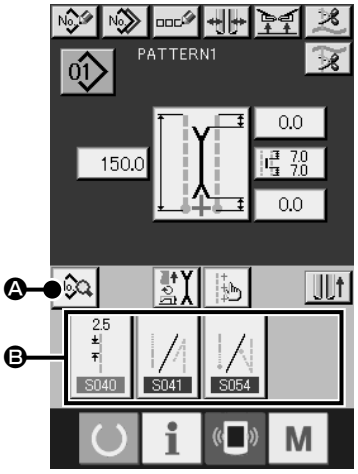
编辑图案数据画面（画面 D）

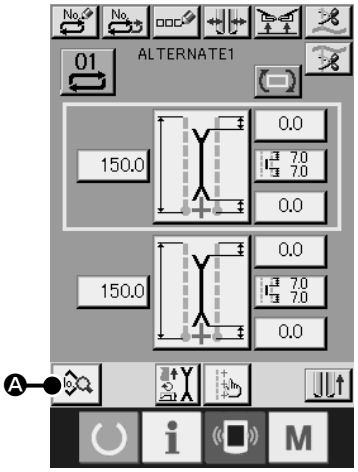
7. 变更缝制数据时

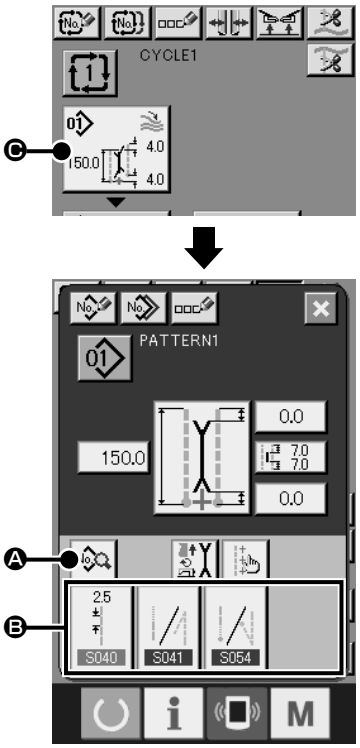
(1) 缝制数据的变更方法

① 显示输入画面

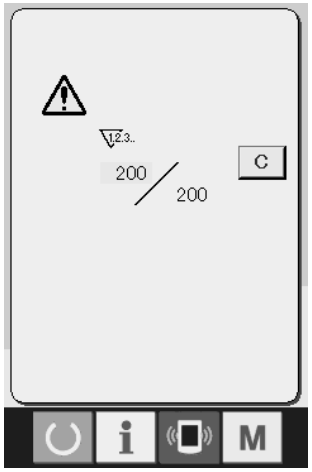
显示出单独缝制模式、交替缝制模式、循环缝制模式的输入画面之后，便可以变更缝制数据。
经常使用的缝制数据可以登记到输入画面的缝制数据快捷按钮 Ⓑ，并可以直接设定。而且，详细的缝制数据，按了 Ⓐ 之后，也可以设定。







参考
1. 变更循环缝制模式的缝制数据时，按了编辑图案数据按钮 Ⓒ 之后，可以变更。
2. 缝制数据快捷按钮 Ⓑ 在交替缝制模式时不显示。
3. 关于缝制数据快捷按钮 Ⓑ，请参照 "VI-12. 管理数据输入画面时 " p. 73。
4. 缝制数据的详细内容，请参照 "VI-7. (2) 缝制数据一览 ① 在数据输入画面显示的项目 " p. 49。



缝制数据一览画面（画面 A）

② 选择变更的缝制数据

按了 Ⓐ 之后，缝制数据一览画面（画面 A）被显示出来，请选择想变更的数据。

注意 有的形状，不能使用的数据项目不能显示，请注意。

(2) 缝制数据一览

① 在数据输入画面显示的项目

No.	项目	设定范围 / 编辑单位	初期值	
S001	**变换动作模式** 选择有无缝纫机马达、中心切刀、角刀动作。 送布模式　 送布、缝纫机切线 送布、缝纫机切线、中心切刀模式　 送布、缝纫机切线、中心切刀、角刀模式	- - -		
S003	**变换缝制模式** 选择缝制模式。 ＊ 交替缝制模式时的带盖优先缝制用 S002 设定。 L 尺寸缝制　 左袋盖缝制 右袋盖缝制　 袋盖优先缝制	- - -		○
S004	**设定 L 尺寸** L 尺寸缝制时，设定缝制长度。 ＊ S003 仅设定 L 尺寸缝制时可以设定。 ＊ 长尺寸宽幅规格时，最大可以设定至 250mm。 （但是，没有角刀时，最大可以设定至 300mm。）	18.0 ～ 220.0 / 0.1mm	150.0mm	※
S005	**标记光照射位置的变换** 选择开始缝制照射 / 结束缝制照射 / 中心照射。 开始缝制照射　 结束缝制照射 中心照射	- - -		
S008	**落袋盖数据（开始左缝制）** 调整左侧袋盖的开始缝制位置。 ＊ S003 仅设定袋盖缝制时可以设定。 	-9.9 ～ 9.9 / 0.1mm	0.0mm	※ △
S009	**落袋盖数据（结束左缝制）** 调整左侧袋盖的结束缝制位置。 ＊ S003 仅设定袋盖缝制时可以设定。 	-9.9 ～ 9.9 / 0.1mm	0.0mm	※ △
S010	**落袋盖数据（开始右缝制）** 调整右侧袋盖的开始缝制位置。 ＊ S003 仅设定袋盖缝制时可以设定。 	-9.9 ～ 9.9 / 0.1mm	0.0mm	※ △

※・・・由于设定状态不同，其他项目不显示。

○・・・在 APW-895NE 上无法使用 S003 左(右)襟翼缝纫和襟翼缝纫优先。

△・・・在 APW-895NE 的标准状态下无法使用的项目。

No.	项目	设定范围 / 编辑单位	初期值	
S011	**落袋盖数据（结束右缝制）** 调整右侧袋盖的结束缝制位置。 ＊ S003 仅设定袋盖缝制时可以设定。 	-9.9 ～ 9.9 / 0.1mm	0.0mm	※ △
S017 S018	**设定中心切刀动作位置** 设定开始缝制 / 结束缝制中心切刀的切断位置。 ＊ 请一定调整各个标准部件，让角刀的 V 字顶点对齐。 开始缝制 中心切刀位置 结束缝制 中心切刀位置	0.0 ～ 25.0 / 0.1mm ＊仅 APW-895L 最大 30.0	7.0mm	
S019	**开始缝制角刀动作位置** 设定开始缝制角刀的切断位置。 	-9.9 ～ 9.9 / 0.1mm	0.0mm	
S020	**结束缝制角刀动作位置** 设定开始缝制角刀的切断位置。 	-9.9 ～ 9.9 / 0.1mm	0.0mm	
S030 S031 S032	**设定标记光** 设定开始缝制照射 / 结束缝制照射 / 中心照射的各种标记光照射位置。设定值为 0.0mm 时，缝制位置和标记光照射位置相同。请在把标记光照射到与缝制位置不同的位置时使用。 开始缝制照射 结束缝制照射 中心照射	-100.0 ～ 100.0 ＊前标准 为 -80.0 ～ 100.0 / 0.1mm	0.0mm	
S069	**变换胶辊堆积器停止 / 动作** 选择胶辊堆积器的停止 / 动作。 ＊ SP047 仅设定胶辊堆积器安装时显示。 停止 动作	- - -		※
S070	**变换夹杆堆积器停止 / 动作** 选择夹杆堆积器的停止 / 动作 ＊ SP046 仅设定夹杆堆积器安装时显示。 停止 动作	- - -		※

※・・・由于设定状态不同，其他项目不显示。
△・・・在 APW-895NE 的标准状态下无法使用的项目。

② 在缝制数据一览画面显示的项目

No.	项目	设定范围 / 编辑单位	初期值	
S002	**选择袋盖优先缝制** 选择袋盖优先缝制模式。 ＊ 仅设定交替缝制模式时可以设定。 袋盖优先 禁止缝制 袋盖优先 缝制模式	－ － －		※
S006	**选择标记光照射位置的自动变换** S005 在开始缝制照射时或结束缝制照射时，缝制结束后自动地变换标记光照射位置。 ＊ 交替缝制模式、循环缝制模式时不动作。 停止 动作	－ － －		※
S012	**袋盖强制停止数据** 不能检测袋盖缝制结束端时，从后标准位置缝制了设定长度后停止。 ＊ S003 仅设定袋盖缝制时可以设定。 	0.0 ～ 10.0 / 0.1mm	5.0mm	※
S040	**平缝间距** 设定平缝部分的缝制间距。 	2.0 ～ 3.4 / 0.1mm	2.5mm	
S041	**选择开始缝制缩缝 / 倒缝** 选择开始缝制缩缝 / 倒缝。 缩缝 倒缝	－ － －		
S042	**开始缝制缩能针数** 设定开始缝制缩缝针数。 ＊ S041 仅选择缩缝时可以设定。 	3 ～ 19 / 1 针	5 针	※
S043	**开始缝制缩缝间距** 设定开始缝制缩缝间距。 ＊ S041 仅选择缩缝时可以设定。 	0.5 ～ 1.5 / 0.1mm	1.0mm	※
S044	**开始缩缝第 1 针间距** 设定开始缝制缩缝的第 1 针间距。 ＊ S041 仅选择缩缝时可以设定。 ＊ U024 仅选择缩缝 / 倒缝详细设定时可以设定。 	0.1 ～ 1.5 / 0.1mm	1.0mm	※

※・・・由于设定状态不同，其他项目不显示。
△・・・在 APW-895NE 的标准状态下无法使用的项目。

No.	项目	设定范围 / 编辑单位	初期值	
S045	**开始缩缝第 2 针间距** 设定开始缝制缩缝的第 2 针间距。 ＊ S041 仅选择缩缝时可以设定。 ＊ U024 仅选择缩缝 / 倒缝详细设定时可以设定。 	0.1 ～ 1.5 / 0.1mm	1.0mm	※
S046	**开始缩缝第 3 针间距** 设定开始缝制缩缝的第 3 针间距。 ＊ S041 仅选择缩缝时可以设定。 ＊ U024 仅选择缩缝 / 倒缝详细设定时可以设定。 	0.1 ～ 1.5 / 0.1mm	1.0mm	※
S047	**开始缝制倒缝针数** 设定开始缝制倒缝针数。 ＊ S041 仅选择倒缝时可以设定。 	1 ～ 12 / 1 针	3 针	※
S048	**开始缝制倒缝间距** 设定开始缝制倒缝间距。 ＊ S041 仅选择倒缝时可以设定。 	0.5 ～ 3.0 / 0.1mm	2.0mm	※
S049	**开始缝制倒缝加固间距** 设定开始缝制倒缝加固间距。 ＊ S041 仅选择倒缝时可以设定。 	-2.0 ～ 2.0 / 0.1mm	-1.5mm	※
S050	**开始缝制倒缝折回第 1 针间距** 设定开始缝制倒缝的折回部第 1 针间距。 ＊ S041 仅选择倒缝时可以设定。 ＊ U024 仅选择缩缝 / 倒缝详细设定时可以设定。 	0.1 ～ 3.0 / 0.1mm	2.0mm	※
S051	**开始缝制倒缝折回第 2 针间距** 设定开始缝制倒缝的折回部第 2 针间距 ＊ S041 仅选择倒缝时可以设定。 ＊ U024 仅选择缩缝 / 倒缝详细设定时可以设定。 	0.1 ～ 3.0 / 0.1mm	2.0mm	※

※・・・由于设定状态不同，其他项目不显示。

No.	项目	设定范围 / 编辑单位	初期值	
S052	**开始缝制倒缝折回第 3 针间距** 设定开始缝制倒缝的折回部第 3 针间距。 ＊ S041 仅选择倒缝时可以设定。 ＊ U024 仅选择缩缝 / 倒缝详细设定时可以设定。 	0.1 ～ 3.0 / 0.1mm	2.0mm	※
S053	**缝制开始倒褶折回修正** 设定缝制开始倒褶折回修正值。 ＊ S041 仅选择倒缝时可以设定。 ＊ K061 仅用图案数据补正时可以设定。 	-2.0 ～ 2.0 / 0.1mm	1.0mm	※
S054	**选择结束缝制缩缝 / 倒缝** 选择结束缝制缩缝 / 倒缝。 缩缝 倒缝	- - -		
S055	**结束缝制缩缝针数** 设定结束缝制缩缝针数。 ＊ S054 仅选择缩缝 s 时可以设定。 	3 ～ 19 / 1 针	5 针	※
S056	**结束缝制缩缝间距** 设定结束缝制缩缝间距。 ＊ S054 仅选择缩缝时可以设定。 	0.5 ～ 1.5 / 0.1mm	1.0mm	※
S057	**缩缝最终针间距** 设定结束缝制缩缝的最终针间距。 ＊ S054 仅选择缩缝时可以设定。 ＊ U024 仅选择缩缝 / 倒缝详细设定时可以设定。 	0.1 ～ 1.5 / 0.1mm	1.0mm	※
S058	**缩缝最终针的前 1 针间距** 设定结束缝制缩缝的最终针的前 1 针间距。 ＊ S054 仅选择缩缝时可以设定。 ＊ U024 仅选择缩缝 / 倒缝详细设定时可以设定。 	0.1 ～ 1.5 / 0.1mm	1.0mm	※
S059	**缩缝最终针的前 2 针间距** 设定结束缝制缩缝的最终针的前 2 针间距。 ＊ S054 仅选择缩缝时可以设定。 ＊ U024 仅选择缩缝 / 大缝详细设定时可以设定。 	0.1 ～ 1.5 / 0.1mm	1.0mm	※

※・・・由于设定状态不同，其他项目不显示。

No.	项目	设定范围 / 编辑单位	初期值	
S060	**结束缝制倒缝针数** 设定结束缝制倒缝针数。 ＊ S054 仅选择倒缝时可以设定。 	1 ～ 12 / 1 针	3 针	※
S061	**结束缝制倒缝间距** 设定结束缝制倒缝间距。 ＊ S054 仅选择倒缝时可以设定。 	0.5 ～ 3.0 / 0.1mm	2.0mm	※
S063	**结束缝制倒缝折回第 1 针间距** 设定结束缝制倒缝折回部第 1 针间距。 ＊ S054 仅选择倒缝时可以设定。 ＊ U024 仅选择缩缝 / 倒缝详细设定时可以设定。 	0.1 ～ 3.0 / 0.1mm	2.0mm	※
S064	**结束缝制倒缝折回第 2 针间距** 设定结束缝制倒缝折回部第 2 针间距。 ＊ S054 仅选择倒缝时可以设定。 ＊ U024 仅选择缩缝 / 倒缝详细设定时可以设定。 	0.1 ～ 3.0 / 0.1mm	2.0mm	※
S065	**结束缝制倒缝折回第 3 针间距** 设定结束缝制倒缝折回部第 3 针间距。 ＊ S054 仅选择倒缝时可以设定。 ＊ U024 仅选择缩缝 / 倒缝详细设定时可以设定。 	0.1 ～ 3.0 / 0.1mm	2.0mm	※
S067	**结束缝制倒缝最终针间距** 设定结束缝制倒缝最终针间距。 ＊ S054 仅选择倒缝时可以设定。 	-2.0 ～ 2.0 / 0.1mm	-1.5mm	※
S068	**结束缝制倒缝折回补正** 设定结束缝制倒缝折回补正值。 ＊ S054 仅选择倒缝时可以设定。 ＊ K061 仅用图案数据补正时可以设定。 	-2.0 ～ 2.0 / 0.1mm	1.0mm	※

※・・・由于设定状态不同，其他项目不显示。

No.	项目	设定范围 / 编辑单位	初期值	
S071	**堆积位置** 从角刀位置只让大压脚移动设定距离后，让堆积器动作。(＋ : 里侧　－ : 前侧) ＊ 动作量的范围受结束缝制时的大压脚的位置的限制。 ＊ 仅使用 SP046 夹杆堆积器，或使用 SP047 胶辊堆积器，而且设定 S069 胶辊堆积器动作，或设定 S070 夹杆堆积器动作时可以设定。 	0 ～ 500mm / 1mm	0mm	※
S072	**堆积器定时器 1** 设定胶辊转动时间。设定时间之前，布料传感器检测到无布料后，停止转动。 ＊ 仅使用 SP047 胶辊堆积器选购品，而且设定 S069 胶辊堆积器动作时可以设定。 	0.0 ～ 9.9 / 0.1 秒	0.5 秒	※
S073	**至开始缝制位置的空送速度** 设定至开始缝制位置的空送速度。 	3 ～ 8 / 1	5	
S074	**至角刀位置的空送速度** 设定至角刀位置的空送速度。 	3 ～ 6 / 1	5	
S075	**变换折边装置停止 / 动作** 选择折边装置的停止 / 动作。 ＊ SA117 仅使用折边选购品时可以设定。 停止　 动作	- - -		※
S076	**变换芯布自动供给装置停止 / 动作** 选择芯布自动供给装置的停止 / 动作。 ＊ SA120 仅使用芯布自动供给选购品时可以设定。 ＊ 由于供给芯布而不使用图案时，请注意不要让芯布露出到机台上面。下一次使用时，请按一次操作盘上的重复拉出按键，然后再进行切断的重复拉出动作。 停止　 动作	- - -		※
S077	**袋盖长度** 设定袋盖的长度。 S076 选择芯布自动供给装置动作，而且 S003 缝制模式变换选择袋盖缝制时可以设定。 ＊ 本设定是为了决定芯布自动供给装置的拉芯布长度而进行设定。缝制长度通过袋盖传感器的检测来决定。 	37.0 ～ 220.0 / 0.1mm	150.0mm	※ △

※・・・由于设定状态不同，其他项目不显示。

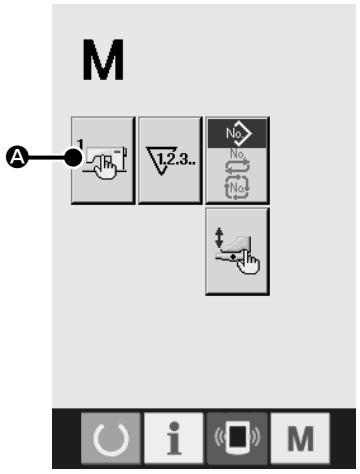
△・・・在 APW-895NE 的标准状态下无法使用的项目。

No.	项目	设定范围 / 编辑单位	初期值	
S078	**缝纫机高速转速** 设定缝制部的转速。 ＊ K059 仅转速设定选择为选择图案数据时可以设定。 	1000 ～ 3000 / 100sti/min	2500sti/ min	※
S079	**缝纫机低速转速** 设定缩缝、倒缝部的转速。 ＊ S078 受缝纫机高速转速的限制。 ＊ K059 仅缝纫机转速设定选择为选择图案数据时可以设定。 ＊ 倒缝时，实际的低速转速上限限制为 1500sti/min。 	1000 ～ 2500 / 100sti/min	1500sti/ min	※

※・・・由于设定状态不同，其他项目不显示。

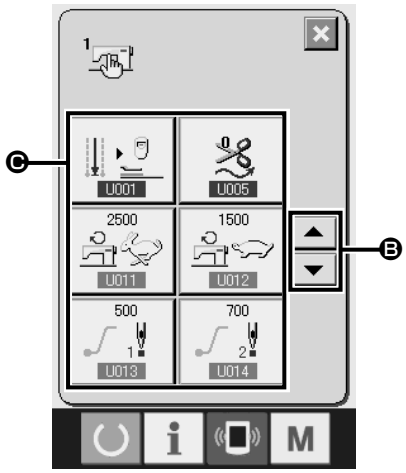
8. 变更存储器开关数据时

(1) 存储器开关数据的变更方法



① 显示存储器开关数据一览画面

按了模式变换键 M 之后，画面上存储器开关按钮 Ⓐ 被显示。按此按钮之后，存储器开关数据一览画面（画面 A）被显示出来。



存储器开关数据一览画面
（画面 A）

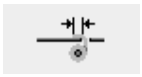
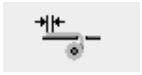
② 选择想变更的存储器开关按钮

按了上下滚动按钮 Ⓑ，请选择想变更的数据项目按钮 Ⓒ。

(2) 存储器开关数据一览

① 等级 1

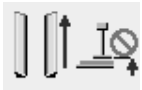
存储器开关数据（等级 1）是缝纫机通用的动作数据，即是所有的缝制图案通用的数据。

No.	项目	设定范围 / 编辑单位	初期值	
U001	**变换结束缝制后的大压脚位置** 从前进端 / 中间返回 / 压脚返回 / 后退端停止种选择缝制终了后的大压脚位置。 大压脚前进端停止 大压脚中间返回 大压脚压脚返回 大压脚后退端停止	- - -		
U002	**开始前进端动作待机时间** 设定大压脚开始前进端动作的待机时间。 ＊ U001 仅设定为前进端停止时可以设定。 	0.50 ～ 9.99 / 0.01 秒	3.00 秒	※
U003	**开始缝制芯布自动供给反复拉布次数** 设定开始缝制芯布自动供给装置反复拉布次数。 ＊ SA120 仅使用芯布自动供给选购品时可以设定。 	2 ～ 9 / 1	3	※
U004	**结束缝制芯布自动供给反复拉出长度** 设定结束缝制芯布自动供给装置的反复拉出长度。 ＊ SA120 仅使用芯布自动供给选购品时可以设定。 	0 ～ 99.9 / 0.1mm	0mm	※
U005	**切线同步时间** 从标准 / 中间 / 最长种选择结束缝制后的切线同步时间，调整结束缝制缝线的长度。 标准 0 中间 1 最长 2 ＊ 实装了 SA125 定尺寸钉拉链装置，设定为标准值 0 之后，上线有可能切不断。	- - -		
U007	**堆积器定时器 2** 设定从向堆积台放置布料的夹杆动作开始至放开布料为止的待机时间。 ＊ SP046 仅使用夹杆堆积器选购品时可以设定。	0.00 ～ 9.99 / 0.01 秒	0.70 秒	※

※・・・由于设定状态不同，其他项目不显示。

No.	项目	设定范围 / 编辑单位	初期值	
U008	**堆积器定时器 3** 设定取布料杆的动作时间。 ＊ SP046 仅使用夹杆堆积器选购品时可以设定。	0.00 ～ 9.99 / 0.01 秒	0.70 秒	※
U009	**堆积器定时器 4** 设定加快大压脚上升松开缝制物的同步时间。夹小缝制物时，用自重调整下落量。 ＊ SP046 仅使用夹杆堆积器选购品时可以设定。	0.00 ～ 9.99 / 0.01 秒	0.00 秒	※
U011	**缝纫机高速转速** 设定缝制布的转速。 ＊ K059 仅选择了用存储器开关设定缝纫机转速时，可以设定。	1000 ～ 3000 / 100sti/min	2500sti/min	※
U012	**缝纫机低速转速** 设定缩缝、倒缝部的转速。 ＊ U011 受缝纫机高速转速限制。 ＊ K059 仅选择了用存储器开关设定缝纫机转速时，可以设定。 ＊ 倒缝时，实际的低速转速上限限制为 1500sti/min。	1000 ～ 2500 / 100sti/min	1500sti/min	※
U013	**软起动第 1 针** 限制开始缝制第 1 针的转速。	500 ～ 2500 / 100sti/ min	1500sti/min	
U014	**软起动第 2 针** 限制开始缝制第 2 针的转速。	500 ～ 2500 / 100sti/min	2500sti/min	
U015	**软起动第 3 针** 限制开始缝制第 3 针的转速。	500 ～ 2500 / 100sti/min	2500sti/min	
U016	**大压脚返回速度** 设定大压脚返回速度。	3 ～ 9 / 1	7	

※・・・由于设定状态不同，其他项目不显示。

No.	项目	设定范围 / 编辑单位	初期值	
U017	**选择断线检测** 选择有 / 无断线检测。 有断线检测 无断线检测	- - -		
U018	**袋盖压脚动作模式** 选择袋盖压脚的动作顺序。 从右面 从左面 左右同时 放置袋盖侧 ＊ 踏板管理设定时设定为左右同时动作后，便无视此参数，左右同时动作。	- - -		△
U019	**变换大压脚下降顺序** 选择大压脚的下降顺序。 从右面 从左面 左右同时 ＊ 踏板管理设定时设定为左右同时动作后，便无视此参数，左右同时动作。	- - -		
U020	**折边板动作模式** 在角刀顶起时，选择折边板「返回 / 不返回」。 返回 不返回	- - -		
U021	**禁止滚边器减压上升** 禁止空送时的滚边器减压上升。  禁止减压上升 减压上升	- - -		
U022	**变换连续踩踏板定时器有效 / 无效** U023 选择连续踩踏板定时器的有效 / 无效。 ＊ K054 仅设定为一次踩踏板时可以设定。 无效 有效	- - -		※
U023	**连续踩踏板定时器** 设定踩住踏板放置缝制物时，各装置顺序动作的时间间隔。 ＊ K054 仅设定为一次踩踏板时可以设定。 	0.1 ～ 2.0 / 0.1 秒	0.5 秒	※

※・・・由于设定状态不同，其他项目不显示。

△・・・在 APW-895NE 的标准状态下无法使用的项目。

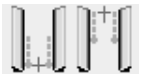
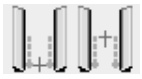
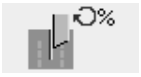
No.	项目	设定范围 / 编辑单位	初期值	
U024	**详细设定缩缝 / 倒缝** 详细设定缩缝 / 倒缝部的间隙「设定 / 不设定」。 设定 不设定	- - -		
U025	**袋盖止动器的位置** 缝制袋盖时，设定标记光的开始缝制照射位置（距离机针）。 ＊ 仅进行标记光的照射位置设定，实际的缝制位置是用袋盖传感器检测的袋盖断位置。 	80.0 ～ 280.0 / 0.1mm	80.0mm	△
U028	**堆积器定时器 5** 设定从抓布料的动作开始至放开布料为止的待机时间。 ＊ 仅限使用 SP048 抓取堆积器选购项目时可以进行设定。 	0.00 ～ 9.99 / 0.01 秒	1.00 秒	
U029	**堆积器定时器 6** 设定摆头机臂的动作时间。 ＊ 仅限使用 SP048 抓取堆积器选购项目时可以进行设定。 	0.00 ～ 9.99 / 0.01 秒	1.50 秒	
U033	**设定角刀固定距离** 设定移动一侧角刀和固定一侧角刀之间的距离。 如果针对不同 K053 角刀实际配备了驱动用电磁阀的设定功能时，压紧装置会移动，让开始缝纫的位置对准移动一侧角刀的位置。	35.0 ～ 220.0 / 0.1mm	100.0mm	
U245	**加润滑脂针数** 表示补充润滑脂后的缝纫机动作针数。 ＊ 按了清除按钮之后，针数被清除到 0。请一定补充了润滑脂之后再进行清除。 	- - -	- - -	
U500	**选择语言** 选择在操作盘上显示的文字语言。 日本語 日文　English 英文 中文简体字 中文（简体字）　中文繁體字 中文（繁体字） Español 西班牙文　Italiano 意大利文 Français 法文　Deutsch 德文 Português 葡萄牙文　Türkçe 土耳其文 Tiếng Việt 越南文　한국어 韩文 Indonesia 印尼文　Русский 俄文	- - -	未选择	

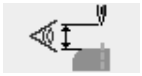
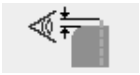
※・・・由于设定状态不同，其他项目不显示。

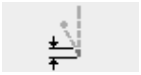
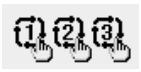
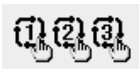
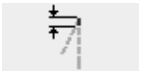
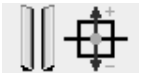
△・・・在 APW-895NE 的标准状态下无法使用的项目。

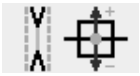
② 等级 2

存储器开关数据（等级 2）是缝纫机具有的通用动作数据，也是通用于所有的缝制图案功能的数据。它是维修人员为对象的数据，持续 6 秒钟按模式开关就可以编辑数据。

No.	项目	设定范围 / 编辑单位	初期值
K051	**安装标记光** 选择安装 / 不安装标记光。选择了不安装后，标记光不动作。 不安装 安装	- - -	
K052	**缝制位置的选择** 请一定根据在后标准位置结束缝制的模式和从前标准位置开始缝制的模式以及 S005 的设定改变缝制位置的过去用过的模式中选择。 ＊ 前标准位置 ： 距离机针 80㎜ 后标准位置 ： 距离机针 300㎜ （长尺寸宽幅规格是 330㎜， 但是，设定为 K058 后是 380㎜）  过去的动作模式  固定缝制位置模式（后标准） 固定缝制位置（前标准）	- - -	
K053	**设定驱动不同角刀用电磁阀** 设定安装 / 不安装驱动不同角刀用电磁阀。 不安装 安装	- - -	
K054	**踏板动作模式的变换** 设定踩踏板的使用模式。 7 级踏板模式 一次踩踏板模式	- - -	
K055	**中心切刀切断富余率** 可以设定对于中心切刀的转速的富余率。 	300 ～ 500 / 1%	350%

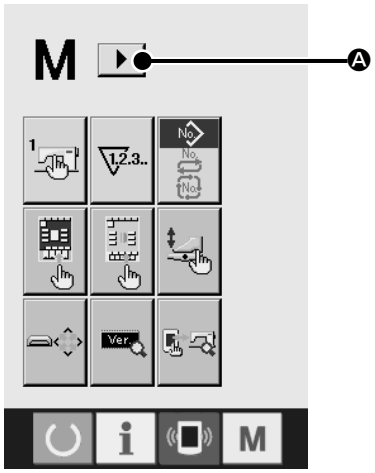
No.	项目	设定范围 / 编辑单位	初期值
K056	**禁止间歇传送的设定** 选择进行 / 禁止间歇传送缝制。 ＊ 进行间歇传送时，缝纫机的最高转速限制在 1,500sti/min。 进行间歇传送缝制 禁止间歇传送缝制	- - -	
K057	**变换落袋盖数据的编辑标准** 选择用操作盘设定的落袋盖数据为袋盖检测端的补正值或选择传感器检测之后至开始缝制的距离为补正值。 袋盖检测端补正  传感器补正	- - -	
K058	**扩大 L 尺寸数据范围** 设定是否把 L 尺寸长度的数据范围扩大至 L 尺寸最大 220mm + 15mm。 长尺寸宽幅规格时，可以被扩大至 250mm + 50mm。 ＊ 使用 M004 长尺寸宽幅规格进行 250mm 以上的长缝制时，角刀不动作。 ＊ M004 长尺寸宽幅规格时，把比 250mm 小的袋盖布放到＋ 50mm 的区域之后，角刀不动作。 不扩大 扩大	- - -	
K059	**选择设定缝纫机转速** 选择用存储器开关还是用图案数据选择缝纫机转速的设定。 存储器开关 图案数据	- - -	
K060	**选择反射袋检查模式** 设定 ON/OFF 反射袋检查模式。 设定为 ON 之后，打开电源，首先通过大压脚前进动作自动地下降压脚，然后用反射袋进行劣化检查。 ＊ 因为大压脚自动地下降，所以请一定使用隔板。 OFF ON	- - -	
K061	**选择倒缝折回补正设定** 选择用存储器开关还是用图案数据设定倒缝折回的补正。 存储器开关 图案数据	- - -	

No.	项目	设定范围 / 编辑单位	初期值
K062	**补正结束缝制倒缝折回** 设定结束缝制倒缝折回补正。 ＊ K061 仅选择存储器开关时可以设定。 	-2.0 ～ 2.0 / 0.1mm	1.0mm
K063	**选择图案一览画面的模式变换按钮的显示** 在图案一览画面，显示模式变换按钮，可以选择不同模式的数据。 不显示 显示	- - -	
K066	**循环缝联结功能** 联结奇数图案和偶数图案，最多可以缝制 12 步骤。 仅可以进行 1 和 2、3 和 4、…、19 和 20 的组合联结。  联结功能 OFF 联结功能 ON	- - -	
K069	**中心刀下降时间** 设定中心刀的下降时间。 	10 ～ 100 / 1	40
K070	**设定禁止中心刀单触键动作** 选择为了正确地切断缝制结束侧中心刀的切断位置的单触键动作的有无。 进行单触键动作 禁止单触键动作	- - -	
K071	**结束缝制倒缝折回补正** 设定结束缝制倒缝折回补正值。 ＊ K061 仅用图案数据补正时可以设定。 	-2.0 ～ 2.0 / 0.1mm	1.0mm
K080	**补正大压角马达原点** 补正大压角马达的原点。 	-10.0 ～ 10.0 / 0.1mm	0.0mm

No.	项目	设定范围 / 编辑单位	初期值
K081	**补正角刀马达原点** 补正角刀马达的原点。 	-5.0 ～ 5.0 / 0.1mm	0.0mm
K082	**补正标记光原点（正下方）** 补正标记光马达的原点。原点位置在光照射的正下方，距离机针 230mm。 ＊ M004 长尺寸宽幅规格时,灯光照射位置是距离机针 246mm 的位置。 	-500 ～ 500 / 1pulse	0 pulse
K083	**补正标记光原点（机针侧）** 补正机针侧距离标记光马达的原点的位置。光照射位置距离机针 80mm。 ＊ M004 长尺寸宽幅规格时，灯光照射位置是距离机针 96mm 的位置。 	-500 ～ 500 / 1pulse	0 pulse
K084	**补正标记光原点（操作者侧）** 补正操作者侧距离标记光马达的原点的位置。光照射位置距离机针 380mm。 ＊ M004 长尺寸宽幅规格时,灯光照射位置是距离机针 396mm 的位置。 	-500 ～ 500 / 1 pulse	0 pulse
K085	**补正到缝马达原点** 补正到缝马达的原点。 	-30 ～ 30 / 1 pulse	0 pulse

9. 设定选购项时

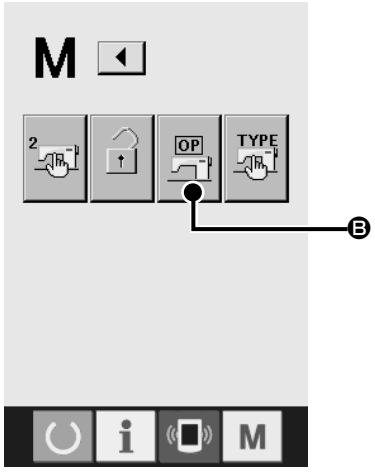
(1) 选购项设定的变更方法



① 显示模式变换画面的第 2 个画面

持续 6 秒钟按模式变换键 M 之后，在画面上右滚动按键 ▶ Ⓐ 被显示出来。

按了此按键之后，模式变换画面的第 2 个画面（画面 A）被显示出来。

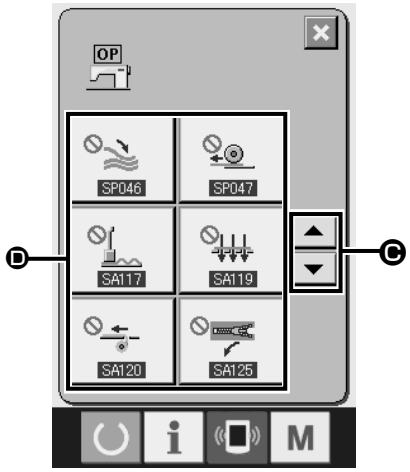


模式变换画面第 2 画面
（画面 A）

② 显示选购项目设定一览画面

在画面上选购项目设定按键 OP Ⓑ 被显示出来。

按了此按键之后，选购项目设定一览画面（画面 B）被显示出来。



设定选购项一览画面
（画面 B）

③ 选择想变更的选购项目的设定

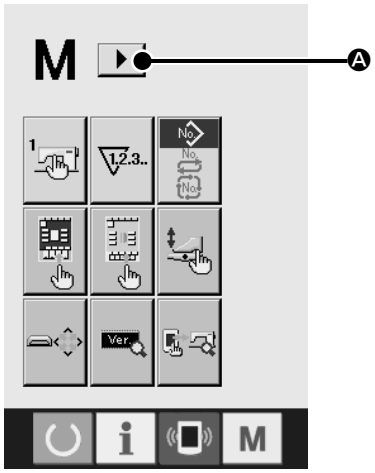
请按上下滚动按键 ▲ ▼ Ⓒ，选择想变更的数据项目按键 Ⓓ。

(2) 设定选购品一览

设定选购品的安装状态之后，各选购品就可以动作。

No.	项目	设定范围 / 编辑单位	初期值
SP046	设定安装 / 未安装夹杆堆积器。 未安装 安装	- - -	 未安装
SP047	设定安装 / 未安装胶辊堆积器。 未安装 安装	- - -	 未安装
SP048	设定抓取堆积器装置的安装 / 未安装。 未安装 安装	- - -	 未安装
SA117	设定安装 / 未安装打褶装置。 ＊ 但是,实装时，M001 标准部件尺寸设定被限制在8～12㎜的范围。 ＊ M004 长尺寸宽幅规格时，打褶装置不动作。 未安装 安装	- - -	 安装
SA119	设定安装 / 未安装真空装置。 ＊ M004 长尺寸宽幅规格时，真空装置不动作。 未安装 安装	- - -	 未安装
SA120	设定安装 / 未安装芯布自动供给装置。 ＊ M004 长尺寸宽幅规格时，芯布自动供给装置不动作。 未安装 安装	- - -	 未安装
SA125	设定安装 / 未安装拉链装置。 ＊ 但是,实装时，M001 标准部件尺寸设定被限制在16～20㎜的范围。 ＊ M004 长尺寸宽幅规格时，定尺寸钉拉链装置不动作。 未安装 安装	- - -	 未安装

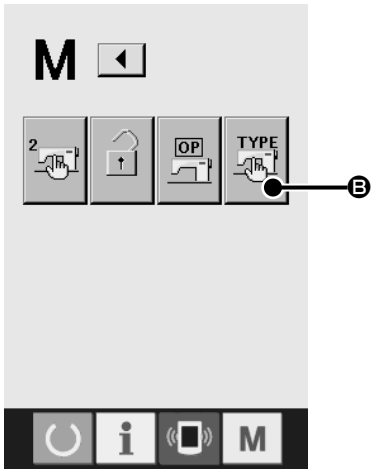
(1) 装置设定的变更方法



① **显示模式变换画面的第 2 个画面**

持续 6 秒钟按模式变换键 M 之后，在画面上右滚动按键 ▶ Ⓐ 被显示出来。

按了此按键之后，模式变换画面的第 2 个画面（画面 A）被显示出来。

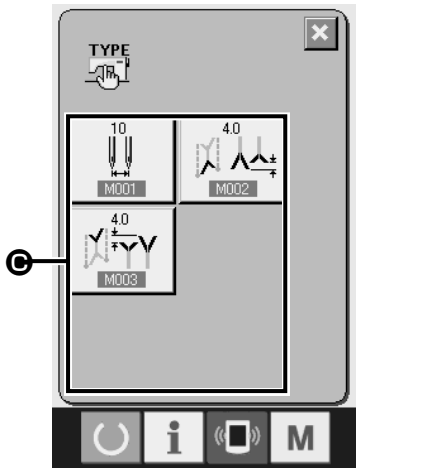


模式变换画面第 2 画面
（画面 A）

② **显示装置设定一览画面**

在画面上装置设定按键 TYPE Ⓑ 被显示出来。

按了此按键之后，装置设定一览画面（画面 B）被显示出来。



装置一览画面
（画面 B）

③ **选择想变更的装置设定**

请选择变更的数据项目按键 Ⓒ。

(2) 装置设定一览

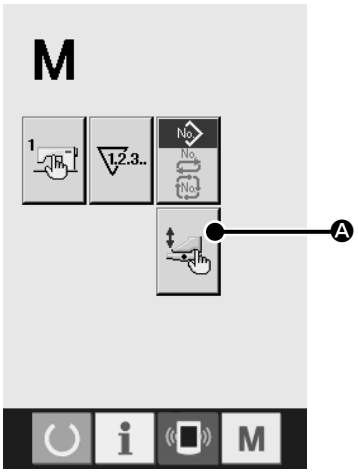
设定安装的规格之后，符合规格的装置可以动作。

No.	项目	设定范围 / 编辑单位	初期值
M001	**标尺尺寸** 设定缝纫机的标尺尺寸。 ＊ M004 长尺寸宽幅规格时，范围扩大到 22 ～ 32mm。 ＊ 通过标尺尺寸的设定值，角刀被变更动作。 ＊ 安装了 SA117 打褶装置时限制在 8 ～ 12mm 的范围，安装了 SA125 安装了定长尺寸拉链缝钉装置时，范围限制在 16 ～ 20mm。 	8 ～ 20 （22 ～ 32） / 2mm	10mm
M004	**选择长尺寸宽幅规格** 使用长尺寸宽幅规格时进行设定。 标准：安装标准压脚 缝制尺寸 220mm 长尺寸宽幅规格：安装长尺寸宽幅用压脚 缝制尺寸 250mm **出货时根据安装的大压脚的规格进行设定。否则会发生碰撞，因此请不要选择安装的大压脚以外规格的零件。**	- - -	

11. 管理踏板操作时

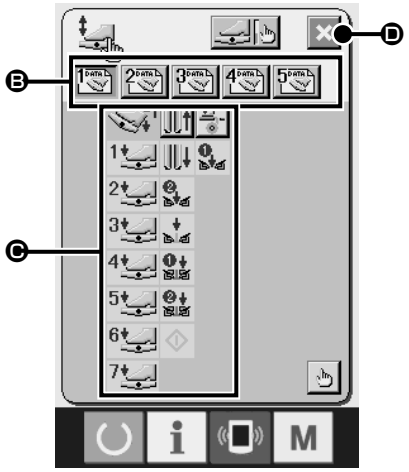
对于踏板的各级踩踏，可以根据使用情况任意地登记“滚边器下降”“袋盖压脚下降”等动作功能。
另外，管理的踏板操作数据最多可以从 5 种中选择使用。

(1) 选择管理数据使用的方法



① **显示踏板管理画面**

按了模式变换键 M 之后，画面上踏板管理按钮 Ⓐ 被显示出来。
按此按钮之后，踏板管理画面（画面 A）被显示出来。

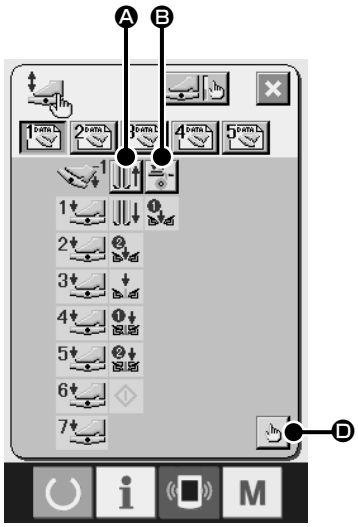


踏板管理画面（画面 A）

② 从按钮 Ⓑ 中选择管理登记的 5 种踏板操作数据。此时，选择的踏板操作数据内容显示在 Ⓒ。

③ 按了结束画面按钮 Ⓓ 之后，确定选择的踏板操作数据，然后返回到原来的画面。

(2) 管理踏板操作数据

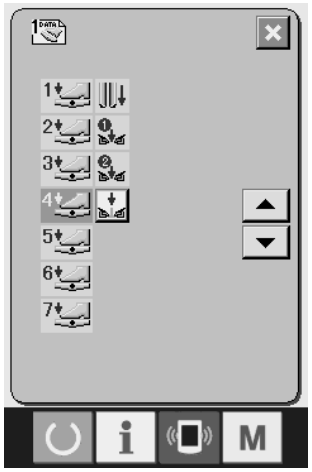


① 按了按钮 Ⓐ之后，设定反踩踏板让大压脚后退或不后退。

显示	内容
	后退
	不后退

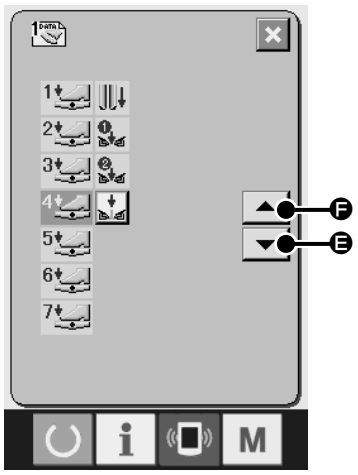
② 按了按钮 Ⓑ之后，设定反踩踏板让芯布压脚动作或不动作。

显示	内容
	动作
	不动作

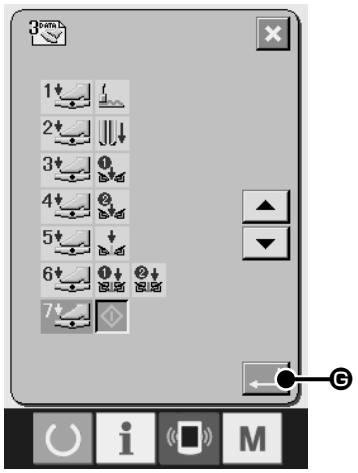


ペダル動作機能設定画面
（画面 A）

③ 只要按下按钮 Ⓓ，就会显示踏板动作功能设定画面（画面 A），能够根据踩下踏板的次数设定动作功能。



④ 能够从第 1 次开始按照顺序登记如下功能。可以登记的功能变为 这样的按钮状态，顺序地被显示出来。只要按下，就会显示反转，并被登记。使用▲▼按钮 Ⓔ推进踏板次数。使用 Ⓕ复位踏板次数时，变成前一个状态。



最后，登记之后，确定按钮 Ⓖ 被显示，请按此按钮确定登记数据。

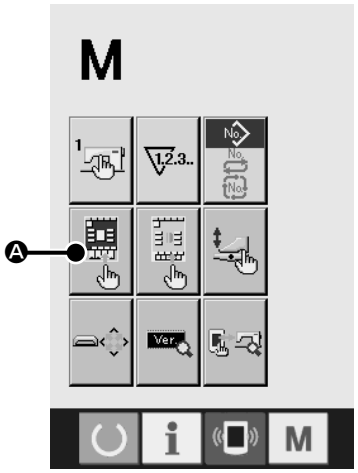
＊ 可以空级进行登记。

＊ 在 NE 规格上，未搭载襟翼压紧装置。但是，在设定踏板时，有必要对襟翼压紧装置的动作进行设定。虽然动作被设定，但是此步骤在缝纫机工作时会被跳过。

显示	内容	显示	内容
	打褶 ON（选购品）		关闭按器下降
	真空吸引（选购品）		袋盖压脚单侧下降
	大压脚单侧下降		袋盖压脚另一侧下降
	大压脚另一侧下降		缝纫机开始

12. 管理数据输入画面时

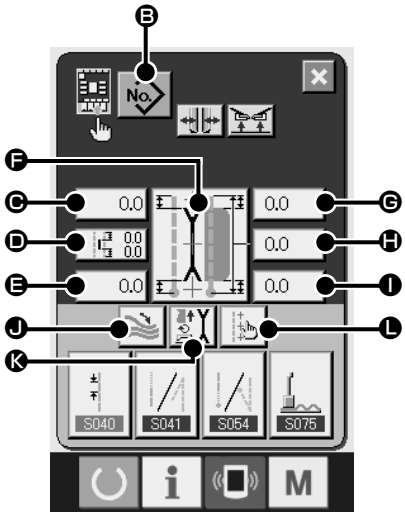
在数据输入画面上显示的按钮，可以根据用户的使用情况进行管理。



① 显示输入画面的管理画面

持续 3 秒钟按模式变换键 M 之后，在画面上输入画面的管理按钮 Ⓐ 被显示出来。

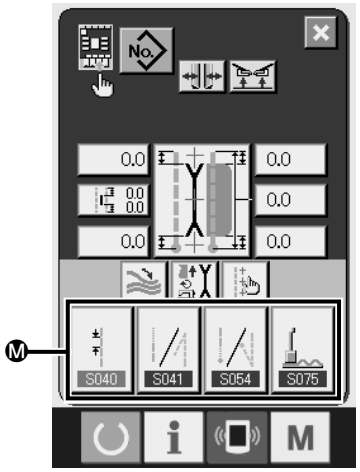
按此按钮之后，输入画面的管理画面被显示出来。



② 选择按钮状态

Ⓑ ～ Ⓛ 按钮，每按之后可以变换钮扣显示 / 不显示。请根据用户的使用情况进行管理使用。

符号	显示	不显示	内容	初期状态
Ⓑ			图案一览按钮	
Ⓒ			落袋盖数据（开始左缝制）	
Ⓓ			设定中心刀动作位置	
Ⓔ			落袋盖数据（结束左缝制）	
Ⓕ			变换缝制模式	
Ⓖ			开始缝制角刀动作位置	
Ⓗ			设定Ｌ尺寸	
Ⓘ			结束缝制角刀动作位置	
Ⓙ			变换堆积器停止 / 动作	
Ⓚ			变换动作模式	
Ⓛ			设定标记光	



③ **向缝制数据管理按钮登记**

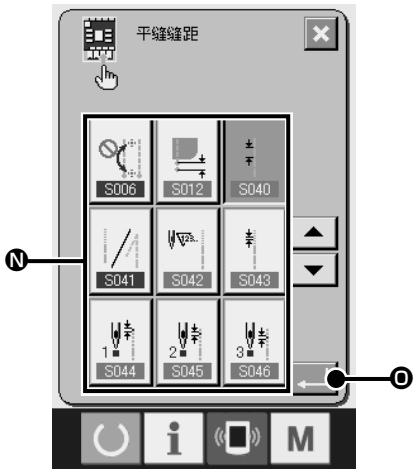
对于缝制数据管理按钮 Ⓜ，可以登记最多 4 个缝制数据。请登记频繁使用的缝制数据然后使用。

按了想登记的管理按钮 Ⓜ 之后，缝制数据一览画面（画面 A）被显示出来。

④ **选择登记的缝制数据**

请通过缝制数据按钮 Ⓝ，选择想登记的缝制数据。

再次按了选择的按钮之后，选择被解除。



缝制数据一览画面（画面 A）

⑤ **向管理按钮登记**

按了确定按钮 Ⓞ 之后，结束向管理按钮登记，返回输入画面的管理画面。登记的缝制数据在管理按钮 Ⓜ 上被显示出来。

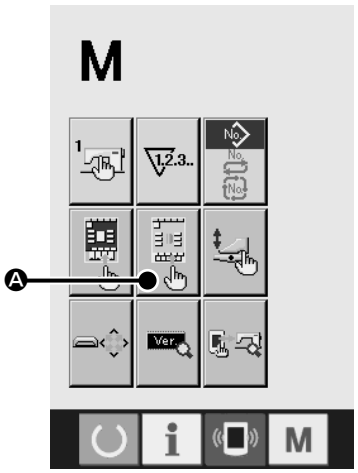
购买时，从左顺序开始，

a.		平缝缝距
b.		选择开始缝制缩缝 / 倒缝
c.		选择结束缝制缩缝 / 倒缝
d.		变换打褶装置停止 / 动作

被登记着。

13. 设定缝制画面的管理

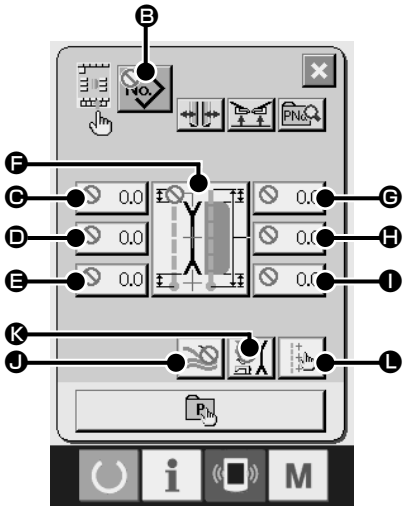
输入数据画面上显示的按钮，可以根据用户的使用情况进行管理。



① 显示缝制画面的管理画面

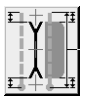
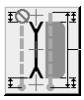
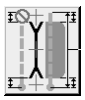
持续 3 秒钟按模式变换键 M 之后，在画面上缝制画面管理按钮 Ⓐ 被显示出来。

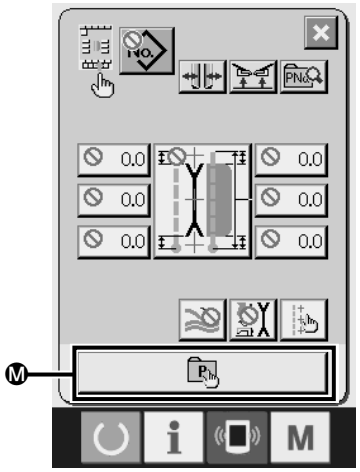
按了此按钮之后，缝制画面的管理画面被显示出来。



② 设定按钮的状态

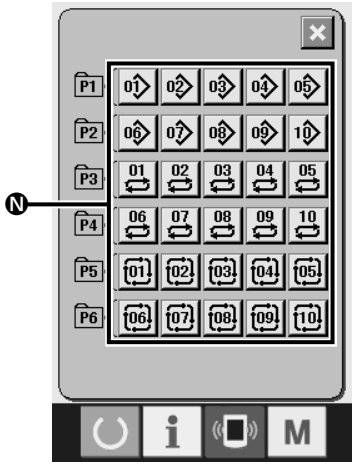
Ⓑ ～ Ⓛ 的按钮，每按按钮后可以变换按钮显示 / 不显示。请根据用户的使用情况管理使用。

符号	显示	不显示	内容	初期状态
Ⓑ			图案一览按钮	
Ⓒ			落袋盖数据（开始左缝制）	
Ⓓ			设定中心刀动作位置	
Ⓔ			落袋盖数据（结束左缝制）	
Ⓕ			变换缝制模式	
Ⓖ			开始缝制角刀动作位置	
Ⓗ			设定Ｌ尺寸	
Ⓘ			结束缝制角刀动作位置	
Ⓙ			变换堆积器停止 / 动作	
Ⓚ			变换动作模式	
Ⓛ			设定标记光	



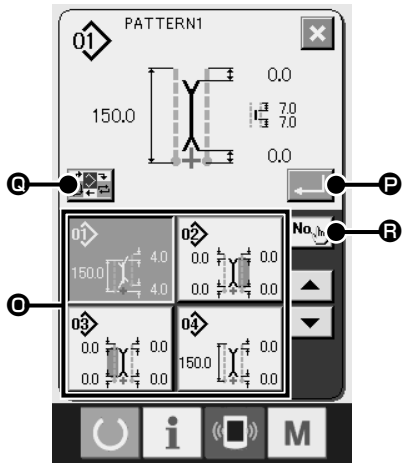
③ 登记直接图案。

按了直接图案登记按键 Ⓜ 之后，显示出直接图案登记一览画面（画面 A）。



直接图案一览画面
（画面 A）

在直接图案一览画面上，可以自由地可以最多登记 30 个单独缝制 / 交替缝制 / 循环缝制的图案数据。
请经常使用的图案数据进行登记后使用。
按了图案一览按键 Ⓝ 之后，会显示出直接图案选择画面（画面 B）。



直接图案选择画面
（画面 B）

请用图案选择按键 Ⓞ 选择想登记的图案。
另外，按了 No. 输入按键 Ⓡ 之后，就会显示出十数字键，然后可以用十数字键的输入功能选择想登记的图案。

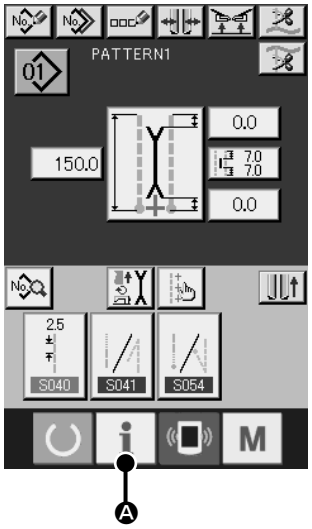
参考 再次按了选择的按键之后，选择可以被解除。

按了确定按键 Ⓟ 之后，则结束向直接按键的登记，然后返回直接图案一览画面（画面 A）。
按了模式变换按键 Ⓠ 之后，可以向单独 → 交替 → 循环缝制进行变换。

参考 购买时，直接按钮上没有登记图案。

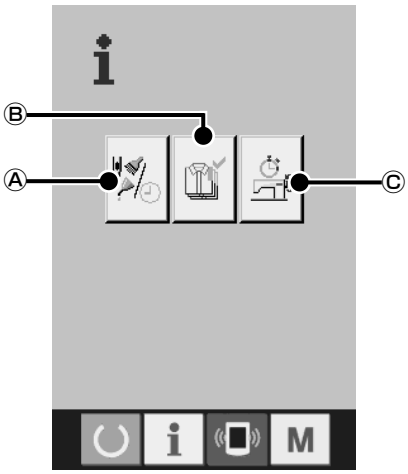
14. 使用信息时

在信息功能中有以下 3 种功能。



① 显示信息画面

在输入画面，按了开关表的信息键 ❹ 之后，信息画面（画面 A）被显示出来。



信息画面（画面 A）

Ⓐ 维修检查信息

指定机油更换（加润滑脂）时期、机针更换事前、清扫时期等，经过指定时间之后，可以发出通知警报。

→请参阅 "VI-14. (1) 看维修检查信息时 " p. 78。

Ⓑ 生产管理信息

指定机油更换（加润滑脂）时期、机针更换事前、清扫时期等，经过指定时间之后，可以发出通知警报。

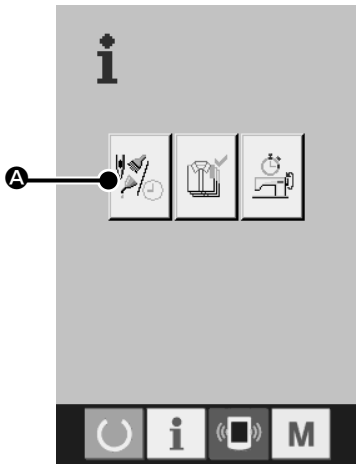
→请参阅 "VI-14. (3) 看生产管理信息时 " p. 80、"VI-14. (4) 设定生产管理信息时 " p. 82。

Ⓒ 运转测定信息

通过缝纫机的运转情况，可以显示机器运转率、间隔时间、机器时间、机器速度等信息。

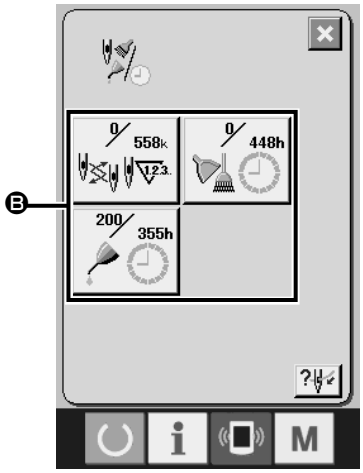
→请参阅 "VI-14. (5) 看运转测定信息时 " p. 84。

(1) 看维修检查信息时



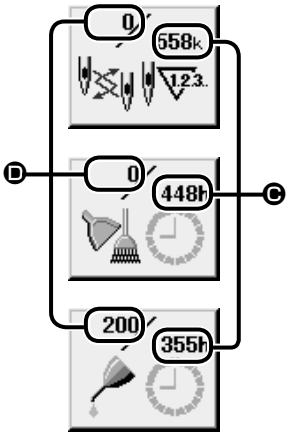
① 显示维修信息画面

请按显示信息画面的维修检查信息画面按钮 Ⓐ。

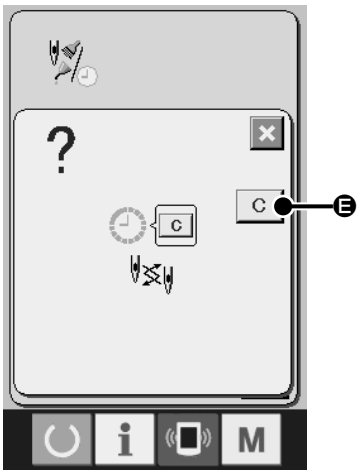


在维修检查信息画面上显示以下 3 种信息。

- 机针更换（1,000 针）：
- 清扫时间（小时）：
- 机油更换时间（小时）：



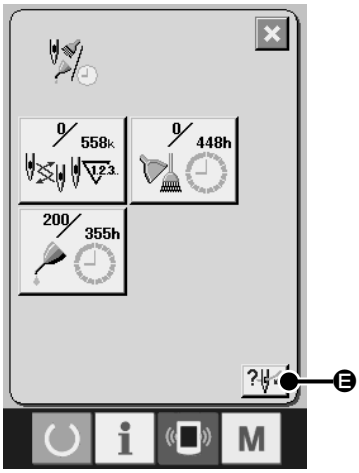
在各种项目按钮 Ⓑ 上显示着通知检查的间隔 Ⓒ 和至更换为止的剩余时间 Ⓓ。
另外，可以清除至更换为止的剩余时间。



② 清除至更换为止的剩余时间

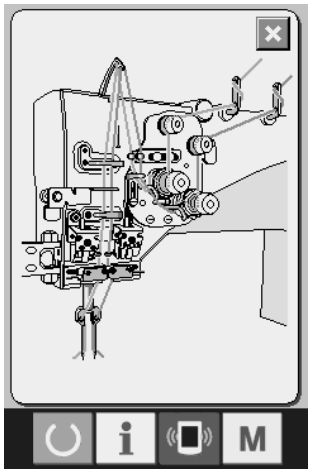
按了想清除的项目按钮 Ⓑ 之后，清除更换时间画面被显示出来。

按了清除按钮 C Ⓔ 之后，至更换的剩余时间被清除。

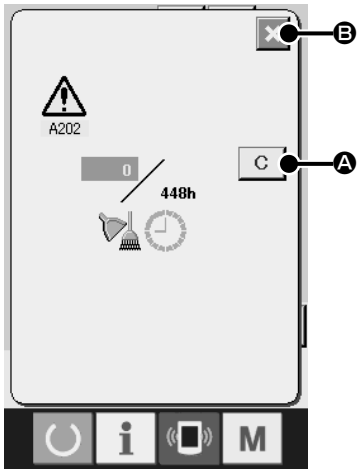


③ 显示穿线图

按了在维修检查信息画面上显示的穿线按钮 [?] Ⓔ 之后，上线穿线图被显示出来。
穿线时，请参考使用。



(2) 警告的解除方法



到了指定的检查时间之后，警告画面被显示出来。
清除检查时间时，请按清除按钮 [C] Ⓐ。清除检查时间，关闭凸起画面。不清除检查时间时，请按取消按钮 [×] Ⓑ，然后关闭凸起画面。
直至清除检查时间之前，每 1 缝制结束后显示警告画面。

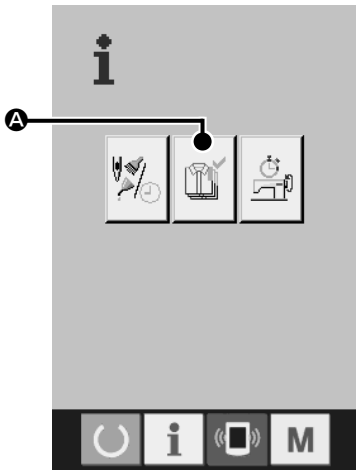
各项目的警告号码如下所示。

- 机针更换　　：A201
- 清扫时间　　：A202
- 机油更换时间：A203

(3) 看生产管理信息时

在生产管理画面上，指定开始，可以显示从开始直至现在的生产件数、生产目标件数等。生产管理画面有以下 2 种显示方法。

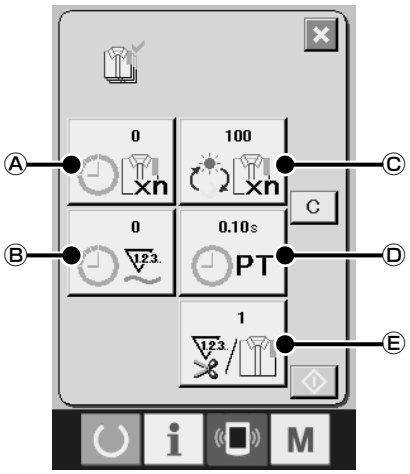
[在信息画面显示时]



① 显示生产管理画面

请按信息画面的显示生产管理画面按钮 Ⓐ。生产管理画面被显示出来。

在生产管理画面上显示着以下 5 种信息。



Ⓐ：现在的目标值
自动地显示现在的目标缝制件数。

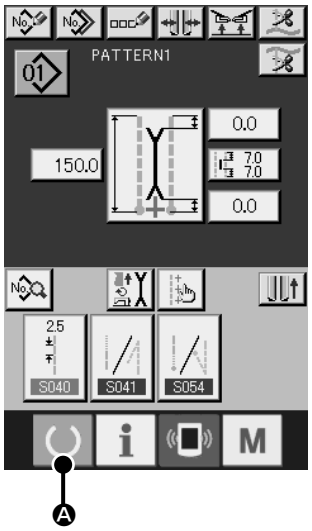
Ⓑ：实际值
自动地显示缝制的件数。

Ⓒ：最终目标值
显示最终目标缝制件数。

Ⓓ：间隔时间
显示 1 工序花费的时间（秒）。

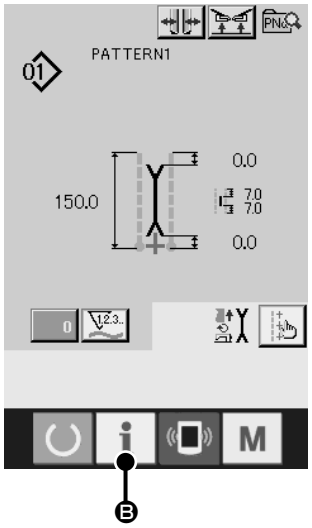
Ⓔ：切线次数
显示平均 1 工序的切线次数。

参考 请参照 "VI-14. (4) 设定生产管理信息时 " p. 82，输入Ⓒ件数、Ⓓ时间（单位 ：秒）、Ⓔ次数。



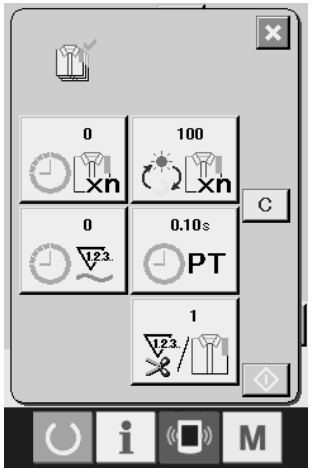
① **显示缝制画面**

在输入画面按了模式变换键 Ⓐ之后，缝制画面被显示出来。



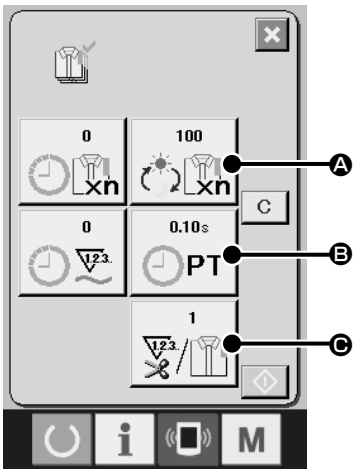
② **显示生产管理画面**

在缝制画面按了信息键 Ⓑ之后，生产管理画面（画面 A）被显示出来。



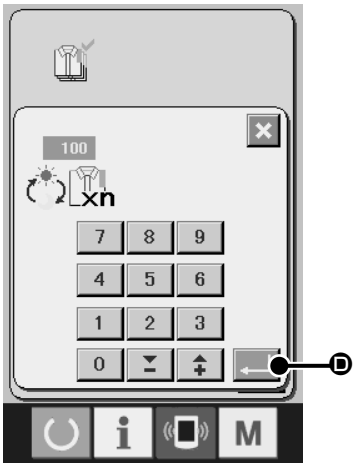
显示内容和功能与「在信息画面显示时」相同。

(4) 设定生产管理信息时



① **显示生产管理画面**

请参照 "VI-14. (3) **看生产管理信息时** " p. 80，显示生产管理画面。



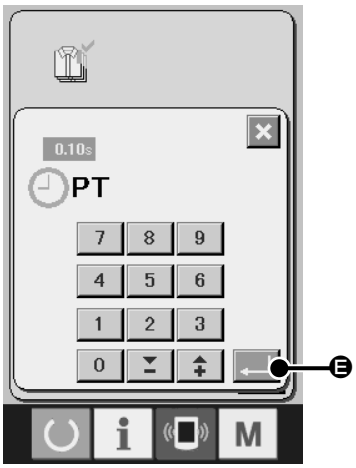
② **输入最终目标值**

首先，请输入以后缝制工序的生产目标件数。

按了项目①的最终目标值按钮 Ⓐ 之后，最终目标值输入画面被显示出来。

请用十数字键或上下箭头按钮输入想要输入的值。

输入后，请按确定按钮 Ⓓ。



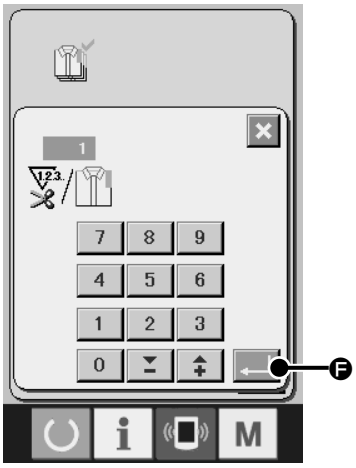
③ **输入间隔时间**

接着，请输入 1 工序花费的间隔时间。

按了项目①的间隔时间按钮 Ⓑ 之后，间隔时间输入画面被显示出来。

请用十数字键或上下箭头按钮输入想要输入的值。

输入后，请按确定按钮 Ⓔ。



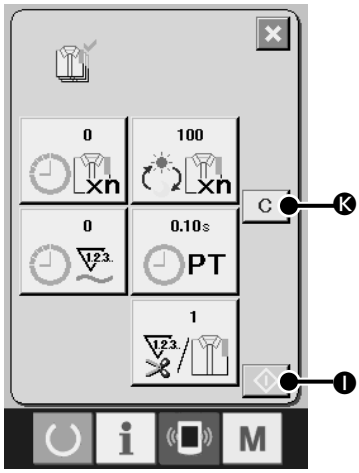
④ **输入切线次数**

接着，请输入平均 1 工序的切线次数。

按了项目①的切线次数按钮 Ⓒ 之后，切线次数输入画面被显示出来。

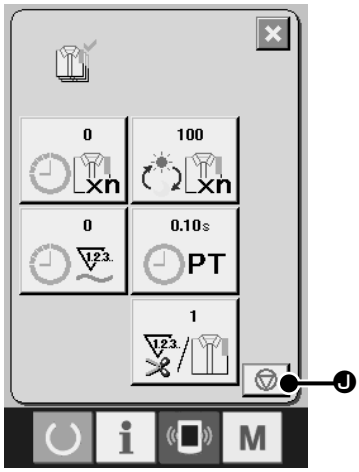
请用十数字键或上下箭头按钮输入想要输入的值。输入后，请按确定按钮 Ⓕ。

※ 输入值是 0 时，切线次数不计数。请连接外部开关后使用。



⑤ **开始生产件数的计数**

按了开始按钮 ❶ 之后，开始计数生产件数。

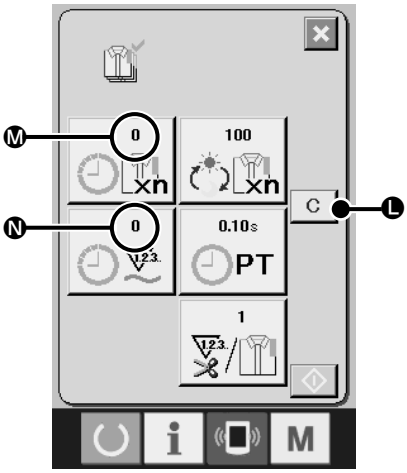


⑥ **停止计数**

请参照 "VI-14. (3) **看生产管理信息时** " p. 80，显示生产管理画面。

在计数时，停止按钮 ❶ 被显示。按了停止按钮 ❶ 之后，计数停止。

停止后，在停止按钮位置的开始按钮 ❶ 被显示。如果继续进行计数时，请再次按开始按钮 ❶。直至按了清除按钮 C ❹ 之前，计数的值不被清除。

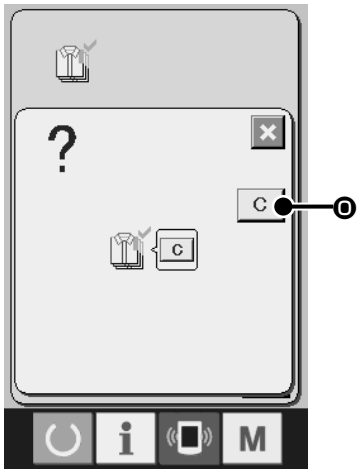


⑦ **清除计数值**

清除计数值时，首先停止计数，然后请按清除按钮 C ❺。

被清除的值仅为现在的目标值 ❼ 和实际值 ❽。

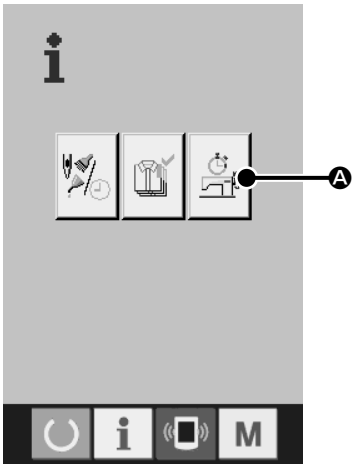
※ 仅在停止状态时显示清除按钮。



按了清除按钮 C ❺ 之后，显示清除确认画面。

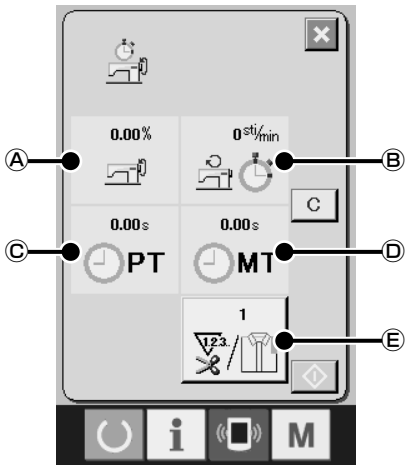
在清除确认画面，按了清除按钮 C ❿ 之后，计数值被清除。

(5) 看运转测定信息时



① 显示运转测定画面

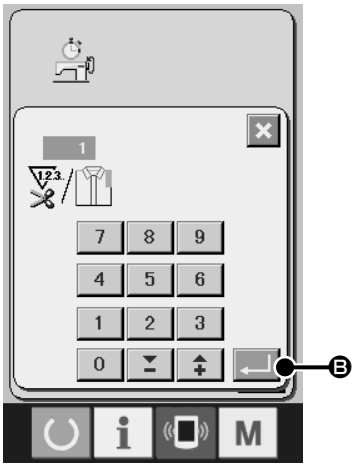
请按信息画面的显示运转测定画面按钮 Ⓐ。显示运转测定画面（画面 A）。



运转测定画面（画面 A）

在运转测定画面上显示着以下 5 种信息。

Ⓐ：自动地显示从开始测定时起的运转率。
Ⓑ：自动地显示从开始测定时起的平均机器速度。
Ⓒ：自动地显示从开始测定时起的平均间隔时间。
Ⓓ：自动地显示从开始测定时起的平均机器工作时间。
Ⓔ：显示平均 1 工序的切线次数。
请参照下一项目②，输入次数。



② 输入切线次数

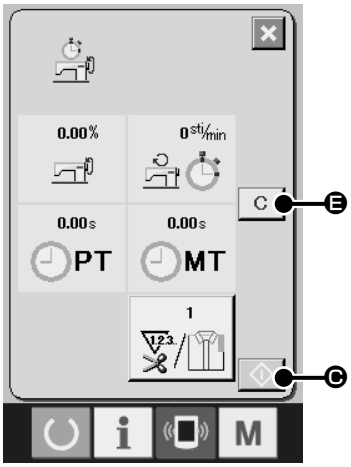
接着，请输入平均 1 工序的切线次数。

按了切线次数按钮 Ⓔ之后，切线次数输入画面被显示出来。

请用十数字键或上下箭头按钮输入想输入的值。

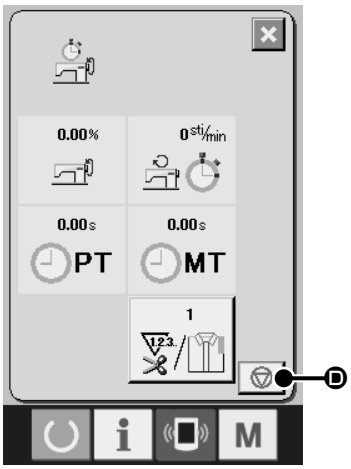
输入后，请按确定按钮 Ⓑ。

※ 输入值是 0 时，切线次数不计数。
请连接外部开关后使用。



③ **开始测定**

按了开始按钮 ◇ Ⓒ 之后，开始各数据的测定。

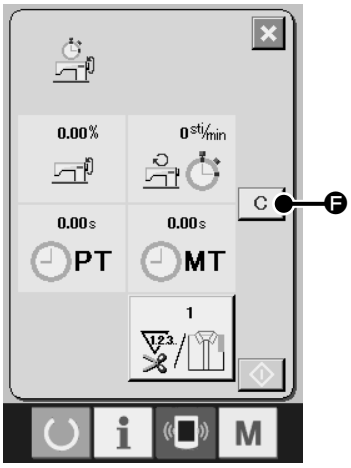


④ **停止计数**

请参照 "VI-14. (5) **看运转测定信息时** " p. 84 的项目①、②，显示运转测定画面。

在测定时，停止按钮 ⊘ Ⓓ 被显示。按了停止按钮 ⊘ Ⓓ 之后，测定停止。

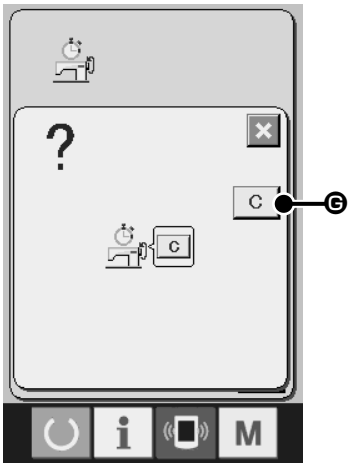
停止后，在停止按钮位置的开始按钮 ◇ Ⓒ 被显示。如果继续进行测定时，请再次按开始按钮 ◇ Ⓒ。直至按了清除按钮 C Ⓔ 之前，测定的值不被清除。



⑤ **清除计数值**

清除计数值时，首先停止计数，然后请按清除按钮 C Ⓕ。

※ 仅在停止状态时显示清除按钮。



按了清除按钮 C Ⓕ 之后，显示清除确认画面。

在清除确认画面，按了清除按钮 C Ⓖ 之后，计数值被清除。

15. 使用通讯功能时

使用通讯功能，可以把其他缝纫机编制的缝制数据下载到此缝纫机。另外，还可以把上述数据加载到记忆媒体或电脑里。
作为通讯的媒体，本机备有记忆媒体和 USB 通讯接口。

(1) 关于可以使用的数据

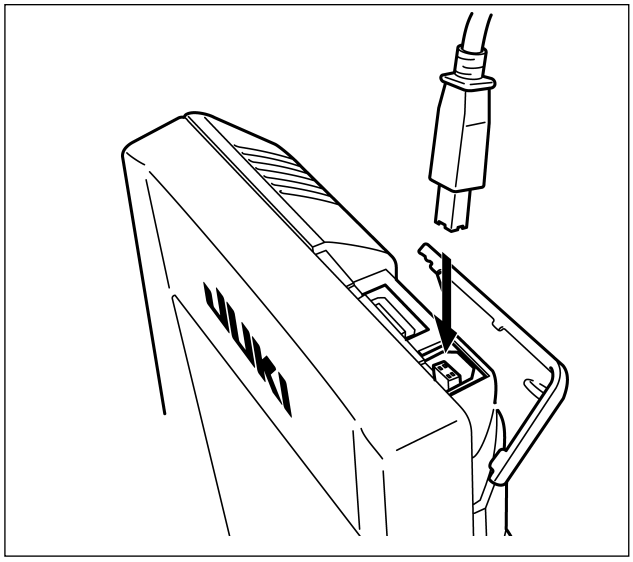
数据名称		后缀	数据内容
缝制数据		APW ××× .EPD	用缝纫机编制的 APW 专用缝制数据

××× : 文件 No.

(2) 使用媒体进行通讯时

有关媒体的使用方法，请参阅 "VI-1. 前言 " p.22。

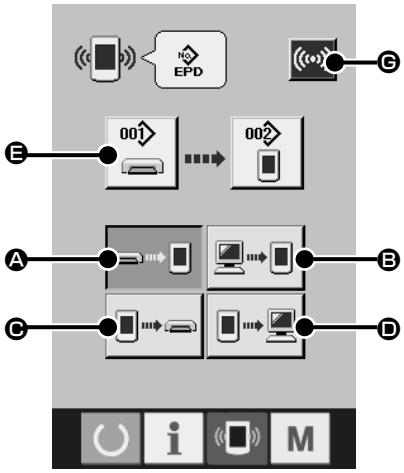
(3) 使用 USB 进行通信时



把 USB 电缆连接到电脑等上，进行数据的存取。

触点部如果脏污会造成接触不良，因此请不要用手触摸，也不要沾上脏污，灰尘，油等异物，妥善保管。另外，静电会造成内部元件的损坏，请充分注意。

(4) 装入数据时



通讯画面（画面 A）

① 显示通讯画面

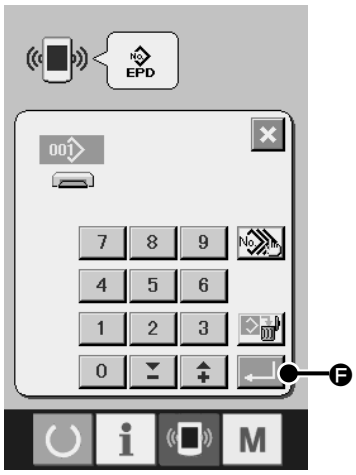
在输入画面，按了开关部的通讯键 之后，通讯画面（画面 A）被显示出来。

② 选择通讯方法

通讯方法有以下 4 种。

Ⓐ 媒体 → 操作盘写入数据
Ⓑ 电脑（服务器）→ 操作盘写入数据
Ⓒ 操作盘 → 媒体写入数据
Ⓓ 操作盘 → 电脑（服务器）写入数据

请选择希望的通讯方法按钮。



③ 选择数据号码

按了 Ⓔ 之后，选择写入文件画面被显示出来。

请输入想写入的数据文件号码。请输入文件号码种的文件名 APW×××.EPD 的 ××× 部分的数字。
可以同样地指定写入摸底图案 No.。写入目的对象为操作盘时，未登记的图案 No. 被显示出来。

④ 确定数据号码

按了确定按钮 Ⓕ 之后，选择数据号码画面关闭，返回到通讯画面（画面 A）。

⑤ 开始通讯

按了开始通讯按钮 Ⓖ 之后，开始数据通讯。

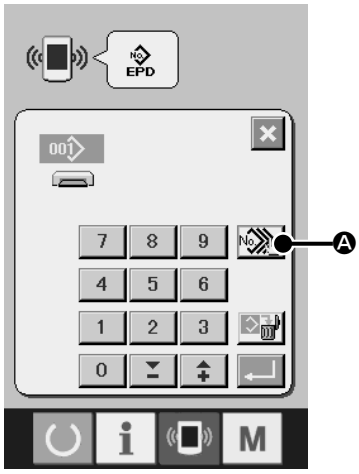
通讯中，显示画面，通讯结束后，返回通讯画面。

注意 读取数据中请不要打开盖子。否则有可能数据不能读取。

(5) 将复数个数据一起写入时

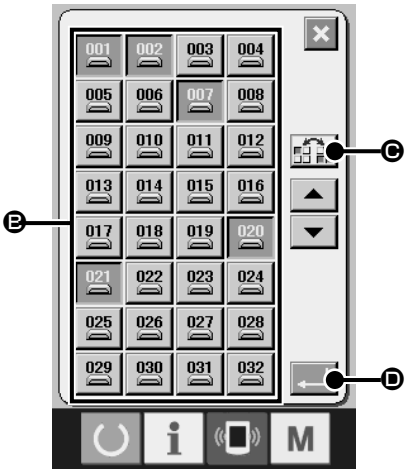
可以选择复数个写入缝制数据，一起写入。写入目的对象的图案 No 与选择的数据号码相同。

重要 媒体 No. 99 以后不能选择复数数据。



① **显示选择写入文件画面**

按了选择复数文件按钮 Ⓐ 之后，选择复数个数据号码画面被显示出来。

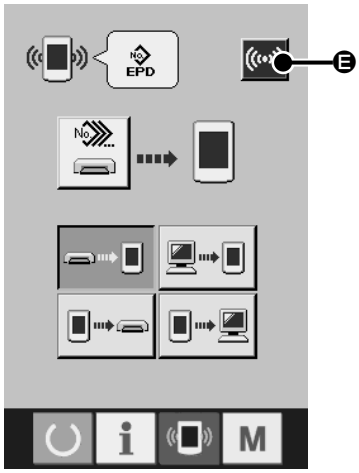


② **选择数据号码时**

保存的数据文件号码一览被显示出来，因此请按想写入的文件号码按钮 Ⓑ。也可以用反转按钮 Ⓒ，反转按钮的选择状态。

③ **确定数据号码**

按了确定按钮 Ⓓ 之后，选择复数个数据号码画面关闭，选择数据的工作结束。



④ **开始通讯**

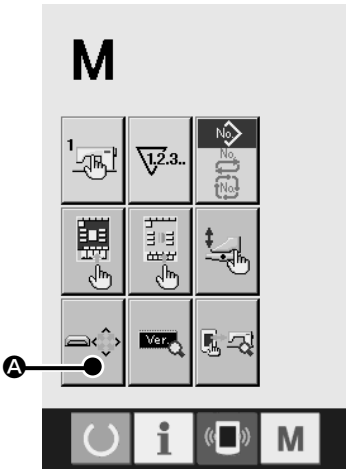
按了开始通讯按钮 Ⓔ 之后，开始数据通讯。

在通讯中画面上，通讯中的数据号码、写入数据总数以及数据通讯结束的数据数被显示出来。

＊ 向已经保存的图案 No. 上写入时，写入前，确认改写画面被显示出来。改写时，请按确定按钮 ↵ Ⓕ。
不显示改写确认画面，进行全部改写时，请按全部改写按钮 ALL Ⓖ。

16. 进行媒体的格式化时

要再次初期化媒体时，请一定用 IP-420 来进行。电脑进行初期化的媒体 IP-420 不能读取使用。



① **显示媒体初期化画面**

持续 3 秒钟按马达变换键 M 之后，在画面上显示出媒体格式化按键 Ⓐ。按了此按键之后，就会显示出媒体格式化画面。

② **开始媒体的初期化**

把想初期化的媒体安装到媒体插口，然后盖上盖子，按确定按键 Ⓑ 之后，开始初期化。

初期化之前，请事先把媒体里需要的数据保存到其他媒体里。

初期化之后，内部的数据将被消去。

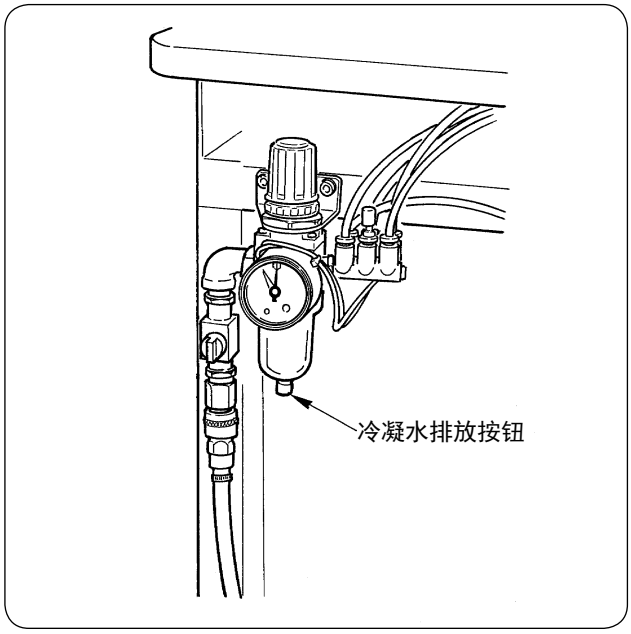
VII. 维修

1. 检查

为了保持本机的功能，请一定定期地实施以下的维修检查。
如果不进行维修检查的话，就有可能发生机械故障，因此请一定定期地实施维修。

(1) 压缩空气装置的维修检查

⚠注意	为了防止突然的起动发生事故，请不要把手、脚、脸、工具放到上面。



- 请每日排放出冷凝水。请按过滤器下部的冷凝水排放按钮，排放冷凝水。

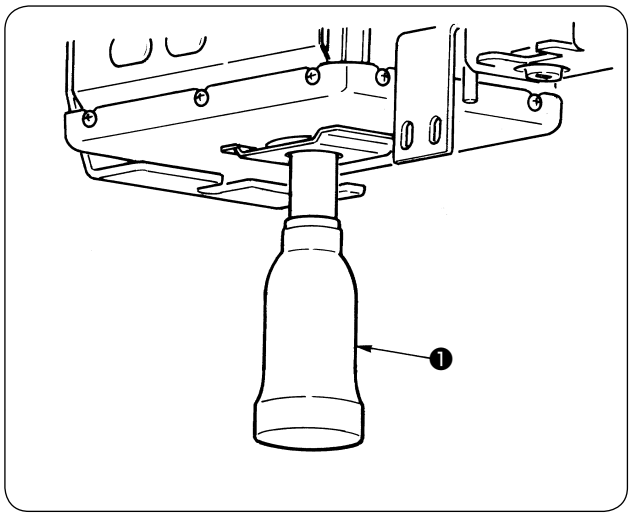
(2) 有关缝纫机的维修检查

⚠注意	为了防止突然的起动造成事故，请关掉电源之后再进行操作。

- 在大压脚等机器零件上如果粘附了灰尘之后，会影响机器的正常动作，因此工作前请一定进行清扫。另外，旋梭护罩内的线屑，请每星期一定清扫一次。
- 工作前，请一定检查中心切刀、角切刀的切割状态，发现切割不良时，请尽快更换。
- 请一定使用指定的 JUKI MACHINE OIL No. 1（MDFRX1600C0）给缝纫机加油。
- 请定期地更换导线器毡垫。（请参照 "V-1. (3) 上线的穿线方法 " p. 14。）

（3）关于旋梭废油

⚠注意	为了防止突然的起动造成事故，请关掉电源之后再进行操作。

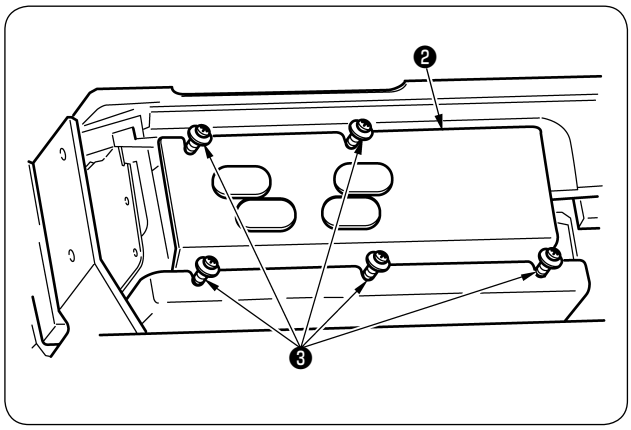


缝纫机机头护罩上的油瓶❶里废油存积到一半之后，请转动油瓶卸下来，扔掉废油。

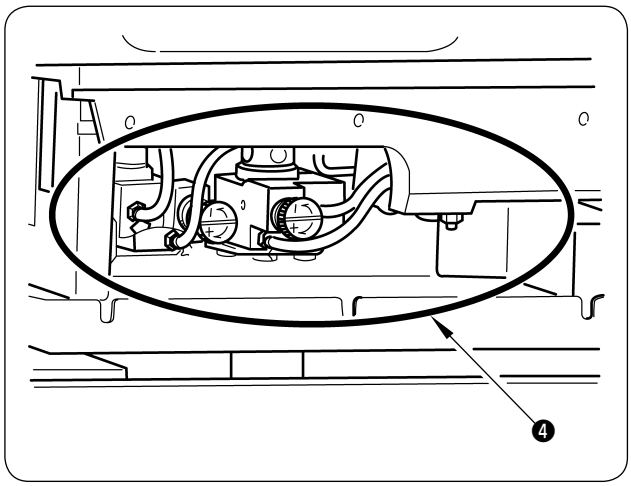
（4）关于旋梭轴座的清扫

⚠注意	为了防止突然的起动造成事故，请关掉电源之后再进行操作。

请定期清扫积存在旋梭油护罩内的布屑等。



- 抬起缝纫机，拧松固定螺丝❸（5 处），慢慢地卸下油护罩❷。



- 请清扫旋梭护罩内部❹。

2. 标记光

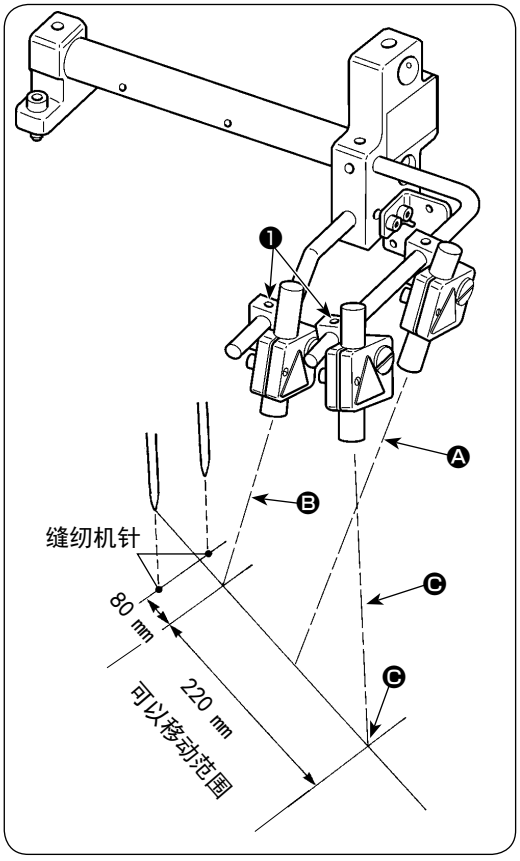
⚠警告

1. 激光直接照射到眼睛之后，会造成视力障碍。请不要窥视激光出光孔。
2. 接通电源的状态下，请绝对不要装卸标记灯。同时也不要使用于标记以外的用途。

⚠危险

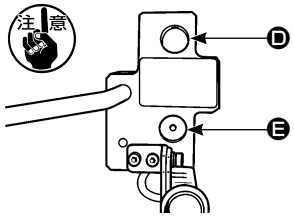
使用规定外的控制装置、调整装置，或者采用规定外的操作程序进行操作时，有被有害放射线照射的危险。

（1）固定标记（标准）



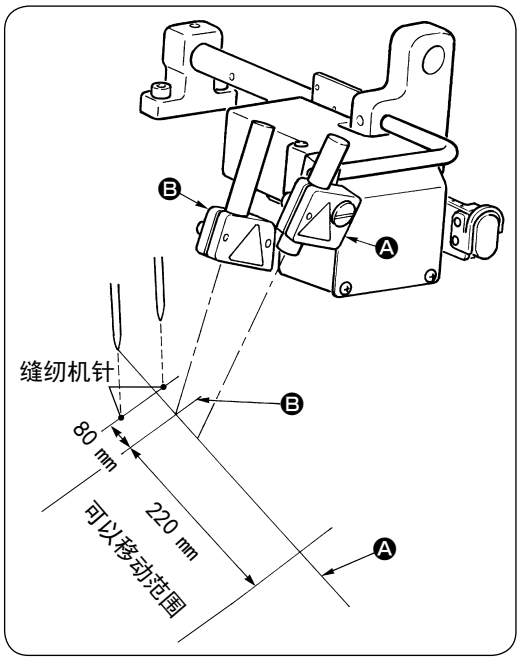
1) 从操作人处看，前侧的标记光作为设定纵线标准用 Ⓐ 使用，里侧的标记光作为设定横线标准 Ⓑ、Ⓒ 使用。

2) 标记光的横线照射位置，有缝制规格来决定，请拧松螺丝❶，调整标记灯 Ⓑ 和 Ⓒ 的角度。

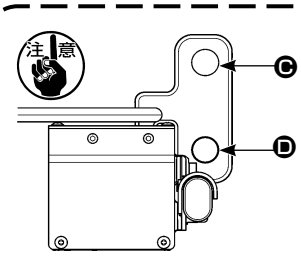


· 标尺尺寸为 8 ～ 16mm 时，请使用下侧的安装孔 Ⓔ，18mm 以上时，请使用上侧的安装孔 Ⓓ。

（2）移动标记（选项）

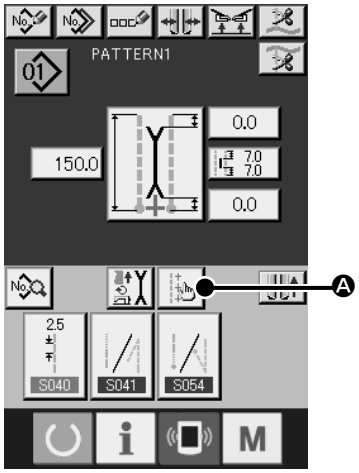


从操作人处看，前侧的标记光作为设定纵线标准用（固定）Ⓐ 使用，里侧的标记光作为设定横线标准（根据缝制规格移动）Ⓑ 使用。



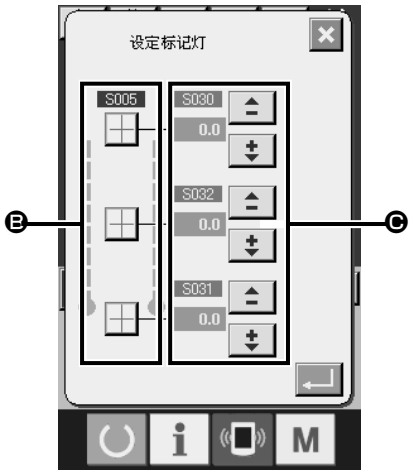
· 标尺尺寸为 8 ～ 16mm 时，请使用下侧的安装孔 Ⓓ，18mm 以上时，请使用上侧的安装孔 Ⓒ。
· 上下安装位置变更后，请一定进行标记光马达原点调整。

（3）标记光照射位置的调整



1） 按了输入画面的按钮 Ⓐ 之后，显示设定标记光画面，可以调整标记光的照射位置。

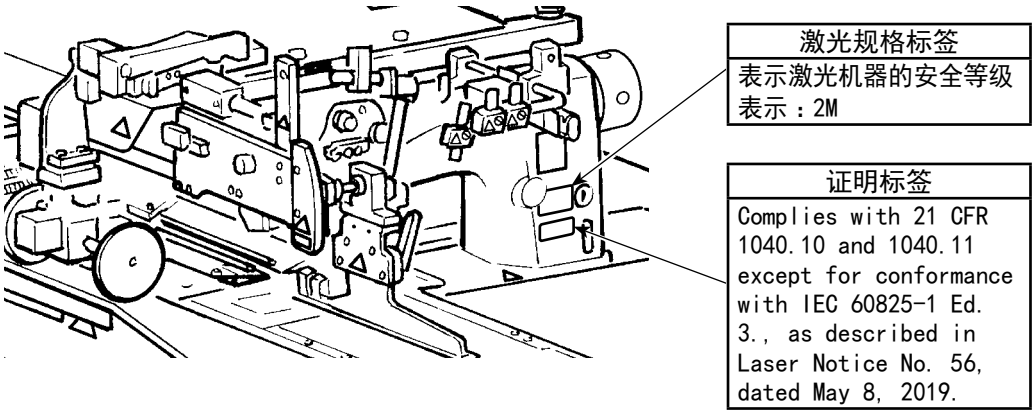
2） 标记光的横线照射位置根据缝制规格来决定，根据 Ⓑ「 S005 开始缝制照射 / 结束缝制照射 / 中心照射的变换」和「 S004 L 尺寸设定」自动地移动照射位置。
Ⓒ 的补正值为 0.0mm 时，标记光照射缝制位置。



3） 对于缝制位置，想移动标记光照射位置时，请设定 Ⓒ 的各种补正值之后再使用。

S030 ： 开始缝制照射位置补正
S031 ： 结束缝制照射位置补正
S032 ： 中心照射位置补正

激光规格	
横基准激光	纵基准激光
2 级 激光产品	2M 级 激光产品
最大输出 ： 1.0mW	最大输出 ： 3.5mW
波长 ： 650nm	波长 ： 650nm
安全规格	
JIS C 6802 ： 2014	
IEC 60825-1 ：2014 Ed.3	



3. 向规定部位补充润滑脂

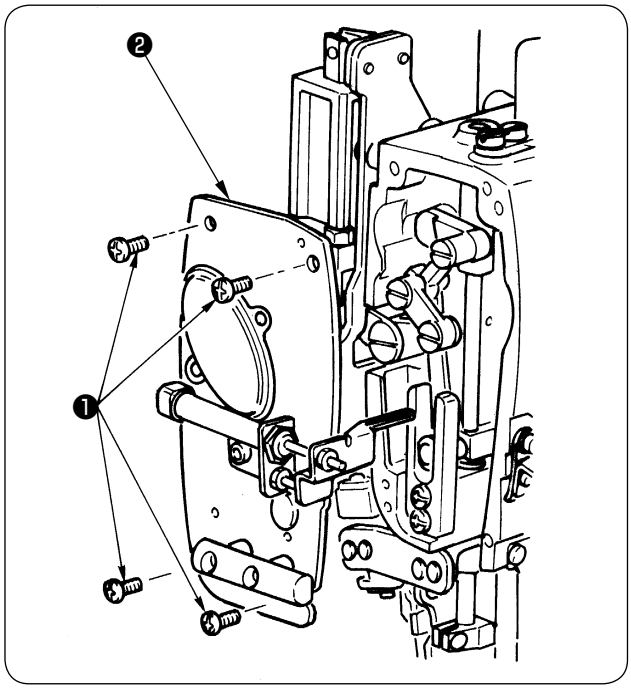
※ 「补充润滑脂警告 E220」、「补充润滑脂错误 E221」显示时，或使用了 1 年后，请一定补充润滑脂。

缝纫机动作了 4000 万针以后，打开电源时，在操作盘上会显示处通知向规定部位补充润滑脂的「补充润滑脂警告 E220」。按复位按钮 [//] ，退出错误画面之后，可以继续使用，但是错误不能接触，再次打开电源时，还会显示错误。补充了润滑脂之后，叫出「存储器开关 U245 」，然后用清除按钮 C 把动作针数复位到“0”。

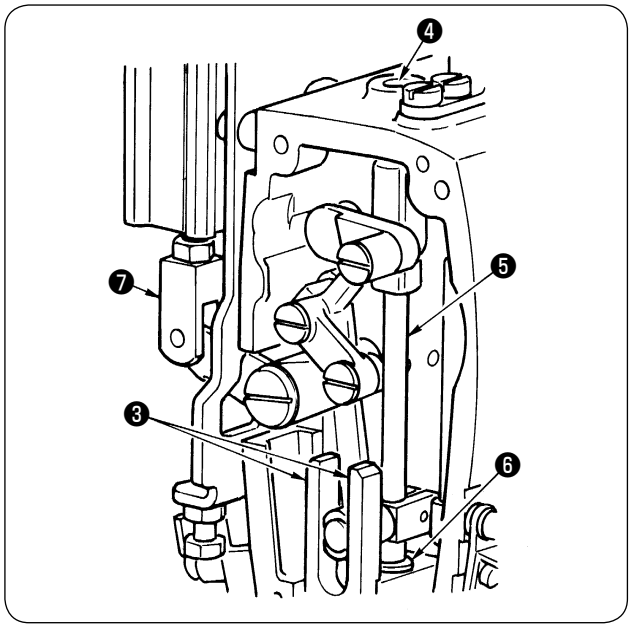
继续使用达到 4800 万针之后，在操作盘上会显示「补充润滑脂错误 E221」。此时，按复位按钮 [//] ，接触了错误画面之后也不能缝制。请一定补充润滑脂，叫出「存储器开关 U245 」，然后用清除按钮 C 把动作针数复位到“0”。

1. 补充润滑脂后，如果不把存储器开关 U245 清除到“0”，「补充润滑脂警告 E220」、「补充润滑脂错误 E221」还会再次显示。
2. 下面说明的向规定部位补充润滑脂，请一定使用复数的润滑脂软管（货号 : 40006323）。补充了规定外的润滑脂的话，有可能损坏零件。
3. 请您一定注意保管好使用后的润滑脂软管。

⚠注意 为了防止突然的起动造成事故，请关掉电源之后再进行操作。

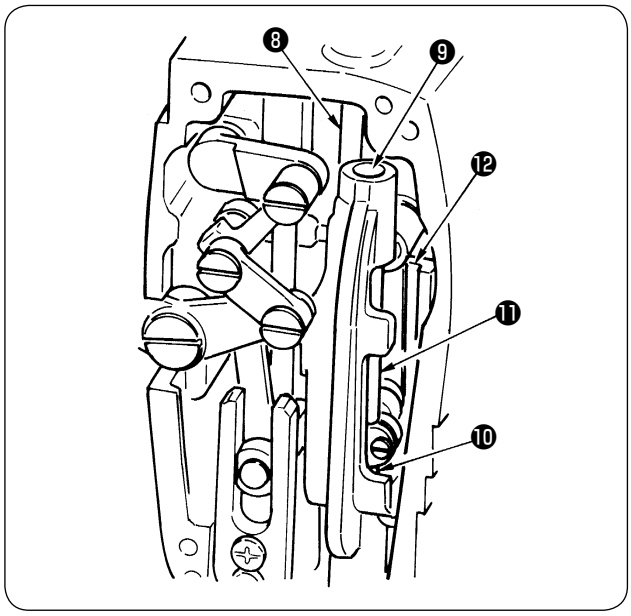


① 卸下 4 个固定螺丝❶，然后取下面板❷。



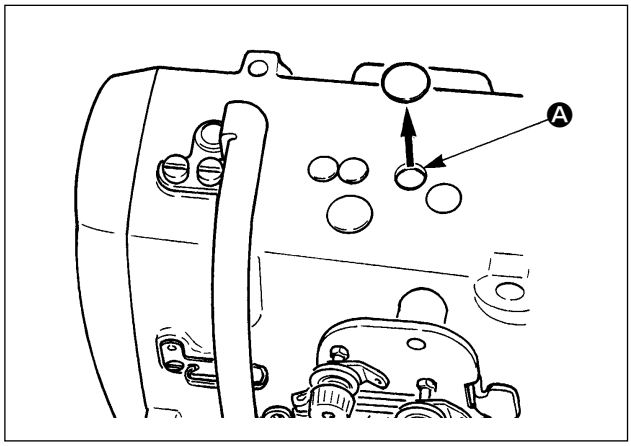
② 向中心刀补充润滑脂

- 向导向器两面❸、切刀杆金属部件上❹、切刀杆金属部件下❻涂抹润滑脂。
- 在没有供给空气的状态下，上下移动起杠接头❼，切刀杆❺就会上下移动，让金属部件内的润滑脂向里面浸透。



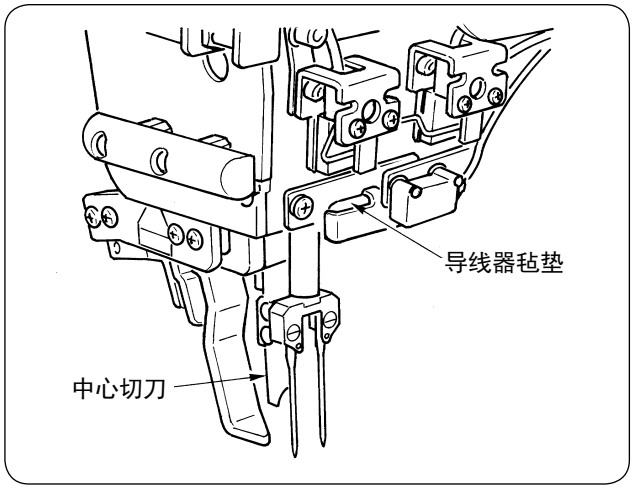
③ 向针杆补充润滑脂

向挑线杆❽、针杆上部❾、针杆下部⓾、针杆⓫、针杆⓬涂抹润滑脂。



④ 卸下橡胶盖，清除掉 Ⓐ 孔中粘附的旧润滑脂，然后向孔里注入新的润滑脂，再盖上橡胶盖。

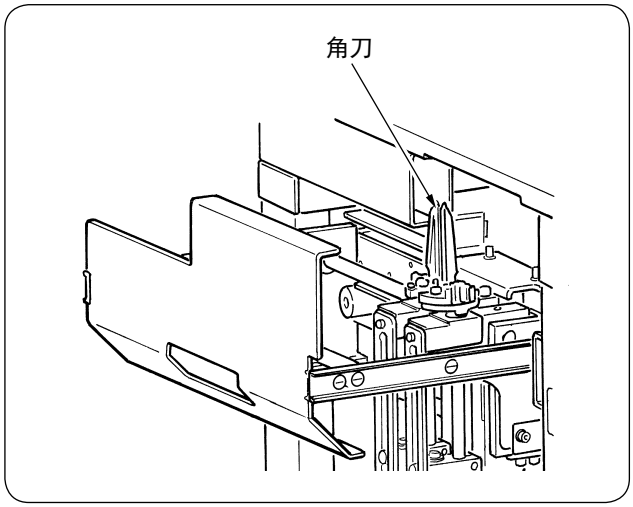
4. 关于更换消磨零件



以下的零件是消磨零件，请定期地进行更换。

· 导线器毡垫（货号 ： 40034444）
不定期地更换零件的话，穿线部分磨损，而发生断线现象。

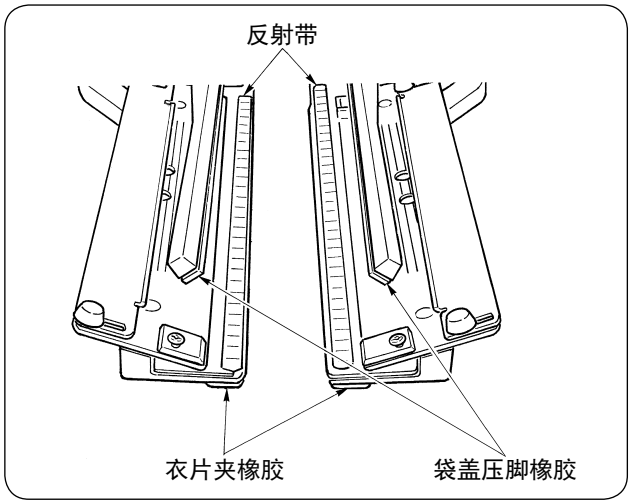
· 中心切刀（货号 ： 40026155）



· 角刀

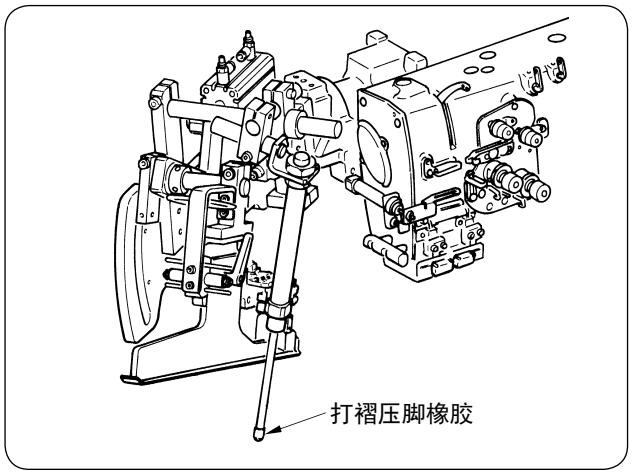
标尺尺寸	货号
8 ～ 14㎜	16607301、16607400
16 ～ 20㎜	16607509、16607608
22 ～ 26㎜	16607707、16607806
28 ～ 32㎜	16607905、16608002

不定期地更换零件的话，会发生切线不良，影响缝制产品的质量。



· 衣片夹橡胶

	品番
标准	40034825
长尺寸宽幅规格	40040827



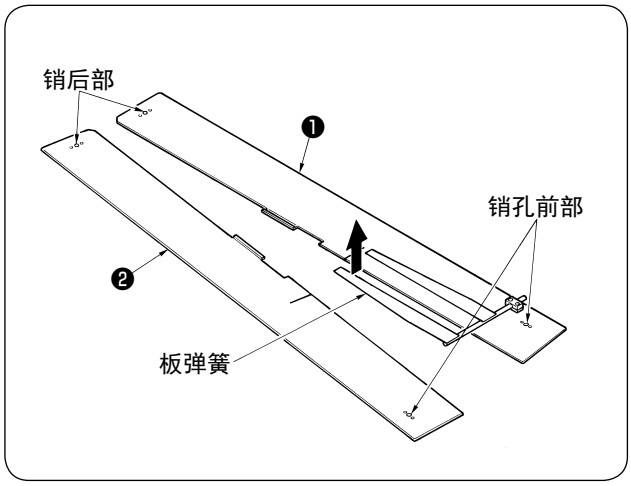
· 打褶压脚橡胶（货号 ： 40034733）

布定期地更换零件的话，压布压脚功能下降，影响缝制产品质量。

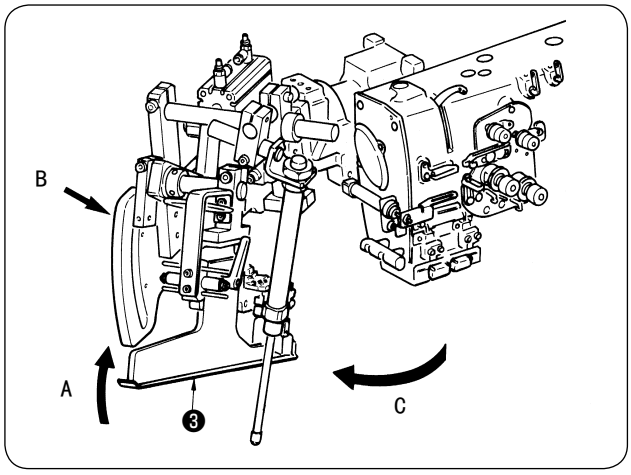
5. 缝纫机的放倒方法

⚠注意

· 为了防止突然的起动造成事故，请关掉电源之后再进行操作。
· 放倒缝纫机或抬起缝纫机时，请注意不要夹到手、手指等。

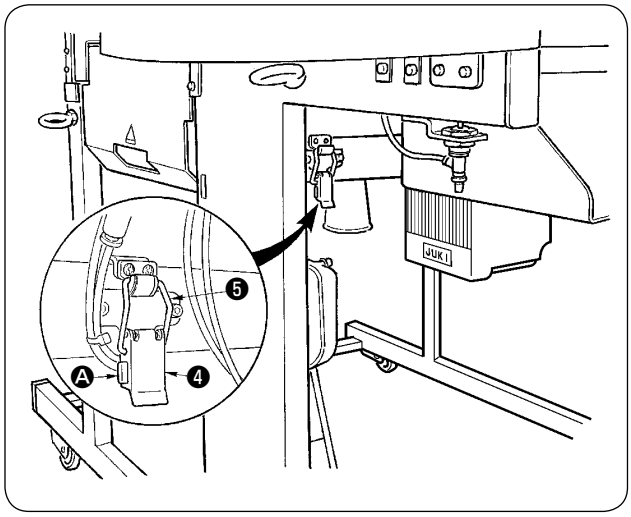


① 取下缝制机台❶、❷。

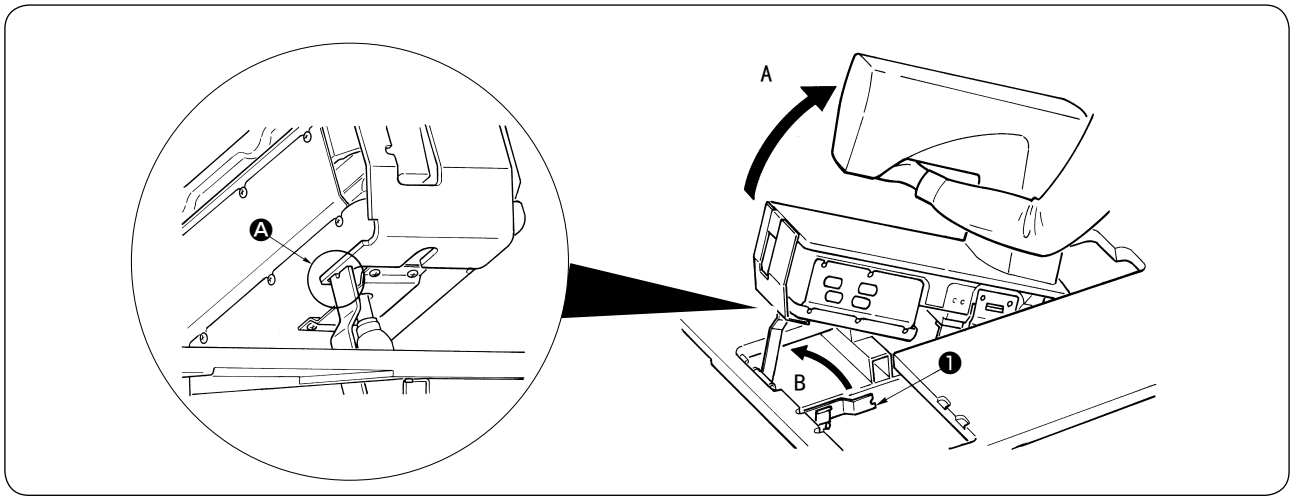


② 转动滚边器。
向 A 方向抬起滚边器❸之后，用手支撑 B 部，让整个滚边器向 C 方向转动。

参考 因为滚边器被球塞锁定，请用力向 C 方向转动解除锁定。



③ 解除缝纫机固定铰链。
一边按压 Ⓐ 部，一边解除缝纫机固定铰链❹，然后取下铰链钩❺。



⚠注意	1. 转动缝纫机机头时，请一定 2 人以上进行操作。 2. 为了防止对人身的伤害，从抬起了缝纫机的状态把缝纫机机头返回到原来的位置时，请确认了气动弹簧下面没有放置工具和零部件之后再把缝纫机机头返回到原来的位置。 3. 为了防止对人身的伤害和缝纫机的损坏，请用工具和部件防护气簧的杆部以免弄上机头。 4. 为了防止对人身的伤害，如果气动弹簧杆部因损伤动作变坏时或动作不良时，请立即进行更换。[请不要使用 JUKI 纯正的气动弹簧（货号 : 40023177）以外的零件。] 5. 为了防止发生人身伤害事故，卸下气簧的状态下请不要使用缝纫机。

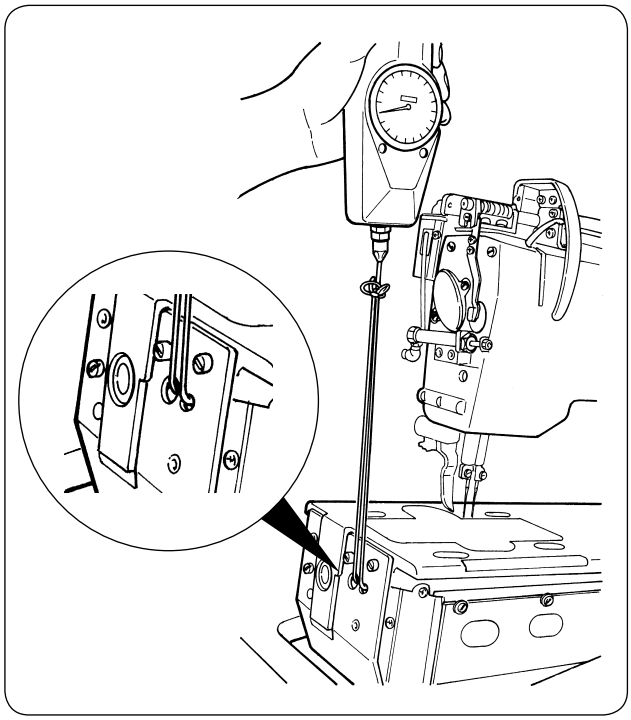
④ 转动缝纫机。

- 拿着缝纫机机架下侧，把整个缝纫机向 A 方向拉。
- 向B方向抬起缝纫机固定板❶，把缝纫机固定❶板的前端插入缝纫机机台孔，然后固定缝纫机。（参照Ⓐ）

⑤ 返回缝纫机时，请按照相反的顺序安装缝纫机。

6. 气簧的大致更换时期

⚠注意	• 为了防止突然的起动造成事故，请关掉电源之后再进行操作。 • 放倒缝纫机或抬起缝纫机时，请注意不要夹到手、手指等。



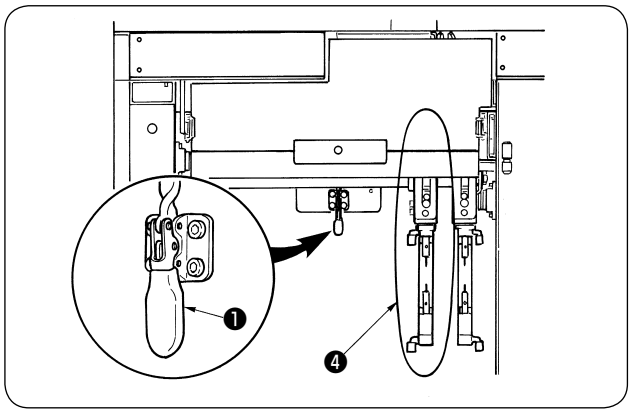
气簧是消耗品，即使使用次数很少，但是气簧内部的气体也会自然泄漏，而不能发挥确保安全的推力。如左图所示那样，把绳子穿过机台前端的孔，起吊缝纫机时需要 130N 以上的力时，请立即更换新的 JUKI 纯正的气簧（货号 : 40023177）。

注意 气簧是非常精密的娇贵零件，如果杆部损伤或气簧不能伸缩时，横向荷重就会出现弱的部分。因此，维修或清扫缝纫机时，请充分注意，以便可以长久地使用缝纫机。

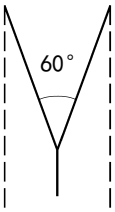
7. 关于角刀的调整

⚠注意

1. 为了防止突然的起动造成事故，请关掉电源之后再进行操作。
2. 为了防止人身事故，请不要用手或手指触摸切刀刃。
3. 为了防止因不熟练造成的事故，或因错误调整造成的事故，调整作业应让接受过安全教育的维修技术人员来进行。
4. 因为这是用螺丝刀进行调整的操作，所以请注意不要让手滑动。

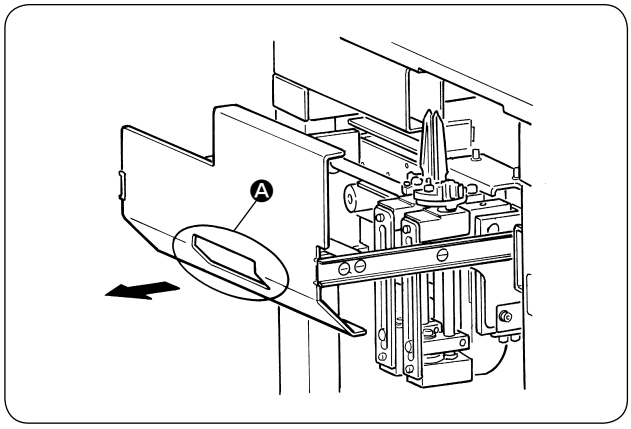


参考 关于本机的角刀调整角度，请让刀刃不容易碰到袋布立起部，出货时大约调整为60°。



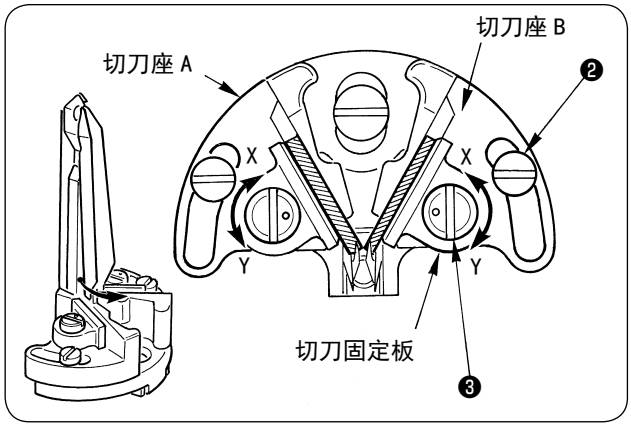
① 解除扭矩夹❶。

注意 在拉出时，请在解除肘夹之前，让移动一侧的角刀❹回到初始位置。
如果在不位于初始位置的状态下拉出，角刀与工作台会接触，有可能造成角刀折损。



② 拿着 Ⓐ 部，向箭头方向拉出。

参考 请拉出，直到顶住。

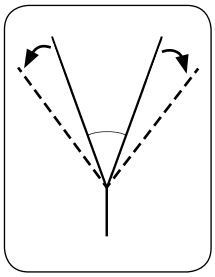


③ 调整方法

[切刀张开角度的调整]

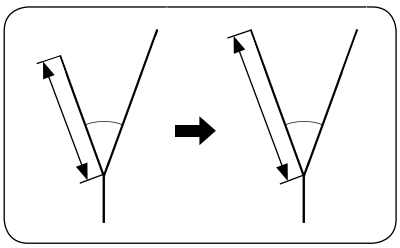
1） 拧松角度调整螺丝❷，调整切刀座 A、B，然后固定。

参考 在左右方向拧送切刀的转动方向不同。



[切刀切割长度的调整]

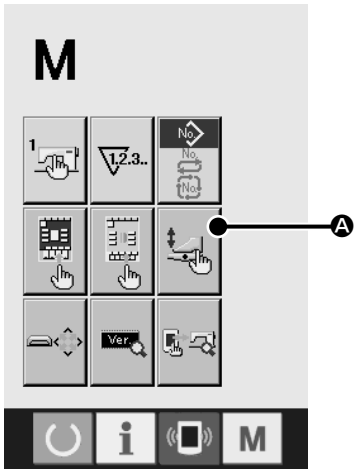
1） 用一字形螺丝刀等向箭头 Y 方向转动偏心销❸，拧松切刀。
2） 倾斜切刀，调整切割长度。
3） 用一字形螺丝刀等向箭头 X 方向转动偏心销❸，固定切刀。



④ 调整结束后，返回原来的位置，用扭矩夹❶固定。

注意 返回时，请把移动侧角刀❹返回到初期位置。

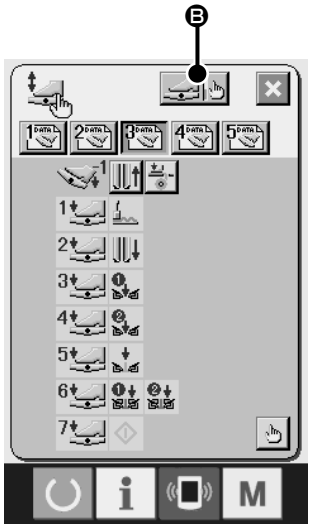
8. 脚踏板的调整方法



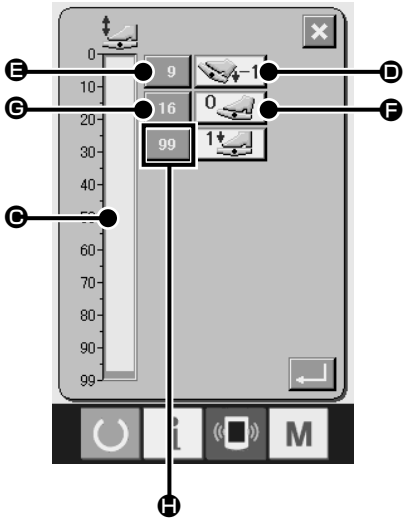
① **显示踏板管理画面**

持续 3 秒钟按模式变换键 M 之后，在画面上显示的踏板管理按钮 Ⓐ 由绿色变为浅蓝色。

按此按钮之后，维修人员登记的管理画面被显示出来。

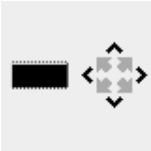
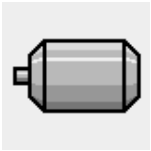
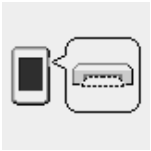
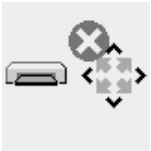


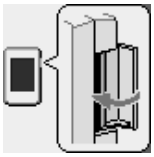
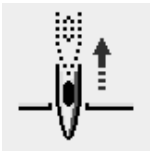
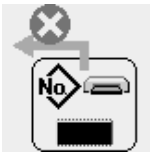
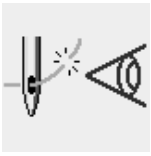
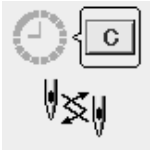
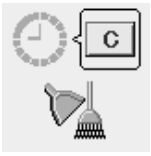
② 只要按下踏板调节按钮 Ⓑ，就会显示踏板调节画面，设定针对踏板操作的数值。

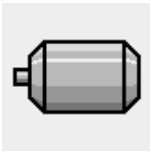
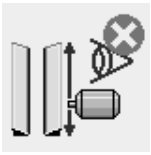
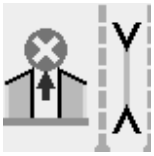
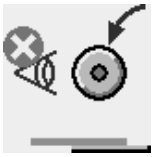
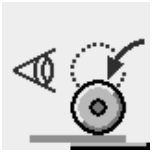
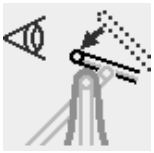


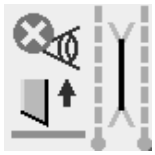
③ 在调整杆显示 Ⓒ 上，在 0 ～ 99 的范围内显示着现在的踏板踩踏状态时踏板传感器电压值。
首先，在踩踏踏板的状态下按倒踩输入按钮 Ⓓ。此时的电压值被输入倒 Ⓔ。然后，在踏板空档状态下按空档输入按钮 Ⓕ。此时的电压值被输入到 Ⓖ。最后，在向前踩下踏板的状态下，按下向前踩下输入按钮 Ⓗ。此时的电压会被输入至 Ⓘ。

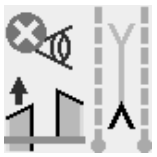
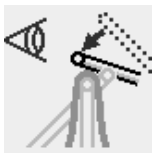
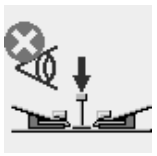
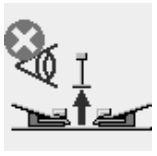
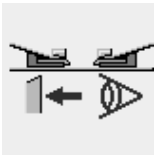
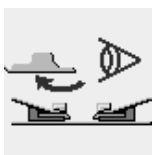
9. 错误代码一览

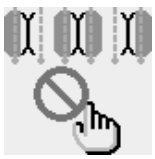
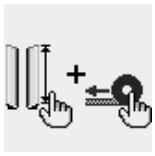
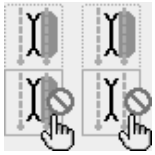
错误代码		错误内容	复位方法
E001		**主 CPU 的 EEP-ROM 初始化**	电源 OFF
E007		**缝纫机锁定** 由于发生若干故障，缝纫机主轴不转动	电源 OFF
E010		**图案 No. 错误** 选择图案 No. 时，没有用十字键登记指定的图案 No	复位后，可以重新起动
E011		**没有插入外部媒体** 没有插入媒体	复位后，可以重新起动
E012		**读取错误** 不能读取媒体的数据	复位后，可以重新起动
E013		**写入错误** 不能把数据写入媒体	复位后，可以重新起动
E015		**格式化错误** 不能格式化媒体	复位后，可以重新起动
E016		**超过外部媒体容量** 媒体的容量不足	复位后，可以重新起动
E022		**文件 No. 错误** 在服务器或媒体中没有指定文件	复位后，可以重新起动
E024		**图案数据超过尺寸** 存储器尺寸超过	复位后，可以重新起动

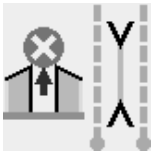
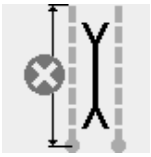
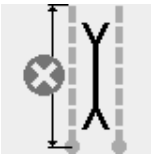
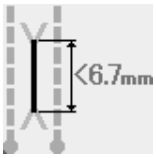
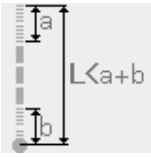
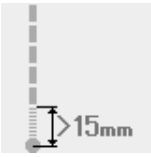
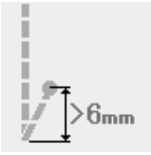
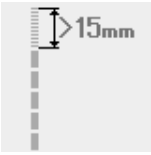
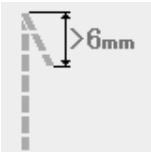
错误代码		错误内容	复位方法
E027		**读取错误** 不能读取服务器的数据	复位后，可以重新起动
E028		**写入错误** 不能向服务器写入数据	复位后，可以重新起动
E029		**媒体插孔的盖开着**	复位后，可以重新起动
E030		**针杆上位置偏离** 针杆偏离机针上位置	请转动手飞轮，把针杆返回到上位置。
E031		**空气压力过低** 空气的压力过低	复位后，可以重新起动
E032		**文件兼容异常** 文件不能读取	复位后，可以重新起动
E045		**图案数据异常** 花样图案数据损坏了	复位后，可以重新起动
E050		**停止开关** 按了停止开关后	复位后，可以重新起动
E052		**检测断线错误** 检测断线后	复位后，可以重新起动
A201		**更换机针时期警告** 动作针数达到操作盘设定的更换机针数后	复位后，可以重新起动
A202		**清扫时期警告** 缝纫机的运转时间达到操作盘设定的清扫时间后	复位后，可以重新起动

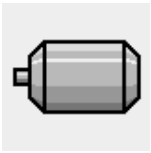
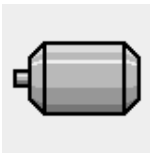
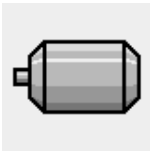
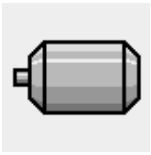
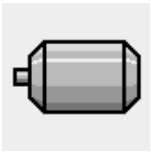
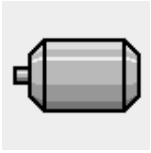
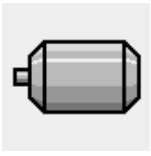
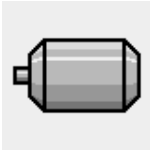
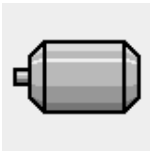
错误代码		错误内容	复位方法
A203		**更换机油时期警告** 缝纫机的运转时间达到了操作盘设定的更换机油时间后	复位后，可以重新起动
E220		**补充润滑脂警告** 动作针数达到 4000 万针后	复位后，可以重新起动
E221		**补充润滑脂错误** 动左针数达到 4800 万针后，变为不能缝制的状态 ＊ 涂了润滑脂后，清除了存储器开关 U245 补充润滑脂针数后可以解除错误。	复位后，可以重新起动
E303		**半月板传感器错误** 不能检测缝纫机的上死点	电源 OFF
E349		**异常检测传感器没有反应** 应急措施是，用复位按钮重新起动，虽然可以继续使用，但是请检查传感器，如果损坏的话，一定进行更换。	复位后，可以重新起动
E366		**中心刀不下降。**	复位后，可以重新起动
E367		**角刀放不进。** M004 长尺寸宽幅规格，角刀张开量超过 250㎜ 时	复位后，可以重新起动
E368		**拉链没有了**	复位后，可以重新起动
E369		**胶辊堆积器下降端传感器不能检测**	复位后，可以重新起动
E370		**走过了胶辊堆积器下降端传感器**	复位后，可以重新起动
E371		**走过了夹杆堆积器布料压脚传感器**	复位后，可以重新起动

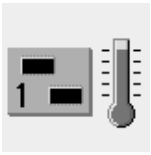
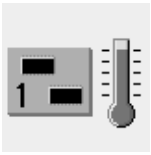
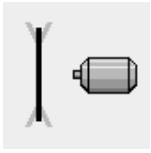
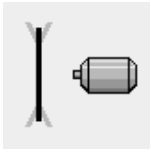
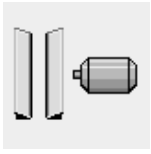
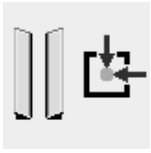
错误代码		错误内容	复位方法
E372		走过了夹杆堆积器送布原点传感器	复位后，可以重新起动
E373		右侧的反射带劣化了	复位后，可以重新起动
E374		左侧的反射带劣化了	复位后，可以重新起动
E376		连续踩踏板错误	复位后，可以重新起动
E377		中心刀上方检测传感器不能检测	复位后，可以重新起动
E378		检测夹杆堆积器张开	复位后，可以重新起动
E379		胶辊堆积器上升传感器不能检测	复位后，可以重新起动
E380		袋盖传感器不受光	复位后，可以重新起动
E381		不能检测袋盖后端（强制停止） 缝制结束后显示错误	复位后，可以重新起动
E382		检测袋盖脏污错误	复位后，可以重新起动
E383		不能检测袋盖前端	复位后，可以重新起动

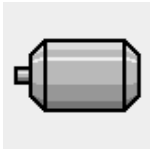
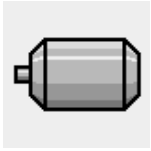
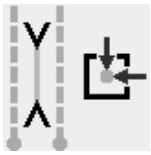
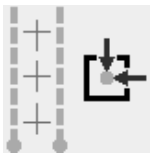
错误代码		错误内容	复位方法
E386		检测角刀固定侧下方错误	复位后，可以重新起动
E387		检测角刀固定侧上方错误	复位后，可以重新起动
E388		检测角刀移动侧下方错误	复位后，可以重新起动
E389		检测角刀移动侧上方错误	复位后，可以重新起动
E390		布料传感器错误 堆积器动作结束后，布料还留着	通过传感器输入自动复位
E391		检测 ST 布料压角上升错误	复位后，可以重新起动
E392		检测 ST 送布原点错误	复位后，可以重新起动
E393		检测滚边器下方错误	复位后，可以重新起动
E394		检测滚边器上方错误	复位后，可以重新起动
E398		检测角刀拉出错误	复位后，可以重新起动
E399		检测滚边器打开错误	复位后，可以重新起动

错误代码		错误内容	复位方法
E401		**不能复制** 想要向已经登记的图案 No. 改写复制时	按取消按钮可以复位
E402		**不能删除** 想要删除循环缝使用的图案时	按取消按钮可以复位
E403		不能新编制 在新编制图案 NO 选择已经登记的图案时	按取消按钮可以复位
E404		**没有指定号码的数据** 媒体和服务器里没有指定 No. 的数据	按取消按钮可以复位
E435	- - -	**输入范围以外错误** 用十数字键设定的数值超过了设定范围时	复位后，可以重新起动
E484		**不能缝制钉拉链数据**	复位后，可以重新起动
E485		**不能缝制钉拉链以外的数据**	复位后，可以重新起动
E486		**不能缝制钉袋盖数据**	复位后，可以重新起动
E487		**长压脚和无端拉锁同时被选择**	复位后，可以重新起动
E488	- - -	**标尺大小超过了输入范围**	复位后，可以重新起动
E489		**袋盖优先设定交替缝制模式时，设定了钉左右袋盖以外的组合数据时**	复位后，可以重新起动

错误代码		错误内容	复位方法
E490		**不能送到角刀位置** 长规格把袋盖放到跟前时	复位后，可以重新起动
E491		**角刀长度过小** 角刀的间隔小，不能放入切刀时	复位后，可以重新起动
E492		**L 尺寸过小** 输入的 L 尺寸长度过小，不能缝制时	复位后，可以重新起动
E493		**L 尺寸长度过大** 输入的 L 尺寸长度过大，不能缝制时	复位后，可以重新起动
E494		**中心刀长度错误** 中心刀的长度比切刀尺寸 6.7mm 小时	复位后，可以重新起动
E495		**开始缝制结束缝制超过长度** 缝制长度比开始缝制和结束缝制的各缩缝（倒缝）长度的合计值小时	复位后，可以重新起动
E496		**结束缝制缩缝超过长度** 缩缝间距 × 针数超过了 15.0mm 时	复位后，可以重新起动
E497		**结束缝制倒缝超过长度** 倒缝间距 × 针数超过了 6.0mm 时	复位后，可以重新起动
E498		**开始缝制缩缝超过长度** 缩缝间距 × 针数超过了 15.0mm 时	复位后，可以重新起动
E499		**开始缝制倒缝超过长度** 倒缝间距 × 针数超过了 6.0mm 时	复位后，可以重新起动
E702		**检测 CPU 异常** CPU 上发生程序异常时	电源 OFF

错误代码		错误内容	复位方法
E703		**操作盘连接到预定外的缝纫机（机种错误）** 初期通讯，操作盘和缝纫机的机种不同时	复位后，可以重新起动
E704		**系统的版本不同** 初期通讯，系统软件的版本不对时	电源 OFF
E730		**主轴妈的编码器不良或欠相** 缝纫机马达的编码器发生异常时	电源 OFF
E731		**主轴马达传感器不良或位置传感器不良** 缝纫机马达的传感器或位置传感器不良时	电源 OFF
E733		**主轴马达倒转** 缝纫机马达倒转时	电源 OFF
E802		**检测电源瞬间停电** 检测到电源瞬间停电时	电源 OFF
E811		**电源电压过高错误** 输入电源超过规定值时	电源 OFF
E813		**电源电压过低错误** 输入电源在规定值以下时	电源 OFF
E901		**主轴马达 IPM 异常** 伺服控制电路板的 IPM 异常时	电源 OFF
E903		**脉冲马达电源（50V）异常** 伺服控制电路板的脉冲马达电源变动超过 ±15%时	电源 OFF
E904		**电磁电源（33V）异常** 伺服控制电路板的电磁电源变动超过 ±15%时	电源 OFF

错误代码		错误内容	复位方法
E905		**伺服控制电路板用散热温度异常** 请经过一些时间之后重新打开电源	电源 OFF
E915		**操作盘⇔主 CPU 之间不能通讯** 数据通讯时发生异常后	电源 OFF
E916		**主 CPU ⇔主轴 CPU 之间不能通讯** 数据通讯时发生异常后	电源 OFF
E917		**操作盘⇔电脑之间不能通讯** 数据通讯时发生异常后	复位后，可以重新起动
E918		**主电路板散热温度异常** 请经过一些时间之后重新打开电源	电源 OFF
E943		**主 CPU 的 EEP-ROM 不良** 不能向 EEP-ROM 写入数据时	电源 OFF
E983		**检测中心切刀马达锁定**	电源 OFF
E984		**中心刀马达异常**	电源 OFF
E985		**大压脚马达异常错误**	复位后，可以重新起动
E986		**大压脚脉冲马达原点检索错误**	复位后，可以重新起动
E987		**倒缝马达原点检索错误**	复位后，可以重新起动

错误代码		错误内容	复位方法
E988		口袋盖检测马达原点检索异常出错	复位后，可以重新起动
E992		角刀马达原点检索异常出错	复位后，可以重新起动
E998		角刀脉冲马达原点检索错误	复位后，可以重新起动
E999		标记光马达原点检索错误	复位后，可以重新起动

10. 输入号码表

名称	连接连接器 No
检测空气压力	MAIN CN-30
标记广微调整侧原点传感器	MAIN CN-36-6
角刀马达原点传感器	MAIN CN-37-7
倒缝马达原点传感器	MAIN CN-38-6
断线检测（左）	INTA CN62A-2
断线检测（右）	INTA CN63A-2
布料传感器	INTA CN65A-3
检测大压脚异常	INTA CN66A-3
检测滚边器开放	INTA CN68A-1
检测滚边器上方	INTA CN71A-3
标记光原点传感器	INTA CN75A-2
检测大压脚原点	INTA CN77A-2
检测中心刀上升	INTA CN79A-1
袋盖传感器（左）	INTB CN60B-2
袋盖传感器（右）	INTB CN61B-2
检测脚刀拉出 SW	INTB CN62B-2
检测底线残量（左）	INTB CN64B-2
检测底线残量（右）	INTB CN64B-5
开始 SW	INTB CN65B-3
暂停 SW	INTB CN69B-1
踏板量传感器	INTB CN76B-2
检测角刀固定侧下方	INTB CN79B-1
检测角刀固定侧上方	INTB CN80B-1
检测角刀移动侧下方	INTB CN81B-1
检测角刀移动侧上方	INTB CN82B-1
检测辊上升	INTB CN83A-19
检测堆积器开放	INTB CN83B-13
堆积器原点	INTB CN83B-15

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25 · 01 Printed in Japan