ENGLISH

**DDL-8000CS
Long pitch kit
INSTRUCTION MANUAL**

CONTENTS

1. General

The long pitch kit is an optional part kit that changes the maximum stitch length to 7 mm (standard: 5 mm).

2. List of long pitch kit parts

Part number of the long pitch kit : 40218198 (with four teeth)

· List of parts supplied with the machine

Description	Parts No.	Qty
Feed dog	40133950	1
Throat plate	B1109552000	1

Part number of the long pitch kit：40298199（with three teeth）

· List of parts supplied with the machine

Description	Parts No.	Qty
Feed dog	23614506	1
Throat plate	11028008	1

Part number of the long pitch kit：40298200（with four teeth）

· List of parts supplied with the machine

Description	Parts No.	Qty
Feed dog	40216364	1
Throat plate	23645807	1

Part number of the long pitch kit：40298201（with three teeth）
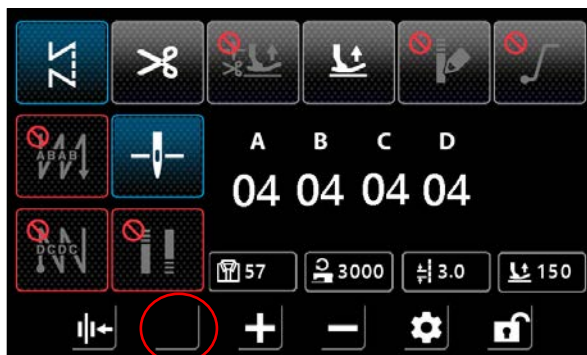
· List of parts supplied with the machine

Description	Parts No.	Qty
Feed dog	40218606	1
Throat plate	11062007	1

> **Caution** **When attaching the device to the sewing machine, be sure to turn off the power supply and ensure that the main motor has completely stopped rotating.**
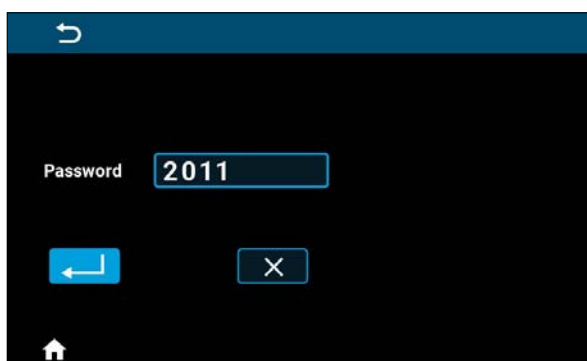
3. How to operate the panel

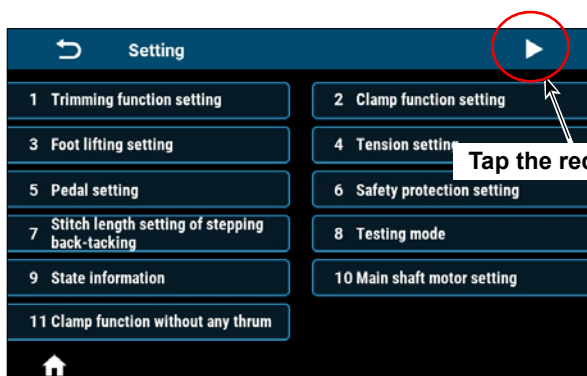3.1 The service level parameter setting screen will be displayed.

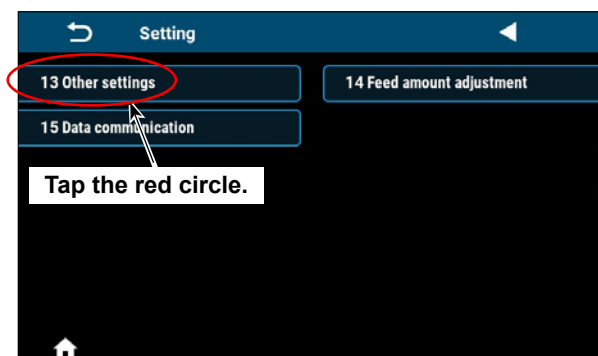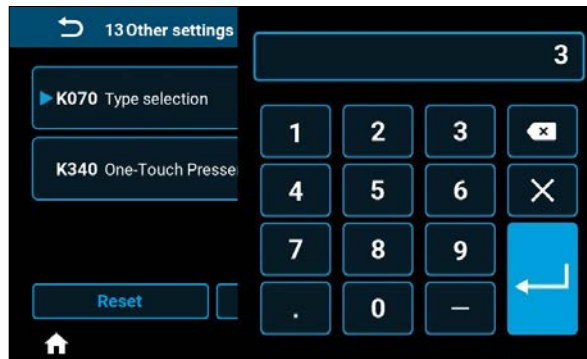**Tap the red circle twice.**

3.2 Enter the password "2011".

Password 2011

3.3 The screen will change.

Setting

1 Trimming function setting	2 Clamp function setting
3 Foot lifting setting	4 Tension setting
5 Pedal setting	6 Safety protection setting
7 Stitch length setting of stepping back-tacking	8 Testing mode
9 State information	10 Main shaft motor setting
11 Clamp function without any thrum	

Tap the red circle.

3.4 Select "Other settings".

Setting

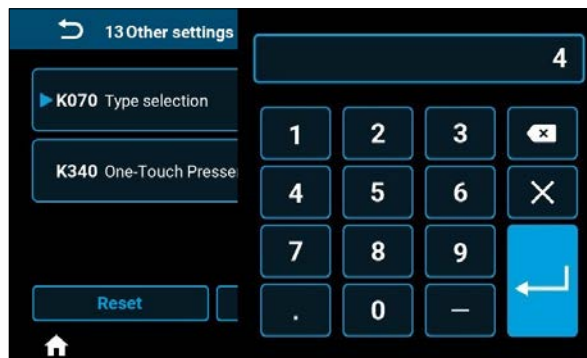| 13 Other settings | 14 Feed amount adjustment |
| 15 Data communication | |

Tap the red circle.

3.5 For model DDL8000CSM, select 3 as the Type selection.
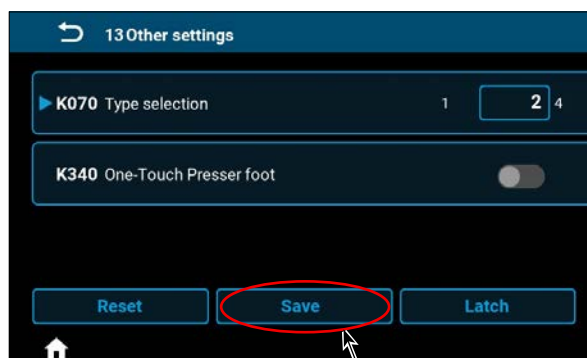

For Models DDL8000CSC and DDL8000CSH, select 4 as the Type selection.

3.6 Click the "Save" button to complete the type selection.
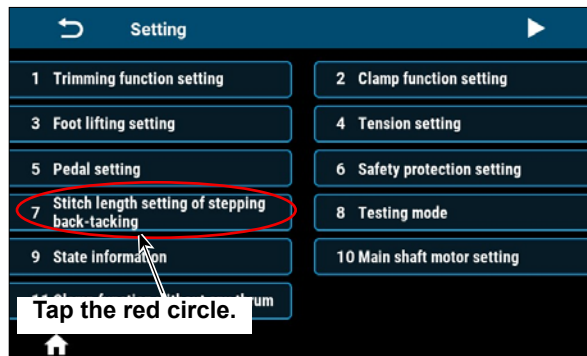
> **Caution** **Performing the machine head model settings will initialize the parameters.**

Tap the red circle.

3.7 Next, adjust the pitch data.

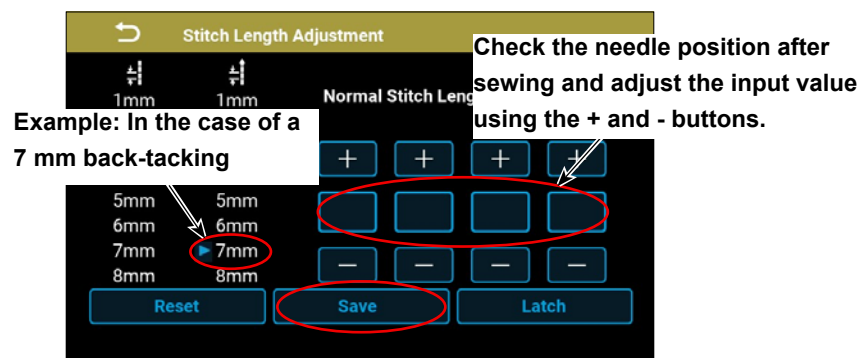Go to the service level parameter setting screen and press the "Stitch length setting of stepping back-tacking" button.

↺ **Setting**	▶
1 Trimming function setting	2 Clamp function setting
3 Foot lifting setting	4 Tension setting
5 Pedal setting	6 Safety protection setting
7 Stitch length setting of stepping back-tacking	8 Testing mode
9 State information	10 Main shaft motor setting

Tap the red circle.

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3.8 Tap to select the pitch data you want to set.

Measure the actual needle entry position and adjust the input data.

After changing the data, click the "Save" button to set the value.

↺ **Stitch Length Adjustment**

1mm   1mm   Normal Stitch Leng

Check the needle position after sewing and adjust the input value using the + and - buttons.

Example: In the case of a 7 mm back-tacking

5mm	5mm
6mm	6mm
7mm	▶7mm
8mm	8mm

+ + + +

− − − −

Reset   Save   Latch

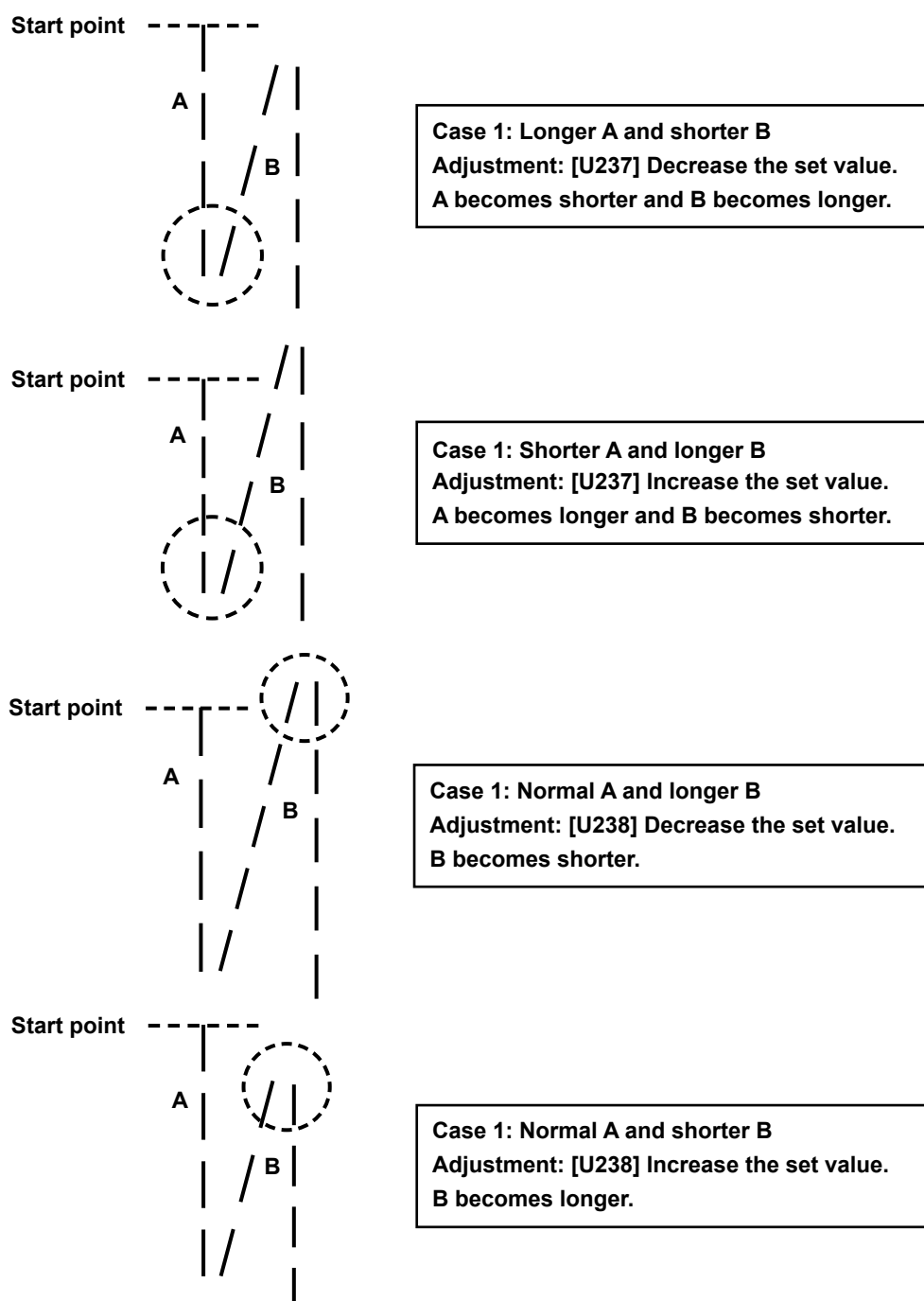# 4. Adjusting the forward and reverse feed stitch

If you want to perform automatic reverse feed stitching with a feed pitch length longer than "5 mm" and adjust the forward and reverse feed stitch due to differences in fabric types, etc., make the following adjustments separately.

Memory switch

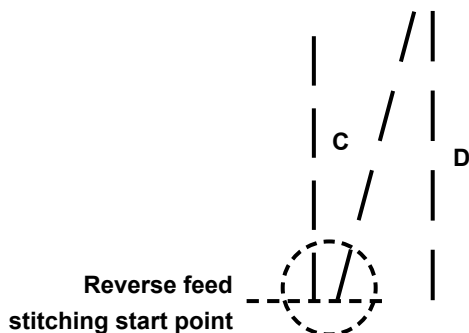| No.	Item	Target feed pitch length
U237	Reverse feed stitching timing compensation 11 at the start	
U238	Reverse feed stitching timing compensation 12 at the start	
U239	Reverse feed stitching timing compensation 13 at the end	5.1mm to 7mm
U240	Reverse feed stitching timing compensation 14 at the end	
U241	Multi-layer stitching timing compensation 15	
U242	Multi-layer stitching timing compensation 16	

4-1. Aligning the stitches for the reverse feed stitching at the sewing start (Memory switch No. U237, U238)

Recommendation: Select the stitching alignment for section A before selecting section B.

Start point

A
B

Case 1: Longer A and shorter B
Adjustment: [U237] Decrease the set value.
A becomes shorter and B becomes longer.

Start point

A
B

Case 1: Shorter A and longer B
Adjustment: [U237] Increase the set value.
A becomes longer and B becomes shorter.

Start point

A
B

Case 1: Normal A and longer B
Adjustment: [U238] Decrease the set value.
B becomes shorter.

Start point

A
B

Case 1: Normal A and shorter B
Adjustment: [U238] Increase the set value.
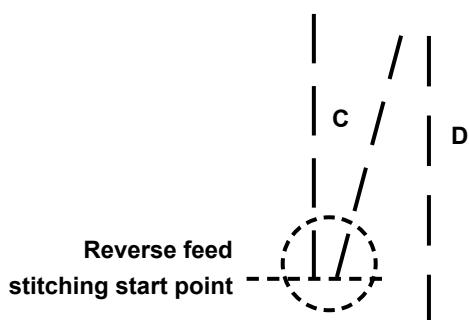**B becomes longer.**

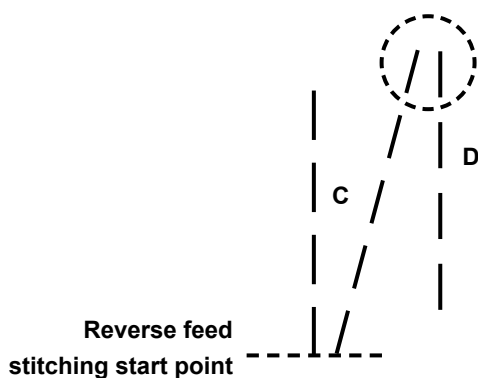## 4-2. Aligning the stitches for the reverse feed stitching at the sewing end (Memory switch No. U239, U240)

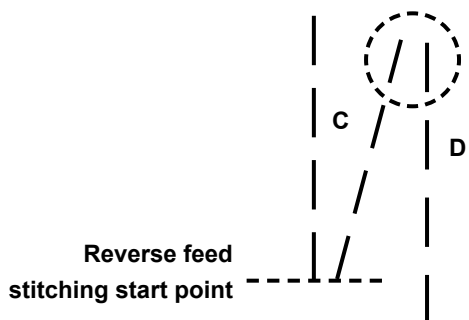Recommendation: Select the stitching alignment for section C before selecting section D.

Case 1: Longer C
Adjustment: [U239] Decrease the set value.
C becomes shorter.

Case 1: Shorter C
Adjustment: [U239] Increase the set value.
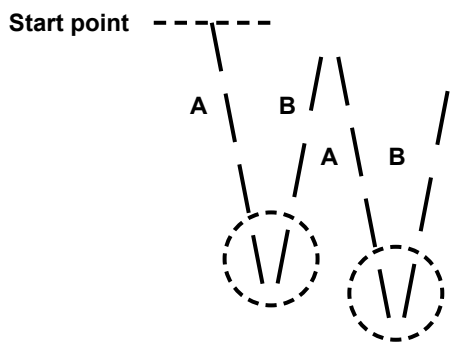**C becomes longer.**

Case 1: Longer C and shorter D
Adjustment: [U240] Decrease the set value.
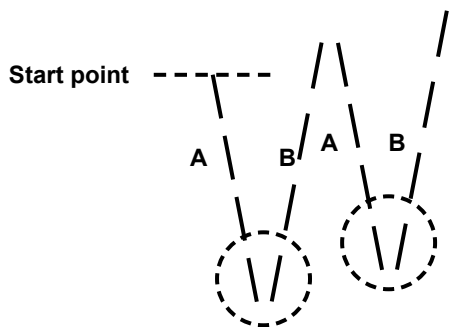**C becomes shorter and D becomes longer.**

Case 1: Shorter A and longer B
Adjustment: [U240] Increase the set value.
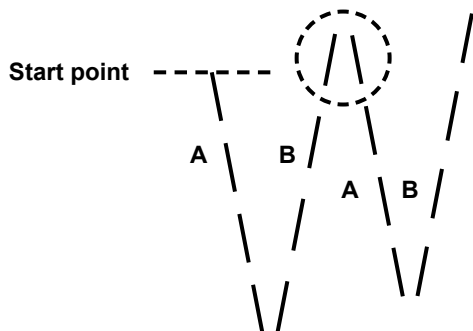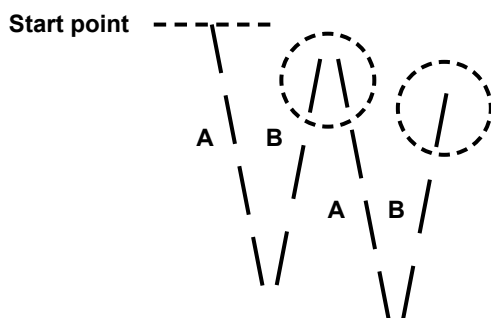**C becomes longer and D becomes shorter.**

Start point

Case 1: Longer A and shorter B
Adjustment: [U241] Decrease the set value.
A becomes shorter and B becomes longer.

Start point

Case 1: Shorter A and longer B
Adjustment: [U241] Increase the set value.
A becomes longer and B becomes shorter.

Start point

Case 1: Normal A and longer B
Adjustment: [U242] Decrease the set value.
B becomes shorter.

Start point

Case 1: Normal A and shorter B
Adjustment: [U242] Increase the set value.
B becomes longer.