

SERVICING MANUAL

MEMORY CRAFT 3500

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TOP COVER & FACE PLATE ATTACHING AND REMOVING

Top cover

To remove:

1. Remove 3 screws (A) & (B) and top cover.

To attach:

2. Attached the top cover with 3 screws (A) and (B).

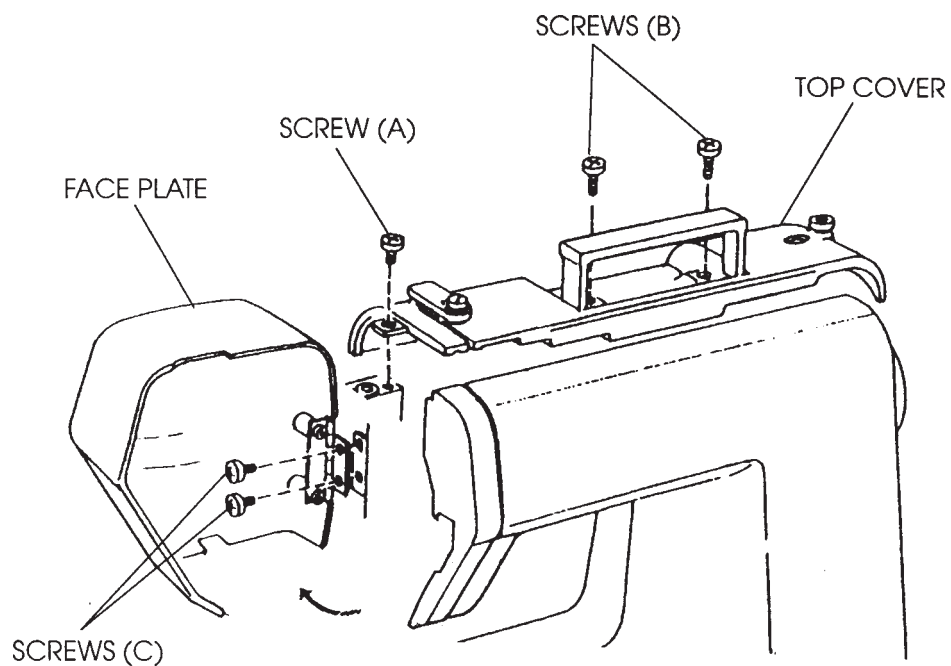
Face plate

To remove

3. Remove 2 screws (C) and face plate.

To attach

4. Attach the face plate with 2 screws (C).



BASE & BED COVER ATTACHING AND REMOVING

Base

To remove:

1. Remove 6 screws (A) and base.

To attach:

2. Attach the base with 6 screws (A).

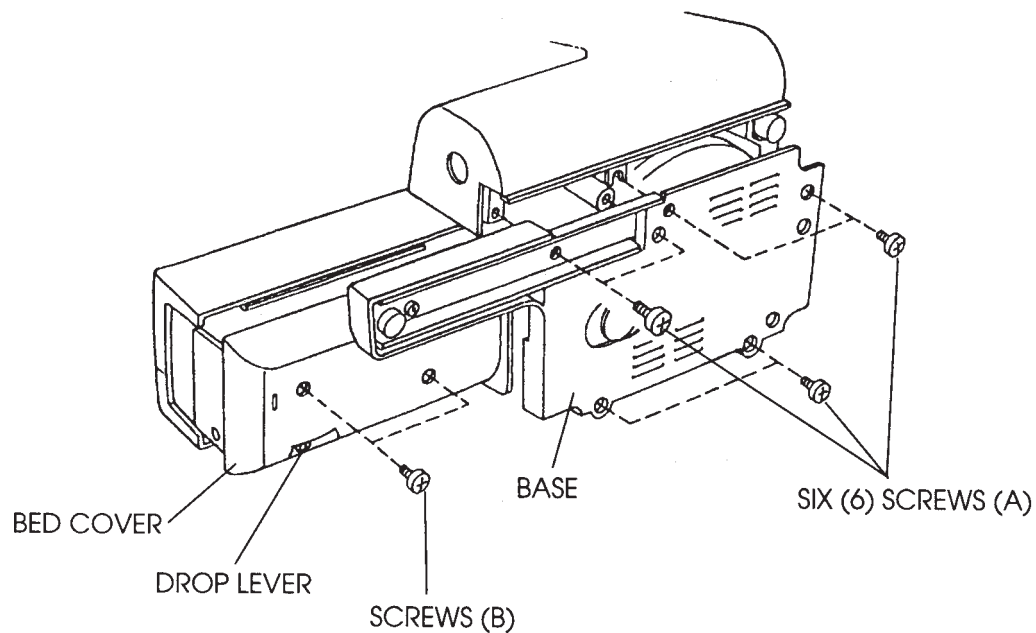
Bed cover

To remove:

3. Move the drop lever to the left, then remove 2 screws (B).
4. Remove the bed cover.

To attach:

5. Move the drop lever to the left and attach the bed cover with 2 screws (B).



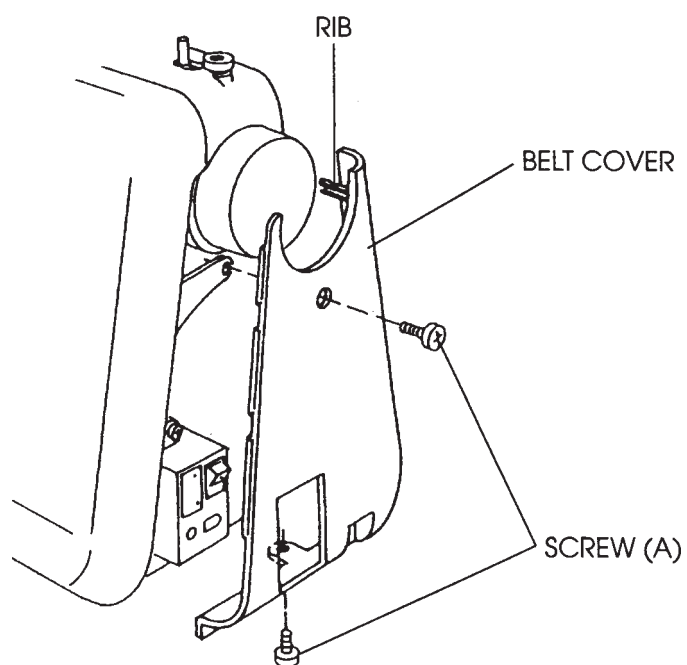
BELT COVER ATTACHING AND REMOVING BELT COVER

To remove:

1. Remove 2 screws (A) and belt cover, then pull out.

To attach:

2. Attach the belt cover with 2 screws (A).



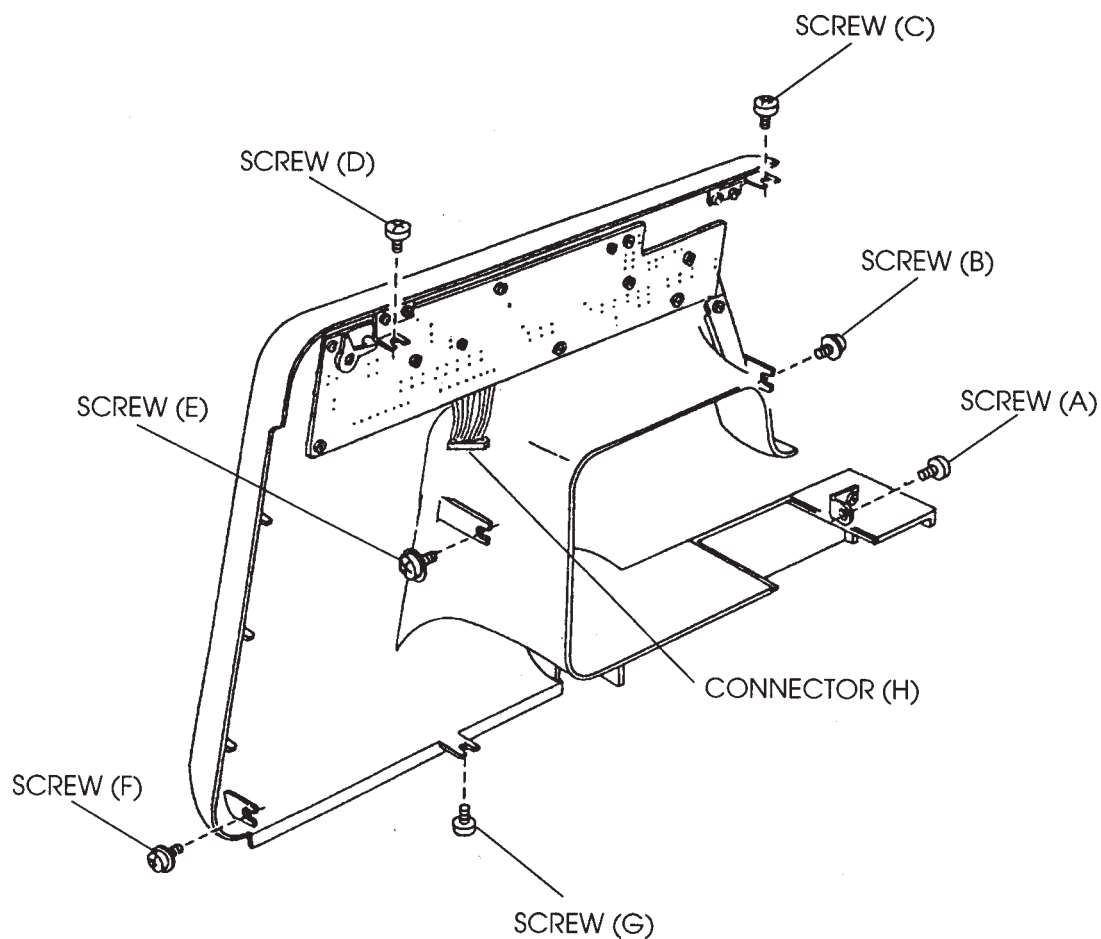
FRONT PANEL ATTACHING AND REMOVING FRONT PANEL

To remove:

1. Remove the top cover, belt cover and bed cover (see page 1, 2 and 3)
2. Remove screw (A) and loose screws (B), (C), (D), (E), (F) and (G).
3. Pull out connectors (H) and remove the front panel.

To attach:

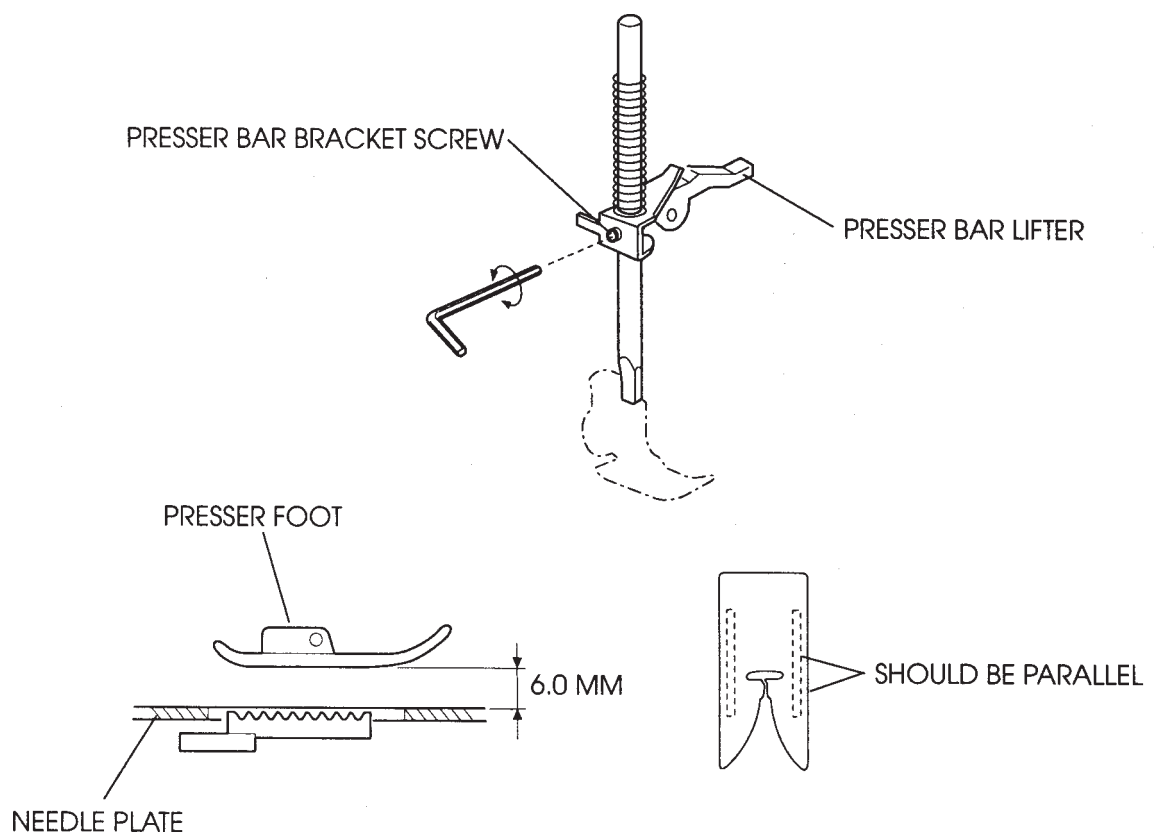
4. Insert connectors (H) and attach the front panel.
5. Tighten the screws.



TO ADJUST THE PRESSER BAR HEIGHT

The standard presser bar height is 6.0 mm between the bottom surface of the foot and needle plate when the presser bar lifter is in the position.

1. Open the face plate.
2. Raise the presser foot, loosen the presser bar bracket screw and adjust the height to 6.0 mm.
3. Check if the presser foot is parallel to the openings for the feed dog on the needle plate. If not, adjust it.
4. Tighten the presser bar bracket screw while holding the presser bar to keep the foot parallel to the openings.
5. Close the face plate.



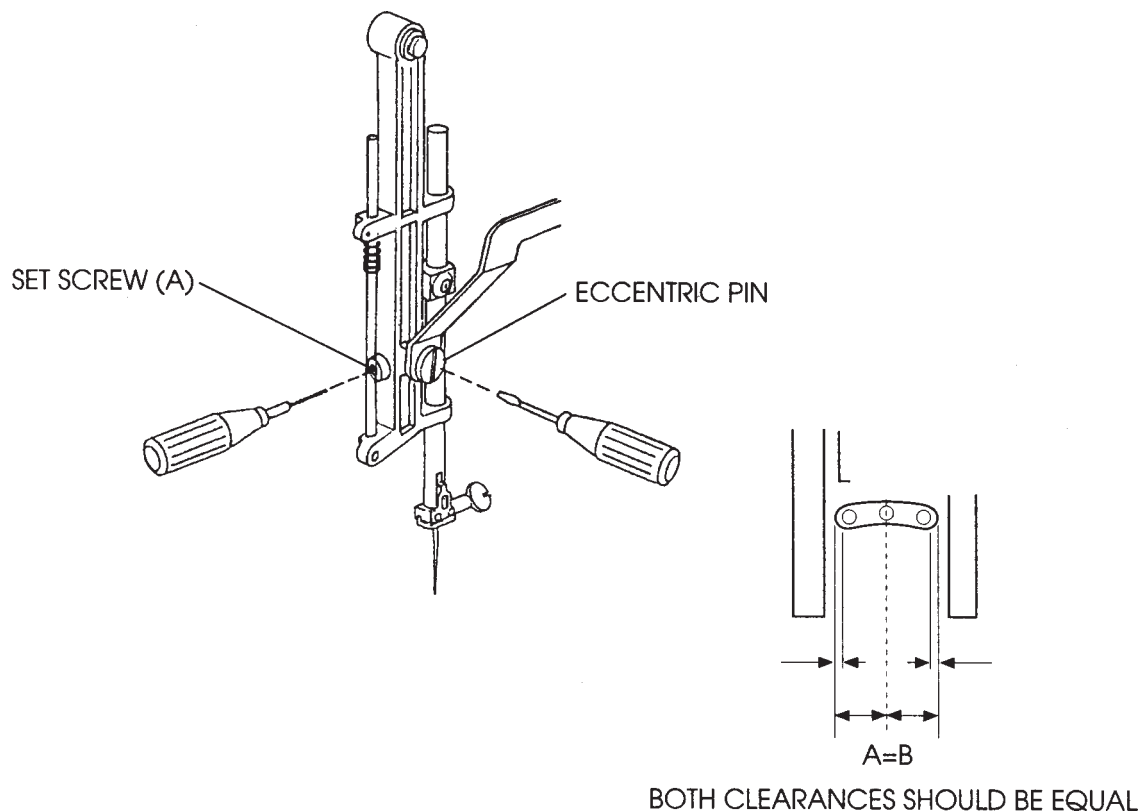
TO ADJUST THE NEEDLE DROP

When you select the pattern (↺), the needle drop should be in the center position of the needle hole in the needle plate.

When the needle swings in maximum zigzag width, the distance between both edges of the needle hole on the needle plate and the needle drop position should be equal.

1. Turn on the power switch.
2. Select pattern (↺), or pattern (↻) at maximum zigzag width.
3. Loosen the set screw (A).
4. Turn the eccentric pin to adjust the needle drop.
5. Tighten the set screw (A).

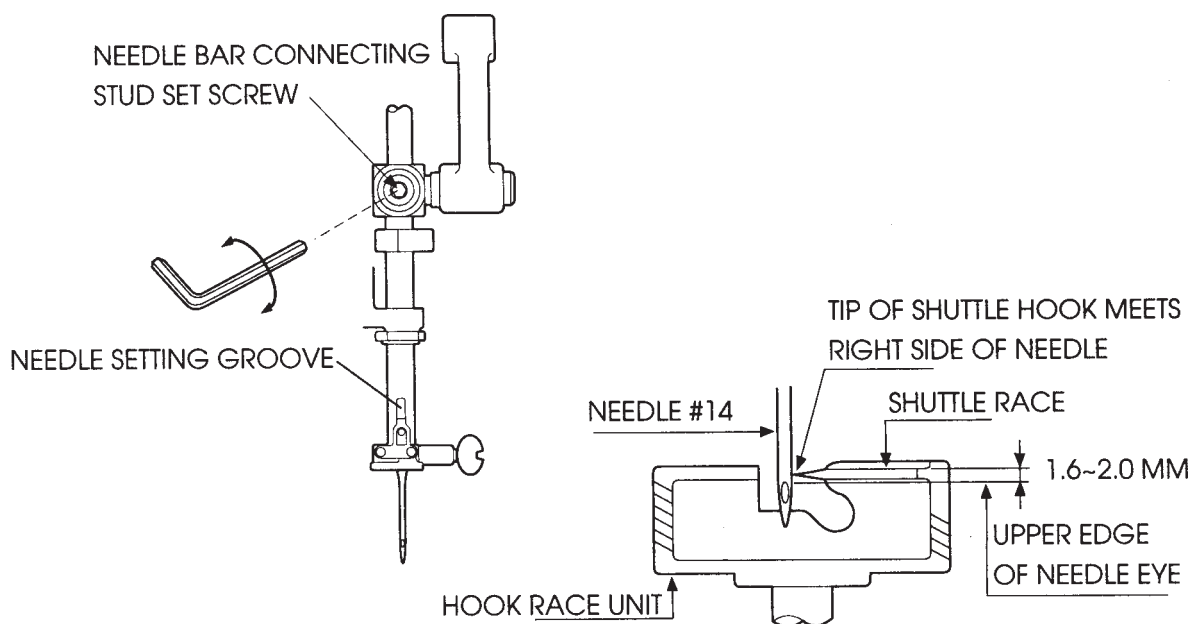
Note: check the hook timing after this adjustment.



TO ADJUST THE NEEDLE BAR HEIGHT

The standard distance between the upper edge of the needle eye and the tip of shuttle hook should be in the range of 1.6-2.0 mm when the tip of shuttle hook meets the right side of the needle in ascending travel of needle from its left and lowest position.

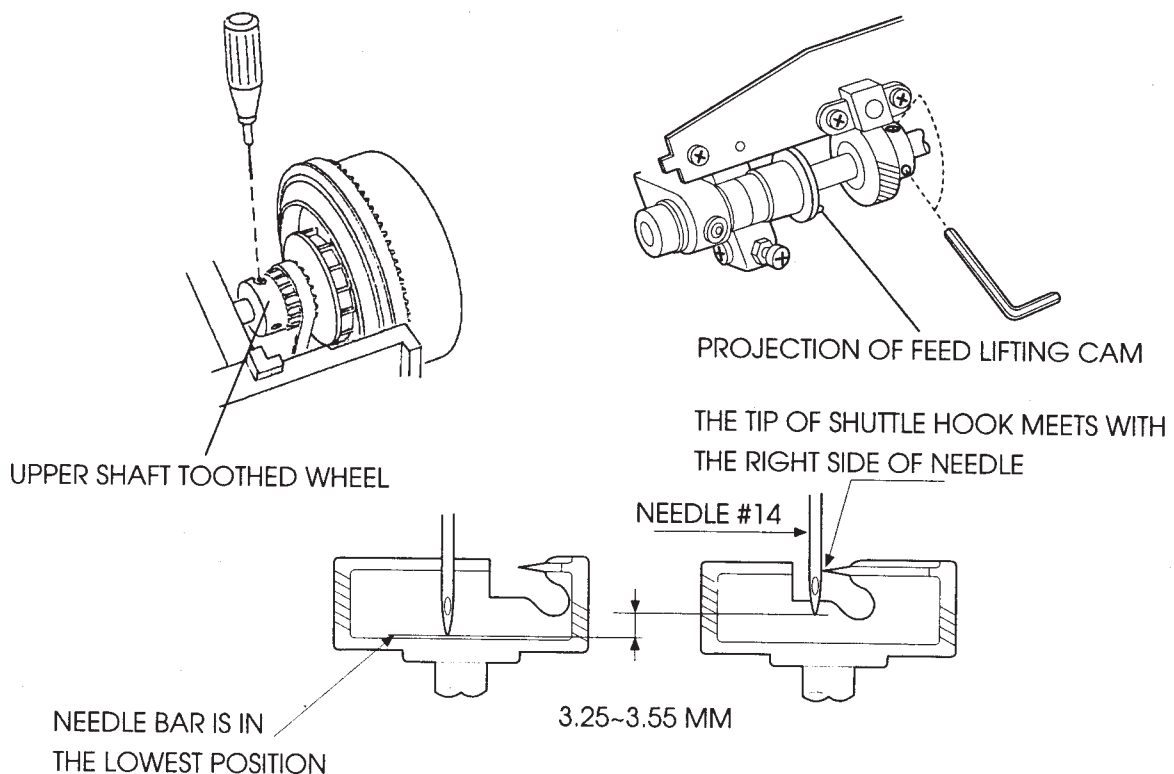
1. Remove the needle plate & bobbin holder.
2. Turn on the power switch and select the pattern (↶).
3. Turn the hand wheel toward you until tip of shuttle hook meets the right side of the needle.
4. Loosen the needle bar connecting stud set screw.
5. Adjust the height of the needle bar by moving the needle bar upward or downward without turning it.
(Make sure that the needle setting groove on the needle bar is in the front.
6. Tighten the set screw.
7. Insert the bobbin holder.
8. Attach the needle plate.



TO ADJUST THE HOOK TIMING

When the pattern (↵) is selected, the amount of ascending travel of the needle bar from its lowest position to the position where the tip of the rotary hook exactly meets the right side of the needle should be 3.25 to 3.55 mm.

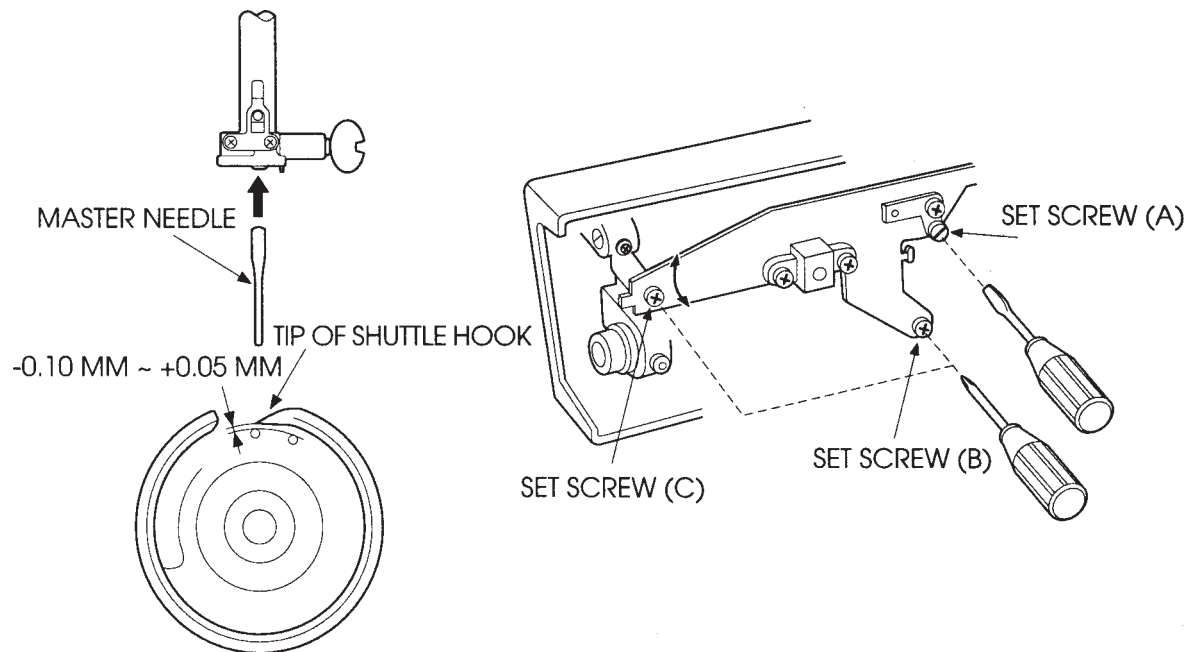
1. Remove the needle plate and bobbin holder.
2. Turn on the power switch and select the pattern (↵).
3. Remove the top cover, belt cover and bed cover (see pages 1, 2 and 3).
4. Turn the hand wheel toward you and set the needle bar to the lowest position.
5. In this condition.
 - * If the projection of feed lifting cam is in the lowest position, loosen the set screws of lower shaft timing wheel.
 - * If not, loosen the set screws of upper shaft toothed wheel.
6. Raise the needle bar further 3.25 to 3.55 mm from the lowest position.
7. Turn the lower shaft gear until the tip of shuttle hook meets with the right side of needle.
8. Tighten the set screws of lower shaft timing wheel or upper shaft toothed wheel.
9. Attach the bed cover, belt cover, top cover, bobbin holder and the needle plate.



TO ADJUST THE CLEARANCE BETWEEN THE NEEDLE AND THE HOOK

The clearance between needle and shuttle hook should be -0.10 to $+0.05$ mm. If not, make an adjustment as follows:

1. Remove the needle plate and bobbin holder.
2. Replace the needle the master needle.
3. Turn on the power switch and select the pattern (⌘).
4. Loosen the set screws (B) and (C), and slightly tighten the hinge screw (A).
5. Turn the hand wheel and adjust the clearance between the master needle and the point of shuttle hook in the left and right needle positions to -0.10 mm to $+0.05$ mm by moving the shuttle hook set plate up or down.
6. Tighten the set screws (A), (B) and (C).
7. Replace the master needle with the needle.
8. Insert the bobbin holder and attach the needle plate.

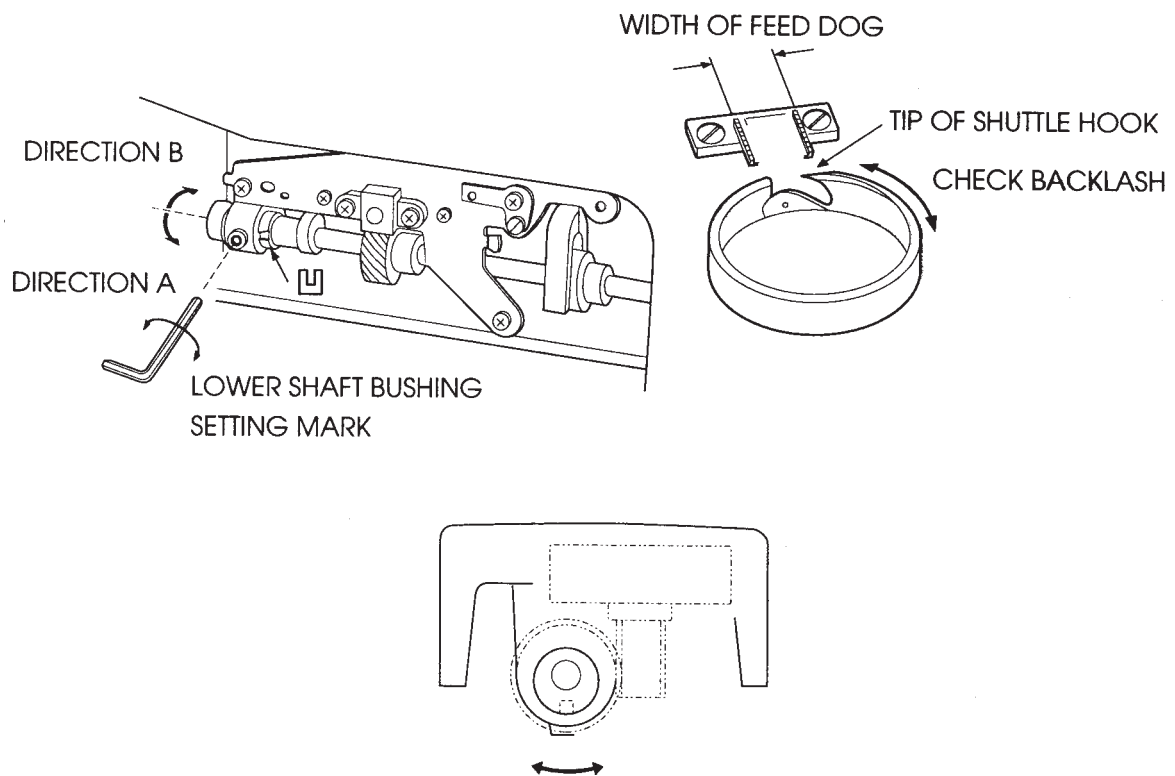


TO ADJUST THE BACKLASH OF HOOK DRIVE GEAR AND LOWER SHAFT GEAR

The backlash of gears should be smooth and should be less than 0.8 mm when the tip of shuttle hook is within the width of the feed dog as shown below.

1. Remove the bed cover (see page 2).
2. Loosen the hexagonal socket screw.
3. (A) if the backlash is too great, turn the lower shaft bushing in direction A.
(B) If the backlash is too little, turn the lower shaft bushing in direction B.
4. Tighten the hexagonal socket screw.
5. Attach the bed cover.

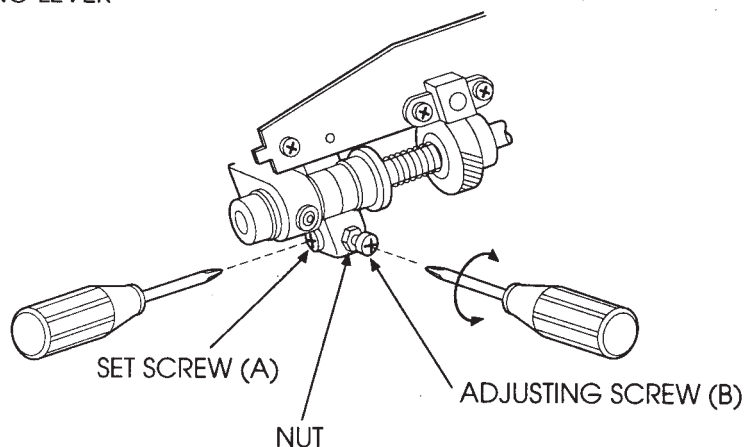
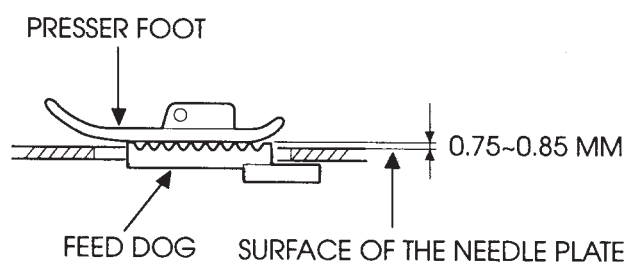
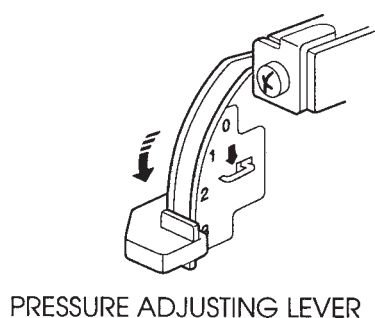
Note: After adjusting the backlash, be sure to check and adjust the "HOOK TIM-ING" and the "FEED DOG HEIGHT" (see pages 8 and 11).



TO ADJUST THE FEED DOG HEIGHT

When pressure adjusting lever is at “3” and the presser foot is lowered, the highest Position of the feed dog should be 0.75 to 0.85 mm from the surface of the needle Plate.

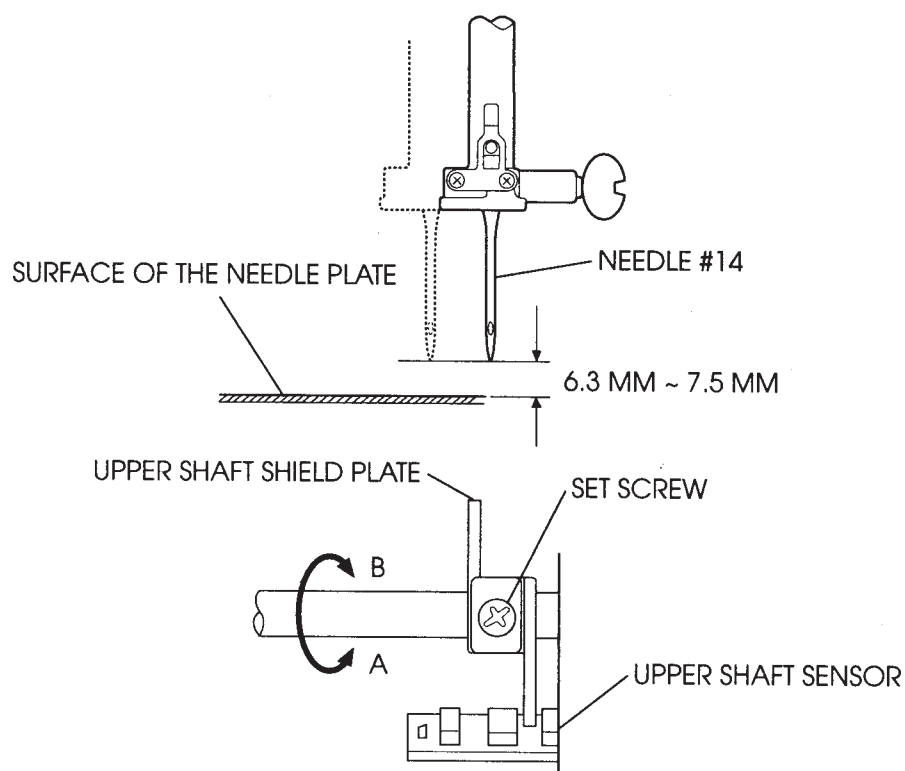
1. Set the pressure adjusting lever at “3” with the presser foot lowered.
2. Turn on the power switch.
3. Turn the hand wheel toward you to get the highest position of feed dog.
4. Remove the bed cover.
5. Loosen the set screw (A) and nut.
6. Adjust the feed dog height to 0.75 mm to 0.85 mm by turning the adjusting screw (B).
7. Tighten the nut and set screw (A).
8. Attach the bed cover.



TO ADJUST THE UPPER SHIELD PLATE POSITION

When the machine is set for zigzag stitching, the needle should start to swing 6.3 mm to 7.5 mm above the surface of the needle plate.

1. Remove top cover.
2. Turn on the power switch and select the pattern (⌘)
3. Turn the hand wheel toward you slowly with your hand until the needle starts to swing.
 - (A) If higher than 7.5 mm, loosen the set screws and turn the upper shaft shield plate in direction of A.
 - (B) If lower than 6.3 mm, loosen the set screws and turn the upper shaft shield plate in direction of B.
4. Push the upper shaft shield plate as close as possible to the left. (it should not touch the upper shaft sensor.) Then tighten the set screw.
5. Turn the hand wheel toward you, and check the start swing.
6. Attach the top cover (see page 1).

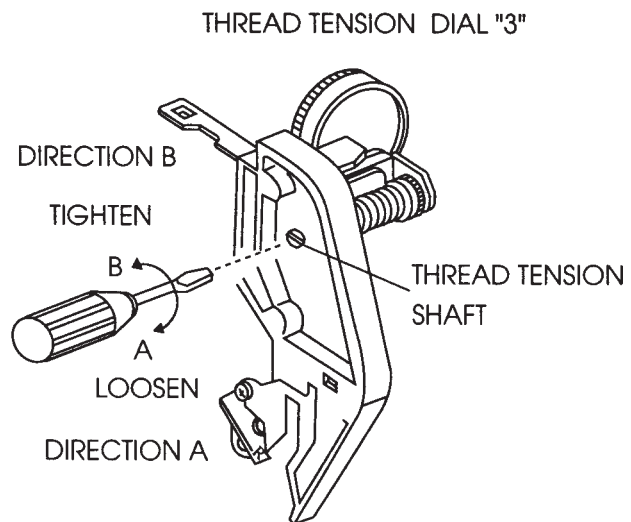
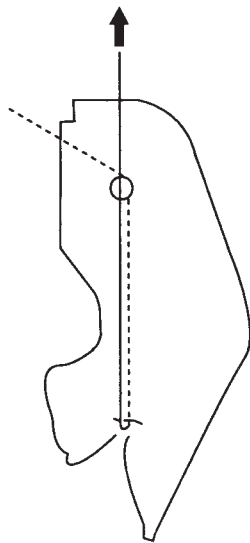


TO ADJUST THE UPPER THREAD TENSION

The standard of upper thread tension should be 75g to 90g when pulling the thread (cotton thread #50) in direction a with setting the tension dial at "3" (make sure the Foot is lowered.)

1. Set the thread tension dial to "3".
2. Open the face plate and adjust the thread tension by turning the thread tension shaft with a screwdriver in direction...
(A) to loose the tension.
(B) to tighten the tension.
3. Close the face plate.

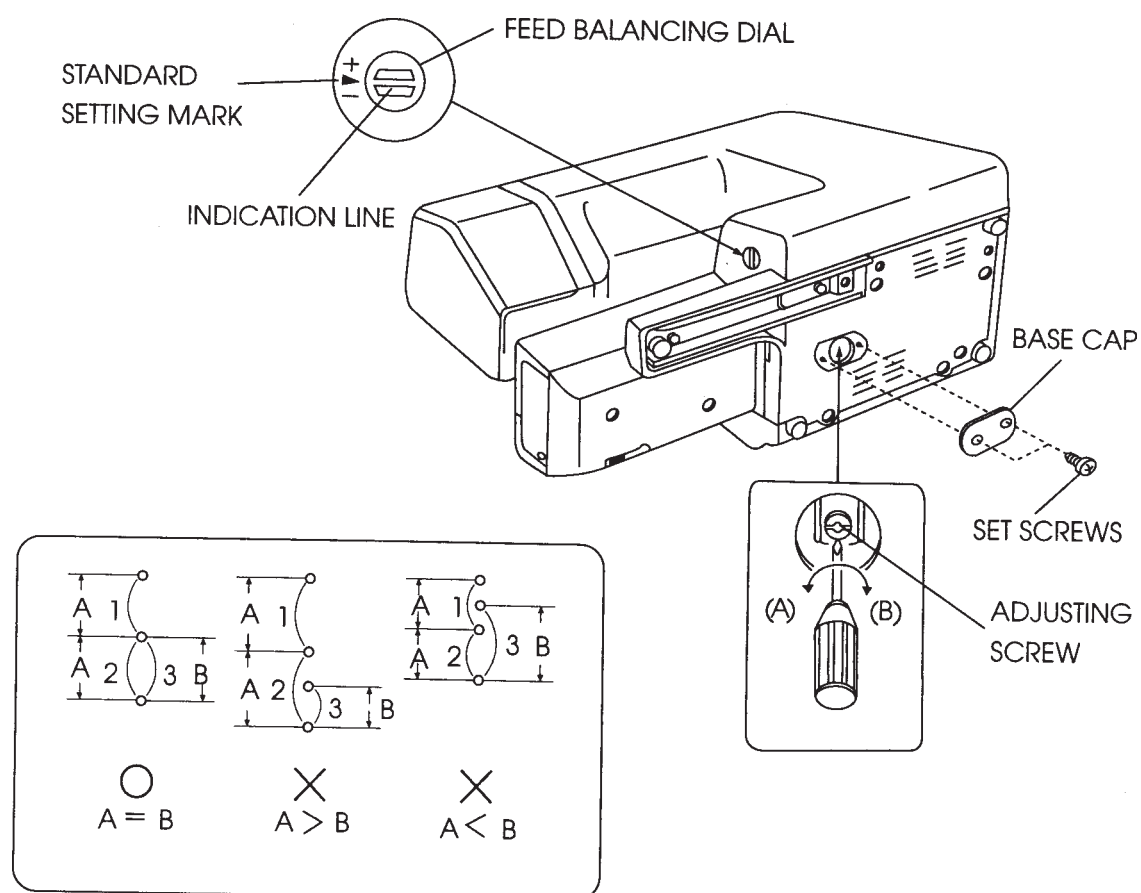
PULL THE #50 COTTON THREAD
IN THE DIRECTION OF ARROW



TO ADJUST THE STRETCH FEED BALANCE

When pattern “||||” is sewn with the feed balancing dial at the standard setting mark (►), the sewn pattern should be as indicated by the mark “0” the following figure.

1. Set the pattern “||||”, and the feed balancing dial at standard setting mark (►).
2. Remove the screws and base cap as illustrated.
3. Adjust the stretch stitch feed balance by turning the adjusting dial in direction A or B.
4. Attach the base cap with screws.



TO REPLACE AND ADJUST THE THREADER PLATE

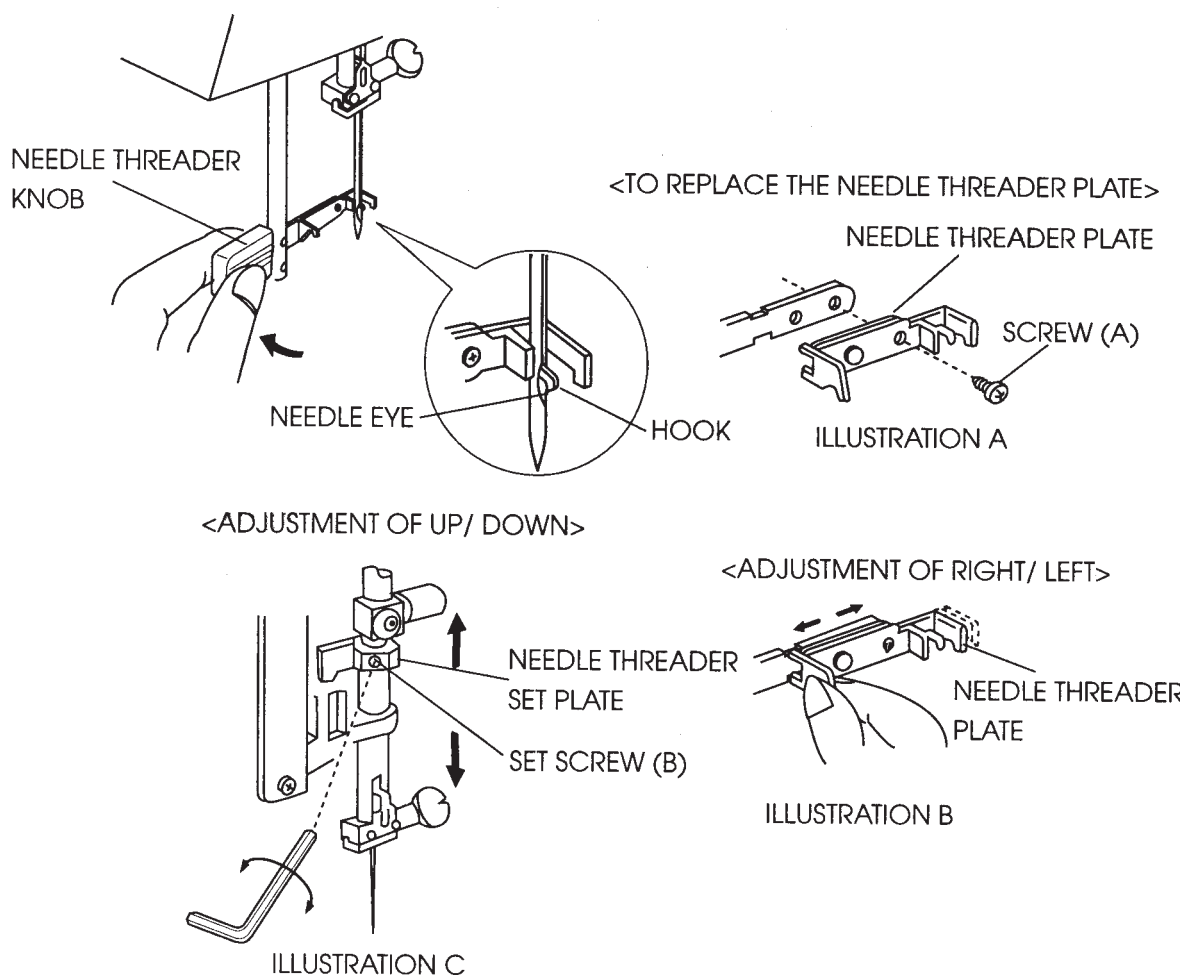
If the needle threader plate is broken or bent, replace it as follows:

To replace:

1. Turn the hand wheel toward you until the needle bar reaches its highest position and lower the needle threader knob as far as it will go.
2. Loosen screw (A) and replace the needle threader plate (see the Illustration A).

To adjust:

3. If the hook touches the right or left side of the needle eye, loosen screw (A) and move the needle threader plate (see the Illustration B).
4. If the hook touches the top or bottom of the needle eye, loosen set screw (B) and move the position set plate (see the Illustration C).



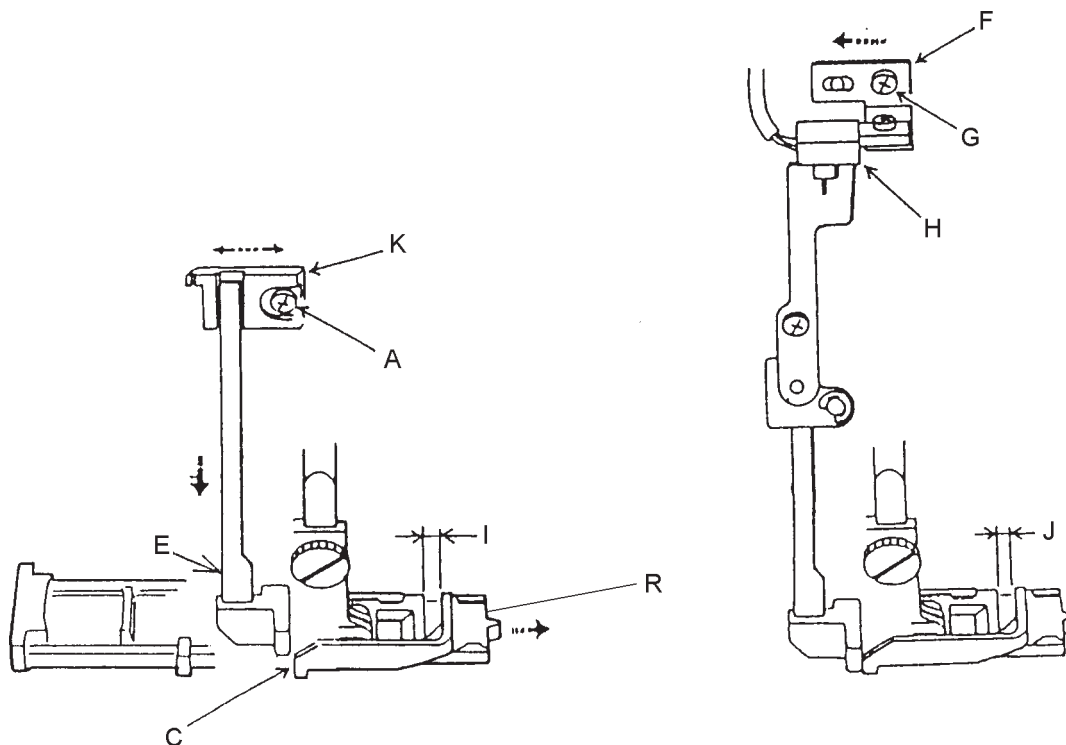
TO ADJUST THE BUTTONHOLE LEVER

A) Buttonhole lever guide

1. Attach the automatic buttonhole foot (R).
2. Loosen the set screw (A) and leave the clearance of 2.9mm (I) between the spring holder and slider (B) by moving the buttonhole lever guide (K). In this condition, the buttonhole lever (E) should touch the spring holder (C) slightly.
3. Tighten the set screw (A).

B) Buttonhole sensor

1. Turn the power switch on while pressing the reverse button, then press BH1 at once. "H SENSOR H or L" will appear in the screen.
2. Lower the buttonhole lever (E). Then leave the clearance (J) of 1.6mm between the slider (B) and Spring holder (C).
3. Loosen the set screw (G) and move the buttonhole sensor base plate (F) from the right to left slowly. At the position where the screen message changes from "H SENSOR L" to "H SENSOR H" tighten the set screw (G).
4. When the clearance between the spring holder (C) and slider (B) is:
 - * 1.4mm, the screen shows "H SENSOR H"
 - * 1.8mm, the screen shows "H SENSOR L"



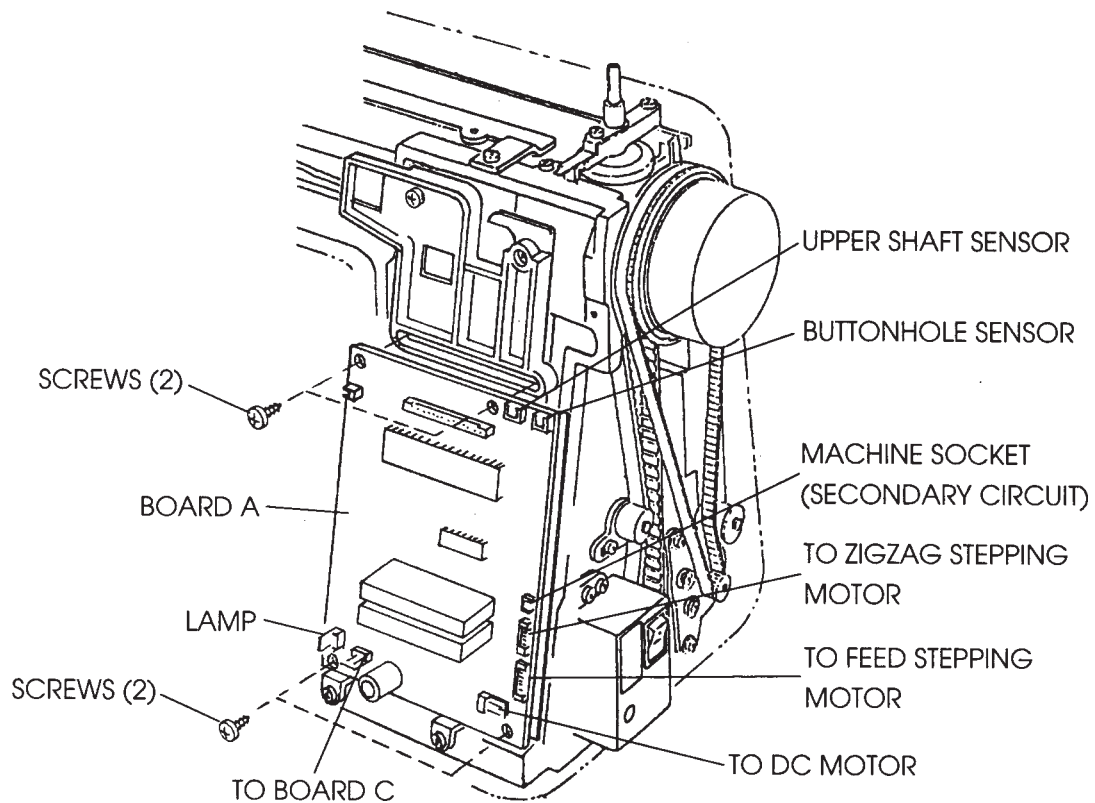
BOARD A ATTACHING AND REMOVING

To remove:

1. Remove the front cover unit.
2. Pull out 8 connectors from the board A.
3. Remove 4 screws and board A.

To attach:

4. Follow the above procedure in reverse.



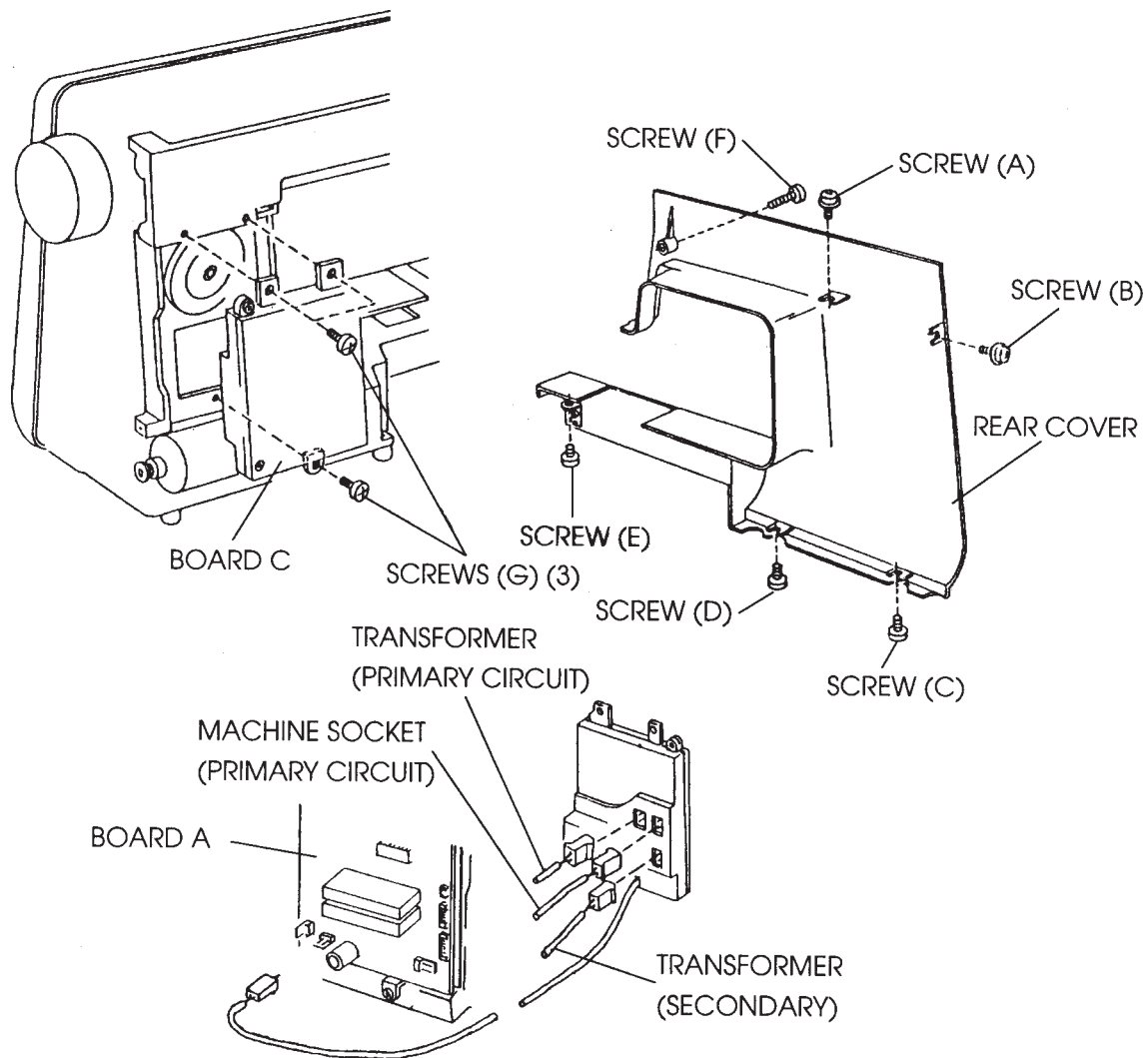
BOARD C ATTACHING AND REMOVING

To remove:

1. Remove the front panel unit (see page 4).
2. Loosen screws (A), (B), (C) and (D), and remove screws (E) and (F).
3. Remove the rear cover.
4. Pull out the 4 connectors and remove screws (G).
5. Remove board C.

To attach:

6. Attach board C with 3 screws and insert the connectors.
7. Attach the rear cover with 6 screws.
8. Attach the front panel unit.



BOARD C AND FUSE ATTACHING AND REMOVING

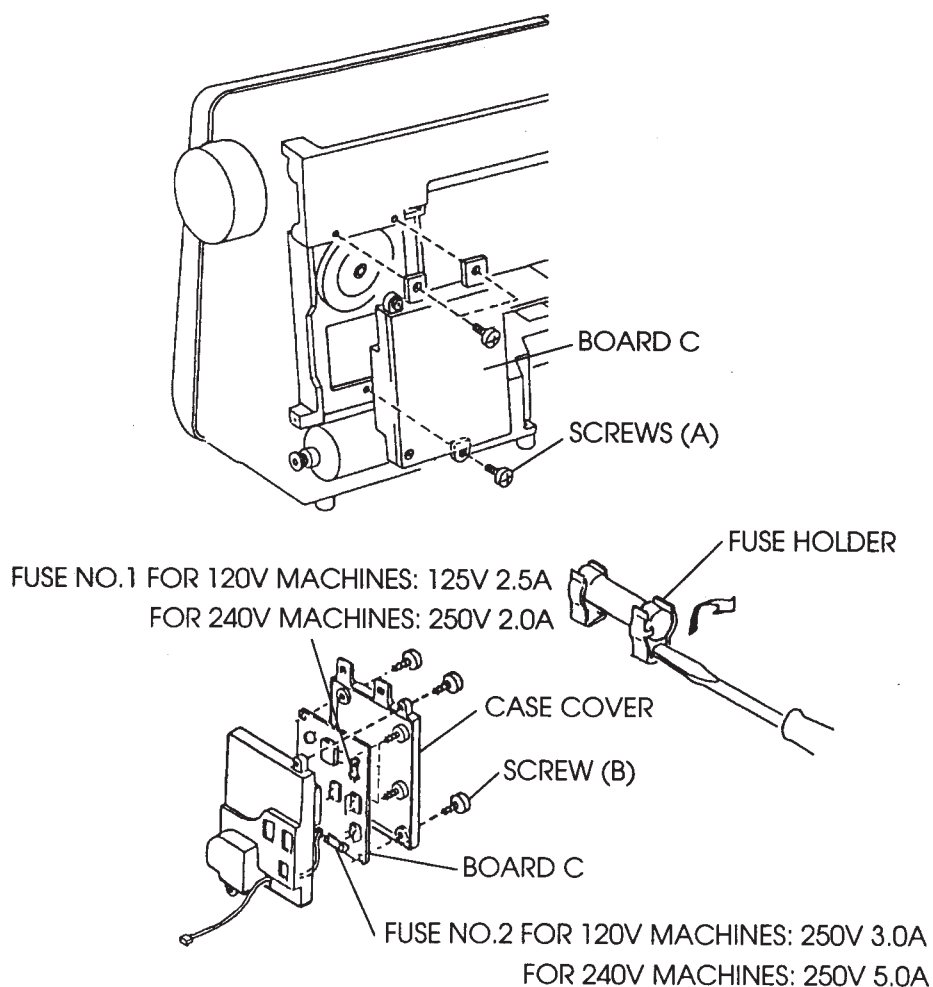
To remove:

1. Remove the rear cover.
2. Remove 3 screws (A) and board C (see page 18).
3. Remove 3 screws (B) and remove case cover.
4. Replace fuse or board C.

To attach:

5. Attach the case cover with 3 screws (B).
6. Attach the board C with 3 screws (A).
7. Attach the rear cover.

Note: to replace fuse, pry it out of the fuse holder with a screwdriver, as shown below.
Two specified fuses are used for board C.



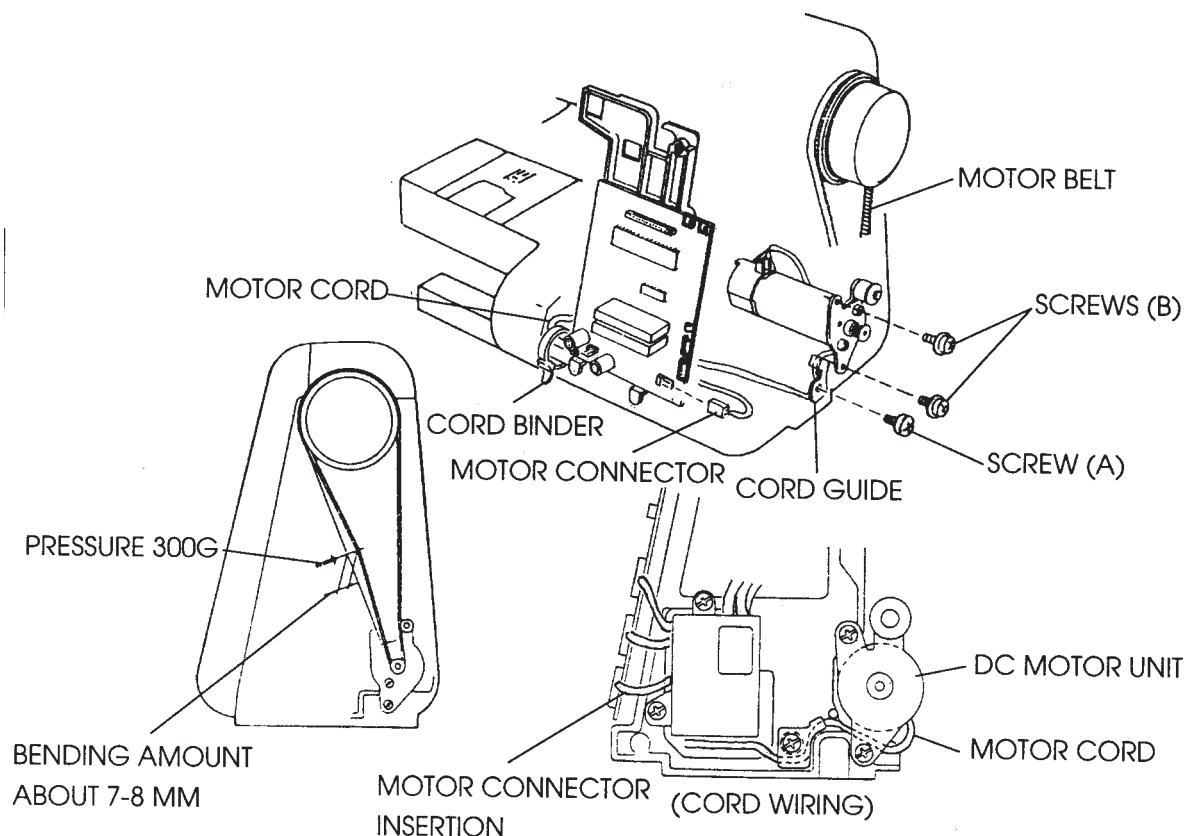
DC MOTOR UNIT ATTACHING AND REMOVING DC MOTOR

To remove:

1. Remove the front panel unit (see page 4).
2. Remove the machine socket unit (see page 22) (no need to pull out the connectors)
3. Cut the cord binder and pull out the motor connector from board A.
4. Remove the screw (A) and cord guide.
5. Remove the motor belt, screws (B) and the motor.

To attach:

6. Attach the DC motor by tightening the two screws (B) slightly.
7. Attach the motor belt and adjust the belt tension.
8. Set the cord guide with screws (A).
9. Secure the cord with the cord binder.
10. Connect the motor connector to the board A.
11. Attach the machine socket unit and front panel unit.



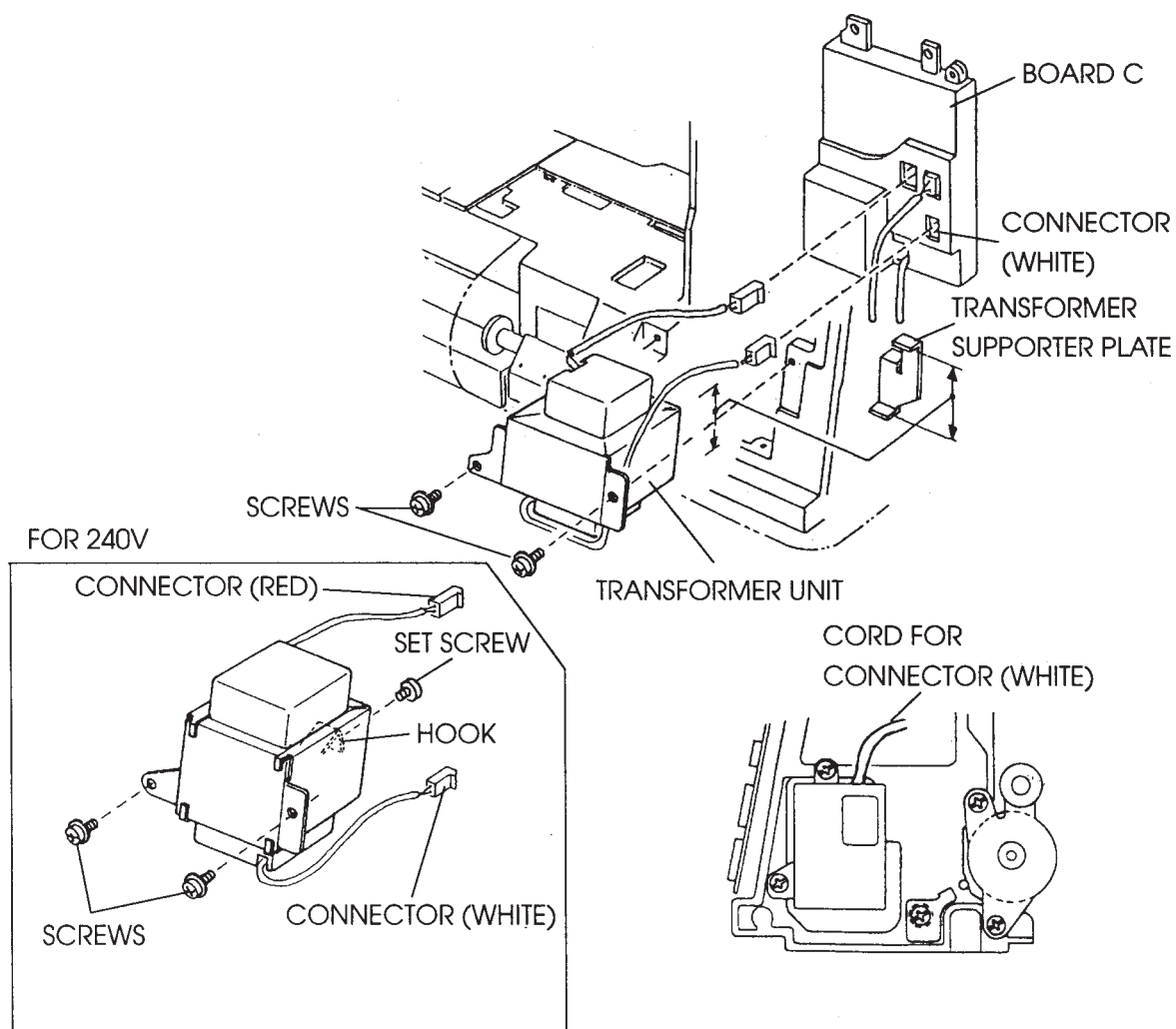
TRANSFORMER UNIT ATTACHING AND REMOVING TRANSFORMER UNIT

To remove:

1. Remove the front panel unit (see page 4).
2. Remove the board A and C (page 17) and machine socket unit (page 22).
3. Pull out the connectors for the transformer from the board C.
4. Remove 2 screws and transformer (for 120V). Remove 2 screws and transformer (for 220-240V).

To attach:

5. For 120V, attach the transformer unit with supporter plate 2 screws. For 220-240V, attach the transformer unit with 3 screws (2 for the transformer and 1 for the hook).
6. Insert the connectors in the board C.
7. Attach the machine socket unit, board C, board A and front panel.



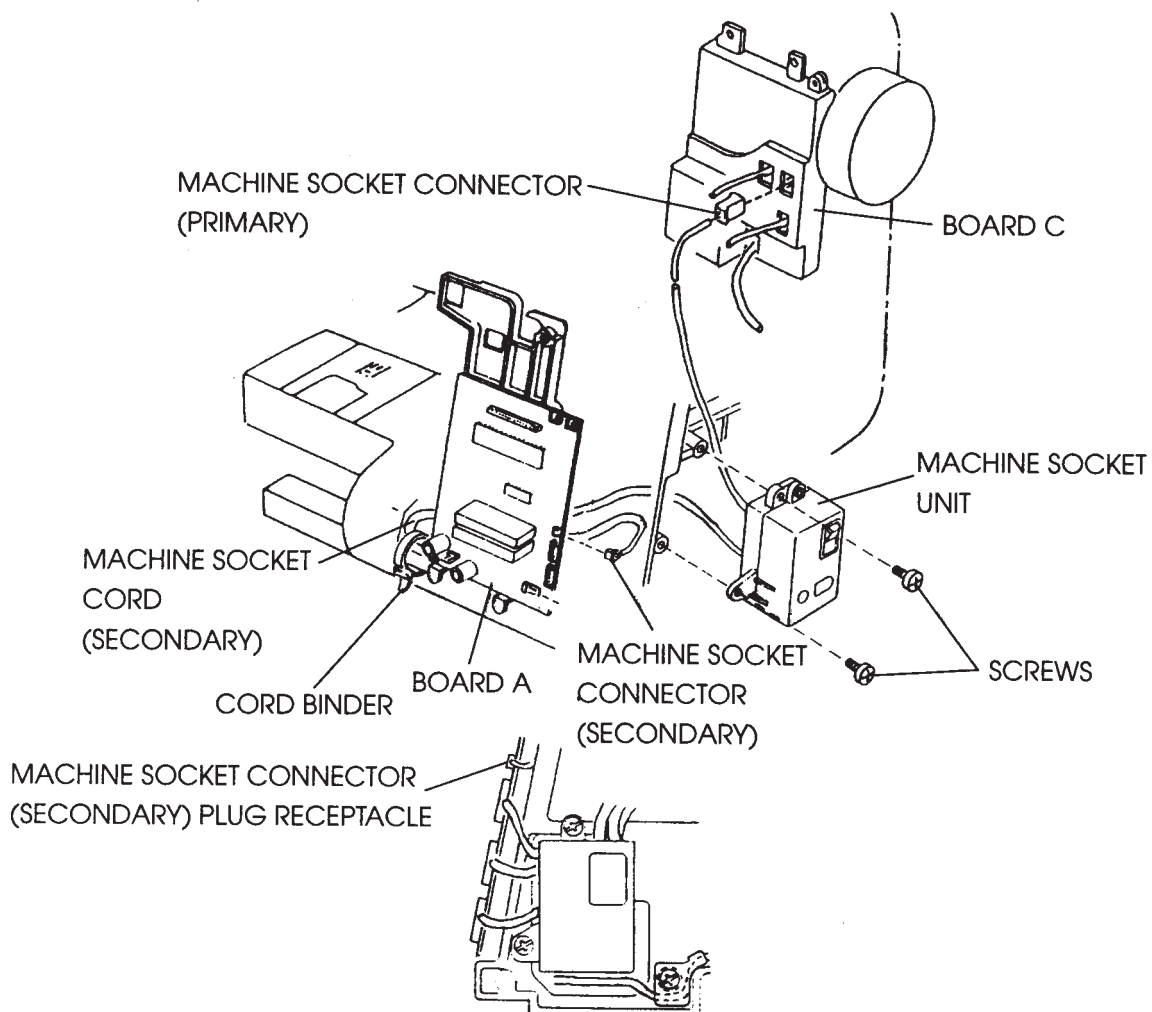
MACHINE SOCKET UNIT ATTACHING AND REMOVING

To remove:

1. Remove the front panel unit, board C and base unit.
2. Cut off the cord binder and pull out the connectors from boards A and C.
3. Remove 2 screws and machine socket unit.

To attach:

4. Attach the machine socket unit with 2 screws.
5. Secure the cords with a cord binder and insert the connectors.
6. Attach the base unit, board C and front panel unit.



BUTTONHOLE LEVER ATTACHING AND REMOVING

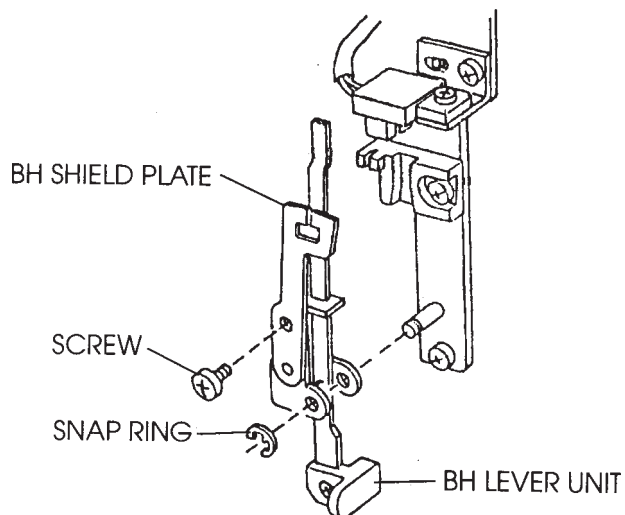
To remove:

1. Remove set screw and buttonhole shield plate.
2. Remove the snap ring.
3. Pull the buttonhole lever toward you, and remove it.

To attach:

4. Insert the shaft into the holes of the buttonhole lever unit (with the buttonhole shield plate removed), and attached the buttonhole lever with the snap ring.
5. Attach the buttonhole shield plate with the screw.

Note: After changing the buttonhole lever unit adjust the buttonhole lever (see page 16).



BOARDS F AND K ATTACHING AND REMOVING

Board K

To remove:

1. Remove the front panel unit (see page 4).
2. Remove the 9 screws.
3. Pull out the connector from board F and remove board K.

To attach:

4. Follow the above procedure in reverse.

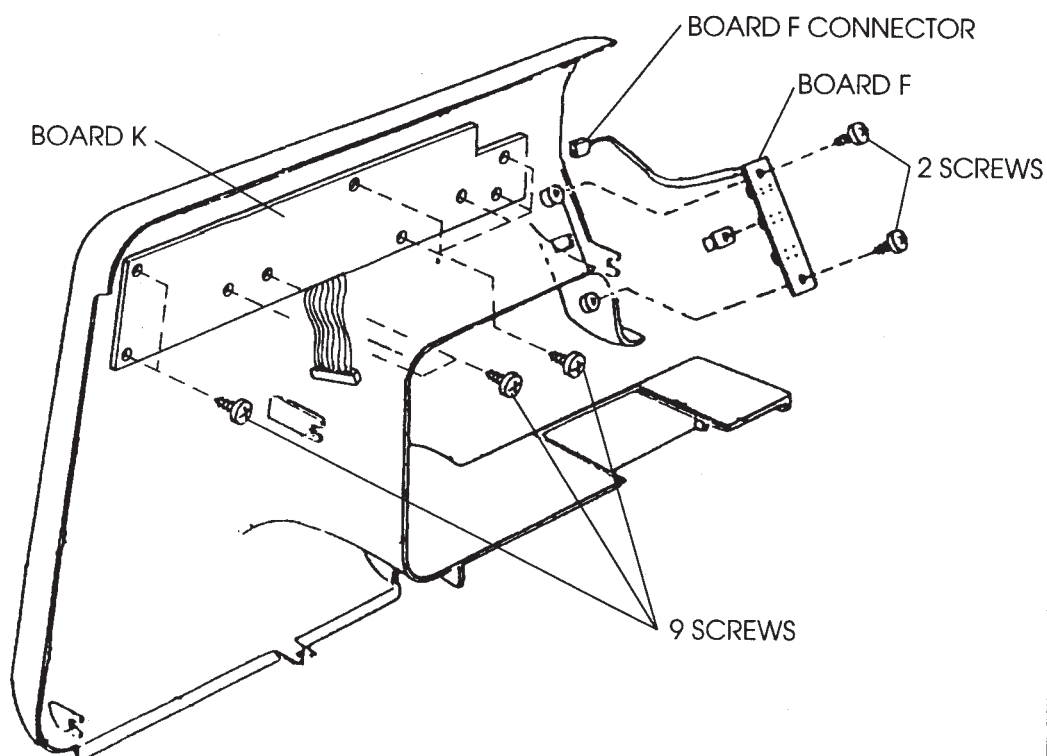
Board F

To remove:

1. Remove the front panel unit (see page 4).
2. Pull out the connector from board F. Remove 2 screws and board F,

To attach:

3. Follow the above procedure in reverse.



BUTTONHOLE SENSOR ATTACHING AND REMOVING BUTTONHOLE SENSOR UNIT

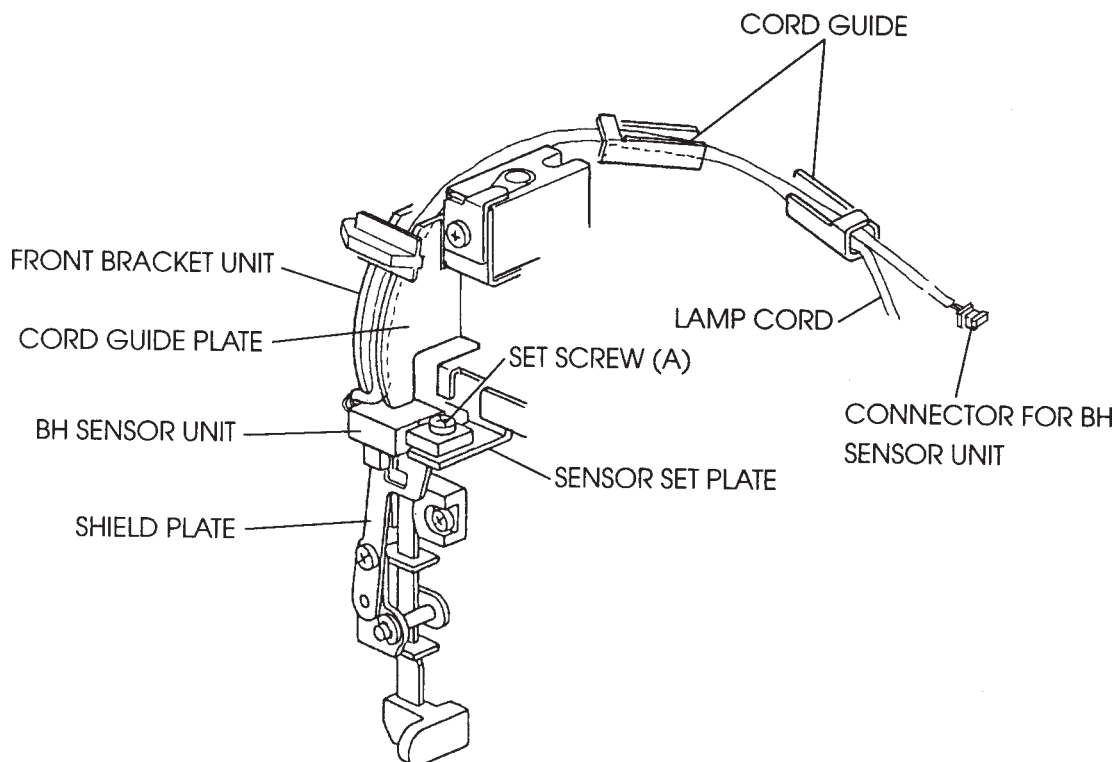
To remove:

1. Remove the front panel (see page 4).
2. Remove screw (A) and remove the buttonhole sensor unit from the sensor set plate.
3. Pull out the connector of buttonhole sensor unit from the board K.
4. Pull out the cord of buttonhole sensor unit from cord guide and remove the buttonhole sensor unit.

To attach:

5. Insert the buttonhole sensor cord through the front bracket unit and cord guide plate and the two cord guides.
6. Insert the buttonhole sensor unit connector into board K.
7. Attach the buttonhole sensor unit to the sensor set plate and adjust so that the shield plate does not touch the buttonhole sensor unit when moving.
8. Tighten screw (A).
8. Attach the front panel unit.

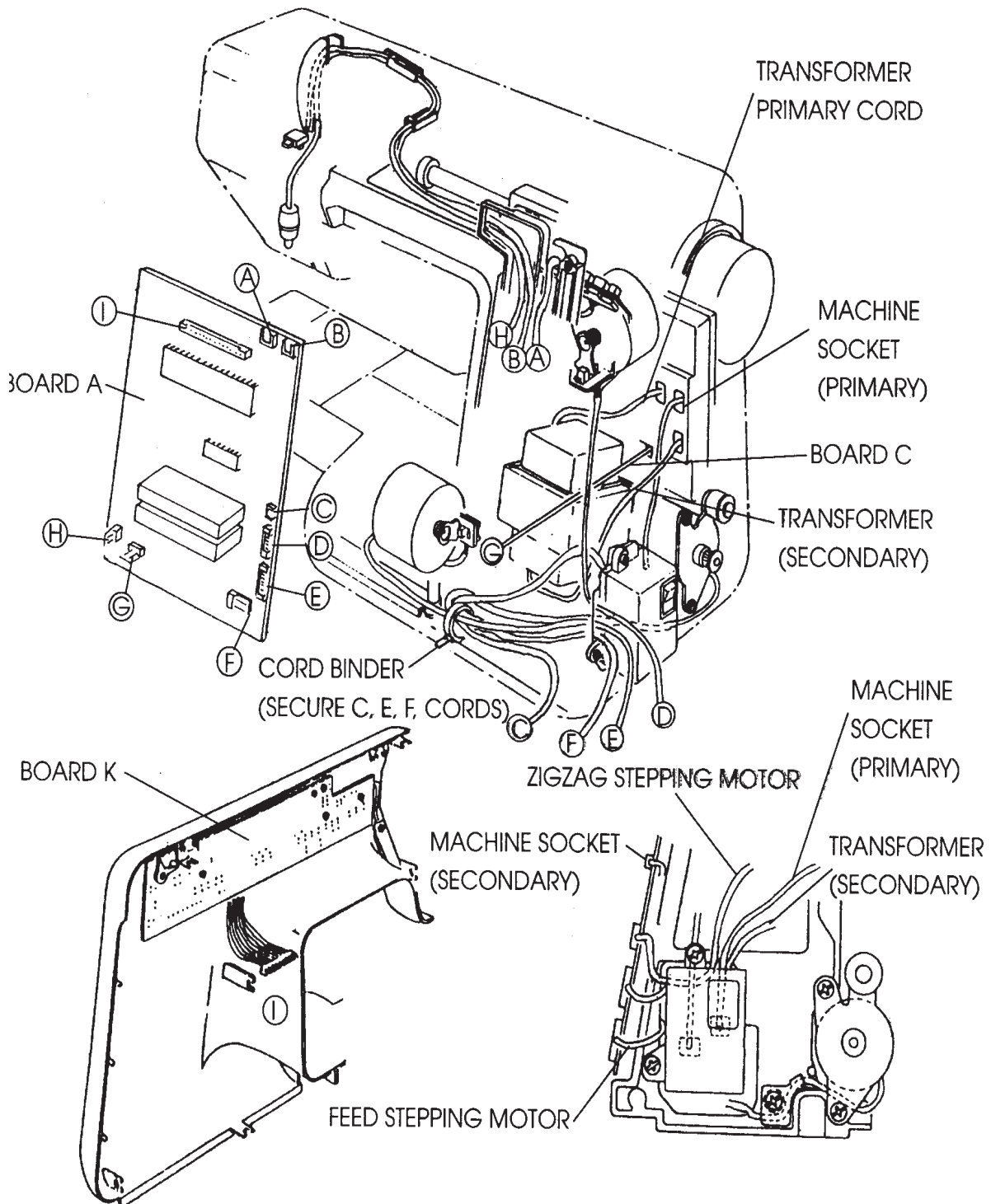
Note: when replacing the buttonhole sensor unit check the adjustment of the buttonhole lever (see page 16).



WIRING DIAGRAM

The connectors of the electrical components should be connected to the respective positions shown in the figure below.

- | | |
|---|--|
| <ul style="list-style-type: none"> A. Upper shaft sensor B. Buttonhole sensor C. Machine socket (secondary circuit) D. Zigzag stepping motor unit | <ul style="list-style-type: none"> E. Feed stepping motor unit F. DC motor unit G. Board C H. Lamp socket unit I. Board K |
|---|--|



MEMORY CRAFT 3500 DIAGNOSIS CHART

(Procedure 1)

If nothing happens on the machine when turned on the power switch is, turn off the power switch and do following:

1. Check all wire connections and recheck.
2. Replace the machine socket and recheck.
3. Replace board A and recheck.
4. Replace board d and recheck.
5. Replace the transformer unit and recheck.

If lamp bulb does not light when the power switch is turned on, turn off the power switch and do following:

1. Replace the lamp bulb and recheck.
2. Replace board A and recheck.

If LCD (liquid crystal display) shows nothing when power switch is turned on,

1. Replace LCD unit and recheck.
2. Replace board K and recheck.
3. Replace board A and recheck,

Note: when checking operation the machine may suddenly start running. For your safety, turn off the power switch when replacing any parts. Always recheck after replacing defective parts.

(Procedure 2) - use of diagnosis chart

Preparation:

1. Turn off the power switch.
2. Push the bobbin winder spindle to the left.
3. Detach the presser foot and raise the presser foot lever,
4. Raise needle bar all the way up.
5. Connect the foot controller.

Note: If a defect was found in step 01, do not proceed to further steps.

Turn off the power switch and do following:

1. Replace LCD unit and recheck.
2. Replace board K and recheck.
3. Replace board A and recheck.

If a defect was found in step 02, you cannot proceed further.

Turn off the power switch and do following:

1. Replace board F and recheck,
2. Replace board K and recheck.
3. Replace board A and recheck.

Note: during diagnosis, press the memory key when the correct result is obtained and press the clear key if the result is incorrect to proceed to the next step,

MEMORY CRAFT 3500 DIAGNOSIS CHART (NO.2)

STEP	TEST OPERATION	CORRECT CONDITION	DEFECT CONDITION & CORRECTION
01) LCD, LED TEST	TURN ON THE POWER SWITCH WHILE PRESSING THE REVERSE STITCH KEY. THEN PRESS THE AUTO-LOCK KEY WITHIN 2.5 SECONDS. (MACHINE RUNS NORMALLY IF THE AUTO-LOCK KEY IS PRESSED TOO LATE.)	1. LCD SHOWS (840 TEST MODE). 2. LCD SHOWS (SELF-CHECK START). 3. BUZZER SOUNDS. LCD  → FLASHING ↕ REPEAT  → NOT FLASHING	IF UNABLE TO ENTER TEST MODE, REPLACE THE FOLLOWING PARTS AND RECHECK: 1. BOARD F 2. BOARD K 3. BOARD A
02) KEY TEST	PRESS THESE KEYS IN THE FOLLOWING ORDER: REVERSE STITCH, STITCH WIDTH +, -, STITCH LENGTH +, -. THEN PRESS THE REMAINING KEY FROM LEFT TO RIGHT AND TOP BOTTOM.	1. BUZZER SOUNDS. 2. LCD SHOWS (KEY). 3. EACH TIME YOU PRESS THE KEY, THE BUZZER SOUNDS.	IF NO BUZZER SOUNDS WHEN YOU PRESS A KEY: REPLACE THE FOLLOWING PARTS AND RECHECK: 1. BOARD F 2. BOARD K 3. BOARD A
03) BH SENSOR TEST	1. PULL DOWN THE BH LEVER. 2. MOVE THE BH LEVER TO FRONT AND BACK.	1. BUZZER SOUNDS AND LCD SHOWS (BH SENSOR L). 2. LCD SHOWS...H (HIGH) 3. LCD SHOWS...L (LOW)	IF NOT WORKING CORRECTLY, REPLACE THE FOLLOWING PARTS AND RECHECK: 1. BH SENSOR UNIT 2. BOARD K 3. BOARD A
04) BOBBIN WINDER SWITCH TEST	1. PUSH BOBBIN WINDER SPINDLE TO RIGHT POSITION. 2. PUSH BOBBIN WINDER SPINDLE TO LEFT POSITION.	EACH TIME THE BUZZER SOUNDS AND LCD SHOWS (SPOOL).	IF NOT WORKING CORRECTLY, REPLACE THE FOLLOWING PARTS AND RECHECK: 1. BOARD K 2. BOARD A
05) UPPER SHAFT POSITIONING SENSOR TEST	TURN THE HANDWHEEL TOWARD YOU TO MOVE THE NEEDLE BAR TO THE HIGHEST POSITION, THE LOWEST POSITION AND FINALLY THE HIGHEST POSITION AGAIN.	1. BUZZER SOUNDS AND LCD SHOWS (PH SENSOR H. H.) 2. LCD SHOWS (PH SENSOR L. H.) AT HIGHEST NEEDLE POSITION. 3. LCD SHOWS (PH SENSOR H. L.) AT HIGHEST NEEDLE POSITION (AFTER ONE ROTATION).	IF NOT WORKING CORRECTLY, REPLACE THE FOLLOWING PARTS AND RECHECK: 1. UPPER SHAFT SENSOR UNIT 2. BOARD A
06) ZIGZAG STEPPING MOTOR TEST	TURN THE HANDWHEEL TOWARD YOU TO MOVE THE NEEDLE BAR TO THE HIGHEST POSITION. THEN PRESS THE REVERSE STITCH KEY.	1. BUZZER SOUNDS AND LCD SHOWS (ZIGZAG MOTOR). 2. ZIGZAG STEPPING MOTOR RETURNS TO DEFAULT POSITION.	IF NOT WORKING CORRECTLY, REPLACE THE FOLLOWING PARTS AND RECHECK: 1. ZIGZAG STEPPING MOTOR 2. BOARD A
07) FEED STEPPING MOTOR TEST	TURN THE HANDWHEEL TOWARD YOU TO MOVE THE NEEDLE BAR TO THE LOWEST POSITION AND PRESS THE REVERSE STITCH KEY.	1. BUZZER SOUNDS AND LCD SHOWS (FEED MOTOR). 2. FEED STEPPING MOTOR RETURNS TO DEFAULT POSITION.	IF NOT WORKING CORRECTLY, REPLACE THE FOLLOWING PARTS AND RECHECK: 1. FEED STEPPING MOTOR 2. BOARD A
08) FOOT CONTROLLER TEST	PRESS FOOT CONTROLLER FULLY AND RELEASE IT.	1. BUZZER SOUNDS AND LCD SHOWS (CONTROLLER). 2. BUZZER SOUNDS WHEN YOU RELEASE THE FOOT CONTROLLER.	IF NOT WORKING CORRECTLY, REPLACE THE FOLLOWING PARTS AND RECHECK: 1. FOOT CONTROL UNIT 2. MACHINE SOCKET UNIT 3. BOARD A
09) DC MOTOR TEST	PRESS THE REVERSE STITCH KEY.	1. BUZZER SOUNDS AND LCD SHOWS (DC MOTOR). 2. MACHINE RUNS SLOW, THEN FAST AND STOPS.	IF THE NEEDLE DOES NOT STOP IN THE HIGHEST POSITION OR IF IT RUNS AT UNEVEN SPEED, REPLACE DC MOTOR UNIT BOARD A. FOR DEFECTS OTHER THAN THE ABOVE, REPLACE THE FOLLOWING PARTS AND RECHECK: 1. DC MOTOR 2. BOARD C 3. TRANSFORMER UNIT

NOTE: WHEN ALL STEPS ARE COMPLETED, LCD SHOWS (SELF-CHECK END)
IF EVERYTHING WAS OK.....LCD SHOWS (CHECK OK)
IF ONE OR MORE ERRORS OCCURRED...LCD SHOWS (ERROR---A)(EXAMPLE)

"A" MEANS BOARD A. THE LETTERS HAVE THE FOLLOWING MEANING;

B...BH SENSOR	K...BOARD K
C...FOOT CONTROLLER	P...UPPER SHAFT POSITIONING SENSOR
D...DC MOTOR	R...MACHINE SOCKET
X...ZIGZAG STEPPING MOTOR	Y...FEED STEPPING MOTOR

MULTIPLE LANGUAGE FUNCTION

The display language can be changed if necessary, as illustrated bellow.

1. Remove the top cover unit,
2. Move the DIP switches with the end of the lint brush (example).
3. Replace the top cover unit after adjustment.

