



GTN1054BHVB/HE800B OPERATION MANUAL

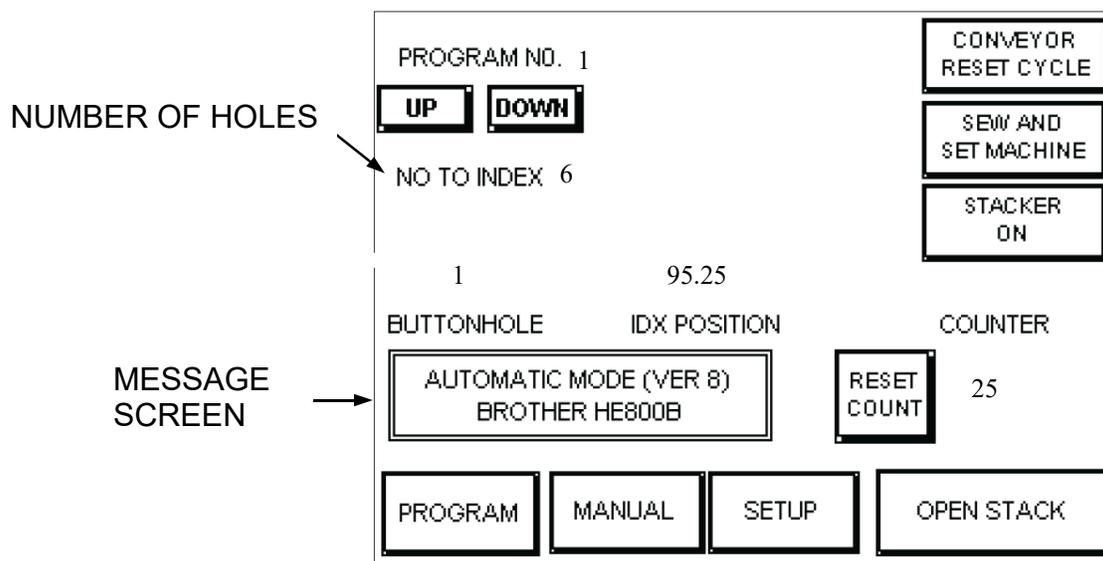


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GTN1054BHVB MAIN SCREEN



UP/DOWN KEYS: You can change the program in memory by touching the UP or DOWN key. The number to the right of the keys shows you the number of the program in memory. You can have 15 pre-programmed index styles in memory for fast call up.

SEW AND SET MACHINE: This key is used to sew one buttonhole manually. Is not used to start cycle. Use the black momentary switch on the mouse assembly to start a cycle. “Note, use this key on the Brother HE800B to load the Brother sew data. This key replaces the stock foot pedal

CONVEYOR/RESET CYCLE: Use this key to drop fabric conveyor for testing during the sew process or to reset the index count back to zero. Note: If you are in a indexing cycle this key will abort the cycle.

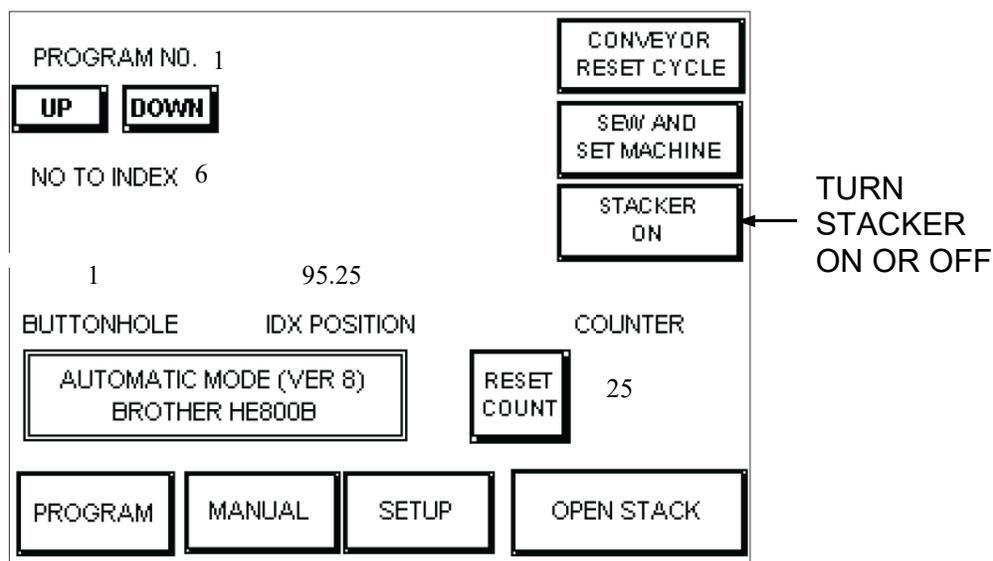
NO TO INDEX: Number of buttonholes to be sewn in the current program.

BUTTONHOLE: Current buttonhole to be sewn.

IDX POSITION: After sewing a buttonhole this is the distance it will move to sew the next buttonhole.

MESSAGE SCREEN: Screen to show current state of indexer. (EMERGENCY, ERROR, MANUAL, etc....)

GTN1054BHV MAIN SCREEN; continued



PROGRAM: Changes screen to program screen. In this screen you can create or edit index programs. **NOTE! PROGRAM FUNCTION MAY BE BLOCKED FROM OPERATOR. YOU CAN LOCK OR UN-LOCK THIS FUNCTION FROM THE SETUP SCREEN.** GTN indexers use the metric system of measurement. 1" is equal to 25.4 mm. (3 1/2" = 3.5" X 25.4 mm= 88.9 mm)

MANUAL: From this screen you can perform manual functions. Note: In manual screen you can not reverse index feed. You can only move in forward direction.

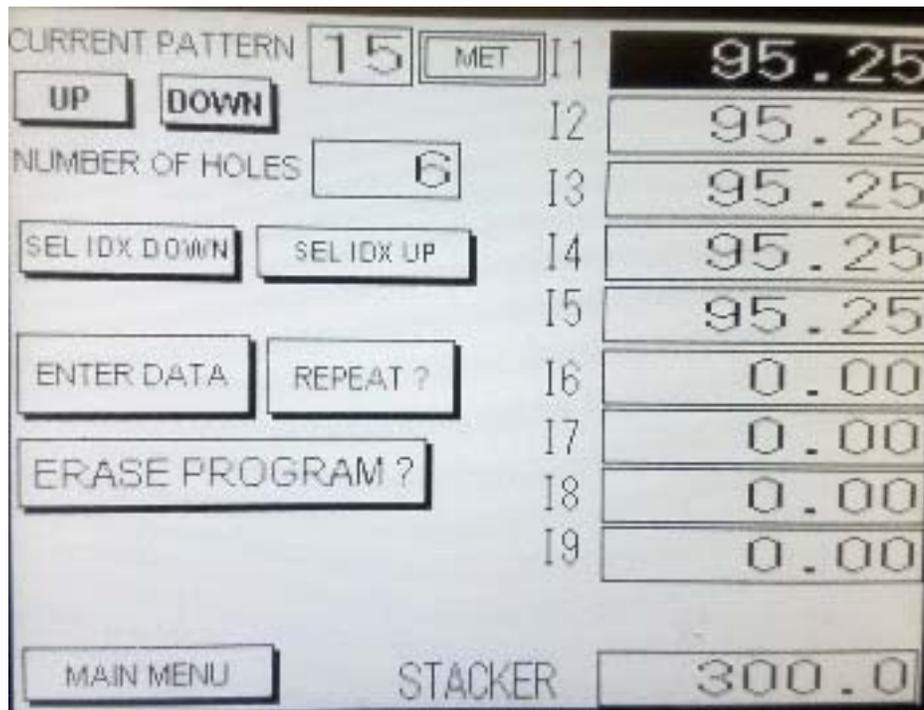
SETUP: From this screen you can change parameters or diagnostic functions.

OPEN STACK: When you press this key you can the stacker. If you press the key again the stacker will close. Stacker will automatically close when you start a indexing cycle if you forget to close.

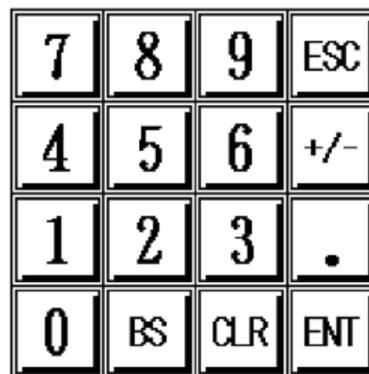
STARTING AUTOMATIC INDEXING OF MACHINE: Load shirt front into the clamps on both sides of the indexer. Press black momentary switch on left guide assembly. (When you release the clamp switch sewing will begin. If you hold for more then 3 seconds the clamps will abort and sewing will not start. This allows the operator to cancel sewing if shirt was miss placed) Clamps must be in a latch position for the machine to start.

RESET COUNT: This key will reset the production counter to zero. The count number will increment after each index cycle is finished.

GTN1054BHV PROGRAM INSTRUCTION

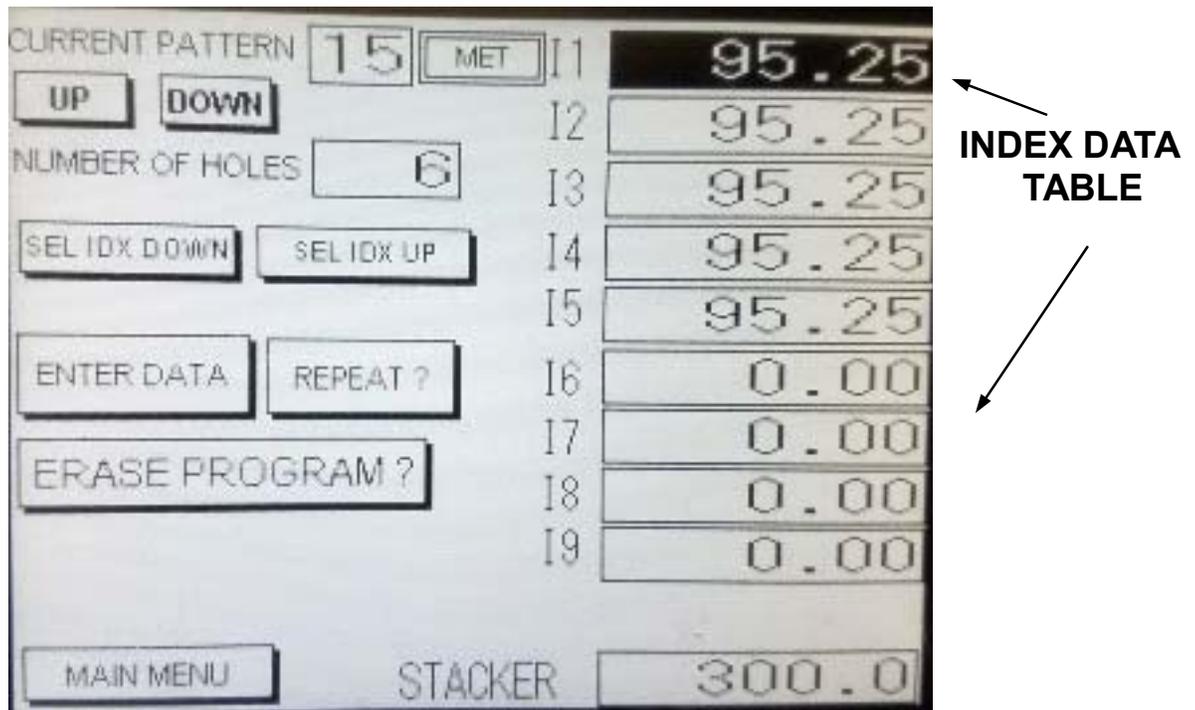


NOTE: While in programming mode when you select **ENTER DATA** or **STACKER** data cell a keyboard will appear so you can enter the data.



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GTN1054BHV PROGRAM INSTRUCTION



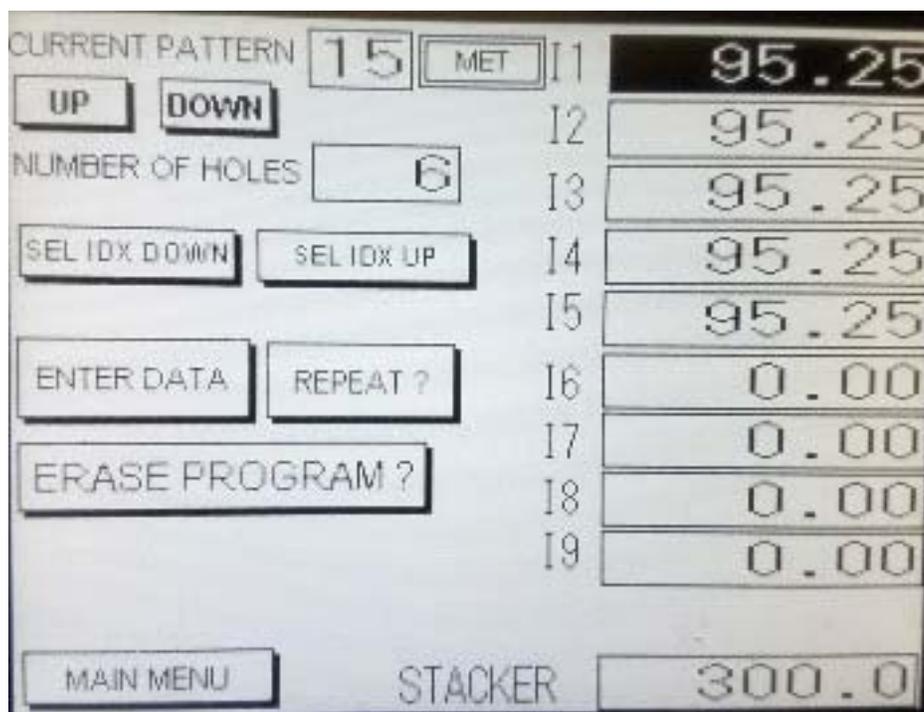
PROGRAM: The current pattern number will show you the pattern you are creating or editing. You can create or edit all 15 patterns from this screen.

NUMBER OF HOLES: This number should be entered first. This number represents how many holes are required on the shirt. (This is not amount of indexes) By selecting the number of indexes first the program can automatically repeat data for you. Also it's good practice because you can not index more then the number in this box.

ENTER INDEX TABLE: After number of holes is established now enter actual spacing between holes. If I1 is not high lighted, press SEL INDEX UP making sure that I1 is highlighted. If I1 is highlighted press ENTER DATA. A keyboard will appear and the data at I1 will flash. Enter the space you want for the first index. After you entered the first index you have a choice how to continue. You can select index down and enter a value for the space between 2 and 3, or you can auto repeat.

REPEAT?: If all spacing between holes will be identical (usually always identical) press the repeat key. The remainder of indexes are input automatically. (Note: whichever data cell is highlighted when you repeat "only" cells below it will be repeated.

GTN1054BHV PROGRAM INSTRUCTION



STACKER: Press stacker data area, in the keyboard screen enter the amount of space the conveyor will move the shirt into the stacker. If you enter 300 you will move the shirt 300 mm (11.8”) into the stacker after the final buttonhole is sewn. By increasing or lowering this number you will achieve a balanced stack on the stack arm. This data will also save itself into the selected program.

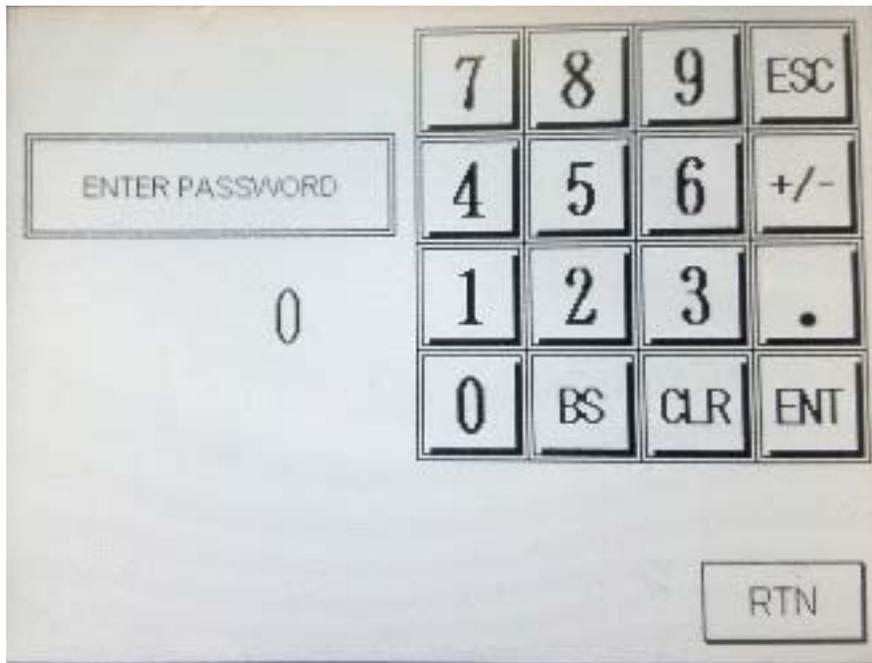
EXAMPLE PROGRAM ABOVE:

Current program number (pattern) is 15, the number of holes in this program is 6. Spacing between the holes will be 95.25 mm (equals $95.25 \text{ mm} / 25.4 \text{ mm} = 3.75$ ” or 3 3/4”) The stacker will feed for 300 mm (11.8”) after the last buttonhole is sewn.

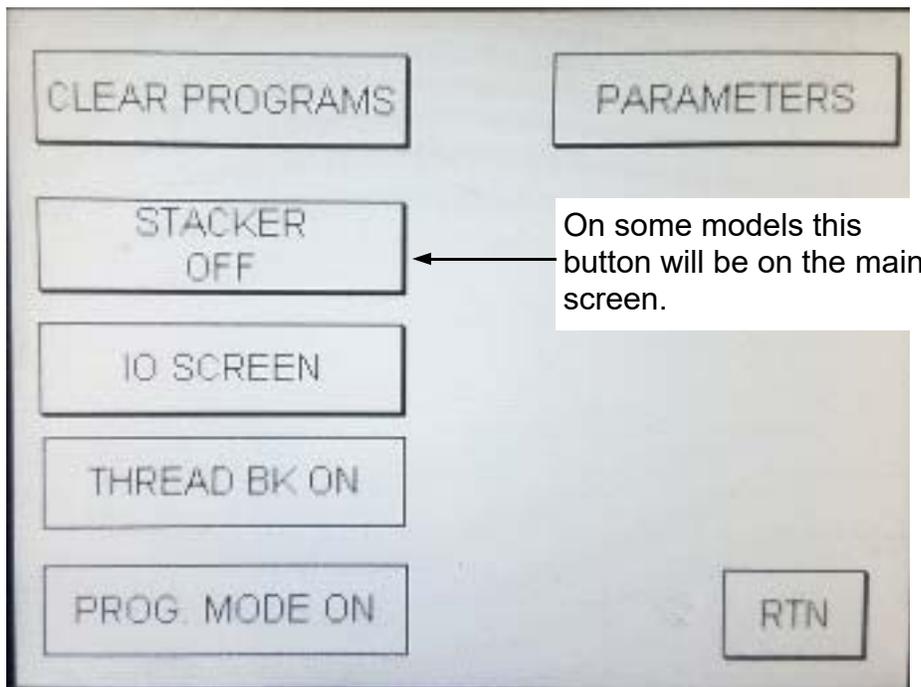
When you change the program (pattern) number the entered data is saved automatically **or** if you press main menu to return to the main screen the data will automatically save.

“You must be in the main screen to operate the sewing and indexing cycle.

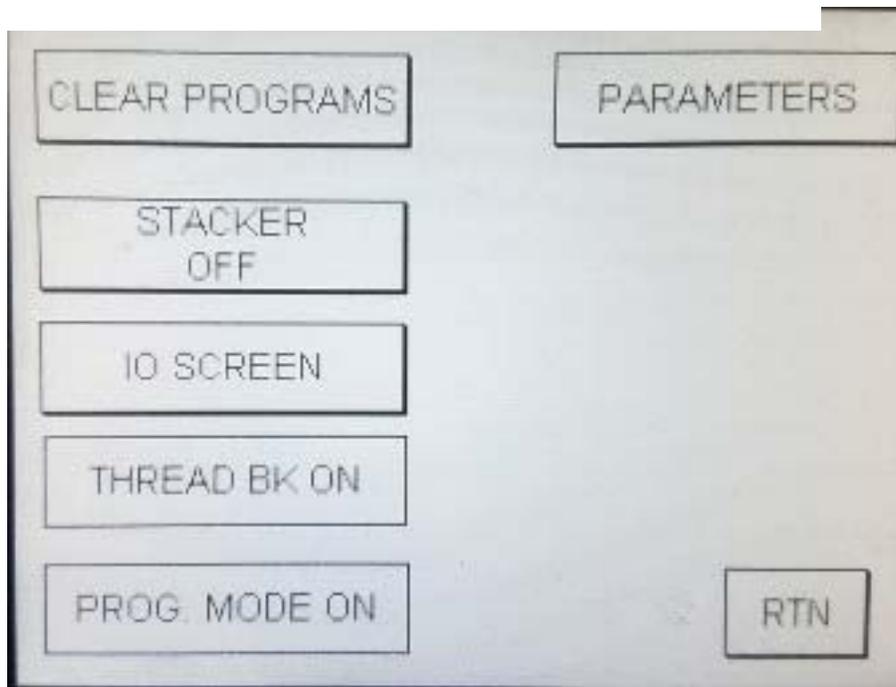
SETUP "ENGINEERING LEVEL"



ENGINEERING LEVEL: To change parameters, clear data, or lock programs you must get to the engineering level. Press on the data number area and using the keypad type **2007** and enter. This will change the engineering level from off to on. Note: The text in the message screen will say Engineering level open.



SETUP SCREEN OPTIONS



CLEAR: Pressing this button will erase all stored patterns. If you press abort no changes will be made. CAUTION! After you press clear you will have 2 options. Clear all 1 to 15 stored programs or abort. If you clear you can not restore!

STACKER: You can turn the stacker on or off. Normally “on”. Note: on some models this button will be on the main screen.

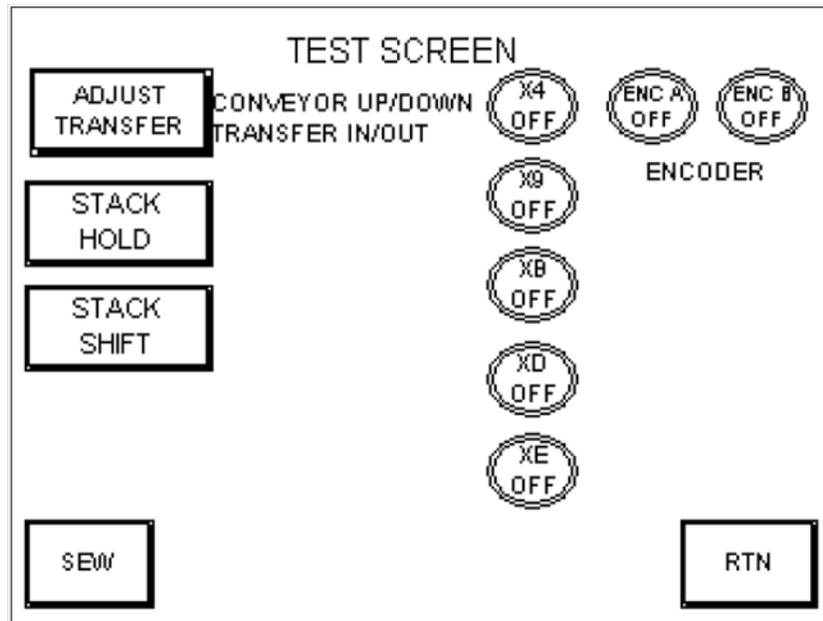
THREAD BK: When using thread break sensors on the sewing head this should be turned on.

PROGRAM MODE: If you want to block operator from changing program data turn this function off. Operator will be able to change program number 1 ~ 15, but the operator can not change the input data.

IO SCREEN: Screen can be used for diagnostics in the event of a technical issue. (explained later in the manual)

PARAMETERS: Screen will allow some parameter adjustments. (explained later in the manual) Use extreme caution when making parameter changes.

I/O SCREEN OPTIONS



ADJUST TRANSFER: Pressing this key will move the conveyor to the start position and lower the conveyor. This helps technicians adjust the down position of the conveyor.

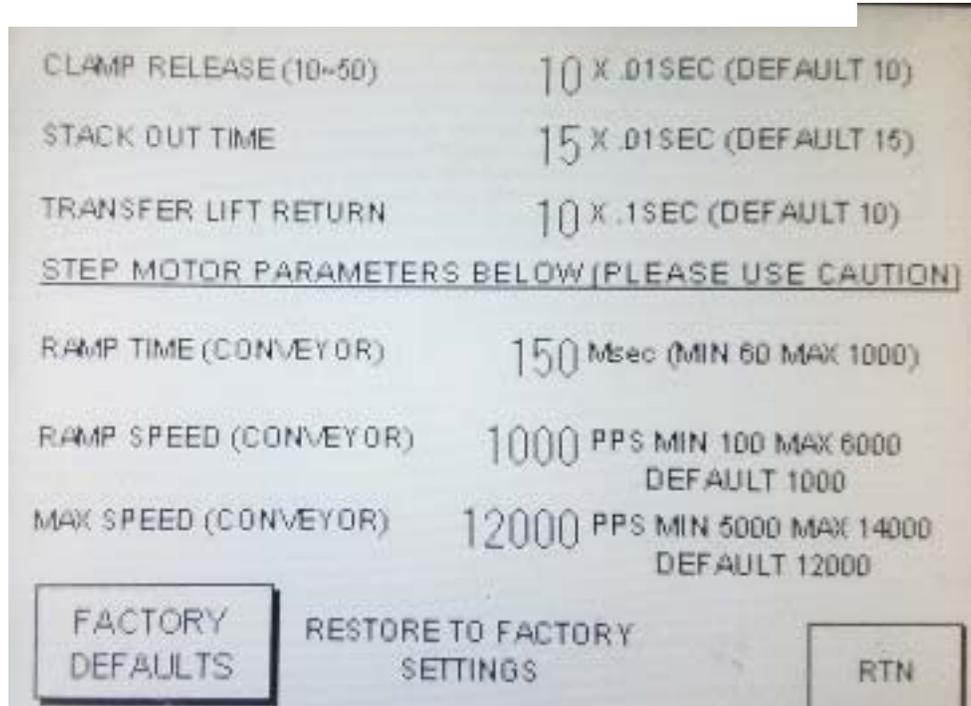
STACK HOLD: This key will test the clamp action of the stacker.

SHIFT STACK: Pressing and holding this key will send the stacker out. This helps technicians adjust the air flow control of the stack shifting cylinder.

INPUT VISUAL TEST: You can visually see the inputs of X4, X9, X8, XD, and XE. Used to check for faulty sensors or input switch.

ENC A and ENC B show the output pulses coming from the encoder mounted on the feed mechanism. When the machine is running these two inputs must be alternating on and off. If they do not output any pulses the encoder is faulty. (If you slightly move the large gear on encoder assembly you would see these two display lights toggle on and off.)

PARAMETER SCREEN OPTIONS



Use caution when changing parameters.

FACTORY DEFAULTS: Pressing this key will restore parameters to GTN factory specifications. Normally these settings should not be changed.

CLAMP RELEASE: Time delay on the right side clamp. This clamp must release before sewing head goes into motion. (default 10)

STACK OUT TIME: Adjustment to the amount of time the stacker moves out during stacking sequence. (default 15)

TRANSFER LIFT RETURN: Adjustment to delay the time the clamp arm stays down during stacking.

RAMP TIME, RAMP SPEED, and MAX SPEED should be kept at defaults. For explanation of these parameter settings please contact GTN INC.