



ZSK Stickmaschinen GmbH

MADE
IN
GERMANY

T8 Operating Unit User Manual



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General Settings

Reset

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1. Switch off the machine
2. Wait 20 sec.
3. Switch on the machine

Press ZSK-button until green diode jumps to pantograph field immediately.

Hold down the blue button until the yellow field appears.

L5 Use most recent setup data

L6 Use default data

L8 Resume switch-on operation

L8 Resume design stitch

Install mouse

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Switch off the machine

Connect the mouse to a free USB port.



Design from internet

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When the notification “No design on desk” appears while loading disk to machine-computer your design name is too long.

Info: Design name may not be longer than 8 characters.

Change T8 Computer

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- Connect new computer T8
- Switch on the machine
- Fault no. 42
- R8 Confirm
- Fault no. 58
- R8 Confirm
- Fault no. 104
- R8 Confirm
- Put in USB stick
- L7 Pantograph configuration
- ▼ ZSK machine software
- L8 Change directory
- ▼ Anw...
- L8 Change
- ▼ To ZSK
- L8 Select all files
- L8 Install
- R8 Exit
- Fault no. 71
- R8 Confirm
- L6 ☒ Use default data
- L8 Resume switch-on operation
- L8 Confirm

Info: Language for dialog change

L7

R1 Language for dialog texts

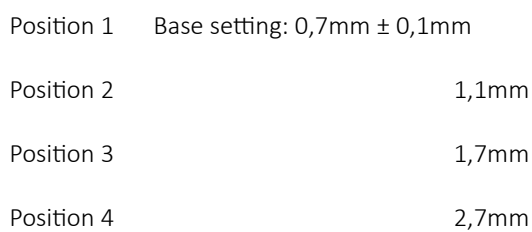


Choose

L8 Confirm

L8 Previous

Info: It is advantageous to load the ZSK software again



i-Button

The meaning of button

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Pressing + e.g. L3 i

[L1] Machine Information

At this point any information about the machine can be found, including e.g. serial number.

Password

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- L1
Shift + U₀
- L8 Machine password
- L8 Change
- L4 Password 1
- L5 Password 2
- L6 Password 3
- L8 Accept password

[L2] Machine Setup

All functions for embroidery are set up here

Language Change

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- L2
- R1 Language for dialog texts
- ▼ Choose
- L8 Confirm
- L8 Previous
- Or Shift + U1



Sequins 5/7/4 ...

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L2

L3 Sequins

L4 Sequins e.g. 7 mm

L8 Confirm

L8 Previous

From Simple to Complete Operations Mode

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L2

L3 Accept authority

XXXX

With "U" button

L8 Confirm

Change start stitches after trimming

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L2

Shift + U₀

L5 Trimming set-up

Start stitches after trim.

4

<-- > with "U" button

L8 Confirm

L8 Previous

Selective embroidery ON/OFF

[Back to Overview](#)

L2

Shift + U0

R5 Thread break set-up

L1 ☐ Selective embroidery

L8 Confirm

L8 Previous

Constant Speed ON/OFF

[Back to Overview](#)

(Machine design must be closed)

L2

L1 Speed set-up

L3 ☒ Constant speed (ON/OFF)

L8 Confirm

L8 Previous

Info: If constant speed is activated while loading process, an error message will appear - „Optimizing of too long stitches“.

Snap in back stitches (design must be on screen)

[Back to Overview](#)

L2

R1 Operation modus setup

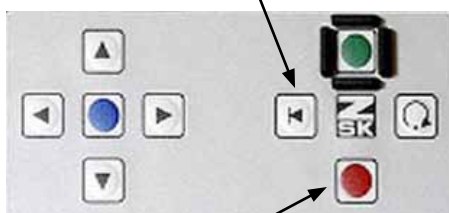
L5 ☒ Snap in back stitches

L8 Confirm

L8 Previous

Info: When you tap on “back-stitch-button” the pantograph moves backwards until you press “stop-button” (red button).

Back- Stitch Button



Stop Button

Change access authority

[Back to Overview](#)

L2

Insert Access authority with “U” button e.g.

L7 Change access authority

Insert new access authority with “U” button e.g.

L4 Confirm access authority 2222

L8 Confirm



Appliqué travel (Close machine design)

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L2

R1 Operating modes setup

L2 ☒ Appliqué travel

☒ R2Continue embroidery immediately

L8 Confirm

L8 Previous

Info: Load and embroider the design with all travels to place the appliqué accordingly.

Positioning (Close machine design)

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L2

R1 Operating modes setup

L3 ☒ Positioning

R3 ☒ Continue embroiders immediately

L4 X path

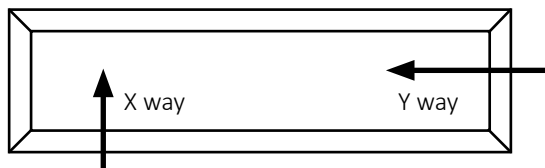
U2 

U3 Enter f.ex. 150mm via the "U" button

✕ maybe enter R4 y path direction

L8 Confirm

L8 Previous



Info: Load and embroider a design
For changing the frames, the positioning will be carried out after the completion automatically

Automatically reverse embroider stitches

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L2

Shift + U0

R5 Thread break setup

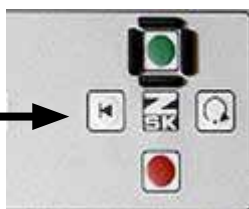
L2 Automatically reverse embroider stitches

U1 = 1
 U0 = 0 } = 10

L8 Confirm

L8 Previous

If there are to less press



Displacement after trimming

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L2

Shift + U0

L5 Trimming setup

L4 Displacement after trimming

With "U" button e.g. 100 Inc = 10 mm

L8 Confirm

L8 Previous

Switching thread sensing (up/down) (on/off)

[Back to Overview](#)

L2

Shift + U0

R5 Thread breaks setup

L4

L5 upper & lower

L8 Confirm

L8 Previous



Tool Borer/ Loop/ Cord/ Sequin

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L2

L2 Tool setup

e.g. R3 ☒ Cord embroidery

L8 Confirm

L8 Previous

[L3] Service

Maintenance functions and testing of machine attachments

DIP Switches (Borer Version)

[Back to Overview](#)

L3
Shift + U₀

L5 ZSK engineer

L2 DIP switches



Choose (until Borer version) (S 29 – S 32)

L7 Change setting



Choose

L8 Change setting

L8 Save setting

L7 Change setting

4. Switch of machine

5. Wait 30 seconds

6. Switch on machine

Info: Needle assign

R5

1 2 3 4 5
1 2 3 4 5

↙ Borer

L7 Defaults

L8 Confirm

DIP Switches (Sequin Device)

[Back to Overview](#)

L3

Shift + U₀

L5

ZSK engineer

L2

DIP switches



Choose (until sequin device) (S33- S36)

L7

Change setting



Choose

- 0000 - NO
- 1000 - Right
- 0100 - Left
- 1100 - Right and Left

L8

Change setting

L8

Save setting

L7

Change setting

DIP Switches (Loop-Cord Device)

[Back to Overview](#)

L3

Shift + U₀

L5

ZSK engineer

L2

DIP switches



Choose (until Loop device vers.) (S37-S40)

L7

Change setting

L8



Choose

- 0000 - NO
- 1000 - Right
- 0100 - Left
- 1100- Right and Left

L8

Change setting

L8

Save setting

L7

Change setting



Pantograph Start Change

[Back to Overview](#)

- L3
Shift + U₀
- L5 ZSK engineer
- L1 Degrees
- DEL

 press

e.g. 285 (feed data into) (U2 U8 U5)
- L8 Confirm
- L8 Previous
- L8 Previous

Machine Input Signals 1

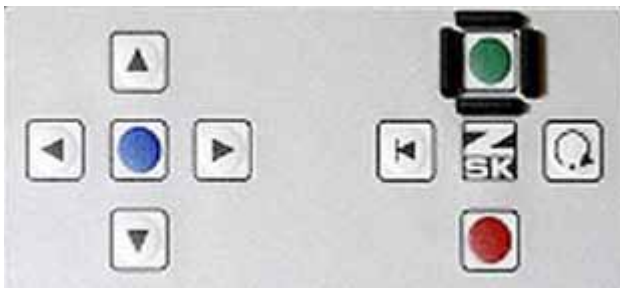
[Back to Overview](#)

- L3
Shift + U₀
- L5 ZSK engineer
- R1 Input signals
e.g. L1 Main shaft
HWOT: 0
- 4x R8 previous

Machine Input Signals 2

[Back to Overview](#)

- L3
Shift + U₀
- L5 ZSK engineer
- R1 Input signals
- L8 Automatic input signal check



test

- 4x R8 Previous

Status KSP Boards

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- L3
Shift + U₀
- L5 ZSK engineer
- R2 Status of KSP boards
- Info:** Head switch on
- L8 Help informations
- 4x R8 previous

Status of Sequin Devices

[Back to Overview](#)

- L3
Shift + U₀
- L5 ZSK engineer
- R3 Status of sequin devices
- Info:** Help switch on
- L8 Help information
- 4x R8 Previous

Fill Stitch Optimization

[Back to Overview](#)

- L3
Shift + U₀
- L5 ZSK engineer
- L3 Machine optimization
- L2 ☒ Fill stitch optimization
- L8 Confirm
- L8 Previous
- L8 Previous



Thread Trimmer Cleaning Position

[Back to Overview](#)

L3

L1



Start machine

Clean with air

2x L8 previous



Oil

Load Recovery Disk

[Back to Overview](#)

L3

Shift + U0

L5 ZSK engineer

R6 Load recovery disk

Create Recovery Disk

[Back to Overview](#)

L
Shift + U0

3

L5 ZSK engineer

L6 Create recovery disk

Create Service Disk

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L3

R1 Create service disk

L8 Format disk

L3 Machine version:

Shift + U2 = J

Shift + L1 = A

Shift + L6 = F

JAF 0215- 495

TAB

R7 = space

U10 = 0

U2 = 2

U1 = 1

U5 = 5

L2 = -

U4 = 4

U9 = 9

U5 = 5

OK

L4 Customer Montero

Shift + U5 = M

U7 = 0

U6 = n

R7 = t

L5 = e

U10 = r

U7 = 0

OK

L7 Write data to disk

L7 Previous

Adjustment of Stitch Sheet

[Back to Overview](#)

- Always Middel Needle

L3

R2 Test machine attachment



Position main shaft

L8 Start testing

With "U" button choose 125

L8 Start testing

Start Machine



Push jump-stitch-magnet

Push down needle bar

Adjust the stitch plate

R8 Stop testing

2x R8 Previous

Install needle plunger without washers

[Back to Overview](#)

Work needle has fallen down

L3

R2 Test machine attachment



Position main shaft

L8 Start testing

L7 Main shaft position

With "U" button choose 125

L8 Start testing

Start machine --> push green Button



Push jump-stitch-magnet

Adjustment of the degree coder

[Back to Overview](#)

L3

Shift + U₀

L5 ZSK engineer

L1 Degrees

R7 Main shaft position (big number)

Cancel

Rotate main shaft and insert set-up pin in cam disk

Continue

Adjusting the degree coder until screen shows 136 degree and fix it

L8 Previous

L8 Confirm

2x L8 Previous

Remove setup pin



Test machine attachment

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L3

R2 Test machine attachment



e.g. Trimmer motor

L8 Start testing

Press stop button

R8 Stop testing

R8 Previous

R8 Previous

Rotary hook adjustment (Test machine)

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L3

R2 Test machine attachment



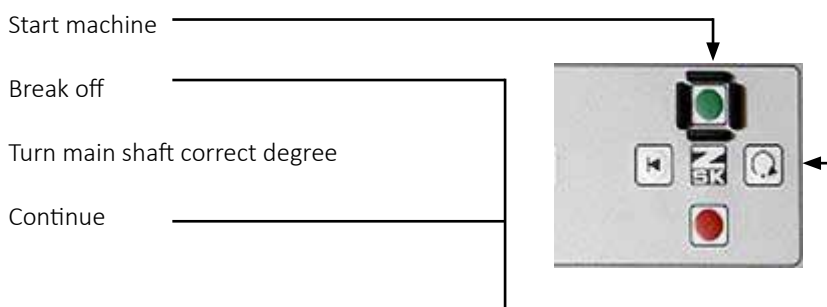
Position main shaft

L8 Start testing

L7 Main shaft position (e.g. 202)

L8 Start testing

L8 Main shaft position (high number)



Sequin "Test machine attachment"

[Back to Overview](#)

L3

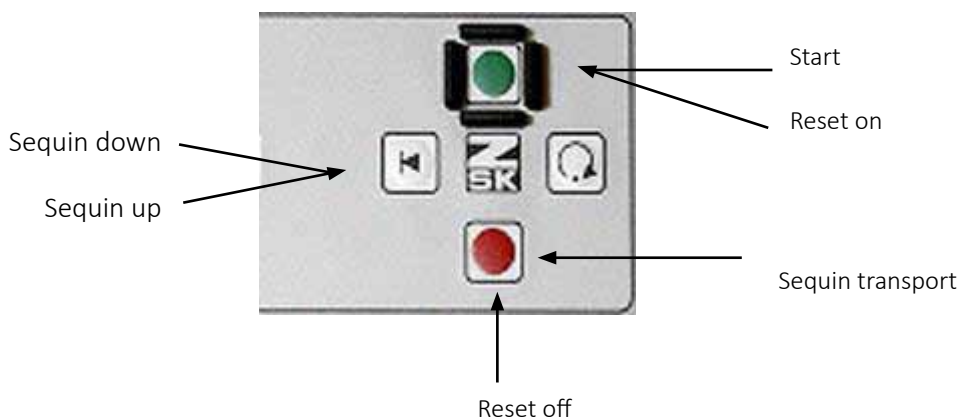
R2 Test machine attachment



Sequin

L8 Start testing

- If the machine is in the position for example Needle 4, start the machine
- If you press START, the machine will switch to Sequin needle
- If the machine is already on Sequin needle, do not start the machine, because this will start the Sequin reset



Borer test machine attachment

[Back to Overview](#)

L3

R2 Test machine attachment



Borer

L8 Start testing

L7 Set boring depth
Main shaft position 141 with "U" button

L8 Start testing
Start machine

L8 Main shaft position (high number)

Break off
Correct 141
Continue
Push jump-stitch-magnet and press borer bar down.

Additional monitoring (photoelectric barrier)

[Back to Overview](#)

L3

Shift + U0

L5 ZSK engineer

L2 Dip switches



Additional monitoring (S 109 – S 112)

L7 Change setting



1000 available (version 1)

L8 Change setting

L8 Save settings

L7 Change setting then.....

Switch off machine

Wait 30 sec.

Switch on machine



Needle down (basic adjustment)

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L3

Shift + U0

L5 ZSK engineer

L1 Degrees



Needle position
With U button (from 70 – 100)

L8 Confirm

L8 Previous

L8 Previous

Trimming: change the degree

[Back to Overview](#)

(if the thread is not always cut)

L3

Shift + U0

L5 ZSK engineer

L1 Degree



Trimming: Interim position

Changing and saving of the default values degrees

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L3

Shift + U0

L5 ZSK engineer

L1 Degrees



Trimming: Interim position e.g. 318

Shift + U0

With “U” button insert 318

L8 Confirm

L8 Previous

L8 Previous

High speed pantograph

[Back to Overview](#)

L3

Shift + U0

L5 ZSK engineer

L2 Dip switches



Up to high speed pantograph (S105-S108)

L7 Change setting



Up to 0000 not available

1000 available (Version 1)

0100 available (Version 2)

L8 Change setting

L8 Save setting

L7 Change setting, then terminate machine...

Switch off machine

Wait 30 seconds

Switch on machine

Loop and cord food align

[Back to Overview](#)

L3

R2 Test machine attachment



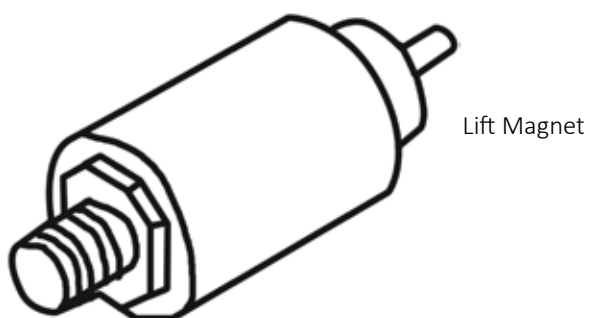
Position main shaft

L8 Start testing

With "U" button insert 100

L8 Start testing

Start machine






[L4] Design Manager

To import several designs into the T8 or to export existing files from the T8, please go into this menu.

Load Disk with Optimize

Back to Overview

- L4
- L1 Load from disk
- TAB
-  Choose
- L8 select design
- L4 optimize with user defined values
- Info:** Optimize with user defined values must be switched on!


Delete all designs in memory

Back to Overview

- L4
- L8 Delete from memory
- U5
- L8 Select design
- L8 Delete design
- R8 Exit

Write to USB device

Back to Overview

- L4
- R2
- U1
-  Select design
- L8 Select design
- L7 Create directory right here

(e.g. design)

OK
- L8 Select
- L6 Write name
- OK
- L8 Confirm

Delete design from USB device

[Back to Overview](#)

L4

L6 Delete from USB device



Select

L8 Select

U1



Choose design

L8 Select design

L8 Delete design

R8 Previous

Load from USB device to EDITOR

[Back to Overview](#)

L4

L2 Load from USB device



Select directory (design)

L8 Select

U1



Select

L8 Select design

L8 Confirm

L6 Optimize with default values

L6 No design modification

R8 Previous



Delete stitch in design (EDITOR)

[Back to Overview](#)

(Mouse must be connected)

L5

U1



Choose design

L8

Select design

R1

- Zoom on frame with right-mouse-button
- Zoom in with L1
- Perhaps center up with L4-L7
- Pick stitch with left-mouse-button

DEL

(delete)

L8

Confirm

R8

L8

Store design

L8

Overwrite design

L6

Optimize with default values

Info: If have pressed R5 (edit stitch) and “U” and you want back then press R3.

Info: If you have pressed R5 (edit stitch) and L4 – L7 press R1 twice.

Load design from disk (into EDITOR)

[Back to Overview](#)

L4

L1

Load from disk

U1



Choose design

U4



Choose design



U4



Choose design

L8

Select design

L6

Optimize with default values

L6

No design modification

L8

Confirm / R8 Previous

Load all designs from disk (into EDITOR)

[Back to Overview](#)

- L4
- L1 Load from disk
- U5
- L8 Select design
- L6 Optimize with default values
- L6 No design modification
- L8 Confirm
- R8 Previous

Delete all designs on disk

- L4
- L5 Delete design on disk
- U5
- L8 Select design
- L8 Delete design
- R8 Previous

Delete dame design on disk

[Back to Overview](#)

- L4
- L5 Delete design on disk
- U1
- ▼ Choose design
- U4 ☐
- ▼ Choose design ☐
- U4 ☐
- ▼ Choose design
- L8 Select design
- L8 Delete design
- R8 Previous






Write all design to disk

[Back to Overview](#)

- L4
- R1 Write data to disk
- U5
- L8 Select design
- L8 Confirm
- R8 Previous

Write same design to USB stick

[Back to Overview](#)

- L4
- R2 Write to USB device
- U1
- ▼ Choose design
- U4 
- ▼ Choose design 
- U4 
- ▼ Choose design
- L8 Select design
- L7 Create directory right here
Write name with “U” button

Write all designs to USB stick

[Back to Overview](#)

- L4
- R2 Write to USB device
- U5
- L8 Select design
- L7 Create directory right here
Write name with “U” button
- OK
- L8 Select
- L8 Confirm
- R8 Previous

Load same designs from USB stick

[Back to Overview](#)

L4

L2 Load from USB device



(Choose directory)

L8 Select

U1

U4



Choose design



U4



L8 Select design

L6 Optimize with default values

L6 No design modification

L8 Confirm

R8 Previous

Load all designs from USB stick to any directory

[Back to Overview](#)

L4

L2 Load from USB device



Choose directory

L8 Select

U5

L8 Select design

L6 Optimize with default values

L6 No design modification

L8 Confirm

R8 Previous

L8 Confirm

R8 Previous



Write same designs to 2H Disk

[Back to Overview](#)

- L4
- L1 Load from disk
- U1
- ▼ Choose design
- U4 ☐
- ▼ Choose design ☐
- U4 ☐
- ▼ Choose design
- L8 Select design
- L8 Select design
- L8 Confirm
- R8 Previous

Delete same design from memory

[Back to Overview](#)

- L4
- L8 Delete from memory
- U1
- ▼ Choose design
- U4 ☐
- ▼ Choose design ☐
- U4 ☐
- ▼ Choose design
- L8 Select design
- L8 Delete design
- R8 Exit

Write data to disk HD

[Back to Overview](#)

L4

R1

U1



Choose

L8

Select design

Info:

| | |
|-----|------------------------------|
| U6 | Display design only |
| U7 | Display tables only |
| U8 | Display all designs/ table |
| U9 | Find design/ table by name |
| U10 | Find design/ table by number |

Write data to 2DD ZSK code disk

[Back to Overview](#)

L4

R1

Write data to disk

U1



Choose

Info:

| | |
|----|-----------------------|
| U6 | Display design only |
| U9 | Find design by name |
| U0 | Find design by number |

L8

Select design

OK

R8

Previous

Format disk

[Back to Overview](#)

L4

R5

Format disk
Choose with format at disk
e.g. L5 HD 1.44 MB transp. Code disk

L8

Format

R8

Previous

Initialize memory (No design on screen)

[Back to Overview](#)

L4

R6

Initialize memory

L8

Initialize memory


R8

Previous




Load from disk to EDITOR

[Back to Overview](#)

| | |
|---|---------------|
| L4 | |
| L1 | |
| U1 | |
|  | Choose design |
| L8 | Select design |

Delete from memory (one design)

[Back to Overview](#)

| | |
|---|--------------------|
| L4 | |
| L8 | Delete from memory |
| U1 | |
|  | Choose design |
| L8 | Select design |
| L8 | Delete design |
| R8 | Previous |

Format disk DD ZSK Stick

[Back to Overview](#)

| | |
|----|--|
| L4 | |
| R5 | Format disk |
| | <input checked="" type="checkbox"/> L6 DD 720 KB ZSK stick data disk |
| L8 | Format |
| R8 | Previous |

Write data to disk DD ZSK Stick

[Back to Overview](#)

L4

R1 Write data to disk

U1



Choose

L8 Select

| | | | | | | |
|----|----|----|---|---|--|--|
| 1 | 2 | 3 | 4 | 5 | | |
| 9 | 10 | 11 | | | | |
| 17 | 18 | | | | | |

L8 Select disk location

R8 Previous

Write to new USB device (Create directory)

[Back to Overview](#)

L4

R2 Write USB device

U1



Choose

L8 Select design

L7 Create directory right here

Enter the name of the design

OK

L8 Select

L8 Confirm

R8 Previous





[L5] Editor

To make adjustments in a design you have to close the design and enter the editor.

Special Function Change

Back to Overview

e.g. Needle to Stop



- L5
- 
- Choose
- L8
- Select design
- R5
- 
- e.g. Needle No.1
- with

TAB

 choose (special function change / insert
- with "U" button choose e.g. stop
- L8
- Change
- R7
- L8
- Design store

Needle Change „Change“

Back to Overview



- L5
- 
- Choose
- L8
- Select design
- L3
- L7
- ☐
- All special function
- L1
- ☒
- Needle change
- L8
- Confirm
- 
- Needle choose
- R5
- with

TAB

 special function change / insert
- e.g. U3
- L8
- change
- R7
- L8
- Design store
- L8
- Overwrite design
- L6
- Optimize with default values


Special Function Insert (Stop)

[Back to Overview](#)

- L5
-  Choose
- L8 Select design
- L3
- L7 ☒ All special functions
- L8 Confirm
-  Needle choose
- R5
- with TAB special function insert
- U0 MORE
- U2 Stop
- L8 Insert
- R7
- L8 Design Store
- L8 Design overwrite
- L6 Optimize with default values

Control Needle 1 Start and End of Design

[Back to Overview](#)

- L5
-  Choose
- L8 Select design
- U4 Design end
- U3 Design start
- R7
- L7 Design not store



Search Design No. and Insert Special Function

[Back to Overview](#)

L5



Choose

L8

Select design

R1

L1

U5

New no. with "U" button

L8

Confirm

R5

Special function insert
e.g. U5 (or press "U0" until stop.....)

L8

Insert

R7

L8

Design store

L8

Design overwrite

L6

Optimize with default values

Move Start and End Point

[Back to Overview](#)

L5



Choose

L8

Select design

R4

L4

Move start point



Choose with L / R button

L8

Confirm

R4

R4

Move end point



Chose with L / R button

L8

Confirm

R7

L8

Design store

L8


Design overwrite

L6

Optimize with default values

Delete all Fixing Sequences

[Back to Overview](#)

- L5
-  Choose
- L8 Select design
- R4
- L5 Delete all fixing sequences
- L8 Fixing sequences delete
- R7
- L8 Design store
- L8 Design overwrite
- L6 Optimize with default values

Store the Editor with Adjustment


[Back to Overview](#)

- L5
-  Choose
- L8 Design select
- R5
- R6
- L2 ☒ Adjustment (Store Editor)
- L8 Confirm
- R7
- L8 Store design
- L8 Overwrite design




Switch Display to Graphic or Tabel View

[Back to Overview](#)

| | |
|---|------------------|
| L5 | |
|  | Choose |
| L8 | Select design |
| R1 | |
| R7 | |
| L7 | Design not store |

Modify Design

[Back to Overview](#)

| | |
|---|--|
| L5 | |
|  | Choose |
| L8 | Select design |
| R4 | |
| L2 | Modify |
| | E.g. L6 <input checked="" type="checkbox"/> Mirror |
| L8 | Modify |
| R8 | Previous |
| R7 | |
| L8 | Design store |
| L8 | Design overwrite |

Optimize - Editor ZSK

[Back to Overview](#)

L5



Choose

L8

Select design

R4

L1

Optimize

L4

Optimize with user defined values

L1

☒ Insert start needle 1

L2

☐ Preset stop function (Tajima)

L3

☐ Trimming ☐ Tajima

R1

☒ Home

R2

☐ DST Borer offset (Tajima)

R3

☐ Jump stitch without travel (Tajima)

L5

More settings

L1

☒ Trim Special function

L2

☒ Cleaning 3 INC

L3

☒ Trim Stitch Length mm

R1

☒ Insert fixing sequences

R2

☒ Maximum stitch length INC

R3

☐ 167'er design

L8

Accept setting

L8

Optimize with set values

L8

Previous

R7

L8

Store design

L8

Overwrite design



Optimize - Editor Tajima

[Back to Overview](#)

L5



Choose

L8

Select design

R4

L1

Optimize

L4

Optimize with user defined values

L1



Insert start needle 1

L3



Trimming 3 Jump stitches

R1



Home

R2



DST Borer offset INC

R3



Jump st. without travel

L2



Preset stop function



2 Stop = Needle 2

3 Stop = Needle 3

4 Stop = Needle 4

Last stop Needle 10 --> If there are a lot of stitches between the last stop and end.

If there are only 1-3 stitches you need Needle 10.

L8

Accept stop table

L5

More settings

L1



Trimming special functions

L2



Cleaning INC

L3



Trimming stitch length 20 mm

R1



Insert fixing sequences

R2



Maximum stitch length INC

R3



167' design

L8

Accept settings

L8

Optimize with set values

L8

Previous

R7

L8

Store design

L8

Overwrite design

Optimize - Editor Tajima

[Back to Overview](#)

L5



Choose

L8

Select design

R4

L1

Optimize

L4

Optimize with user defined values

L1

☒ Insert start needle 1

L3

☒ Trimming 3 Jump stitches

R1

☒ Home

R2

☒ DST Borer offset with "U" button

R3

☐ Jump st. without travel

L2

☒ Preset stop function



To 2 stop

U0

MORE

U3

= Borer ON

U4

= Borer OFF

U9

U2

= Needle 2

U3

= Needle 3 <-- If there are a lot of stitches between last stop and design end.
If there are only 1-3 stitches choose needle No.1

L8

Accept stop table

L5

More settings

L1

☒ Trimming special functions

L2

☐ Cleaning INC

L3

☒ Trimming stitch length 20 mm

R1

☒ Insert fixing sequences

R2

☒ Maximum stitch length INC

R3

☐ 167' design

L8

Accept settings

L8

Optimize with set values

L8

Previous

R7

L8

Store design

L8

Overwrite design



Optimize - Editor Tajima Borer

[Back to Overview](#)

L5



Choose

L8

Select design

R4

L1

Optimize

L4

Optimize with user defined values

L1



Insert start needle 1

L3



Trimming 3 Jump stitches

R1



Home

R2



DST Borer offset with "U" button

R3



Jump st. without travel

L2



Preset stop function



To 2 stop

U0

MORE

U3

= Borer ON

U4

= Borer OFF

U3

= Borer ON

U4

= Borer OFF

Last stop before design end never borer "ON"

U9

U1

Needle 1

L8

Accept stop table

L5

More settings

L1



Trimming special functions

L2



Cleaning INC

L3



Trimming stitch length 20 mm

R1



Insert fixing sequences

R2



Maximum stitch length INC

R3



167' design

L8

Accept settings

L8

Optimize with set values

L8

Previous

R7

L8

Store design

L8

Overwrite design

Insert needle 1 to design end

[Back to Overview](#)

L5

U1



Choose

L8

Select design

R1

U4



Trim before design end

R5

TAB (Insert special function)

U1

L8

Insert

R7

L8

Store design

L8

Overwrite design

L6

Optimize with default values

Insert trimming

[Back to Overview](#)

L5

U1



Choose design

L8

Select design

If there are no stitches, press L1

U5

With U button insert stitch number

L8

Confirm

With U2 20 stitches forward

With U1 20 stitches backward

With



1 stitch forward

With



1 stitch backward

R5

L6 (Insert special function)

U0 (More)

U1 (Trimming)

L8

Insert

R7

L8

Store design

L8

Overwrite design

L6

Optimize with default values



Delete thread trimmer

[Back to Overview](#)

L5

U1



Select design

L8

Select design

If no stitches are shown "L1"

R5

L3

L7

All special functions

R1

Trimming

L8

Confirm



Select trimming

DEL

L8

Confirm

Control unit fault no. 13001

R7

Confirm

L8

Store design

L8

Overwrite design

L6

Optimize with default values

Delete thread trimmer and insert it

[Back to Overview](#)

L5

U1



Choose design

L8

Select design

If no stitches are shown "L1"

U7

Push until you reach the trim thread which you want to delet

DEL

L8

Confirm

Control unit fault no. 13001

R8

Confirm

U2

20 stitches ahead

U1

20 stitches back



1 stitch ahead



1 stitch back



or **U5**
enter stitch number

R5

L6

(Insert special function)

U0

(More)

- U1 (Trimming)
- L8 Insert
- R7
- L8 Store
- L8 Overwrite design
- L6 Optimize with default values

Satin stitch correction

[Back to Overview](#)

L5

U1



Choose design

L8

Select design

R4

L2

Modify design

L3

Satin stitch

L3



Satin stitch

L3



Satin stitch height

U1

or U2 for + or –

U3

With U button insert value e.g. 3 INC



L4 Satin stitch width

U1

or U2 for + or –

U3

With U button insert value e.g. 3 INC

L8

Confirm

L8

Modify

L8

Store design

L8

Overwrite design

Memory Capacity

[Back to Overview](#)

L5

U3

R8

Previous

R8

Previous

--> Actually everywhere there where the directory appears.

--> E.g.: L4 (Design Manager)

Find Design Table/Name

[Back to Overview](#)

L5

U9

E.g.

Anker

OK

--> Actually everywhere there where the directory appears.

--> E.g.: L4 (Design Manager)



Find Design Table with Number

[Back to Overview](#)

L5

U0

Choose number with "U" button

L8 Select design

--> Actually everywhere there where the directory appears.

--> E.g.: L4 (Design Manager)

Design zoom (Editor)

[Back to Overview](#)

L5



Choose

L8 Select design

R1

All "L" button use

All "U" button use

R7

L7 Do not store design

Zoom with Mouse

[Back to Overview](#)

L5

L1



Choose

L8 Select design

R1

With Mouse and right Mouse zoom

With Mouse and left Mouse pick stitch

Use all L button

Check start and end point (no design on the screen)

[Back to Overview](#)

L5

U1



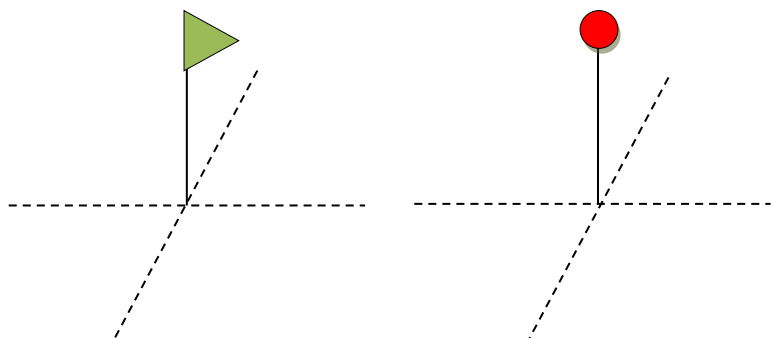
Choose design

L8 Select

R2

U1 (Starting point)

U2 (End point)



Memory capacity

[Back to Overview](#)

L5

U3

Needle 1 (of the end and the start of the design)

[Back to Overview](#)

L5

U1



Find design

L8

Select design

If table view distance relatively ("If not L1")

R5

TAB

(Insert special function)

U1

L8

Insert

L3

L7

☐ All special functions

L1

☒ Needle change

L8

Confirm



Design end

L1



To stitch over design end

U1

L8

Insert

R7

L8

Store design

L8

Overwrite design

L6

Optimize with default values



Needle 1 (of the end and the beginning of the design)

[Back to Overview](#)

L5

U1



Choose design

L8

Select design

R5

TAB

Insert stitch/special function

U1

L8

Insert

Shift +



Line over design end

TAB

Stitch/ special function

U1

L8

Insert

R7

L8

Store design

L8

Overwrite design

L8 Optimize with default values

Insert and move stitch

[Back to Overview](#)

L5

U1



Choose design

L8

Select design

R1

- Zoom with right-mouse-button
- With L1 button zoom bigger
- Perhaps with L4-L7 button centre

- Pick stitch with double-left-mouse-click
- Move stitch to final position
- Press left-mouse-button to place the stitch
- Leave moving mode by OK button
- Move stitch with arrow button



R7

L8

Store design

L8

Overwrite design

L6

Optimize with default values

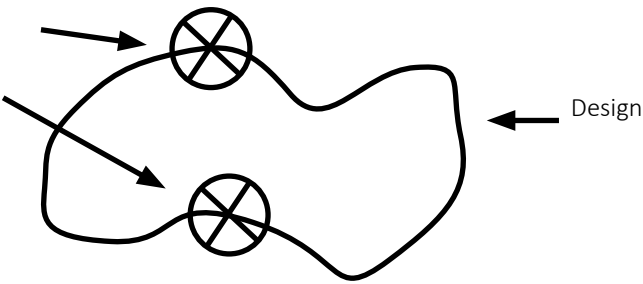


Link design with other design

[Back to Overview](#)

Info:

- Start point must be on design start
- End point must be on design end



L5

U1



Choose design

L8

Select design

R4

R3

Link design with other design

U1



Choose design

L8

Select design

R7

L8

Store design

L8

Overwrite design

L6

Optimize with default values

Repeat view

[Back to Overview](#)

L5

U1



Choose design

L8

Select design

L4

R8

Confirm

L7

Number of heads

With "U" button e.g. 25

R7

Repeat spacing 2400

R8

Previous

R1



Next trimming/ Head selection/ Repeat jump

Special function

[Back to Overview](#)

L5

U1

Choose design

L8 Select design

R1 Display design with graphics view



Move to next special function



Move to previous special function



Move from stitch to stitch

Shift +  Move 20 stitches forward

L1 Zoom in

L2 Zoom out

L3 Adapt display factor to design size

L4 Move image right

L5 Move image left



Head selection (Mouse must be connected)

[Back to Overview](#)

L5

U1



Choose design

L8

Select design

R5

TAB

or L6 (Insert stitch / special function)

U0

(More) 3x

U1

(F-head)

L8

Insert

U0

(More) 3x

U1

(Head selection)

R7

Switch on all odd numbered heads (1-3-5-7...)

L8

Insert special function



To the next trimming

U1

L7

Switch on all even numbered heads (2-4-6...)

L8

Insert special function

U2

or U3 or U4

L8

Insert



To the stitch

U8

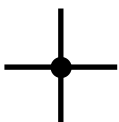
Fixing sequence start

L8

Insert

R1

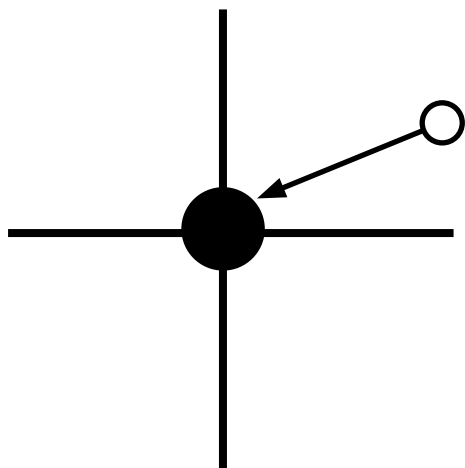
(Big design)



Zoom with right-mouse-button (The area around the cross will be zoomed in)



One stitch down



- Pick stitch with left-mouse-button
 - Double click
 - Move stitch
 - Click left-mouse-button
- (Use this way to apply 3-4 fixing stitches)

| | |
|-----|------------------------------|
| ESC | Detach mouse |
| U9 | (Fixing sequence stop) |
| L8 | Insert |
| | Next trimming |
| R8 | |
| L8 | Store design |
| L8 | Overwrite design |
| L6 | Optimize with default values |

Reducing speed for small fonts

[Back to Overview](#)

| | |
|-----|-------------------------------------|
| L5 | |
| U1 | |
| ▼ | Choose design |
| L8 | Select design |
| R1 | Big picture |
| | Zoom in with right-mouse-button |
| | Pick stitch with left mouse- button |
| R5 | |
| TAB | To insert stitch special function |
| U0 | More |
| U7 | Speed |
| | Enter required speed |
| L8 | Insert |
| L3 | |

[L6] Design repetition

To place the same design several times in the frame you can create here design repetition

Design Repetition (Automatic)

[Back to Overview](#)

L6

L3 Automatic creation of new design table

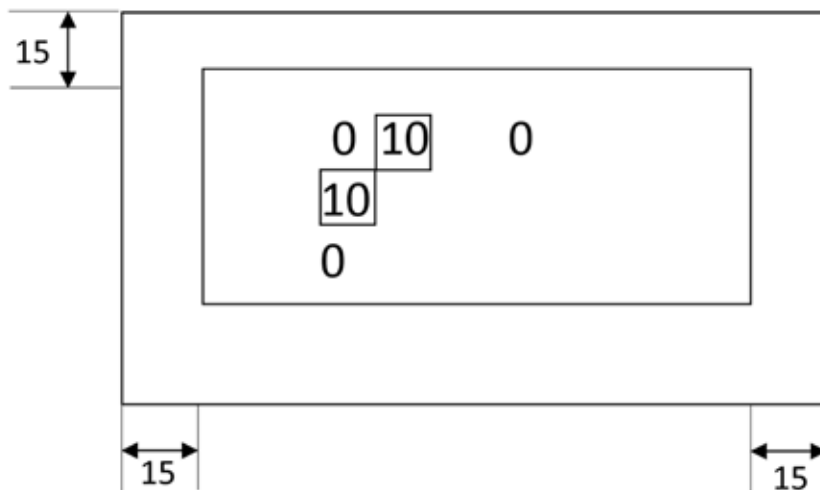
U1



Choose

L8 Select design

495 <-- Change with TAB



L8 Continue

L1 (Determine) filling type ESC

L2 ☒ Divide remaining embroidery field

L3 ☒ Start needle 1 U1

L5 ☒ Design table home

L4 Design no.

L8 Continue

L8 Save

L4 Free design number

L6 New name within OK

L8 Confirm

L8 Previous

Design repetition (manual)

[Back to Overview](#)

L6

L4 Manual creation of new design table

TAB U2

U2

U1



Choose

U8 Select design

TAB (Continue)

Continue with TAB until No.1

U1

TAB

U2

U1

U6



Choose

L8 select design

TAB

Number 3 for example

TAB until ▲

U2 ▼

TAB e.g. 500 feed into

TAB until direction 0 feed into

TAB ___ with U1 (mirror design)

OK

R8 Previous

U1 Next line



[L7] Software/ hardware settings

To change anything regarding hardware or software settings of the machine you have to enter this menu.

Simple Operations Mode

[Back to Overview](#)

L7

R4 Software settings

L1 ☒ Simple operation mode

L8 Confirm

L8 Previous

Pantograph Configuration before Design (Yes/No)

[Back to Overview](#)

L7

R4 Software setting

L2 ☒ Inquiry pantograph configuration

L8 Confirm

L8 Previous

Always Use Default Optimize

[Back to Overview](#)

L7

R4 Software setting

L4 All optimization options

L2 Always use default optimization

L8 Confirm

L8 Previous

Set System Clock

[Back to Overview](#)

L7

R2 Set system clock

Correct with "U" button / TAB

L8 Set system clock

L8 Set system clock

List of Fault Occurences

[Back to Overview](#)

L7

L3 List of fault occurrences

Shift + U0

R8 Previous

R8 Previous

Software Data

[Back to Overview](#)

- T8 Operating System / T8 Terminal Software / Machine Control Software V40

L 7

Shift + U0

L5 Software update

R8 Previous

Info: Also see page 75



Load Software from USB-Stick

[Back to Overview](#)

(Machine ON)

L7

Shift + U0

L5 Software update

Plug in USB-stick

L4 T8 operating system



ZSK machine software

L8 change directory



ZSK t8os_xxxxx.....choose

L8 Select

L8 Install

L5 T8 terminal Software



ZSK machine software

L8 Change Directory



ZSK t8_xxxxx.tsxx choose

L8 Select

L8 Install

R4 E.g. Turkish

L8 Confirm

L6 Machine control software V40



ZSK machine software

L8 change directory



ZSK V40_xxxx.V40 choose

L8 Select

L8 Install

L7 Pantograph configuration files



ZSK machine software

L8 Change directory



(ANW) choose

L8 Change directory

▼ ZSK 3B AN...choose

L8 Select all files

L8 Install

R8 Exit

Switch OFF machine

Wait 30 sec.

Switch ON machine

L6 ☒ Use default data

L8 Resume switch-on operation

L8 Confirm

"V40" - Load from Floppy Disk

[Back to Overview](#)

L7
Shift + U₀

L5 Software update


R6 Machine control software V40

"V40" - Load from USB-Stick

[Back to Overview](#)

L7
Shift + U₀

L5 Software update

L6 Machine control software V40
 ZSK machine software

L8 Change directory

▼ ZSKV40_....

L8 Select

L8 Install

R8 Exit

Switch OFF machine

Wait 30 seconds

Switch on machine

L5 ☒ Use most recent setup data

L8 Resume switch on operation





Pantograph file load from Floppy Disk

[Back to Overview](#)

- L7
Shift + U₀
- L5 Software update
- R7 Pantograph configuration file

Pantograph file load from USB-Stick

[Back to Overview](#)

- L7
Shift + U0
- L5 Software update
- L7 Pantograph configuration files
-  ZSK machine software
- L8 Change directory
-  ANW
- L8 Change directory
- ZSK 3B100600.AND
- L8 Select all files
- L8 Install
- R8 Exit
- L8 Confirm

No Modification Option

[Back to Overview](#)

- L7
- R4 Software settings
- L3 Application depend on modification
- L2 No modification options
- L8 Confirm
- L8 Previous

Modification (all options)

[Back to Overview](#)

- L7
- R4 Software settings
- L3 All modification options
- L1 All modification options
- L8 Confirm
- L8 Previous

"ALL" optimization options

[Back to Overview](#)

- L7
- R4 Software settings
- L3 All optimization options
- L1 All optimization options
- L8 Confirm
- L8 Previous

Always default optimization

[Back to Overview](#)

- L7
- R4 Software settings
- L4 All optimization options
- L2 Always use default optimization
- L8 Confirm
- L8 Previous

Design dependent optimization (for Tajima)

[Back to Overview](#)

- L7
- R4 Software settings
- L4 All optimization options
- L2 Design dependent optimization
- L8 Confirm
- L8 Previous



Automatic design no assignment

[Back to Overview](#)

- L7
- R4 Software settings
- L5 Always ask for design number
- L2 Automatic design no assignment
- L8 Confirm
- L8 Previous

Modification application depend only on Cap/ tubular

[Back to Overview](#)

- L7
- R4 Software settings
- L3 All modification depend on modification
- L8 Confirm
- L8 Previous
- Info: Only from disk or USB (not from editor)
 The design may be rotated 180 DEG.

Always ask for design number

[Back to Overview](#)

- L7
- R4 Software settings
- L5 Always ask for design number
- L1 Always ask for design number
- L8 Confirm
- L8 Previous

Display software version

[Back to Overview](#)

- L7
- L1 Display software version
- R8 Previous
- R8 Previous

[R1] Select machine design

Here you can load a design directly into the main menu. Which is then ready to be embroidered.

Load from USB to the machine "R1"

[Back to Overview](#)

- R1
- U4
- ▼ Select pantograph configuration
- L8 Confirm
- ▼ Select directory (design)
- L8 Select
- U1
- ▼ Select design
- L8 Select design
- L8 Confirm
- L6 Optimize with default values
- L6 No design modification
- L8 Accept loaded design

Close machine design

[Back to Overview](#)

- R1
- U8
- L8 close design



Select design from disk

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R1

U3



Select Pantograph

L8

Confirm

U1



Select design

L8

Select design

L8

Confirm

L6

Optimize with default values

L6

No design modification

L8

Accept

Info: Needle assign/ Presser feed height/ Design range

Load from disk for cap/tubular

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if modification application is switched on (Machine design must be closed)

R1

U3



Select e.g. "cap"

L8

Confirm

U1



Select

L8

Select design

L8

Confirm

L6

Optimize with default values

L5

Rotate design 180 DEG

R7

Accept

If you are only working with Tajima designs (Disk)

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1) Activate design dependent optimization (64)

2) Machine design must be closed

R1

U3

▼ Choose pantograph

L8 Confirm

▼ Choose design

L8 Select design

L4 Free design number

L8 Confirm

▼ 2 step

U2 = Needle 2

U3 = Needle 3

U4 = Needle 4 etc.

If there are only 1-4 stitches between last stop and design end: Needle 1

If there are more stitches: Next needle (e.g. 7)

L8 Accept stop table

L2 ☒ Insert start needle 1

L3 ☒ Preset stop function

L4 ☒ Trimming 3 Jump stitches

R2 ☒ Home

R3 ☐ DST Borer

R4 ☐ Jump stitch without...

L5 ☒ More settings (press button)

L2 ☒ Trim special functions

L3 ☐ cleaning ☐ INC

L4 ☒ Trim stitch length e.g. 20 mm (with U button)

R2 ☒ Insert fixing sequence

R3 ☒ Maximum 127 INC

R4 ☐ 167

L8 Accept settings

L8 Optimize with set values

L6 No design modification

R7 Accept loaded design



Load design "R1" from disk or from EDITOR

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R1

| | | | |
|----|--------|----------|---------------------|
| U3 | (Disk) | Question | Start and end point |
| | | Question | Optimize |
| | | Question | modify |

R1

| | | | |
|----|----------|-------------|---------------------|
| U2 | (Editor) | No question | Optimize |
| | | No question | Modify |
| | | No question | Start and end point |

[R2] Design head

Here you find all necessary information about the open design

[R3] Approach stitch

Go directly to a certain stitch in the design and continue from here.

Positioning of Stitch Design on Screen

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R3

L5 New stitch number e.g.
With "U" button

L8 Confirm
Start machine

Positioning of stitch with the mouse

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R3

Zoom with right-mouse-button

Pick stitch with left-mouse-button

L8 Confirm

Start machine (thread trimming)

Start machine

- Or "L" button
- Or R2 number
- Or R3 Next needle change#

[R4] Manual needle change

To change needle during the embroidery of a design there is the manual needle change.

Needle plunger has fallen

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- but not the work needle

Assemble needle without washers

R4

With "U" button choose needle e.g. 3

Start machine

L3

R2 Test machine attachment



Position main shaft

L8 start testing

With "U" button choose

L8 Start testing

Start machine

Push jump-stitch-magnet

Press needle holder down

Insert washer

Do not tighten needle plunger

R8 Stop testing

R8 Previous

R8 Previous

Needle change (manual)

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R4

Select needle by pressing "U" button

Start machine





[R5] Needle assignment

To set needles to the defined colours of the open design, please go into the needle assignment.

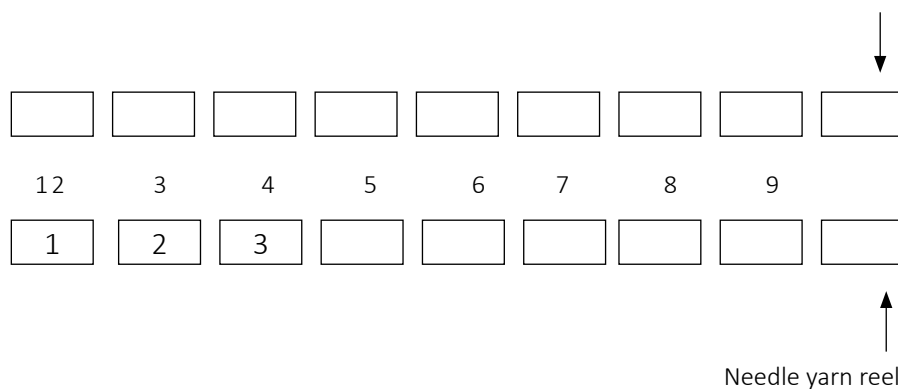
Needle assign

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R5

L7 Default

Needle in design



Info: 1 Needle red = 3
2 Needle blue = 9
3 Needle green = 6

L8 Confirm

[R6] Speed

Here it is possible to set the machine speed in stitches/min

Speed setup / needle

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Specific Design on the Screen

R6

U7

L2 ☒ Needle specific

Work needle

| | | | | | | | | |
|-----|------|-----|-----|------|---|---|---|-----|
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | ... |
| 900 | 1000 | 750 | 800 | 1000 | | | | |

(Choose needle with TAB or L3 for forward and R3 for backward)

L8 Confirm

L8 Confirm

Speeds special/ normal machine design on screen

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R6

U5 (Special)

R6

U6 (Normal)

[R7] Switch off

Before you turn the main switch to shut down the machine, please press R7

[U1] Trimming upper thread / bobbin

Here you can trim manually the upper and bobbin thread

[U2] Trimming bobbin

Here you can manually trim just the bobbin thread

[U3] Design range

In this menu it is possible to position the loaded design in the frame

Design range (design is on the screen)

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U3

R2 Contour finer

R2 Contour finer

U9 Needle down (gradually)
Info: shift + U8 (Needle up)
Move pantograph to start point

U1 = Pantograph positioning fast

U2 = Pantograph positioning slow

U3 = 10 inc. pantograph positioning

U4 = 1 inc. pantograph positioning

Start machine

Attention: Your finger must be on stop-button for safety!

Info: If you press R4
Framing slower again into contour rang->speed will slow down.



[U4] MDA

MDA stitches counter

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U4

e.g. L1 ☒ Counter1

L5 ☒ Order

R8

R8

[U5] Pantograph configuration

Settings for pantograph movement.

Pantograph Configuration

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- No Design on Screen

U5

U6



E.g. ZSK 99 cap attachment

L8 Confirm

Axis Override

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- No Design on Screen

U5

U6

L7 Axis override

Override value height e.g.

| | |
|---|---|
| + | 3 |
|---|---|

U1 E.g. +

TAB

U3

L4 Override value width

| | |
|---|---|
| + | 3 |
|---|---|

U1 E.g. +

TAB

U3

2x L8 Confirm

R8 Previous --> **Info:** Recovery disk we create later

L8 Confirm

Pantograph moves slow

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Note:



Must be activated (Green light)

U5

U1

U0

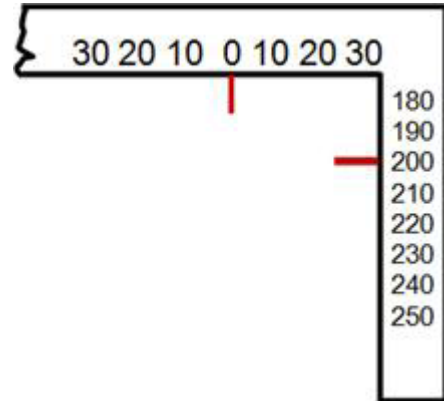
Cap attachment justify

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1. Remove border frame
2. Remove or take down the table



Move pantograph to 0/200 (see pic.)



U5

U6



ZSK99cap.attachment

L8 Confirm

- Justify cap attachment
- Adjust presser foot height

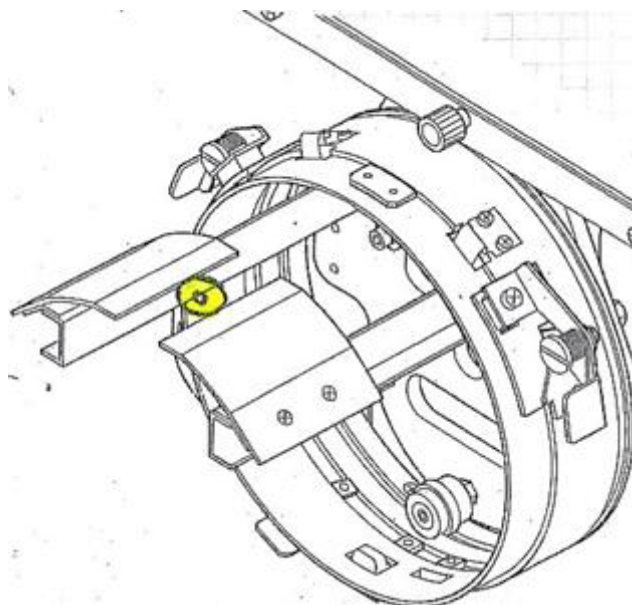
Info: The following conditions have to be kept

- Design is turned through 180°
- Start and end point are the same
- Needle 1 is the first and the last needle (start and end point of design)

Load design

Design range

Embroider



[U6] Set reference point

Save a defined position in your frame to go later back to it.

Defining of a Reference Point after Design Range

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U6

R3

With design name e.g. (cat)

OK

L3 Defining reference point 1

L8 Defining reference point 1

Embroidery

Info: You can fix a reference point for 10 different designs

U7

L3 Move to reference point 1 (cat)

L8 Move to reference point 1

Start machine

[U7] Go to reference point

Go to a defined position of your frame.

Zoom in

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Pick stitch with left-mouse-button

U7

Insert 1000 for speed with "U" button

L8 Insert

L7

L8 Store design

L8 Overwrite design

L6 Optimize standard



[U8] Raise needle/ rotary hook change/ bobbin changer


[U9] Lower needle/ bobbin changer

Exchange Magazine

[U0] More

Brake On/Off

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- U0 More
- U1 Brake On
- U2 Brake Off
- U0  Previous



ABOUT

ZSK Stickmaschinen GmbH is the leading German manufacturer of industrial embroidery machines „Made in Germany“.

With great expertise and experience in the textile machine construction, the company from the Lower-Rhine area has developed a broad range of applications for its embroidery machines.

Beside large machines for the challenges at the mass production and embroidery machines to individualize textiles, ZSK Stickmaschinen GmbH manufactures machines for laying and fixing fibres and wires, the so-called TECHNICAL EMBROIDERY SYSTEMS. ZSK has been developed this sector with the offer of customized embroidery solutions since the 1990's. Today ZSK's TECHNICAL EMBROIDERY SYSTEMS enable the free

orientated laying of fibres and wires in a 2-dimensional space on flexible carrier material. TAILORED FIBER PLACEMENT, meaning the laying according to the distribution of forces within a structural component is a major advantage of this process.

With innovative applications like active wire and fibre supply systems for industrial demands, automatic pull-through systems for the carrier material or a wire hit detection system ZSK TECHNICAL EMBROIDERY SYSTEMS achieve a high level of automatization and efficiency.

SERVICE



Hotline

Sales and service partner in over 75 countries worldwide will help you when you need it.



Spare Parts

Guaranteed fast and global delivery and installation for over 10.000 available spare parts.



Training Courses

Training courses for customers and partners on location or at ZSK headquarter training center.



Technical Support

Trained experts and technicians that speak your language in more than 75 countries.

Email: service@zsk.de



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