

RELIABLE 8100DT

INDUSTRIAL DRAPERY TACKER

PROGRAMMING MANUAL

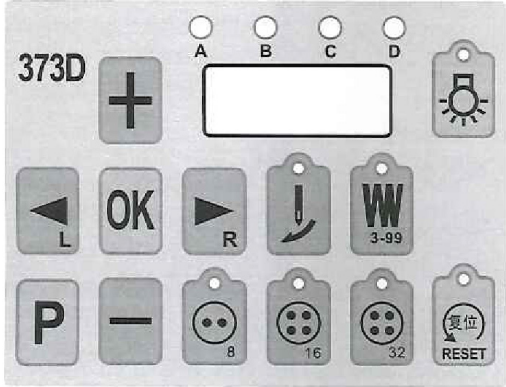
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RELIABLE. RIGHT THERE WITH YOU.











At Reliable, we do what we love, and take pride in doing it right. You want what's best for the people, places and things that matter in your life - from where you live to what you wear. So do we. From the start, we approach every product with a craftsman's attention to detail and passion for making it right. Quality, functionality, design and customer service play an equally important part in delivering what's right for you.









For your safety and to fully enjoy the advantages of this product, please take a few minutes to read all of the important safeguards and care instructions. Keep this manual handy and review the product warranty for your reference.

DISPLAY SCREEN OPERATION INSTRUCTIONS








No.	Button Icon	Function Description
1	LED (A)	When presser foot is in the correct place, the LED (A) will illuminate. When the presser foot is up or put into the wrong position, LED (A) will not illuminate.
2	LED (B)	When the hand wheel on the right side of the machine is rotated to a fixed position (the A1. wheel will auto to find needle stop position), it will be detected by the sensor, LED (B) will illuminate.
3	LED (C)	Up needle position of motor LED
4	LED (D)	LED (D) is a status indicator. When the system is running, LED (D) will illuminate. When the system is on standby or waiting, LED (D) is off.
P1		<p>Draperly tacker 8-stitch shortcut key.</p> <p>When this button is selected, LED will illuminate to indicate the selection. The sewing machine will run in 8-stitch mode.</p> <p>(Can run with 16-stitch or 32-stitch switchable)</p>

<p>P2</p>		<p>Drapery tacker 16-stitch shortcut key.</p> <p>When this button is selected, LED will illuminate to indicate the selection. The sewing machine will run in 16-stitch mode.</p> <p>(Can run with 8-stitch or 32-stitch switchable)</p>
<p>P3</p>		<p>Drapery tacker 32-stitch shortcut key.</p> <p>When this button is selected, LED will illuminate to indicate the selection. The sewing machine will run in 32-stitch mode.</p> <p>(Can run with 8-stitch or 16-stitch switchable)</p>
<p>P4</p>		<p>Wiper function key.</p> <p>When selected the LED will illuminate above the button to indicate it is on. When off, the LED will not illuminate.</p>
<p>P5</p>		<p>Stitch count adjust key.</p> <p>To adjust the stitch count, select the  key. The screen will display and flash "n-08". Select  or  to adjust the stitch count number. Once the desired stitch count is selected, press  to save.</p>
<p>P6</p>		<p>Built-in LED light.</p> <p>To turn on the LED, simply select the button. To turn the LED off, press the button again.</p>
<p>P7</p>		<p>Reset function.</p> <p>When the machine is turned on, press the reset button to clear parameters. Once the reset button is selected, set new parameters based on sewing needs.</p>

1		<p>Parameter adjustment and selection.</p> <p>Once the parameter key is selected, press  or  to select the desired parameter.</p>
2		Press the "OK" button so save desired parameters.
3		The "+" button (modify parameters plus)
4		The "-" button (modify parameters minus)
5		<p>Arrow left.</p> <p>Function in the parameter list to return to the previous page.</p>
6		<p>Arrow right.</p> <p>Function in the parameter list to enter the parameter for adjustment.</p>

SHORTCUT KEY FUNCTIONS

	<p>Hold button to initiate.</p>	<p>This will engage the shortcut to enter the wiper parameter adjustment.</p>
	<p>Hold button to initiate.</p>	<p>This will engage the shortcut to enter the wiper parameter adjustment.</p>
	<p>Hold button to initiate.</p>	<p>To reset to factory settings, press the  button. The screen will display "000". Press and hold  button for 5 seconds to complete.</p>

HOW TO ENTER & MODIFY PARAMETERS

Press the **P** and **-** button at the same time to enter into the "System Parameters" list.

The screen will display "0000" and press **OK** button to enter. Once you are in the parameter

setting screen, press **+** and/or **-** to switch through the parameter numbers. Once you

find the parameter you wish to set, press the **P** button and **OK** to save.

SYSTEM PARAMETERS LIST

System	Function Description	Function Parameter Default Values	Function Parameter Ranges	Parameter Description	Precautions
002	Reset Speed	200	150-800		
021	Reset system password	000	000~003	This parameter is adjusted to 003, hold "OK" button.	Restoring the factory password
023	Display speed		200~1800	Press the "P" button	Display motor speed
024	Governor detected	200		Detection governor normal	Detection should be before reset
025	Automatic running	0	0: CLOSE 1: OPEN	Machine running	Turn the power on again to close the parameter
031	Presser foot advance angle	80	10~90	Larger the angle, greater the sensitivity	
046	Wiper action delayed start time	40	10~2000		
047	Wiper action time	70	10~2000		
048	Wiper action time at full power	70	10~990		

050	Wiper action time at maintained power	50	1~100		
051	Wiper action release	50	20~800		
055	Wiper function on/off switch	000 (off)	0001 (on)		
058	Foot lift action time at full power	160	0~900		Affects electro-magnets when too high
059	Foot lifter power	100%	0~100%		Optimal parameters 80~100
060	Foot lifter at maintained power	6%	0~100%		Not recommended at high - affects heat
061	After presser foot release - delay time of needle down	1	1~900		
063	Foot lifter needle sensor switch	1	0: OFF 1: ON		When parameter 63 is closed, you need to set parameter 61 to 350 to prevent needle from breaking
065	Presser foot delay time	0	0~900		
071	Running speed	1500	200~1800		

ERROR CODE ANALYSIS

ERROR CODE	SOLUTION
ER-01 Needle position error	1. Hand wheel & motor issue 2. Hand wheel magnet off 3. Hand wheel magnet polarity reversal 4. Nine-pin terminal head poor contact 5. Motor hall damaged
ER-02 Pedal velometer signal wrong	1. Velometer not plugged in 2. Velometer not plugged in to correct box 3. Velometer line broken 4. Velometer damage
ER-03 Motor phase error signal	1. Nine-pin terminal poor contact 2. Hall and rotor has large deviations when the motor is mounted 3. Motor hall damage
ER-04 Motor stall protection	1. Sewing overweight or blocked 2. Motor overload 3. 4-wire motor drive cable is not connected or inserted
ER-05 Hardware over current	1. Sewing overweight or blocked 2. Motor overload 3. Motor phase signal line is not connected
ER-07 Serial communication timeout	1. Display - bad cable connection to motherboard 2. Motherboard chip damage
ER-09 Poor memory	1. Motherboard memory corruption
ER-13 No signal to presser foot	1. Presser foot sensor is mounted too far away 2. Presser foot sensor damage 3. Magnet on presser foot connecting bar is not connected properly or installed backwards
ER-14 Reset sensor can not find the needle position	1. The sensor on left induction aluminum wheel is damaged 2. Magnet on aluminum wheel not connected or installed backwards
ER-15 9700 Error signal	1. 9700 encoder is damaged



Reliable Corporation ("Reliable") warrants to original purchaser of its products that every product sold by Reliable (a "Reliable Product") is free from defects in material and workmanship for a period of one year from the date of purchase if properly used and maintained. Subject to the conditions and limitations set forth below, Reliable will either repair or replace any part of a Reliable Product that proves defective by reason of improper workmanship or materials. If the defective Reliable Product is no longer available and cannot be repaired effectively or replaced with an identical model, Reliable shall replace the defective Reliable Product with a current Reliable Product of equal or greater value. Repaired parts or replacement products will be provided by Reliable on an exchange basis, and will be either new or refurbished to be functionally equivalent to new. If Reliable is unable to repair or replace a Reliable Product, it will refund the current value of that Reliable Product at the time the warranty claim is made.

This limited warranty does not cover any damage to a Reliable Product that results from improper installation, accident, abuse, misuse, natural disaster, insufficient or excessive electrical supply, abnormal mechanical or environmental conditions, wear and tear resulting from normal use of the product, or any unauthorized disassembly, repair, or modification. This limited warranty does not extend to any indirect, consequential or incidental damages that may be suffered by a user or from the use of a Reliable Product, including without limitation, any liability for third party claims for damage, and is limited to the amount paid by the original purchaser Reliable Product with respect to which this limited warranty protection applies. This limited warranty does not apply with respect to products that have been altered or which are missing serial numbers or for products not purchased directly from Reliable or a dealer authorized by us to sell Reliable Products.

This limited warranty is the only warranty that applies to any Reliable Product, supersedes any and all terms that may be contained in any other document or purchase order and may not be altered or amended except expressly in writing by Reliable.

To obtain a repair or replacement under the terms of this warranty, please contact our customer service group at 1-800-268-1649 or at support@reliablecorporation.com. You will be required to submit an original receipt via fax or e-mail. The receipt must reflect that you are the original purchaser, the product was bought directly from us or from an authorized Reliable dealer and that the warranty claim is being made within the warranty period. You will be issued a return authorization number (RA#) and asked to ship the defective product together with proof of purchase and RA#, prepaid insured to the following address:

Reliable Corporation, 5-100 Wingold Avenue, Toronto, ON M6B 4K7. Freight collect shipments will be refused. The risk of loss or damage in transit will be borne by the customer. Once Reliable receives the defective product, it will initiate the repair or replacement process.

If you have any questions regarding this warranty, you may write to:

Reliable Corporation
100 Wingold Avenue, Unit 5
Toronto, Ontario
Canada M6B 4K7
www.reliablecorporation.com



1 800 268 1649
www.reliablecorporation.com