

SHDA-SK550A Operation Specifications

I Instructions of Marks on Screen Display






Program mark: containing 100 (0-99) program codes for storage.



Mark of number of segments: 3 to 15 segments available for option, which means that one armhole can be finished by 3 to 15 segments of stitching.



Mark of each segment setup: standing for the setup for every segment when armhole has been segmented. When sewing begins after setup is finished,  1 means to sew from segment 1;  2 means

segment 2 is being sewn, and the rest can be done in the same manner. When it is set in , the second armhole will be sewn reversely from the last segment you set as the first segment.



Mark of wrinkling value: the wrinkling value set for a certain segment, range of setup between 0.0-15.



Mark of number of stitches: the number of stitches required for a certain segment (under automatic stitching), range of setup between 0-255. Under the state of semiautomatic stitching, it is set in 0.



Mark of stitch length: the size of stitch length, range of setup between 1.5-5.5mm.



Mark of semiautomatic stitching: means that when the first segment is finished and the second segment begins, act on the knee controlled segment converter with the right leg to proceed to the second segment. There will be sound of beep, and the first segment in the circle diagram will turn into red lines.



Mark of automatic stitching: means that when setup of number of segments, wrinkling value and number of stitches for each segment is done, fully automatic stitching may be realized.



: On state of automatic scissors



: Off state of automatic scissors




: Loosened state of auxiliary tension disc




: Clamped state of auxiliary tension disc





: Sewing on left sleeve only


 : Sewing on right sleeve only

 : Automatic switchover of left and right sleeves


 : The switchover between the two program codes in series operation (automatically)



 : Programs in series, there being 10 numbers from 0 to 9 (subprograms)



 : The program in series is no. 0 (it may be used to stand for left sleeve)



 : The program in series is no. 0 (it may be used to stand for right sleeve)

II Instructions of keystroke function:






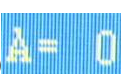




 Reset key: press reset key to reset in case of error occurred on display screen.


 Select key: selection between automatic segment skipping  or semiautomatic segment skipping

 and automatic trimming on  or trimming off. It is defaulted as semiautomatic segment skipping

 and automatic trimming on .

 Select key: selection set key of left sleeve only , right sleeve only , automatic switchover of left and right sleeves , or series program .

 Select key: when selecting series program  setup, press  to enter into  setup, press  to enter into ,  and  setup, press  and  for plus and minus of digits.


 Select key: access to control mode. It is unable to enter into control mode when machine is under stitching state. Only when backpedal (finished automatic trimming) ends stitching, it can enter into control mode.

 Plus key: being automatic segment skipping  select key under .

 Minus key: being semiautomatic segment skipping  select key under .







 Left arrow: under the state of , press  to select program A.

 Right arrow: under the state of , press  to select program B.

 Enter key, escape key.

Note: ,  and  are alternate keys that are not needed to operate. If  is pressed by mistake, press  to escape.




III Instructions of practical operation:
































Press  into program code setup,  to move the cursor into setup of segment number, press  into first segment setup,  into the setup of wrinkling value in the first segment,  into setup of stitch number in the first segment (only needed under the state of automatic stitching),  into stitch length setup (the size of stitch length needs only one-time setup).



e.g. 1:

Setup of a new program: code into 0, segment number into 8, stitch length into 2.4.

Wrinkling value set into 0.0 in the first segment, 3.0 in the second, 1.5 in the third, 0.0 in the fourth, 4.0 in the fifth, 1.5 in the sixth, 3.0 in the seventh, 0.0 in the eighth, instructions as following:

Press ,  flashes, press  or  to set into 0. Here, the setup of program code is finished. Press ,  flashes, press  or  to set into 8. Here, the setup of segments is finished. Press ,  flashes, press  or  to set into 1. Press ,  flashes, press  or  to set into 0.0. Press ,  flashes, press  to set into 2. Press  to change  value into 3.0. (Here, wrinkling value is up, while stitch may be too loose). Press ,  flashes. (Here, press  to make auxiliary tension disc clamped, and screen will display ). Change the value into 3. It is normal to hear auxiliary tension disc loosened here, and there is no need to press  to

clamp. Press  to change  into 1.5, press  to change  into 4, and press  to change  into 0.0. Press ,  flashes, change the value into 5. Press  to change  into 4.0. Press ,  flashes, press , and press  to change  into 6, press  to change  into 1.5, press  to change the value into 7, press  to change  into 3.0. Press ,  flashes. press  to clamp the auxiliary tension disc, and change  into 8. Press  to change  into 0.0. Press  to move the cursor onto , press  or  to set the value into 2.4, press  to enter and escape.

Note: when wrinkling value is greater than or equal to 3.0, the auxiliary tension disc must be set into clamped state. When wrinkling is none or less than 3.0, open the auxiliary tension disc. If left and right sleeves are to be sewn from the same starting point, press  to set into .

e.g. 2





Setup of series program code:

Left sleeve: 0.0-1.0-3.0-0.0-3.0-1.5-0.0

Right sleeve: 3.0-0.0-3.0-1.5-0.0-0.0-1.0

Press , repress  till  is appeared at the bottom of the screen.

Follow the steps in e.g. 1 to set the value of left sleeve into any a number between 0-99, and set the value of right sleeve into any a program code not the same as that of the left.

E.g.: set the left sleeve into program 0 and right sleeve into program 99. Press  and then  to set A into A=0, press  to set B into B=99, then press  to finish.

IV Control pedal

1. Control pedal comprises front, neutral, rear I and rear II positions. The front controls the speed of stitching, rear I raises the presser, while rear II represents stitching ended and trimming finished (under the

state of ).

22. Wrinkling value control pedal is to increase or decrease the wrinkling value in the process of stitching. When stitching is finished, wrinkling value will resume. Step forward once and relax the left foot, wrinkling value will increase 0.5; step backward once and relax the left foot, wrinkling value will decrease 0.5.