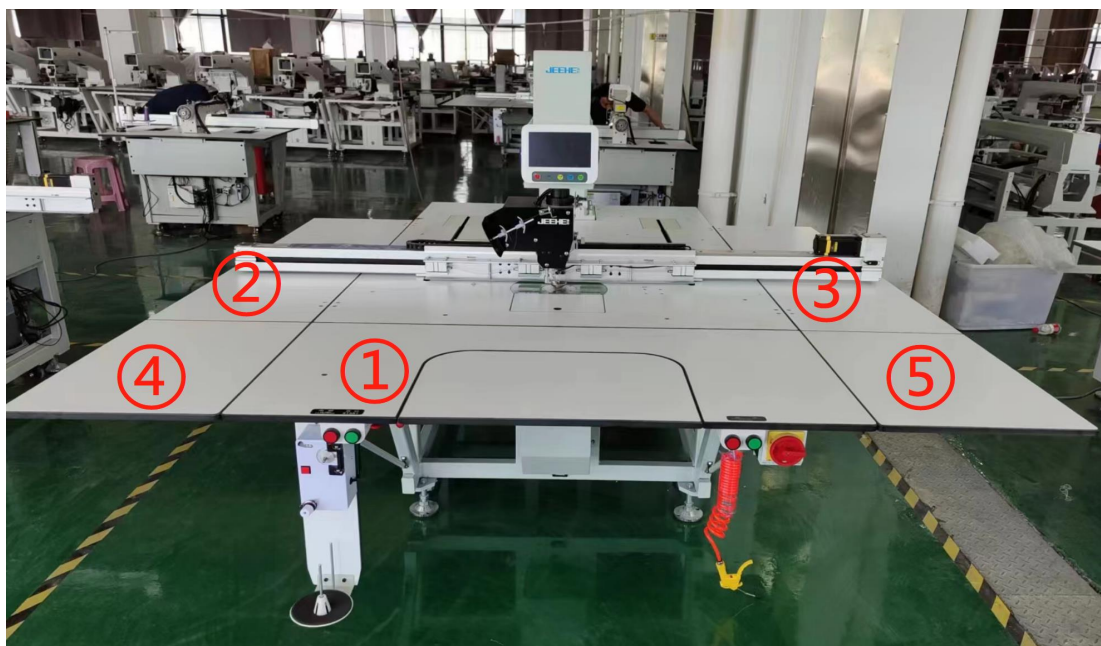


Installation & Testing Manual-- Wenkong system

1



2



Take out the table supports from the box.

Fix on machine base and tables accordingly.

Support AB are short, total 4pcs, use for support left and right table ②③;

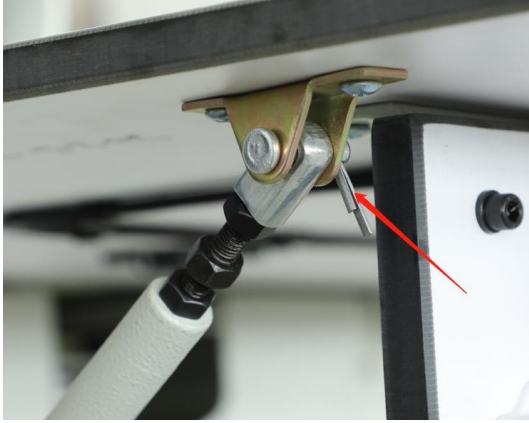
Support C is midium length, total 2pcs, use for support table ④⑤.

Support D is longest, total 2pcs, packed separately out of the box, use for support front table ①.



One side of the support fixed on the machine base;
Another side connect below the table, fixed by cotter.

3



4



Table ④⑤ must use 4pcs iron blocks to connect with other tables.

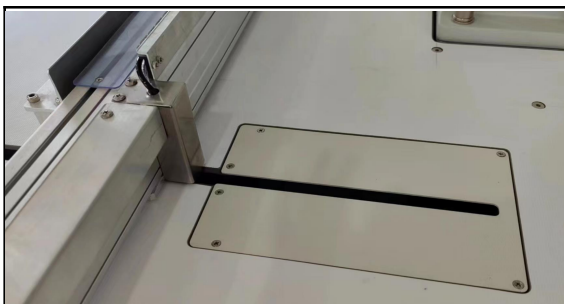
*After table install completely, please move the drive front & back, left & right, to check the whole machine table is flat or not.

5

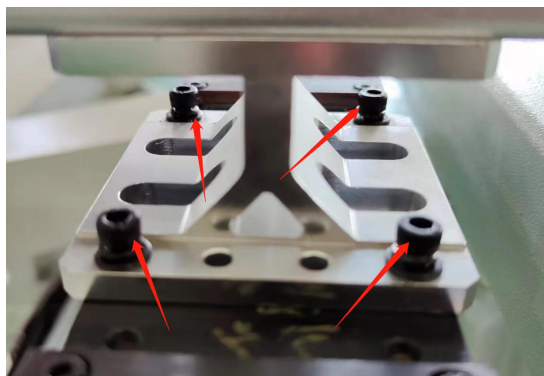
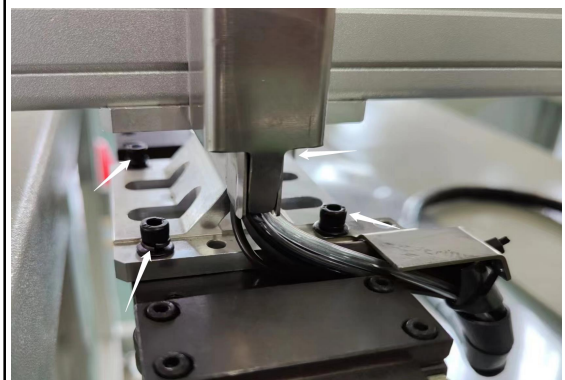


Install the bobbin winder below the table

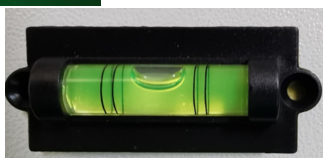
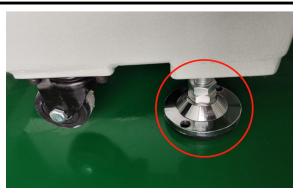
6



Fix the drive by the 3pcs screws which in different length accordingly.
*Please fix the screws tightly.



7



Please place the machine in horizontal position.
You can adjust through feet to achieve horizontal position.

8



Please connect power supply.
220V, single phase

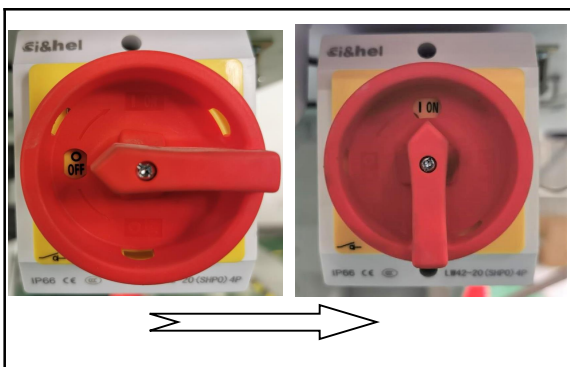
Connect air compressor.
(some parts request air cylinder drive.)

9



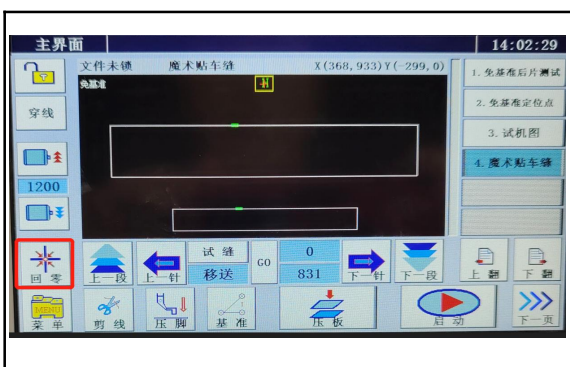
Please check barometer
Normally air pressure should
between 0.5MPa to 0.6MPa

10



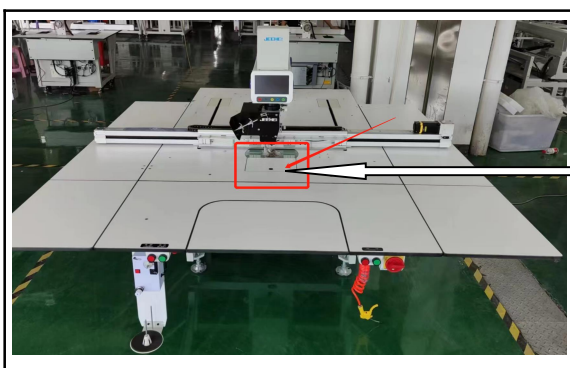
Turn right to power on the
machine

11



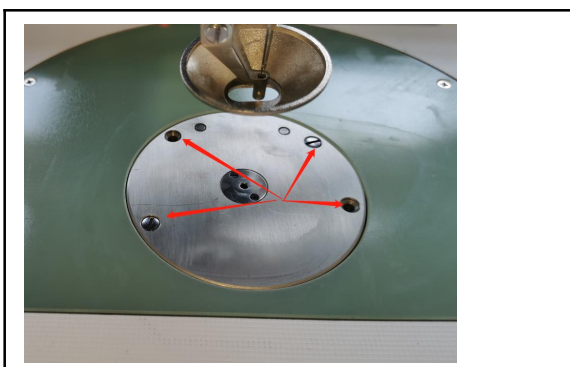
Press "Home" zero position.
*Please don't approach the drive.
The drive will move to check all
limits.
*Please don't operate below the
head.
The head will turn 360° to zero
position

12



Please remove the cover

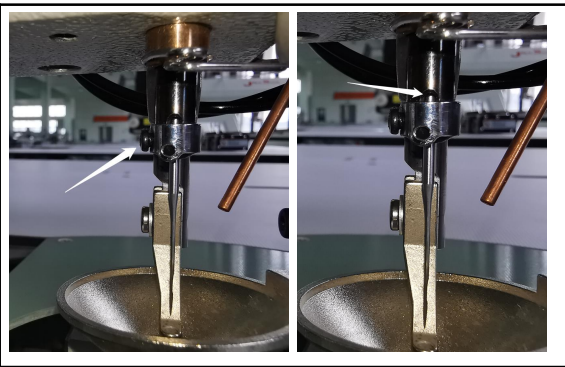
13



Use slot type scwdriver
Loose the screws on the
needle plate.
Remove the needle plate

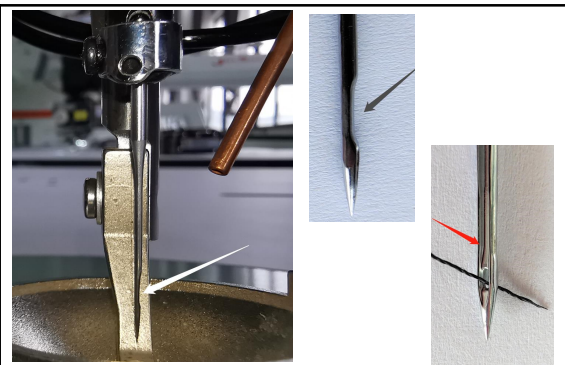
Install needle

14



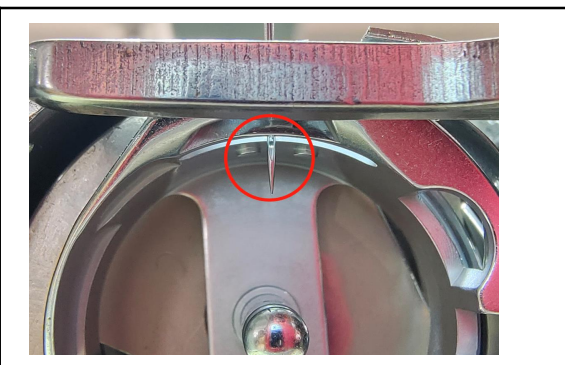
Loose the screw of the needle clip
Install the needle to the end of the top, tight the screw.

15



Needle concave toward rotary hook
sharp
Needle groove toward operator

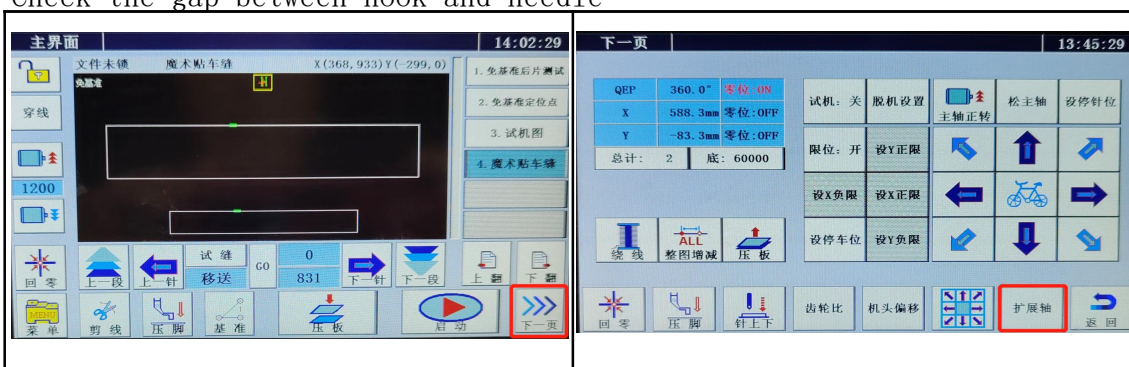
16



When needle bar in lowest position, the whole needle eye shown in the rotary hook

Check the gap between hook and needle

17



Press next page

Press EXT

18



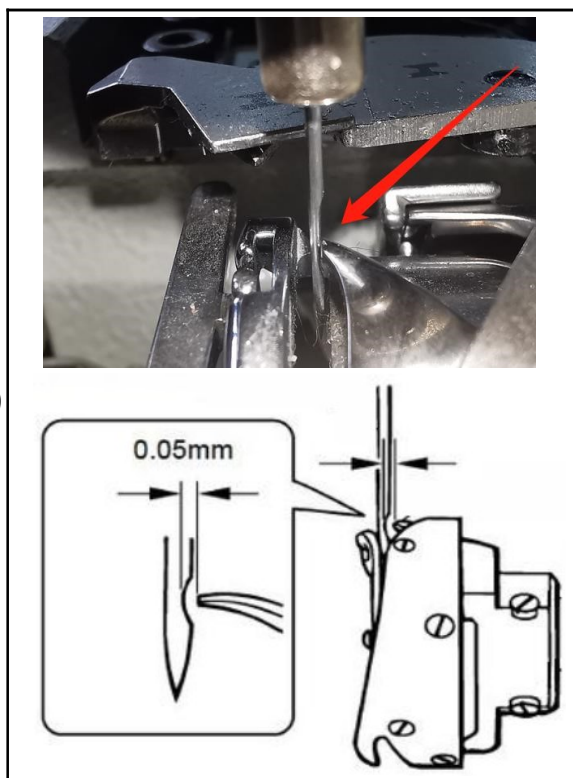
Press Home

(In case of wrong operate)



Press U+ let the needle down

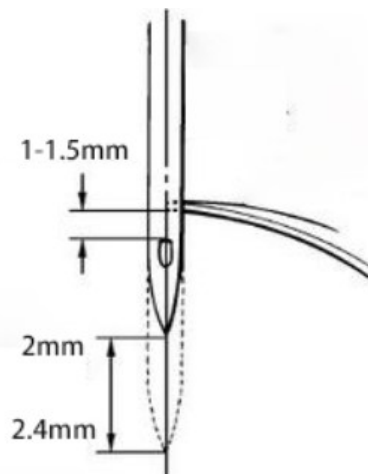
19

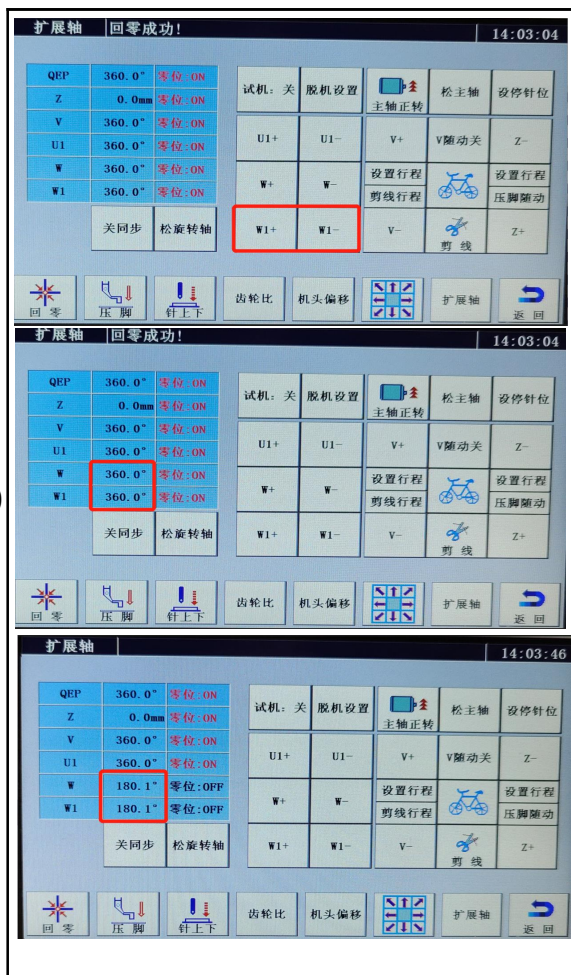


Height: 1-1.5mm upper of the needle eye

Gap: Needle to rotary hook sharp about 0.5mm

Depth: Needle sharp to the lowest position about 2-2.4mm



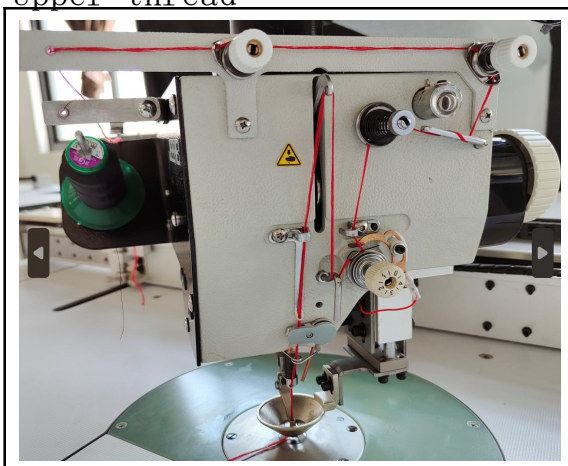


Press W1+ or W1- Make the head and hook box turn to 90° 180° 270°



Gap of needle to rotary hook, must check 4 directions.
press R- or R+, let the head and rotary hook turn to 90° 180° 270° 360°

Upper thread



Upper thread threading method

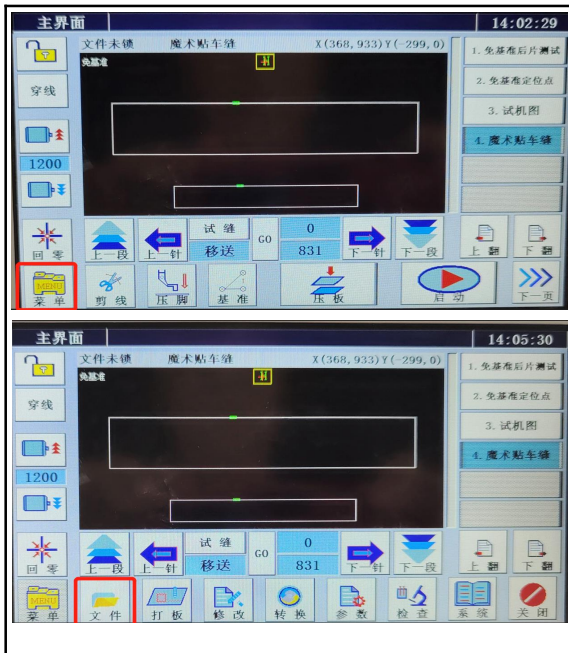
Insert file

22



Put on USB pen drive
USB pen drive volume should
less than 16G

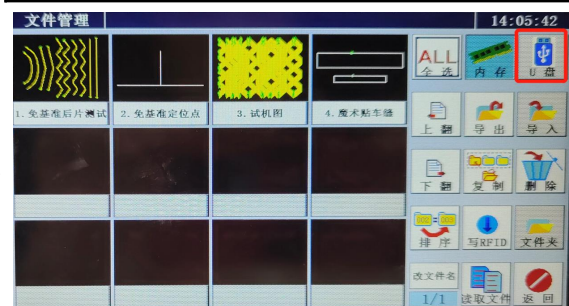
23



Press Menu

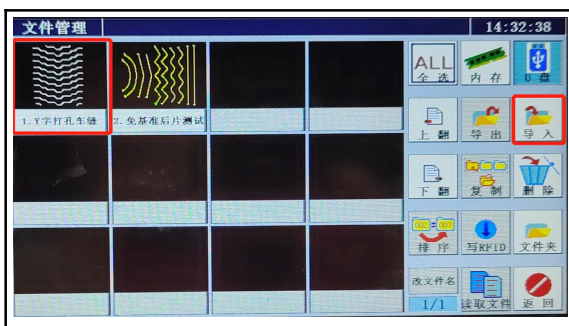
Press File

24



Press USB

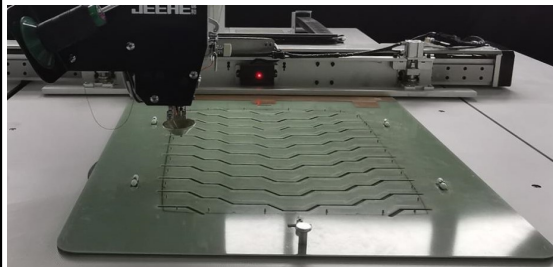
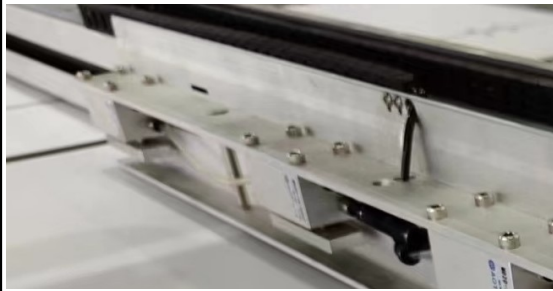
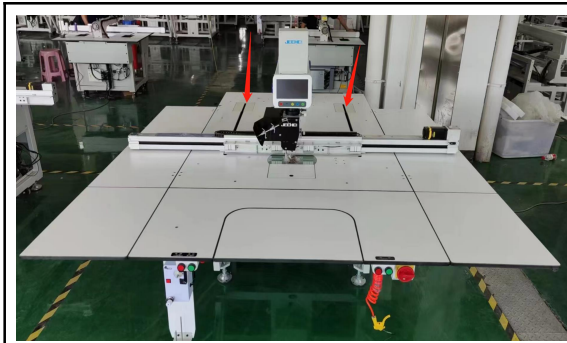
25



Select the design
Press input

Check 2nd Home

26



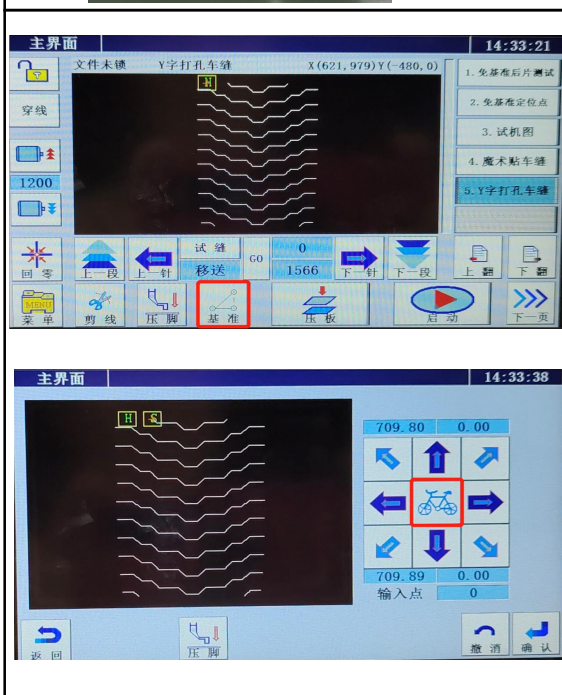
Put on Template (Empty template, without fabric)
Pls make sure the frame clip / frame press are correctly
Press the frame clip button below the left side of the table

27

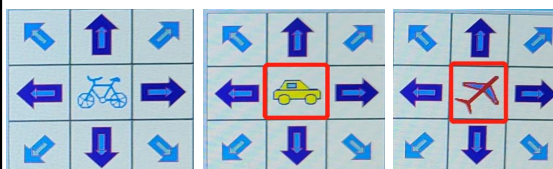


check the start point of the design
Find the start point on the template
*Need to check the "start point on the template" with needle plate hole in middle

28



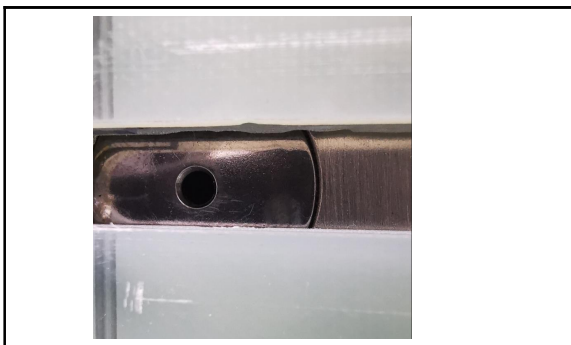
Press BasePt



Low speed Medium speed High speed
Can move the frame by the 8 arrows
check the "start point on the template" with needle plate hole in middle
Press confirm

Press Back, Press on Next Stitich, machine will move forward, pls check

29

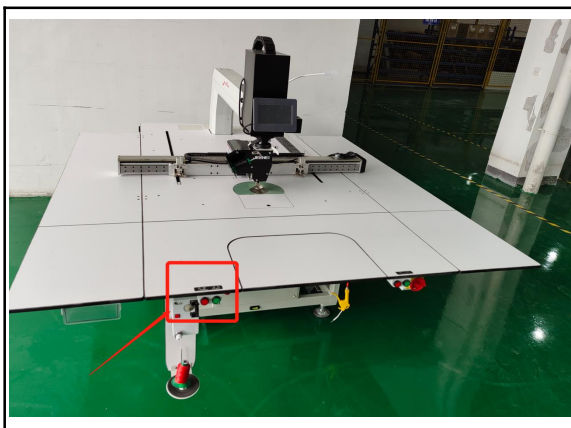


every start, end, corner, make sure the needle plate hole in the template

Needle plate hole should in the middle of template groove (single stitch line)

Needle plate hole edge to stitch edge about 3mm

30



Press Start Button

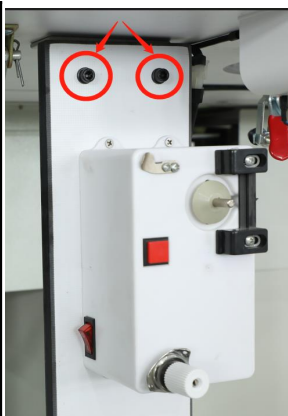
Trial sewing to check press foot in the middle of groove all the way sewing.

Bobbin winder install and use

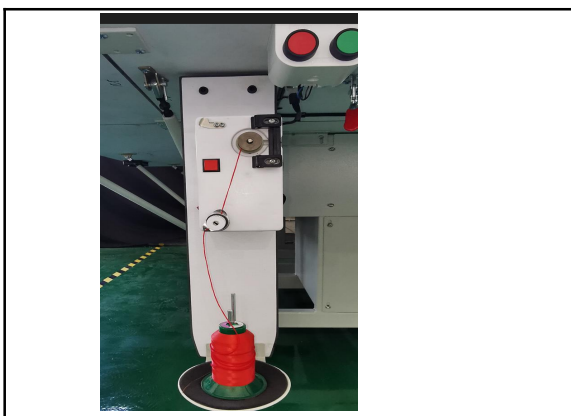
31



Take the bobbin winder out from box, install it below the table

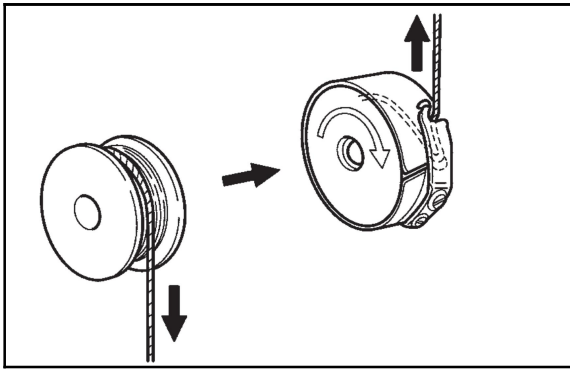


32



Wind the bobbin thread

33



Put the bobbin in the bobbin case

34



Put the whole bobbin case in the rotary hook

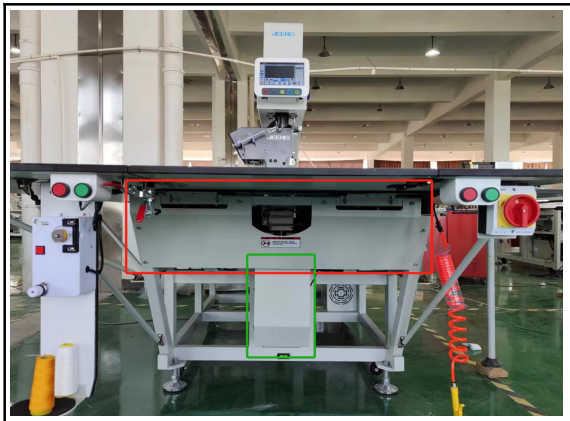
Adjust method for rotary hook timing

35



Please make sure machine is in horizontal position

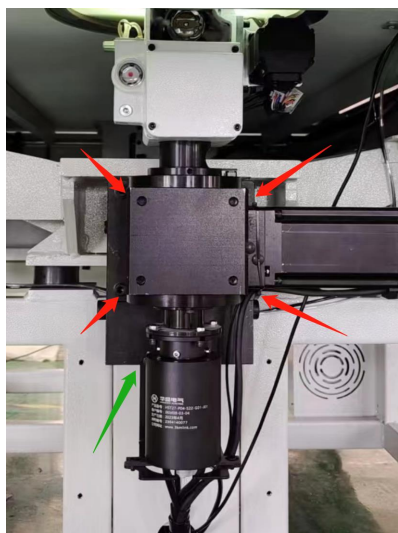
36



When the gap between needle and rotary hook too big, we can adjust the head (front-back, left-right), to achieve reasonable gap.

Loose the screws of the upper and down cover, take off the covers

37

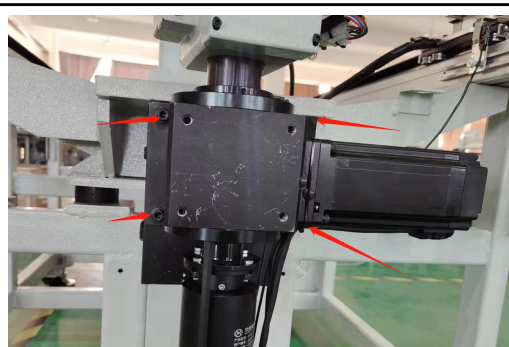


38



When the gap of rotary hook and needle too big at 0° & 180° , you can adjust the screw down the rotary hook, to achieve reasonable gap

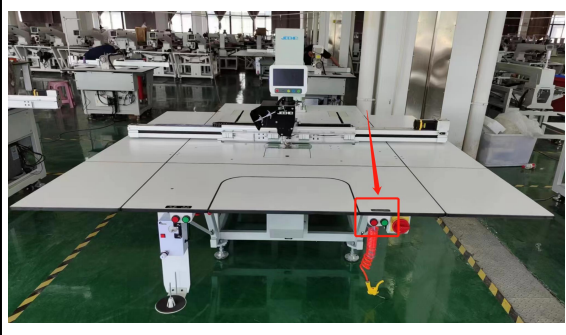
39



When the gap of rotary hook and needle too big at 90° & 270° , you can adjust the 4 screws on side of the machine, to achieve reasonable gap
Pls tight the screws after adjust.

Emergency stop

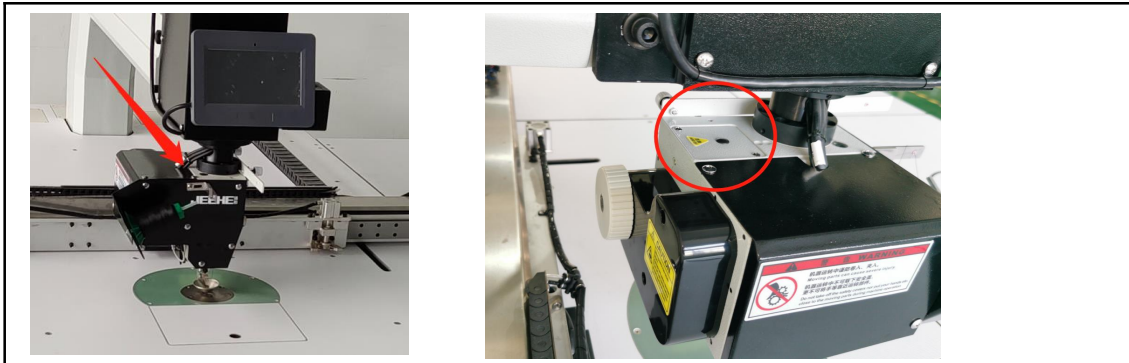
40



Emergency stop below the right side of table

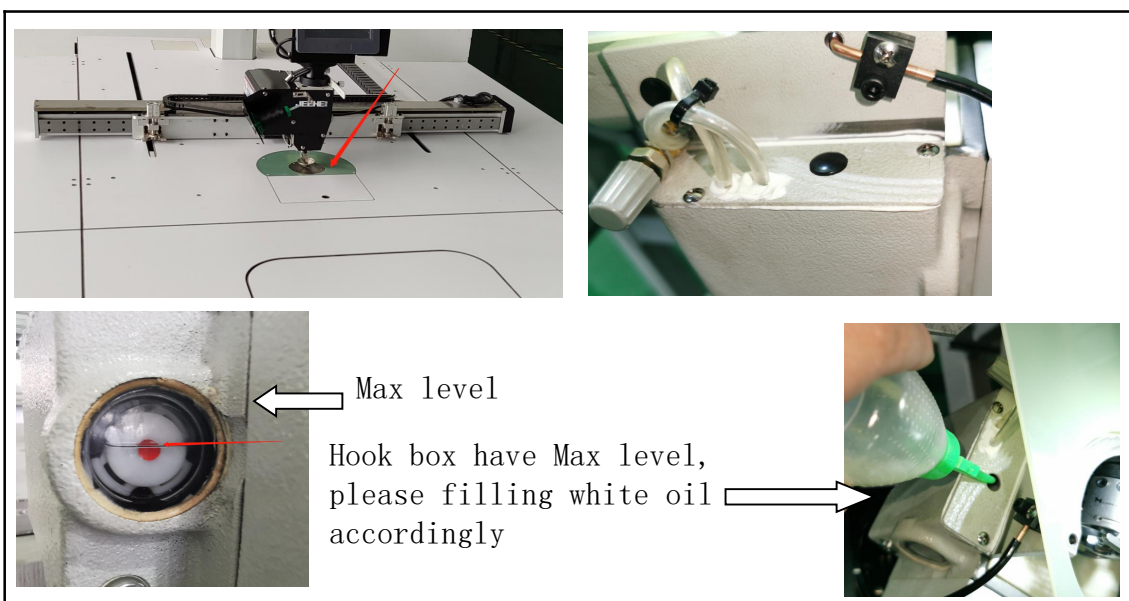
Lubricate instruction

41



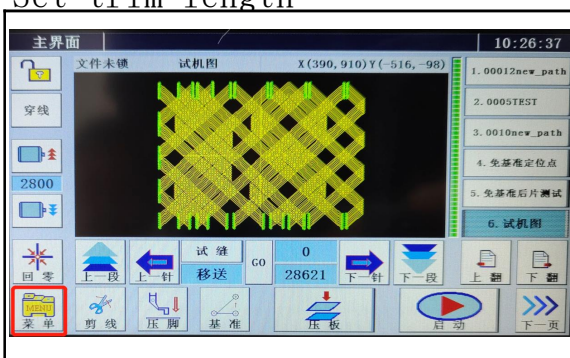
Head with trace oil. Use white oil.
Drop some drips a week.

42



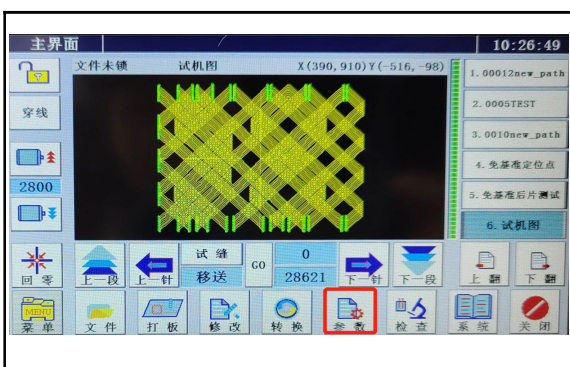
Set trim length

43



Press Menu

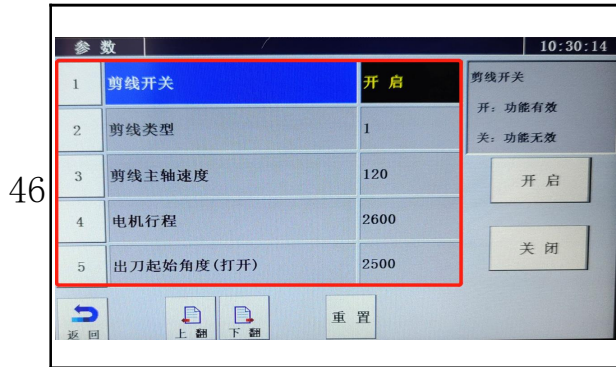
44



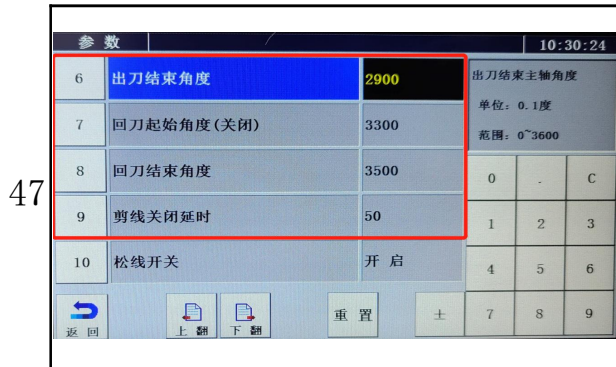
Press Param



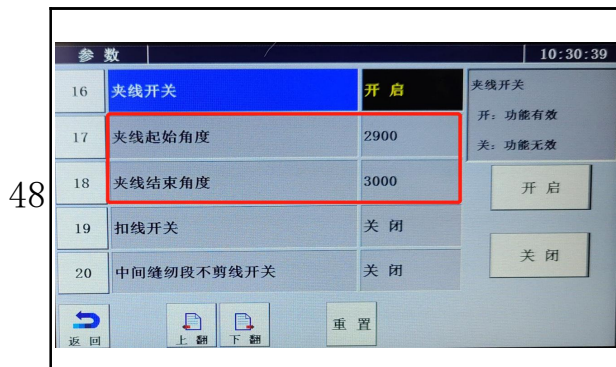
Press Trim Release



Normal trim parameters keep same as factory record



5 ----2500
6 ----2900
7 ----3500
8 ----3600
9 ----50



17 ----3100
18 ----3500

Set bobbin thread length

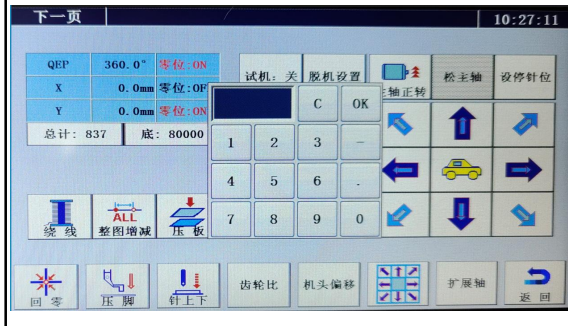


Next page



50

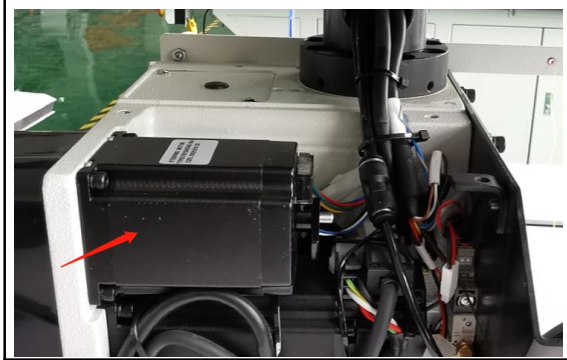
Press the bobbin area



Press the Number area, put the Approximate length of bobbing thread. Unit: mm

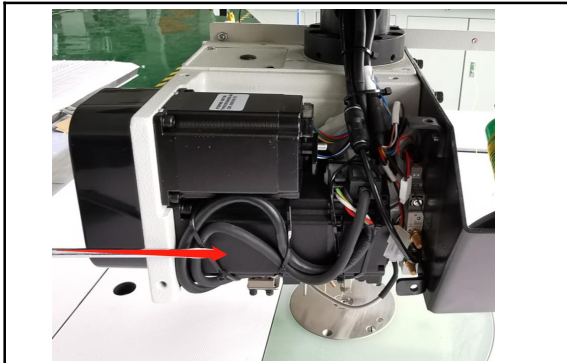
Machine will stop when that length use-up.

Each motors



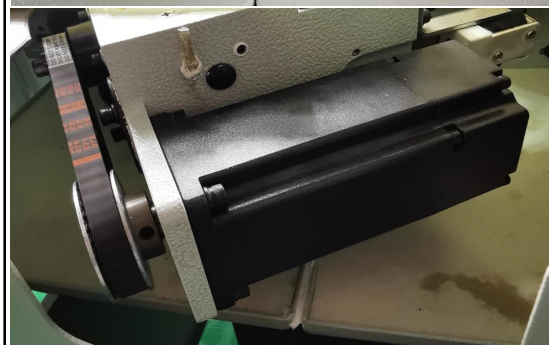
51

Press foot motor



52

Upper shaft motor



53

Down shaft motor

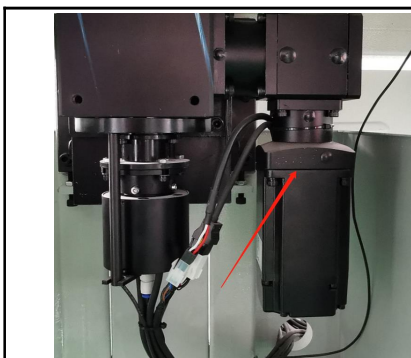


54

Y motor



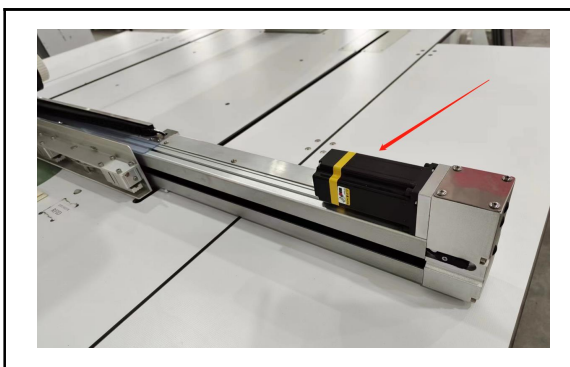
55



56

Down rotate motor

57



X motor

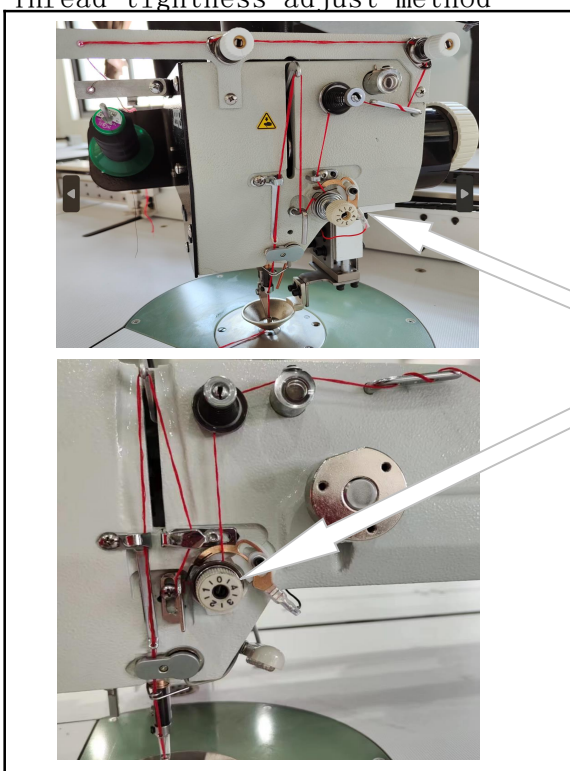
58



Upper lift motor

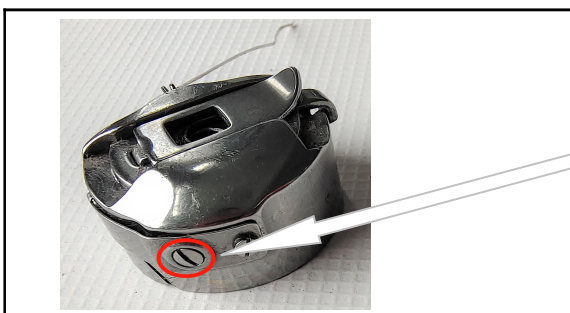
Thread tightness adjust method

59



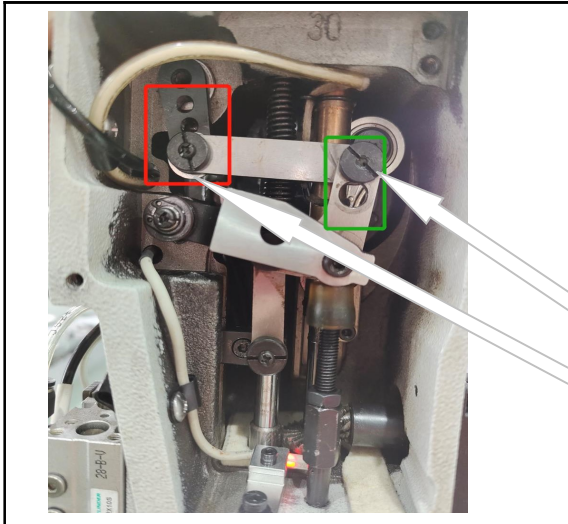
When the stitches too loose or too tight, you can adjust the tensions.

60



When the bobbin thread too tight or too loose, you can adjust the screw on the bobbin case.

61



If the bad stitch quality can't change through above method, you can adjust the press foot running length.

Before adjust

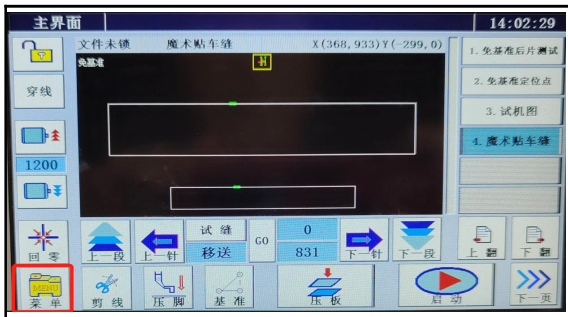
After adjust

62



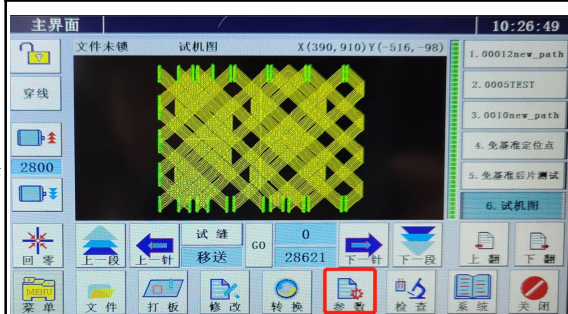
Turning angle adjust

63

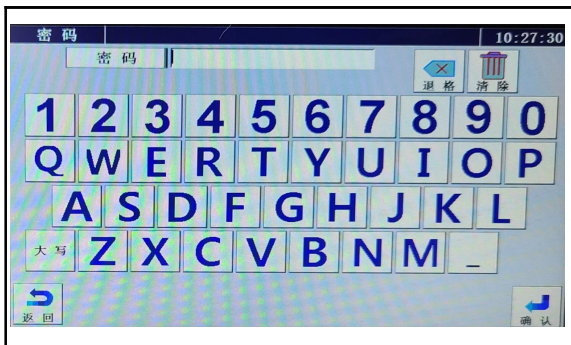


Press Menu

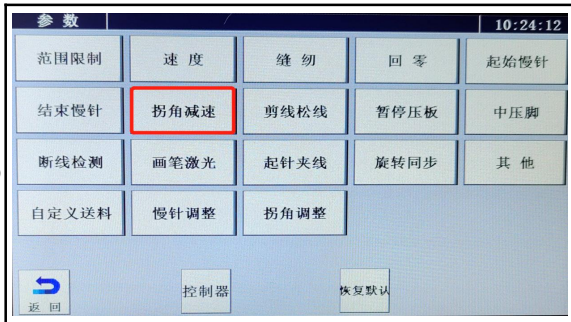
64



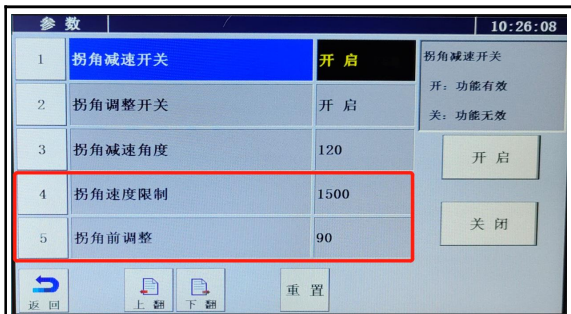
Press Param



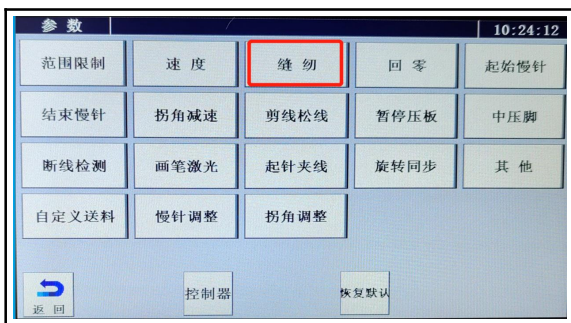
Password: WK999999



Press Corner Slow



Can adjust column 4,5 (Normally no need to adjust)
Corner Min Speed: Main shaft speed when turning
Adjust Before Corner %: smaller number XY move faster



Press Sewing



Can adjust 8: X delay time (Normally no need to adjust)

Before adjust

After adjust

