



## Wiring Harness Installation Instructions and Setup Parameters for 18X8 on Imperial Frame

The QBOT has a number of user adjustable parameters that change the way the QBOT operates. This is a list of the parameters, their description, and the default value.

The parameters can be viewed from the 'Setup' menu. From the Quilt|Record|Options menu, select 'Options'. From the Options menu, select 'Setup' and press 'GO'.

To navigate through the parameters, use the up and down navigation arrows.

To change the value of the parameter, use the right and left navigation arrows.

To store the parameter, press 'GO'. When 'GO' is pressed, 'Setting Saved' is displayed and the user is returned to the Options menu.

The parameters highlighted in **BLUE** must be changed from their default values to the values shown in this chart for proper operation of the 18X8 sewing machine on the Imperial Frame.

For proper operation of the QBOT with the 18X8 sewing machine, you must press and hold the 'Auto Stitch' button while turning on the sewing machine. You will hear a sequence of beeps. Once you hear the sequence of beeps, you may release the 'Auto Stitch' button.

Parameter	Value
Use Metric?	NO
X Axis Direction	1
Y Axis Direction	1
Use Thread Cutter	NO
Wheel Diameter (mm)	22.3
Motor Current (%)	70
SpdCtrl On Delay (mSEC)	200
SpdCtrl Off Delay (mSEC)	2000
Motors Enable Delay (mSEC)	200
Motors Disable Delay (mSEC)	2000
Acceleration Factor	2200
Delta Factor	0.7
Encoder Sample Time (mSEC)	50
Recorder Accuracy	0.1
Check Position Error	YES
Hover Speed Override	3
Thread Cutter Delay (mSEC)	2000
Use Buzzer?	YES
Reset to Defaults?	NO



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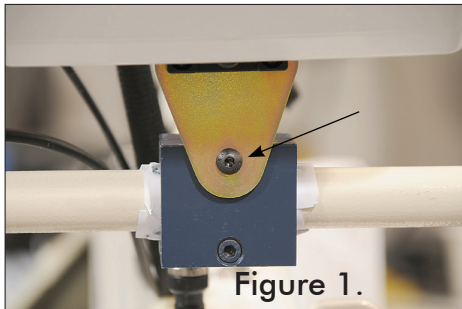


Figure 1.

Remove the upper screw from the front handle mount on the sewing machine and use the screw in this kit to secure the QBOT mounting bracket as shown in the picture to the left.

Next, tilt the QBOT so that you can read the display clearly.



Figure 2.

Following the pictures to the left and below, apply the strain relief pads to the sewing machine as shown. Place three pads along the top of the sewing machine as shown in Figure 2, one pad on the control box as shown in Figure 3, two along the machine base as shown in Figure 4, and two on the belt cover as shown in Figure 5.

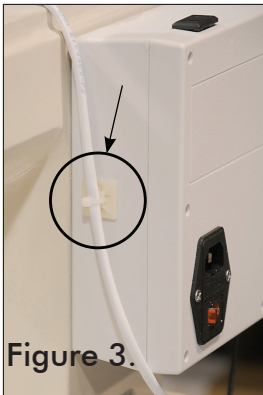


Figure 3.

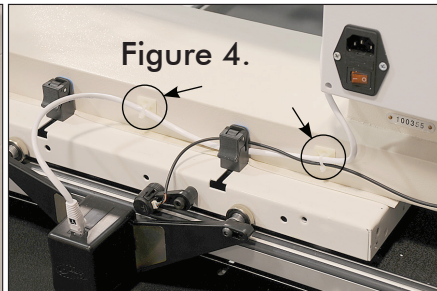


Figure 4.

The wiring harness, power cord for QBOT, and the motor control cable are secured on the top three pads shown in Figure 2. The Y-Axis cable (white) is secured to the pad mounted on the control box shown in Figure 3 and the two pads on the lower part of the machine shown in Figure 4.

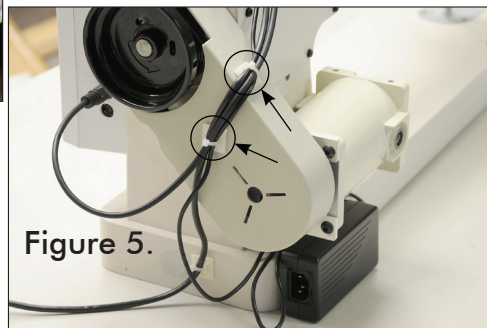


Figure 5.

The X-Axis cable (black), motor control cable, and power supply cable are secured to the two pads mounted on the belt cover, and the X-Axis cable is also secured at the base of back of the machine as shown in Figure 5.

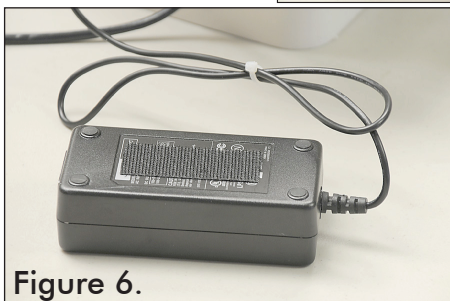


Figure 6.



Figure 7.

Attach the Velcro® strip to the back of the QBOT Power supply and attach to the side of the sewing machine as shown in Figures 6 and 7, respectively.