
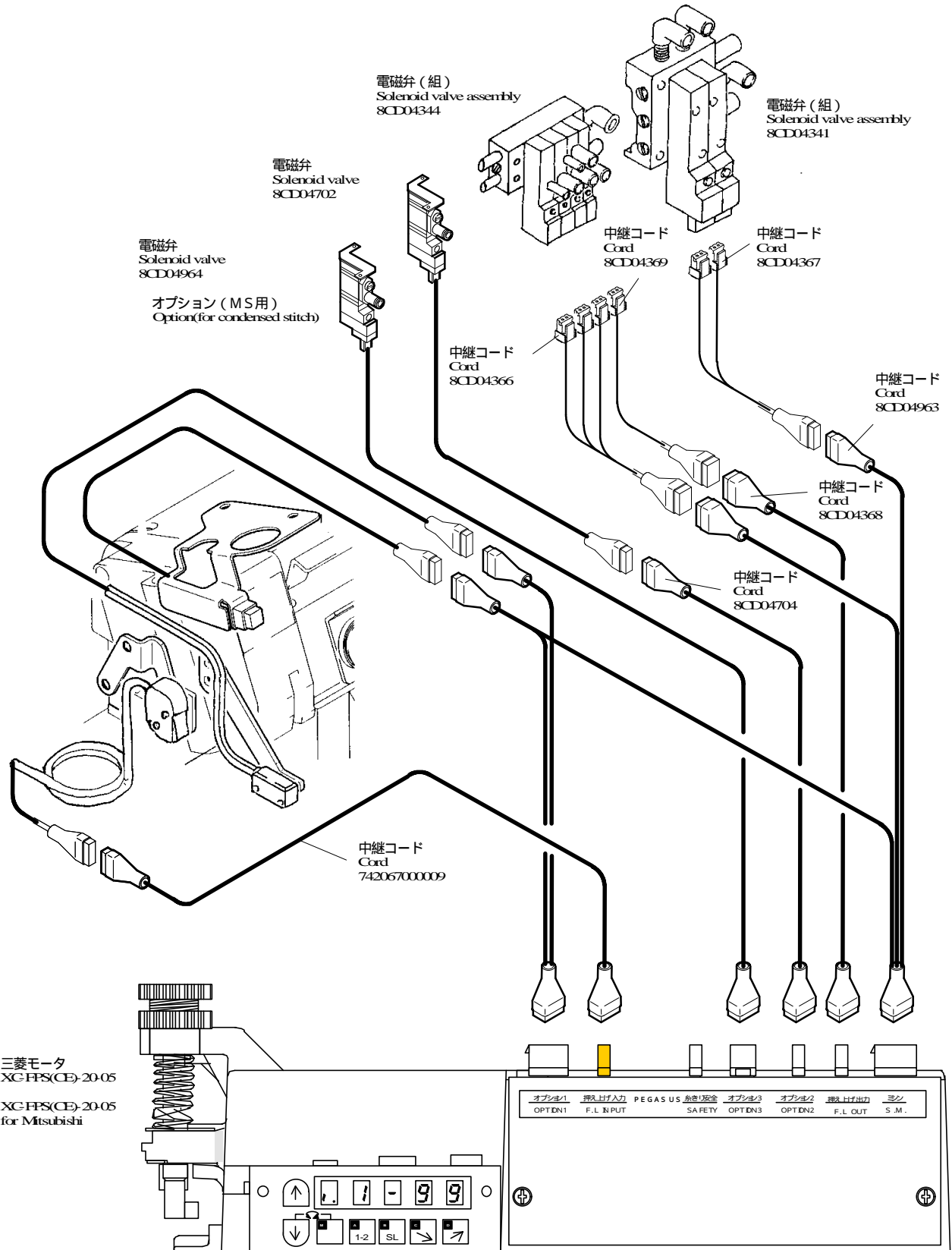


Installation


Connecting the cords

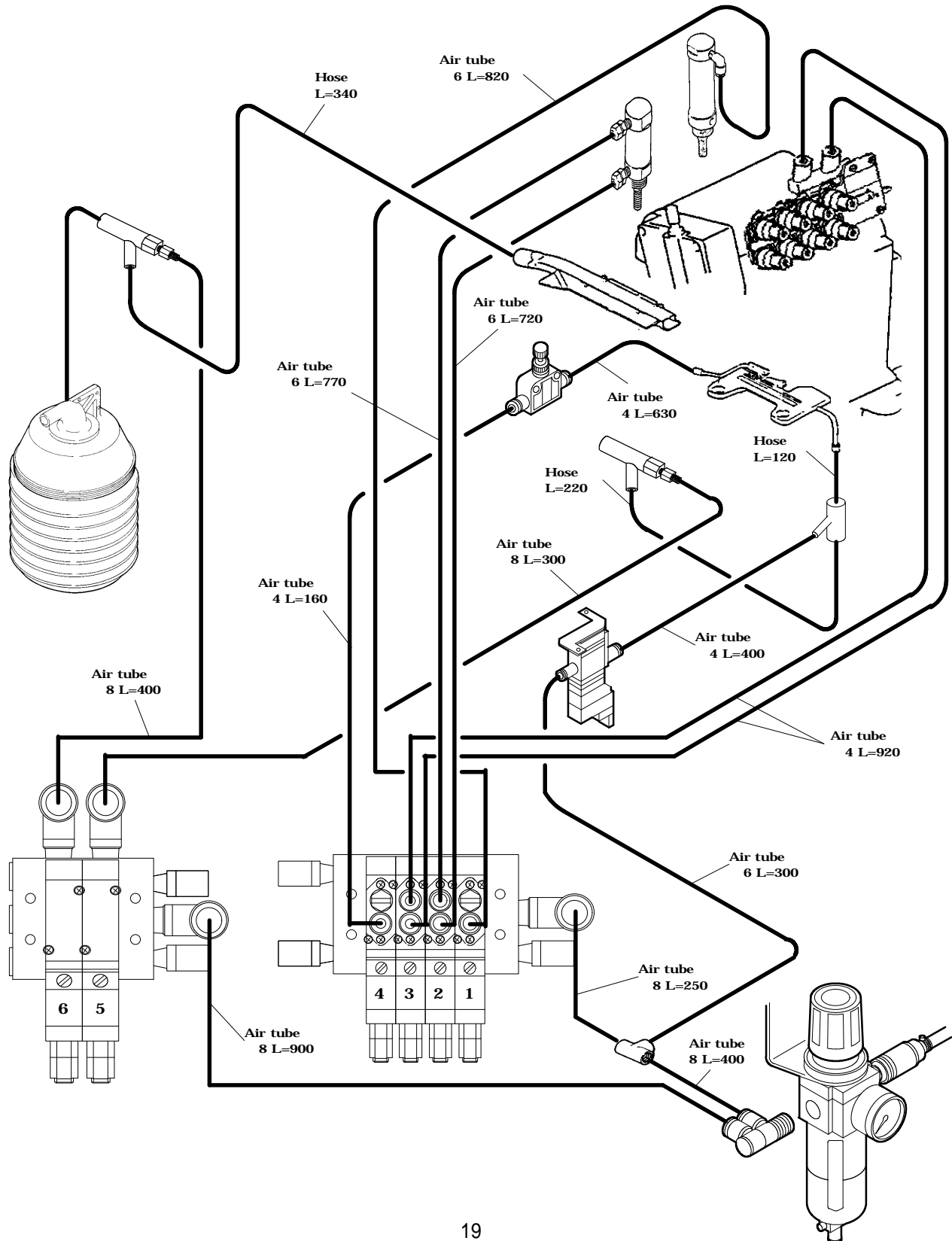
Connect the codes as shown below.  Always turn OFF the first and then connect the cords to the connectors while checking each color and shape.



Installation

Connecting the air lines

Connect the codes as shown below.  Always turn OFF the first and then connect the cords to the connectors while checking each color and shape.



BL

9 0 1Series

Integrated sewing unit for closing sleeves

Programing the sewing data of insert for Mitsubishi XC-FPS(CE)

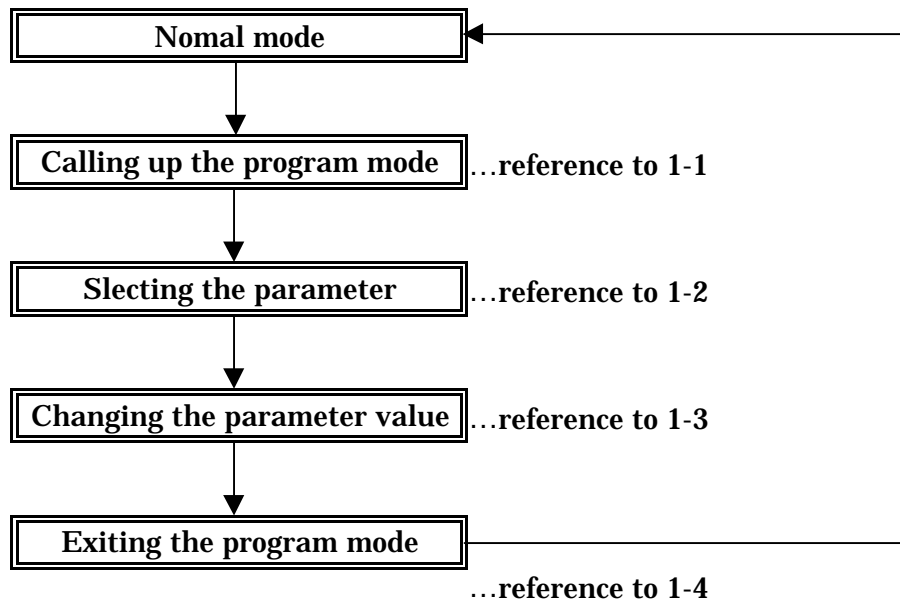


Operating the control box for Mitsubishi XC-FPS

Operating the control box for Mitsubishi XC-FPS

1. Access to programming

The modification of function is changed as shown in the following diagram.

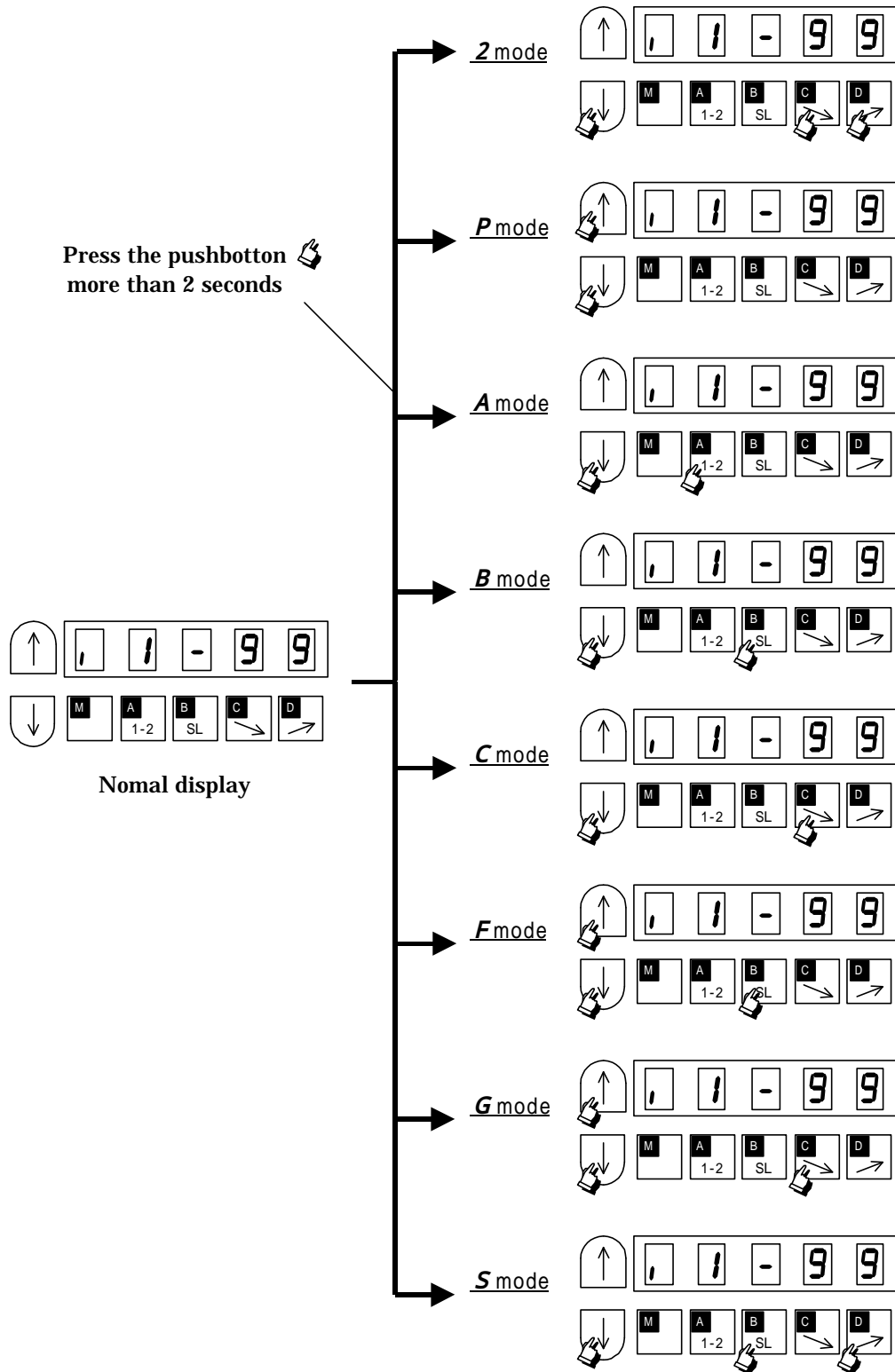


Basic adjustment

Operating the control box for Mitsubishi XC-FPS

1-1 Calling up the program mode

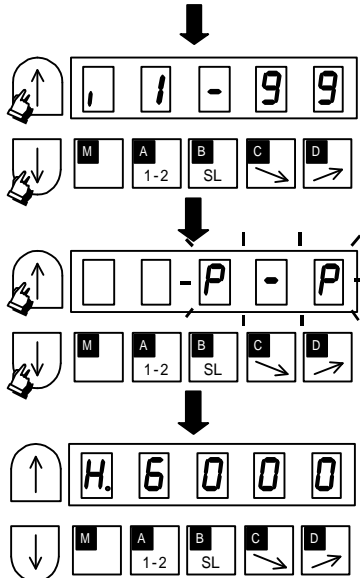
The program mode is changed by pressing the pushbottons  follows.



Basic adjustment

Operating the control box for Mitsubishi XC-FPS

Ex.) Presser foot lifts up automatically after trimming.
Turn the power on.

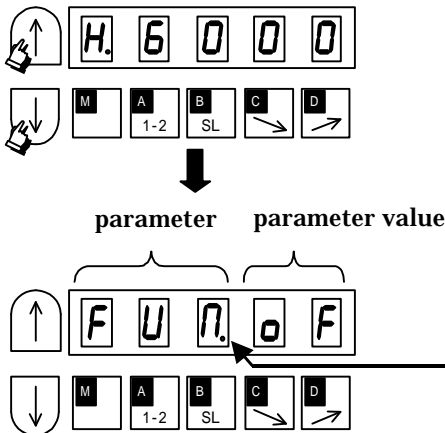


Call up the program mode[P]

The display will flicker.

The first parameter and the value of program mode is displayed.

1-2 Selecting the parameter

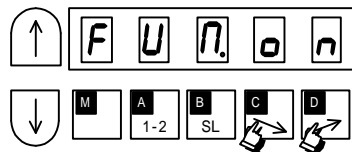


Select the parameter by pressing [] key or [] key several times.

The selected parameter is displayed.

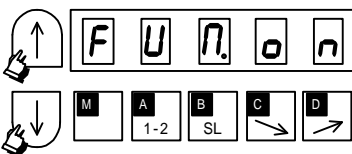
The left side is "parameter" from this point.
The right side is "parameter value" from this point.

1-3 Changing the parameter value



Change the parameter value by pressing [C]key or [D]key several times.

1-4 Exiting the program mode






Return the normal mode by pressing [] key and [] key.

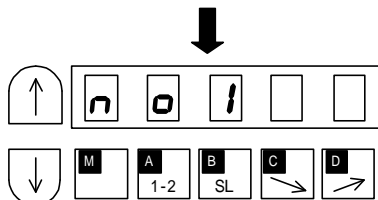
Basic adjustment

Operating the control box for Mitsubishi XC-FPS

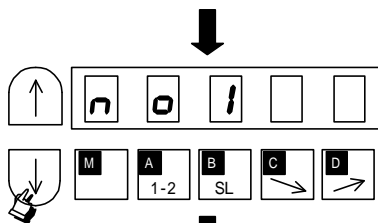
2. Selection of BL sequence


BL900 sequence can be selected by program mode 2.

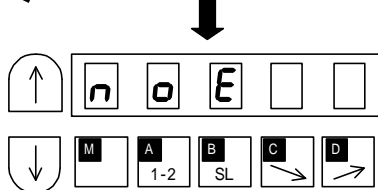
Call up program mode[2](pressing ,  and  more than two seconds)



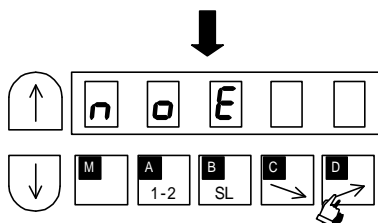
Display after calling up program mode



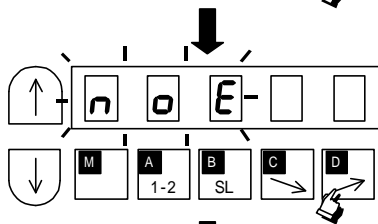
Select the sequence **noE** by pressing pushbutton  about 10 times.



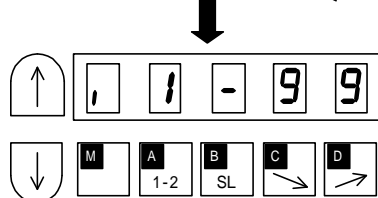
The selected parameter is displayed.



Press pushbutton  more than 2 seconds



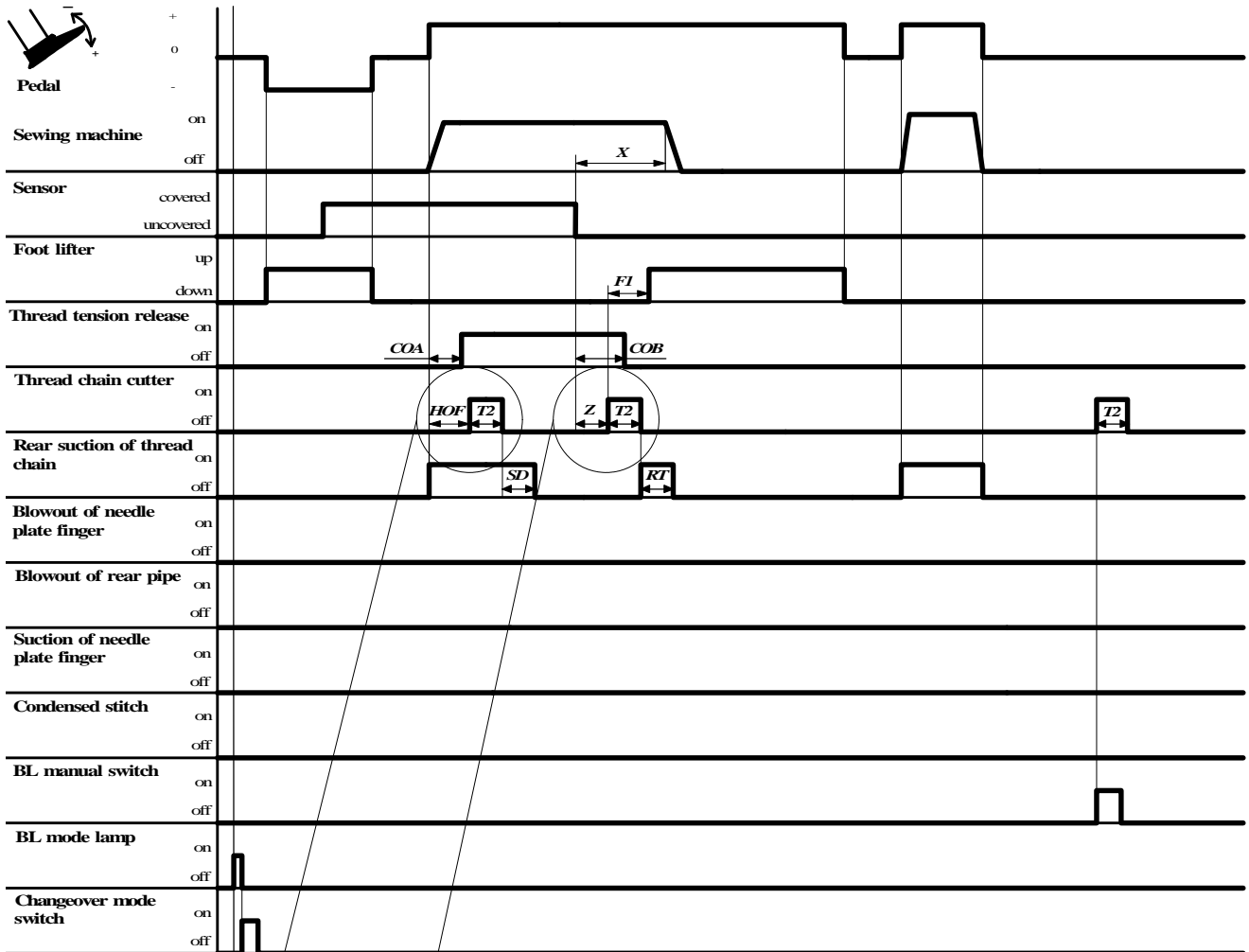
The display will flicker.



Return the normal mode automatically.
Complete to set up.

Basic adjustment

Timing chart (Plain sewing)

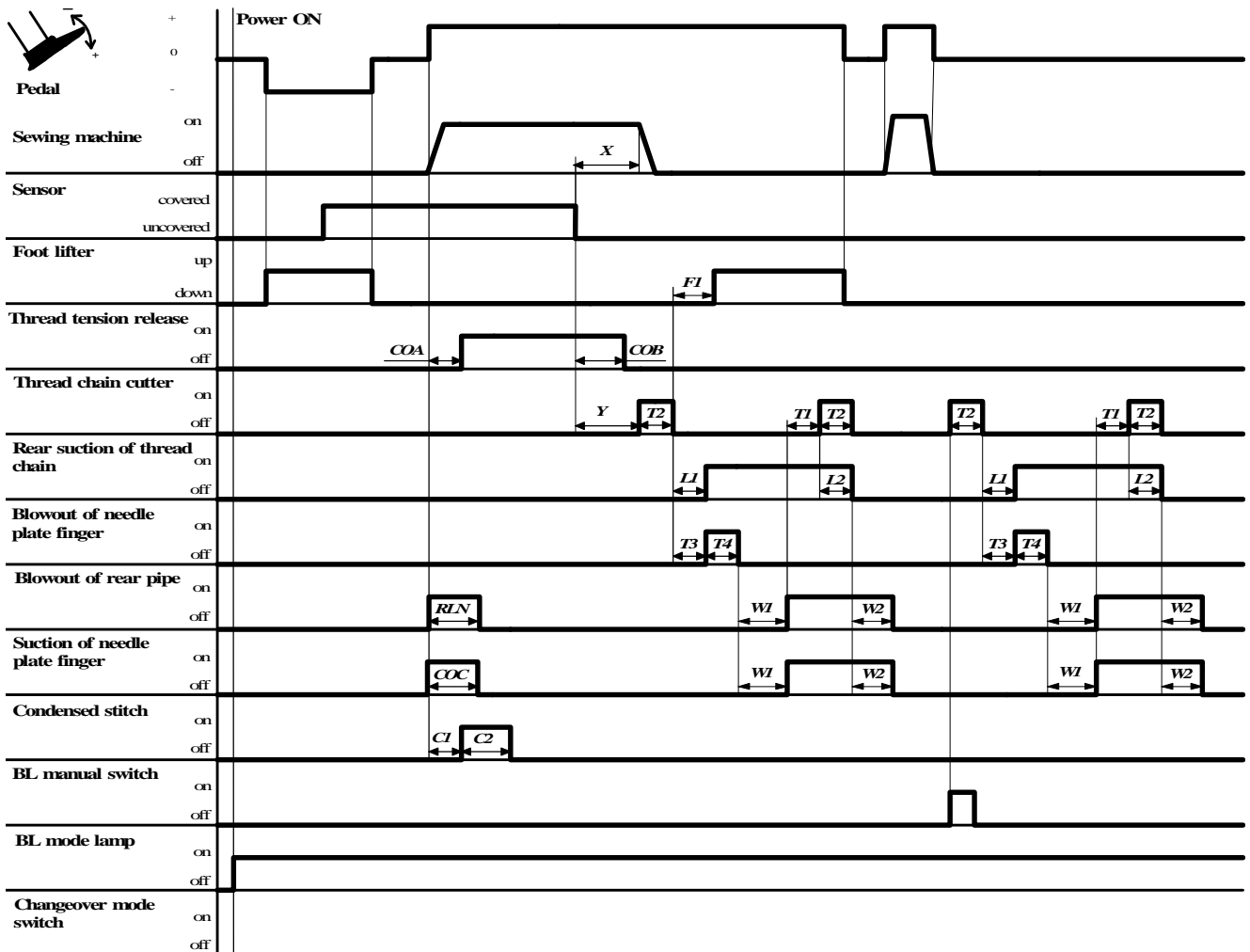


In case of parameter "CSC=on", thread chain cutter does not output at start sewing.
 In case of parameter "CEC=on", thread chain cutter does not output at end sewing.

Program mode	Function	Parameter	Value
mode[P]	Maximum speed	H.	6000(rpm)
mode[F]	Counting until thread tension release "on"	COA.	2 (stitches)
	Counting until thread tension release "off"	COB.	6 (stitches)
	Counting machine stop	X.	35 (stitches)
	Counting until thread chain cutter "on" at end sewing	Z.	15 (stitches)
	Mesh timer for sensor	ED.	0 (ms)
	Function of canceling thread chain cutter at start sewing	CSC.	OF
	Function of canceling thread chain cutter at end sewing	CEC.	OF
	Activation time of rear suction of thread chain at start sewing	SD.	100(ms)
mode[G]	Activation time of thread chain cutter	T2.	50 (ms)
	Delay time of foot lifter	FI.	0 (ms)
	Activation time of rear suction of thread chain at end sewing	RT.	250 (ms)
	Counting until thread chain cutter at start sewing	HOF.	5 (stitches)

Basic adjustment

Timing chart (Backlatch)



Program mode	Function	Parameter	Value
mode [P]	Maximum speed	H	6000(rpm)
mode [F]	Counting until thread tension release "on"	COA.	2 (stitches)
	Counting until thread tension release "off"	COB.	6 (stitches)
	Counting suction of needle plate finger at start sewing	COC.	15 (stitches)
	Counting machine stop	X.	35 (stitches)
	Counting thread chain cutter "on" after sensor uncovered	Y.	20 (stitches)
	Counting blowout of rear pipe at start sewing	RLN.	3 (stitches)
	Mesh timer for sensor	ED.	0 (ms)
mode [G]	Delay time of second thread chain cutter	T1.	100 (ms)
	Activation time of thread chain cutter	T2.	50 (ms)
	Delay time of rear suction of thread chain	L1.	20 (ms)
	Activation time of rear suction of thread chain	L2.	50 (ms)
	Delay time of suction of needle plate finger	W1.	250 (ms)
	Activation time of suction of needle plate finger	W2.	15 (x10ms)
	Delay time of foot lifter	F1.	0 (ms)
	Delay time of blowout of needle plate finger	T3.	20 (ms)
	Activation time of blowout of needle plate finger	T4.	100 (ms)
	Counting until condensed stitch "on" at start sewing	CI.	2 (stitches)
	Counting condensed stitch at start sewing	C2.	10 (stitches)
	Foot lifter mode on:auto of:manual	PET.	oF

Basic adjustment

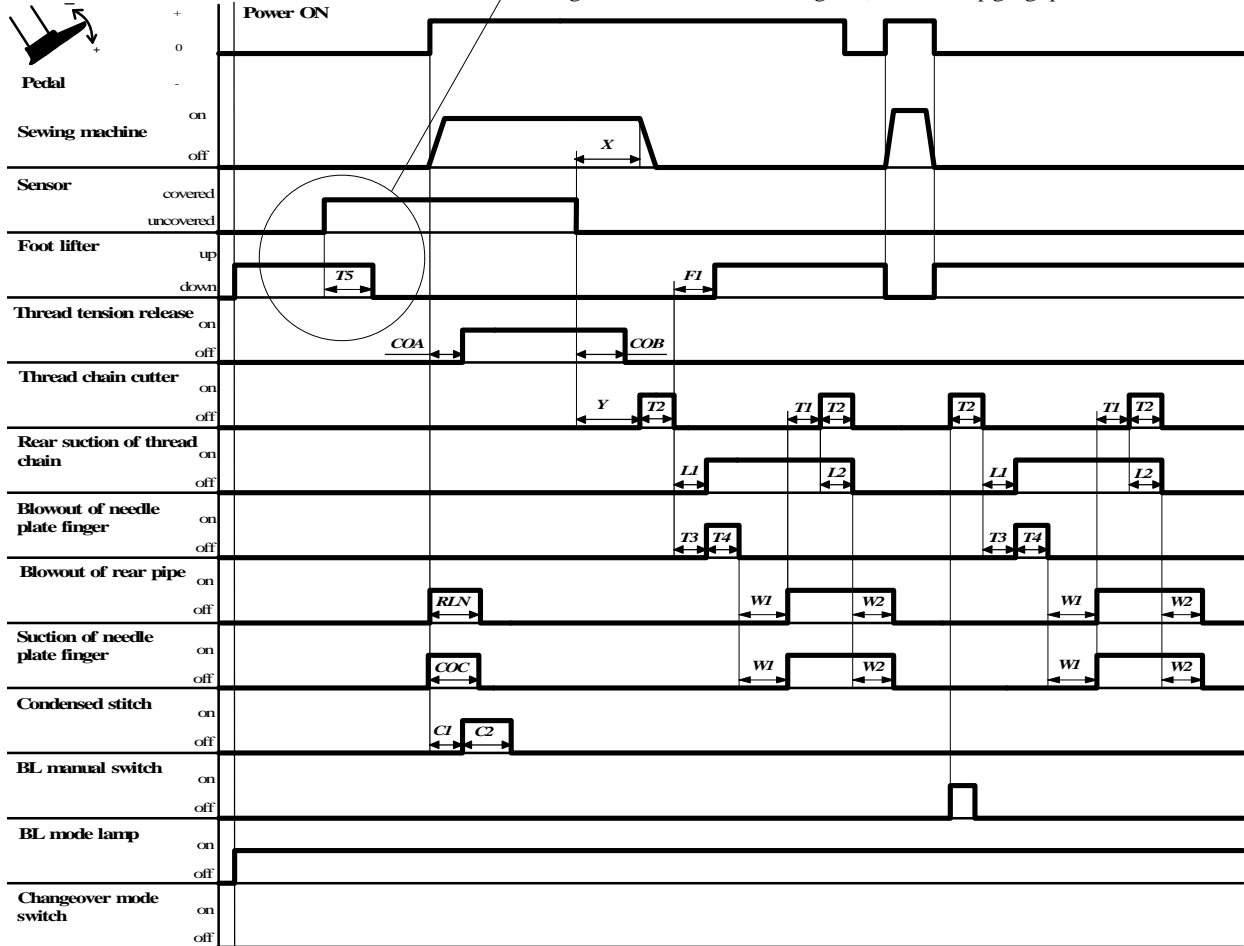
Timing chart (Backlatch)

Auto foot lifter mode

Parameter PET=on

By changing parameter PET=on, foot lifter is operated as follows.

1. Foot lifter keeps going up after power on.
2. If there is a fabric under the sensor, foot lifter goes down after counting "T5".
If get rid of a fabric before counting "T5", foot lifter keep going up.



Program mode	Function	Parameter	Value
mode[P]	Maximum speed	H	6000(rpm)
mode[F]	Counting until thread tension release "on"	COA	2 (stitches)
	Counting until thread tension release "off"	COB	6 (stitches)
	Counting suction of needle plate finger at start sewing	COC	15 (stitches)
	Counting machine stop	X	35 (stitches)
	Counting thread chain cutter "on" after sensor uncovered	Y	20 (stitches)
	Counting blowout of rear pipe at start sewing	RLN	3 (stitches)
	Mesh timer for sensor	ED	0 (ms)
mode[G]	Delay time of second thread chain cutter	T1	100 (ms)
	Activation time of thread chain cutter	T2	50 (ms)
	Delay time of rear suction of thread chain	L1	20 (ms)
	Activation time of rear suction of thread chain	L2	50 (ms)
	Delay time of suction of needle plate finger	W1	250 (ms)
	Activation time of suction of needle plate finger	W2	150 (ms)
	Delay time of foot lifter	F1	0 (ms)
	Delay time of blowout of needle plate finger	T3	20 (ms)
	Activation time of blowout of needle plate finger	T4	100 (ms)
	Counting until condensd stitch "on" at start sewing	T5	500 (ms)
	Counting until condensd stitch "on" at start sewing	C1	2 (stitches)
	Counting condensed stitch at start sewing	C2	10 (stitches)
	Foot lifter mode on:auto of:manual	PET	on