

Uzu[®]

AUTOMATIC FRONT PLACKET MACHINE.



UZ-PL55D-ST/PS

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VOLTAGE :
220V/1Ph/50-60 Hz.

INSTALLATION

- When installing the machine leave some distance from the walls and other machine. The machine must be place on a perfect leveled floor.
- Adjust all of the screws to stable and secure the machine to be in the same level.
- Arrange a 1phase 220V. electric then connect to the ground line and connect to the machine.
- It is important that the machine is connect to the ground line otherwise our guaranty will automatically be reject.

NOTE!!

Only qualified, skilled personal are allowed to operate this machine. Please read carefully the instruction concerning safety, Installation, operation and maintenance in this manual.

SAFETY CAUTIONS

- For safety before moving the machine make sure that the following should be made:
 - Switch off and pull the plug out of the socket.
 - The compressed air inlet valve must be shut, and all the compressed air inside the machine must be discharged (UZ-PL33-ST/PS)
- Pause switch must be pressed before re-thrusting the thread.
- Machine must be turned off before changing bobbin, needle, knife adjustment cleaning etc.
- Do not operate the machine without eye guard.
- Sharp knife is equipped, do not touch except operator.
- Do not operate the machine before lubricating properly.

1. INSTRUCTION FOR HIDDEN PLAKET.

POWER ON then wait for a while, monitor will be show as below (see figure 1)



Figure 1

Press **Hidden** (Hidden Placket) then press **Next** go to **Home** page.(See Figure 3)



Figure 2

Home page (See Figure 3)

JL >> Show sewing shape that you choose. (See item 4, Figure 7,8 on page 3)

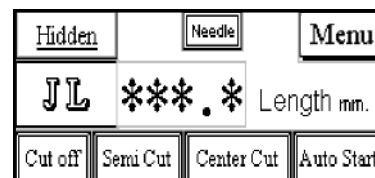
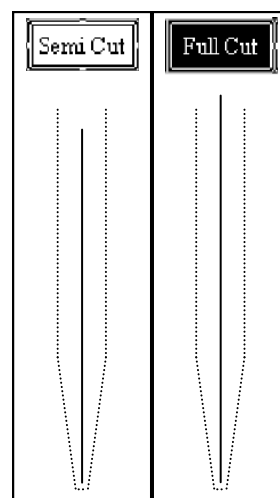


Figure 3

1.1 LENGTH ADJUSTMENT. >> Press ******** then enter sewing length.

- Cut off** Cutting knife ON/OFF
- Semi Cut** Knife cutting lower than start and end stitching (See page 8 Pict.11)
- Full Cut** Knife cutting over start and end stitching. (See page 8 Pict.12)
- Center Cut** For cutting after complete stitching (Hidden placket sewing shape only)
- Auto Start** Auto start sewing, Press "ST2" on foot switch once .
- Hidden** Shown Placket type that you choose.(Press for five seconds to change center placket)



NOTE! IF THE CLAMP IS MOVED WHILE **Needle** SHOWS WHITE COLOR AN ERROR MESSAGE WILL SHOW "ERROR NEEDLE DOWN"

TOUCH THE SCREEN AND TURN THE NEEDLE TO UP POSITION (THE BUTTON WILL CHANGE TO BLACK COLOR) THEN YOU CAN MOVE THE CLAMP AGAIN.

2. QUANTITY SETTING.

Press **MENU** on **HOME** page (See Figure 3) go to **MAIN MENU** page.

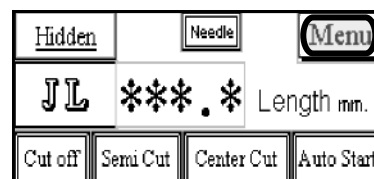


Figure 3

Count Press go to sewing quantity setting. (See Figure 4)

Count OFF Press to start counting. (See Figure 5)

Set Qty Enter sewing quantity as requirement.

Count Hold pressing to reset quantity.

Add(+) **Sub(-)** Press to increase or decrease quantity.



Figure 4



Figure 5

3. SETTING START AND END STITCHING TYPE.

Press **Type** Go to setting start and end stitching type. (See Figure 6, Pict. 1)

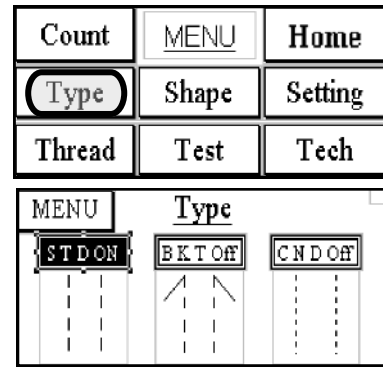
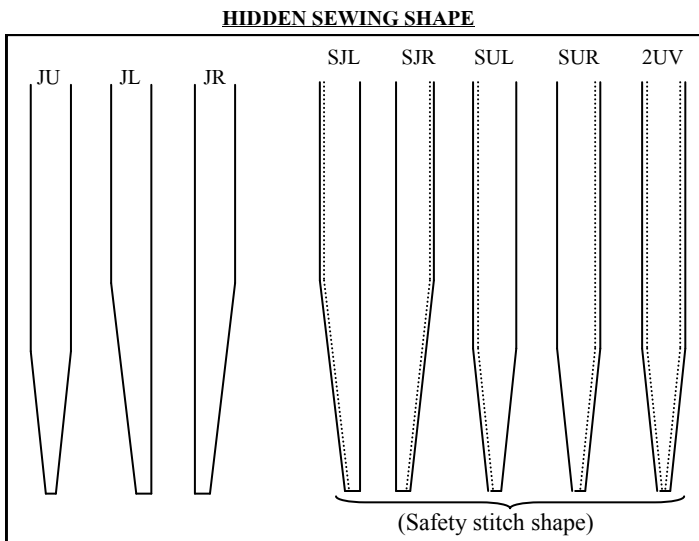


Figure 6

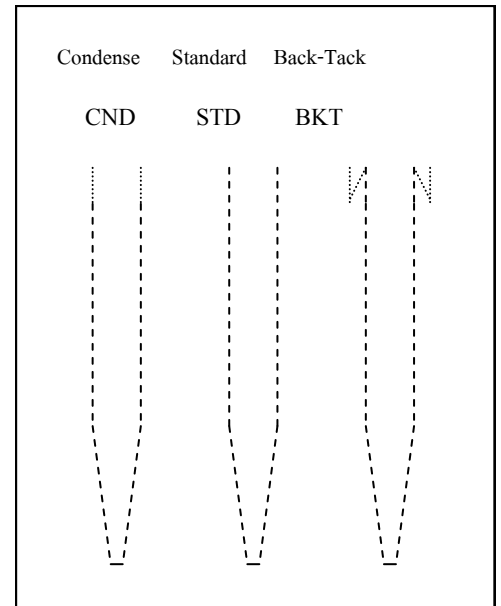
4. CHOOSE SEWING SHAPE(HIDDEN PLACKET)

Shape Press to choose sewing shape. (JL, JU, JR and Safety stitch SJL,SJR, SUL,SUR,2UV) (See Figure 7,8 and Pict. 2)

** The button will change to black light to confirm sewing shape.**



Pict. 2



Pict. 1

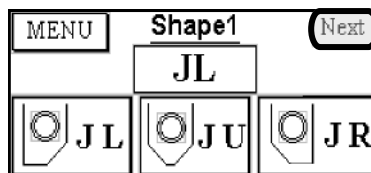
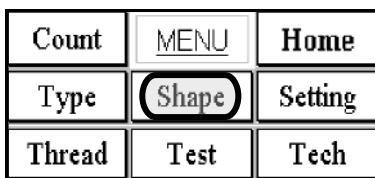


Figure 7

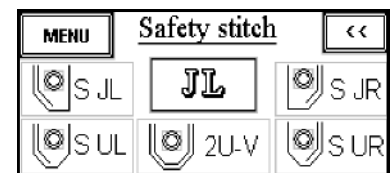


Figure 8

5. SEWING SHAPE ADJUSTMENT (HIDDEN PLACKET)

On menu page, press **Setting** to adjust sewing shape. (See Figure 9,10,11)

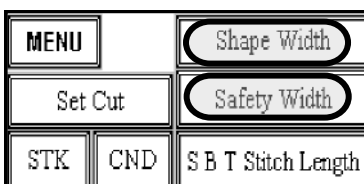


Figure 9

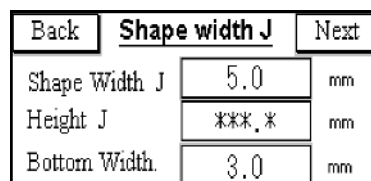


Figure 10

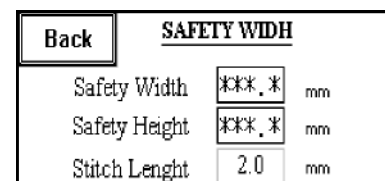


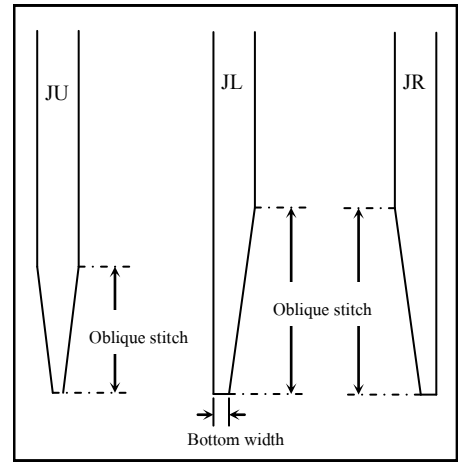
Figure 11

For Safety stitch shape only

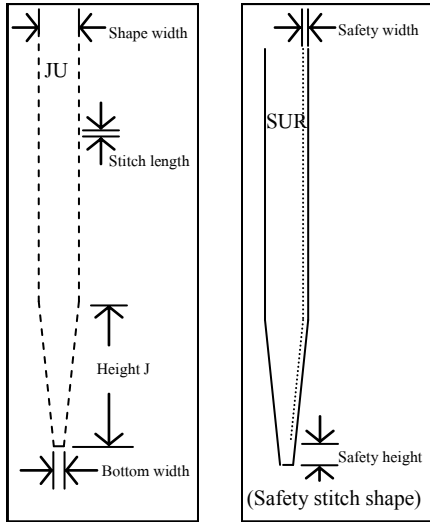
NOTE !! FIGURE 11 SHOWS SAFETY STITCH SHAPE FOR SJL,SJR,SUL,SUR,2UV ONLY.

5.1 SETTING SEWING SHAPE AND STITCH LENGTH.

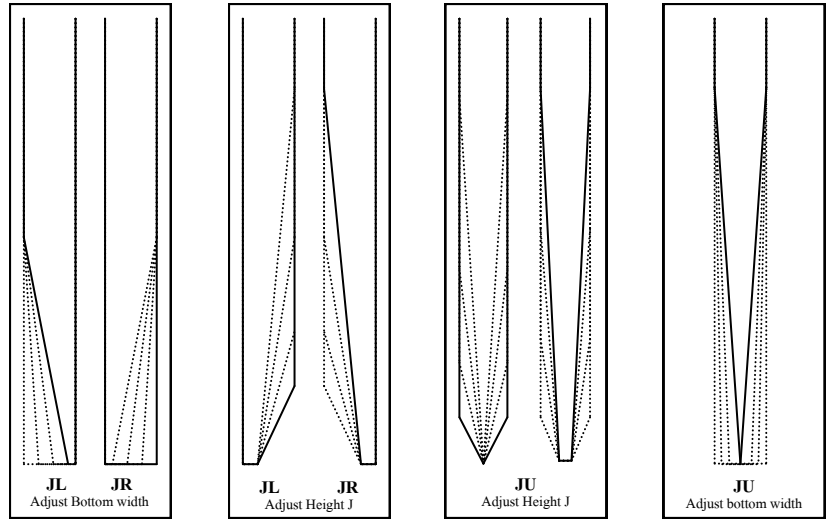
- Shape Width** >> Input sewing width from 5-8 mm.(See Pict.4)
- Height J** >> Setting height of oblique stitching. (See Figure 9.1 and Pict. 3,4)
- Bottom width** >> Input Bottom sewing shape from 5-8 mm.(See Pict.3,4)
- Safety Width** >> Input width of safety stitch.(See Pict.4)
- Safety Height** >> Input height of safety stitch at start sewing position.(See Pict.4)
- Stitch** >> Stitch length of 2.0mm., 2.3mm., 2.5mm., 2.8mm.and 3mm. are available to select.



Pict. 3



Pict. 4



SEWING SHAPE AFTER ADJUST BOTTOM WIDTH AND HEIGHT J.

5.2 START AND END BACK-TACK OR CONDENSE STITCH LENGTH.

Count	MENU	Home
Type	Shape	Setting
Thread	Test	Tech

MENU	Shape Width
Set Cut	Safety Width
STK	CND
	S B T Stitch Length

Figure 12

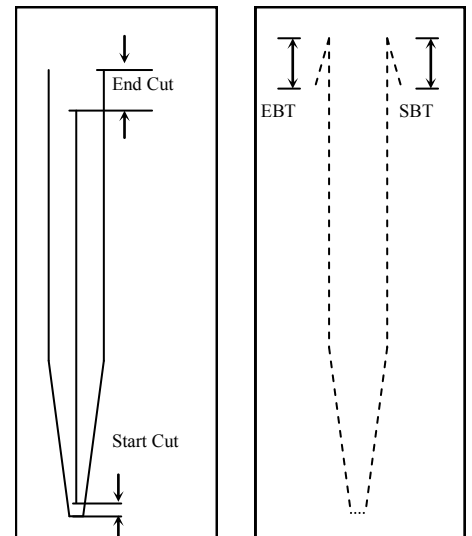
Back	S B T Stitch		***.*	mm
	E B T Stitch		***.*	mm
	Stitch Length		2.0	mm

Figure 13

Press **Menu** >> **Setting** (See Figure 12)

SBT >> Start back-tack and condense stitch length.(See Figure 13,Pict.5)

EBT >> End back-tack and condense stitch length.(See Figure 13,Pict.5)



Pict. 6

Pict. 5

5.3 KNIFE CUTTING POSITION ADJUSTMENT.

Press **Set Cut** >> (See Figure 12,14 and Pict.6)

Start Cut >> Start cutting position. (Bottom position)

End Cut >> End cutting position. (*Semi Cut only*)

MENU	Shape Width
Set Cut	Safety Width
STK	CND
	S B T Stitch Length

Back	Start Cut	
	Start Cut	End Cut
	**.*	**.*
	mm	mm
	Cutting Speed	
	**** Hz	

Figure 14

5.4 CONDENSE STITCH BOTTOM LEFT AND RIGHT POSITION.

Press **CND** (See Figure 15 and Pict. 7)

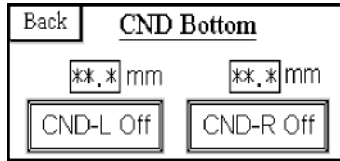
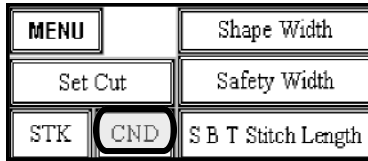
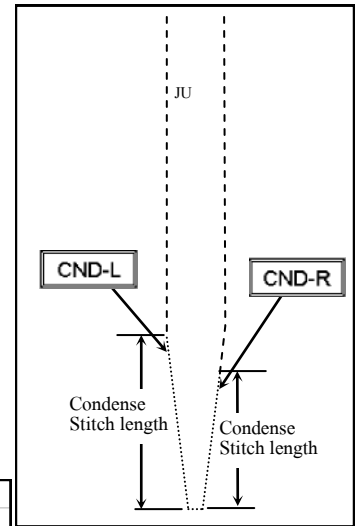


Figure 15

Press **CND-L** >> Choose sewing condense stitching on left side.

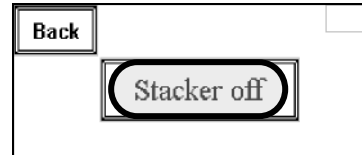
Press **CND-R** >> Choose sewing condense stitching on right side.

Press ****.* mm** >> Setting condense stitch length.



Pict. 7

5.5 STACKER ACTIVATE. Press **STK** then **Stacker off**



6. BOBBIN THREAD REMAIN SETTING. Press **Thread** See Figure 16.

Sets the length of thread in the bobbin to stop sewing before the thread ran out. The highest standard is 3000cm. Minimum standard is 200cm. When the bobbin thread remaining is 200cm, the machine will automatically stop with flashing message alert.

****Able to press "PAUSE" Button to continue sewing.****

INSTRUCTION

- 1) Bobbin thread fully winding, Press "Reset"
- 2) Attach bobbin thread then continue sewing until bobbin thread is finished.
- 3) Change new bobbin thread.
- 4) Use the maximum number 3000 then subtract with the remaining thread (**Remain**) and put the result in **Thread max** and then press **RESET**.

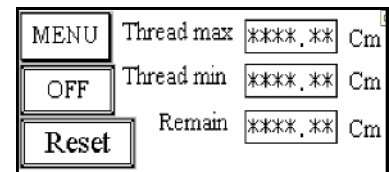
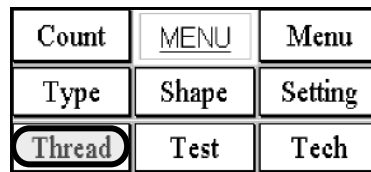


Figure 16

NOTE !! IF YOU DO NOT WANT TO PROCEED THIS FUNCTION YOU CAN CANCEL THE ACTION BY PRESSING OFF BUTTON.

6.1 UPPER THREAD BREAK WARNING.

In case of thread break while sewing, machine will stop and PAUSE lamp will blink with message shown in figure 17.

- >> To re-threading, press "FORWARD" or "REVERSE" to move clamp to the thread break position then press "PAUSE" to continue stitching.
- >> Press "RESET" to cancel stitching.

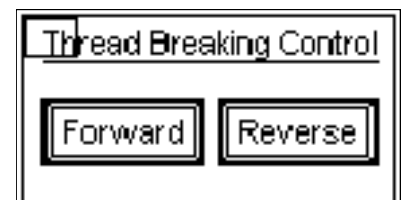


Figure 17

NOTE !! NEEDLE MUST BE IN AN UPWARDS POSITION TO BE ABLE TO PRESS "FORWARD OR REVERSE"

CAUTION !! FOR SAFETY PRESS PAUSE EVERYTIME YOU RE-THRUST THE THREAD.

7. TESTING FUNCTION. Press **Test** on menu page to testing mode (see Figure 18)

7.1 STACKER TESTING .Press **Stacker** (See Figure 18)

Test Stacker Press before testing. (see Figure 19)

<< Stacker arm move out.

-< Stacker's jaw close

Test Stacker Press again to quit the testing function.

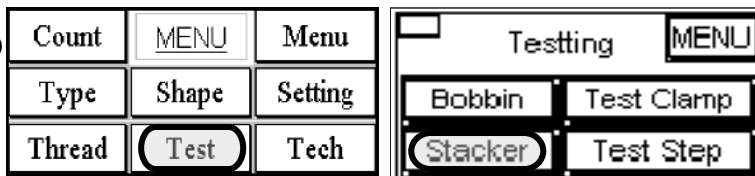


Figure 18

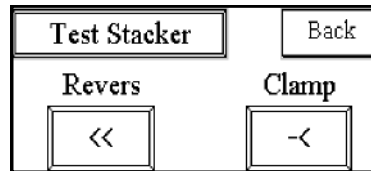


Figure 19

7.2 TESTING THE MOVEMENT OF CLAMP. Press **Test Clamp** Figure 18 (Use for clamp adjustment so it doesn't crash with knife or needle)

Test Clamp (dle)

Needle Press to start testing (see Figure 20)

▲ Light must be black **▼** color.

< Move backward **>** Move forward

Move left

Move right

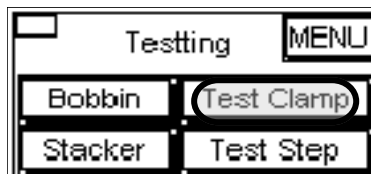


Figure 18



Figure 20

Note! While moving clamp if crash with knife or needle you can adjust it

7.3 TEST THE SHAPE OF STITCHING AND MARKING LIGHT.

Press **Test Step** (Clamp will move according to the shape chosen JU, JR or JL)

Testing

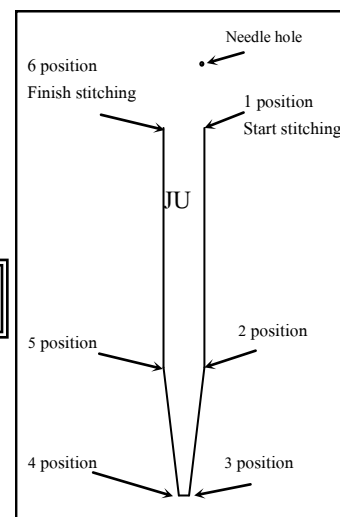
1. Press the foot switch (ST1) to move the clamp forward.
2. Use A4 paper to put beneath the clamp, press foot switch (PF2) to make the clamp press down.
3. Press **Test** to start the testing (see Figure 21)
4. Press **Start Step** to move clamp(Clamp moves one step every pressing)
5. When clamp move one step move the needle to stick on paper to reposition. (see Pict.6)
6. Able to press (ST1) to stitch for testing, after testing clamp move reverse so it can set light marker.
7. Press **Test** quit the testing.
8. Press RESET button to move the clamp back to its original position.



Figure 21

CAUTION! WHEN TURN THE NEEDLE UPWARDS **Needle MUST TURN BLACK IN ORDER TO MOVE THE CLAMP.**

NOTE!! ● JU HAVE 6 POSITIONS ● JR HAVE 5 POSITIONS ● JL HAVE 5 POSITIONS.
S JL,SJR,SUL AND SUR UNABLE TO TEST. USE JL,JR AND JU INSTEAD IT.



Pict. 6

7.4 REWIND WITH BOBBIN. Press **Bobbin**

1. Press **PAUSE** Button.
 2. Press **START** to start rewind the thread
- (See Figure 22)

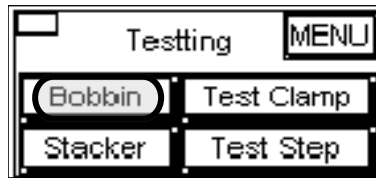


Figure 18

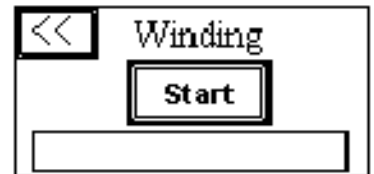
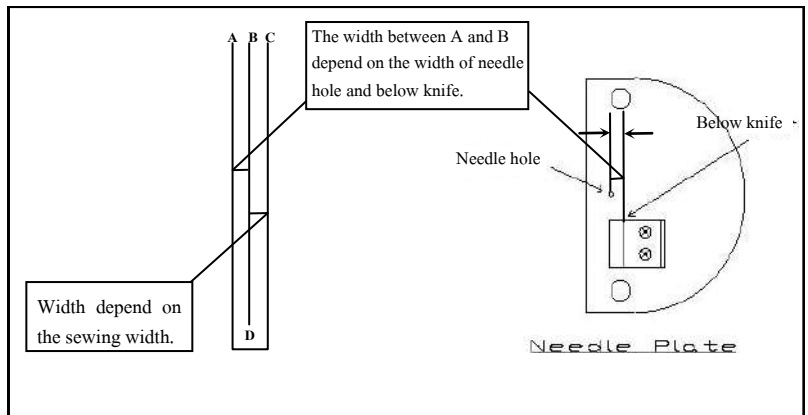


Figure 22

8. KNIFE SETTING FOR CUTTING CLOTH. (Width of cutting cloth)

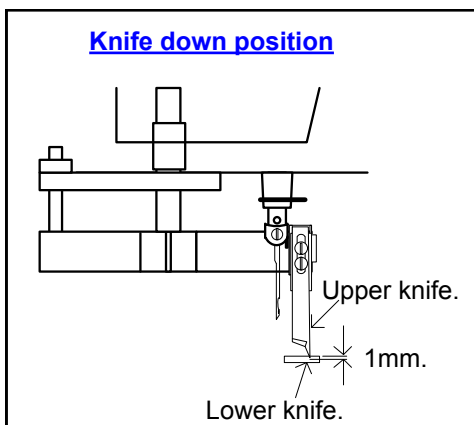
8.1 SETTING THE WIDTH OF CUTTING.

Machine will start stitching from C to A and the knife will cut from D to B, If you want the width of cutting to be A from B which is 3 mm. You have to adjust the below knife to separate from the needle hole 3 mm.(See Pict.7) And the width from B to C will have to adjust the width of the stitching shape. (See item 5,Figure 10 page 3 and item 5.1 page 4)

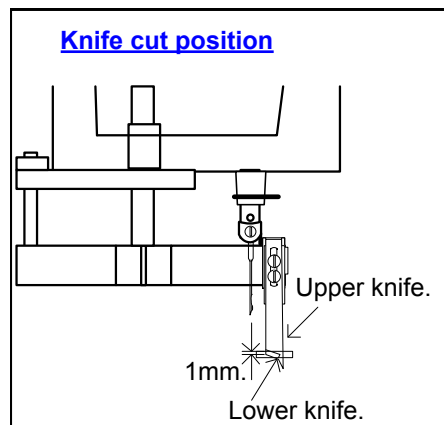


Pict. 7

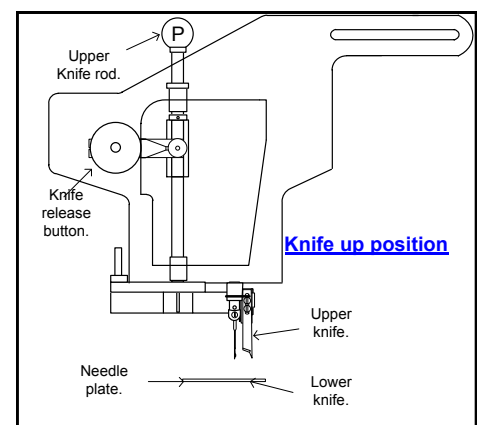
8.2 KNIFE SETTING.



Pict.8



Pict.9



Pict.10

When adjust the below knife to the width wanted press “P” (see Pict. 10) to move the upper knife downwards, then adjust the tip of upper knife to be lower than top of the lower knife about 1-1.5 mm. (see Pict.8) then move the upper knife downwards and level the sharp edge of the upper knife to be lower than the lower knife about 1 mm. (see Pict.9) then adjust the screw tight, adjust upper knife to be close to lower knife and try using the upper knife to cut the cloth.

CAUTION!! FOR SAFETY PLEASE PRESS PAUSE OR SWITCH OFF BEFORE ADJUSTING THE KNIFE.

9. INSTRUCTION FOR CENTER PLACKET.

◇ Press & hold **Hidden** to go to center placket menu.(See Figure 23)

◇ Power turn OFF then turn ON

Press **Center** and **Next** (See Figure 24) Message will appear warning to increase the width of clamp (See Figure 25) then press **Yes** to confirm (See Figure 26)

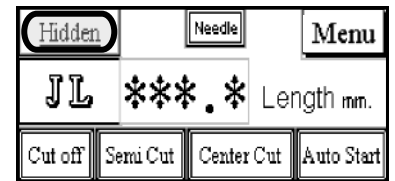


Figure 23

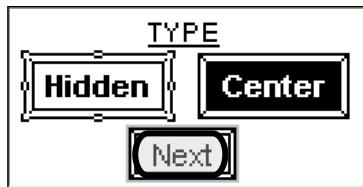


Figure 24

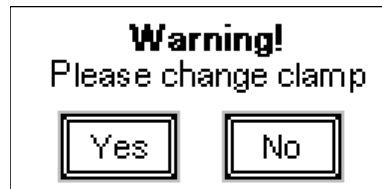


Figure 25

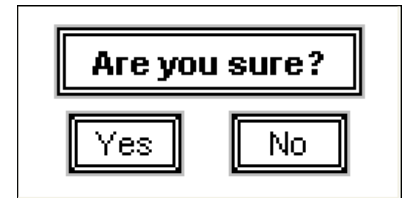


Figure 26

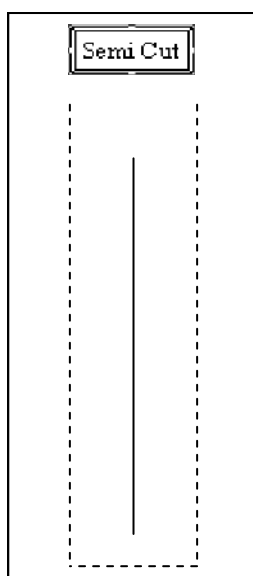
CAUTION !! IN ORDER TO CHANGE TO CENTER PLACKET, IF THE PREVIOUS CLAMP SETTING WAS NARROW THE WIDTH WILL NEED TO BE WIDEN AS CENTER PLACKET WOULD REQUIRES MORE SEWING SPACE TO WORK WITH. THIS WILL HELP PREVENT THE CLAMP FROM RUNNING INTO THE PRESSURE FOOT. FOR SAFETY, THE SEWING WIDTH WILL AUTOMATICALLY CHANGE TO 5 MM. SO THE OPERATOR HAVE TO CHANGE THE WIDTH EVERY TIME WHEN THE SWITCH IS TURNED ON OR CHANGE FROM HIDDEN PLACKET TO CENTER PLACKET. A WARNING MESSAGE WILL ALSO BE SHOWN ON THE SHAPE WIDTH SECTION WHEN ENTERING THE SEWING WIDTH JUST TO REMIND THE USER.

9.1 LENGTH SETTING. Press *****.*** and set the length as needed

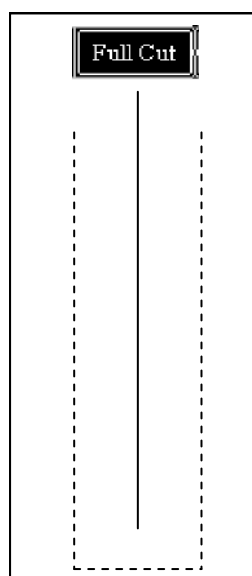
9.2 KNIFE ACTIVATION. (See Figure 27)

Semi Cut Knife cutting lower than start and end stitching. (See Pict. 27)

Full Cut Knife cutting over start and end stitching.(Complete cut)(See Pict. 27)



Pict. 11



Pict. 12

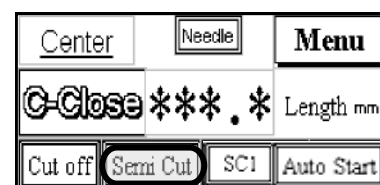


Figure 27

10. SEWING PATTERN SETTING.

10.1 CHOOSE SEWING SHAPE. Press **Shape**

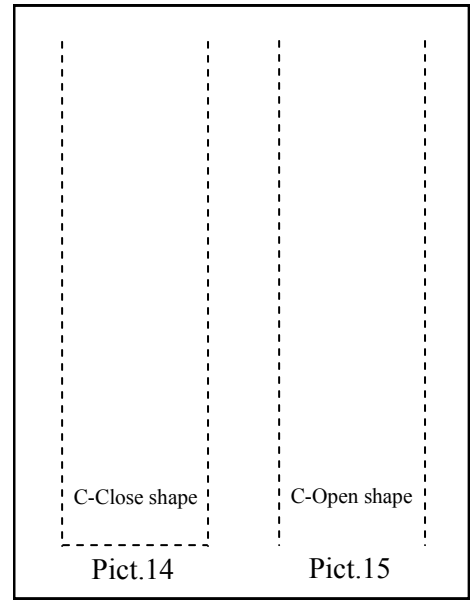
C-Close U-Shape Sewing (Please see Pict. 14)

C-Open Parallel-Lines Sewing (Please see Pict. 15)

Count	MENU	Menu
Type	Shape	Setting
Thread	Test	Tech

MENU	C-OPEN	
U	U	V
SUL	2U	SUR

Figure 30

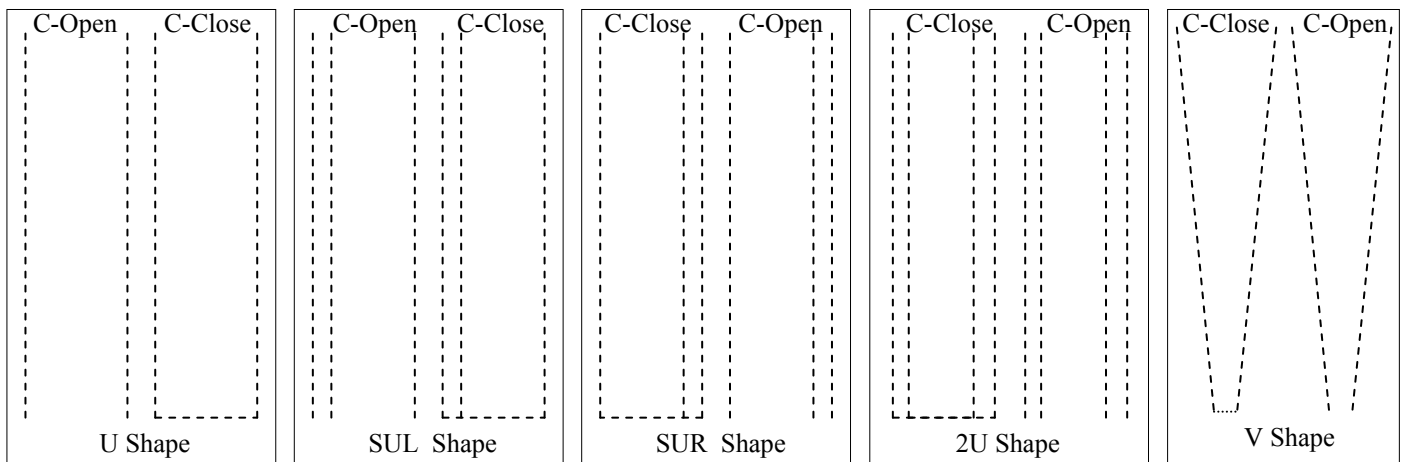


CENTER PLACKET SHAPE

Count	MENU	Home
Type	Shape	Setting
Thread	Test	Tech

MENU	C-OPEN	
U	U	V
SUL	2U	SUR

Figure 30



10.2 SETTING CENTER PLACKET SEWING SHAPE. (See pict.16,17)

Count	MENU	Home	MENU	Shape Width	
Type	Shape	Setting	Set Cut	Safety Width	
Thread	Test	Tech	STK	CND	S B T Stitch Length

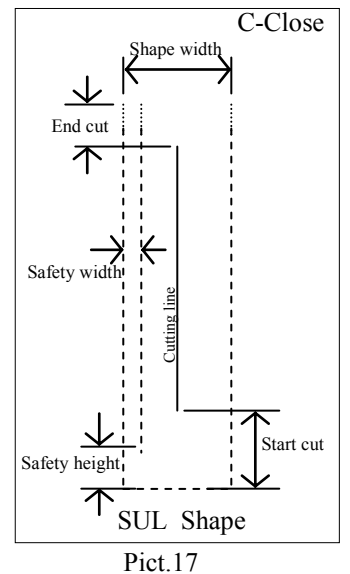
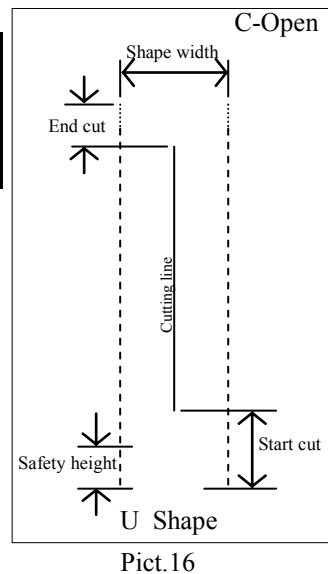
Figure 31

Back	SHAPE WIDTH
Shape Width	***. * mm
Bottom Width	***. * mm

Figure 31.1

Back	SAFETY WIDTH
Safety Width	***. * mm
Safety Height	***. * mm

Figure 31.2



11. CUTTING POSITION SETTING.

11.1 Setting from Home page. Press **SC1** (See Figure 28)

Cutting Speed > Set the speed of clamp while cutting. Activate on SC2 and DC2 only.

SC 1 > Knife cutting once along stitching. Adjust the cutting distance by adjusting the upper-lower knives (See item 8.1, Pict.7 page 7)

SC 2 > Knife cutting once after sewing ends. Adjust the cutting distance by using program. (Please see Pict.13,14 Figure 30)

DC 1 > Twice Knife Cutting.

1st time: (Left side) Knife cutting along stitching. Adjust the cutting distance by adjusting the upper-lower knives.

2nd. time: (Right) Knife cutting after sewing ends. Adjust the cutting distance by using program. (See Pict.13,14 Figure 30.1)

DC 2 > Knife cutting twice after sewing ends which cuts the right side first then the left side on the second time. Adjust the cutting distance by using programs (See Pict.13,14 Figure 30.1)

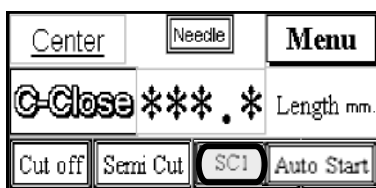


Figure 28

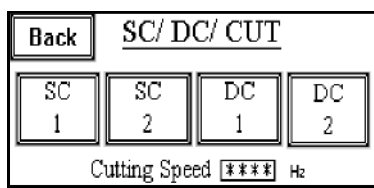


Figure 29

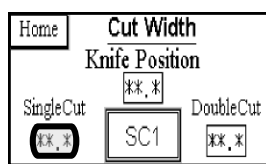


Figure 30

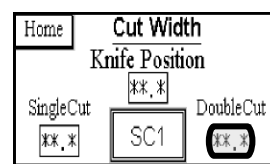
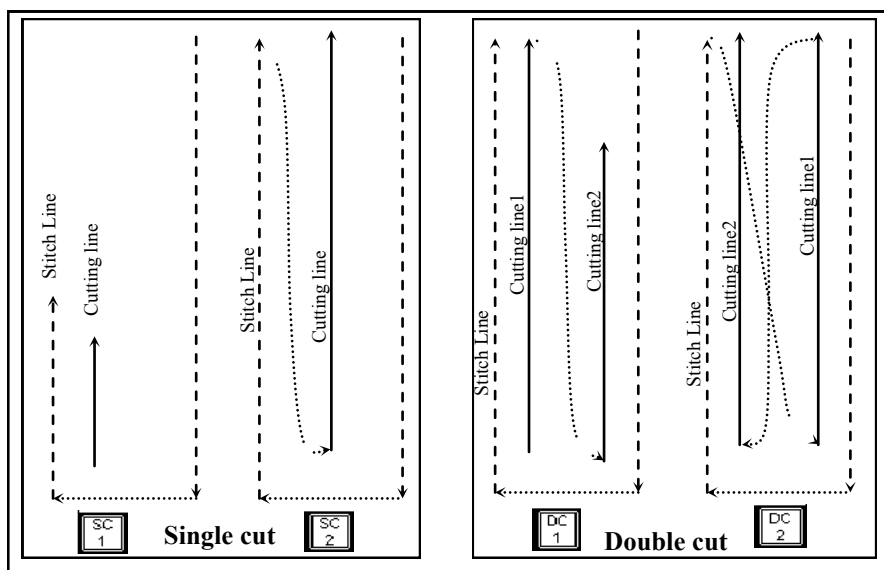
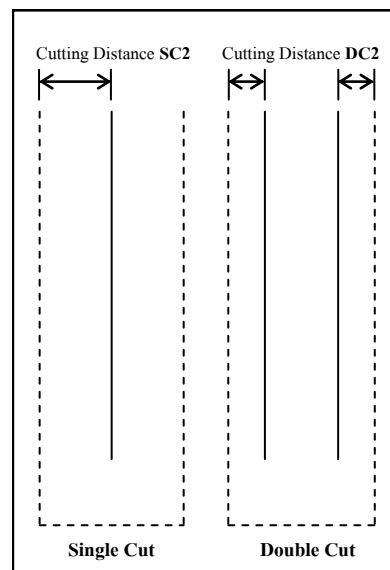


Figure 30.1



Pict.13



Pict.14

11.2 Setting from menu setting. Press **Setting** (See Figure 31,32,33)

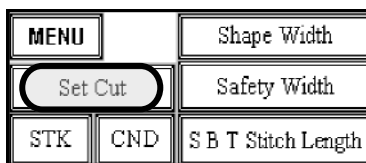


Figure 31

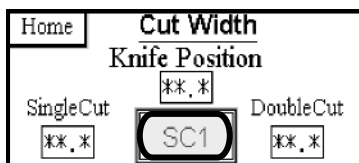


Figure 32

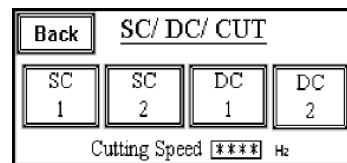


Figure 33

KNIFE POSITION have to be the same as the distance between needle hole and lower knife. (See item 8.1 pict.7 page 7.)

SINGLE CUT Setting would only need to be done once after the sewing ends. (Activate on "SC2" only See Pict.13,14)

DOUBLE CUT Setting the distance of the knife to stitching line.(Only 2nd time for "DC1" and 2 times for "DC2" see Pict.13,14)

CAUTION KNIFE POSITION have to be the same as the distance between needle hole and lower knife otherwise the cutting distance will not match.

12. TECHNICAL SETTING.

**** This section is only applicable for skilled technician with training which a pass code is required****

Press **Tech** to enter Technician Setting mode (Please see Figure 34)

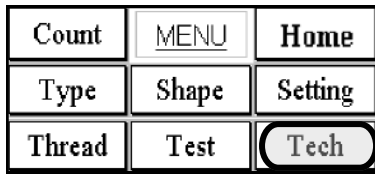


Figure 34

Input pass code then press **DONE** to activate Technical Setting mode (Please see Figure 36)



Figure 35

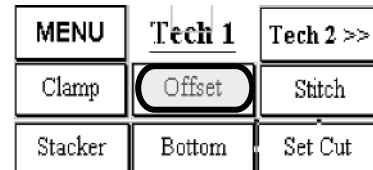


Figure 36

12.1 OFFSET SETTING. Press **Offset**

When the length sewed is not the same as the amount set, press numbers.

And adjust the amount as required. (Please see Figure 37)

Offset JL Shows sewing pattern that needs an Offset Setting. (Figure 37).

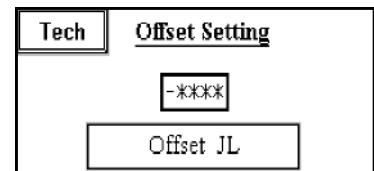


Figure 37

12.2 CLAMP SETTING. Press **Clamp** (Please see Figure 38)

- **Start point >>** Distance from original position to the starting sewing position.

Delay ** 0.01ms** >> Set to delay action.

Clamp Up >> Press to select other mode for setting.

- **Clamp up >>** To delay the time before the clamp move upwards.
- **Clamp down >>** To delay the time before the clamp move downwards.
- **Move back >>** To delay the time before the clamp move backward.
- **Move forward >>** To delay the time before the clamp move forward.
- **Sewing point >>** To delay the time before the clamp move forward and start sewing.
- **Sewing start >>** To delay the time before the clamp start sewing.
- **Move to SF >>** To delay the time before the clamp moves to the center.
- **Stacker point >>** To delay the time before the clamp moves to stacker point.
- **Auto start >>** To delay the time after pressing pedal. (used for automatic system only)

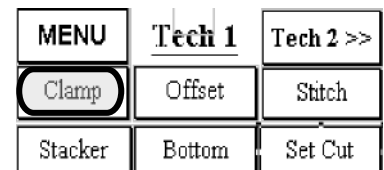


Figure 36

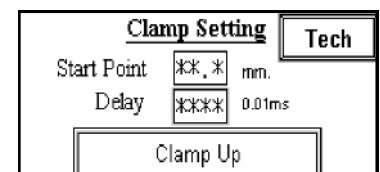
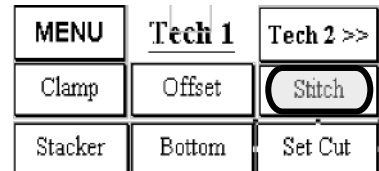


Figure 38

12.3 SPEED STITCH SETTING. Press **Stitch** (See Figure 39)

Stitch 2.0 mm Press to select the stitch length that needs adjusting.

Speed ** Hz** Press to adjust the speed.



12.4 STACKER TIMING SETTING. Press **Stacker** (See Figure 40)

Delay **** Press to set the timing of the stacker.

- **Start clamp >>** Set delay time before stacker move in.
- **Move forward >>** Set delay time before stacker move out.

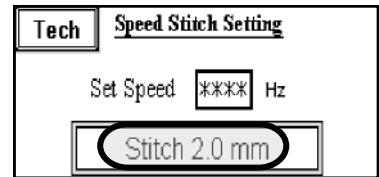


Figure 39

12.5 KNIFE TIMING SETTING. Press **Set Cut** (See Figure 41)

Knife Cut ON Press to select other mode.

- **Knife cut on >>** Set delay time before knife cutting fabric.
- **Knife cut off >>** Set delay time before knife lifts up.
- **Start thread cut >>** Set delay time before cutting the thread.
- **Thread cut hold >>** Set delay cutting time before moving back.
- **Thread cut end >>** Set delay time after cutting is finished.
- **Sensor S2 on >>** Set delay time after thread break.

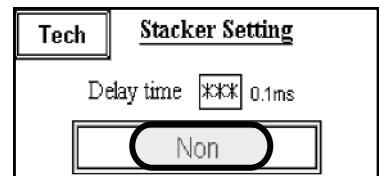


Figure 40

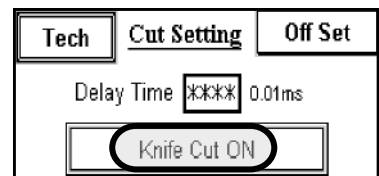


Figure 41

12.6 KNIFE OFFSET SETTING. Press **Off Set** (See Figure 42)

CUT HEIGHT CENTER >> Set cutting position for Center Placket program. (See Figure 18)

CENTER KNIFE HIDDEN >> Set center position cutting for Hidden Placket (Please see Figure 19)

*(This function will work when selecting center cutting by pressing **Cent** (Please see 1.2 ,Fig3 Page 2)*

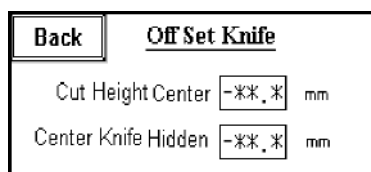
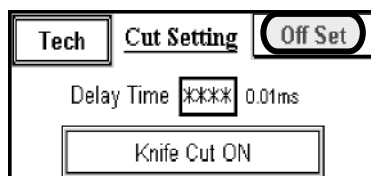
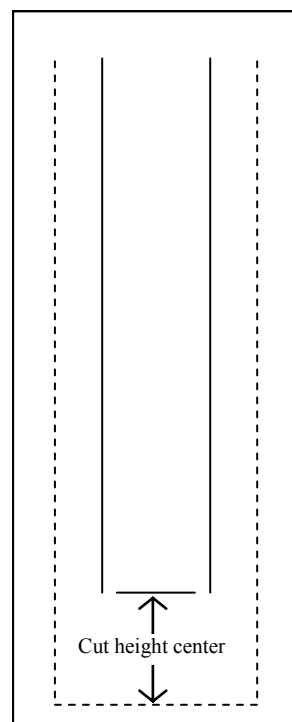
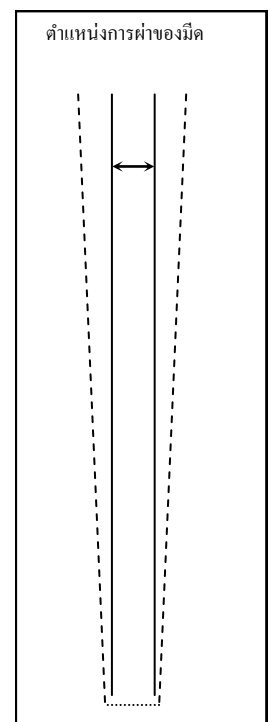


Figure 42



Pict.18



Pict.19

Press **Tech2** to enter to Tech 2 page.

12.7 OUTPUT SIGNAL TESTING. Press **Output** (See Fig.43)

Clamp Up Press to select other function for testing.

Test Press and hold to test OUTPUT SIGNAL (See Fig. 44)

- **Clamp up** >> Lift the clamp upwards.
- **Clamp down** >> The clamp press downwards.
- **Cut on** >> Upper Knife move down.
- **Cut off** >> Release upper knife.
- **Sewing** >> Sewing Start.
- **Thread** >> Testing thread trimmer.
- **None** >> ไฟมาร์คตำแหน่งเข็ญ
- **Pause lamp** >> Pause lamp.
- **None** >> ไฟมาร์คโต๊ะเตรียม
- **Stacker swing arm** >> Stacker swing arm solenoid.
- **Stacker clamp** >> Stacker clamp solenoid.
- **Pressure foot** >> Pressure foot solenoid.
- **Blow thread** >> Air blow pump.

12.8 INPUT SIGNAL SETTING. Press **Input** (See Figure 43,45)

Use to check the signal of INPUT SENSOR and other switches.

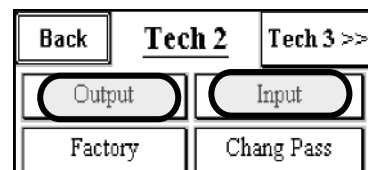
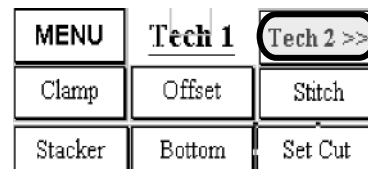


Figure 43

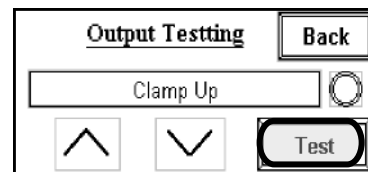


Figure 44

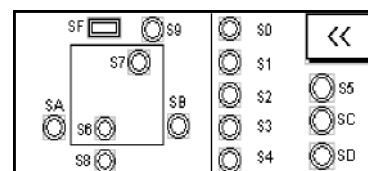


Figure 45

INPUT LIST

- S0** Synchronizer.
- S1** Foot sw. (ST1)
- S2** Thread break sensor.
- S3** Foot sw. (PF2)
- S4** Clamp up sensor. (NO)
- S5** Clamp down sensor. (NO)
- S6** Forward delay sensor.
- S7** Backward delay sensor.
- S8** Forward end sensor. (NC)
- S9** Backward end sensor. (NC)
- SA** Pressure foot sensor (NO)
- SB** Limit sensor (Right side) (NC)
- SC** Reset sw.
- SD** Pause sw.
- SF** Center position sensor.
- SW.3** Limit sw. Stacker.

OUTPUT LIST

- Y0** Carriage clamp move forward. (X-CW.)
- Y1** Carriage clamp move backward. (X-CCW.)
- Y2** Pressure foot Solenoid.
- Y3** Carriage clamp move left. (Y-CW.)
- Y4** Carriage clamp move right. (Y-CCW.)
- Y5** Air compressor relay.
- Y6** Clamp up relay.
- Y7** Clamp down relay.
- Y8** Upper knife move down.
- Y9** Release upper knife.
- YA** Sewing control.
- YB** Thread trimmer.
- YC** Pause lamp.
- YD** ไฟมาร์ค ตำแหน่งเข็ญ
- YE** Cutting motor.
- YF** ไฟมาร์ค โต๊ะเตรียม
- Y1** Stacker move out.(PFO-E16T)
- Y2** Stacker move in.(PFO-E16T)

12.9 RESET ALL DATA TO FACTORY SETTING.

Factory Press and hold go back to the original setting. (See Figure 46)

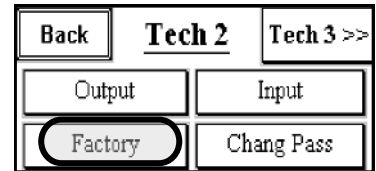


Figure 46

12.10 SET WORKING LENGTH OF THE CLAMP. Press **Tech3** (See Figure 47)

- **Back point >>** Set the distance of carriage clamp moving.
- **Stacker point >>** Set the stopping point of the clamp while stacker activate.

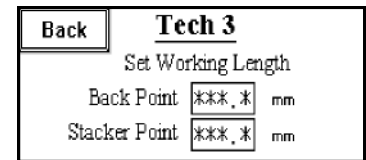
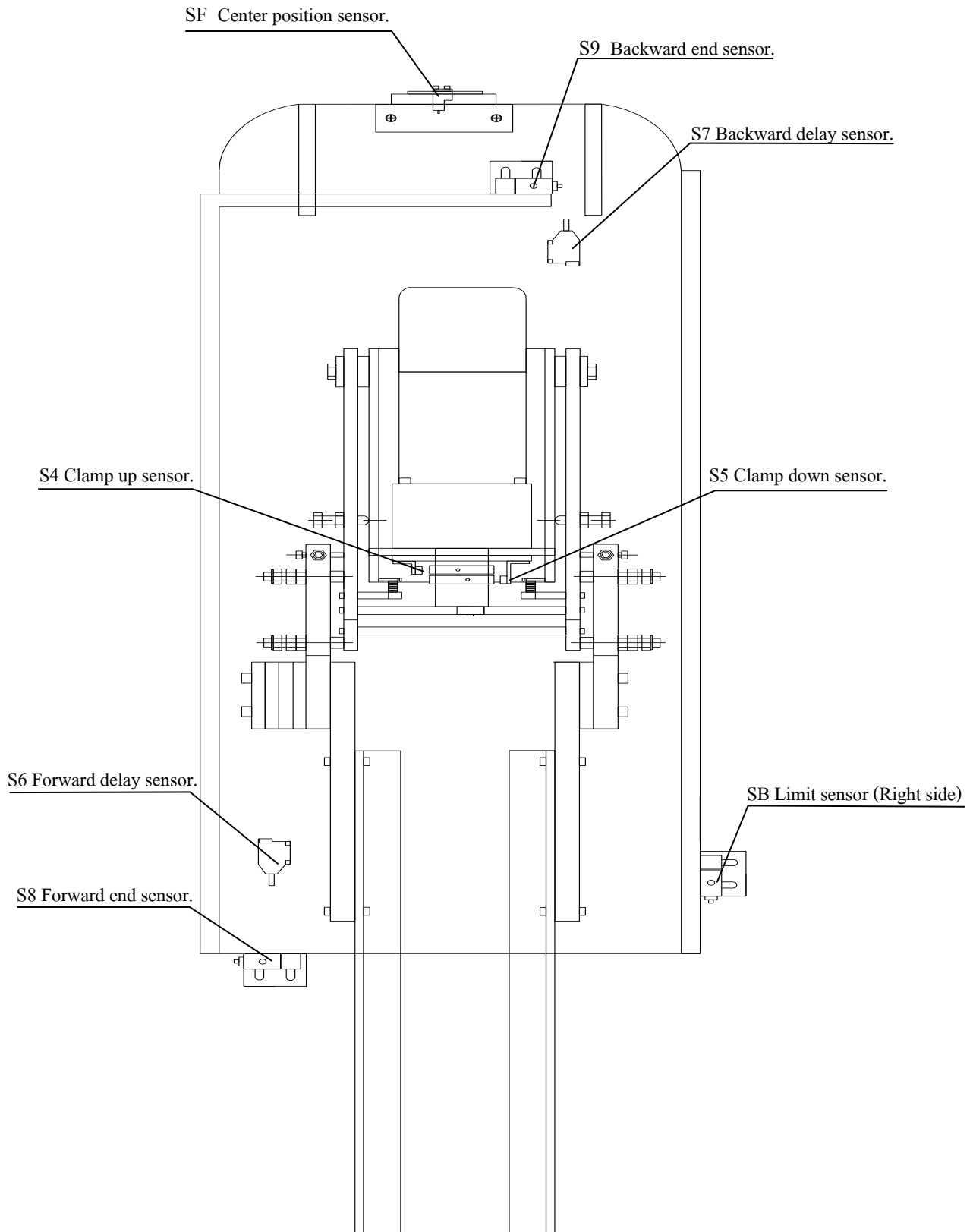


Figure 47

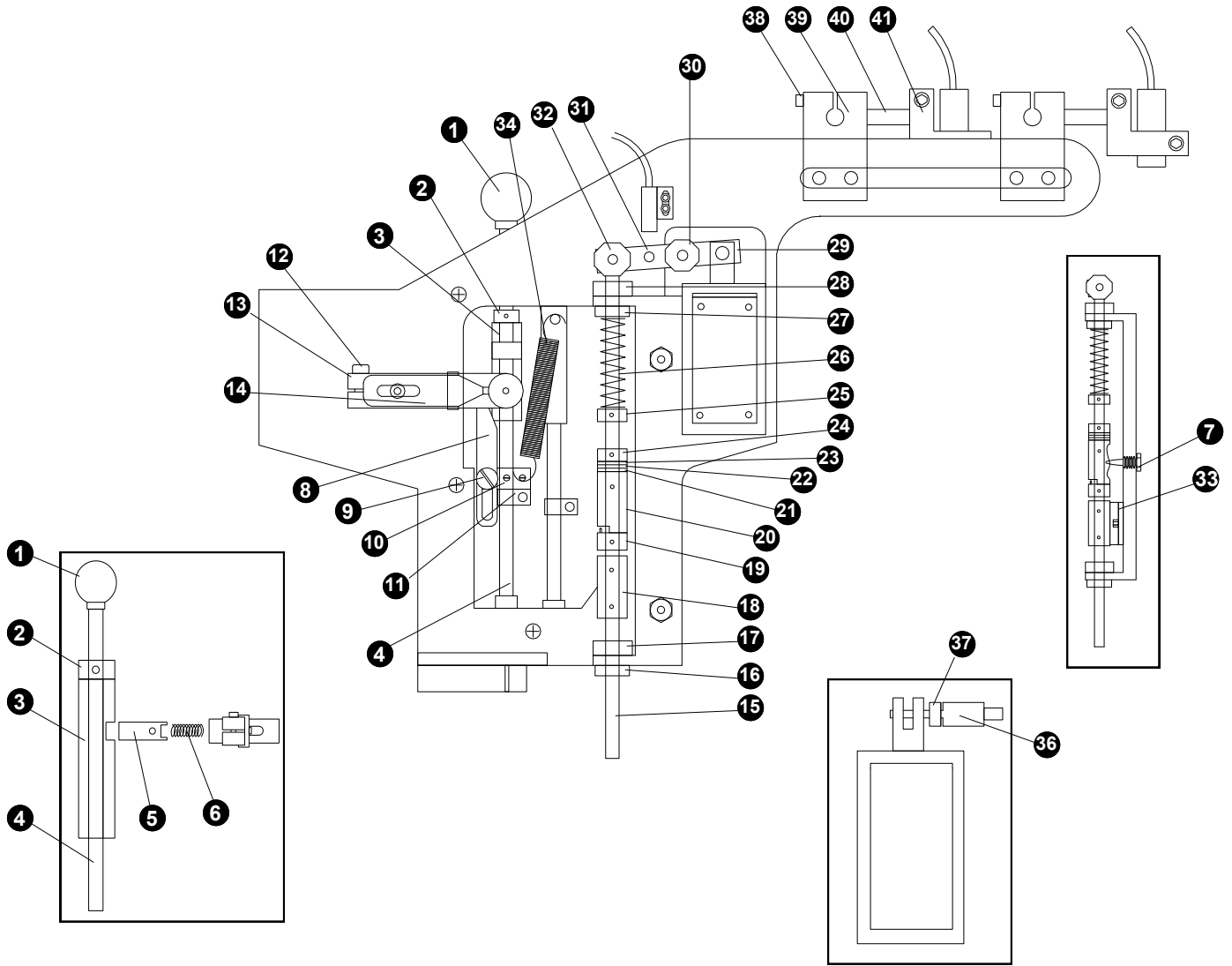
13. ERROR CODE.

ERROR MESSAGE	PROBLEM	SOLUTION
Error Needle Down	Needle stops in a wrong spot	• Move the needle to the needle up position.
Error Sensor S4	S4 sensor is not working when the clamp is being lift up.	• Clean S4 sensor then check the connector and input signal.
Error sensor S5	S5 sensor is not working when clamp is being pushed down.	• Clean S5 sensor then check connector and input signal.
Error sensor S8,S6	<ul style="list-style-type: none"> • S6 sensor is not working. (Press RESET, clamp will move forward and stop) • S8 sensor is not working. (Press RESET, clamp will not move) 	<ul style="list-style-type: none"> • Clean S6 sensor then check the connector and input signal. • Clean S8 sensor then check the connector and input signal.
Error sensor S9,S7	<ul style="list-style-type: none"> • S7 sensor is not working. (Press RESET, clamp will move backward and stop) • S9 sensor is not working. (Press RESET, clamp does not move) 	<ul style="list-style-type: none"> • Clean S7 sensor then check the connector and input signal. • Clean S9 sensor then check the connector and input signal.
Error sensor SB	While Pressing Reset, clamp will move to the right but sensor SB is not working.	• Clean SB sensor ,Check Connector and input signal.
Error sensor SF >>Reset	After sewing finished, clamp will move to the left and sensor SF is not working.	Press Error button on the screen and press RESET, to clean the sensor, plate gap, clamp rod. Then check gear belt.
Error sensor position >>Reset	Clamp is in a wrong position.	Press pause button then press Error message on the screen then press reset button.

POSITION OF SENSORS



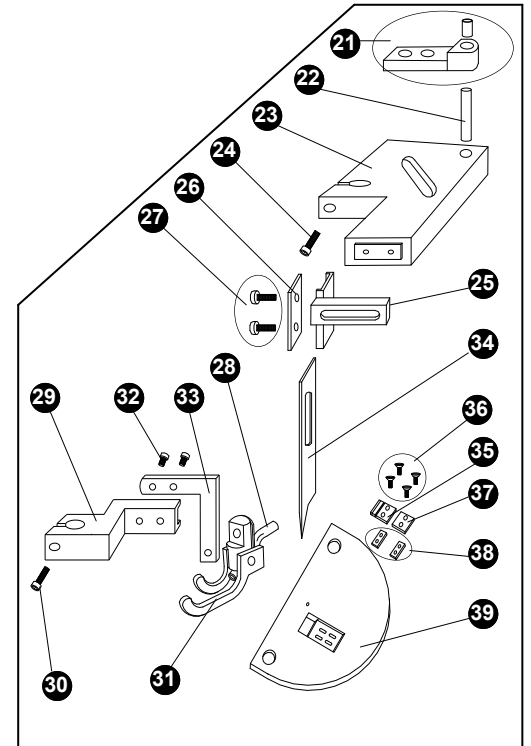
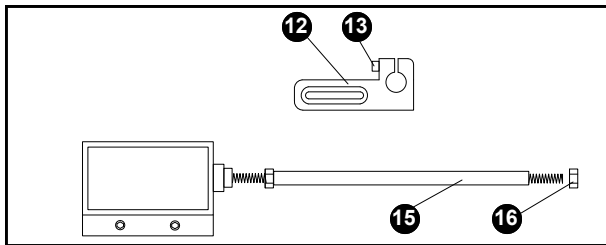
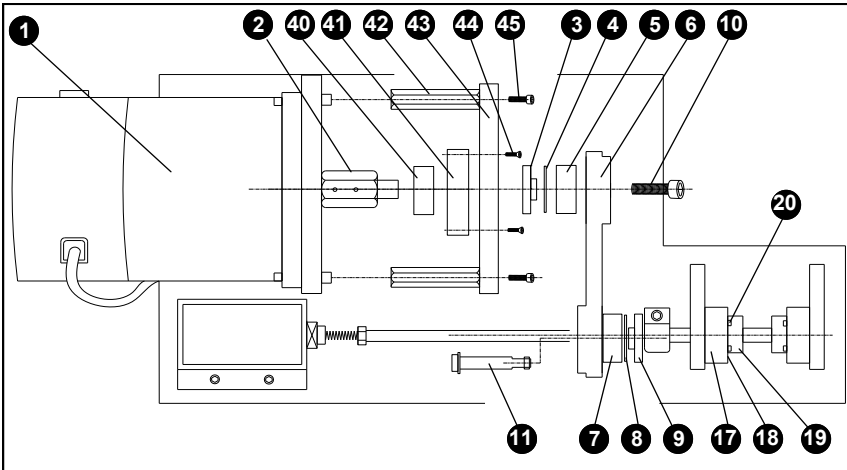
FACE PLATE (FP.)



No.	Part No.	Part Name	Qty.
1	PL55FP0001	Knife pressing Knob	1
2	PL55FP0002	Bushing	1
3	PL55FP0003	Clutch pin bushing	1
4	PL55FP0004	Pressure foot bar	1
5	PL55FP0005	Knife driving rod clutch pin	1
6	PL55FP0006	Spring	1
7	PL55FP0007	Bolt	1
8	PL55FP0008	Knife pusher	1
9	PL55FP0009	Screw	1
10	PL55FP0010	Knife bar guide bracket	1
11	PL55FP0011	Knife Bar guide bracket	1
12	PL55FP0012610	Screw	1
13	PL55FP0013	Knife drive clutch retainer	1
14	PL55FP0014	Release arm rod	1
15	PL55FP0015	Cutting knife bar	1
16	PL55FP0016	Bushing	1
17	PL55FP0017	Bushing	1
18	PL55FP0018	Joint	1
19	PL55FP0019	Cam guide	1
20	PL55FP0020	Cam	1
21	PL55FP0021	Washer	1

No.	Part No.	Part Name	Qty.
22	PL55FP0022	Bearing	1
23	PL55FP0023	Washer	1
24	PL55FP0024	Bushing	1
25	PL55FP0025	Bushing	1
26	PL55FP0026	Spring	1
27	PL55FP0027	Bushing	1
28	PL55FP0028	bushing	1
29	PL55FP0029	Pressure foot press link	1
30	PL55FP0030	Screw	1
31	PL55FP0031	Magnet	1
32	PL55FP0032	Knife rod joint	1
33	PL55FP0033	Screw	1
34	PL55FP0034	Spring	1
35			
36	PL55FP0036	Knife pushing rod	1
37	PL55FP0037	Roller	1
38	PL55FP0038601	Screw	1
39	PL55FP0039	Marking light support	2
40	PL55FP0040	Marking light arm	2
41	PL55FP0041	Marking light holder	2

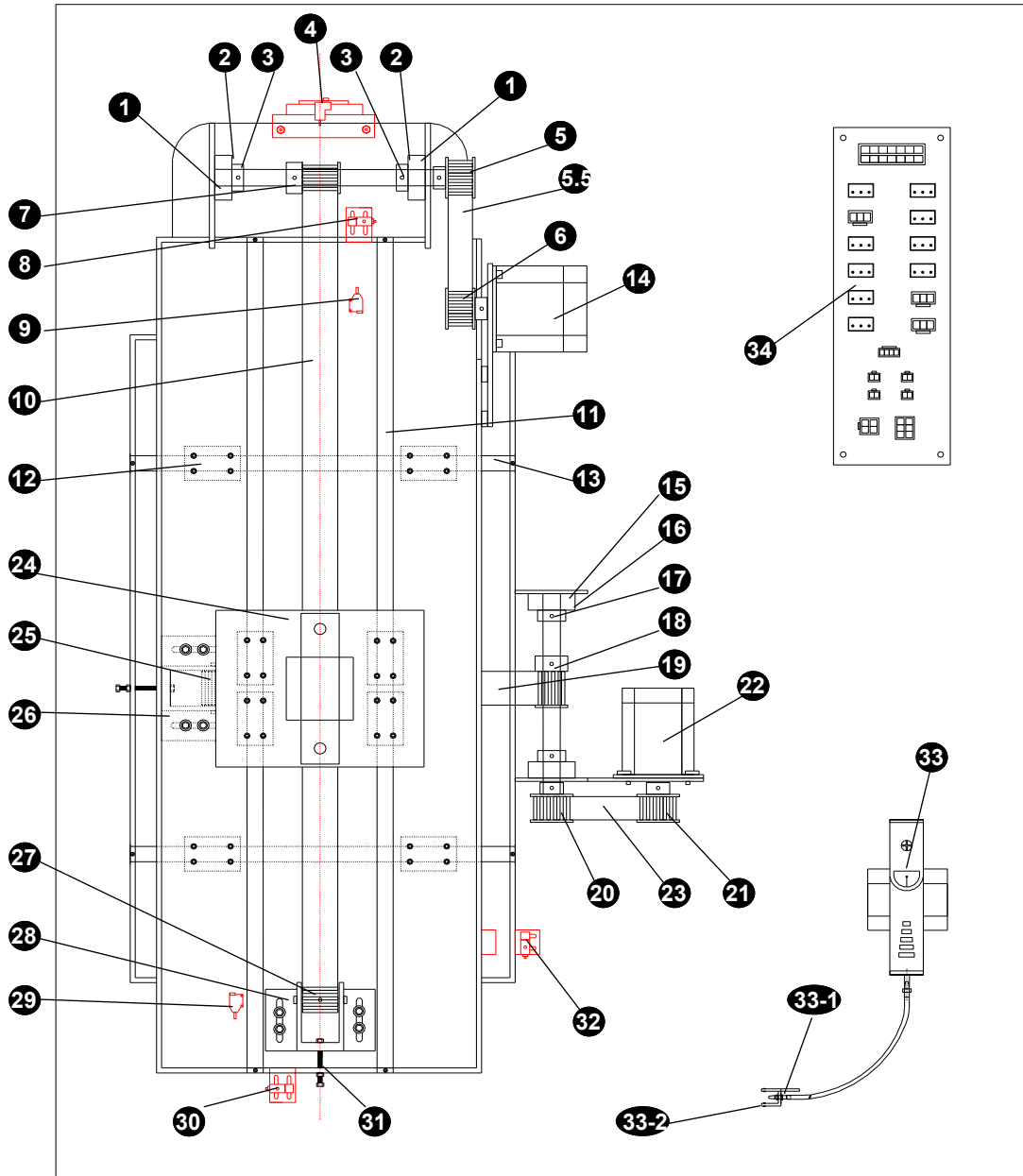
CUTTING MECHANISM COMPONENTS (CMC.)



No.	Part No.	Part Name	Qty.
1	PL55CMC001	Motor	1
2	PL55CMC002	Joint	1
3	PL55CMC003	Retainer	1
4	PL55CMC004	Ring	1
5	PL55CMC005	Bearing	1
6	PL55CMC006	Crank rod	1
7	PL55CMC005	Bearing	1
8	PL55CMC004	Ring	1
9	PL55CMC003	Retainer	1
10	PL55CMC010610	Screw	1
11	PL55CMC011	Screw	1
12	PL55CMC012	Lifting rock shaft crank	1
13	PL55CMC013610	Screw	1
14			
15	PL55CMC015	Screw	1
16	PL55CMC016	Nut	1
17	PL55CMC017	Collar bearing	1
18	PL55CMC018	Bearing	1
19	PL55CMC019	Bushing	1
20	PL55CMC020508	Screw	1
21	PL55CMC021	Knife driving block	1
22	PL55CMC022	Stud	1

No.	Part No.	Part Name	Qty.
23	PL55CMC023	Knife driving base	1
24	PL55CMC024610	Screw	1
25	PL55CMC025	Knife holder	1
26	PL55CMC026	Washer	1
27	PL55CMC027	Screw	1
28	PL55CMC028	Air tube	1
29	PL55CMC029	Pressure foot support	1
30	PL55CMC030610	Screw	1
31	PL55CMC031	Pressure foot	1
32	PL55CMC032407	Screw	2
33	PL55CMC033	Pressure foot holder	1
34	PL55CMC034	Upper knife	1
35	PL55CMC035	Lower knife	1
36	PL55CMC036	Lower knife screw	4
37	PL55CMC037	Lower knife support	1
38	PL55CMC038	Nut	1
39	PL55CMC039	Needle plate	1
40	PL55CMC040	Bearing	1
41	PL55CMC041	Bearing seat	1
42	PL55CMC042	Bolt	4
43	PL55CMC043	Plate	1
44	PL55CMC044	Screw	4
45	PL55CMC045	Screw	4

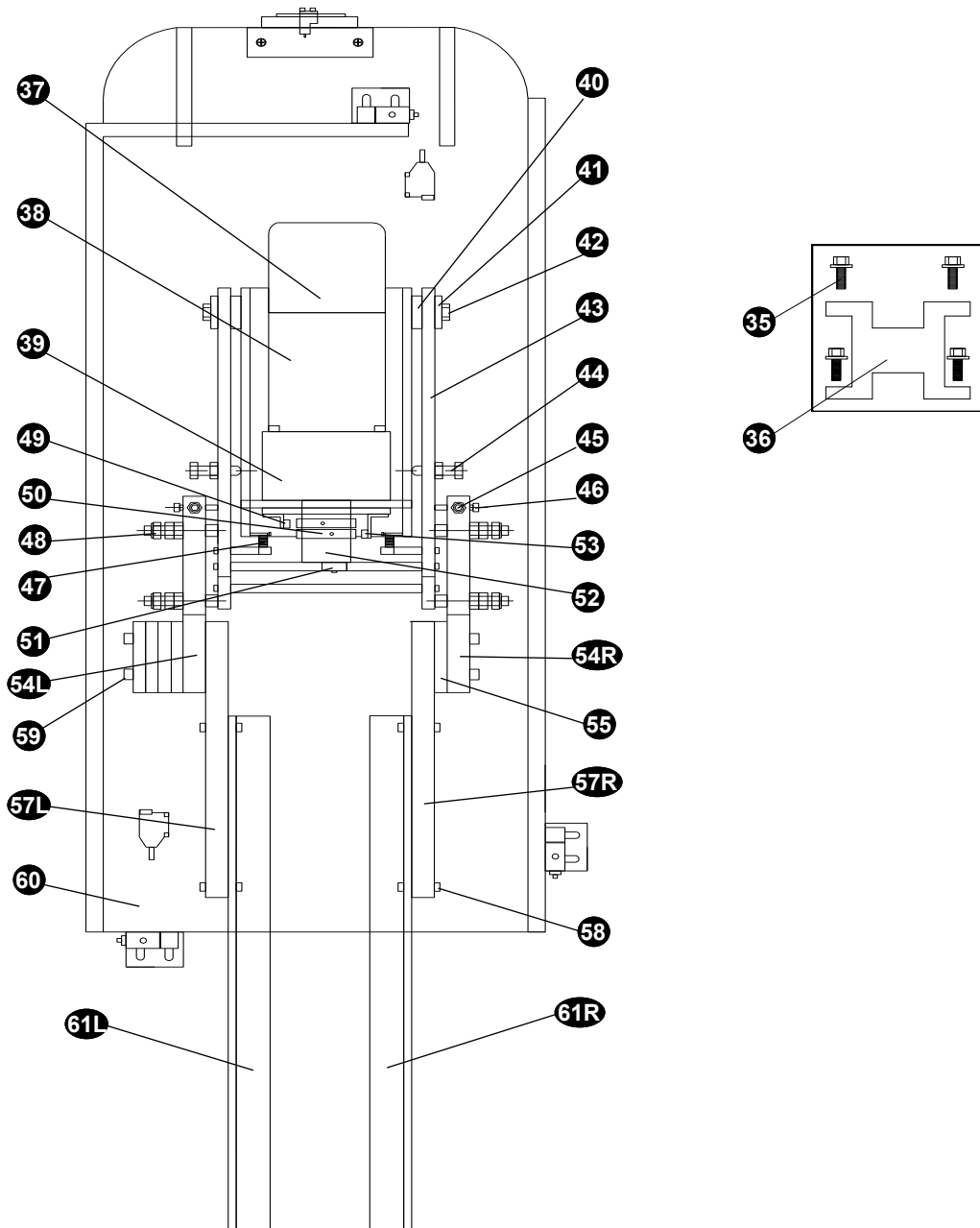
CARRIAGE CLAMP (CRC.)



No.	Part No.	Description	Qty.
1	PL55CRC001	Bearing case	2
2	PL55CRC002	Bearing	2
3	PL55CRC003	Bushing	2
4	PL55CRC004	Sensor	1
5	PL55CRC005	Cogwheel	1
5-5	PL55CRC005-5	Belt	1
6	PL55CRC006	Cogwheel	1
7	PL55CRC007	Cogwheel	1
8	PL55CRC008	Sensor	1
9	PL55CRC009	Sensor	1
10	PL55CRC010	Belt	1
11	PL55CRC011	Shaft	2
12	PL55CRC012	Baring	1
13	PL55CRC013	Shaft	1
14	PL55CRC014	Stepping motor	1
15	PL55CRC015	Bearing case	2
16	PL55CRC016	Bearing	2
17	PL55CRC017	Bushing	1
18	PL55CRC018	Cogwheel	1

No.	Part No.	Description	Qty.
19	PL55CRC019	Belt	1
20	PL55CRC020	Cogwheel	1
21	PL55CRC021	Cogwheel	1
22	PL55CRC022	Motor	1
23	PL55CRC023	Belt	1
24	PL55CRC024	Clamp Base	1
25	PL55CRC025	Cogwheel Y	1
26	PL55CRC026	Cogwheel support Y	1
27	PL55CRC027	Cogwheel X	1
28	PL55CRC028	Cogwheel support X	1
29	PL55CRC029	Sensor	1
30	PL55CRC030	Sensor	1
31	PL55CRC031	Belt adjust screw	1
32	PL55CRC032	Sensor	1
33	PL55CRC033	Thread sensor adjustor	1
33-1	PL55CRC033-1	Thread break sensor	1
33-2	PL55CRC033-2	Thread guide	1
34	PL55CRC034	Board connector	1

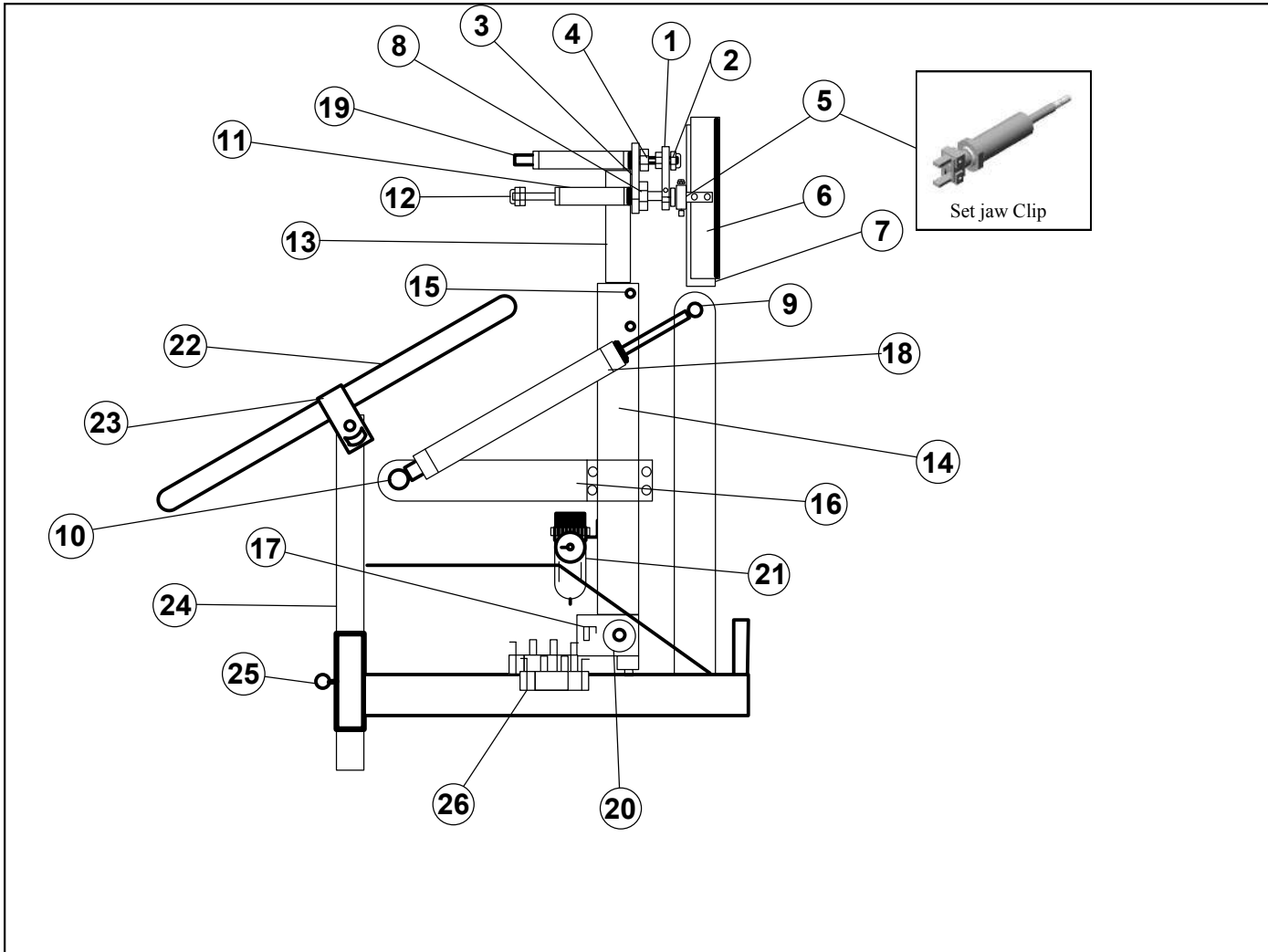
CARRIAGE CLAMP (CRC.)



No.	Part No.	Description	Qty.
35	PL55CRC035	Screw	1
36	PL55CRC036	Clamp seat	1
37	PL55CRC037	Breaking coil	1
38	PL55CRC038	Motor	1
39	PL55CRC039	Gear box	1
40	PL55CRC040	Bearing	1
41	PL55CRC041	Washer	2
42	PL55CRC042	Screw	2
43	PL55CRC043	Arm	2
44	PL55CRC044	Screw	2
45	PL55CRC045	Screw	2
46	PL55CRC046	Screw	2
47	PL55CRC047	Spring	2
48	PL55CRC048	Clamp adjusting screw	4

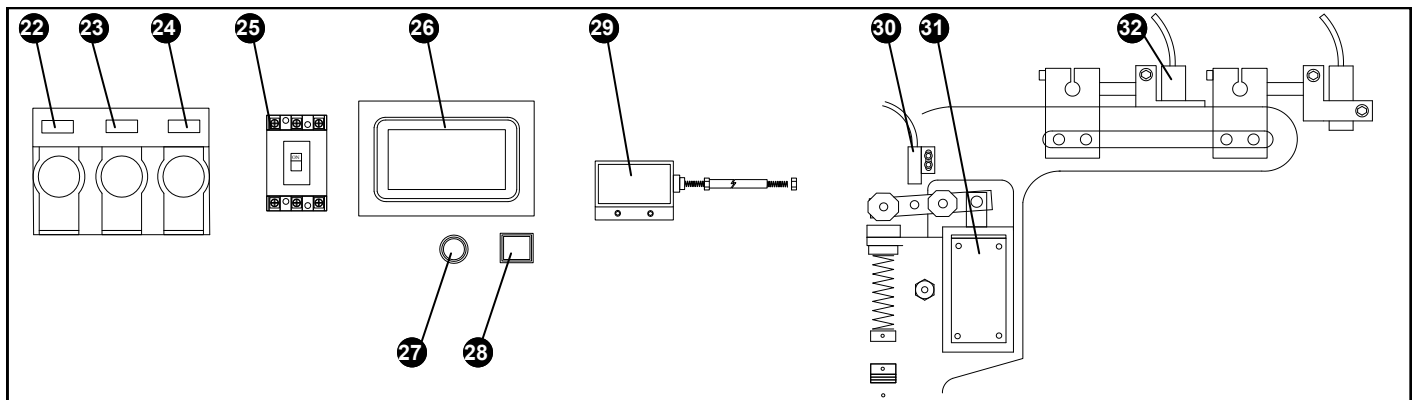
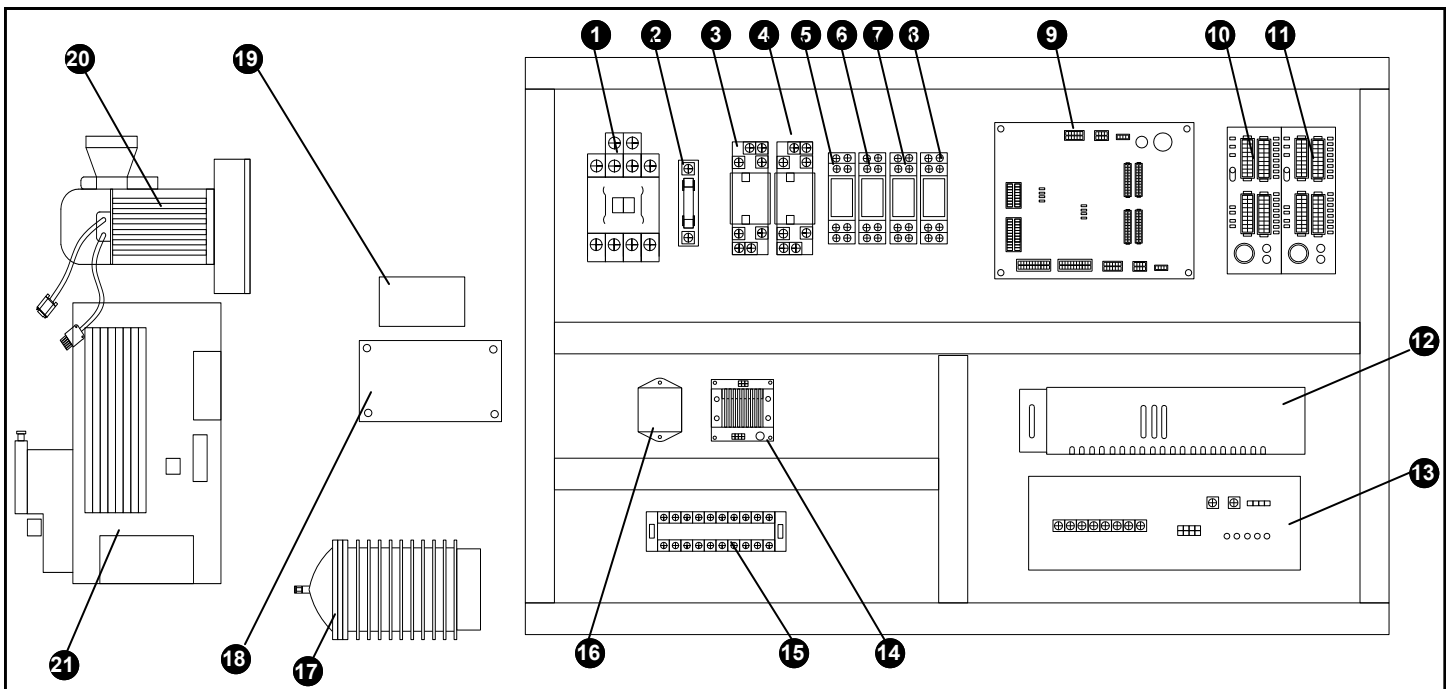
No.	Part No.	Description	Qty.
49	PL55CRC049	Sensor	1
50	PL55CRC050	Cam	2
51	PL55CRC051	Bearing	1
52	PL55CRC052	Bush	1
53	PL55CRC053	Sensor	1
54L	PL55CRC054L	L-Clamp support	1
54R	PL55CRC054R	R-Clamp support	1
55	PL55CRC055	Spacer	2
57L	PL55CRC057L	L-Clamp holder	1
57R	PL55CRC057R	R-Clamp holder	1
58	PL55CRC058	Screw	4
59	PL55CRC059	Screw	4
60	PL55CRC060	Tray	1
61L	PL55CRC061L	L-Carriage clamp	1
61R	PL55CRC061R	R-Carriage clamp	1

STACKER (STK)



No.	Part No.	Description	Qty.
1	PL55STK001	Jaw plate	1
2	PL55STK002	Nut Cover	1
3	PL55STK003	Lock plate	1
4	PL55STK004	Nut	1
5	PL55STK005	Set Jaw Clip	1 Set
6	PL55STK006	Upper clip	1
7	PL55STK007	Lower clip	1
8	PL55STK008	Nut Lock plate	1
9	PL55STK009	Screw	1
10	PL55STK010	Screw	1
11	PL55STK011	Jaw Cylinder	1
12	PL55STK012	Nut Cover	1
13	PL55STK013	Jaw handle	1
14	PL55STK014	Jaw handle	1
15	PL55STK015	Screw	1
16	PL55STK016	Moving arm	1
17	PL55STK017	Micro switch	1
18	PL55STK018	Cylinder	1
19	PL55STK019	Cylinder arm	1
20	PL55STK020	Cam	1
21	PL55STK021	Air regulator	1
22	PL55STK022	Stacker bar	1
23	PL55STK023	Bar holder	1
24	PL55STK024	Bar support	1
25	PL55STK025	Screw	1
26	PL55STK026	Solenoid valve	1

ELECTICALLY (ETC.)



No.	Part No.	Description	Qty.
1	PL55ETC001	Magnetic switch	1
2	PL55ETC002	Fuse	1
3	PL55ETC003	Relay	1
4	PL55ETC004	Relay	1
5	PL55ETC005	Relay	1
6	PL55ETC006	Relay	1
7	PL55ETC007	Relay	1
8	PL55ETC008	Relay	1
9	PL55ETC009	Control board	1
10	PL55ETC010	PLC.	1
11	PL55ETC011	Expansion PLC.	1
12	PL55ETC012	Power supply	1
13	PL55ETC013	Motor driver	1
14	PL55ETC014	Motor driver	1
15	PL55ETC015	Terminal	1
16	PL55ETC016	Filter	1
17	PL55ETC017	Compressor	1

No.	Part No.	Description	Qty.
18	PL55ETC018	Foot switch control board	1
19	PL55ETC019	Marking light power supply	1
20	PL55ETC020	Main motor	1
21	PL55ETC021	Control box	1
22	PL55ETC022	Foot switch (ST1)	1
23	PL55ETC023	Foot switch (PF2)	1
24	PL55ETC024	Foot switch (Auto)	1
25	PL55ETC025	Main breaker	1
26	PL55ETC026	Touch screen monitor	1
27	PL55ETC027	Pause switch	1
28	PL55ETC028	Power switch	1
29	PL55ETC029	Knife up solenoid	1
30	PL55ETC030	Sensor (SA)	1
31	PL55ETC031	Knife down solenoid	1
32	PL55ETC032	Marking light	2

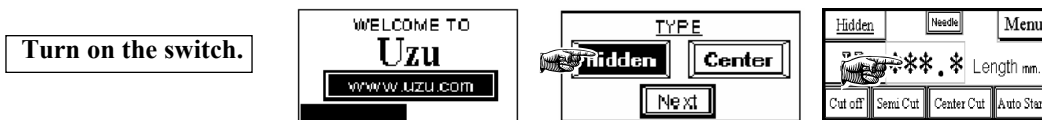
TROUBLE SHOOTING

Trouble	Position	Input	Cause	Solution
Clamp move forward then stop (Pressure foot dropdown.) - แคลมป์เคลื่อนมาข้างหน้าแล้วหยุด,ตีนคิไม่ยก	SA (NC)	XA	No signal from SA sensor. - ไม่มีสัญญาณจาก SA	Clean SA sensor, Check connection, and PLC input. - ทำความสะอาด, เช็คข้อต่อสาย เซ็นเซอร์ SA เช็ค PLC input
Clamp moves backwards slowly. - แคลมป์เคลื่อนถอยหลังช้า	S7 (NC)	X7	A signal from S7 sensor. - มีสัญญาณจาก S7	Clean S7 sensor. - ทำความสะอาด S7
Clamp move backward then stop and cannot move forward. Code “Error S7,S9” appeared. - แคลมป์ถอยหลังแล้วหยุดเคลื่อนแคลมป์ไปข้างหน้าไม่ได้, กด Reset ขึ้น Error S7,S9	S7(NC)	X7	No signal from S7 sensor. - ไม่มีสัญญาณจาก S7	Clean S7 sensor, Check connection, and PLC input. - ทำความสะอาด, เช็คข้อต่อสายเซ็นเซอร์ S7 เช็ค PLC input
Clamp moves forwards slowly. - แคลมป์เคลื่อนเดินหน้าช้า	S6(NC)	X6	Input signal from S6 sensor. - มีสัญญาณจาก S6	Clean S6 sensor. - ทำความสะอาด S6
Clamp move forward then stop and cannot move forward. Code “Error S6,S8” appeared. - แคลมป์เคลื่อนเดินหน้าแล้วหยุด แคลมป์เคลื่อนถอยหลังไม่ได้, กด Reset ขึ้น Error S6,S8	S6(NC)	X6	No signal from S6 sensor. - ไม่มีสัญญาณ S6	Clean S6, Check connection, and PLC input. - ทำความสะอาด, เช็คข้อต่อเซ็นเซอร์ S6, เช็ค PLC input
- Clamp in front position shows error S7,S9. - If clamp at S7 position is working. - Turn on SW, clamp will stop with Error S7,S9. - แคลมป์ป้อนด้านหน้าจะขึ้น Error S7,S9 - ถ้าแคลมป์ป้อนที่ตำแหน่ง S7 จะทำงานได้ปกติ - ปิด SW. แคลมป์หยุด แล้ว Error S7,S9	S9 (NC)	X9	No signal from S9 sensor. - ไม่มีสัญญาณจาก S9	Clean S9, Check connection, and PLC input. - ทำความสะอาด, เช็คข้อต่อสาย เซ็นเซอร์ S9 เช็ค PLC input
- Clamp move backward then stop with Error S6,S8. - During an operation, clamp moves backwards and stop with loud noise. - แคลมป์เคลื่อนถอยหลังแล้วหยุดขึ้น Error S6,S8 - ขณะทำงานแคลมป์เคลื่อนถอยหลังแล้วหยุดเสียงดัง	S8 (NC)	X8	No signal from S8 sensor. - ไม่มีสัญญาณจาก S8	Clean S8, Check connection, and PLC input. - ทำความสะอาด, เช็คข้อต่อสายเซ็นเซอร์ S8, เช็ค PLC input
After pressing “RESET”, clamp cannot move to the left side but can operation. - กด Reset แคลมป์ไม่เลื่อนซ้ายแต่สามารถทำงานได้ปกติ	SB (NC)	XB	No signal from SB sensor. - ไม่มีสัญญาณจาก SB	Clean SB, Check connection, and PLC input. - ทำความสะอาด, เช็คข้อต่อสาย SB เช็คสัญญาณ input
Turn switch ON, then press RESET the clamp move to the left end with loud noise then error SF appeared - เปิดเครื่อง กดReset แคลมป์เคลื่อนซ้ายสุด แล้ว - มีเสียงดัง และ Error SF	SF (NC)	XF	No signal from SF sensor. - ไม่มีสัญญาณจาก SF	Clean SF, Check connection, and Make adjustment. - ทำความสะอาด, เช็คข้อต่อสาย SF เช็คสัญญาณ input
- Power turn ON, Clamp doesn't move (Error SB) - Go to test mode> Test clamp press R-L no action. - เปิดเครื่อง แคลมป์ไม่เลื่อน (Error SB) - เข้า Test mode > Test clamp กดเลื่อนซ้าย-ขวาไม่ได้	XB		SB no signal sensor. - ไม่มีสัญญาณจาก SB	Check Y motor and motor driver connection. - เช็คข้อต่อสายมอเตอร์(Y) เลื่อนซ้าย-ขวา

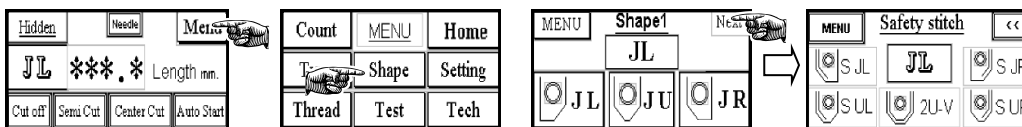
การเรียกใช้โปรแกรม // PROGRAM INSTRUCTION Model: UZ-PL55/ST-PS

HIDDEN PLACKET // โปโลสาปซ่อน,สาปหลบ

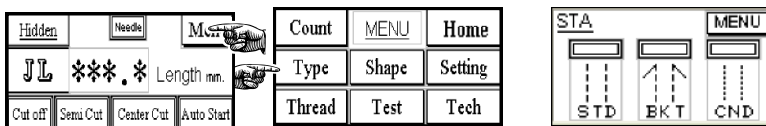
1. SEWING LENGTH SETTING // ตั้งความยาว



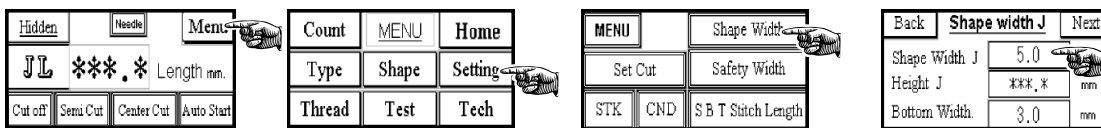
2. CHOOSE SEWING SHAPE // เลือกรูปแบบการเย็บ



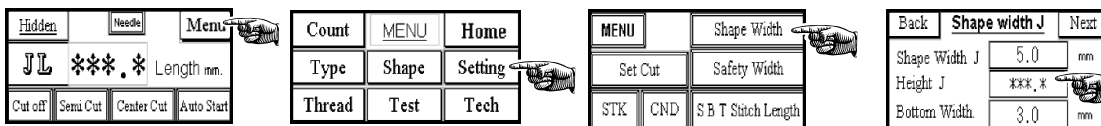
3. CHOOSE START AND END STITCH // เลือกแบบการเย็บ เริ่ม-จบ



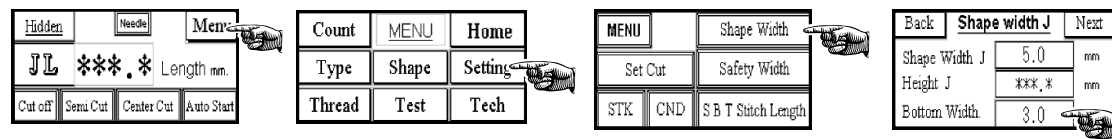
4. WIDTH ADJUSTMENT // ตั้งความกว้าง



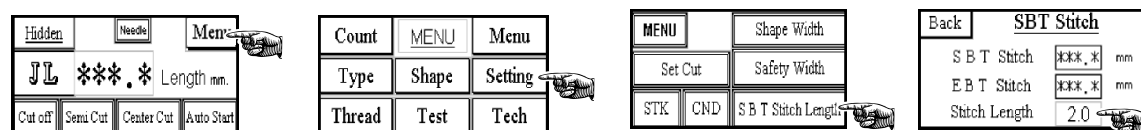
5. SLANT STITCH (Height J) // ตั้งความสูง เส้นเฉียง



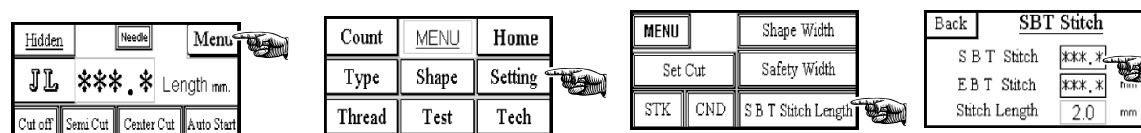
6. CHOOSE BOTTOM WIDTH // ตั้งความกว้างกันสาป



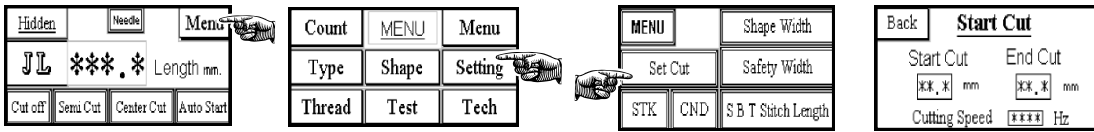
7. CHOOSE STITCH LENGTH // ตั้งฝีเข็มถี่-ห่าง



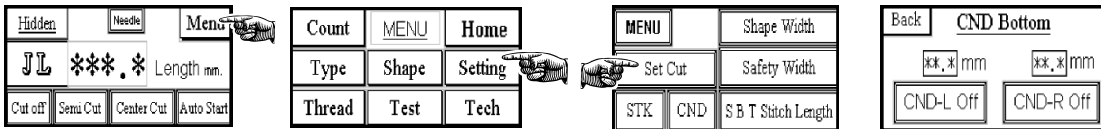
8. START AND END STITCH LENGTH (SBT,EBT) // ตั้งความยาวการเย็บ เริ่ม-จบ



9. START AND END CUTTING POSITION // ตั้งตำแหน่งการเริ่ม-จบ การผ่าผ้า



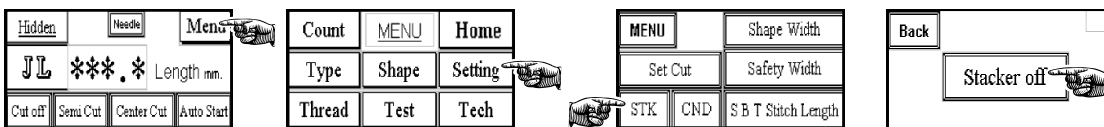
10. ACTIVATE BOTTOM DENSITY STITCH (CND-L,CND-R) // ตั้งฝีเข็มย่น และความยาว มุมล่างซ้าย-ขวา



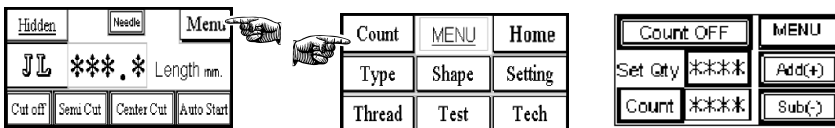
11. KNIFE ACTIVATE, SEMI-FULL CUT, CENTER CUT, AND AUTO START SEWING.

// คำสั่งเปิด-ปิด มีดผ่าผ้า / ผ่ากลาง / ผ่าเลยเส้นเย็บ และคำสั่งเย็บอัตโนมัติ (เหยียบครั้งเดียวจักรจะทำงานโดยอัตโนมัติ)

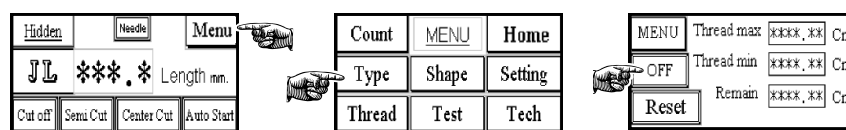
12. STACKER ACTIVATE // เปิดใช้งาน STACKER



13. COUNTING OR RESET TOTAL SEWING QUANTITY // คำสั่งนับจำนวนชิ้นงาน, การลบค่าจำนวนเพื่อเริ่มนับใหม่

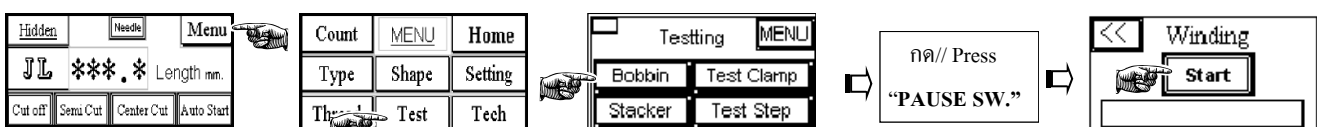


13. BOBBIN THREAD SETTING OR CANCEL ACTIVATE // การตั้งค่าความยาวด้ายในกระสวย/การยกเลิกการวัดค่าด้ายในกระสวย



14. THREAD BREAKING WARNING // การปฏิบัติเมื่อด้ายขาด

15. BOBBIN WINDING // การกรอด้วยกระสวย



16. CENTER PLACKET SEWING // การเรียกใช้โปรแกรมสาปโซว์

16.1) Power turn "OFF" then turn "ON"
ปิดแล้วเปิดสวิตซ์ใหม่

WELCOME TO Uzu
www.UZU.com

TYPE
Hidden Center
Next

Warning!
Please change clamp
Yes No

Are you sure?
Yes No

16.2) While using hidden placket.
ขณะใช้โปรแกรมสาปหลวม

Press for 5 second.
กดค้าง 5 วินาที

Hidden Needle Menu
JL *** * Length mm.
Cut off Semi Cut Center Cut Auto Start

TYPE
Hidden Center
Next

17. CHOOSE SEWING SHAPE // เลือกแบบการเย็บ

Center Needle Menu
C-Close *** * Length mm.
Cut off Semi Cut SC1 Auto Start

Count MENU Home
Type Shape Setting
Thread Test Tech

MENU G-OPEN
U U V
SUL 2U SUR

18. CHOOSE CUTTING TYPE, CUTTING SPEED // การเลือกรูปแบบการผ่าผ้า, ความเร็วการผ่าผ้า

1

Center Needle Menu
C-Close *** * Length mm.
Cut off Semi Cut SC1 Auto Start

Count MENU Home
Type Shape Setting
Thread Test Tech

MENU Shape Width
Set Cut Safety Width
STK CND S B T Stitch Length

Home Cut Width
Knife Position
SingleCut DoubleCut
SC1

Back Cutting Type
SC 1 SC 2 DC 1 DC 2

2

Center Needle Menu
C-Close *** * Length mm.
Cut off Semi Cut SC1 Auto Start

SC1 : One cut with reverse stitching. / มีดผ่าครั้งเดียวพร้อมขณะเย็บ
SC2 : One cut after complete stitching. / มีดผ่าครั้งเดียวหลังจากเย็บเสร็จ
DC1 : Two cut. / มีดผ่า 2 ครั้ง
1st., Cut with reverse stitching. / ครั้งแรกผ่าพร้อมเย็บ
2nd., Cut after complete stitching. / ครั้งที่ 2 หลังจากเย็บเสร็จ
DC2 : Two cut after complete stitching. / มีดผ่า 2 ครั้งหลังจากเย็บเสร็จ

19. SETTING CORRECT KNIFE POSITION.(ACTUAL SIZE)
// การตั้งค่าระยะห่างมีดและเข็ม (ต้องตั้งให้เท่ากับระยะห่างจริง)

Center Needle Menu
C-Close *** * Length mm.
Cut off Semi Cut SC1 Auto Start

Home Cut Width
Knife Position
SingleCut DoubleCut
SC1

Needle plate / เข็มเข็ม
Knife position.
Needle hole / รูเข็ม
Lower knife / มีดล่าง

Home Cut Width
Knife Position
SingleCut DoubleCut
SC1

Home Cut Width
Knife Position
SingleCut DoubleCut
SC1

ระยะการผ่าครั้งเดียว // Single Cut Position.
ระยะการผ่า 2 ครั้ง // Double Cut Position.

20. CLAMP TESTING // ทดสอบ Clamp

Center Needle Menu
C-Close *** * Length mm.
Cut off Semi Cut SC1 Auto Start

Count MENU Home
Type Shape Setting
Thread Test Tech

Testing MENU
Bobbin Test Clamp
Stacker Test Step

Back Needle < >
Test Clamp

22. SEWING POSITION TESTING (Move Clamp to Sewing Position Then Press Down) // ทดสอบตำแหน่งเย็บ (เลื่อน Clamp มาด้านหน้า แล้วกดลง)

Center Needle Menu
C-Close *** * Length mm.
Cut off Semi Cut SC1 Auto Start

Count MENU Home
Type Shape Setting
Thread Test Tech

Testing MENU
Bobbin Test Clamp
Stacker Test Step

<< Test Step
Needle Start Point
1st Test 2nd Start Step

23. STACKER TESTING // ทดสอบชุดหีบขึ้นงาน

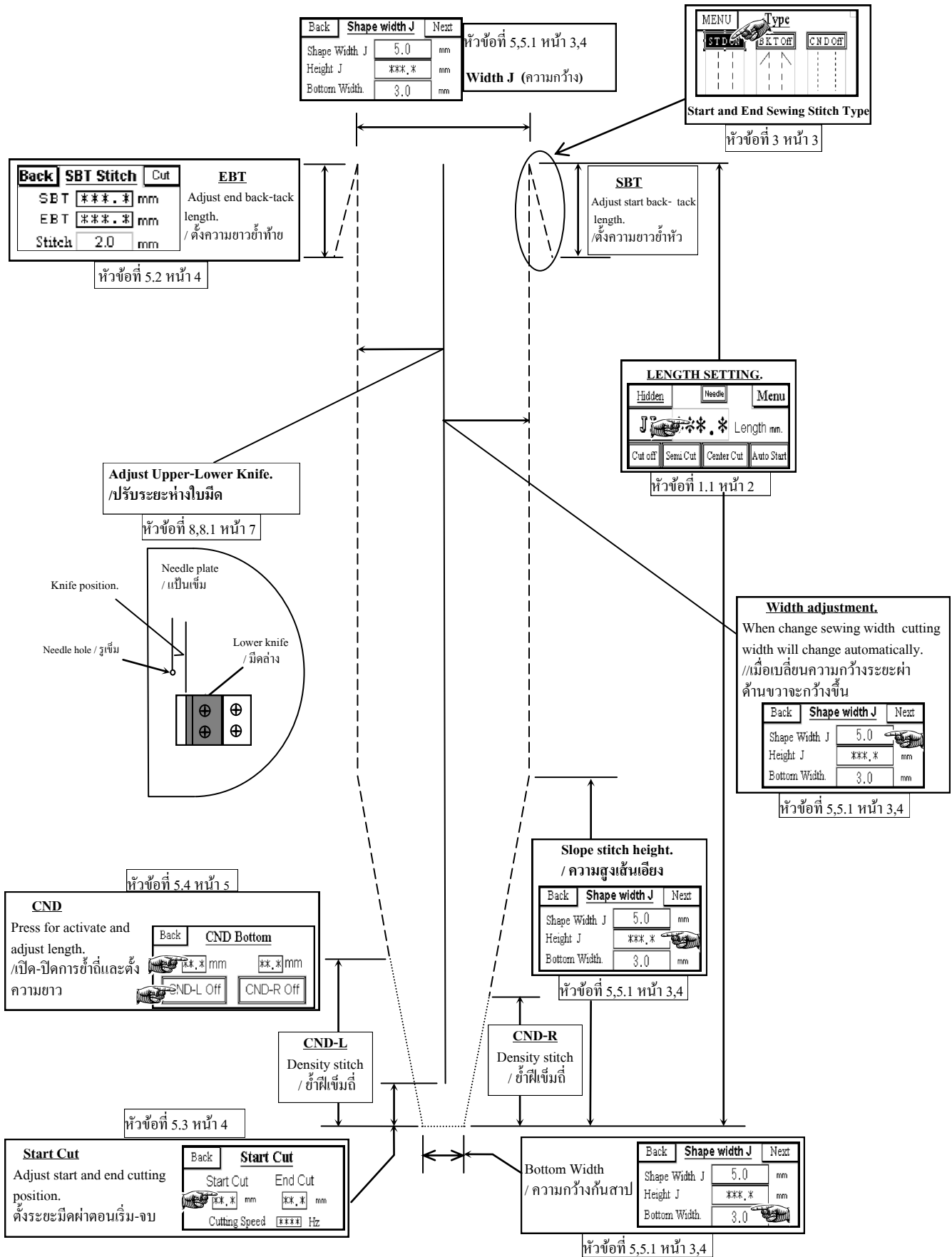
Center Needle Menu
C-Close *** * Length mm.
Cut off Semi Cut SC1 Auto Start

Count MENU Home
Type Shape Setting
Thread Test Tech

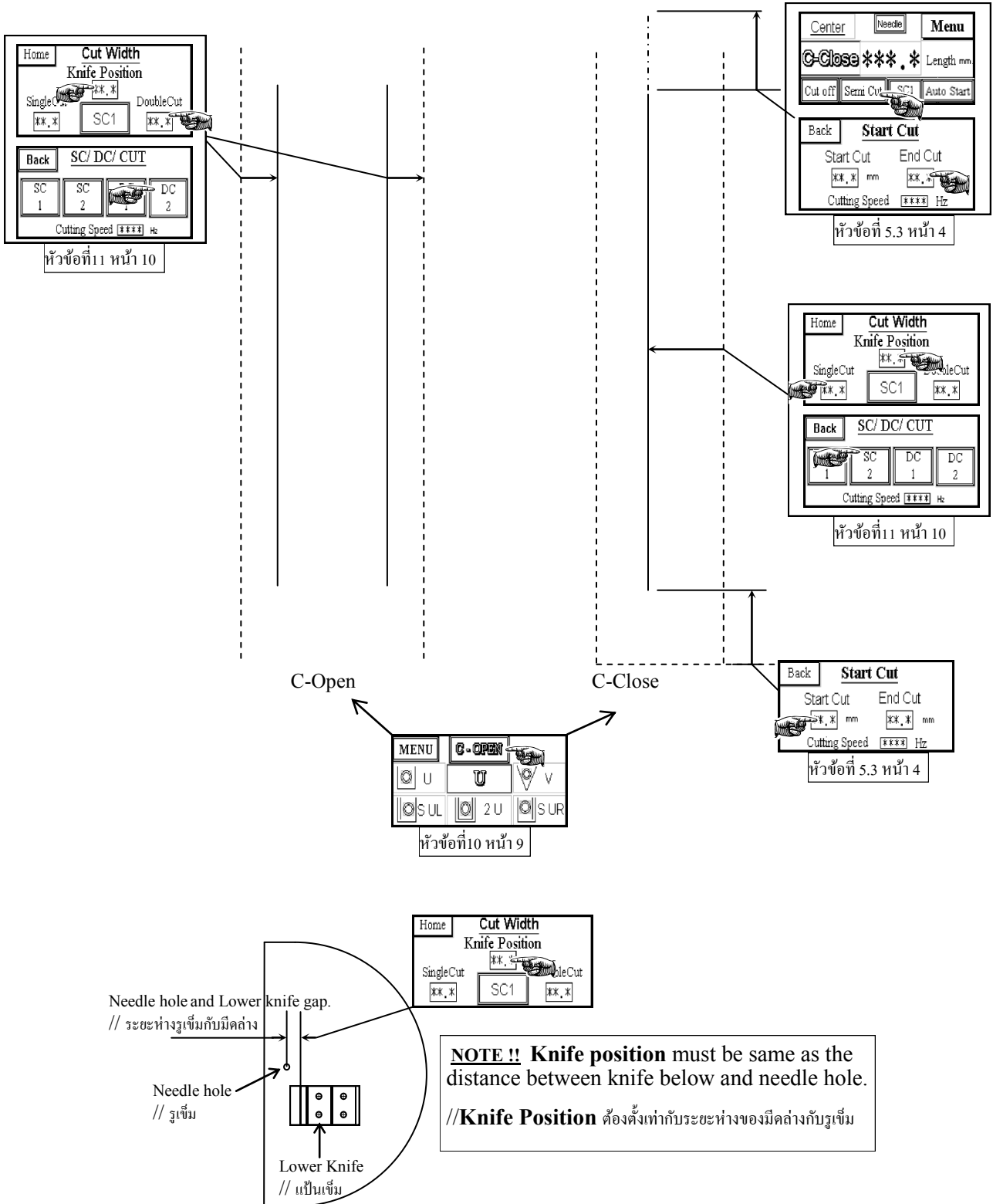
Testing MENU
Bobbin Test Clamp
Stacker Test Step

1st Test Stacker Back
Revers Clamp

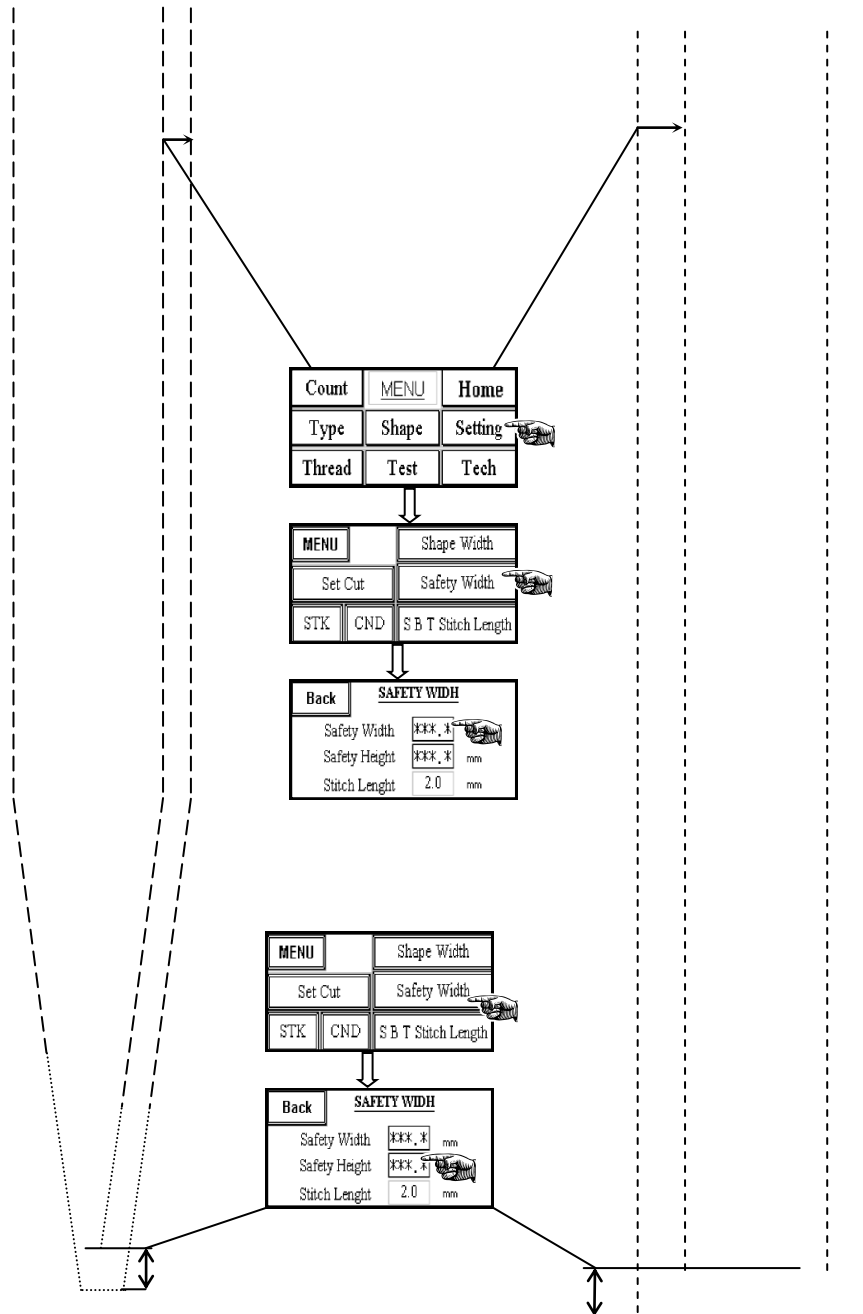
HIDDEN PLACKET SHAPE // โปรแกรม สายซ่อน,สายหลบ



CENTER PLACKET SHAPE // โปรแกรมสถาปไซส์



SAFETY STITCH // โปรแกรมเย็บเซฟตี้

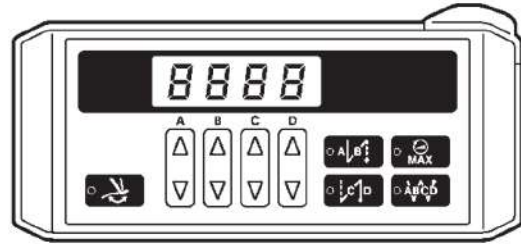


SEWING HEAD FUNCTION SETTING

1). DEFAULTS SETTING

+ → (1) While pressing continuous backtick key, press the power ON switch. In.AL will appear in the display.

→ Press for 2 seconds or more.



2). LOCK FUNCTION

While pressing the start backtick key and C, press the power ON switch.

PLU0 , PLU1 = Unlock

PLU2 , PLU3 = Lock

Press to enter.

3). SLOW START, NEEDLE POSITION.

+ → While pressing the end backtick key, press the power ON switch.

	= ON
	= OFF
	= 1800
	= OFF
	= Up
	= OFF

Select the other item and change the value. Press to see then value.

4). SLOW START STITCH AND SPEED SETTING.

+ + → While pressing the end backtick key and max key, press the power ON switch.

F100 (Slow stitch) = 3
F183 (Slow speed) = 150

5). ADJUSTING THE NEEDLE UP STOP POSITION.

+ → (1) While pressing the key, press the power ON switch.

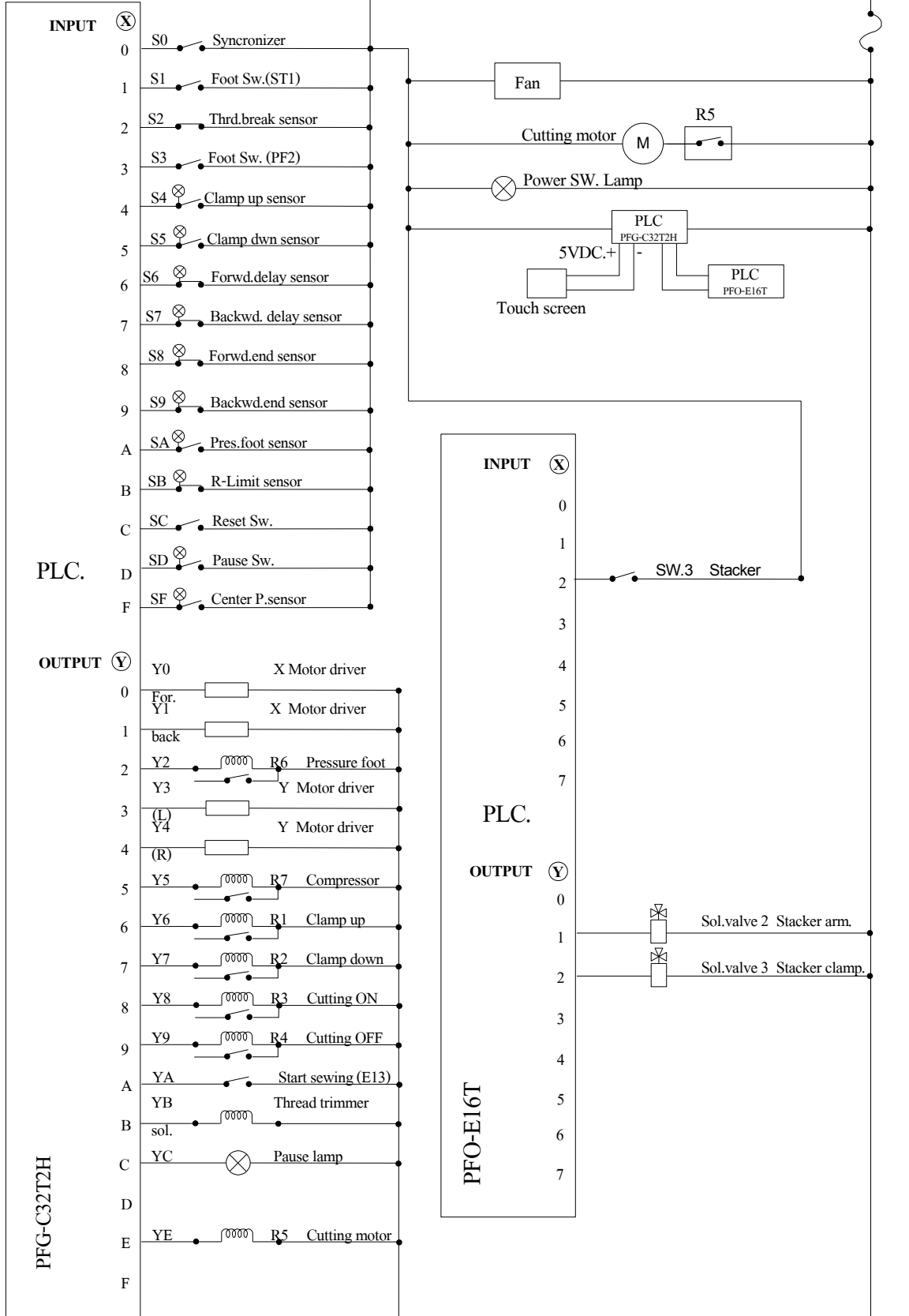
	= 5
	= 5
	= 5

UZ-PL55D-ST/PS Circuit Diagram

24VDC.

0V.

24V.



PL55D-ST/PS Circuit Diagram.

