

OSCAR HS MC TRAINNING

Beginner course

I 、 MC introduce

II、 Threading yarn and changing needle

III、 Roller pattern running steps

IV、 Other operation

V、 MC maintenance

VI、 Safety Precautions

I、MC introduce



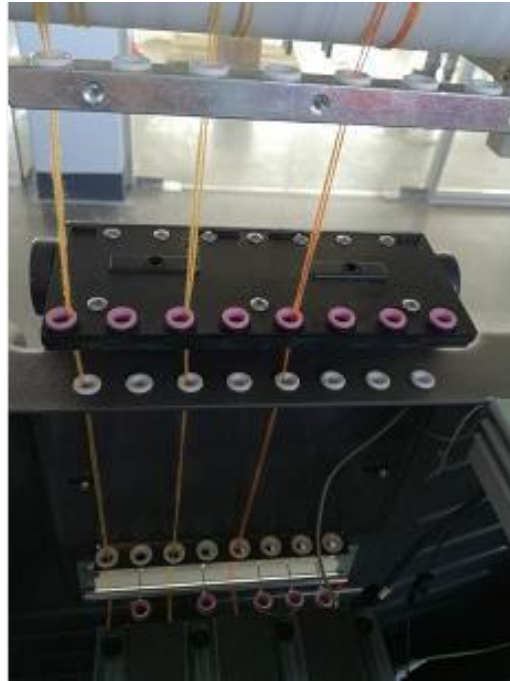
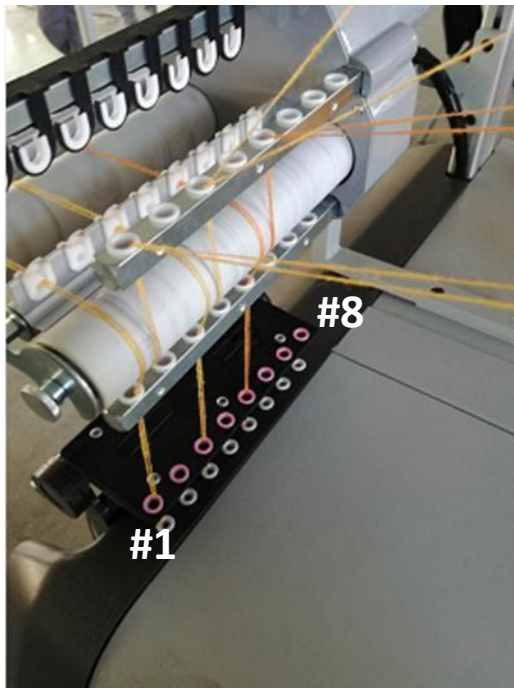
I 、 MC introduce

- 1-knob switch: main power switch
- 2-red /green switch : off/start switch
- 3-emergency button: Safety protection button
- 4-operation bar: clockwise rotate , slow & fast running , contrarotation then stop
- 5-monitor
- 6-iron box
- 7-carriage
- 8-feeder sets
- 9-side tension device: give yarn a tension & alarm while yarn cutting
- 10-provider: smooth yarn while MC running
- 11-top tension device: give yarn a tension and alarm while yarn cutting or have a knot

II、Threading yarn and changing needle

1、Threading yarn

Yarn one-one correspondence



II、Threading yarn and changing needle



II、Threading yarn and changing needle

Yarn must have tension



II、Threading yarn and changing needle

yarn alarm must be well



II、 Threading yarn and changing needle

2.1 four needles

needle



Long
Jack



spring
Jack



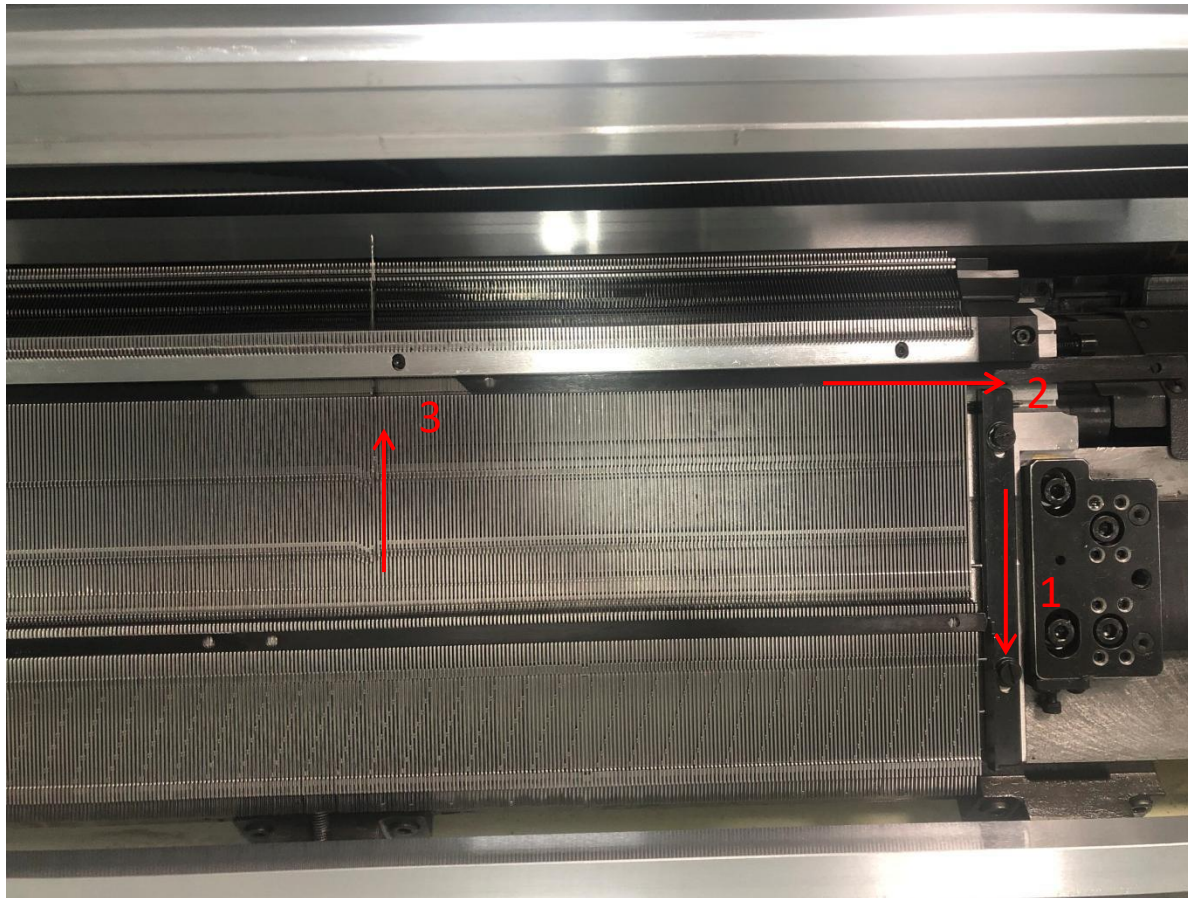
Selection
Jack



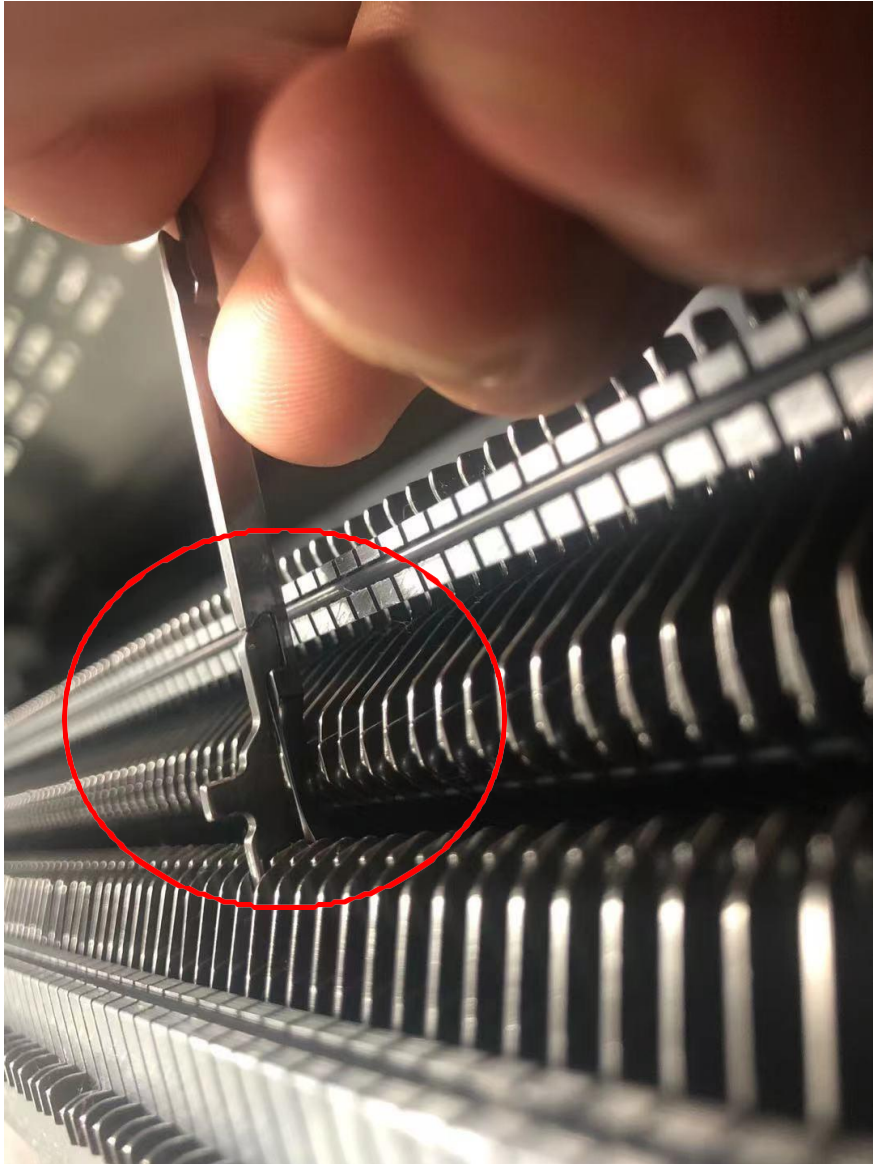
II、 Threading yarn and changing needle

2.2 needle open & setup

Needle & long Jack are moving together, open needle scale, push up the long Jack pin, then takeout from upside of needle bed



II、Threading yarn and changing needle



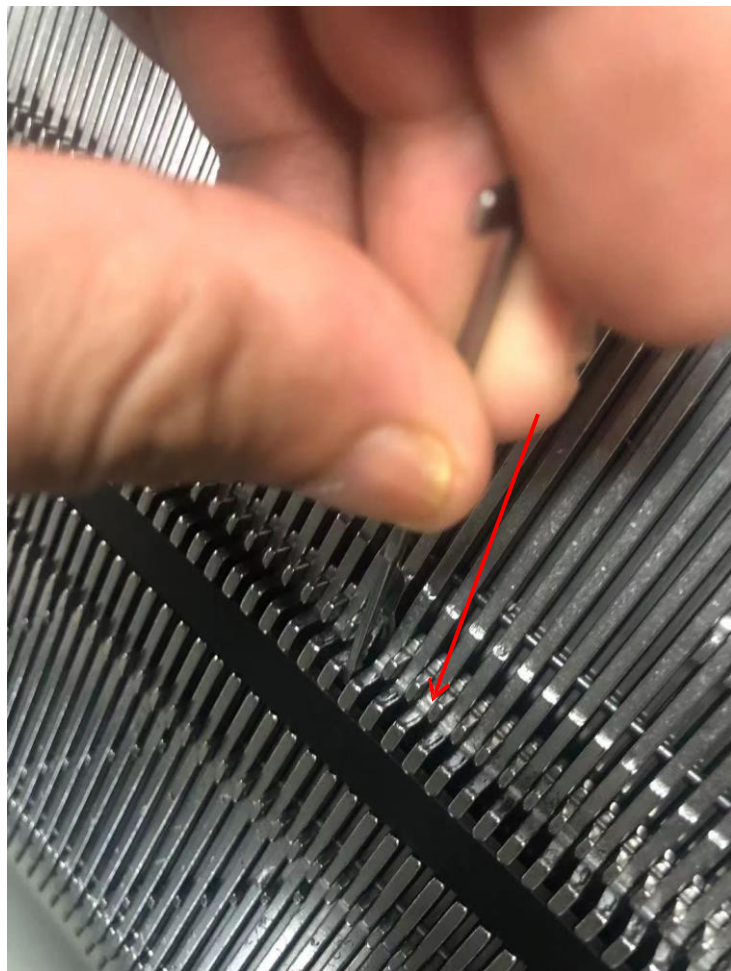
**Needle and long Jack
match like picture, then
together push in needle
bed**

II、Threading yarn and changing needle

Spring Jack open with step2 direction, there are 60° angle with needlebed, please use pliers

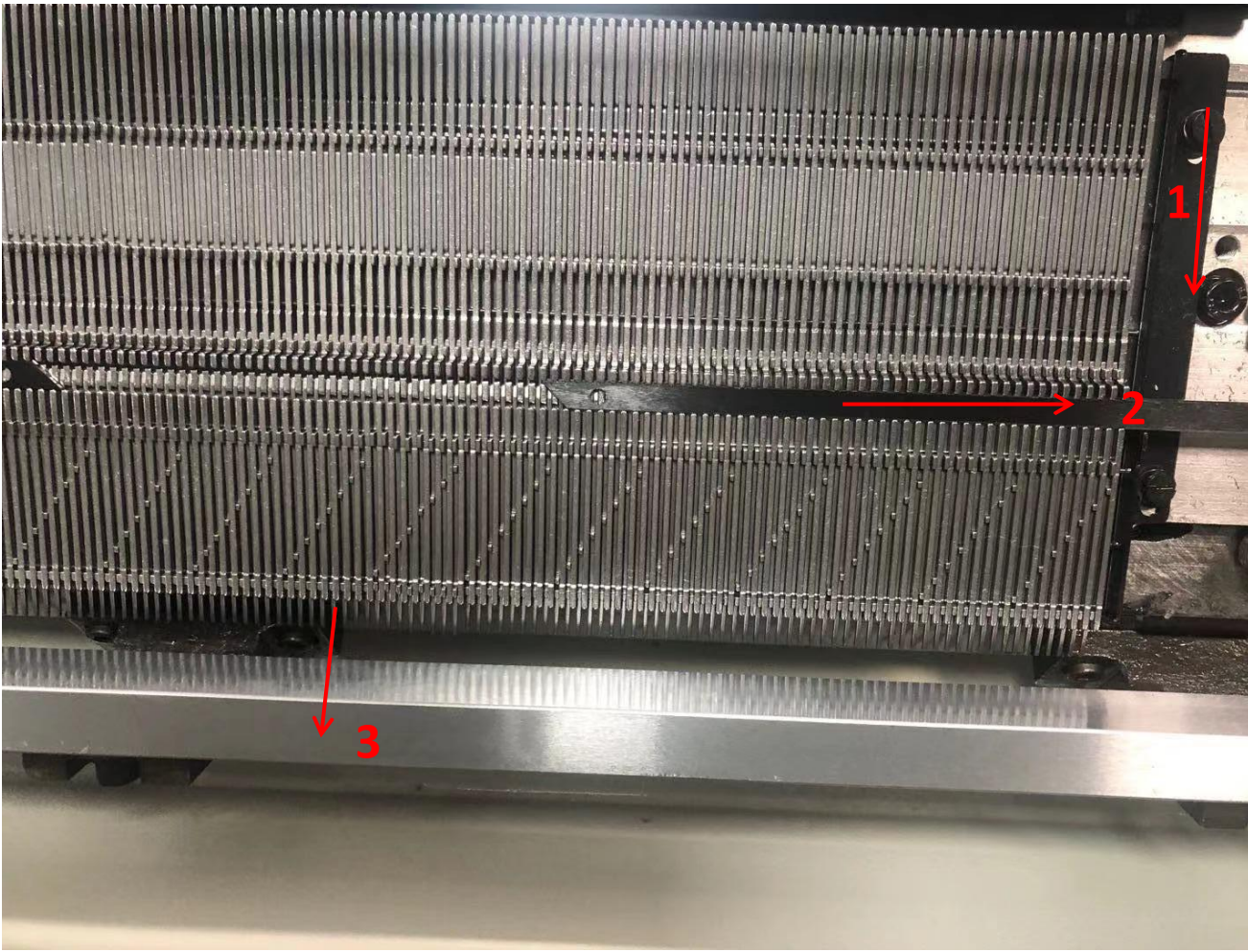


II、Threading yarn and changing needle



II、 Threading yarn and changing needle

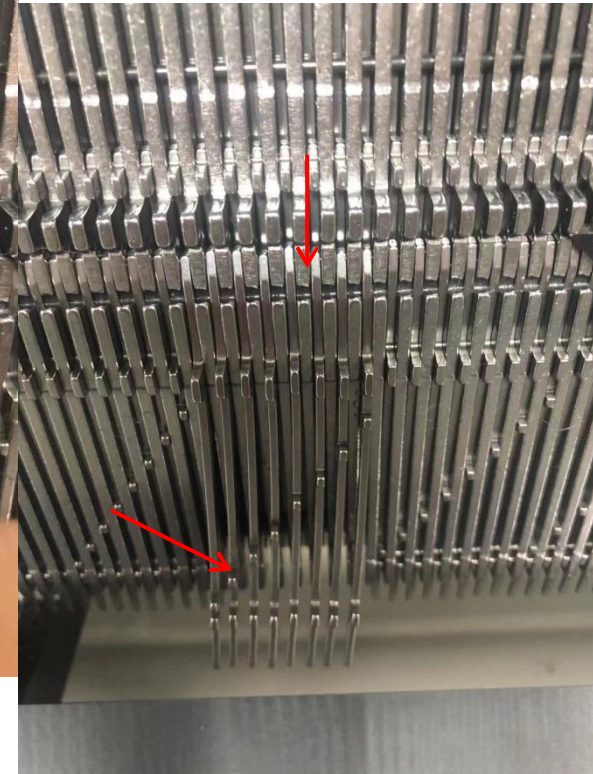
Selection Jack open after the scale moving , and it is curving, and have 8 number , we call them NO.1 selection JackNO.8 selection Jack from top to bottom , compare with the Jack pin



II、Threading yarn and changing needle



One hand press on
the head , another
hand push Jack
into needle bed



III、Roller pattern running steps

Power on: knob switch keep “—” , press green button

Choose the pattern in file interface

Set the start needle at running interface

Check the feeder or change one to another

Threading the yarn

Set speed 、 stitch、 takedown/roller value

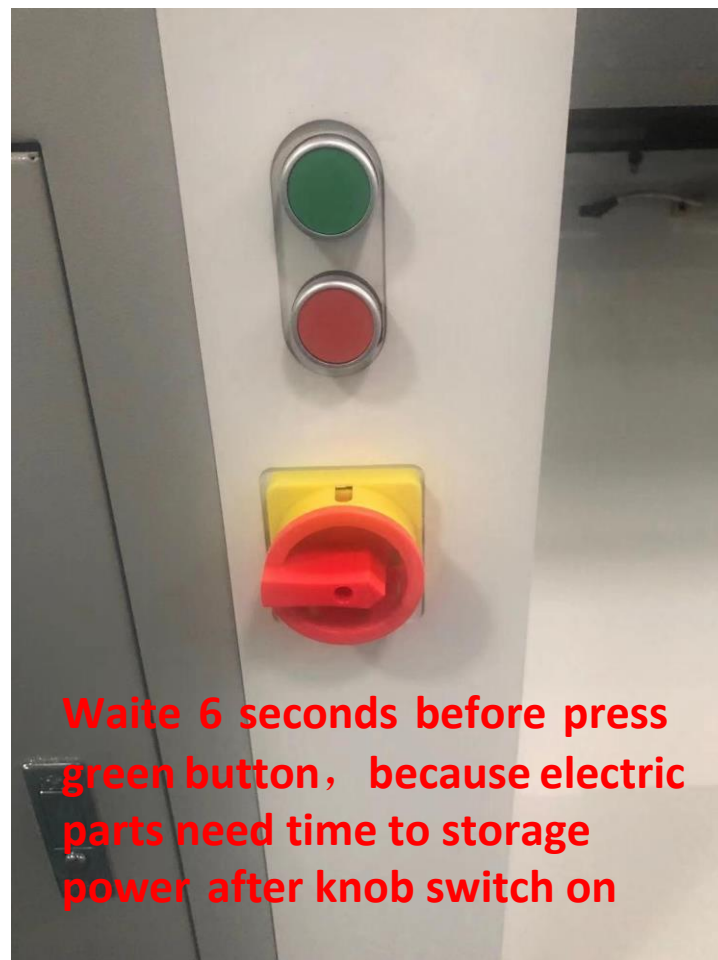
Reset the carriage , lock the rows

Unlock while fabric got by roller

Unload after pattern finish

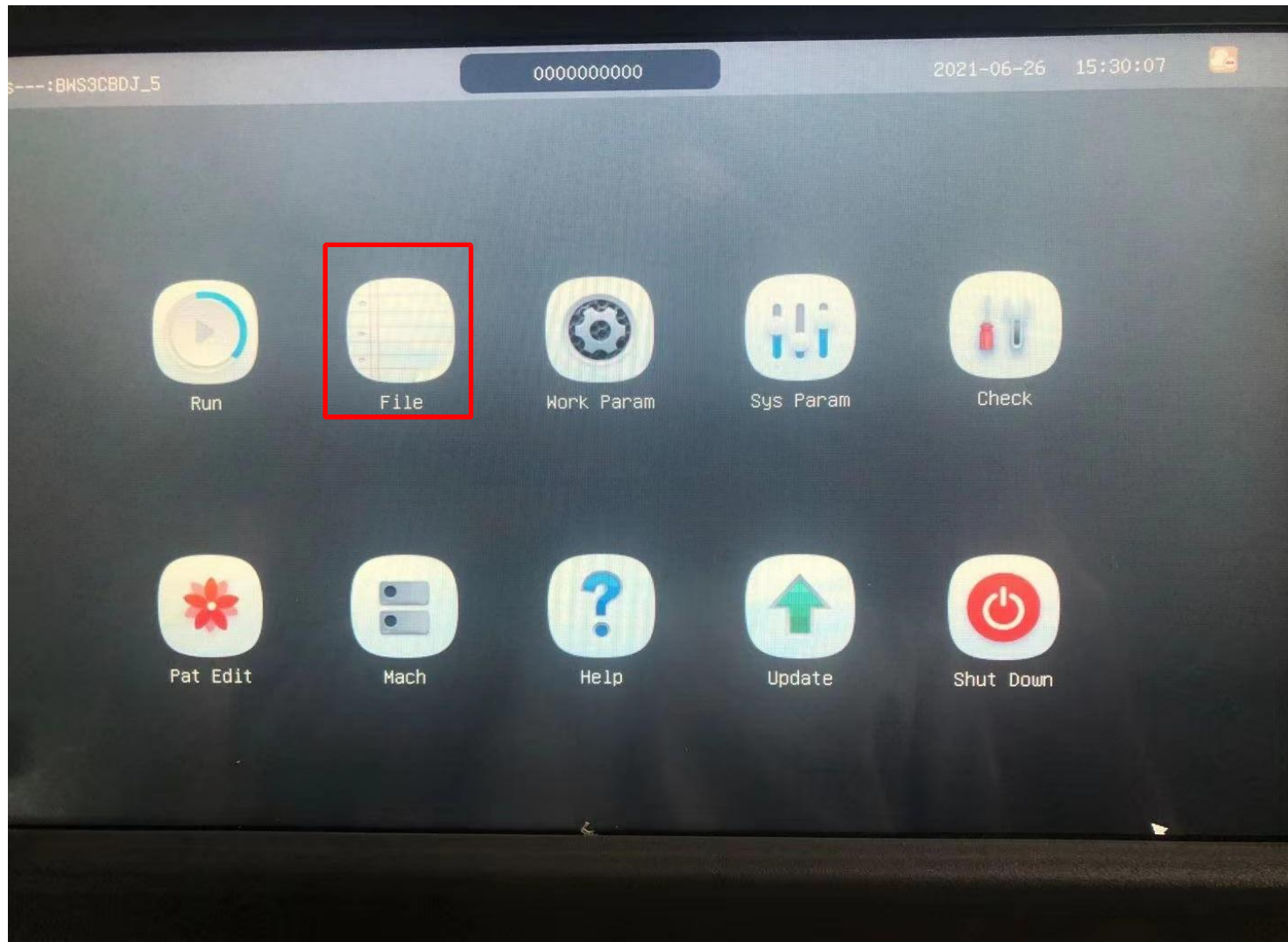
Ⅲ、Roller pattern running steps

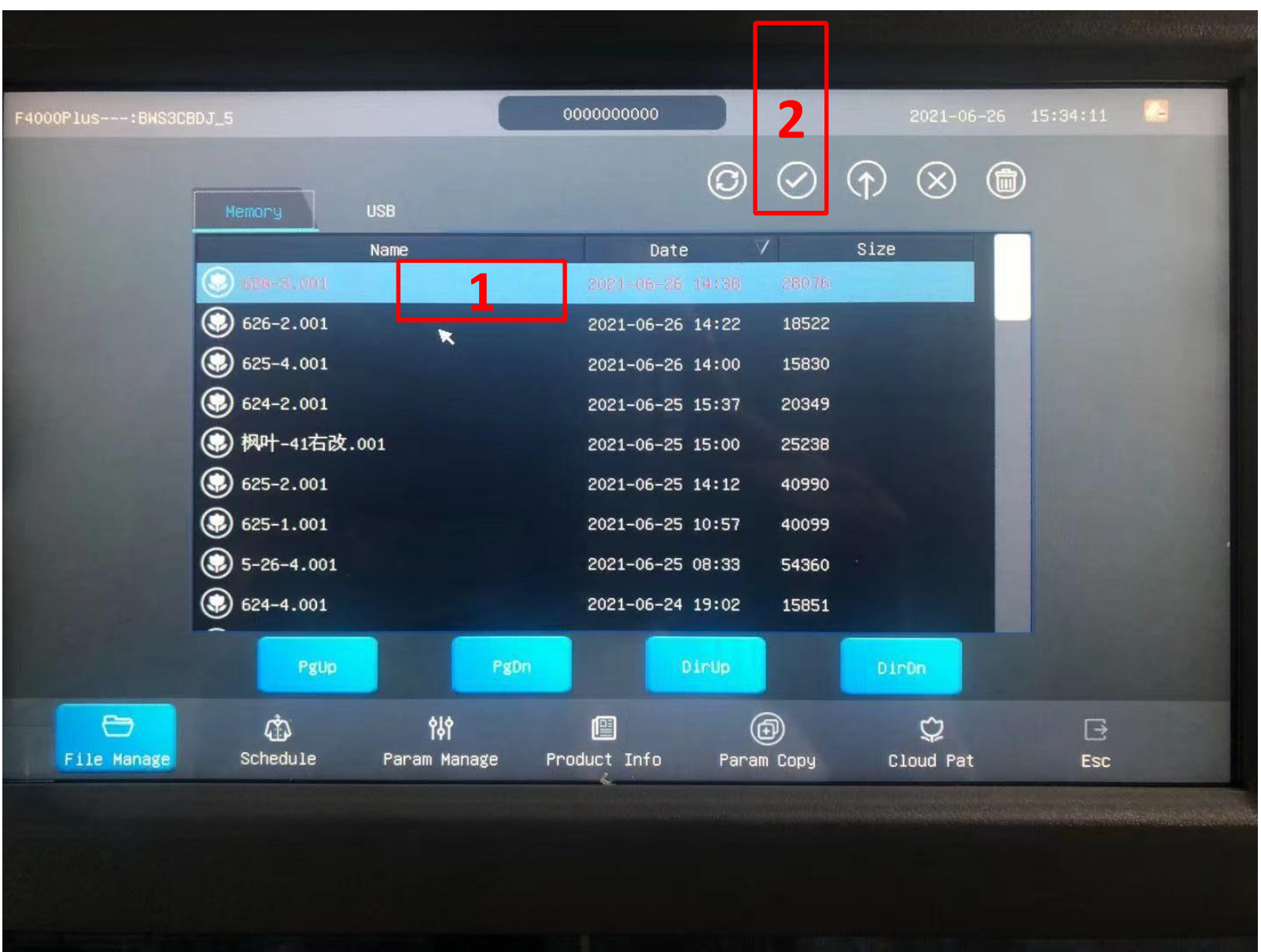
Power on: knob switch keep “—” , press green button



Waite 6 seconds before press green button, because electric parts need time to storage power after knob switch on

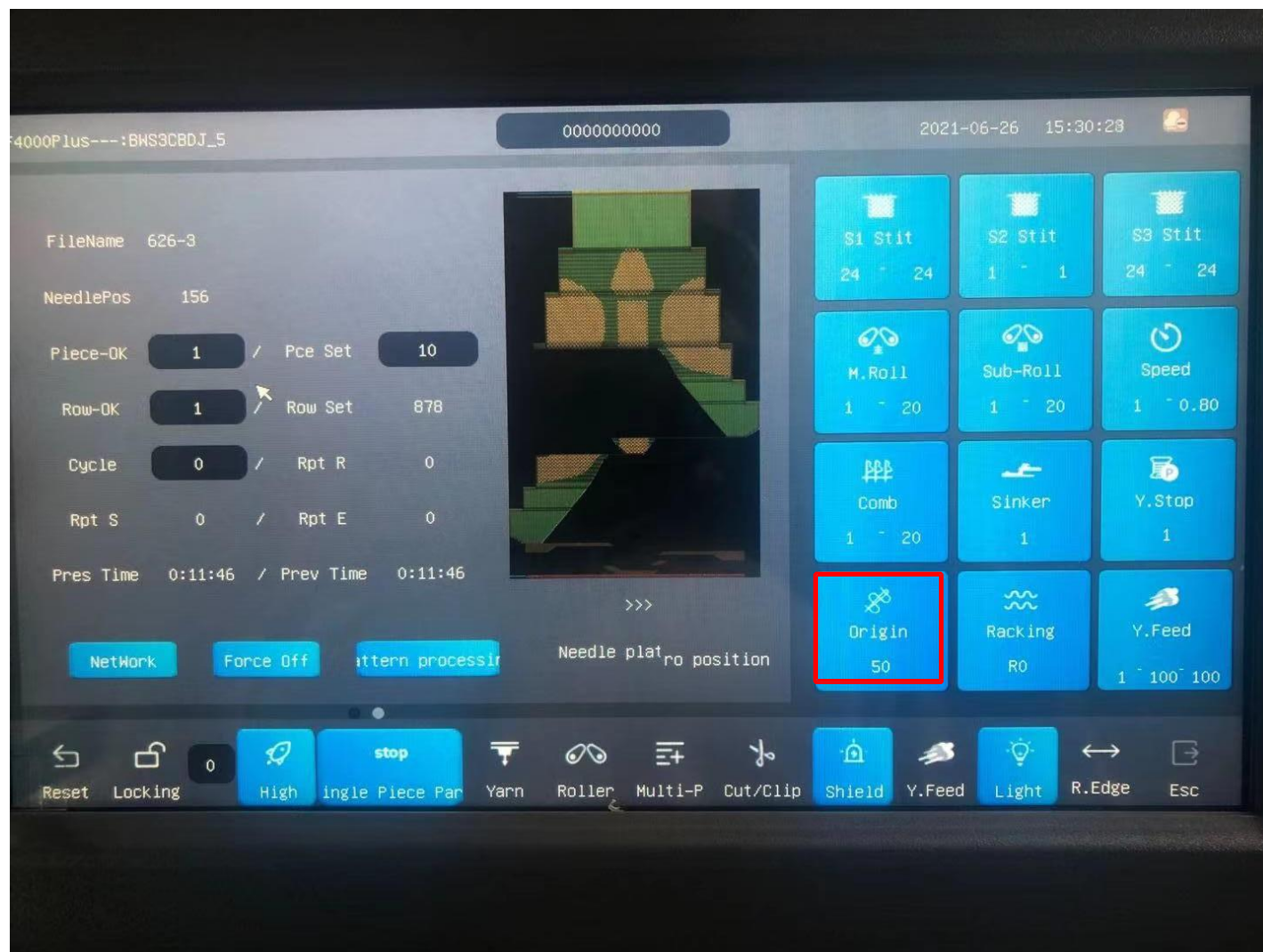
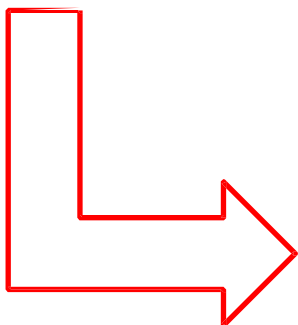
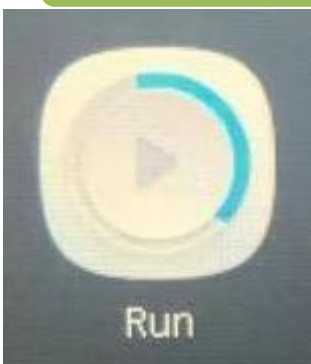
Choose the pattern in file interface





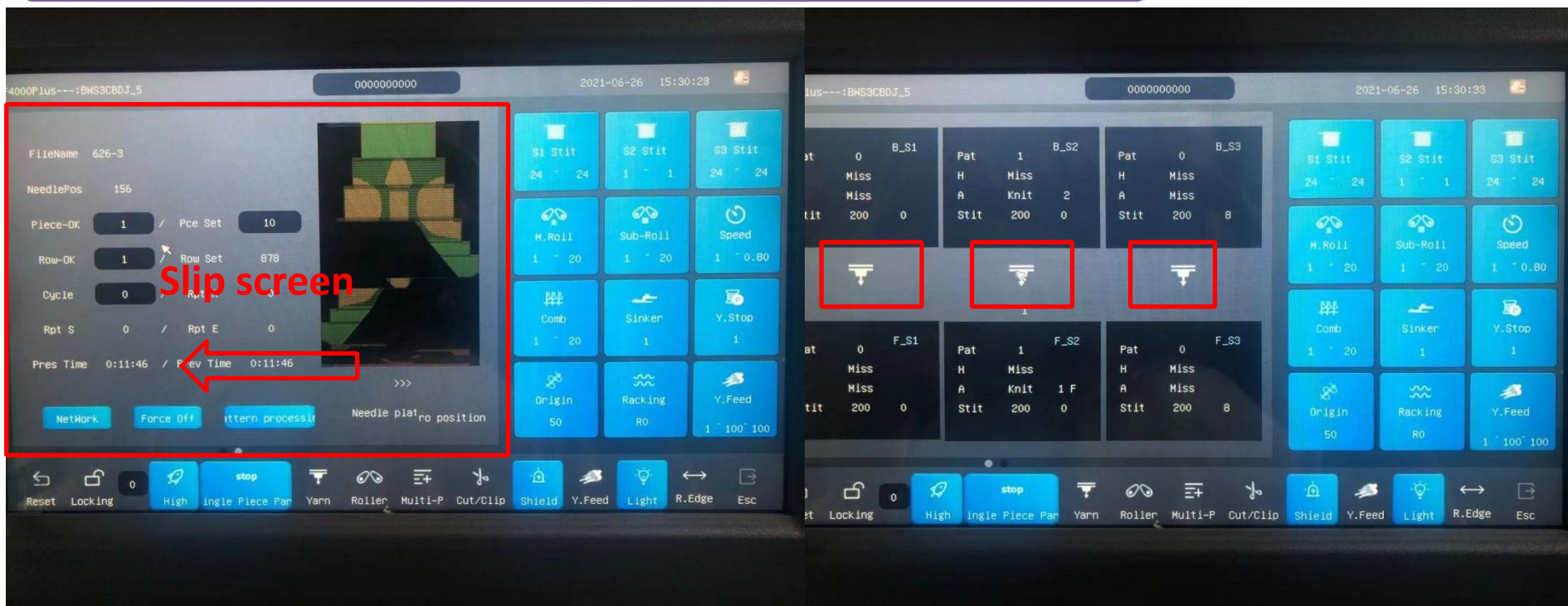
III、Roller pattern running steps

Set the start needle at running interface



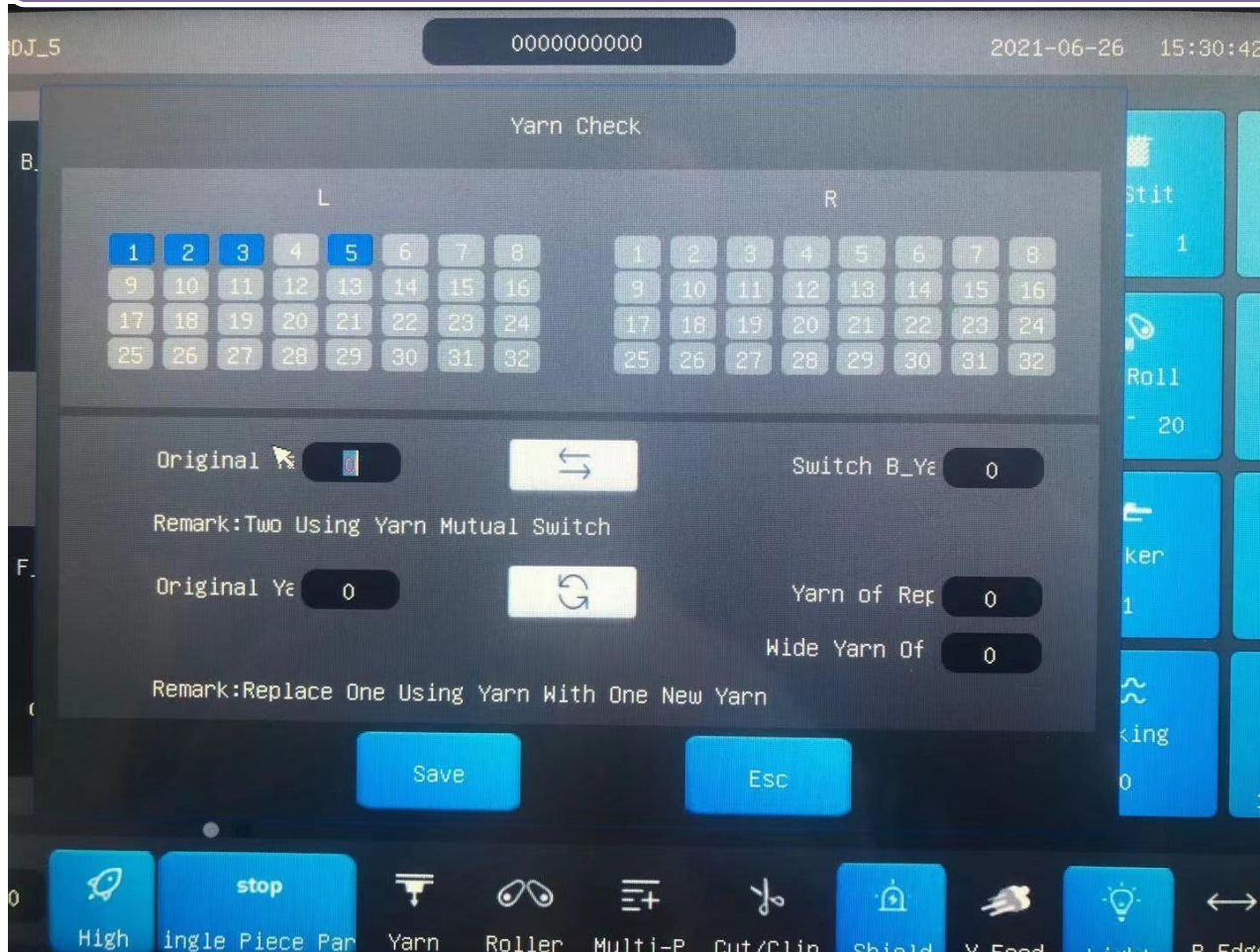
III、Roller pattern running steps

Check the feeder or change one to another



III、Roller pattern running steps

Check the feeder or change one to another



III、Roller pattern running steps

Set speed、stitch、takedown/roller value



Stitch: control fabric size/loop size

Roller: control tension of fabric while knitting

Speed: carriage running speed

Yarn stop: feeder stop position out of knitting area

III、Roller pattern running steps

Rules of stitch

F4000Plus---:BWS3C8DJ_5 0000000000 2021-06-26 15:30:55

Work Stit Not Work Stit Tight Density Double Stit Degree of beak

	<<-S1		<<-S2		<<-S3		S3->>		S2->>		S1->>	
	Front	Back	Front	Back	Front	Back	Front	Back	Front	Back	Front	Back
1	200	200	200	200	200	200	200	200	200	200	200	200
3	0~600 280	280	280	280	280	280	280	280	280	280	280	280
4	250	250	250	250	250	250	250	250	250	250	250	250
5	300	300	300	300	300	300	300	300	300	300	300	300
7	320	320	320	320	320	320	320	320	320	320	320	320
8	265	265	265	265	265	265	265	265	265	265	265	265
23	250	250	250	250	250	250	250	250	250	250	250	250
Empty	200	200	200	200	200	200	200	200	200	200	200	200

Page: 1/16

PnUp PnDn Copy Copy F_Panel Copy B_Panel

Stit Setup M.Motor Sinker Roller Comb Yarn Park Multi-P Y.Feed Esc

Used value will be red colour , and show before of unused value

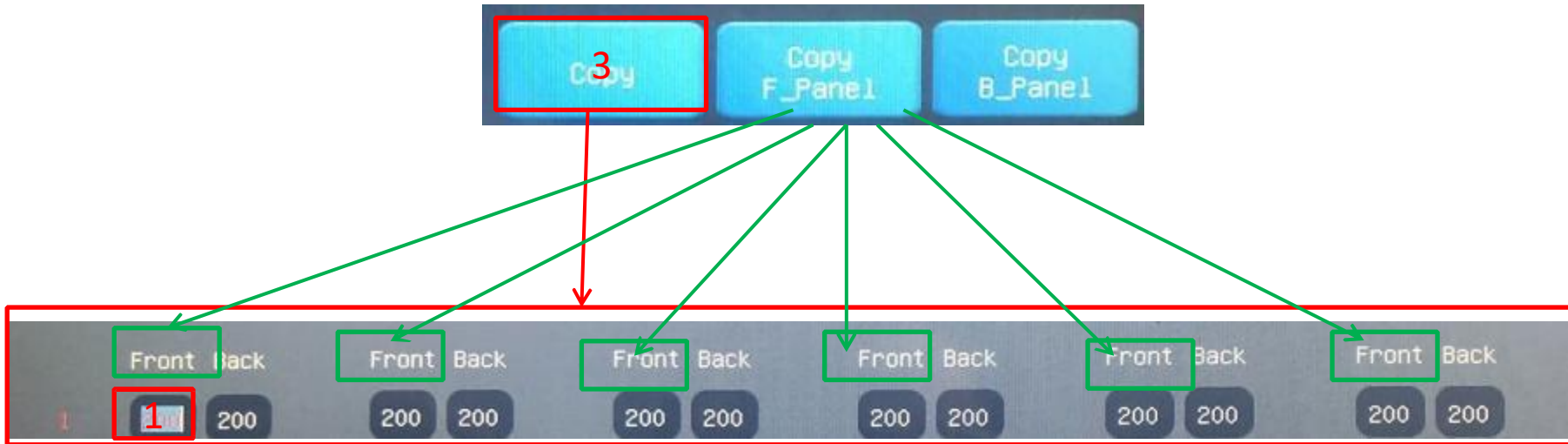
III、Roller pattern running steps

Rules of stitch

sample: 7G 26s/2 2ply or 3ply; normal section					
sect ion	stitch	reference value	sect ion	stitch	reference value
1	birds eyes	180—220		3by1 rib	230—270
2	full needles	200—230	7	translation	Rib—body
3	fall off	300—400			follow chart
4	ribbing starting	50—120	8	body	Jersey280—450
5	tubular	120—260			double220—300
6	tubular rib	250—300	9	bind off	follow chart
	1by1 rib	100—160	16	finish yarn	260—360
	2by1 rib	160—220	23	transfer	Same as 8
	2by2 rib	160—230	24	empty rows	220—320
	3by2 rib	220—270	25	elastic yarn	450-600
	3by3 rib	220—280	/		

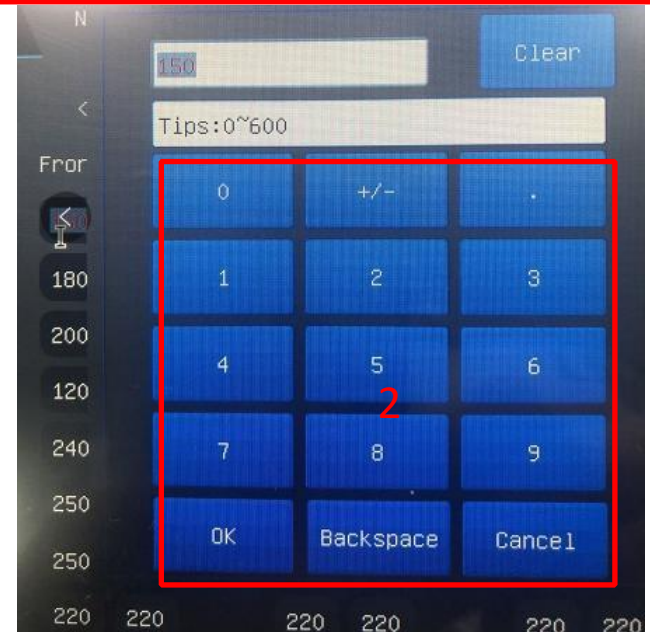
III、Roller pattern running steps

Rules of stitch



We set up one value then use “copy” normally, “copy F-panel” and “copy B-panel” used to specific pattern and , which value copy choose it first, operation steps is 1 -2-3

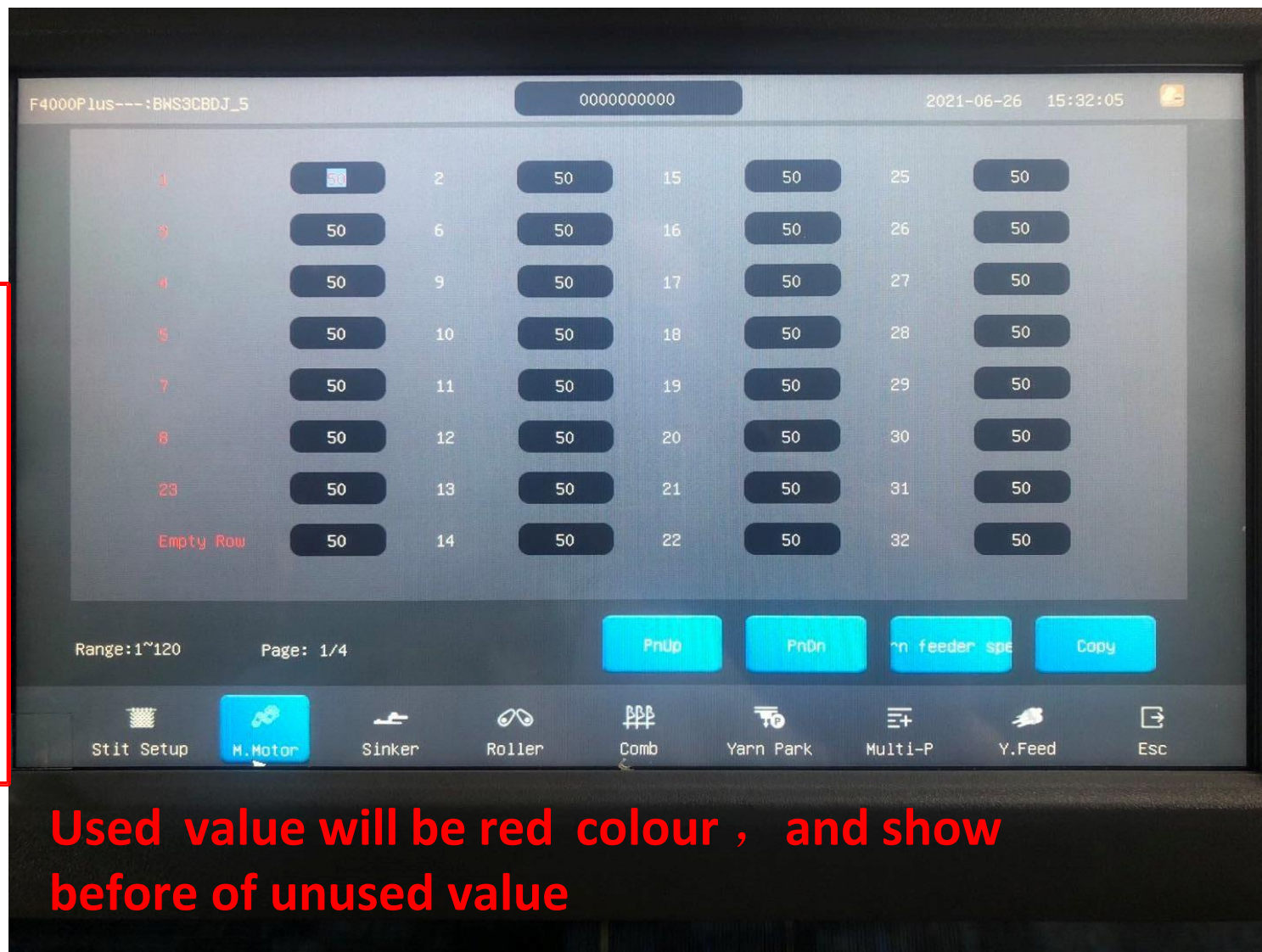
The value more ,the fabric loose more



III、Roller pattern running steps

speed

The value more,
the speed fast
more,
production
speed within 70
is better for
machine life



F4000Plus---:BNS3C8DJ_5 0000000000 2021-06-26 15:32:05

1	50	2	50	15	50	25	50
3	50	6	50	16	50	26	50
4	50	9	50	17	50	27	50
5	50	10	50	18	50	28	50
7	50	11	50	19	50	29	50
8	50	12	50	20	50	30	50
23	50	13	50	21	50	31	50
Empty Row	50	14	50	22	50	32	50

Range: 1~120 Page: 1/4 PnUp PnDn On feeder spe Copy

Stit Setup M.Motor Sinker Roller Comb Yarn Park Multi-P Y.Feed Esc

Used value will be red colour , and show before of unused value

III、Roller pattern running steps

takedown

The value more,
the takedown
more, 23
section within 5
normally



III、Roller pattern running steps

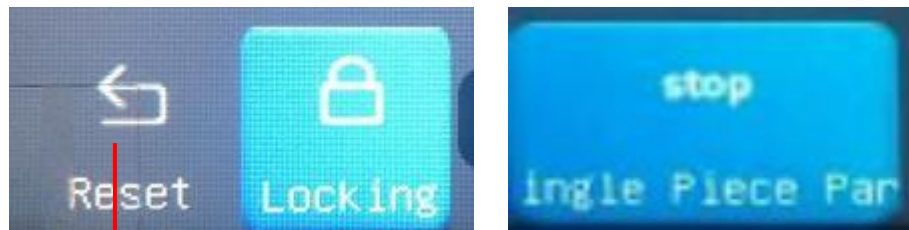


- 1、the value more , the distance more
- 2、main yarn near, finish yarn far
- 3、main yarn keep within 1 inch
- 4、feeder don't overlap

Yarn feeder stop position

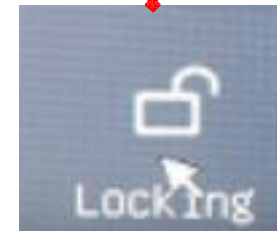
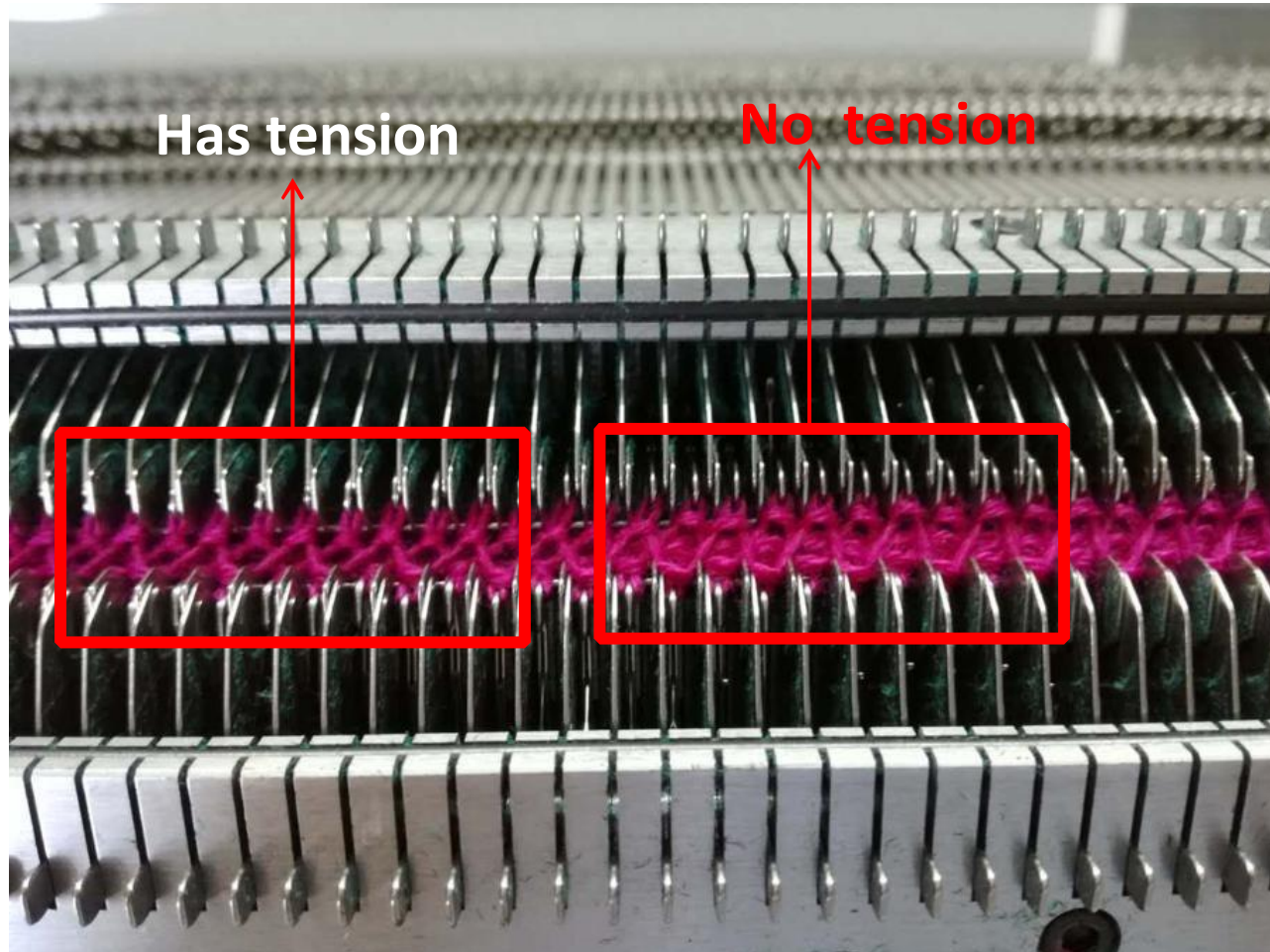
III、Roller pattern running steps

Reset the carriage , lock the rows



III、Roller pattern running steps

Unlock while fabric has tension



Be careful ,
unlock till all
fabric has tension

III、Roller pattern running steps

Unload after pattern finish



F3, yarn feeder will be took out , and unload the fabric
Another way, hand move feeder to far of knitting area,
running carriage

operation cautions

1.Safety first

2.Check needle bed and carriage condition before running machine

3.Remember lock 1-2 row

4.Fabric have tension of takedown , remember unlock

5.Keep an eye on fabric of needle bed gap, adjust stitch takedown depends actual situation

6.Press the emergency button or feeder free when threading yarn or change needles

IV、 Other operation---multi pieces

1.system parameter- comb (off) --clip (off)

2.Running interface—origin need small

3.open the pieces

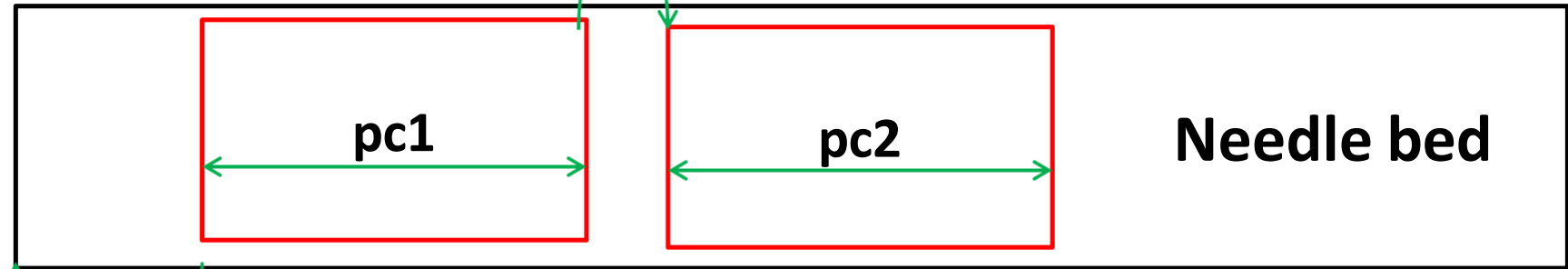
4.Set piece space

5.Change the yarn feeder

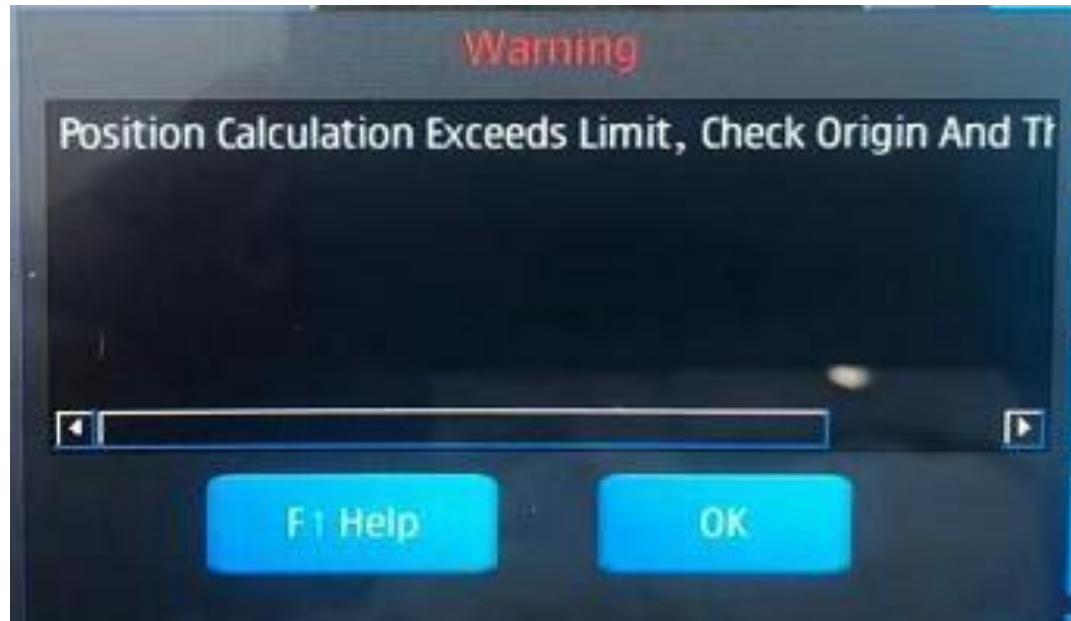
6.Lock the rows, Free running 2 rows , look at selection Jack , find out area of each piece , push the yarn feeder to beginning of each knitting area

IV、Other operation---multi pieces

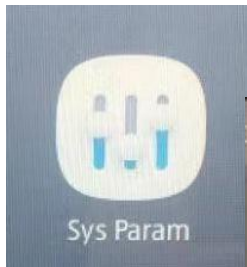
Piece space



Origin+pc1+ piece space+pc2 ≤ needle bed, otherwise



IV、Other operation---multi pieces



8888

000Plus---:BWS2Dj_5 0000000000 2021-06-29 09:23:48

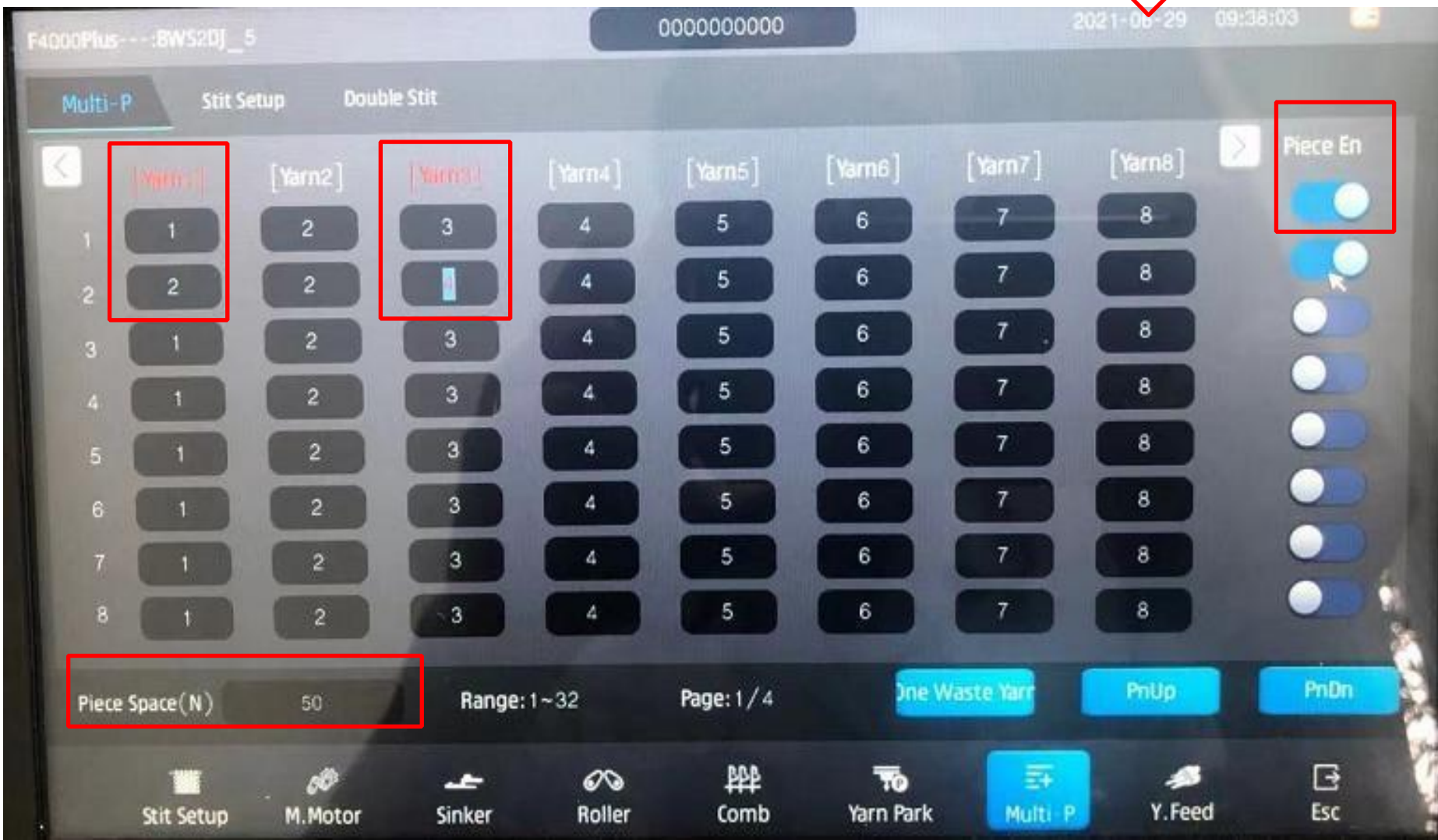
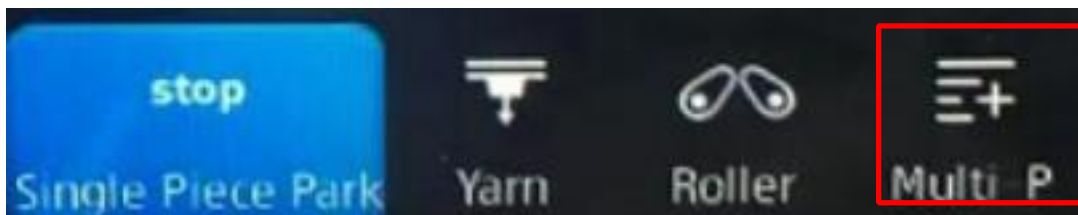
Left Park Pos. (N)	149	Right Park Pos. (N)	834	Cut Act Times	1
Comb Park Torque (%)	Left Limit Pos - Needle Zero Pos	No	R_Clip Enabled	No	
Comb Enable	No	Comb Delay Y.Open	100	Comb Y.Hook Failed	25
L_Clip2 Highest	800	Clip 1 Park Pos	0	1~100 Pin Pull	1
L_Clip1 Highest	800	L_Clip2 Park Pos	0	101~200 Pin Pull	5
R_Clip2 Highest	800	Clip4 Park Pos	0	201~300 Pin Pull	10
R_Clip1 Highest	800	R_Clip1 Park Pos	0	301~400 Pin Pull	10
Cut Do With Clip	No	Cut Over Zero More	0	401~500 Pin Pull	10
Cut-Clip Mode	Normal	Test Menu Modify En	No	More Than 500 Pin Pull	20
Comb Brake Rows	2	R_Yarn Initial Pos	0	Pre-Hook Mode	0
L_Yarn Initial Pos	0				

Normal Racking Trans.Rack Knit Rack Stit Offset Dou.Stit Comb Spe.Machine Esc

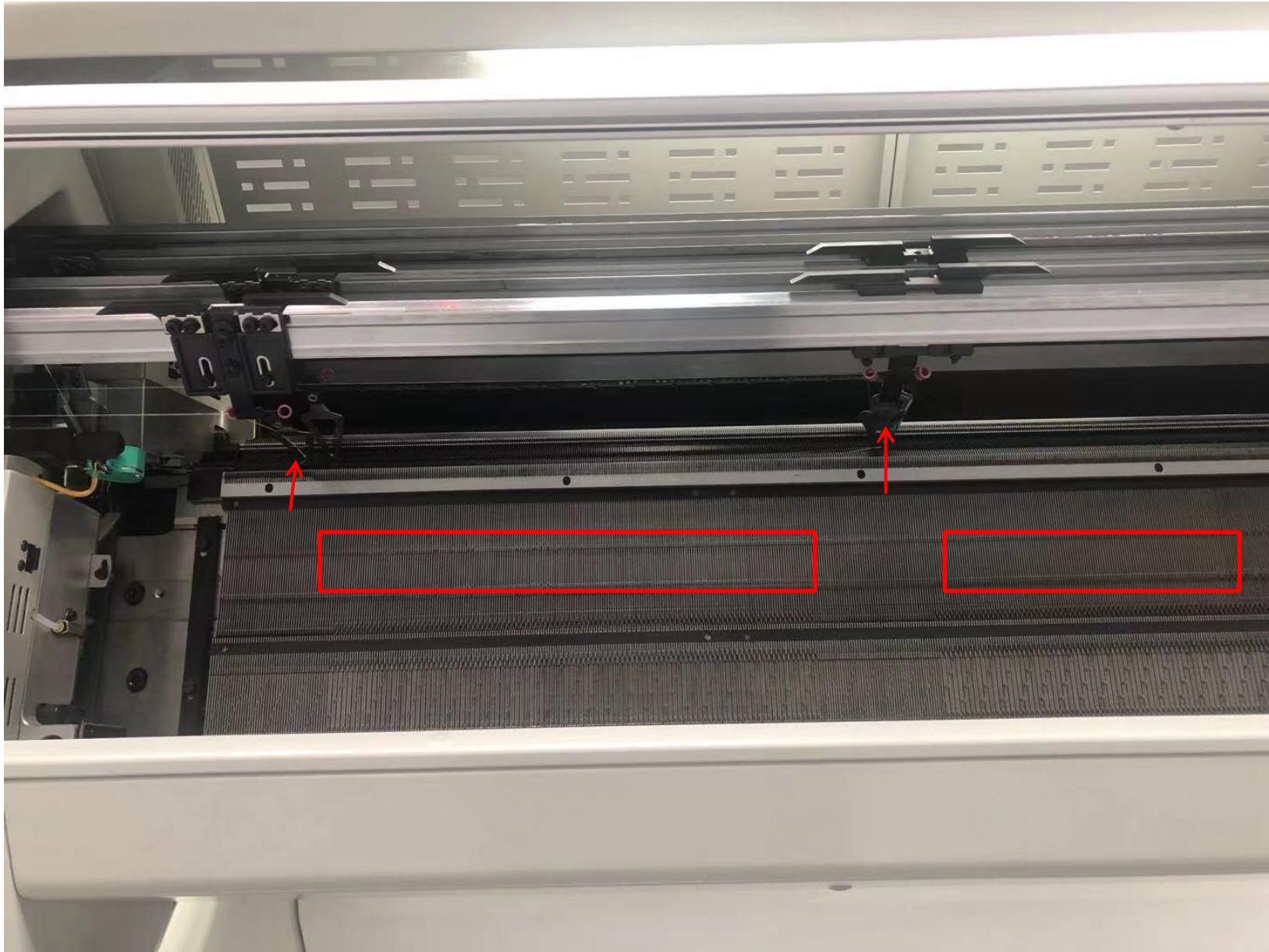


MeMeTech

IV、Other operation---multi pieces

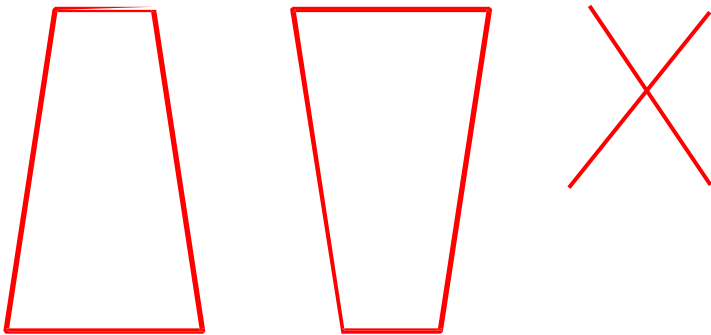


IV、Other operation---multi pieces



IV、 Other operation---cycle

Cycle means lock some rows to knitting, same with pattern start lock



1. Same knitting before and after cycle rows
2. Feeder position park same before and after cycle
3. Needles same before and after cycle

IV、Other operation---cycle

Cycle 1

F4000 5200026742 2021

	Start Row	End Row	Cycle-index	
1	1	4	1	Delete
2	50	100	20	Delete
3	0	0	0	Delete
4	0	0	0	Delete
5	0	0	0	Delete
6	0	0	0	Delete
7	0	0	0	Delete
8	0	0	0	Delete
9	0	0	0	Delete
10	0	0	0	Delete

Cancel last 1

1

Total Row 196

Save

Cnt

Pat

C Yarn

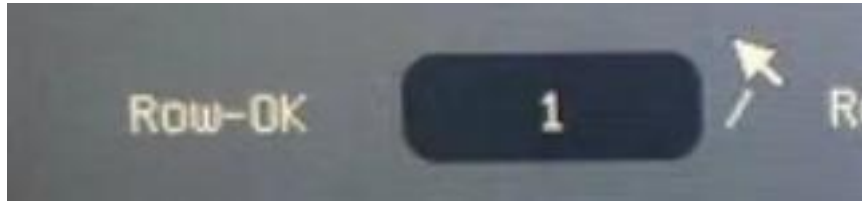
Econ

Var.Den

Crop

Esc

IV、 Other operation---jump



Machine go to running the row you set up, and carriage auto reset after setup this parameter,

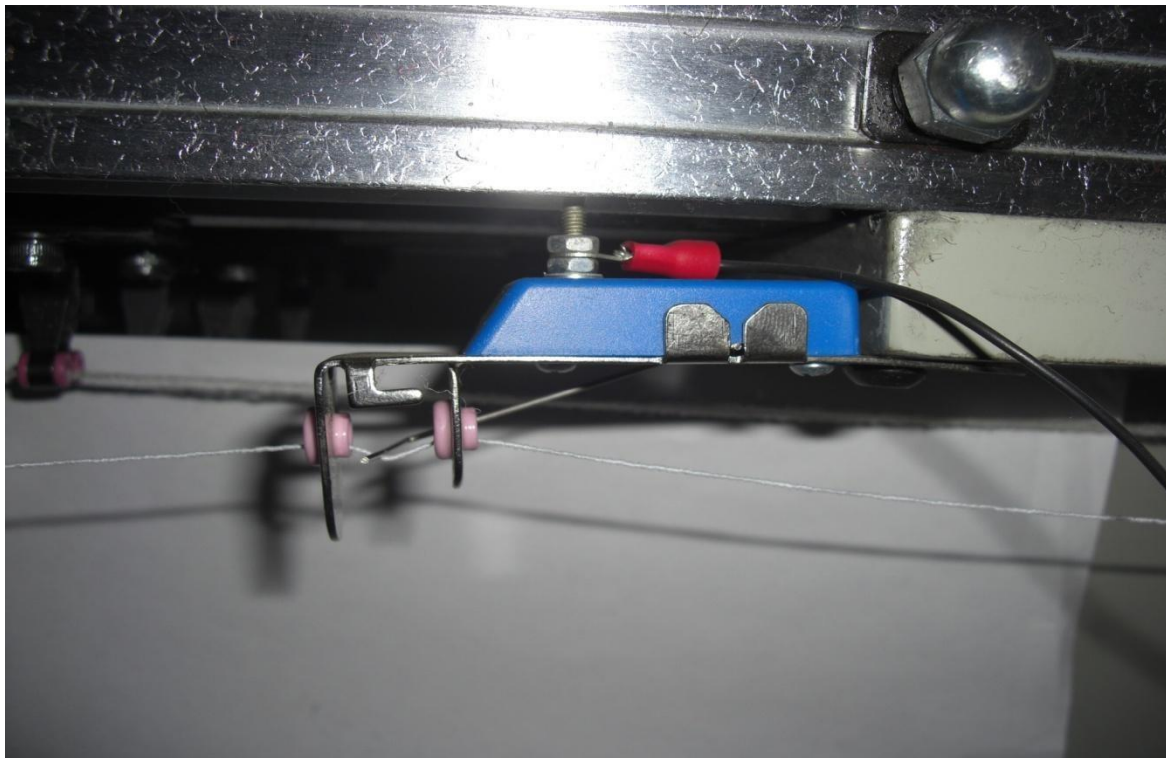
before jump rows, make sure that

- 1. Carriage stop outside of knitting area**
- 2. Needles are same before and after jump**
- 3. Yarn feeder stop same side of knitting area**
- 4. Pattern is matched before and after jump**

why need be careful these things?

IV、 Other operation---comb pattern running

- 1、 must use comb pattern, it has auto yarn feeder in and out, auto unload fabric , and use #8 feeder for comb yarn
- 2、 #8 yarn feeder must threading comb yarn



Machine left side

IV、Other operation---comb pattern running

4、comb & clip enable “on”

Plus---:BWS2DJ_5 0000000000 2021-06-29 16:02:51

Left Park Pos.(N)	149	Right Park Pos.(N)	834	Cut Act Times	1
Comb Park Torque(%)	Left Limit Pos~ Needle Zero Pos	Yes	R_Clip Enabled	Yes	
Comb Enable	Yes	Comb Delay Y.Open	100	Comb Y.Hook Failed	25
L_Clip2 Highest	800	Clip1 Park Pos	0	1~100 Pin Pull	1
L_Clip1 Highest	800	L_Clip2 Park Pos	0	101~200 Pin Pull	5
R_Clip2 Highest	800	Clip4 Park Pos	0	201~300 Pin Pull	10
R_Clip1 Highest	800	R_Clip1 Park Pos	0	301~400 Pin Pull	10
Cut Do With Clip	No	Cut Over Zero More	0	401~500 Pin Pull	10
Cut-Clip Mode	Normal	Test Menu Modify En	No	More Than 500 Pin Pull	20
Comb Brake Rows	2	R_Yarn Initial Pos	0	Pre-Hook Mode	0
L_Yarn Initial Pos	0				

Normal

Racking

Trans.Rack

Knit Rack

Stit Offset

Dou.Stit

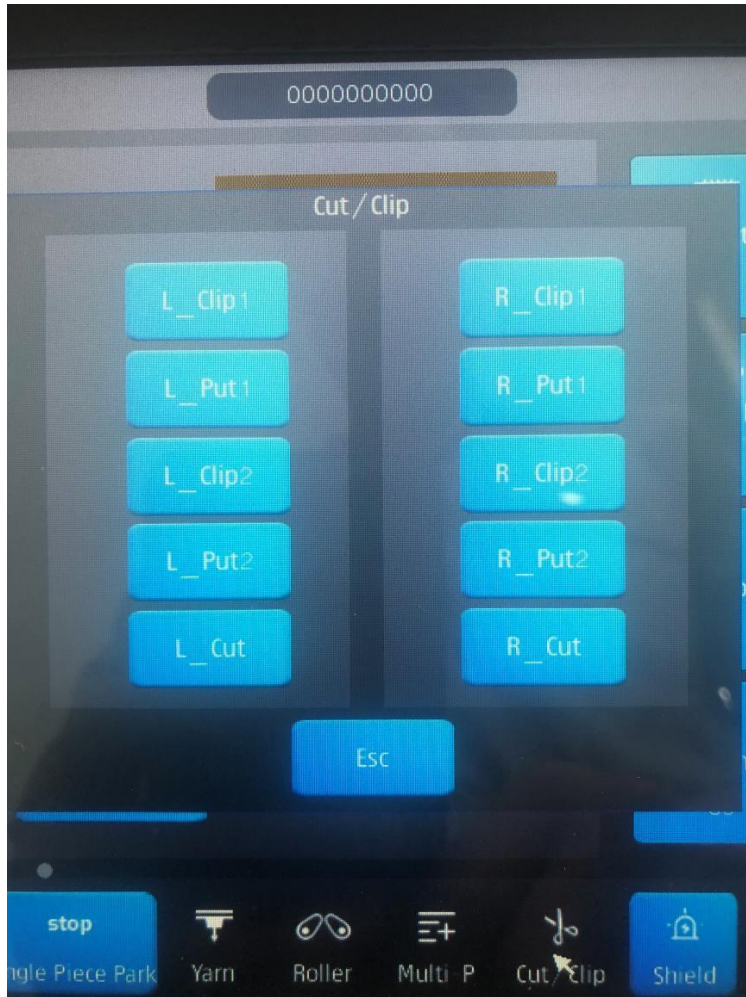
Comb

Spe.Machine

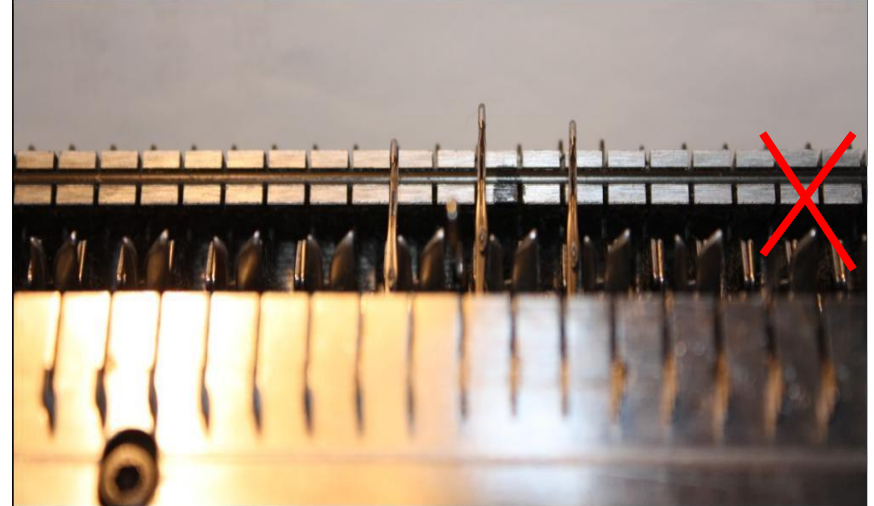
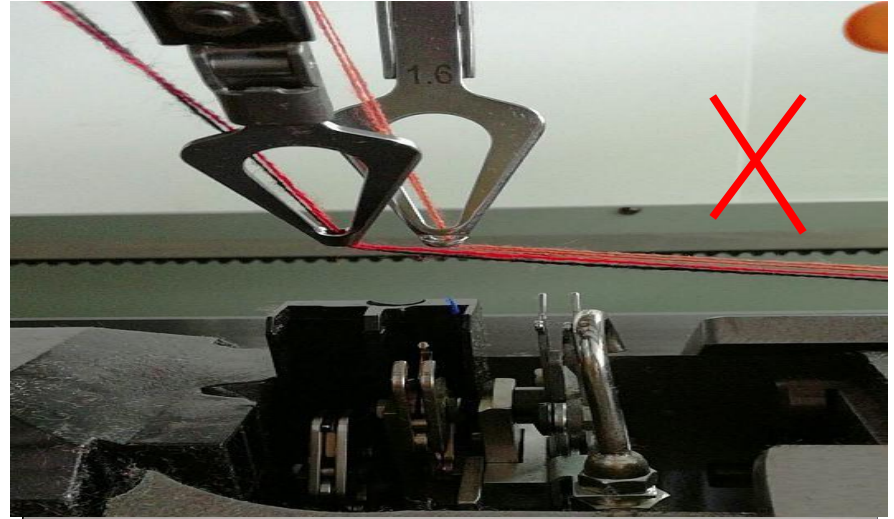
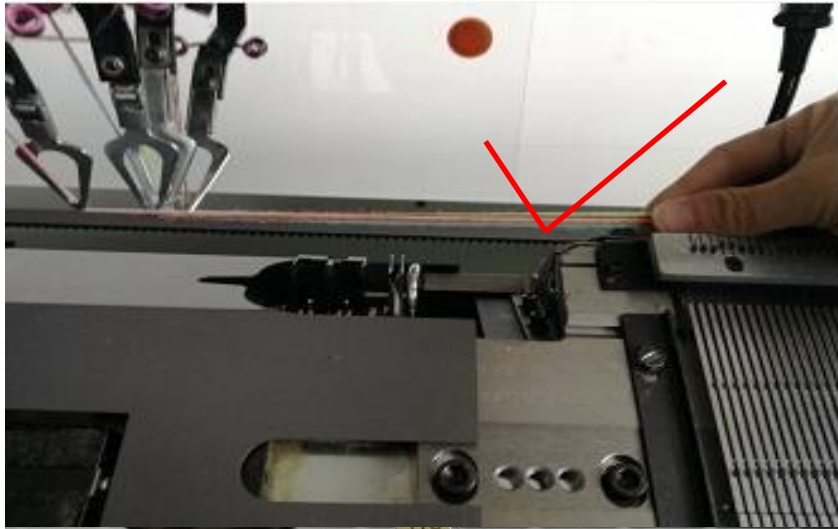
Esc

IV、 Other operation---comb pattern running

5、 all feeder push out of clip, hook the yarn and cut extra yarn



IV、 Other operation---comb pattern running



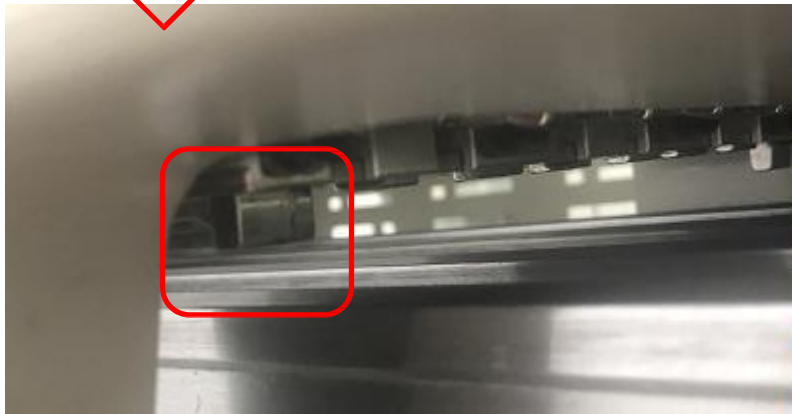
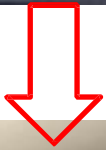
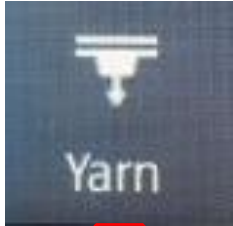
Safety for your body & machine, please operation with right way

IV、 Other operation---set up preset pieces



Set up 4 pieces, then knitting 4 pieces machine stop & alarm

IV、 Other operation---yarn feeder free



Used to hand unload fabric while problem happened or threading yarn

IV、 Other operation---file interface

1

Memory

USB

2

Refresh

Check

Download

Cancel

Delete

Name	Time	Size
System Volume Information	2021-06-29 15:52	4096
000.RNS	2021-06-29 15:48	39883
111.RNS	2021-06-29 15:47	34011
628-1-1.RNS	2021-06-28 18:02	25267
628-1.RNS	2021-06-28 16:10	22860
BW鞋21003.RNS	2021-06-24 08:33	31973
623-2.RNS	2021-06-23 16:08	15868
8967-41.RNS	2021-06-23 14:08	104050
四色-41右-1.RNS	2021-06-23 10:19	204896

PgUp

PgDn

DirUp

DirDn

Manage

Schedule

Param Manage

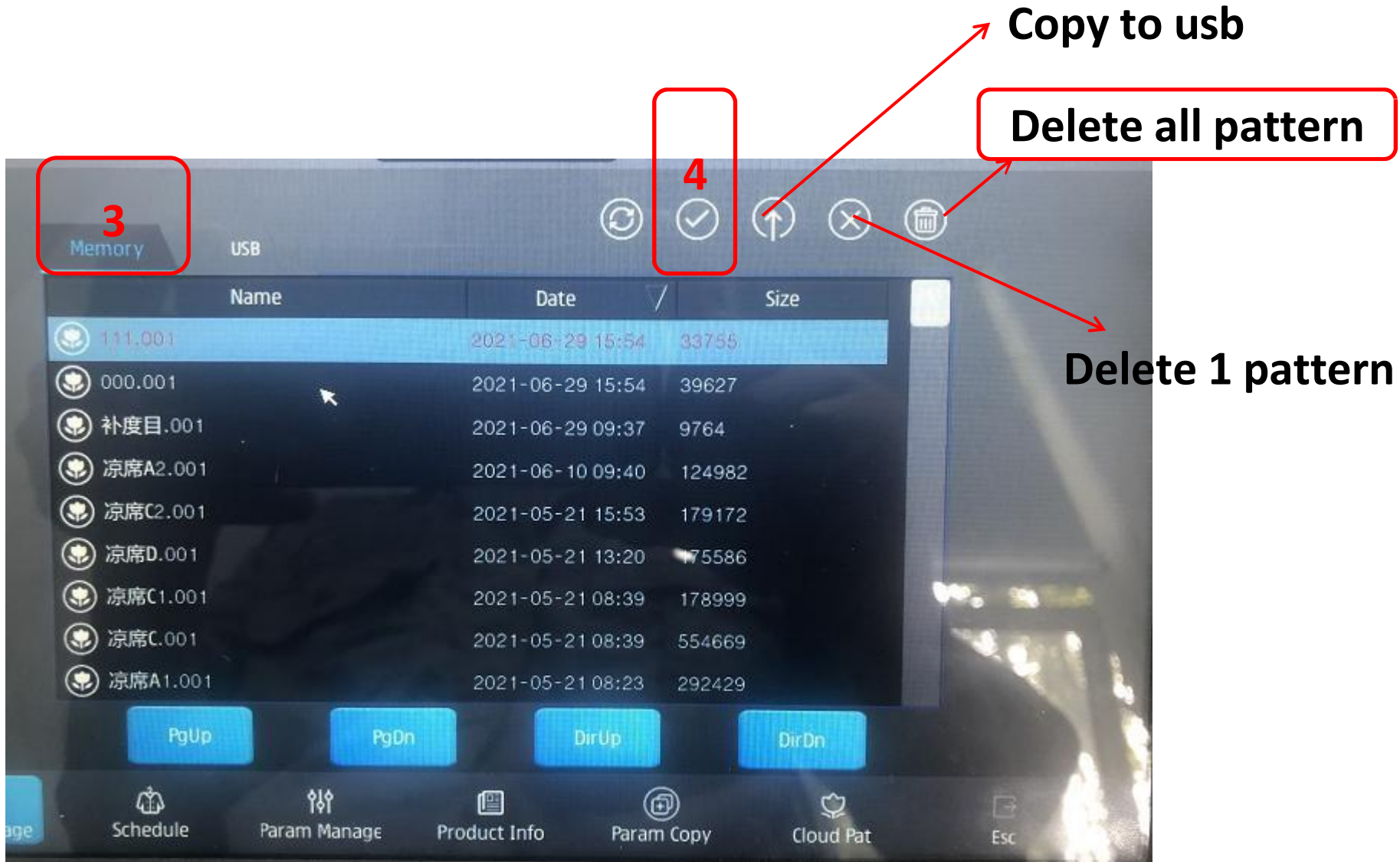
Product Info

Param Copy

Cloud Pat

Esc

IV、 Other operation---file interface



The screenshot shows the MeMeTech file interface. At the top, there is a 'Memory' button (labeled 3) and a 'USB' button (labeled 4). Below these are several icons: a refresh icon, a checkmark icon, an upload icon, a delete icon, and a trash can icon. The main area displays a table of files with columns for Name, Date, and Size. The first row is highlighted. At the bottom, there are four buttons: PgUp, PgDn, DirUp, and DirDn. Below these are six icons: Schedule, Param Manage, Product Info, Param Copy, Cloud Pat, and Esc.

3 Memory

4 USB

Copy to usb

Delete all pattern

Delete 1 pattern

Name	Date	Size
111.001	2021-06-29 15:54	33755
000.001	2021-06-29 15:54	39627
补度目.001	2021-06-29 09:37	9764
凉席A2.001	2021-06-10 09:40	124982
凉席C2.001	2021-05-21 15:53	179172
凉席D.001	2021-05-21 13:20	175586
凉席C1.001	2021-05-21 08:39	178999
凉席C.001	2021-05-21 08:39	554669
凉席A1.001	2021-05-21 08:23	292429

PgUp PgDn DirUp DirDn

Schedule Param Manage Product Info Param Copy Cloud Pat Esc

Over

Thanks