5. Memory switches

The sewing machine operation can be changed by changing the setting of the memory switch.

(1) Memory switch start and change

1. When the ⎡M⎤ key is pressed in the state that the sewing LED is turn off, the user level setting mode is assumed for the memory switches. When the ⎡M⎤ key is continuously pressed for 6 seconds, the service level setting mode is assumed for the memory switches.

   (Caution) In the case of continued pressing, the buzzer sounds after 3 seconds and 6 seconds, respectively. The buzzer sound after 3 seconds indicates that the test mode has become effective.

2. The memory switch number can be modified with the +/⎡ and −/⎡ keys.

3. Select a required number of memory switch by pressing the +/⎡ −/⎡ key, then fix the number by pressing ⎡O⎤ key to turn on the LED.

4. Change the contents of the memory switch with the +/⎡ and −/⎡ keys.

5. The factory shipment values can be recovered with the ⎡⟋⎤ key.

6. The contents of modification can be registered by pressing the ⎡O⎤ key. In this case, the sewing LED is turn off and the select condition of the memory switch number is recovered.

7. When the ⎡M⎤ key is pressed, the memory switch setting mode is finished and normal operating conditions are recovered.

The upper 3 digits are used for the memory switch number.

The upper 2 digits are used for the contents of setting.
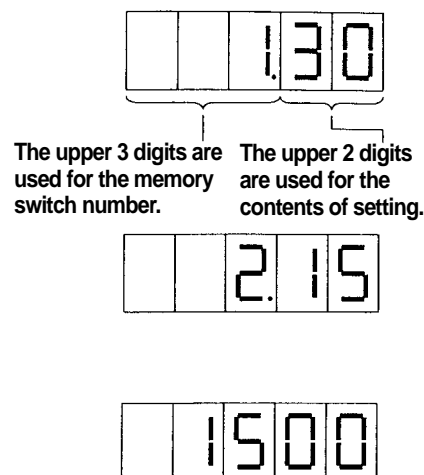
(2) Table of memory switch functions

Some initial values for shipment may change according to models.

The contents are divided into two categories of user level (U) and service level (S).

Indication	Level	Functions	Setting range	State when delivered	Remarks
1.30	U	Max sewing speed (Setting possible in the unit of 100rpm)	400~3000rpm	3000	To be set at 2700 for the LK-1900AW and LK-1903A.
2.15	U	Sewing speed for the first stitch (with needle thread clamp) (Setting possible in the unit of 100rpm)	400~1500rpm	1500	
3.30	U	Sewing speed for the second stitch (with needle thread clamp) (Setting possible in the unit of 100rpm)	400~3000rpm	3000	
4.30	U	Sewing speed for the third stitchj (with needle thread clamp) (Setting possible in the unit of 100rpm)	400~3000rpm	3000	
5.30	U	Sewing speed for the 4th stitchj (with needle thread clamp) (Setting possible in the unit of 100rpm)	400~3000rpm	3000	
6.30	U	Sewing speed for the 5th stitch (with needle thread clamp) (Setting possible in the unit of 100rpm)	400~3000rpm	3000	
7.--	U	Thread tension for the first stitch (with needle thread clamp)	0~200	200	
8.--	U	Thread tension at the time of thread trimming	0~200	0	
9.--	U	Changeover timing of thread tension at the time of thread trimming	−6~4 (~−1:32°, 0:28°, 1:24°~)	0	When the setting value isincreased, operation becomes faster in the unit of 4°.
10.4	U	Sewing speed for the first stitch (with needle thread clamp) (Setting possible in the unit of 100rpm)	400~1500rpm	400	
11.9	U	Sewing speed for the second stitch (with needle thread clamp) (Setting possible in the unit of 100rpm)	400~3000rpm	900	
12.30	U	Sewing speed for the third stitch (with needle thread clamp) (Setting possible in the unit of 100rpm)	400~3000rpm	3000	
13.30	U	Sewing speed for the 4th stitch (with needle thread clamp) (Setting possible in the unit of 100rpm)	400~3000rpm	3000	
14.30	U	Sewing speed for the 5th stitch (with needle thread clamp) (Setting possible in the unit of 100rpm)	400~3000rpm	3000	
15.--	U	Thread tension for the first stitch (with needle thread clamp)	0~200	0	
16.--	U	Changeover timing of thread tension at the sewing start (with needle thread clamp)	−5~2 (~ −1: 64°, 0: 60°, 1: 56°~)	0	When the setting value is increased, operation becomes faster in the unit of 4°.
17.0	U	Display of Pattern No., XY enlargement/ reduction scale rate, and max. speed limits; change enabled/disabled	0: Operative 1: Inoperative	0	In case of setting 1, use of M key is prohibited as well. When changing memory switch, pressing M key, turn ON the power switch. (Standard operation panel)
18.0	U	Counter operation	0: Production counter (addition) 1: Bobbin thread counter (subtraction)	0	(Standard operation panel)
19.0	U	Selection of pedal	0: Standard pedal 1: Standard pedal (2-step stroke) 2: Optional pedal 3: Optional pedal (2-step stroke)	0	
20.0	U	Selection of pedal	0: Standard pedal 1: Optional pedal	0	

Indication	Level	Functions	Setting range	State when delivered	Remarks
21.--	S	Standard pedal, clamp switch position	50~200	70	When the setting value is increased, the amount of pedal tread becomes larger.
22.--	S	Standard pedal, 2-step stroke switch position	50~200	120	When the setting value is increased, the amount of pedal tread becomes larger.
23.--	S	Standard pedal, start switch position	50~200	185	When the setting value is increased, the amount of pedal tread becomes larger.
24.0	U	Optional pedal 1 operated	0: OFF when trodden again 1: OFF when released	0	
25.0	U	Optional pedal 2 operated	0: OFF when trodden again 1: OFF when released	0	
26.70	U	Height of work clamp foot at the time of 2-step stroke	50~90	70	Height is lowered when the set value is increased.
27.--	S	Clamp lowering speed during pedal operation (Setting possible in the unit of 10pps)	100~4000pps	4000	
28.--	S	Clamp rising speed during pedal operation (Setting possible in the unit of 10pps)	100~4000pps	1500	Too much rise in the setting level may result in malfunction.
29.--	S	Thread trimmer clamp rising spped at the end of sewing (Setting possible in the unit of 10pps)	100~4000pps	3000	Too much rise in the setting level may result in malfunction.
30.0	U	Pattern's enlargement / reduction reference point	0: Origin 1: Sewing start point	0	The enlargement / reduction point in the pattern data is effective only for 0 setting.
31.0	U	It is possible to stop sewing machine operation with panel's reset key.	0: Disabled 1: Panel's reset key 2: External switch	0	
32.2	U	Buzzer sound can be prohibited.	0: No buzzer sound 1: Panel's operation sound 2: Panel's operation sound + Error sound	2	
33.2	U	No. of stitches for needle thread clamp release	1 ~ 7 stitches	2	
34.--	U	Clamping timing of needle thread clamp	−10~0 (~−1:84°, 0:80°)	0	Delayed in negative direction in the unit of 4°.
35.0	U	Needle thread clamp control disabled	0: Normal 1: Disabled	0	Set at 1 for LK1903A.
36.--	U	Selection of feed operation timing. Set in negative direction when the tightness of stitches is adverse.	−8~16 (~11:64°, 12:60°, 13:56°~)	12	Delayed in negative direction in the unit of 4°. If set at extreme negative, there is danger of needle breakage. Significant when handling heavy materials.
37.1	U	State of work clamp foot after completion of sewing can be selected	0: Work clamp foot goes up after moving at the sewing start. 1: Work clamp foot goes up immediately after the end of sewing 2: Work clamp foot goes up by pedal operation after moving attne sewing start. LK1903A	1	LK-1903A/BR-35 to be set at 0
38.0	S	Sewing is possible only with the start switch, without raising the work clamp foot.	0: Normal 1: Work clamp foot rise disabled.	0	
39.0	U	Each time sewing is finished, origin retrieval is possible. (Except for the cycle sewing)	0: No origin retrieval 1: Origin retrieval enabled	0	
40.0	U	Origin retrieval setting is possible after cycle sewing.	0: No origin retrieval 1: Origin retrieval after the end of one pattern. 2: Origin retrieval after the end of one cycle.	0	

Indication	Level	Functions	Setting range	State when deivered	Remarks
41. 0	U	State of work clamp foot when machine stopped by temporary stop command can be selected.	0: Work clamp foot goes up. 1: Work clamp foot goes up with work clamp foot switch. 2: Lift of work clamp foot is prohibited.	0	
42. 0	U	Needle bar stop position is set.	0: Up position (53°) 1: Upper dead point (22°)	0	Needle bar rotates the reverse direction after the UP position stop and stops when upper dead point stop is set.
43. 1	S	Selection of sewing machine rpm during thread trimming	0:400rpm 1:800rpm	1	This is the sewing machine rpm of the thread spreading by moving knife. When the sewing machine has stopped, thread trimmer is function.
44. 1	S	Selection of whether the thread is moved in the direction of easy trimming.	0: Feeding disabled. 1: Feeding enabled.	1	
45. 16	S	Needle hole guide diameter when feeding is moved for thread cutting. (Setting possible in the unit of 0.2mm)	16~40 (1.6mm~4.0mm)	16 (1.6mm)	When the setting value is increased, the amount of feeding becomes larger.
46. 0	U	Thread trimming can be disabled at the end of sewing.	0: Normal 1: Thread trimming disabled	0	After tentative stoppage, thread trimming is not disabled.
47. 0	S	Thread trimming can be disabled.	0: Normal 1: Thread trimming disabled	0	All thread trimming operation is disabled.
48. 0	U	The origin reset route can be selected with the reset key.	0: Linear reset 1: Pattern returning	0	
49. 16	U	Bobbin winding speed can be set (Setting possible in the unit of 100rpm)	800~2000rpm	1600	
50. 2	U	Operation timing of material closing is selected. (LK1901A only)	0: Output prohibited 1: Operation when work clamp foot comes down. 2: Operation at the time of start	2	For the machines other than LK-1901A, this function is not indicated.
51. 1	U	Wiper operation method can be selected.	0: Without wiper at the time of thread trimming on the way 1: With wiper at the time of thread trimming on the way ① 2: With wiper at the time of th- read trimming on the way ② 3: Magnet wiper	1	① Without return of the last wiper ② With return of the last wiper (When the setting No. 37:1 of the memory switch, wiper operation method can not be used.)
52. - -	S	Magnet wipe-out time (Setting possible in the unit of 10ms)	10~500ms	50	Effective only if the magnet wiper has been selected.
53. - -	S	Magnet wipe-in time (Setting possible in the unit of 10ms)	10~500ms	100	
54. 0	S	Wipe-out timing at the time of upper dead point stop	0: Sewing machine returned and upper dead point stop after wiper operation in up position. 1: Wiper operation after upper dead point stop	0	Effective only if upper dead point stop is selected.
55. 0	U	The stitching at the start of sewing of the pattern for button sewing can be prohibited. For LK-1903A only	0: The stitching effective 1: Tie stitching ineffective	0	For the machines other than LK-1903A, thus function is not indicated.
56. - -	S	Moving limit range in +X direction (right side)	–20~20mm	20	In the state of shipment, no clamp configuration is considered.
57. - -	S	Moving limit range in –X direction (left side)	–20~20mm	–20	In the state of shipment, no clamp configuration is considered.
58. - -	S	Moving limit range in +Y direction (back side)	–20~10mm	10	In the state of shipment, no clamp configuration is considered.
59. - -	S	Moving limit range in –Y direction (front side)	–20~10mm	–20	In the state of shipment, no clamp configuration is considered.
60. - -	S	Jump feed speed of XY (Setting possible in the unit of 10pps)	100~4000pps	2000	

Indication	Level	Functions	Setting range	State when delivered	Remarks
`6 1 - -`	S	XY feed forward / back speed (Setting possible in the unit of 10pps)	100~4000pps	500	
`6 2. 0`	S	When the power supply is turned on, oautomatic preparation is possible without pressing the READY key.	0: Normal 1: Automatic preparation is operated when the power supply is ON.	0	
`6 3. 0`	S	While the needle stays in an upper position, a current is maintained in the main motor to make the needle hard to down.	0: Holding disabled 1: Holding enabled	0	
`6 4. 0`	U	Method of XY enlargement/reduction scale rate setting (IP200 only)	0: % setting 1: Size setting	0	Displayed only for the IP200 operation panel.
`6 5. 0`	U	The origin is moved toward the front by 5mm.	0: Standard 1: 5mm closer to the front	0	This setting is needed when using the LK1904 presser foot and patterns.
`6 6. 4 5`	S	No. of pulses for work clamp foot interlock wiper operation	30~60	45	
`1 5 0. 0`	S	The head falling detector switch can be disabled.	0: Normal 1: Head falling detector switch disabled	0	
`2 0 1 - -`	U	This function sets whether or not the calling of the pattern data is operative.	0: Calling inoperative 1: Calling operative	Setting depends on the model used.	Standard pattern Nos. 1 to 64 can be individually set (Standard operation panel)
`2 4 1. 0`	S	Initialization of model's specifications is executed.	0:LK1900ASS 1:LK1900AHS 2:LK1900AFS 3:LK1900AMS 4:LK1901ASS 5:LK1902ASS 6:LK1902AHS 7:LK1903ASS-301 8:LK1903ASS-302 9:LK1903ASS-311/BR35 10:LK1903ASS-312/BR35 11:LK1900AWS	Setting values are specified at left according to models.	Contents of the memory switches are initialized to the state when delivered. The thread tension of each standard pattern is initialized to the state when delivered. All the registrations patterns and cycles are deleted.
`2 4 5. - -`	U	Grease-up error	The number of stitches is counted based on drive, sewing machine.		Only clearing possible with the RESET key. Clearing should be done after the completion of grease-up action.
`P - - - -`	U	Pattern registration is carried out.			
`C - - - -`	U	Cycle sewing registration is carried out.			
`C P - - -`	S	Test mode is assumed.			