



A5 Computerized Lockstitch Machine

product introduction-A series product

JACK 杰克



A3

Followed by A6, etc.



A4



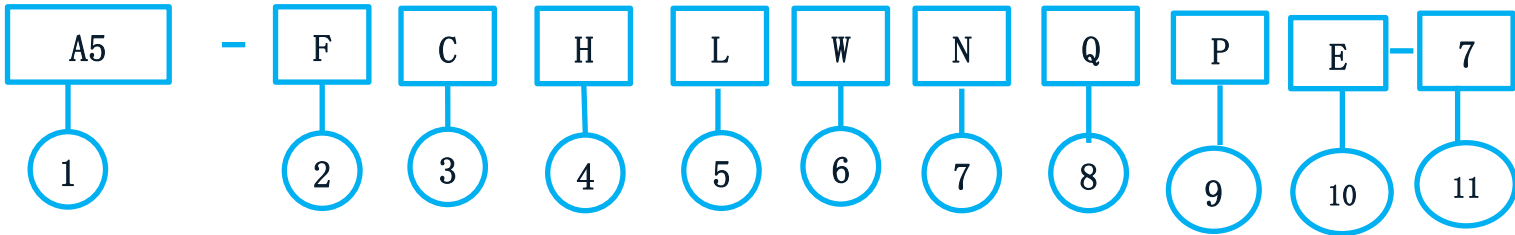
A4S



A5



A5, Jack new generation semi-dry computerized lockstitch machine with shortest remaining thread. It's updates from A4S-N and equipped with semi dry machine head, double knife movement and design of ending condense stitch,



1 model

A2	Computerized lockstitch with auto-trimmer
A2S	Computerized lockstitch with 3 automatic functions
A3	High speed computerized lockstitch
A4	Speaking Computerized lockstitch
A4S	Semi-dry computerized lockstitch machine
A4S-N	Semi-dry computerized lockstitch with bird's nest prevention device
A5	Semi-dry computerized lockstitch with short remaining thread

2 sewing plate

F	Stainless Steel
3	normal
C	chinese hook
4	Japanese hook
A	Light material
H	Heavy material

5 hook type

L	large hook
/	normal hook

6 Machine head

W	Semi-oil
/	With oil

7 Bird's nest prevention device

N	With Bird's nest prevention device
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8 control box

-	Powermax
Q	Qixing
Z	Zobow

9

P	Air suction device
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10

E	Electric suction device
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11

Stitch length

/	5mm
-7	7mm

A5 series parameters

Maximum Speed (rpm)	5000rpm
Stitch length (mm)	5mm
Presser foot height (mm)	9mm (standart) 12mm (max)
Needle type	DBx1 #14
Space for work (mm)	262x128mm

Compared to A4S new function

No.	Product advantages	Advertising
1	Double knives movement	double knife movement and design of ending condense stitch, realize 3mm short thread remaining.
2	assure short thread at the end.	
3	electronic thread tension release	Electronic thread tension release, more efficient
4	Auto Bobbin winder	Automatic winding thread, Save time, high efficiency
5	Bird' s nest prevention	Prevent Bird' s nest, Stitch more beautiful

operating instructions-Factory Reset



P165-0000 change to P165-2115 Reset

Operation steps:

In the power on, press and hold  for 5 seconds, to restore the factory default. When the screen shows , and the screen shows , then panel will display boot screen automatically, which means resets successfully.

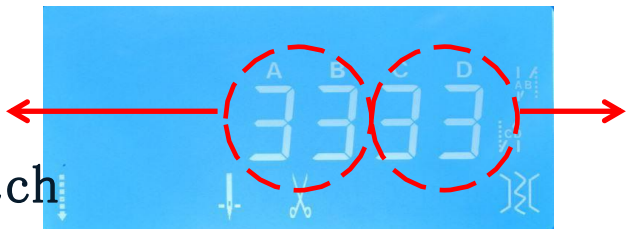
operating instructions-before and after backstitch



operating steps:

In standby mode, press 、 key, Set the number of before and after backstitch

number of
before backstitch



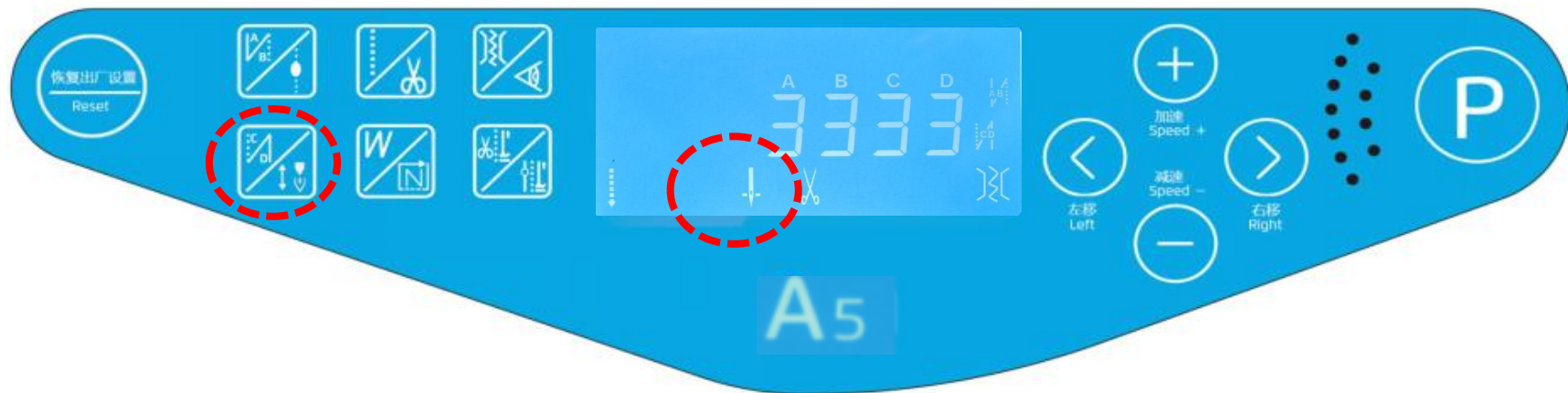
number of after backstitch

operating instructions—without Bird's Nest



In the standby mode, press the button  , the icon  on the screen lights up, indicating that the bird nest function is open.

Adjust the needle place

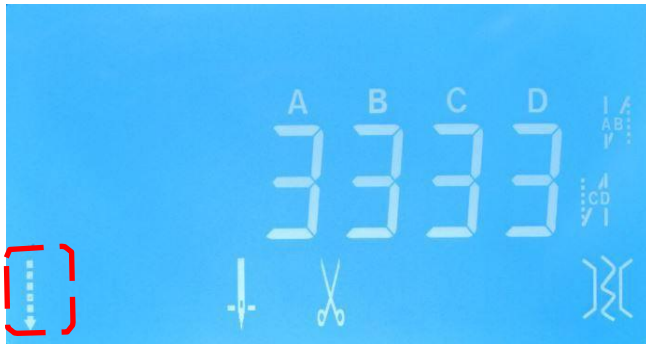


Long press , when in screen shows , can adjust

free seaming and scissors setting



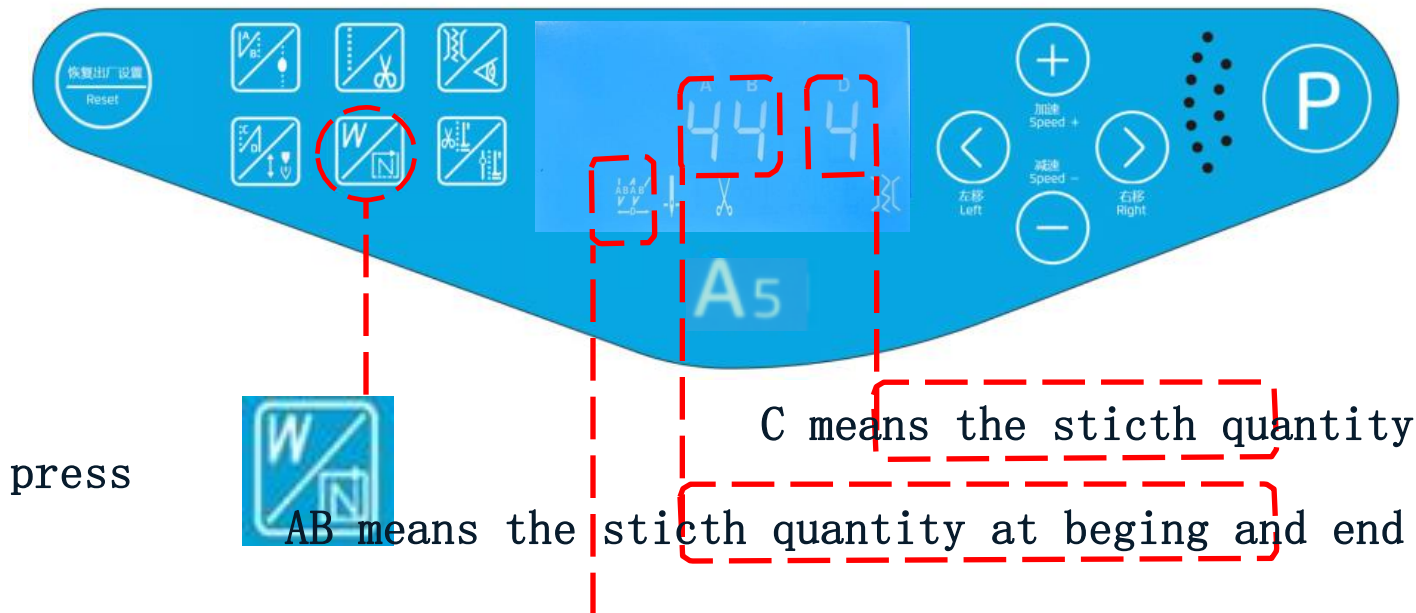
Free seam/shearing
switch



Free swing: press  The screen turn on 

means free sewing model

Timing turn ; long press  , when it turn
off in the screen, it means timing turn off



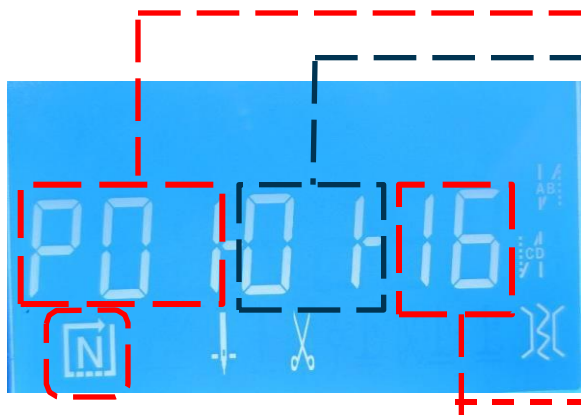
W缝: press , when shows  means it in W sewing adjust  

And adjust the   The stitcth quantity not more than 15



Long press

long press , screen shows  ess to adjust



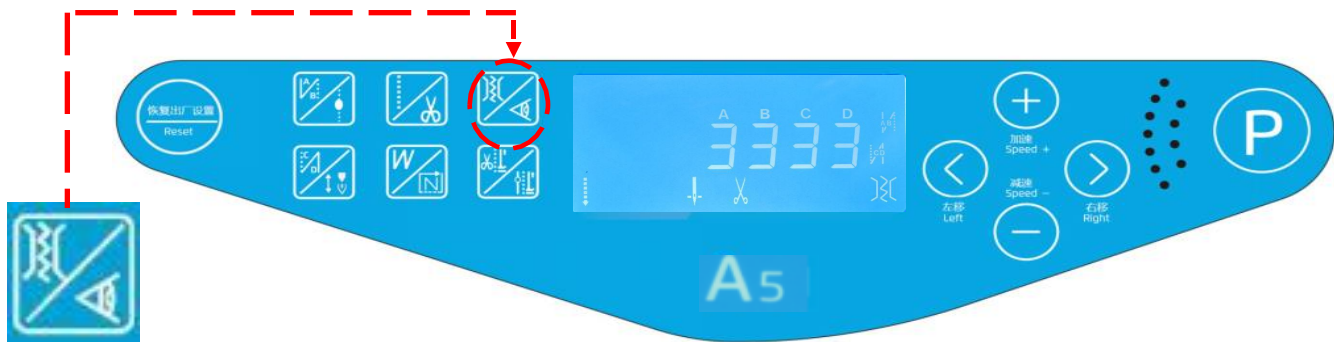
液晶屏显示区

The sect quantity, not more than 24.

The quantity stitch of each sect

Needle stitch quantity.

The sensern of auto-press lifter

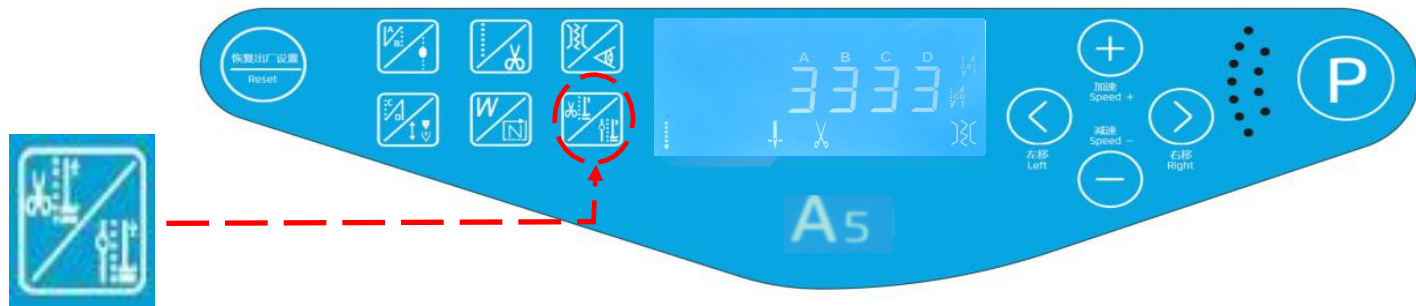


Long press to turn on and off

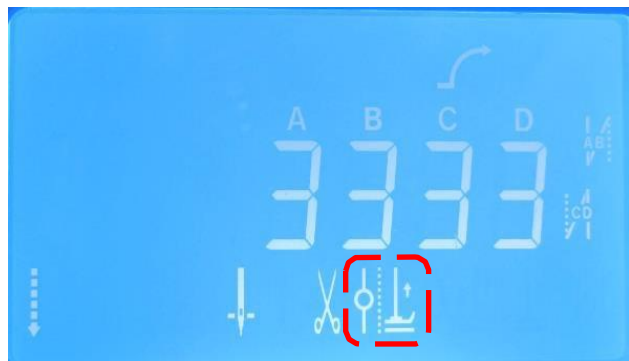
Long press , if shows , means it is turn on

Long press , if shows , means it is turn off

Auto-press lifter



Switch of press
lifter



Long press ,  means mid-stitch auto-press lifter turn on

Long press ,  means mid-stitch auto-press lifter turn off

:

Press ,  Means after trimming the press turn on

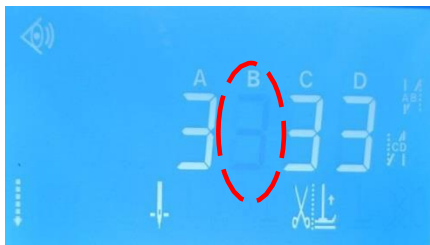
press ,  Means after trimming the press turn off



Press to up the speed



Press to down the speed



Left shift select: parameter settings, parameter values need to increase the key, the standby interface cursor left shift key.



Right move select: parameter setting, the parameter value needs to reduce the key, the right cursor right move button at the standby interface.



Press **P** , than press  ,

When it shows  The change wheel makes the point on the handwheel and the engraving on the casing Alignment (handwheel is slightly lower), then press **P** button, then press **P** keys align the pins and press **P** to save them

The points on the handwheel on the housing

- 1、 In standby mode, the long press P key enters the parameter mode ;
- 2、 presse   and   to change parameter
- 3、 The parameter interiface flickers when the parameter value is modified. At this time, press the P key, save the modified parameter, and then briefly press the P key to exit the parameter interface and return the standby page.

Paramete r num ber	Paramete r range	Factor y settin g	Description
P01	200~5000	4000	the maximum speed of free sewing
P03	0/1	1	Needle stop position selection (0:up; 1: down)
P04	200~3000	1800	Start back tacking speed
P05	200~3000	1800	End back tacking speed
P06	200~3000	1800	Continuous back sewing speed (W sewing)
P09	0/1	0	Soft start switch (0:off; 1: on)
P15	0/1/2	0	Mode of adding stitch
P16	0~9999	30	Adjust the lift foot response time after the sensor has

P17	0~99	65	Automatic induction presser foot sensor setting (between the maximum and minimum value of the 02C parameter display)
P18	1~120	35	Stitch balance for start back tacking No.1(Pull in compensation)
P19	1~120	20	Stitch balance for start back tacking compensation release
P22	0~50	8	Needle compensate position switch interval
P24	0~1024	80	Trimming point of pedal
P25	1~120	35	Stitch balance for end back tacking
P26	1~120	20	Stitch balance for end back tacking
P27	0~2	1	presser foot induction model (0-2) 0 : swith off, 1 : after trimming presser foot lifter, 2 : presser foot lifter before and after trimming
P30	0~31	0	Feedforward torque of motor: 0: normal functions 1-31: feedforward torque level
P31	10~199	50	Trimming afterburner coefficient (motor afterburner)
P32	1~500	400	Thread clamp solenoid full open time (ms)

Operation Instruction - technical parameter

P33	1~100	0	Thread clamp solenoid off time per cycle (ms)
P37	1~100	0	Thread clamp solenoid on time per cycle (ms), (the clamp strength)
P45	1~100	1	Back stitch electromagnet per cycle opening time (ms)
P46	1~100	2	Back stitch electromagnet per cycle closing time (ms)
P47	200~360	360	After trimming anti pull (It realizes trimming is pulled back function)
P49	100~500	250	Trimming speed
P50	100~500	150	Presser foot lifting electromagnet full output time ms
P51	1~100	3	Presser foot lifting electromagnet per cycle opening time (ms)
P52	0~800	100	Running delay time when presser footer comes down (ms), bigger is better
P53	0/1	1	Presser foot lifting function selection 0: off 1: on
P54	1~100	5	Presser foot lifting electromagnet per cycle closing time (ms)
P56	0/1	1	Run to up needle position after Power on : 0: no action 1: action
P57	0~600	100	Presser foot lifting electromagnet protection time, unit: 0.1s ; 0 no pretection。 Maxim can stay 1 minute .When set the middel presser foot lifte and after trimming presser foot lift in effect
P60	200~5000	3000	The maximum speed of constant sewing (Automatic test speed)

Operation Instruction - technical parameter

P62	0/1/2/3	0	Special mode: 0: normal Mode 1: simply sewing mode 2: motor initial angle measurement 3: Calculate the transmission ratio mode 4: automatic test modle 1 (It has needle stop position of automatic test, running 5s , stopping 3S)
P66	0/2	2	2 : open safety switch function ; 0: close ;
P68	0~5000	4000	The maximum speed limit of the machine head (inside spped limite)
P71	0~50	2	Slow release lifter level adjustment, the smaller values and the faster quickly
P76	1~500	60	Back sewing electromagnet full output time ms
P78	10~359	120	clamp thread start angle
P79	0~359	320	clamp thread end angle
P98	0~4	4	Voice volume (0~4),4 maxicum (after factory seeting will not change)
P99	0/1/2	1	Langue selection 0 : voice close , 1 : Chinese, 2 : English, default: Chinese
PA0	1~9999	5000	The lift foot release down Delay time after remove cloth when sensing turn on.
PA1	0~600	50	The lift foot release down Delay time with cloth when sensing turn on. Unit :0.1s

Oil detection	20F	0	0/1	Oil detection funcation selection 0: open 1: close	P+power button
	229	200	0~2500	Waiting time when stitch off the machine (0.25S/1)	

Operation Instruction - technical parameter



Short thread end	0A	800	0~9999	Close needle sewing speed	Switch on machine and long press P key
	0B	1	0~10	Stitch number setting of close needle sewing, 0 default close	
	13F	800	0~9999	Close needle sewing speed	P+power button
	20B	1	0~10	Stitch number setting of close needle sewing, 0 default close	

Operation Instruction - technical parameter

little bird's nest	07	310	5~720		Switch on machine and long press P key
	08	27	0~360	Under bird' s nest mode electronic thread clamp compensating parameter (not tacking sewing slow compensating parameter)	
	108	150	100~ 800	Slow start sewing speed	P+开机键
	15B	1000	0~ 9999	bird's nest mode on	
	167	0	0/1/2	With cutting machine、A4、A4S up and down needle position change	
	207	1	0~999	Start sewing thread slack starting angle (thread slack electromagnet angle)	
	208	35	0~ 9999	Start sewing thread slack end angle (thread slack electromagnet angle)	
	20E	360	10~ 720	Thread clamp electromagnet end angle LE (relative to down needle position angle, bigger than LS)	
	215	1	0 / 1	Thread wipper function selection 0: close 1: open	
	216	1	1~999	Thread wiper delay time ms(interlock mahcine knife start slowly)	
PROJECT NAME					

Operation Instruction - technical parameter



Electro nic thread slack	210	0	0 / 1 / 2 / 3 / 4 / 5 / 6	thread slack electromagnet timing selection: 0: [LS] After set angle then make thread slack movement , until upper needle position delay again [T2] to the setting time 1: [LS] After set angle then make thread slack movement ,until [LE] set angle. 2: [LS] After set angle then make thread slack movement , delay [T2] to setting time . 3:After down needle position signal delay [T1] setting time to slack thread , until delay to [T2] setting time. 4:After upper needle position signal delay [T1] setting time to slack thread , until delay to [T2] setting time 5:After down needle position signal start to thread slack until up needle position stop, then delay [T1] setting time then make [T2] setting thread slack time 6:[LS] After set angle then make thread slack movement , until upper need stop. Then delay [T1] setting time then make [T2] setting thread slack time	P+ power button
	211	35	5-359	thread slack electromagnet starting angle LS (relative to down needle angle	
	212	300	10-359	thread slack electromagnet ending angle LE (relative to down needle angle, bigger than LS)	
	213	1	1-999	thread slack electromagnet starting delay time T1 (ms)	
	214	10	1~999	thread slack electromagnet upper needle position delay time T2 (ms)	
	265	5	0~30	0: forbid to output 5: thread slack electromagnet	

Operation Instruction - monitoring parameter (P+ presser foot lifter key)

JACK 杰克

Parameter number	Parameter description	Parameter number	Parameter description
0 1 0	stitch counter	0 2 6	The machine drive ratio
0 1 1	Counter for sewing pieces	0 2 7	The total used time(hours) of motor
0 1 2	The head of real speed	0 2 8	The sampling voltage of interaction
0 1 3	State of encoder	0 2 9	DSP Software version
0 2 0	DC voltage	0 2 A	Analog input 1
0 2 1	Machine speed	0 2 B	Analog input 2
0 2 2	The phase current	0 2 C	Error counter
0 2 3	Initial	0 2 D	OPG

Troubleshooting

error code	Code meaning	solution
Err-01	Hardware overcurrent	1, turn off the power, restart 2, check the voltage is normal low pressure 176V high pressure 264V 3, turn the hand wheel to see whether the mechanical parts stuck 4, check the motor plug 5, restore the factory, test the motor angle 6,replace the control box
Err-02	Software overcurrent	
Err-03	System undervoltage	
Err-04	Excessive shutdown	
Err-05	Run overpressure	
Err-06	Electromagnet circuit failure	1, check the plug, the pin is off 2, unplug the solenoid plug to see if the error is still 3, replace the electromagnet 4, replace the control box
Err-07	Current detection circuit failure	1、reset the factory 2、replace the control box
Err-08	Motor stall	1, turn the hand wheel to see if the mechanical parts stuck 2, check the motor plug 3, reset the factory, test the motor angle 4, replace the motor 5, replace the encoder 6, replace the control box

Troubleshooting

Err-09	Brake circuit failure	1, check the electrical control box in the cement resistance plug is off 2, check the cement resistance is burst 3, replace the cement resistance 4, replace the control box
Err-10	HMI communication failure	1, check the control panel and the electric control box connection is off, loose, broken 2, restore the factory 3, replace the panel 4, replace the control box
Err-11	Head stop signal failure	1, check the plug is loose 2, replace the encoder 3, replace the control box
Err-12	Motor initial angle detection	fault almost does not appear.
Err-13	Motor HALL fault	1, restore the factory settings 2, replace the motor encoder 3, replace the control box.

Troubleshooting

Err-14	DSP read and write EEPROM failure	1, restore factory settings 2, test the motor angle 3, replace the control box
Err-15	Motor overspeed protection	
Err-16	Motor reversal	
Err-17	HMI read and write EEPROM fault	
Err-18	Motor overload	
Err-23	Motor stall encoder failure	According to E08 to investigation, and E08 solution the same.
报警 UP	Turn the table switch alarm	Pendulum head, to ensure that the switch to restore Taiwan.

specific spare parts list of A5

NO	structure	serial number	description	quantity
1	Short thread	14112002	A5-0928短线头电磁铁支架Bracket	1
2		14127001	A5-0930复位扭簧Spring	1
3		141S20001	A5-0927倒送料连杆轴位螺钉Screw	1
4		14105001	A5-0926短线头连杆Link	1
5		14105002	A5-0937 辅助连杆Link	1
6		141S20003	A5-0938轴位螺钉SM11/64"x40 Screw	1
7		141S20004	A5-0914轴位螺钉SM11/64"x40 Screw	1
8		14104005	A5-0916自动倒送料曲柄Crank	1
9		14126001	A5-0929短线头电磁铁顶销Pin	1
10		1413003300	A5-0933短线头电磁铁组件Solenoid asm.	1

specific spare parts list of A5

NO	structure	serial number	description	quantity
11	Double trimmer	14104002	A5-0615剪线凸轮曲柄轴 Shaft	1
12		14112005	A5-0611刀架压板 Pressing plate	1
13		14119001	A5-0612活动刀Movable knife	1
14		14119002	A5-0613辅助动刀Movable knife	1
15		14103003	A5-0616剪线轴套 Bushing	1
16		14104001	A5-0618剪线曲柄Crank	1
17		141S20002	A5-0621剪线曲柄轴位螺钉Screw	1
18		131S01002	JK-8995-0432 螺钉SM11/64*40 Screw	1
19		14103004	A5-0430下轴前轴套组件Bushing	1
20		14107001	A5-0609剪线主刀架 Knife bracket	1
21		1410700200	A5-0610-00剪线辅刀架组件 Knife bracket	1
22		14112001	A5-0614分线片 Thread separating plate	1
23		14104003	A5-0619剪线辅曲柄Crank	1

specific spare parts list of A5

NO.	structure	serial number	description	quantity
24	Auto thread tension	1413000900	A5-0329-00松线电磁铁组件 Tension release solenoid asm.	1
25		14101017	A5-0331松线顶板 Tension release plate	1
26		14126002	A5-0332松线顶板连接销Pin	1
27		14127002	A5-0347松线顶板复位簧Spring	1
28		1411000200	A5-0305压脚扳手凸轮分部件Cam	1
29		1411200300	A5-0330-00抬压脚前杠杆组件lever	1

specific spare parts list of A5

NO.	structure	serial number	description	quantity
30	Non-oil	14104004	A5-0303针杆曲柄Crank	1
31		14109001	A5-0414滑块导轨Guide	1
32		1413800100	A5-0201挑线组件Thread take-up asm.	1
33		14103010	A5-0407针杆下衬套Bushing	1
34		14103012	A5-0350压杆下衬套Bushing	1
35		14103005	A5-0403针杆上衬套（铜）Bushing	1
36		1410300100	A5-0210上轴前轴套组件Bushing	1
37		14102060	A5-0203上轴 Main shaft	1
38		14123003	A5-0342上轴毡塞Seal	1
39		14104007	A5-0405针杆连接柱（DLC处理后）Needle bar connecting rod	1

specific spare parts list of A5

NO.	structure	serial number	description	description
40	The others	14122001	A5-0145橡皮塞（四孔）Rubber seal	1
41		1413003400	A5-0649-00剪线电磁铁组件 trimmer solenoid asm.	1
42		14112007	A5-0839过线勾Thread gudie	1
43		14122002	A5-0102面板垫Panel pad	1
44		14101001	A5-0104面板Face plate	1
45		14133001	A5-1615一体机电控面板组件(鲍麦克斯) Panel	1
46		14133002	A5-1616一体机电控组件(鲍麦克斯)Control module	1
47		14112008	A5-0177防油板Oil shield plate	1
48		14112004	A5-0178防油罩 Cover	1
49		14127003	A5-0654剪线复位簧 Spring	1
50		14123001	A5-0179防油罩油棉Cotton shield oil	1
51		14123002	A5-0180防油板油棉Oil suet cotton	1
52		1401200300	A4S-1422勾线装置组件（带吸嘴）Wiper asm.	1
53		703375	平缝吸风装置（气动）Suction device	1
54		1413103900	A5-1204绕线器组件 Bobbin winder	1
55		14011007	A4S-1430吸风装置转接线 Connecting cable	1