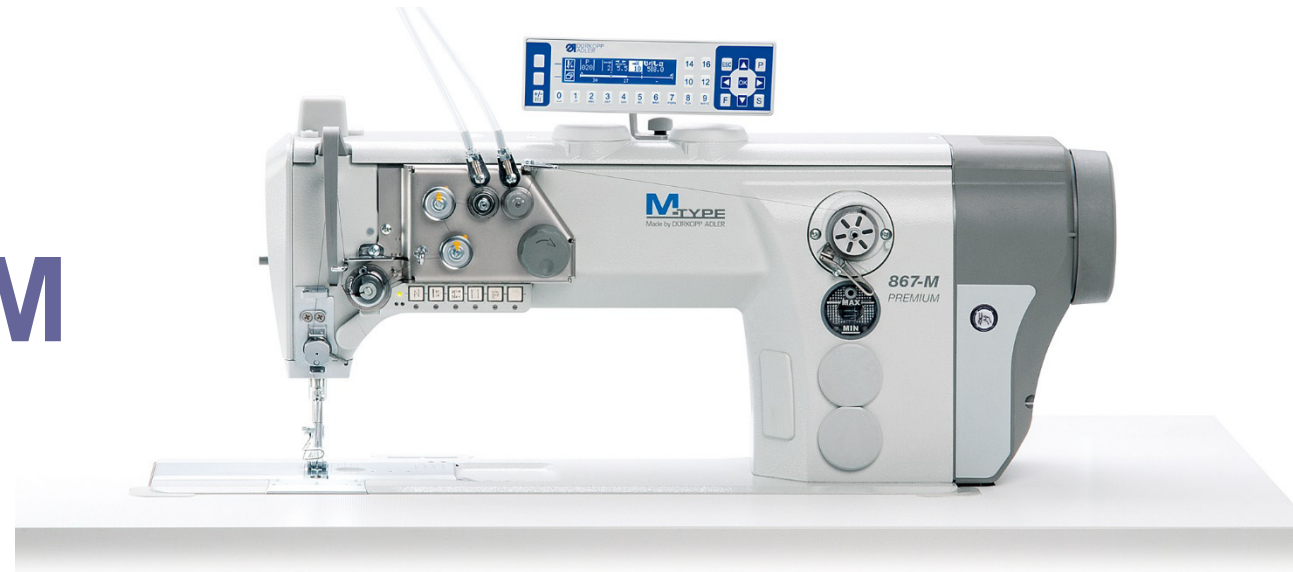


M-TYPE PREMIUM



USER TRAINING

Agenda Operator Training - 2 days (DAY 1)

09:00 - 09:15	Introduction, Overview of training program
09:15 - 10:00	Presentation of advantages and differences vs traditional machine (CLASSIC) New features and functions Advantages, Opportunities for customer
10:00 - 10:30	Machine Components <ul style="list-style-type: none">• Explication• Differences vs CLASSIC machine
10:30 - 10:45	Break
10:45 - 12:15	Push Buttons <ul style="list-style-type: none">• Function Explication• Favourite Button• Control Panel OP3000• Navigation• Description of panel buttons• Explication of displayed parameters (pictograms), modification of base parameters• Exercises
12:15 - 13:15	Lunch

Agenda Operator Training - 2 days (DAY 1)

13:15 - 13:45

Operating modes, explication

Manual Mode: P000

- Navigation in menus
- Description and modification of base parameters
- Explication of other parameters
- Explication and settings of start and end bartack
- Explication of the function Fabric Thickness, specific settings
- Exercises:
Parameter settings, changing between the 1st and 2nd parameter values of base parameters

14:00 - 14:45

Softkey Menu

- Navigation in the softkey menu / quick access menu
- Explication of functions
- Programming the favourite button (assigning a function)

14:45 - 15:00

Break

Agenda Operator Training - 2 days (DAY 1)

15:00 - 16:15

Automatic Mode

- Explication of mode and seam program
- Advantages / Program selection
- Explication of icons displayed
- Exercises:
Sewing in automatic mode, select a predefined program, identify and modify parameter settings

16:15 - 16:45

Conclusion, Questions

Agenda Operator Training - 2 days (DAY 2)

09:00 - 09:30

Recapitulation of the 1st day

Questions

09:30 - 10:30

Edit Mode

- Activate edit mode
- Settings of base parameters
- Explication of global program parameters
- Explication of specific parameters in the seam section
- Explication of additional parameters in automatic mode (Segment End Modes, stitch counting)

10:30 - 10:45

Break

10:45 - 12:15

Parameter settings in edit mode

- Base parameter settings
- Modification of global program parameters
- Settings of specific parameters in a seam section

Exercises: Modification of parameter settings, sewing in automatic mode, get used to navigation in the different menu levels

12:15 - 13:15

Lunch

Agenda Operator Training - 2 days (DAY 2)

13:15 - 14:45

Programming Mode, creation of programmes

- Create a new program
- Modify all parameter settings, Navigation in the menus
- Exercises: Creation of simple programs

14:45 - 15:00

Break

14:30 - 15:15

Programming Mode (cont.)

Exercises:

Creation of complex programs comprising multiple seam sections,
forward/backward sewing in program, parameter settings in program

15:15 - 16:15

Copy and delete programs

Creating programs using teach-in

Exercises: Creation of programs using the teach-in function, parameter settings

16:15 - 16:45

Conclusion, Questions

Why M-TYPE PREMIUM?

- Productivity
 - Higher efficiency due to programming functionality / increased no. of operations per machine.
- Better Quality Results
 - Automatic and more precise adjustment / finer calibration tuning
 - Facility to reproduce parameter settings (more precise results)
 - Impressive new features and settings not feasible with traditional machine
- Saving Time
 - Rapid variation between programs
 - Reduced machine set-up times
- Flexibility
- Positive impact on environment
 - No compressed air needed (except some optional equipment)
- Universal and identical installation of software/programs
 - Quick and easy program transfer with USB
 - M2M (data transfer through network, LAN or WLAN)

Differences PREMIUM vs. CLASSIC



NEW

- Digital function control with panel OP3000
- Reproducible and reusable parameter adjustment
- Creation of automated programs
- Automation of seam sections
- End bar tack settings can vary from adjustments of start bar tack
- Sewing foot lift height adjustment (max. 20 mm)
- Automatic fabric thickness detection
- Jog Dial (electronic handwheel)

Video

Footstroke



Advantages/Opportunities

Problem:

- Small volume lot sizes
 - Numerous models
 - Dynamic model line
- } • long setup times

Solution/Opportunity:

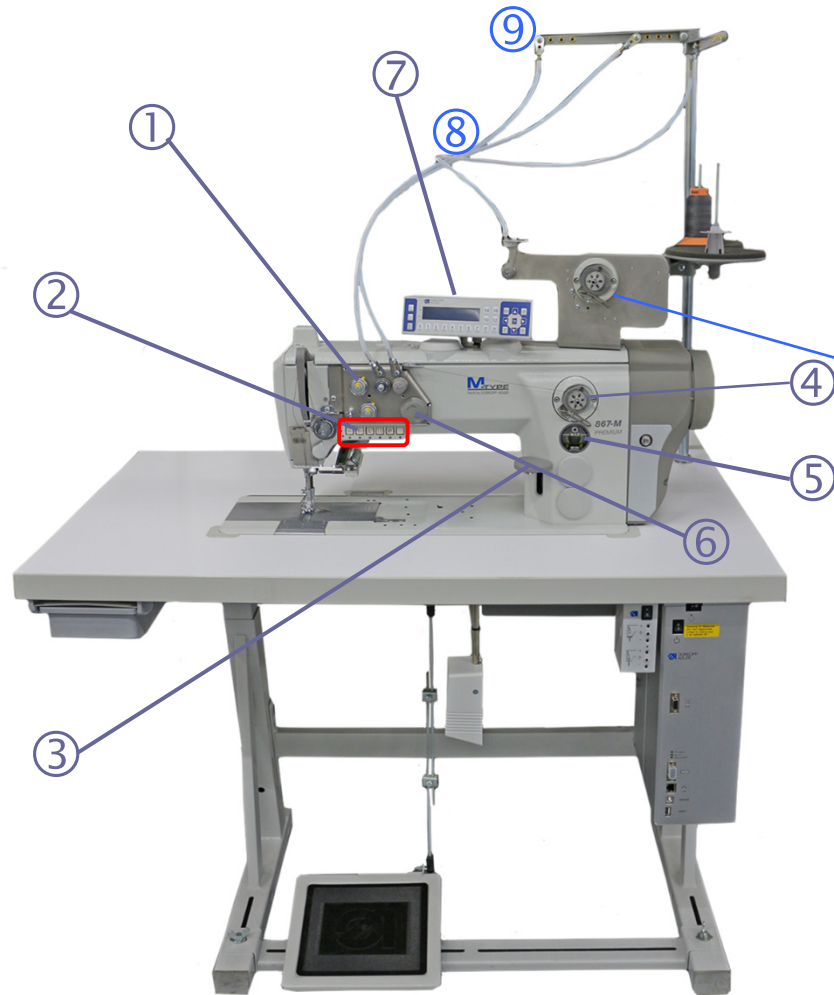
- Programmable sewing machine
- Execution of different seam operations using the same machine



M-TYPE PREMIUM

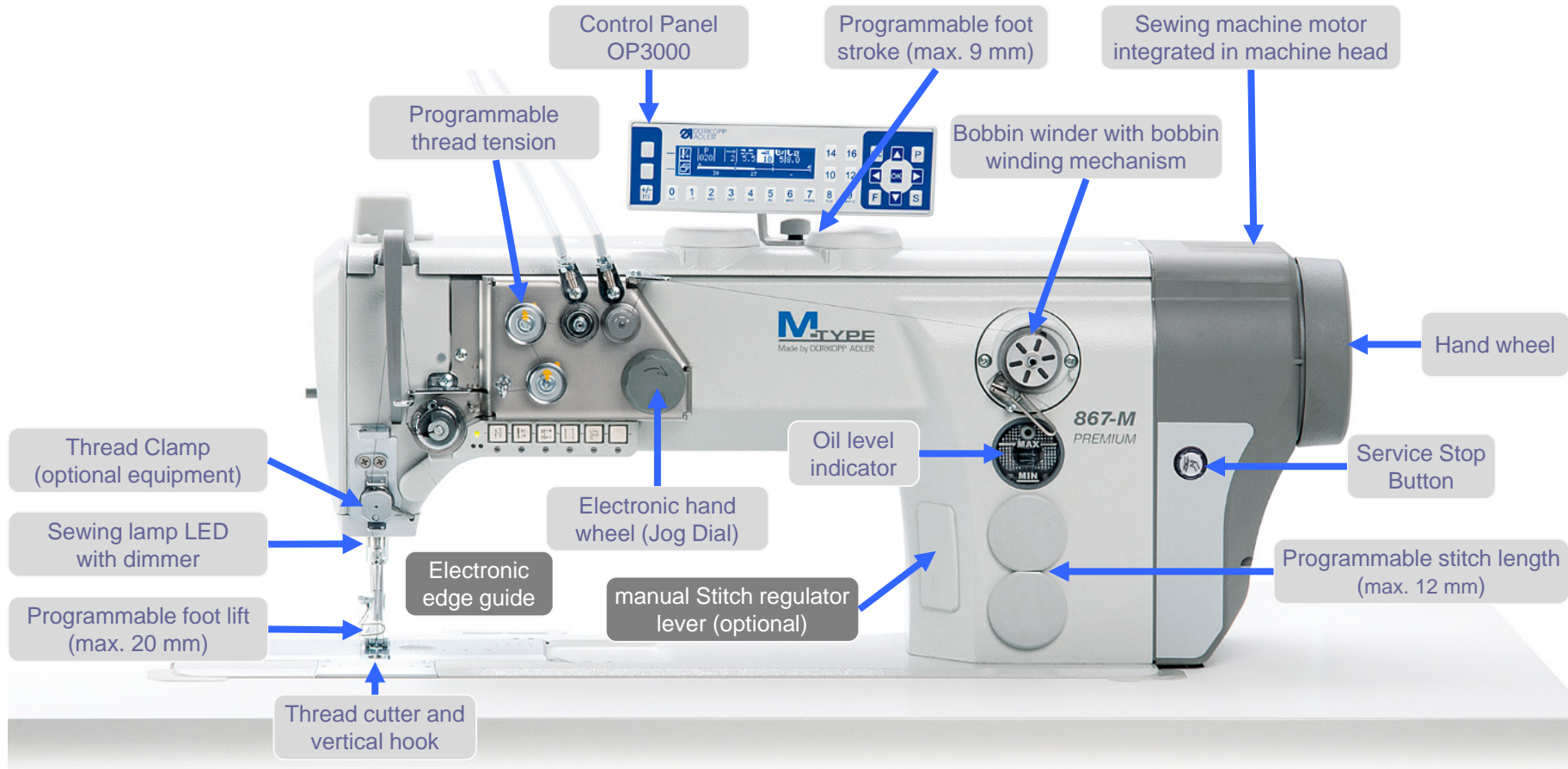


Machine Components



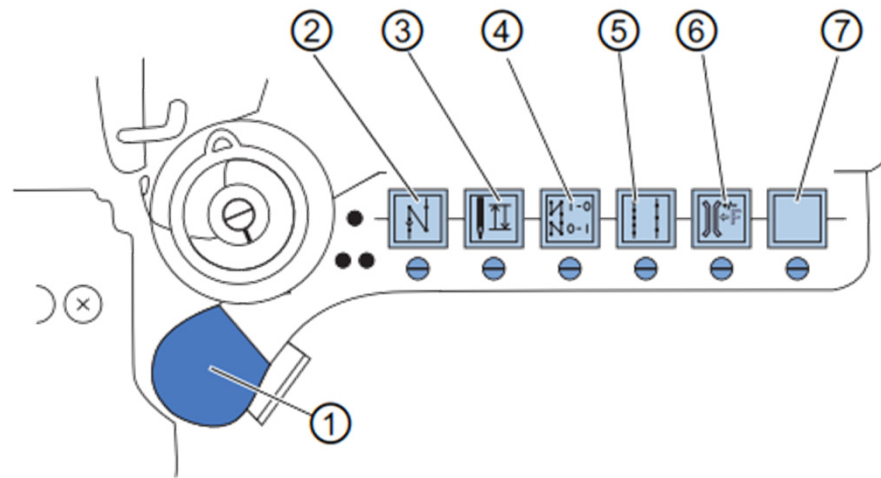
- (1) Programmable thread tension
- (2) Push buttons
- (3) Stitch adjustment lever
- (4) Bobbin winder /
(4a) motorized winder
- (5) Oil level indicator
- (6) Jog Dial (electronic hand wheel)
- (7) Control panel OP3000
- (8) Hose guide
- (9) Thread guide

Machine Components



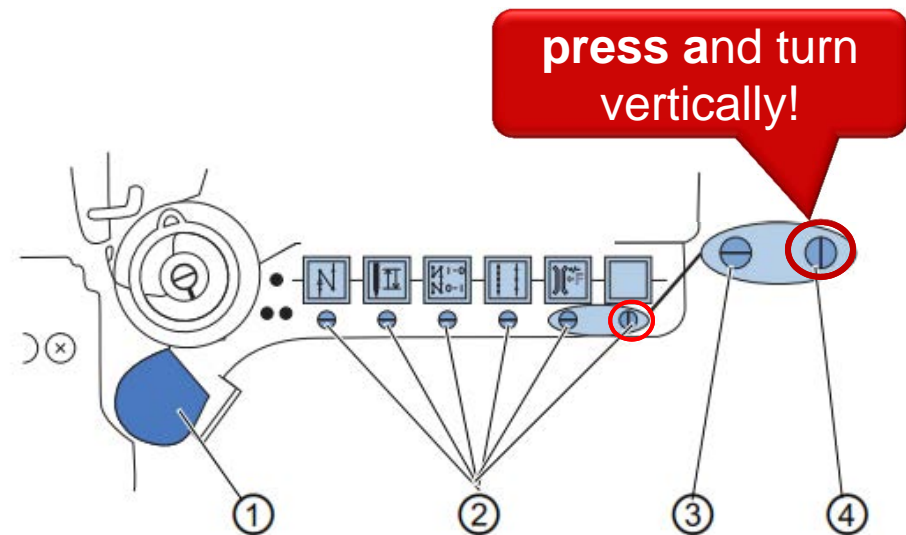
Push Buttons (soft keys)

Function Buttons



- (1) - Favorite button
- (2) - Sewing backwards
- (3) - Needle position
- (4) - Start bartack/end bartack
- (5) - Stitch length preselection
- (6) - Auxiliary thread tension
- (7) - fully customizable button

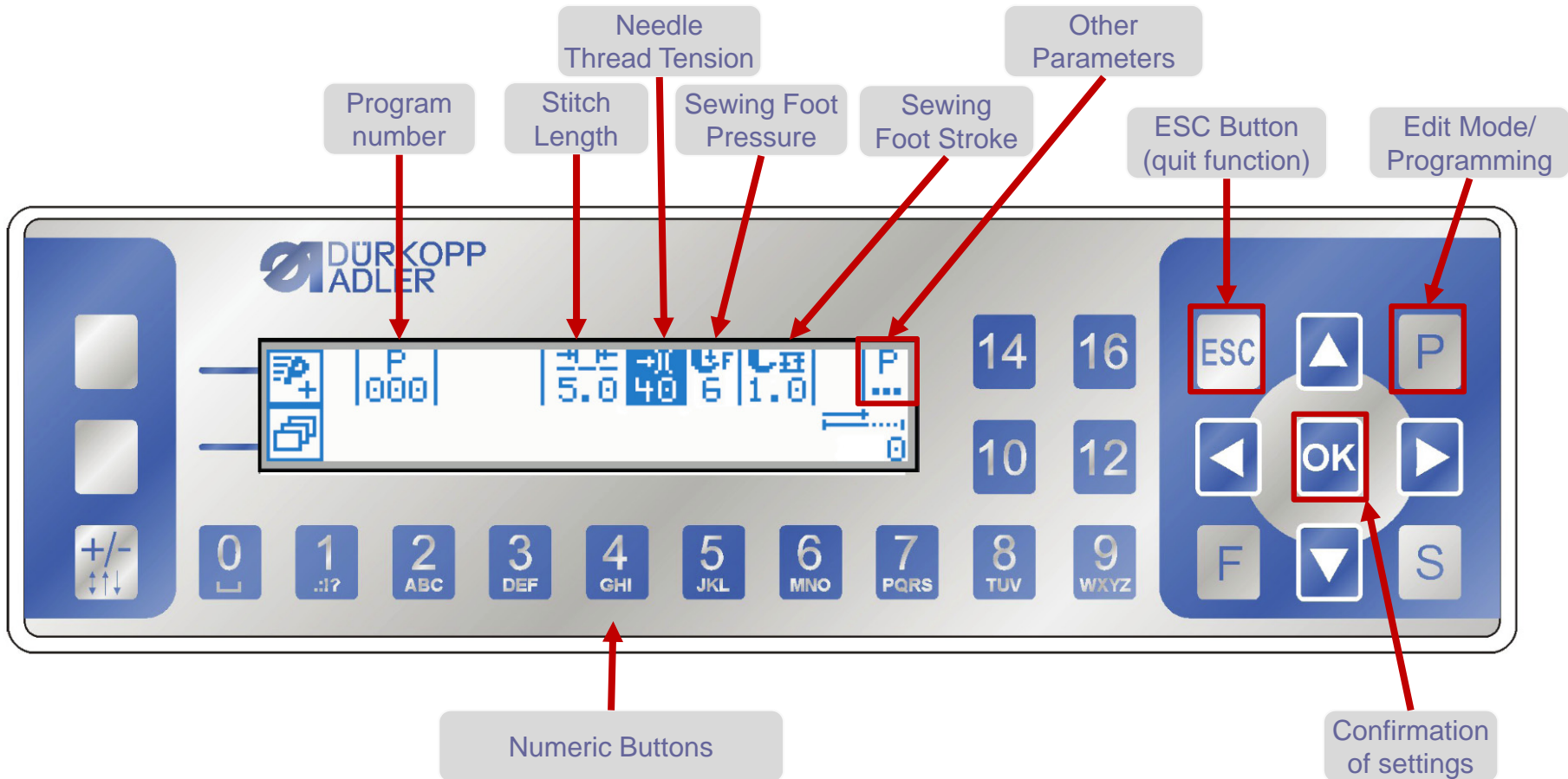
Favorite Button



- (1) - Favorite button
- (2) - Screws
- (3) - Initial position
- (4) - Screw vertical

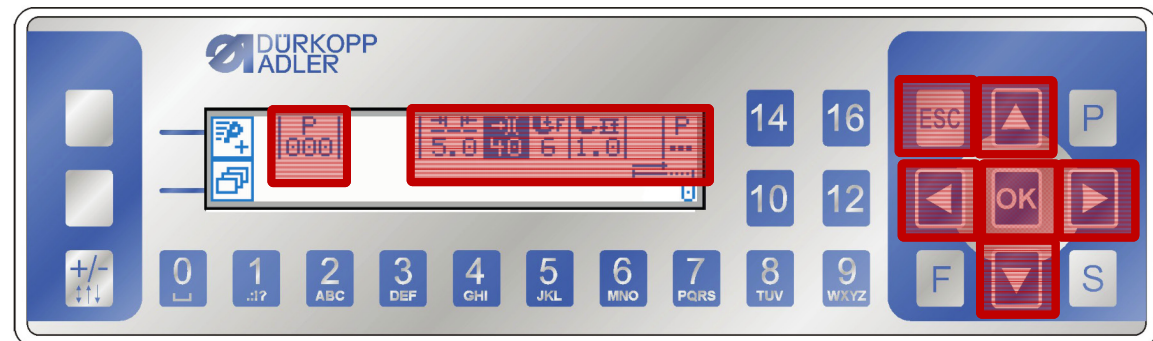
Function Buttons (Notes)

Control Panel OP3000



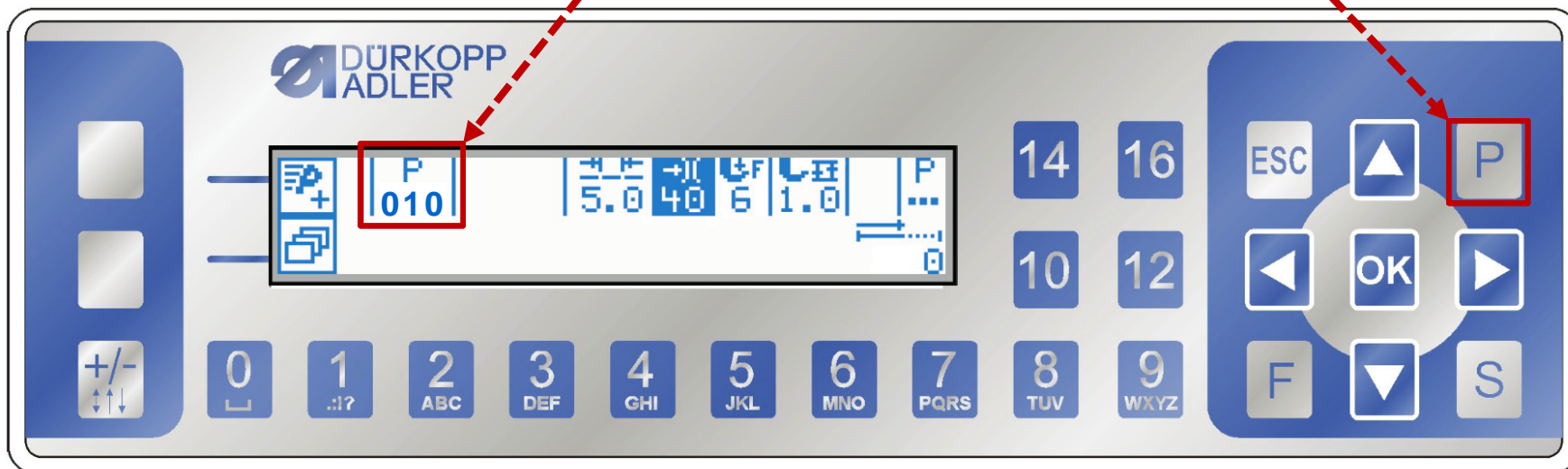
OP3000: Navigation

- Program Selection
- Parameter Settings
- Navigation between parameters: ◀ ▶
- Return to superior menu level: ◀
- Increase/Decrease value: ▲ ▼
- Confirmation: **OK**
- Quit the menu with **ESC** button



Operating Modes

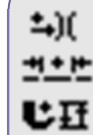
- Manual Mode: P000
- Automatic Mode: P001 - 999
- **Programming Mode / Edit Mode**
 - Activated with button P

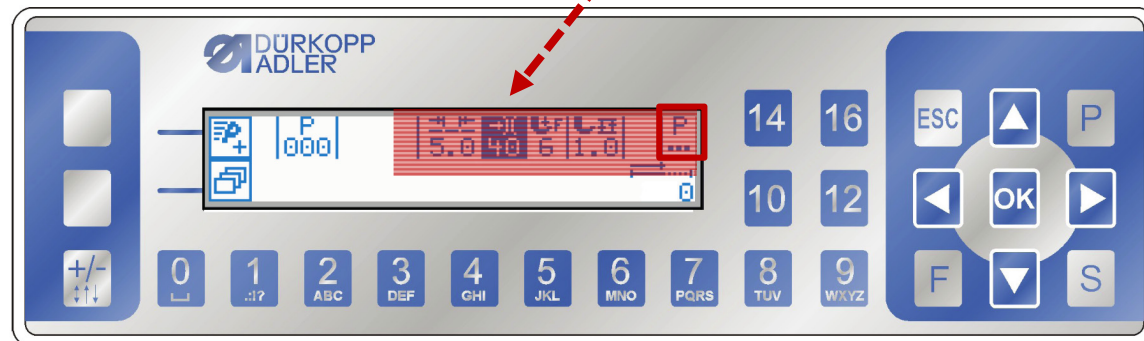


Manual Mode: P000

- Parameter settings on the control panel OP3000

-  Stitch Length (mm)
-  Needle Thread Tension (1-99%)
-  Sewing Foot Pressure (1-20)
-  Sewing Foot Stroke (max. 9 mm)
-  Other parameters:
 - Speed
 - Start Bar Tack / End Bar Tack
 - Thread Trim (Thread Cutter)
 - Sewing Foot lift
 - Bobbin monitor
 - Edge Guide
 - Fabric Thickness

 the auxiliary parameters are indicated with the + sign



Exercise: Sewing in Manual Mode

Pre-settings in Manual Mode

- modify the following parameters:
 - stitch length 3.0 mm
 - needle thread tension 20%
 - sewing foot pressure 6
 - sewing foot stroke 2,5 mm
- adjust the auxiliary values
(**push buttons, knee button**):
 - auxiliary stitch length (6.0 mm)
 - auxiliary thread tension 30%
 - auxiliary foot stroke 9.0 mm

During the Sewing Process

- start sewing
 - activate/deactivate sewing backwards (1)
- activate/deactivate the auxiliary values
 - activate auxiliary stitch length
 - activate secondary foot stroke
 - activate secondary thread tension
 - deactivate the auxiliary values
- stop sewing
(interrupt the sewing process, pedal 0)
 - lift the sewing foot (pedal -1)
 - continue sewing (pedal +1)
- finish the seam (pedal -2)

Manual Mode: Other Parameters



	Max. Speed	maximum speed (stitches/min.)
	Thread Trim	Thread cutter : activate \surd /deactivate with button OK
	Thread Clamp	activate \surd /deactivate with the OK button
	PointPos.	Initial alignment stitch parameter, needle positioning (0 – 359 °)
	Pt. arrêt AV	Start bartack
	Pt. arrêt AR	End bartack
	Foot	Sewing foot lift – Foot position when sewing stops or after thread trim
	Bobbin	Bobbin monitor (different modes)
	Info	Information on certain settings to be displayed on the screen (thickness of material, speed)
	Edge Guide	Gap, value of distance between needle and the material edge (gap and auxiliary gap+)
	Speed Corr.	Correction of effects of high speed (stitch length, needle thread tension, sewing foot pressure, etc.)
	Fabric Thickness	Material thickness detection (alignment/adjustment of foot stroke, stitch length, thread tension, foot pressure and maximum rotation speed)
	LightBarrier	photoelectric light barrier

Manual Mode: Other Parameters (Notes)

Manual Mode: Other Parameters (Notes)

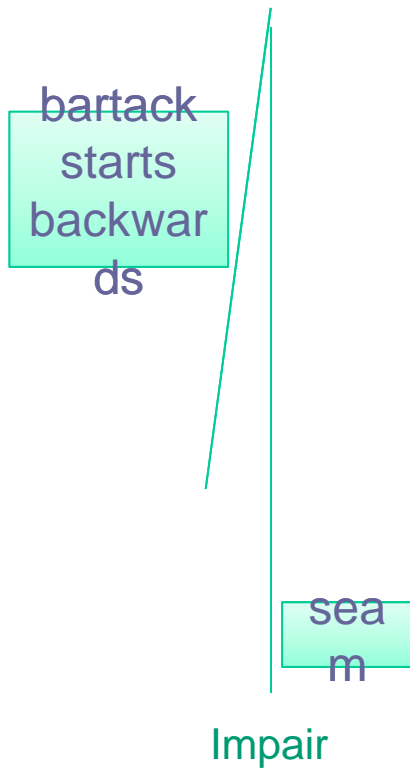
Manual Mode: Other Parameters (Notes)

Start bartack / End bartack

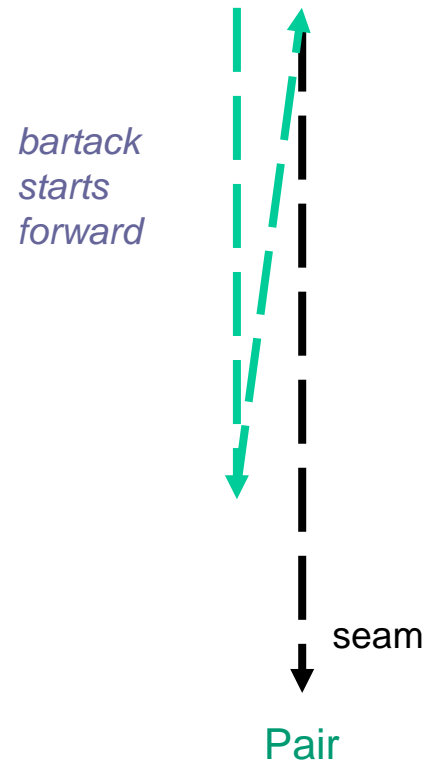
- **Stitches** ↑ – Number of backward stitches (0-50 points)
- **Stitches.** ↓ – Number of forward stitches (0-50 points)
- **Repetitions** – Number of sections in a bartack (0-10 points)
- **t Change** – Waiting time a turning point (0-1000 ms)
- **St.Len.Def.** – Default stitch length (St.Len. ↑ / St.Len. ↓)
- **Speed** – Speed at bartack (50-2000 points/min.)
- **Thr.Tens.Def.** – Default needle thread tension (On/Off: values)
- **Catch bartack** – Bartack before the bartack
- **First/Last Repetition** – Number of stitches different for the 1st section
- **Invert Dir.** – Invert direction (inverts the sewing direction of the bartack)

Start bartack - Repetitions

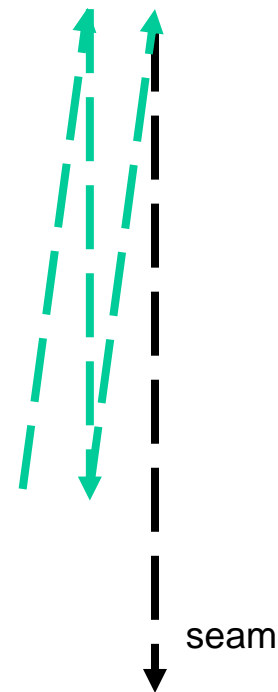
1 Repetition



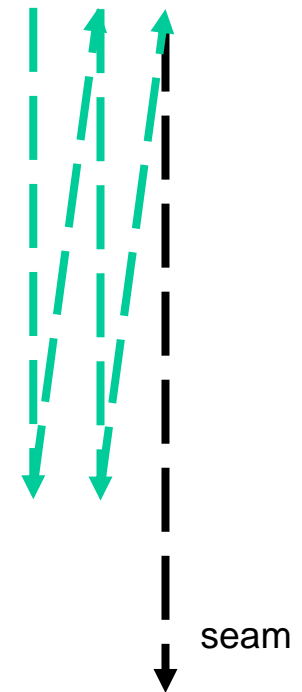
2 Repetitions



3 Repetitions



4 Repetitions



Exercise: Sewing in Manual Mode, other parameters

Pre-setting in Manual Mode

- modify the base parameters:
 - stitch length 5.0 mm
 - needle thread tension 25%
 - sewing foot pressure 5
 - sewing foot stroke 1,5 mm
- modify the other parameters **P...**
 - Thread Trim active On
 - Start bartack active (On)
 - Number of backward stitches (3 points)
 - Number of forward stitches (3 points)
 - **St.Len.Def** – Default stitch length active (On)
 - End bartack active (On)
 - Number of backward stitches (4 points)
 - Number of forward stitches (4 points)
 - **St.Len.Def** – Default stitch length inactive (Off)
 - backward stitch length (2.5 mm)
 - forward stitch lengths (2.5 mm)
 - Gap (edge guide): 10 mm

During sewing process

- start sewing
(automatic start bartack)
- activate/deactivate the auxiliary values:
 - activate 2nd stitch length
 - activate 2nd foot stroke
 - activate 2nd thread tension
 - deactivate the secondary values
- interrupt the sewing process (pedal)
 - lift your foot from pedal
 - continue sewing process / resume
- stop sewing, end of seam (pedal -2)
(automatic end bartack)

Exercise: Bartack with Pedal Stop

Adjustment of bartacks

- other parameters P...
- Start bartack active (On)
 - Number of backward stitches (3 points)
 - Number of forward stitches (3 points)
 - St.Len.Def – Default stitch length active (On)
 - reduced Speed: 200
 - Pedal Stop active (On)
- End bartack active (On)
 - Number of backward stitches (3 points)
 - Number of forward stitches (3 points)
 - St.Len.Def – Default stitch length active (Off)
 - Backward stitch length (3 mm)
 - Forward stitch length(3 mm)
 - reduced Speed: 200
 - Pedal Stop active (On)

During sewing process

- start sewing
(automatic start bartack)
- **interrupt the sewing process** (pedal)
 - lift you foot from pedal
- **continue sewing process / resume**
- **stop sewing**, end of seam (pedal -2)
(automatic end bartack)

With Pedal Stop you can stop sewing during bartack execution.

Parameter Fabric Thickness



Goal:
consistent good
sewing results



**Material
Thickness
Detection**

- Fabric Thickness On/Off
 - Stroke – Sewing foot stroke
 - Stitchlen. - Stitch length
 - Thr.Tens. – Needle thread tension
 - FootPress. – Sewing foot pressure
 - Max.Speed – Maximum speed
- Modes
 - linear
 - 2.OnOff
 - 2.On

Parameter Fabric Thickness (Notes)

Exercises: Adjustment Fabric Thickness

Mode linear

- Active (On)
- **Stroke**
 - **Mode linear**
 - Stroke 8.0
 - ThickMin 2.0 mm
 - ThickMax 5.0 mm
- **Stitchlen.**
 - **Mode linear**
 - Stichlen. (10 %)
 - ThickMin 2.0 mm
 - ThickMax 5.0 mm

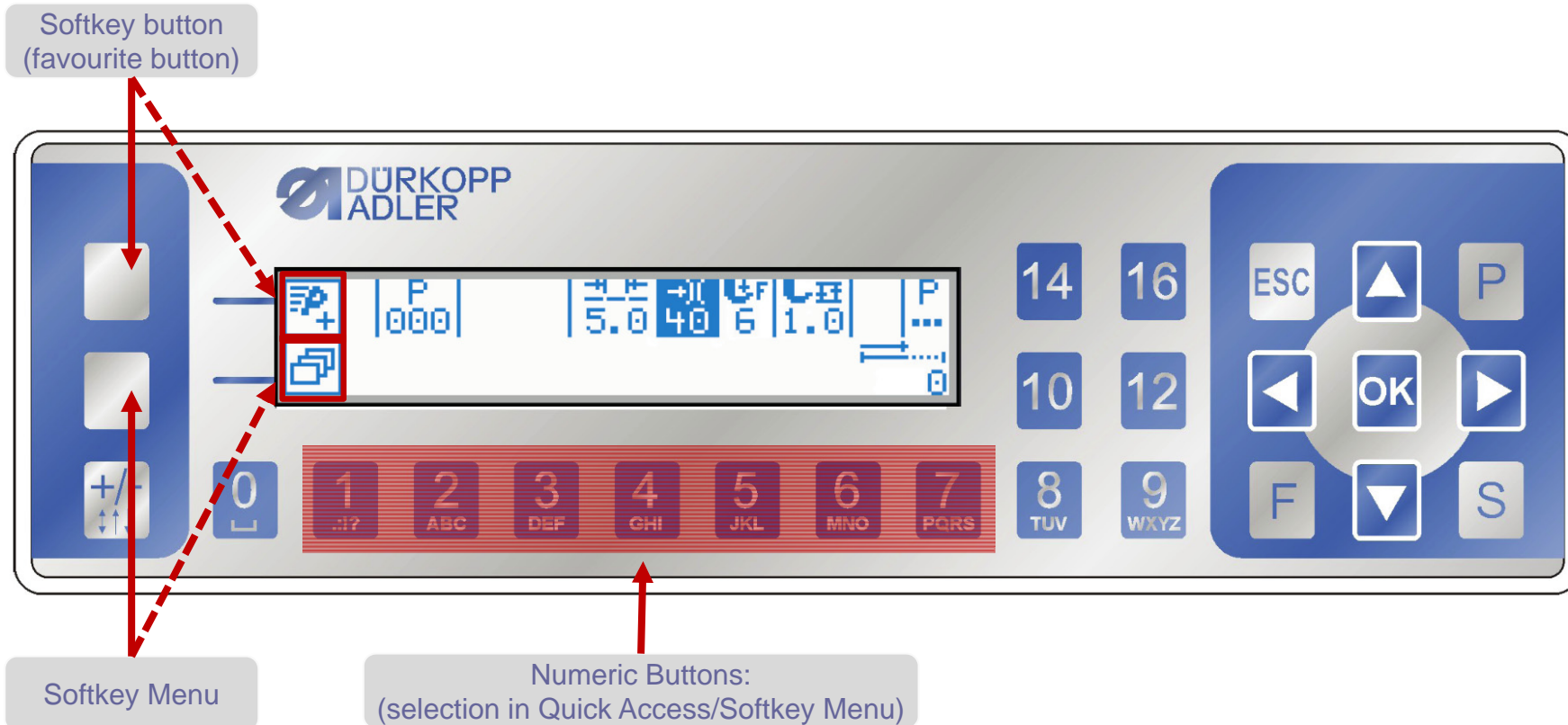
Mode 2. OnOff

- **Stitchlen.**
 - Mode 2. OnOff
 - TickMin 3.0 mm

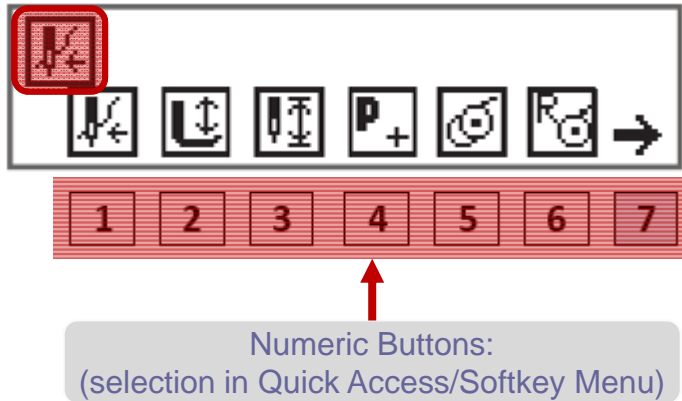
Mode 2. On


- **Stitchlen.**
 - Mode 2. On
 - ThickMin 2.0 mm

OP3000: Quick Access Functions / Softkey Menu



OP3000: Navigation Softkey Menu



- Softkey Menu / Quick Access 
 - Functions / Buttons 1-7
 - 2nd page (button 7)
 - Return to page 1
 - Quit the menu via button ESC
- Softkey button (e.g. Threading Mode)

Functions Softkey Menu

Symbol	Meaning
	Threading mode The needle bar moves to the defined position. The pedal is temporarily locked.
	Raise/lower sewing foot BEFORE the seam: Position of the sewing foot after thread cutting. IN the seam: Position of the sewing foot when sewing stops.
	Needle position up / down If sewing is stopped within the seam, the needle is positioned up or down.
	Programming Activation of programming mode.
	Thread cutter Function active or inactive.

Symbol	Signification
 BEFORE the seam	Bobbin mode
 IN the seam	Perform half stitches Half stitches are performed when the button is pressed (needle position raised or lowered).
	Resetting the bobbin stitch counter The defined maximum s.p.m. of the bobbin used is reset to the starting value.
 2nd page	Thread clamp Function active or inactive.
	2 nd edge stop distance Moves the position for the 2 nd edge stop distance.
	Edge stop reference run If the edge stop has lost its correct position due to an interruption, the reference run returns it to its starting position.

Exercise: Sewing in Manual Mode, Gap and Gap+


Pre-setting in Manual Mode

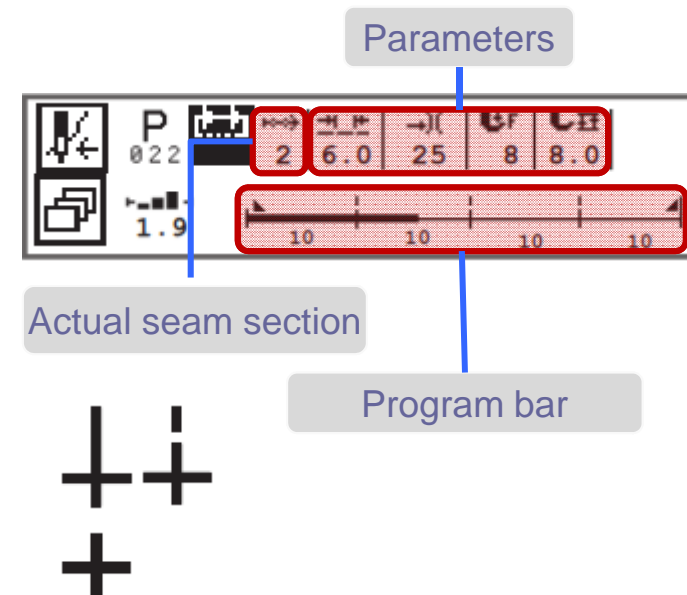
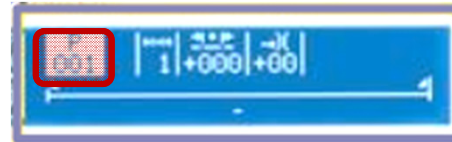
- modify the base parameters :
 - stitch length 3.8 mm
 - thread tension 25%
 - sewing foot pressure 5
 - sewing foot stroke 3 mm
- modify the other parameters **P...**
 - Thread Trim active On
 - Start bartack active (On)
 - Number of backward stitches (3 points)
 - Number of forward stitches (3 points)
 - **St.Len.Def** – Default stitch length active (On)
 - End bartack active (On)
 - Number of backward stitches (3 points)
 - Number of forward stitches(3 points)
 - **St.Len.Def** – Default stitch length active (On)
 - Gap (edge guide): 10 mm
- adjust the auxiliary values:
 - 2nd stitch length 6.0 mm
 - 2nd thread tension 30%
 - **2nd gap (edge guide distance) 20 mm**

During Sewing Process

- start sewing
(automatic start bartack)
 - activate/deactivate the auxiliary values
 - activate 2nd stitch length
 - activate 2nd foot stroke
 - activate 2nd thread tension
 - **activate 2nd gap (gap+)**
 - deactivate the secondary values
- stop sewing, end of seam (pedal -2)
(automatic end bartack)

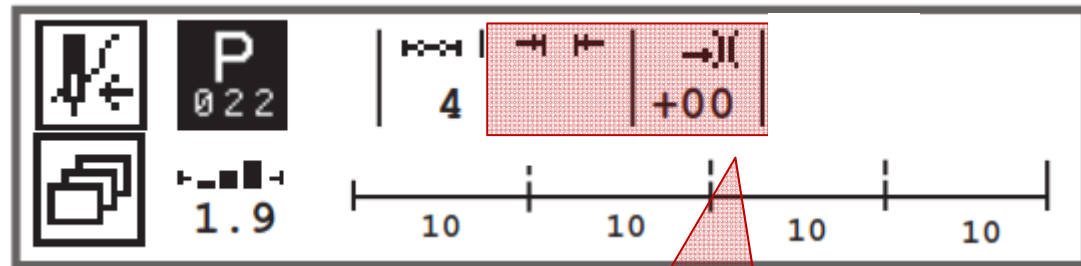
Automatic Mode: P001 - P999

- Program Selection
- During sewing process
 - indication of actual seam section
 - display of parameter values defined in the seam section
 - program progress (program bar)
 - predefined number of stitches per section
 - bartacks 
 - switch between two seam sections with a stop and with/without thread cutting
 - switch between two seam sections without stopping
- Cut off the program (pedal fully back, Pos. -2)
 - bartack and thread trim, if set in program

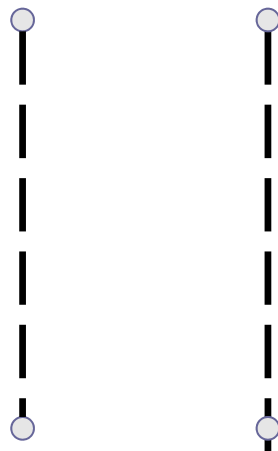


Automatic Mode: Correction Factors

- correction %age for stitch length and thread tension
 - Test results
 - due to the influence of different material



GOAL **REALITY**




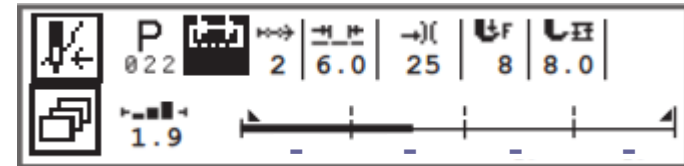
Test the correction values
and adjust alteration %age

Exercise: Identify configurations / settings


- Selection of programme P010
- Which program settings can you identify?
 - Number of seam sections ?
 - Bartacks ?
 - Thread Trim ?
 - Stop between seam sections ?
 - Predefined number of stitches ?

Automatic Mode: Sewing a program


- Program Selection
- Start sewing process
- Switch to following seam section
 - 
 - Function Button no. 6
 - **USEFUL!** Favourite button (assign feature of function buttons)
- Skip a seam section of the program
- Cut off or cancel the program in the seam and resume sewing process
 - Pedal -1 (program remains stopped at cut off point)
 - Pedal -2 (complete cancellation of program and return to starting point)




Exercise: Sewing in Automatic Mode

- A predefined **Simple Program** (1 seam section)
 - Select a program using the right/left arrow navigation buttons: 
 - P001 – SETUP 1**
 - Press the pedal forward and start sewing
 - verify the parameters during sewing process
 - stop sewing in the seam / interrupt sewing process (foot lift up, needle up)
 - resume sewing / continue seam
 - Cut off the program (pedal position -2)
 - bartack automatically executed
 - thread trim

Exercise: Sewing in Automatic Mode

- Utilise a **program** consisting of several seam sections
 - Select a program using the right/left arrow navigation buttons: 
P010 – SEAM 10 MANUEL
 - Sew the program
 - start bartack automatically executed
 - **switch to next seam section** (function button no. 6 or ▶)
 - stop sewing in the program (foot lift)
 - resume sewing process / continue
 - Terminate program (Pedal -2)
 - end bartack automatically executed
 - thread trim
 - Cancel the program

Übung: Nähen im Automatikmodus

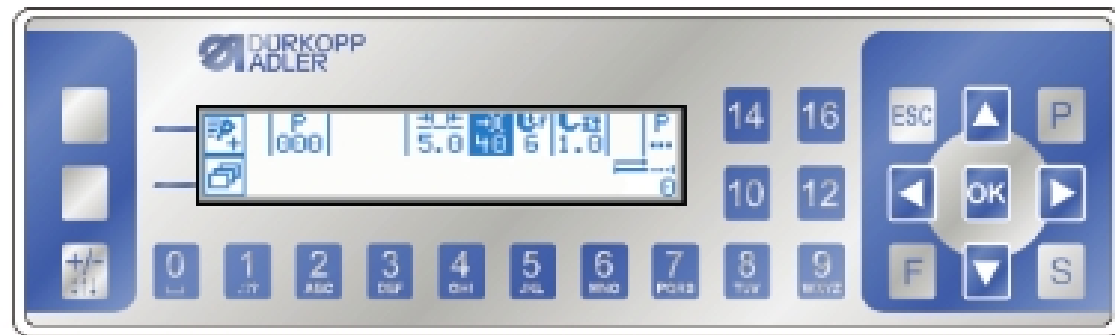
- Sewing of a program consisting of several seam sections and specific number of stitches per section
 - Select a program using the right/left arrow navigation buttons: 
P021 – SEAM AUTOMATIC
 - Sew the program
 - end bartack automatically executed
 - **Automatic stop at the end of the section** (after specific number of stitches)
 - switch to next section by sewing after stop at end of section
 - Terminate program (pedal -2)
 - end bartack automatically executed
 - thread trim

Conclusion Day 1

- Introduction to the M-TYPE PREMIUM machine
 - Advantages, new functions
 - Components of the machine
- Control Panel OP3000
 - Navigation in the menus
 - Softkey Menu
- Manual Mode: P000
 - Parameter adjustment
 - Start bartack / end bartack
 - Parameter Fabric Thickness
- Automatic Mode: P001 - P999
 - Sewing in automatic mode
 - Correction Factors



QUESTIONS?





**THANK YOU
FOR YOUR ATTENTION**


Recapitulation of First Day

- Control Panel OP3000
 - How to navigate in the menus
 - Use of Softkey Menu, favourite button
- Manual Mode: P000
 - Adjustment of base parameters
 - Adjustment of other parameters **P...**
 - Thread Tim
 - Start bartack / End Bartack
 - Edge Guide
 - Parameter Fabric Thickness
- Automatic Mode: P001 - P999
 - Selection of a program
 - Sewing in automatic mode

Edit Mode: Modify an existing program

- activate edit mode pressing button 
(the P flashes)
- **Basic parameters**
 - Direct modification of stitch lengths, thread tension, sewing foot pressure and sewing foot stroke
- **Global parameters** of the program 
 - Program Name
 - Add Values (+) – 2nd values of the parameters
 - Next Program – define subsequent program
 - Bobbin
 - Info
 - Daily Pieces – daily piece counter
 - Point.Pos.
 - Speed Corr – Adjustment factors to correct effects due to high speed
 - FabricThickness

Edit Mode: Modify an existing program (cont.)

- Modify **segment parameters**
 - Navigate on the desired seam section number and press 
- “New” Parameters not shown in manual mode
 - StitchCount – predefine the no. of stitches for the section
 - **Seg.End Modes** – Segment End Modes (any adjustment of what should happen at the end of this seam section)
 - Stop On/Off – Sewing stops at the end of the seam section when switching to the next section.
 - Thread Trim – thread cutting at the end of the section
 - Needle Up – Needle position at the end of the section
 - Foot Lifted – Foot lift at the end of the section
 - FL height – Foot lift height
 - **Backwards** – backwards sewn stitches (On/Off)

Program Parameters (Notes)






Program Parameters (Notes)

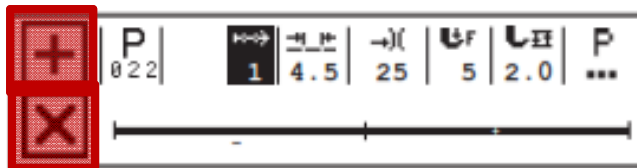
Program Parameters (Notes)





Exercise: Edit Mode – Modify program P010

1. Select the program **P010 – TEST 2** and activate the **Edit mode**
2. Select seam section 1 (first section) and press **OK**.
3. Modify the following parameter settings:
 - **Section 1:**
 - stitch length 6 mm
 - sewing foot stroke 2.5 mm
 - thread tension 30
 - stitch count : mode 1 (count stitches), number of stitches 10
 - Segment End Mode : Stop active On Thread trim inactive Off, Needle Up inactive Off, Foot lifted inactive Off
 - start tack: inactive Off
 - end tack: inactive Off
 - Foot lifted: when sewing stops on the seam: inactive Off
 - **Section 2:**
 - stitch length 3 mm
 - sewing foot stroke 5 mm
 - stitch count: mode 0 (not counted)
 - Segment End Mode: Stop active On, Thread trim active On, Needle Up active On, Foot lifted active On
 - start tack: inactive Off
 - end tack: active On
 - **Global parameters of program:**
 - name of the program: TEST TRAINING
 - FabricThickness: active On
 - Foot Stroke: Mode 2.OnOff, ThickMin. 3 mm
 - stitch lengths: Mode linear, Stitch Length 6mm, ThickMin: 2 mm, ThickMax: 5 mm

Programming Mode: Create a program

1. Activate the softkey menu  and press the  button (in manual or edit mode also button )
2. Program number
(accept proposed number or choose different program number using  or enter one with the numeric buttons)
3. Select 1st seam section and use  to add and activate it.



4. Set **parameters for the seam section**
5. Adjust the **global parameters** of the program  
6. Add more seam sections 
7. Delete a seam section with 
8. Press **ESC** to save program and quit programming mode.

Programming Mode: (Notes)

Exercise: Create a Simple Program

Create a program consisting of one seam section only

- Create program **P007 PROGRAM SIMPLE**
- Add a segment
- Set the **seam section parameters**:
 - stitch length 4 mm
 - sewing foot stroke 3 mm
 - needle thread tension 25
 - Seg.End Modes:
Stop active On, Thread trim active On, Needle Up inactive Off, Foot lifted inactive Off
 - start tack: active On
 - end tack: active On
 - Foot lifted: inactive Off
- Adjust the **global parameters** of the program:
 - Program Name: **P007 PROGRAM SIMPLE**
 - Bobbin: Mode Software, counter 500 points, MotorStop active On, ResetNeces active On
 - DailyPieces: On, Incr.
- Sew the program (test with material)
- Modify any parameter settings in the edit mode if necessary

Exercise: Create a complex Program

Create a program consisting of several seam sections

- Create the program
P008 COMPLEX PROGRAM
- **Section 1:**
 - stitch length 3.8 mm
 - sewing foot stroke 1.5 mm
 - needle thread tension 25
 - stitch count: number of stitches 12
 - Seg.End Mode: Stop active On, Thread Trim inactive Off, Needle Up inactive Off, Foot lifted inactive Off
 - start tack: active On
 - end tack: inactive Off
 - Foot lifted: Off
(foot lift at sewing stop on the seam)
- **Section 2:**
 - stitch length 6 mm
 - sewing foot stroke 5 mm
 - stitch count: mode 0 (not counted)
 - Seg.End Mode: Stop active On, Thread Trim active On, Needle Up active On, Foot lifted On
 - start tack: inactive Off
 - end tack: active On
- **Global parameters of program:**
 - program name: **COMPLEX PROGRAM**
 - FabricThickness: active On
 - Stroke: Mode 2.OnOff, ThickMin 3 mm
 - stitch lengths: Mode linear, ThickMin: 2 mm, ThickMax: 5 mm

Exercise: Create a program LACE

Creation of a program with backward sewing

- Program name: P...
LACE
- Section1:
 - stitch length 4 mm
 - sewing foot stroke 4 mm
 - sewing foot pressure 3
 - thread tension 25%
 - maximum speed: 200
 - Foot lifted: inactive Off
 - Seg.End Mode: Stop On, Thread Trim Off, Needle Up Off, Foot lifted Off
 - number of **backward** stitches: 2 pt
- Section 2:
 - Stitch count.: number of stitches 4 pt
- Section 3:
 - number of stitches **backwards**: 2 pt

Exercise: Programme « Cross »

stitch length: 3,5 mm
sewing foot stroke 3 mm
sewing foot pressure 3
thread tension 20%
maximum speed: 200

Segment 1: 2 forward stitches

Segment 2: 4 backward stitches

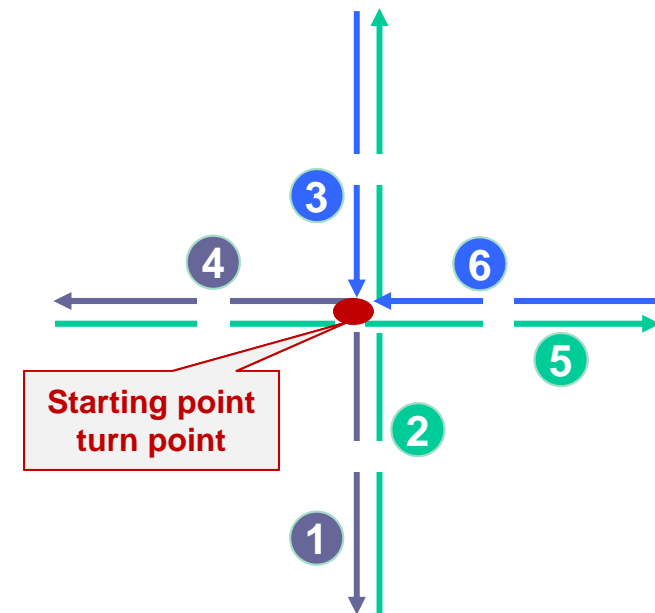
Segment 3: 2 forward stitches, **Foot lifted active On**

--> turn the material 90°

Segment 4: 2 forward stitches,
Foot lifted inactive Off

Segment 5: 4 backward stitches

Segment 6: 2 forward stitches



**P**
001-999

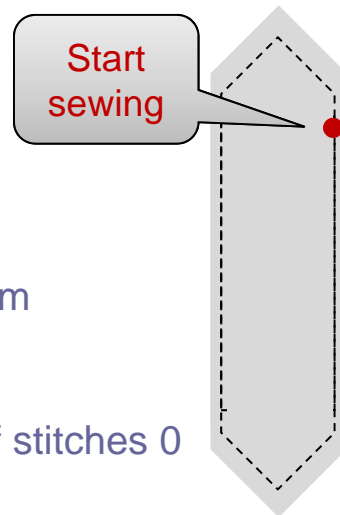
Practice various programs

- Basic parameters
 - stitch length: 3,4 mm
 - thread tension: 20
 - sewing foot pressure: 2
 - sewing foot stroke: 10
- Programs for chapes (bag handles, etc.)
- Latches, bartacks

Exercise: Create a complex program







Create a program consisting of divers seam sections

- Program name: **P... SEWING TEST**
- **Section 1:**
 - stitch length 4 mm
 - sewing foot stroke 4 mm
 - sewing foot pressure 3
 - thread tension 25
 - stitch count: number of stitches 0
 - maximum speed: 200
 - Seg.End Modes: Stop active On, Thread Trim inactive Off, Needle Up inactive Off, Foot lifted active On, H. Foot lifted 13 mm
 - start tack: inactive Off
 - end tack: inactive Off
 - Foot lifted (at stop in the seam): inactive Off
 - Guide: Gap 3 mm




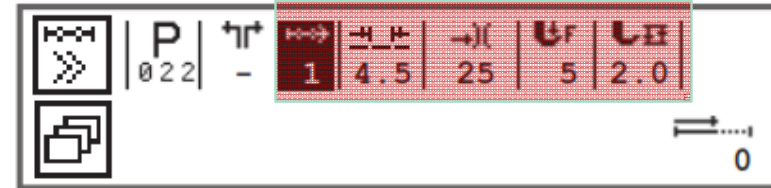
- **Section 2:**
 - stitch count: number of stitches 7
- **Section 3:**
 - stitch count: number of stitches 7
- **Section 4:**
 - stitch count: number of stitches 0
- **Section 5:**
 - stitch count: number of stitches 7
- **Section 6:**
 - stitch count: number of stitches 7
- **Section 7:**
 - stitch count: number of stitches 2
 - Seg.End Modes: Thread Trim inactive Off, Needle Up inactive Off, Foot lifted inactive Off

Programming Mode: Copy / Delete a program

1. Select the program you want to copy
2. Activate the programming mode by pressing the button 
3. Press the numeric button under  in the Softkey Menu 
4. Select the seam section to be edited
and adjust the parameters of the selected section
5. Adapt the global parameters of the program 
6. To **delete a program** press button  in the Softkey Menu 

Creating a program using the Teach-in function

1. Create a new program
2. Press the **Teach-in**  button.
3. Automatic creation of 1st section
4. Adjust basic parameters: stitch length, needle thread tension, sewing foot pressure, sewing foot stroke
5. Press the pedal and complete the seam section up to the desired position on the material.
6. Add a 2nd seam section and set the basic parameters.
7. Press the pedal and complete the 2nd seam section. *If necessary add another new sections (repeat steps 6 and 7).*
8. Terminate program: Push the pedal fully back. The program switches to Edit mode.
9. If necessary, set additional parameters for all seam sections and the global program parameters.
10. Quit with **ESC** button.



Exercise: Create a program using Teach-in

- Create the program P011 LABEL
- Add and activate the 1st seam section and set the basic parameters:
 - stitch length: 5mm
 - needle thread tension: 25%
 - sewing foot stroke: 3 mm
- “Record” 10 points for each seam section segment (by sewing)
- Adjust the parameters for the seam sections:

Section 1	Section 2	Section 3	Section 4
<ul style="list-style-type: none"> • Seg.End Mode: Stop On, Thread Trim Off, Needle Up Off, Foot lifted On • start tack: Off • end tack: Off 	<ul style="list-style-type: none"> • Seg.End Mode: Stop On, Thread Trim Off, Needle Up Off, Foot lifted On • start tack: Off • end tack: Off 	<ul style="list-style-type: none"> • Seg.End Mode: Stop On, Thread Trim Off, Needle Up Off, Foot lifted On • start tack: Off • end tack: Off 	<ul style="list-style-type: none"> • Seg.End Mode: Stop On, Thread Trim Off, Needle Up Off, Foot lifted Off • start tack: Off • end tack: On

- Set the global parameters of the program:
 - Program name: P011 LABEL

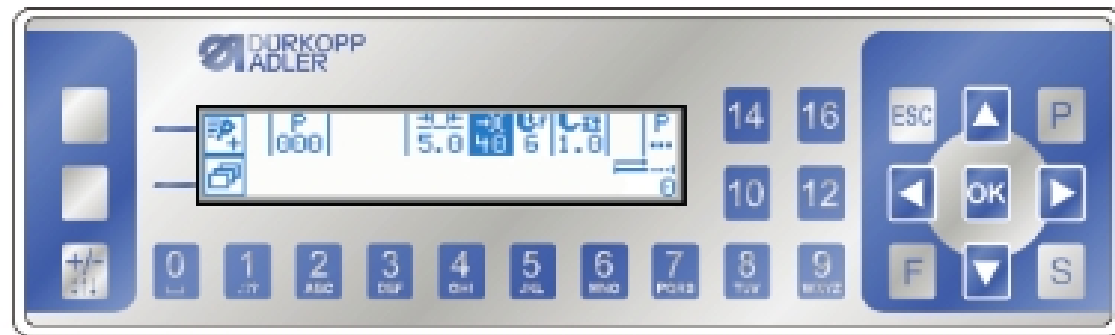
Conclusion Day 2

- Edit Mode: Modify / Edit programs
- Global program parameters
 - Parameters of seam section
- Programming Mode
 - Create programs
 - Adjust basic parameters, parameters for the seam sections and global program parameters
- Copy / Delete a program
- Create a program using the teach-in function

BEST PRACTICE

- Useful sequence for creation of programs
(Adding a new section in the program copies the values of the previous section)
- Pre-set of default values for programs in technical mode
(values used for first section)
- Copy a program and modify settings
- Create a program with teach-in (stitch count)
 - pre-set of base parameters IN THE 1st SECTION
 - NEXT: add new sections (copies parameter values)

QUESTIONS?



**THANK YOU
FOR YOUR ATTENTION**



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