

Technical Advisory Bulletin (TAB)

Bulletin #: TBMELCO033A

January 14, 2022

Product: Melco OS v11.13.143 (and above)

Implementation: ☐ Urgent ☐ Mandatory ☐ As Required ☒ Info Only

Reference: N/A

Subject: TBS Calibration Changes Implemented in Melco OS v11.13.143

SITUATION:

As of Melco OS v11.13.143, the base values for TBS Calibration (Sensitivity and Feed Adjust) have changed.

SOLUTION:

See TBS Calibration instructions below (also included in the EMT16X Operator Manual – Advanced Interface).

RECOMMENDED ACTION:

Note that TBS Calibration Adjustments should only be done if all other settings are correct (Acti-Feed, Bobbin Tension, Presser Foot, Hook Adjustments, etc.)

TBS Calibration

The TBS calibration fields allow for the adjustment of the sensitivity of the Thread Break Sensor and Thread Feed. Machine Calibration Instructions are available along with a specific calibration design file in: <https://melco.zendesk.com/hc/en-us/articles/4420174064269-TBS-Calibration-Settings-in-Melco-OS-v11-13-143-and-above->

- **Sensitivity** - This value allows you to adjust the sensitivity of the Thread Break Sensor. Zero is the default setting. The range of adjustment is -10 to 10. It is recommended to make adjustments in single-unit increments. Adjusting the value up will reduce the number of (false) thread breaks detected (i.e., make the Thread Break Sensor less sensitive). Adjusting the value down will increase the number of (false) thread breaks detected (i.e., will make the Thread Break Sensor more sensitive). If you are experiencing false detections, increase the value. If the machine is missing real thread breaks or taking too long to detect them, decrease the value.

- **Feed Adjust** - This value will affect how the thread is fed and how tight or loose your stitches are. The range of values is -5 to 10. Zero is the default. It is recommended to make adjustments in single-unit increments. Adjusting the value up will create a looser stitch. Adjusting the value down will create a tighter stitch. Going too far negative can create puckering and/or bobbin pull. Going too far positive can create loops in the stitching.