sankosha®
PRESS AND PROGRESS

MF-350E

Instruction Manual

For your safety, please read and fully understand this Instruction Manual thoroughly before beginning operation.
Keep this Manual in a designated place for easy access.
If at any time you have any questions, please do not hesitate to contact us.

Welcome

Thank you for choosing our MF-350E

This machine was delivered to you after thorough inspection at our plant.
Please read this manual carefully for proper usage of this machine.

Product specifications

Model	**MF-350E-V1**
Capacity (*)	40 garments / hour
Power	**1-phase 230V 50Hz 14.0A**
Air Consumption	**140 liter/time**
Steam Consumption	**9.2kg/ hour**
Air Pressure	**0.5MPa**
Steam Pressure	**0.5MPa**
Air Pipe	**3/8B**
Steam Pipe	**Inlet : 1/2B , Outlet : 1/2B**
Weight	**215 kg**
Dimensions Width×Depth×Height	**2095 × 1185 × 1680(mm)**

(*) This number is based on our inspection and testing.
This number may vary depending on machine location, electrical supply, maintenance, garment type and size, operator's speed, etc.

Table of Contents

Safety Guidelines

Warning labels are placed on the machine in order to prevent an operator and others from injury, and to ensure proper and safe operation. For most parts, labels are placed on the operational area of the machine.

Use this product safely upon reading this manual and understand the warning labels on the machine.
Please keep this manual as it will be needed in the future.

■ Please read the description of each warning label below. Each sign shows the degree of risk of injury or damage if the manual and/or labels are not followed and the machine is misused.

	**DANGER**	This indicates a potentially hazardous situation which, if not followed, may result in death.
	**WARNING**	This indicates a potentially hazardous situation which, if not followed, may result in serious injury.
	**CAUTION**	This indicates a potentially hazardous situation which, if not followed, may result in minor or moderate injury.

■ Rules are shown in the table below.

	**General Sign (for Alertness)** This is to alert the user to unspecified caution, warning or danger.		**General Sign (for Prohibition)** This is to alert the user to unspecified prohibition.
	**Shock Hazard** This is to alert the user to a risk of electric shock in certain circumstances.		**Prohibition of Dismantling** This is to alert the user to a risk of injury or shock if the indicated part is dismantled
	**Cut Hazard** This is to alert the user to a risk of cutting hands or fingers by a cutter or others. May cause physical handicap.		**General Sign (for Compulsion)** This is to alert the user to unspecified user's action.
	**Burn Hazard** This is to alert the user to a risk of burn from heat or steam.		**Necessity to Ground** This is to indicate that the machine must be properly grounded, using the attached green wire.
	**Pinch Hazard** This is to alert the user to a risk of pinching by rollers which may cause permanent damage to extremities		**Rotation Hazard** This is to alert the user to a risk of injury if rotating parts of the machine are not properly covered with during maintenance or operation.
	**Rotation Hazard** This is to alert the user to a risk of injury if rotating parts of the machine are not properly covered by during maintenance or operation.		

Sankosha cannot be held legally responsible for any injuries to operators or damages to the machine caused by alterations to the machine or operations not described in the machine manual.

WARNING

■ Installation

Installation and rigging of this product should be performed only by an authorized Sankosha distributor or by qualified personnel who has read this manual.

Improper installation or rigging of this machine may result in shock, injury or burn.

■ Ground Connection

The green wire must be properly grounded.
The electrical code must be conformed to 3 Phase 220V power.

Incorrect connection may cause electric shock.

■ Fire Hazard

Flammable articles such as gasoline, etc should not be located near the machine.

It may cause fire or explosion.

■ Shock Hazard

Do not touch the electric plug or switch.

It may cause electric shock.

■ Shock Hazard

Parts must not get wet when cleaning the machine with water.

It may cause electric shock.

■ Alteration Hazard

Do not improve or dismantle the machine.

It may cause accident.

■ Do not Use During Disrepair

Turn the main power and breaker switches off in case of malfunctions.
Call authorized service personnel.

It may result in injury or further damage to the equipment.

■ Shock Hazard

Do not put a finger or metal into the machine or Control Box.

It may cause electric shock or explosion

■In case of flooding

Please call authorized personnel to inspect and repair the machine if necessary.

It may cause electric shock.

■ Maintenance

Please call authorized service personnel.
Do not dismantle by yourself.

It may cause electric shock, injury, fire or accident.

■ Safety Instructions

- For your safety, please follow the instructions below.

- Only qualified trained personnel can operate the machine.
- Carefully read this Instruction Manual in full before using the machine.
- Make sure there is no one working near the machine before beginning operation.
- The machine should be operated individually at all times.

Before conducting the proper maintenance, always keep following instruction: close the air and steam valves and release their residual pressures.

CAUTION

■ Damage by Water

When the machine is damaged by water, do not use. Ask a local distributor or Sankosha for maintenance or repair.
cause electric shock, injury, fire or accident.

■ Check and cleaning

Electric plugs and electric sockets need to be checked and cleaned periodically.

If you find any damage, call us or your Sankosha distributor.
Breakage can cause electric shock and fire.

■ Inside use only

The machine must be located inside the facility.
Do not place it in a damp or wet area.
It may cause an accident.

■ Not in use abroad

Do not use the machine outside of designated countries.
It may cause fire due to different electrical supply.

■ Regular Clean Up

It may cause dust in the machine if you do not clean the machine for a long time.
It may result improper operation or damage to the equipment.

Cleaning

Both the main power switch and the breaker should be off when cleaning.
It may cause electric shock without power-off.

■ Adequate space

Adequate space around the machine should be secured for service and maintenance.
Potential injury to service/maintenance personnel may result.

■ Maintenance of warning labels

The labels need to be cleaned and replaced if necessary.
It may cause an accident.

■ Operation process

Please follow the operational instructions to enjoy machine performances safely for a long time.
If ignoring the instructions, you may damage the machine or get hurt.

Hazardous Area

Electrically Live Area

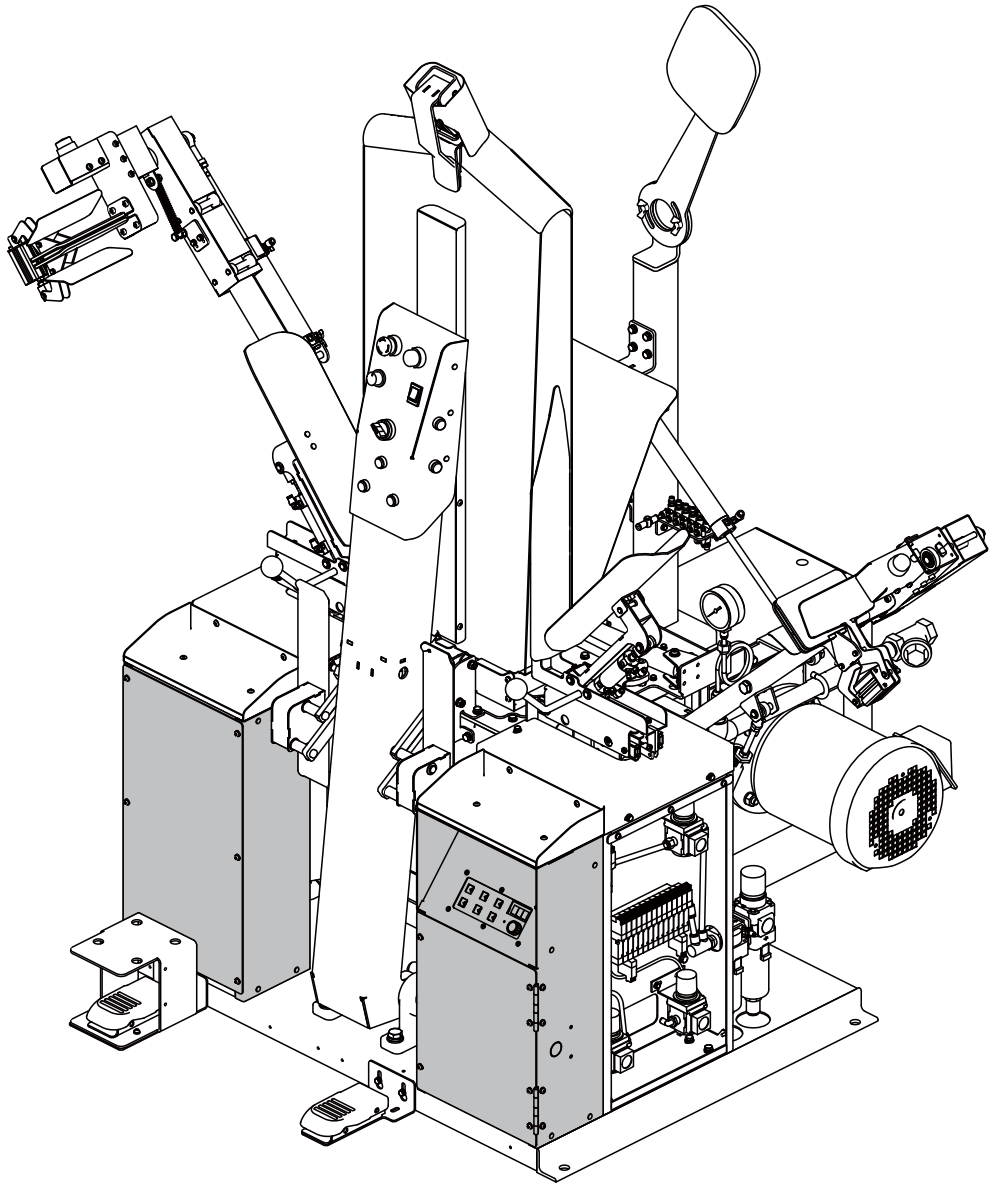
DANGER

The Control box has terminals with lethal voltage.

-Only trained maintenance personnel should open the box.

-Turn off the power before opening the box.

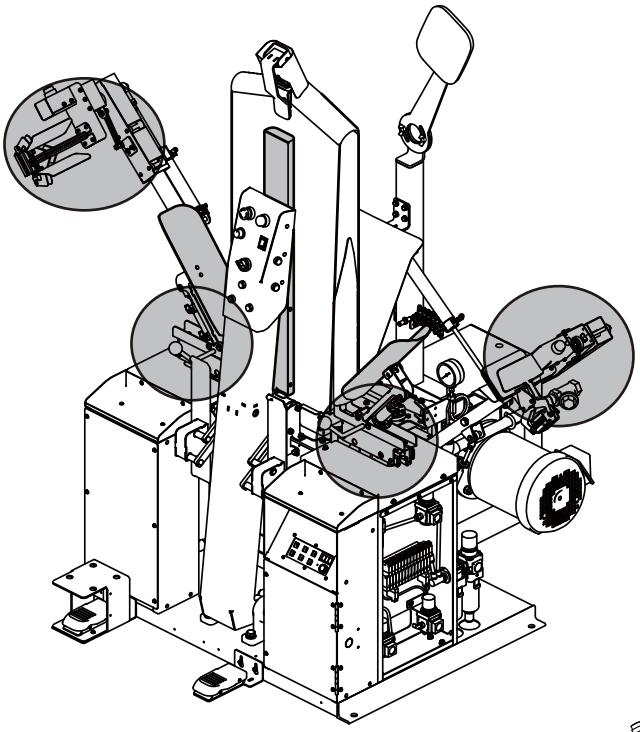
Ignoring this warning will result in serious injury or death due to electric shock.

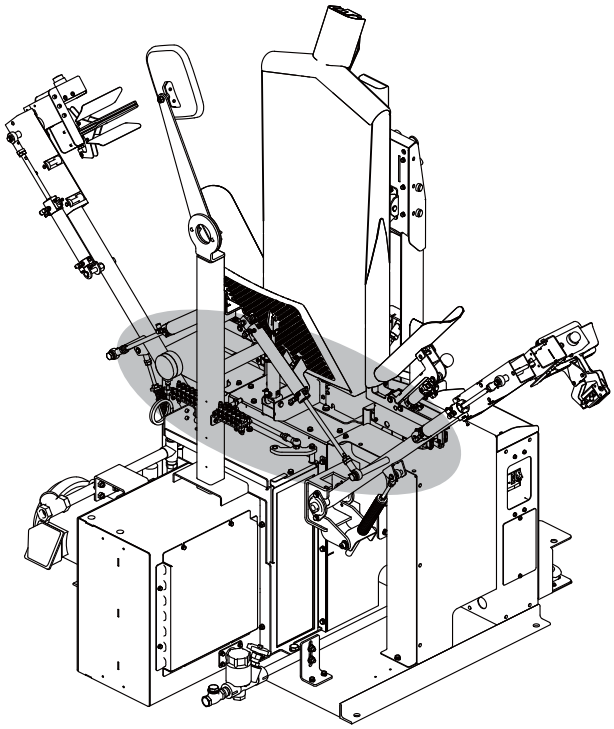


Range of the Machine in Motion

WARNING

The machine has a certain range of motion.
Keep your hands away from all moving parts during operation.
Before starting up or checking for maintenance, turn off the air and electric power.
Ignoring this warning could result in a serious injury.

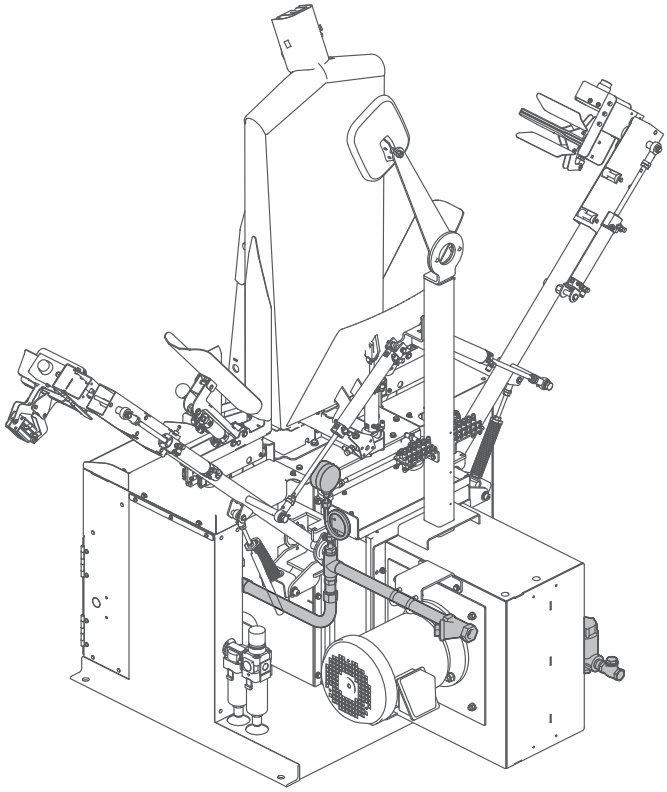


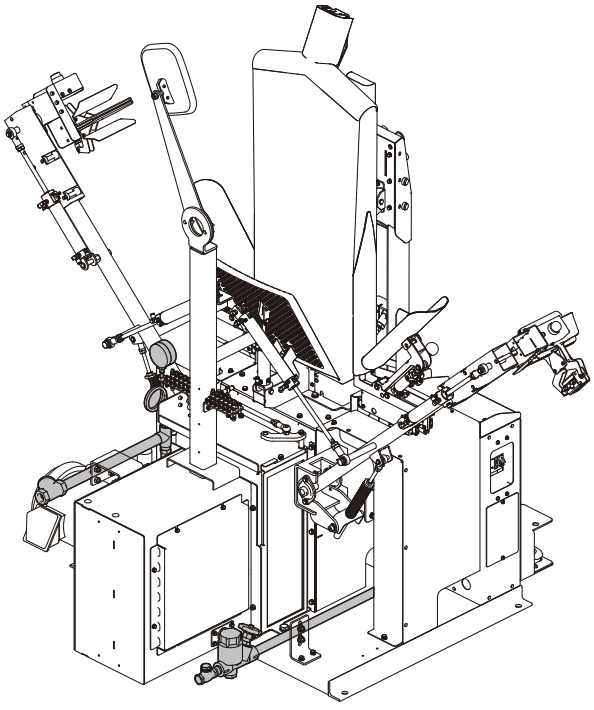


High Temperature Area

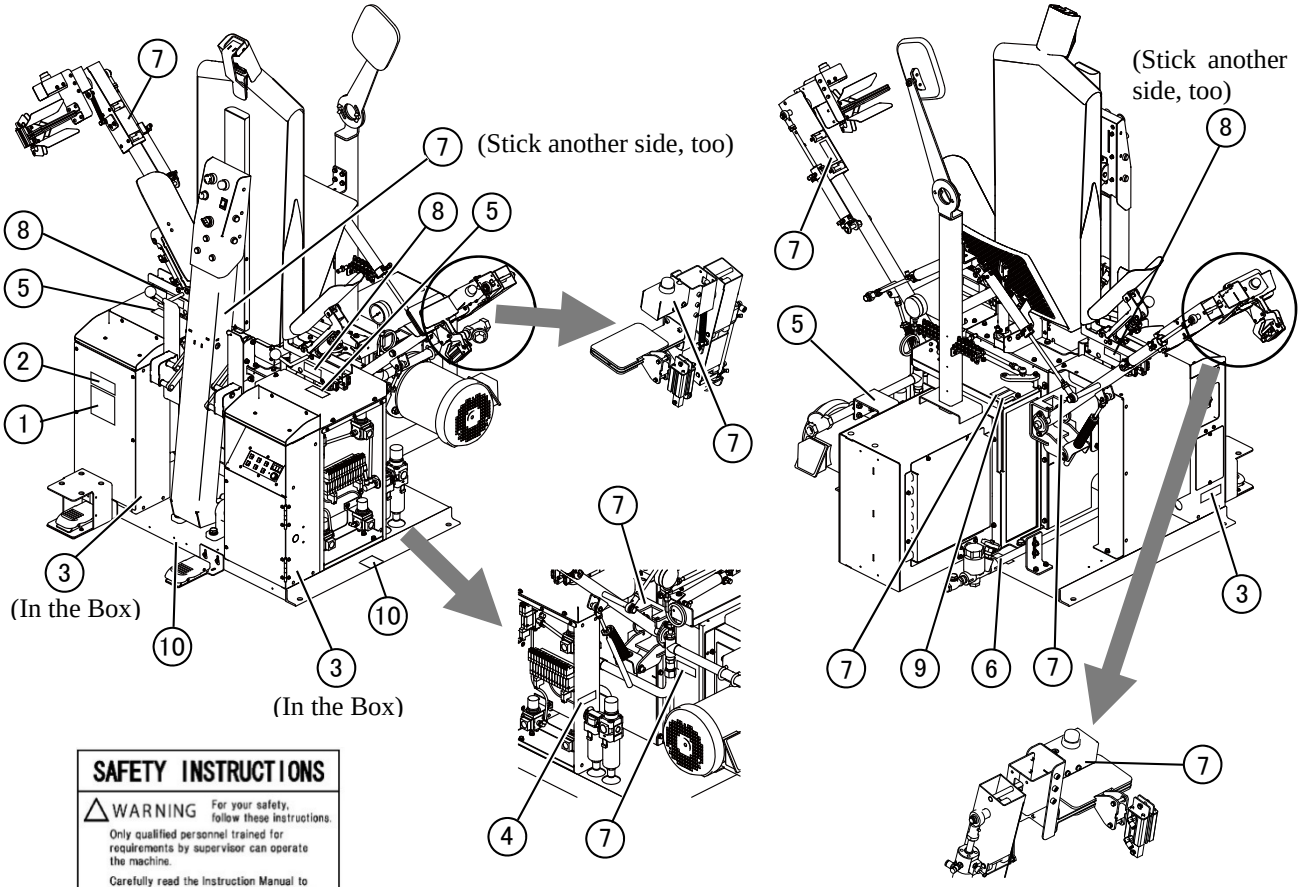
CAUTION

The machine has surfaces that get extremely hot during operation.
Never touch the hot surfaces during and within 30 minutes after the steam has been turned off. Ignoring this warning may result in burns or injury.





Safety Labels on the Machine



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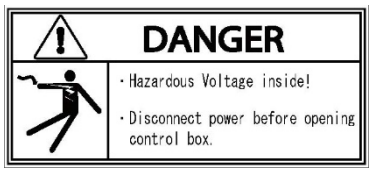
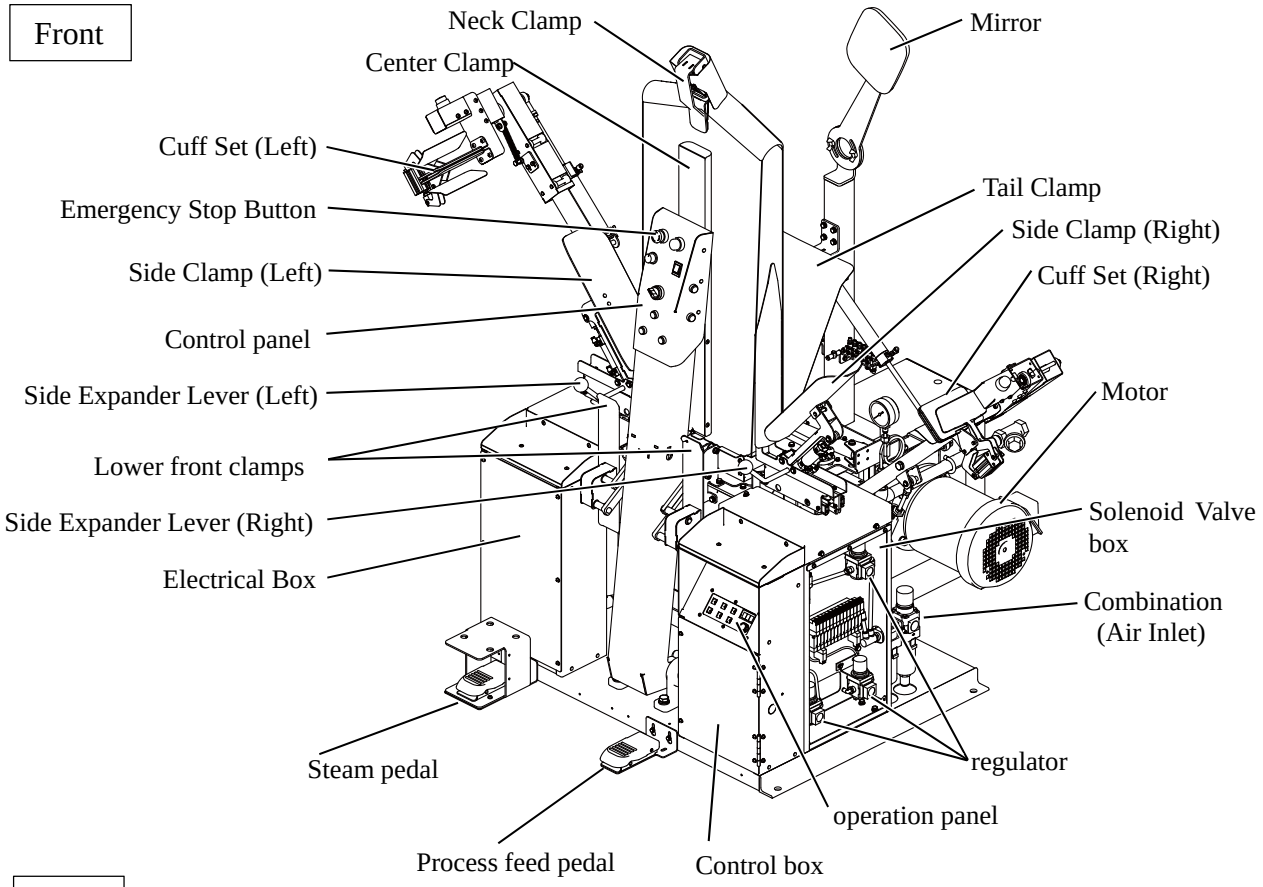


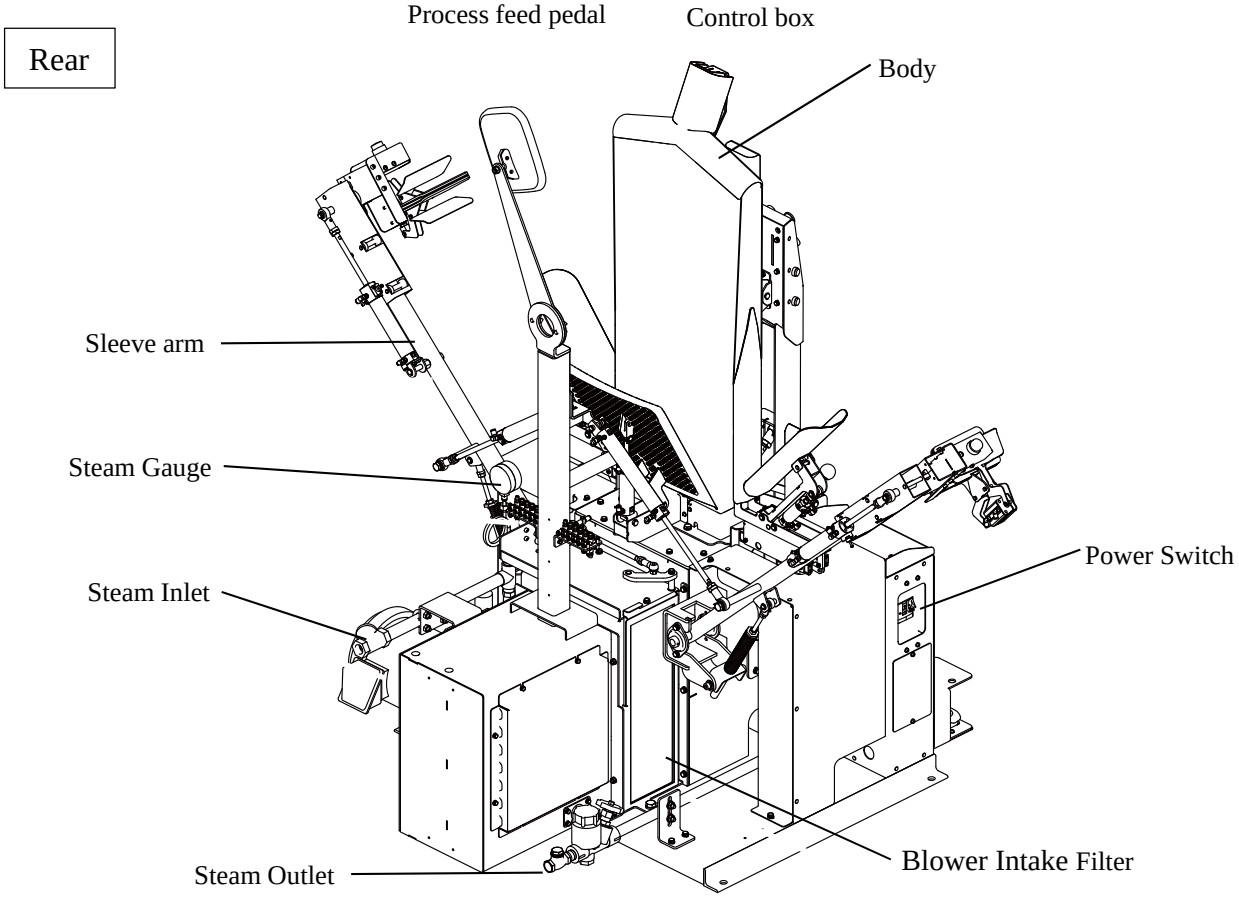
3.	Shock Hazard	It may cause electric shock. Before opening Control Box or cover by repair etc, always turn the power off.
4.	High Pressure Air	High pressure air! Before maintenance, close air valve and drain residual pressure.
5.	Burn Hazard	The sealing portion is hot enough to burn you. Keep hands away from the machine. Do not touch while operating.
6.	High Pressure Steam	High-pressure steam! Before maintenance, close steam valve and let residual steam discharge
7.	Pinch Hazard	Pinch hazard! Keep hands away from the machine. Do not touch while operating.
8.	Cut Hazard	Cut hazard! Keep hands away from the machine. Do not touch while operating.
9.	Keep Filter Clean	Clean filter before operation.
10.		Center Mark Indicating the center of gravity of the machine.

Make sure that each warning label is placed at the location shown above. If any of the labels is missing, damaged, or illegible, contact your distributor to obtain a new one.

Part Names

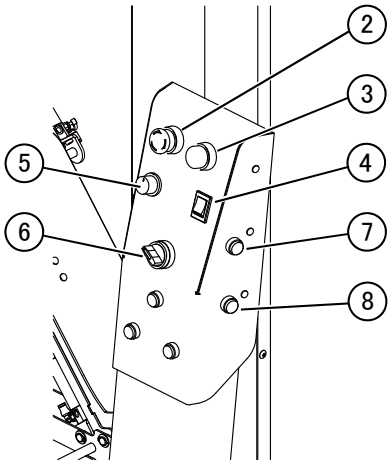
Main Unit

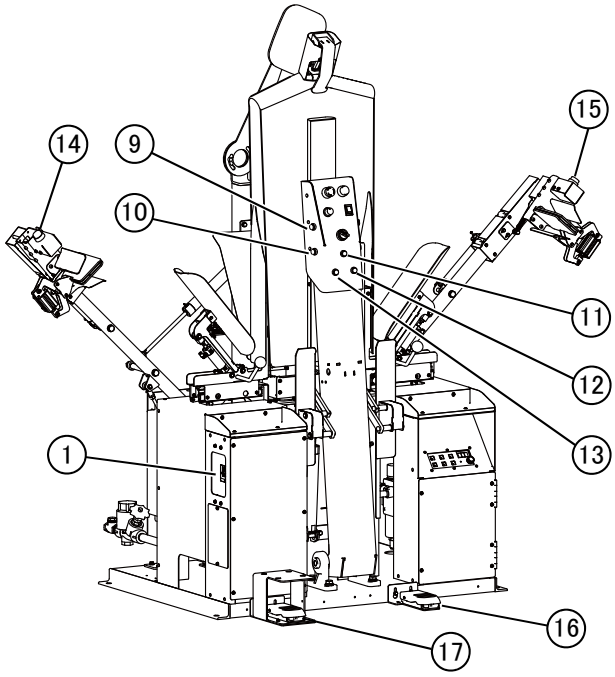




Name and function of control panel

Control panel





① Power Switch

The switch is for the main power.

Power is ON by pushing the black button. Power is OFF by pushing the red button.

*After power is on, press the Reset button to make the machine operable.

② Emergency Stop Button

Press this button at any stage in order to release the press and safely return to the original position.

The Display Window shows “E 1” and the buzzer goes off.

In order to return to normal operation, release the lock by turning the button clockwise. (The buzzer stops and the Display Window shows “- - 1”.)

Then, press the Reset button to make the machine operable.

③ Reset Button

There are five functions.

1. By pressing this button after turning the power ON, the machine is ready to work in normal operation.
2. By pressing this button when the machine stops such as in case of emergency, the machine is ready to work in normal operation.
3. By pressing this button while setting the garment, you can return to the previous work process one by one.
4. Press this button while in automatic operations, the timer for the current operating mode turns off on the way (shortening the operating time).
   - While steam timer is working, the steam stops by pressing this button. Next process (blower) automatically starts.
   - While blower timer is working, the blower stops by pressing this button.
5. By pressing this button while auto finish mode is off, you can release each clamp after each operation is done.

④ Short sleeve/Long sleeve Select Switch

Short sleeve or Long sleeve mode will be selected. Sleeve arms remain opened in Short sleeve mode.

⑤ Blower amount adjustment knob

Blower amount can be adjusted during finishing. Turn right to increase, left to decrease the blower amount.

⑥ Mode Select Switch

3 finishing modes (shirt, blouse Polo/T-shirt) can be selected. Each mode has its own finishing process.

*Refer to “Finishing process by mode” for further details.

⑦ Cuff Clamp Up Button

While pressing this button, the left and right cuff clamp devices slide up.
The angle of the sleeve becomes wide.
This function can reduce slack or crease on an armpit of garment.

⑧ Cuff Clamp Down Button

While pressing this button, the left and right cuff clamp is sliding down.
The angle of the sleeve becomes more acute.
This function can reduce slack or crease on the shoulder of garment.

⑨ Sleeve Arm Close Button

By pressing this button, both sleeve arms close. This function will be effective if you want to reduce the pulling tension of the sleeves.
The sleeve arms will close by pressing this button when the machine is not running.

⑩ Sleeve Arm Open Button

By pressing this button, both sleeve arms open. This function will be effective if you want to intensify the pulling tension of the sleeves.

⑪ Neck clamp / Lower front clamps release button

When setting the garment, this button is for neck clamp on/off.
When in the auto operation mode, this button is for lower front clamps on/off.

⑫ Side Clamp Button (Right)

By pressing this button, the Side Clamp (Right) closes and holds the right side of the garment.
The Side Clamp opens when pressing this button while the Clamp holds the garment.

⑬ Side Clamp Button (Left)

By pressing this button, the Side Clamp (Left) closes and holds the left side of the garment.
The Side Clamp opens when pressing this button while the Clamp holds the garment.

⑭ Cuff Clamp Button (Left)

By pressing this button, the Cuff Clamp (Left) closes and holds the cuff. If you want to set the cuff once again, press this button again. The Cuff Clamp will open.

⑮ Cuff Clamp Button (Right)

By pressing this button, the Cuff Clamp (Right) closes and holds the cuff.
If you want to set the cuff once again, just press this button again. The Cuff Clamp will open.

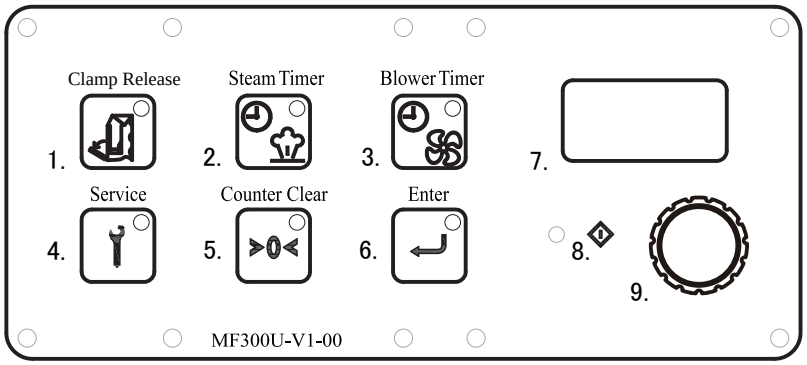
⑯. Process feed pedal

When setting, you can proceed to the next process by stepping on this pedal.

⑰. Steam Pedal

By stepping on this pedal, live steam will be injected.
Be careful about the surroundings in using this function.

Operation Panel



1. Clamps Release button (“Shirt" mode only)
   Turn this button on (green light on) to release the back clamp and the lower front clamps while the blower is on in automatic operation. Time to start releasing can be adjusted by Volume 8. (Factory setting is at 5 seconds.)
   This function is good for drying front and back of garments with thick material.

2. Steam Timer button
   This button is for adjusting the steam timer in automatic operation. This can be done for each mode (shirt, blouse and Polo/T-shirt).
   Turn Select/Set dial (#9) to adjust steam timer and press the Enter button to save the setting.

3. Blower Timer button
   This button is for adjusting the blower timer in automatic operation. This can be done for each mode (shirt, blouse and Polo/T-shirt).
   Turn Select/Set dial (#9) to adjust blower timer and press the Enter button to save the setting.

4. Test button
   This button is for testing each function. Refer to “Test Button Explanations” for further details. You can also change the DIP switches or timer values with the Select/Set dial.

5. Counter Clear button
   When this button is pressed, "0" blinks in the display window. Press Enter to make the counter "0". Press Enter again to return to normal operation.
   ※ This button functions as “Return/Cancel” in operation of each menu.

6. Enter button
   Press this button after changing the timer setting for each mode. The time setting for each mode can be saved.
   ※ This button also functions as “Enter” in operation of each menu.

7. Display Window
   Counter, timer countdown, error code, menu code etc. will be shown here.

8. Power Lamp (red)
   This lamp blinks when the power is turned on or the Emergency Stop Button is pressed.
   By pressing the Reset button, it will go into the normal operation mode. The lamp will be on.

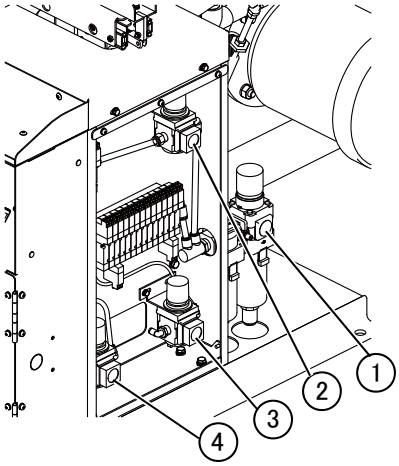
9. Set/Select Dial
   By turning this Dial, you can change the Timer Setting or select the Menu Item.

Operation Procedure

⚠Caution Follow the procedure for proper operation. Improper operation can cause mechanical failure or injury to operators.

Getting Air

- Check whether the air pressure is set at the required level for the filter regulator and other regulators as listed below.

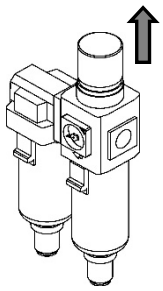


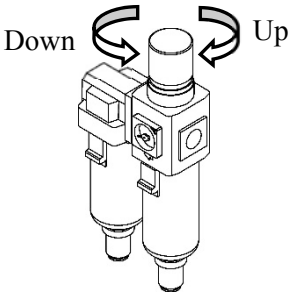
1. Main regulator·····0.5 MPa
2. Regulator (sleeve arm - closing/front clamp) ·····0.25MPa
3. Regulator(shoulder tension)·····0.35MPa
4. Regulator(sleeve arms - opening)·····0.2MPa

Low air pressure can cause a malfunction. If the pressure does not reach its standard level, set the air pressure properly following the procedure below.

■ How to adjust air pressure.

1. Pull the adjustment knob up
2. Turn the knob to adjust air pressure
   Clockwise →Pressure goes up
   Counterclockwise → Pressure goes down
3. Pull the knob down





Check Point

- Check compressor if the main air pressure does not reach 0.5MPa even after the above adjustment.

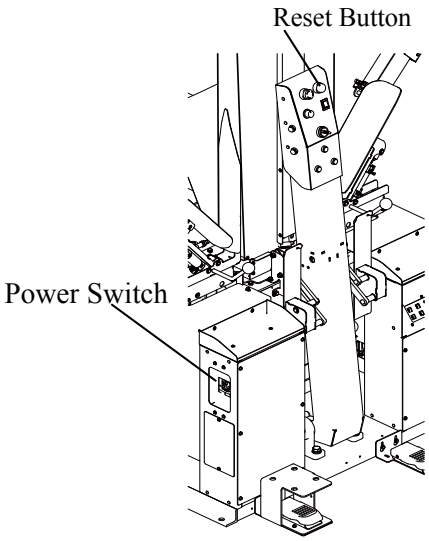
Attention! Run the machine where air can be supplied in a stable condition.
Use after-cooler or similar equipment to supply clean air all times.

Getting Steam

- Check whether steam with the pressure at 0.5MPa or more can be supplied to the machine. If the steam pressure does not reach the required level, it may adversely affect the shirt finishing quality. Always check whether the pressure meets its requirement.

- It takes about 15 minutes until the machine heats up.
  (It may vary depending on the season and the environment.)
  Insufficient heat may adversely affect the shirt finishing quality.

Power On



1. The power is ON by pressing the Black Button at the left side of the Inverter Box.

   →The power lamp blinks and "－ － －" shows up on the Display Window of the Operation Panel.

2. Press the Reset Button.

   →The power lamp turns ON, and the machine is ready to work. The Display window shows the current mode selected and the number of the current process.

   The machine will not work unless the Reset Button is pressed.

Caution The machine will not work unless the Reset Button is pressed.

Set Timers

Change the setting of steam time or blower time according to the material or the wet of the garment.
(Please see page 21 for the factory initial setting.)

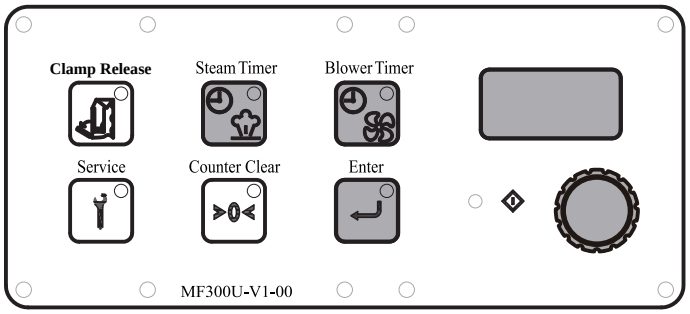
Setting changes are as follows:

1. Press the "Steam Button" or the "Blower Button".

   → The Green lamp turns on the selected button.
   The Display Window shows the current time.

2. Change the time by turning the Set/Select Dial.
   ①Set the time longer by turning clockwise.
   ②Set the time shorter by turning counterclockwise.

3. Press the "Enter Button" to save the change. If you do not want to save, press the selected button (Steam Button or Blower Button) once again.
   When pressing the "Enter Button", the selected time has been saved even though the main power turns OFF. If you do not press the "Enter Button", the selected time will be no longer be in effect after the main power turns OFF.



⚠Caution

・Operate the machine carefully so that your hands or garment are not pinched in the machine while in motion.

Garment setting (In case of “shirt” mode.)

1. Select the “Mode Switch” and the “Short Sleeve/Long Sleeve Switch” subject to the type of garment.

Information Select the mode before the second process (Tail Clamp) of garment is over.

Select combination; neck clamp, shoulder tension, tail clamp, vacuum, center clamp, lower front clamps, cuff clamp and side clamps. The details are as follows:-

Finishing process by mode

		Mode select			
Process number	Machine operation	Polo shirt T-shirt	Shirt	Blouse	Operation
Counter	Neck clamp / Shoulder tension	○	○	○	Foot pedal
2	Tail clump	×	○	○	Foot pedal
3	Vacuum	×	○	○	automatic
3	Center clamp	×	○	○	Foot pedal
4	Lower front clamps	×	○	○	Foot pedal
5	Cuff clamp (right)	Long sleeve: ○ Short sleeve: ×	Long sleeve: ○ Short sleeve: ×	Long sleeve: ○ Short sleeve: ×	Right cuff button or foot pedal
5	Cuff clamp (left)	Long sleeve: ○ Short sleeve: ×	Long sleeve: ○ Short sleeve: ×	Long sleeve: ○ Short sleeve: ×	Left cuff button or Foot pedal
6	Side clamps	×	○	Long sleeve: ○ Short sleeve: ×	Foot pedal
automatic operation	steam	○	○	○	automatic
	Body extension	×	○	○	automatic
	Blower	○	○	○	automatic
	Tail clamp/Lower front clamp release ("shirt" mode only)		○	×	automatic

○: Implement processes
×: Skip process

2. Set the Garment on the Body as the front placket being vertical by setting the first button and its button hole properly. Hold the first button and its hole by the index finger as seen in Figure-1. Step on the Feed Process Pedal.

→The Neck Clamp closes and holds the neck. (Process No.-1-)
Also, the shoulder extension is then activated.
Adjust shoulder width to garment manually.

*If you want to reset the neck again, press the Reset Button or Neck Release Button. The Neck Clamp opens, and you can set the neck once again.
If you want to close the Neck Clamp again, simply press the foot pedal or the Neck Release button.

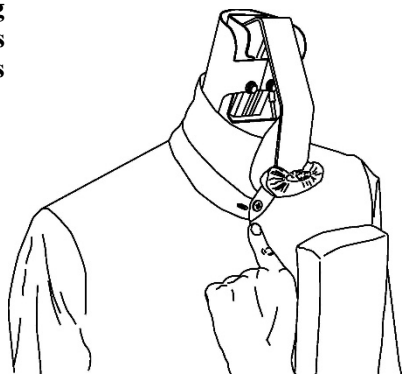


Figure-1

Information If you want to reset the neck, press the Neck Release button, and the neck clamp will open. If you want to close it, press the Neck Release button again or press the foot pedal. After the neck clamp is closed, you can restart the garment setting. If the neck clamp is open, you cannot proceed to the next process.

3. Hold the tail of the garment (both left and right). Pull down the garment to avoid wrinkles at rear tail. Step on the Foot Pedal.

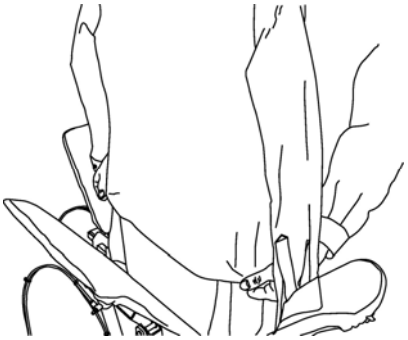


Figure-2

→The Tail Clamp closes and holds the rear bottom of the garment. (Right and left Sleeve Arm also closes under the long sleeve mode.)

→The Vacuum starts to work.
Pull the garment down vertically not to make any wrinkles on the front placket. Set the garment sticking on the Body.

Caution Set the front placket right and left firmly so that the air cannot come out when blowing. Set the front placket properly for the Front Clamp to hold it firmly.

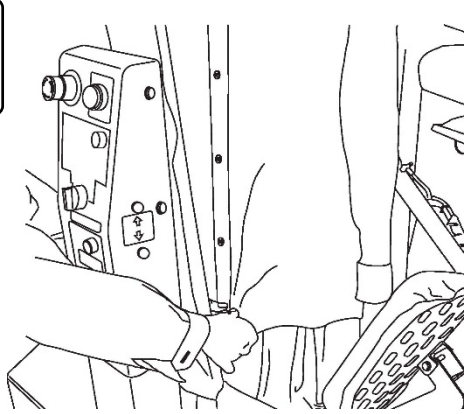


Figure-3

* If you want to reset the tail again, press the Reset Button. The Tail Clamp will open.

4. Step on the Feed Process Pedal again

→The Front Clamp closes and holds the front placket. (The vacuum stops working.)

*If you want to reset the front of the garment again, press the Reset Button. The Front Clamp will open. (The vacuum also will turn on.)

5. Pull both sides with the tension levers and press the feed process pedal. (Figure-7)

→ The Lower front clamps will close.

6. Set Cuff (Long Sleeve) or Short Sleeve

Select Long Sleeve or Short Sleeve

You can select Long Sleeve or Short Sleeve by switching "Short Sleeve Select Button" On and OFF. You can change the setting before you set the cuff.

Long Sleeve

When the Long Sleeve button is ON, the machine is in long sleeve mode. When the Short Sleeve button is ON, press it to engage in Short Sleeve mode.

Short Sleeve

(※ When the Short Sleeve Mode works, left and right Sleeve Arm stay open. They do not slide up.)
When the Short Sleeve Button is OFF (Button lamp turns ON), the Short Sleeve Mode works.
While the Short Sleeve Button is OFF, press this button. The lamp turns ON and the Short Sleeve Mode is ready to work.

●Set the Long Sleeve

※Explain how to set the left sleeve, but you can start to set from either side.

1. Set the cuff to the cradle and press the cuff clamp button.

→The Cuff Clamp will close and holds the cuff.
*If you want to reset the cuff again, press the Cuff Clamp Button. The Cuff Clamp will then open.

2. Set the other cuff the same as above. Press the Cuff Clamp Button. The Cuff Clamp will close and holds the cuff.

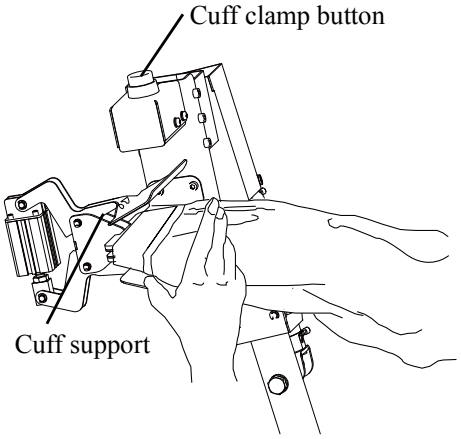


Figure-4

Caution Make sure not to pinch fingers.

Information Turn "d 8" of DIP function ON (see page 25). You can operate the Cuff Clamp by the Foot Pedal. Please make sure the cuff can be set **only from the right side**.

Point If the cuff cannot be set to the cuff cradle, fold it and set on the cradle.

●Set the Short Sleeve

※Use Short Sleeve Clip

（1）Hold the upper side of the sleeve.

（2）Hold the Short Sleeve Clip by the other hand. Open the Short Sleeve Clip keeping the Guide Plate at the lower position. Insert the Guide Plate into the short sleeve. (Figure-5)

（3）Pull down the Clip stretching the wrinkle of the sleeve, then clamp the short sleeve. (Figure-6)

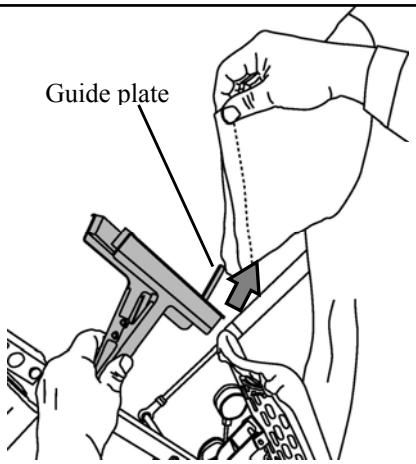


Figure-5

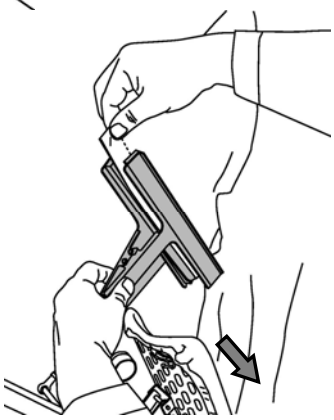


Figure-6

7. Set the Side

Adjust the tension of both sides of the garment by the Side Expander Levers. Step on the Feed Process Pedal.

→The Side Clamps (Right and Left) close and hold the side of the garment. The automatic operation will now begin.

Automatic operation: sleeve arm open → live steam injection → blower/body extension.

※Automatic operation will start in the following order:
"Sleeve Arms open → Steam injects → Blower/Tail Pull".

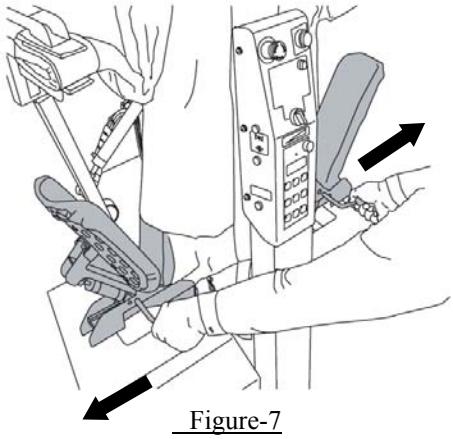


Figure-7

Information

- When you step on the Foot Pedal during the automatic operation, the blowing time will extend 5 seconds per each step. (Maximum: 180 seconds)
- By turning the Set / Select Dial of the operation panel during the automatic operation, you can change the power of the blower. Adjusting the blower power to the specific garment can enhance its finishing quality.
- Press the Reset Button while in automatic operation. The process is over even before the timer finishes. (when Auto Finish Button is on.)

Tips!

For the garment with a side slit, you can set the garment side by side to avoid opening the slit too much when expanding the side.

1 Open the Side Expander Lever carefully to set the slit properly. Press the Side Clamp Button.

→The Side Clamp will close and holds the side.

2 Set the other side the same as above. Press the Side Clamp Button.

→The Side Clamp will close and holds the side.

3 Step on the Foot Pedal.

→The automatic operation will begin to work.

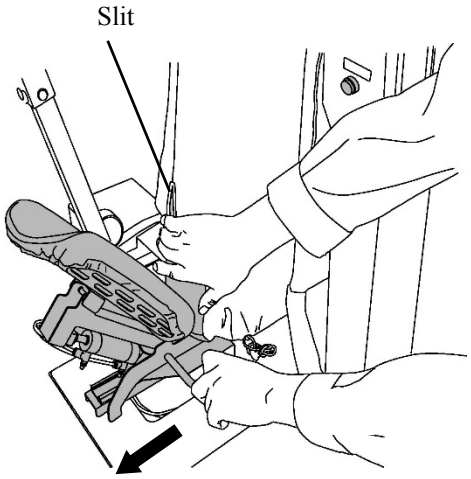


Figure-9

Tips!

While the long sleeve is processed under automatic operation,

1. Wrinkles come out on the shoulder or side (need an angle adjustment)
2. Wrinkles appear on the sleeve by pulling it too much or the sleeve shows slack due to the sleeve not opened positioned properly (need pulling tension adjustment)

In order to deal with the above, you can adjust by the operational button.

1. Change the Angle ･･･Adjust the Sleeve Arm angle by pressing Cuff Clamp Up(⇧) or Down (⇩) Button. They are located at the right side of the Front Arm.
   ･Up Button: Sleeve goes up to the desired level
   ･Down Button: Sleeve goes down to the desired level.

2. Change the Pulling Tension ･･･Adjust the pulling tension on the sleeve by pressing Sleeve Arm Close (◁▷) or Open (⋈) Button. They are located at the left side of the Front Arm.
   ･Close Button: Tension reduces.
   ･Open Button: Tension increases.

8. All the presses are open and complete when the setting time is over. (When the auto finish is ON.)

Take the garment off from the Body, and you can then set the next garment.

Finishing Operation

- Turn the power OFF by pressing the red button at the left side of the Inverter Box.

→The Power Lamp and Display Window will turn OFF.

Caution	After the neck is closed with T-shirt/Polo shirt mode for short sleeve, steam injection activates in the automatic mode. Please be careful.

Other Operation

When You Select the Auto Finish Button Off

After the automatic operation is over, the Front/Rear clamps, the Right/Left clamps and the Neck Clamp stop to work and close. If you want to open the clamps, wait until the time (set by "V6": see page 24) has been up or press the Reset button or the Feed process pedal.

Save Timer Setting

If you want to save the time setting you changed on the Steam Timer or Blower Timer, press the "Enter" Button to save the setting.
If you turn the power OFF before saving the Timer, the previous timer setting will be in effect the next time you turn the power ON.

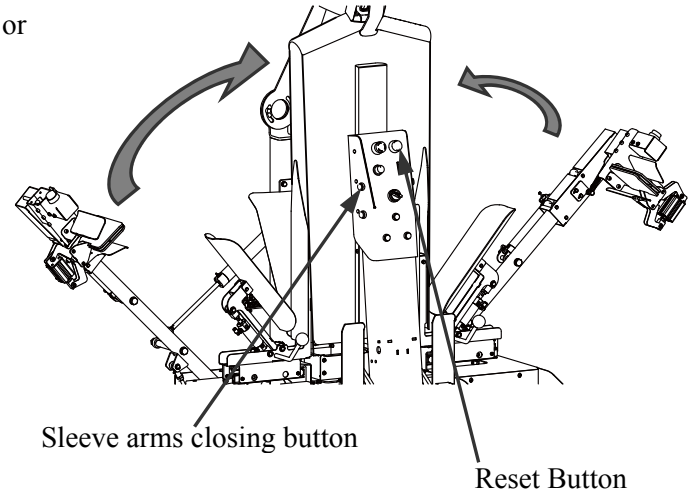
Initial Timer Setting for Each Mode

Mode	Timer name	Initial setting
Polo shirt T-shirt	Steam timer	4.0 sec. (maximum 10 sec.)
	Blower Timer	30 sec. (maximum 180 sec.)
Shirt	Steam Timer	5.0 sec. (maximum 10 sec.)
	Blower Timer	55 sec. (maximum 180 sec.)
Blouse	Steam Timer	5.0 sec. (maximum 10 sec.)
	Blower Timer	40 sec. (maximum 180 sec.)

To close the opened sleeve arms

The sleeve arms can be closed when the machine is not running.

- The sleeve arms can be closed by pressing the "Sleeve Arms Close" button and the indicator in the operation panel shows "off".
- To restart, press the "Reset" button or step on the foot pedal for operation.



Test Operation

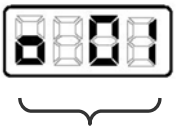
WARNING Before using the test operation, make sure there is no one working near the machine.

Caution Factory setting may vary without any notice due to the change of machine settings.

The Test mode operation enables the machine to run each process by process for testing purposes.

Step 1: Press the “Test Button” on the control panel.
→ The Green lamp turns ON and “o 01” shows up.

The display example of a Test No. "o 01":

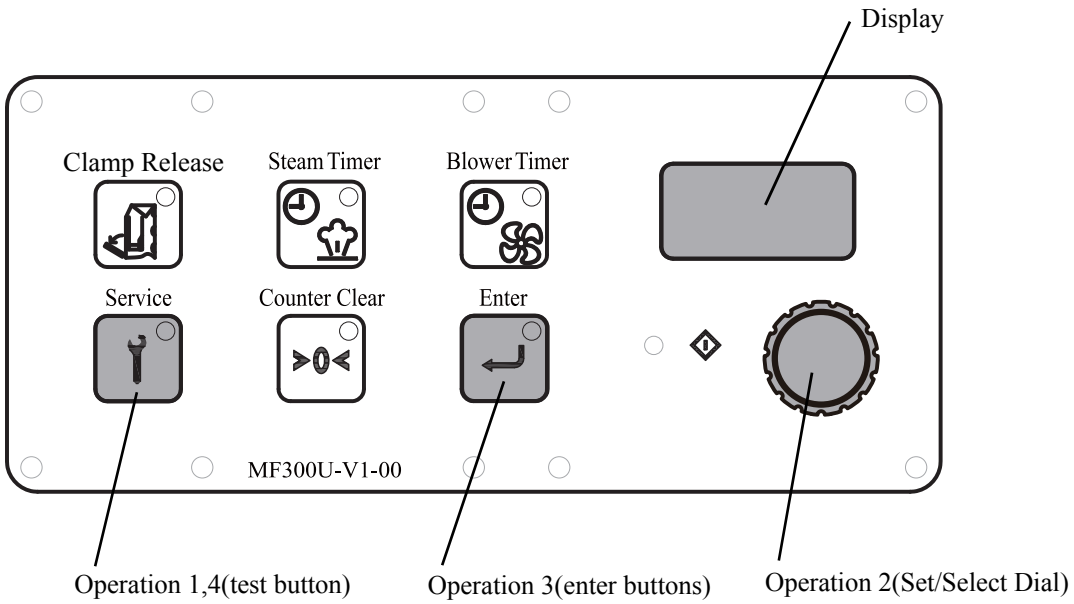


Test No.

Step 2: Select the test number with the “Set/Select Dial”
→ Turn to the right. The test number goes up.
Turn to the left. The test number goes down.
（The number shows up with the order of test number as in the chart at page 30. ）

Step 3: Press the “Enter Button”.
→ The selected Test Mode begins to work. The lamp of the “Enter Button” turns ON while the test is ON.
* Press the “Enter Button” again to stop the test operation.
（Please finish the selected test operation. It does not proceed to the next test.）

Step 4: Press the “Test Button” when you finish the test.
→ The Test Button turns off and the normal operation begins to work



Test Number List

No.	Test Items	Remarks
O1A	Shoulder Expansion/Return	Shoulder, Expansion/Return solenoid valve: ON/OFF.
O2A	Neck Clamp	Neck Clamp solenoid valve: ON/OFF.
O2b	Body Extension	Body Extension solenoid valve: ON/OFF.
O2C	Tail Clamp	Tail Clamp solenoid valve: ON/OFF.
O3A	Front Clamp	Front Clamp solenoid valve: ON/OFF.
O3b	Lower Front Clamps	Lower Front Clamps solenoid valve: ON/OFF.
O4A	Steam Injection	For steam injection test. When the steam button is on, steam can be injected for 0.3 seconds. *No steam injection while the light is blinking.. (To go into the steam injection test, press steam button, check if the light is on and press Enter.)
O4b	Left Side Clamp Closes	Left Side Clamp Closes solenoid valve: ON/OFF.
O4C	Right Side Clamp Closes	Right Side Clamp Closes solenoid valve: ON/OFF.
FAb	Right and Left Side Clamp Closes	Right and Left Side Clamp Closes solenoid valve: ON/OFF.
O5A	Side Clamp Return	Side Clamp Return solenoid valve: ON/OFF.
O5b	Left Cuff Clamp Closes	Left Cuff Clamp Closes solenoid valve: ON/OFF.
O6A	Right Cuff Clamp Closes	Right Cuff Clamp Closes solenoid valve: ON/OFF.
O6b	Cuff Clamp Up/ Down	Cuff Clamp Up/ Down solenoid valve: ON/OFF.
O7A	Vacuum Select	Vacuum Select solenoid valve: ON/OFF.
O7b	Sleeve Arm Open/ Closes	Sleeve Arm Open/ Closes solenoid valve: ON/OFF.
O8b	Front Clamp Vacuum	Front Clamp Vacuum solenoid valve: ON/OFF.
O9A	Blower Motor ON/OFF	The motor starts when this test turns on.
O9b	Vacuum ON/OFF	When this test turns on, the Vacuum Select Solenoid (No. 15) activates. The blower turns to be the vacuum.
10 A	Buzzer	Buzzer sounds when turned ON.
VoL	Check/set Volume	Check, set and change the volume settings. Refer to "Volume Functions on page 24.
DiP	Check/set DIP switches	Check, set and change the DIP switch settings. Refer to "DIP switch feature" on page 25.

■**Volume Function**

- Press “Enter” when 0.8.8. appears in the display window..
- Choose Volume number to check/change as in Table-1 turning the Set/Select dial, and press “Enter”.
- Select and set value turning Set/Select dial, and press “Enter” to save.
- Press “Hard/Soft” button to end Volume function.

Table-1 Volume Functions and Settings

No.	Setting	Initial Setting (sec)
V1	Waiting time after start finishing	1.0 sec. (maximum 3.0 sec.)
V2	Waiting time for release of all clamps after finishing is done.	2.5 sec. (maximum 5.0 sec.)
V3	Waiting time for release of all clamps after blower is finished at automatic operation mode.	1.5 sec. (maximum 5.0 sec.)
V4	Delay time of steam injection at automatic operation mode.	3.5 sec. (maximum 5.0 sec.)
V5	Delay time of cuff clamps release after finishing is done.	1.5 sec. (maximum 3.0 sec.)
V6	Waiting time for release of all clamps when auto-finish is OFF.	6 0 sec. (maximum 180 sec.)
V7	Time to rise sleeve arms a little in finishing.	0.05 sec. (maximum 0.1 sec.)
V8	Release time of tail clamp during finishing,	5 sec. (maximum 175 sec.)
V9	Time of shoulder expansion in setting process	1.5 sec. (maximum 3 sec.)
V10	Delay time to vacuum start.	0.5 sec. (maximum 2.0 sec.)
V11	Shoulder expansion time during steam injection. (Shirt mode)	0.2 sec. (maximum 2.0 sec.)

■**DIP Switches**

- Press “Enter” when 8.8.8. appears in the display window.
- Choose DIP number to check/change as in Table-1 turning Set/Select dial, and press “Enter”.
- Choose on or off of DIP turning Set/Select dial, and press “Enter” to save.
- Press “Hard/Soft” button to end DIP switch function.

Table-2 Dip Switch Functions and Settings

No.	Setting		Initial Setting
d 1	Side clamping process for short sleeve in Polo shirt/ T-shirt and blouse modes.	ON: Side clamps engaged	OFF
		OFF: Side clamps disengaged	
d 2	Auto-finishing mode select	ON: Select.	ON
		OFF: Unselect.	
d 3	Work Cuff Clamp by Foot Pedal	ON : Work	ON
		OFF : Not Work	
d 4	Show garment counter	ON : Show	ON
		OFF : Not Show	
d 5	Ascending/descending order of process display	ON: Descending order	OFF
		OFF: Ascending order	
d 6	Intermediate release button ON in the displayed panel when power is on.	ON: Enable	ON
		OFF: Disable	
d 7	Lowering cuff clamps during finishing long sleeved garment.	ON: Enable	ON
		OFF: Disable	

Trouble?

◎ If your machine doesn't function properly there should be an error number shown on the control panel display. Please see the error number list below along with some helpful hints to get your machine up and running again. If you are unable to get your machine running again after checking the advice below, please contact your local Sankosha distributor or Sankosha USA, Inc's office.

WARNING When working around electrical components such as the electrical box and or the control box, extra care should be taken. When working in the opened electrical box or the control box do not touch any unnecessary areas. Touch only the areas as instructed.

CAUTION If you have any of the following error messages:"EEE", "EE1", "EE2", "EE3", "EE4", "EE5" please turn off the machine and wait for 5 seconds and turn the machine back on. If the error persists, please contact your local Sankosha distributor or Sankosha USA, Inc.

Error No.	1. Error Item
	2. Error Description
	3. Check Point
E1	1. Emergency Stop Button
	2. Emergency Stop Button is being pressed.
	3. (1) Release the Emergency Stop Button by turning the Button clockwise (to the "→" direction). Display shows "- - 1". Press the Reset Button. (2) Wiring may be the cause if E1 displays even after releasing it. Check the Button itself or check for a possible short circuit in the wire.
E11	1. Inverter error
	2. Inverter irregularities.
	3. If the machine stopped due to an inverter error, turn the power off until the inside of the inverter gets cool, then turn it back on. If you turn it on before the inverter is cool, the machine may stop again. If the inverter does not work despite the above, please contact your local Sankosha dealer or Sankosha USA, Inc.
E20	1. Reset Button Error
	2. Reset Button remains ON for more than 15 seconds.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or if there could be a short circuit in the wire.
E21	1. Feed Process Pedal Error
	2. Feed Process Pedal remains ON more than 2 seconds after garment is finished.
	3. (1) Check if the Feed Process Pedal is being pressed. (2) Check the Feed Process Pedal itself or there could be a short circuit in the wire.

Error No.	1. Error Item
	2. Error Description
	3. Check Point
E22	1. Sleeve Arm Close Button Error
	2. Sleeve Arm Close Button remains ON more than 2 seconds after garment is finished.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or there could be a short circuit in the wire.
E23	1. Sleeve Arm Open Button Error
	2. Sleeve Arm Open Button remains ON more than 2 seconds after garment is finished.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or there could be a short circuit in the wire.
E24	1. Cuff Clamp Up Button Error
	2. Cuff Clamp Up Button remains ON more than 2 seconds after garment is finished.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or there could be a short circuit in the wire.
E25	1. Cuff Clamp Down Button Error
	2. Cuff Clamp Down Button remains ON more than 2 seconds after garment is finished.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or there could be a short circuit in the wire.
E26	1. Left Cuff Close Button Error
	2. Left Cuff Close Button remains ON more than 2 seconds after garment is finished.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or there could be a short circuit in the wire.

Error No.	1. Error Item
	2. Error Description
	3. Check Point
E27	1. Sleeve Arm Open Button Error
	2. Sleeve Arm Open Button remains ON more than 2 seconds after garment is finished.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or there could be a short circuit in the wire.
E28	1. Left Side Clamp Close Button Error
	2. Left Side Clamp Close Button remains ON more than 2 seconds after garment is finished.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or there could be a short circuit in the wire.
E29	1. Right Side Clamp Close Button Error
	2. Right Side Clamp Close Button remains ON more than 2 seconds after garment is finished.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or there could be a short circuit in the wire.
E30	1. Neck Release Button error
	2.The button is left pressed for more than 2 seconds after finishing auto-operation or pressing Reset button after turning on power.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or there could be a short circuit in the wire.
E31	1. Steam Pedals Error
	2. The Steam Pedal remains ON more than 2 seconds after garment is finished.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or there could be a short circuit in the wire.

Daily Maintenance

CAUTION

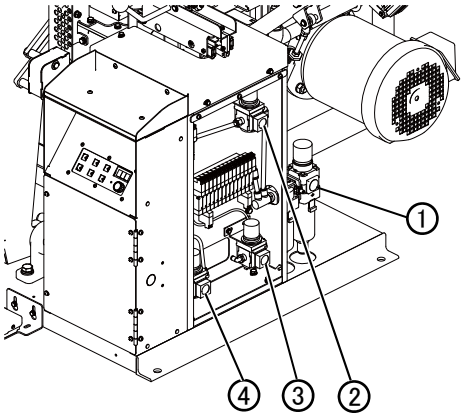
Please read and comprehend carefully this Daily Maintenance thoroughly before operation. Keep this manual in a safe place for easy access at all times. The Checking cycle will differ: daily or annually, according to the item or area that requires maintenance.
Use the "Item Check List" for checking the correct service procedures.
If at any time you have any questions, please do not hesitate to contact your dealer or Sankosha.

Check Item List

Item	Daily	Yearly
1. Air Pressure	○	
2. Regulator/Mist Separator	○	
3. Steam Pressure	○	
4. Steam Trap	○	
5. Cover and Padding	○	
6. Emergency Stop Button	○	
7. Blower Filter	○	
8. Regulator/Mist Separator		○
9. Inverter Cleaning		○

Check Items (daily)

1. Air pressure (daily):Fig.1
   Check the air pressure gauge if it shows the specified air pressure. Refer to “Part Names” on page 14 and “Getting Air” regarding the component location and specified pressure value.



1. Main regulator・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・・0.5 MPa
2. Regulator (sleeve arm close /front clamps)・・・・・・・・・0.25MPa
3. Regulator (shoulder expander)・・・・・・・・・・・・・・・・・・・・・0.35MPa
4. Regulator (sleeve arms open)・・・・・・・・・・・・・・・・・・・・・0.2MPa

Pressure Adjustment

1. Lift the adjustment knob to release lock.
2. Turn the knob to adjust pressure.
   - Clockwise ⇒ Raise pressure.
   - Counter-clockwise Lower pressure
3. Push adjustment knob back down to lock.

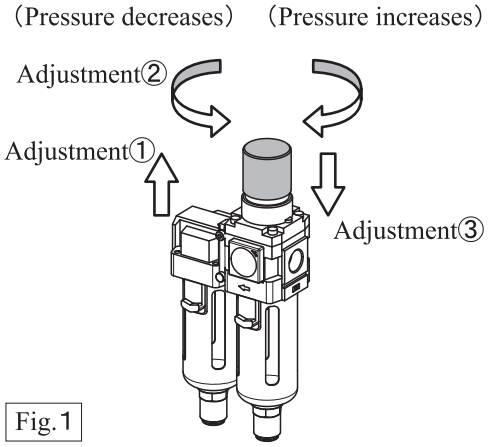


Fig.1

2. Regulators/Mist separator (daily):Fig.2
   Check the auto-draining function of the regulator/mist separators. When the water/oil exceeds half of the tank, it will automatically be discharged.
   If not, discharge it manually turning the drain outlet counter-clockwise to discharge drain. The Auto-drain may not be functioning right.

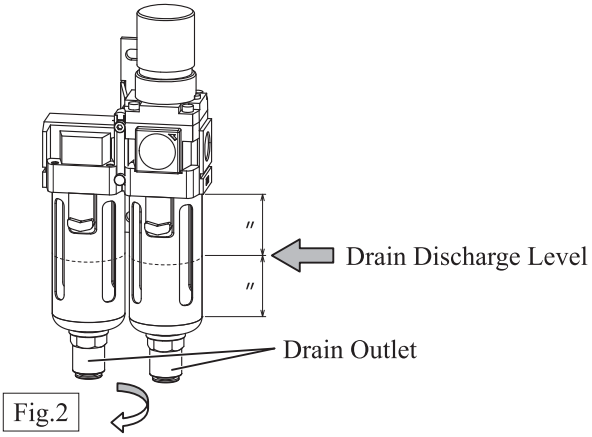


Fig.2

3. Steam pressure (daily):Fig.3
   Check the steam pressure gauge to make sure it shows the specified steam pressure. Refer to “Part Names” on page 14 and “Getting Steam” regarding part location and specified pressure value

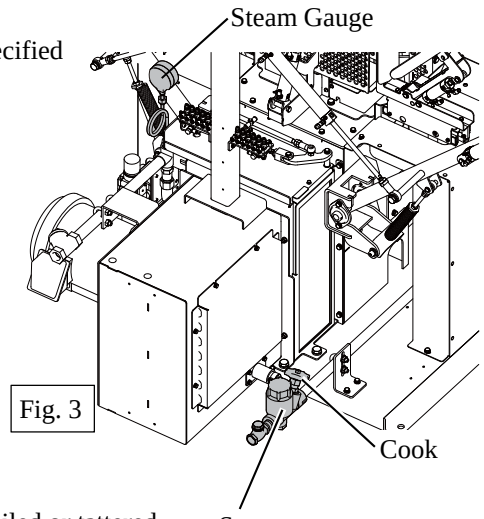


Fig. 3

4. Steam trap (daily):Fig.3
   Check if the steam trap is working properly. If it is not functioning, it may be out of order.
   Open the handle on the steam trap to discharge condensate.
   Close the handle after it has completely drained.

5. Covers (daily)
   Check the covers of upper/middle/lower press to see if they are soiled or tattered. Stains or holes may affect the finishing quality.

6. Emergency stops button (daily): Fig. 4
   Press the Emergency Stop button to make sure it is functioning properly.

7. Filter in vacuum box (daily):Fig.5
   Check if there is trash or dust on the air intake filter. If there is, clean it up ASAP.
   If it is left unclean, the vacuum function will not work properly and it may affect both productivity and the finishing quality.

Fig. 4

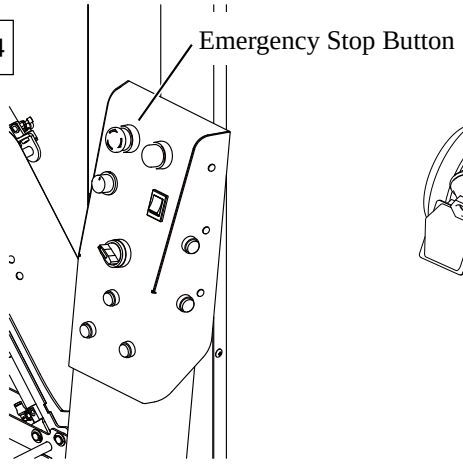
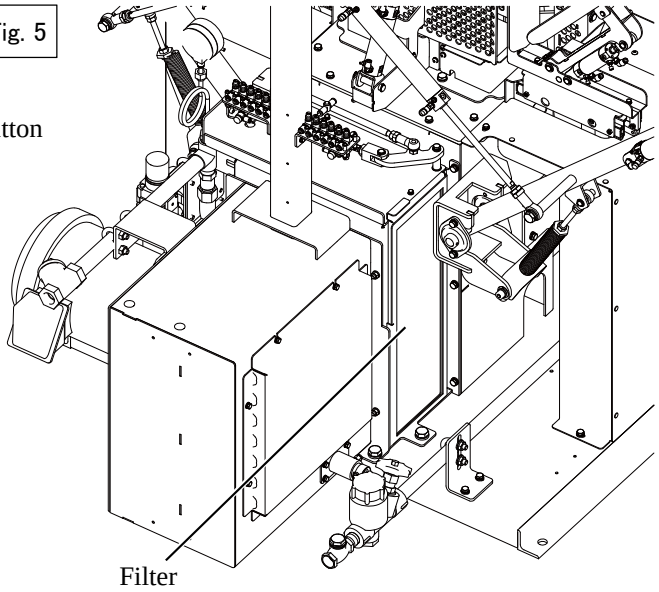


Fig. 5



Check Item (yearly)

8. Regulator/Mist separator filter (once/year):Fig.6
   Clean filters in regulator/mist separator.
   If pressure drops occur frequently, swap out the filter element.

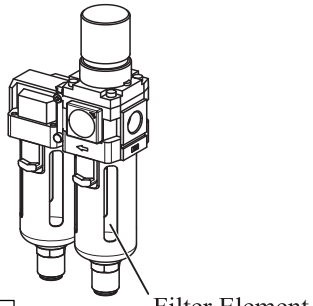


Fig. 6

9. Inverter (once/years):Fig.7

Caution **Be sure to turn the power off while servicing as this is a high voltage part.**

Remove the inverter cover on the right side of the machine.
Clean trash and dust around the inverter.
Mount covers back to the original position after cleaning is done.

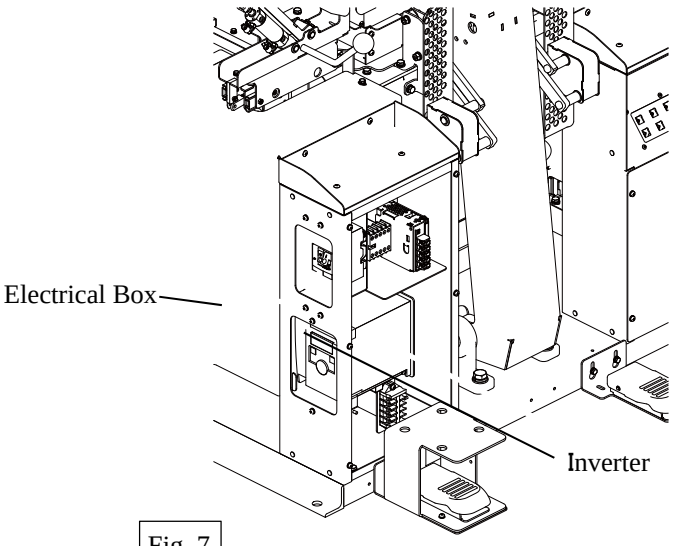


Fig. 7

Check Items - Check Sheet

Daily check items

No	Item	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
1	Air Pressure																
2	Regulator/ Mist Separator																
3	Steam Pressure																
4	Steam Trap																
5	Covers & Padding																
6	Emergency Stop Button																
7	Blast Filter																

No	Item	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31
1	Air pressure															
2	Regulator/ mist separator															
3	Steam pressure															
4	Steam trap															
5	Covers															
6	Emergency Stop Button															
7	Blast filter															

Yearly check items

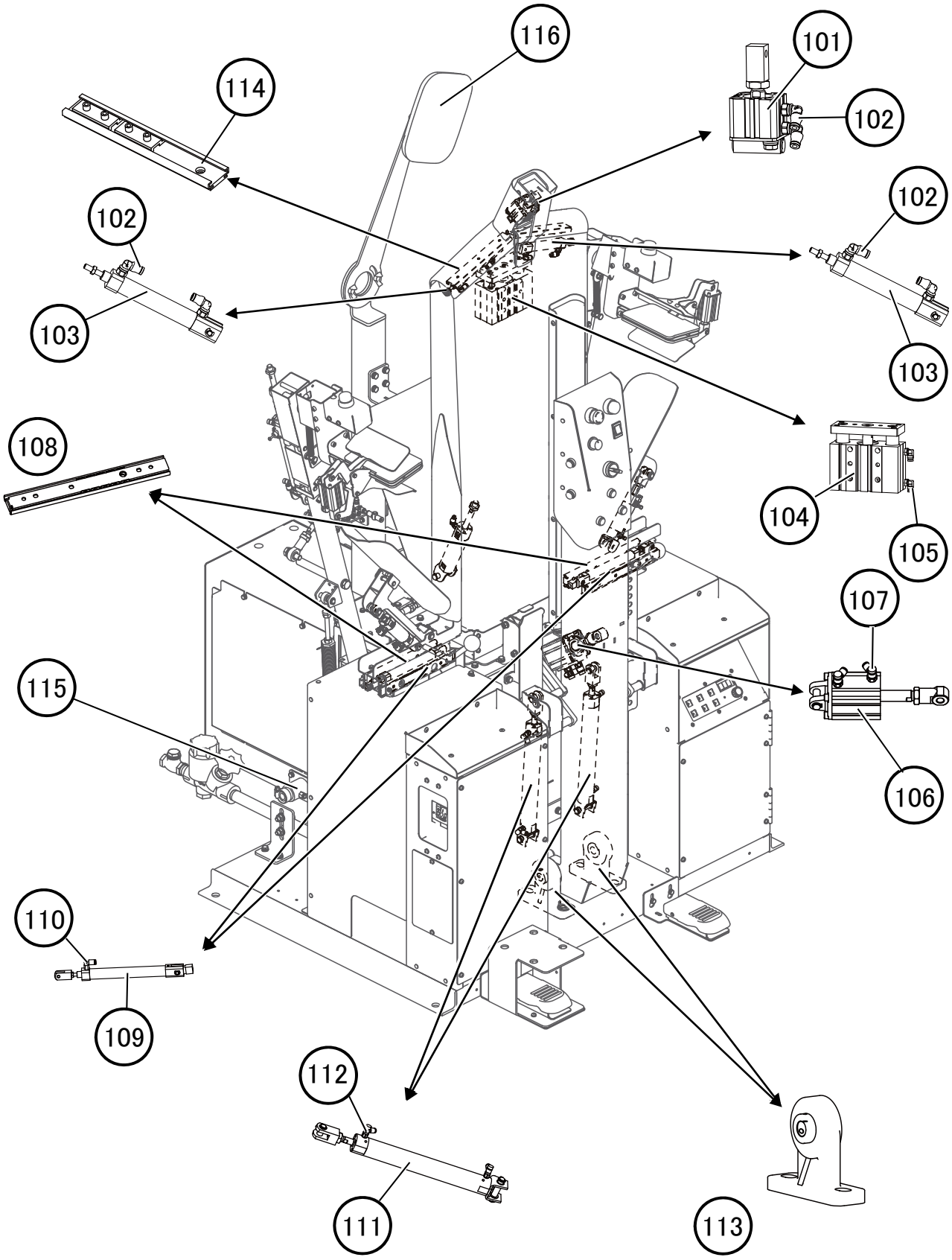
No	Item	1	2	3	4	5	6	7	8	9	10	11	12	13
8	Regulator/Mist separator													
9	Inverter Cleaning													

Photocopy and use this check sheet.

Spare Parts List

Index

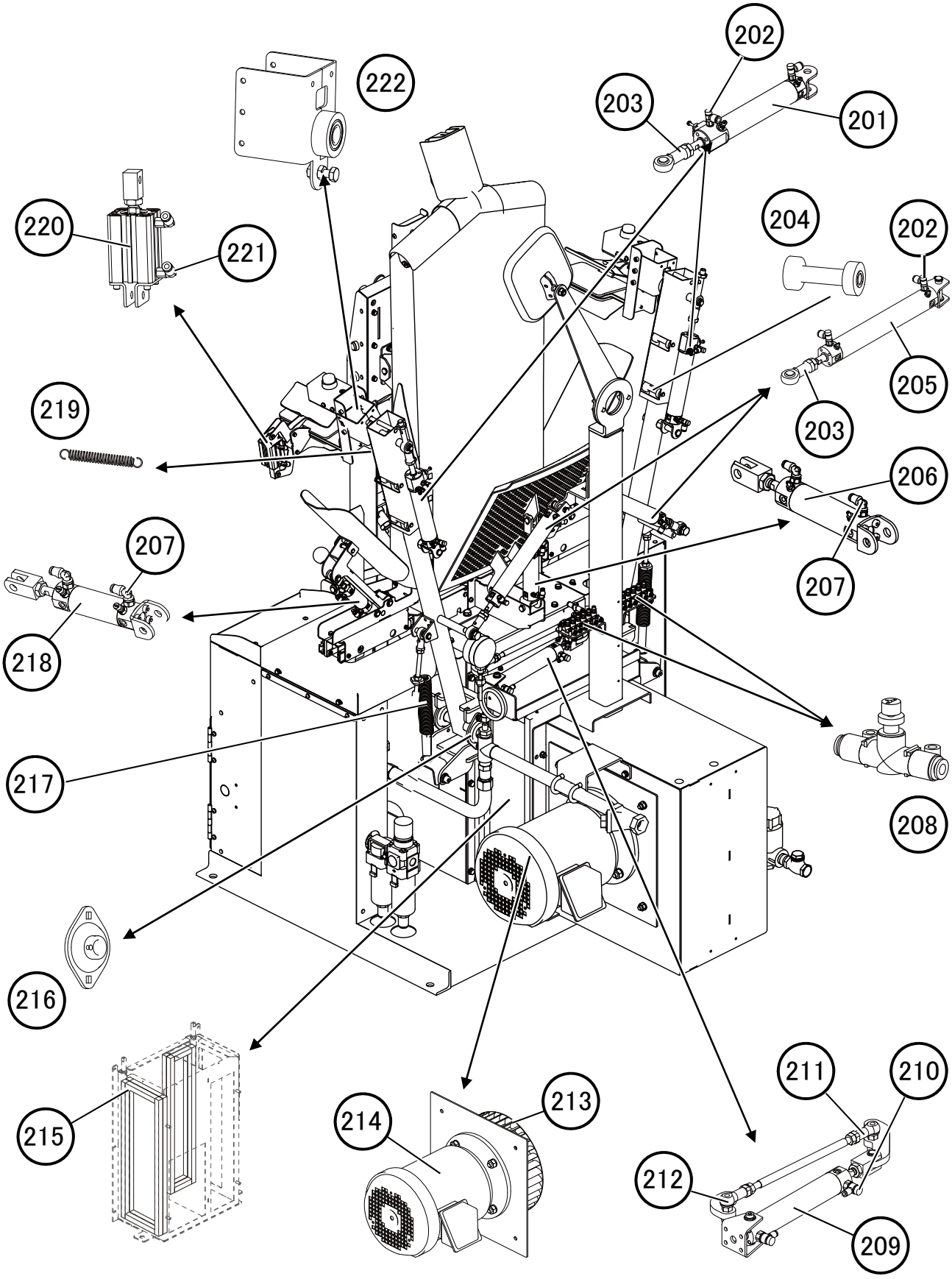
1 : Front Diagram REV : 1



1 : Front Diagram REV : 1

No.	Part Name	Part Namber	Q'ty	Remark
101	Cylinder	B2E019	1	Neck Clamp
102	Joint	C0B010	8	
103	Cylinder	B2J083	2	Shoulder Slide
104	Cylinder	B2K003	1	Stretch
105	Joint	C0C127	2	
106	Cylinder	B2J070	1	Front Clamp
107	Speed Controller	C1A065	2	
108	Slide Rail	E1D007	2	
109	Cylinder	B2J032	2	Side Slide
110	Joint	C0C080	2	
111	Cylinder	B0C007	2	Lower Front Clamps
112	Speed Controller	C1A076	4	
113	Bearing Unit	E4A008	2	
114	Shouider Slide	E1C002	2	
115	Recycled Air Inlet	C1C011	1	
116	Mirror	Q0A007	1	

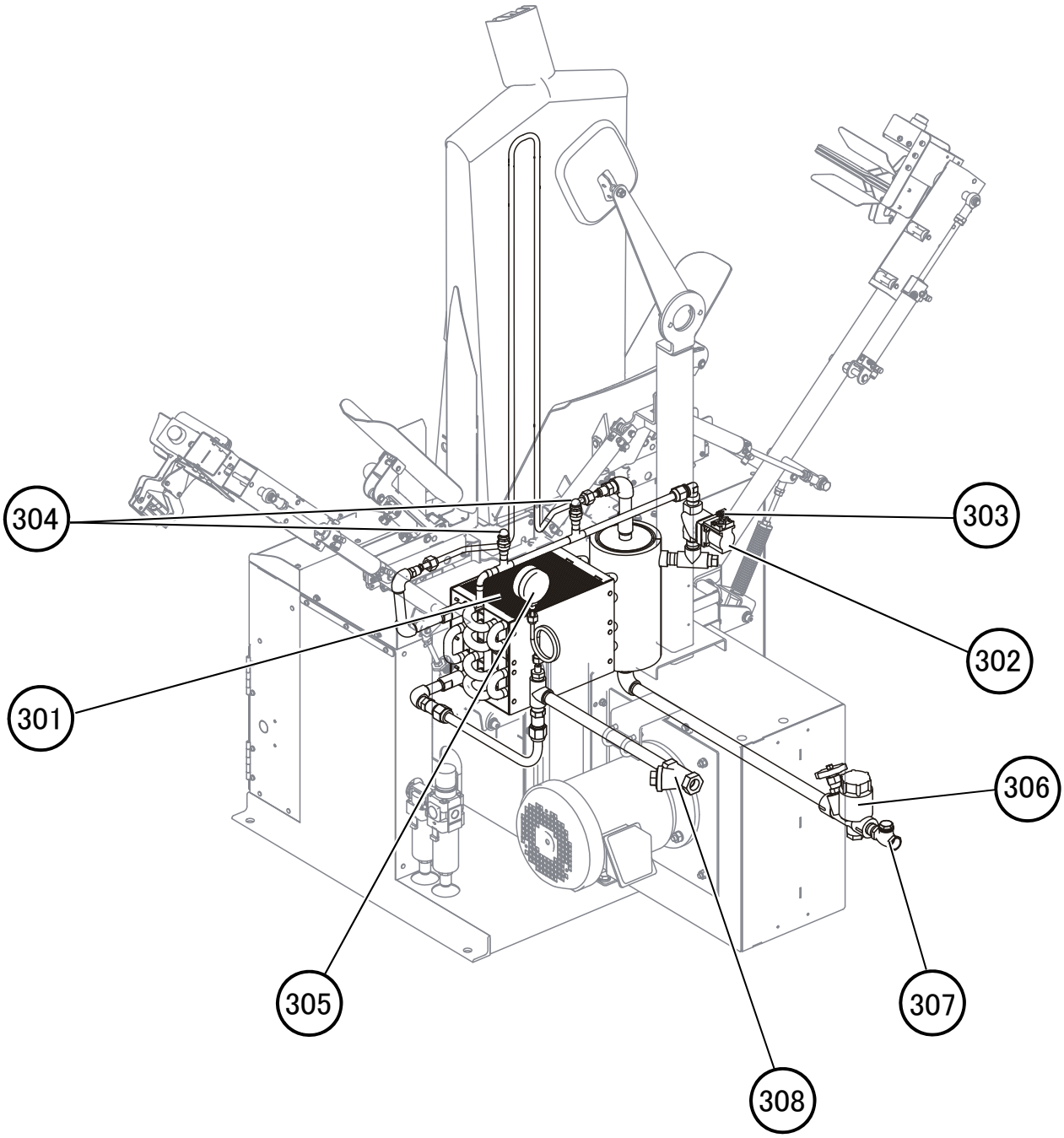
2 : Rear Diagram REV : 1



2 : Rear Diagram REV : 1

No.	Part Name	Part Number	Q'ty	Remark
201	Cylinder	B2I065	2	Cuff Clamp Upper Lower
202	Speed Controller	C1A068	8	
203	Rodend	E5A006	4	
204	Roller	P0A036	8	
205	Cylinder	B2E024	2	Sleeve Arm
206	Cylinder	B2I012	1	Tail Clamp
207	Joint	C0B010	4	
208	Speed Controller	C1G007	20	
209	Cylinder	B0F012	1	Blower / Vacuum Switch Valve
210	Speed Controller	C1A070	2	
211	Link Ball	E5J002	1	
212	Link Ball	E5J001	1	
213	Blower Fan	G2B009	1	
214	Motor	G0E035	1	
215	Packing	Q0A009	4.1m	419mm×8 65mm×4 115mm×4
216	Bearing Unit	E4A024	4	
217	Coil Spring	H0E038	2	
218	Cylinder	B2I013	2	Side Clamp
219	Sping	H0F022	2	
220	Cylinder	B2E029	2	Cuff Clamp
221	Joint	C0C080	4	
222	Bearing	E4B018	4	

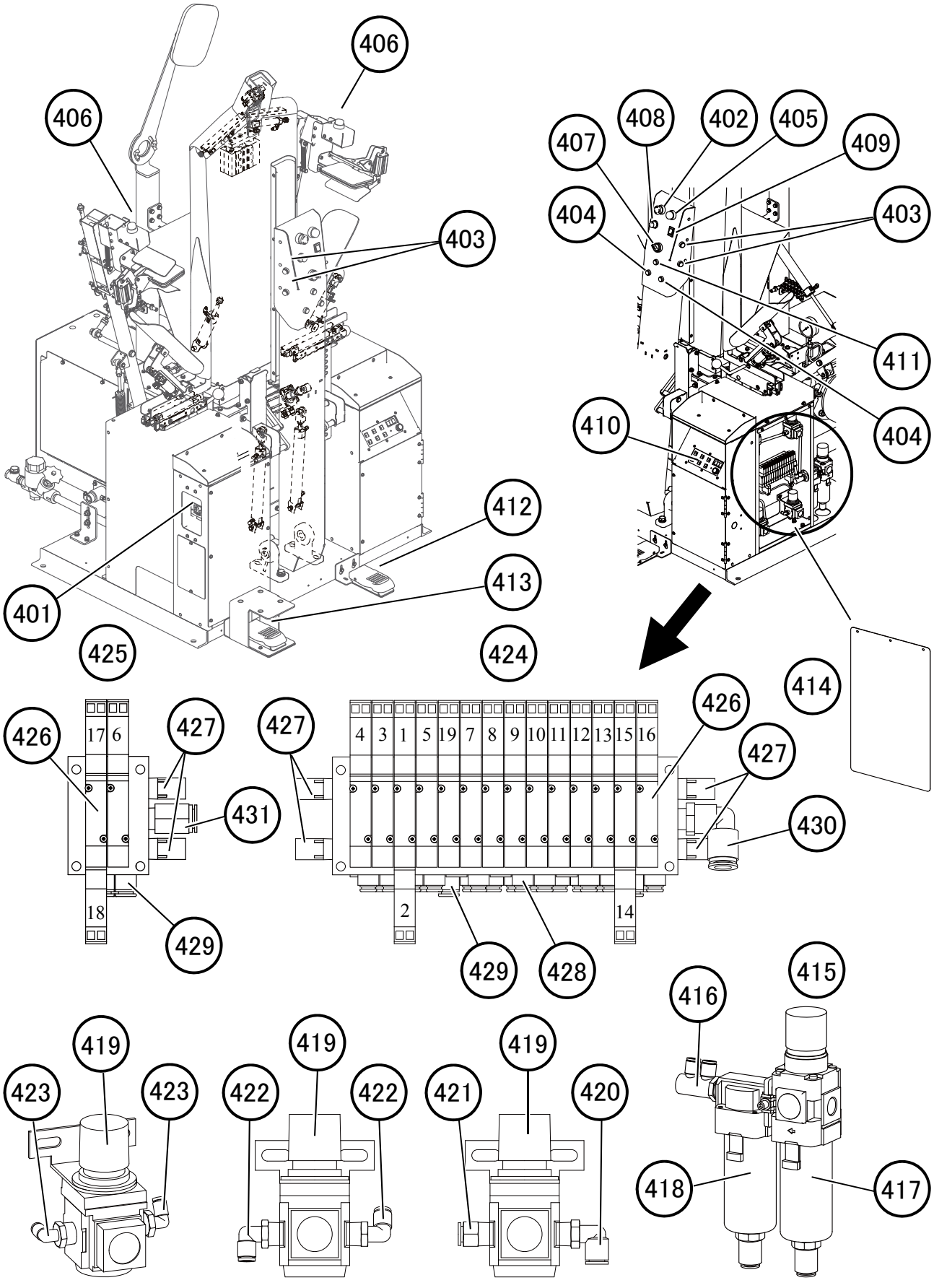
3 : Steam Piping REV : 1



3 : Steam Piping REV : 1

No.	Part Name	Part Number	Q'ty	Remark
301	Radiator	RD320-000	1	
302	Piston Valve	A0G044	1	
303	Joint	C0C127	1	
304	Air Muffler	J0A001	2	
305	Steam Gauge	J0A003	1	
306	Steam Trap	J2N001	1	
307	Lift Check	J2J002	1	
308	Y Type Strainer	J2M012	1	

4： Switch/Solenoid Valve Diagram（1/2）REV ： 1

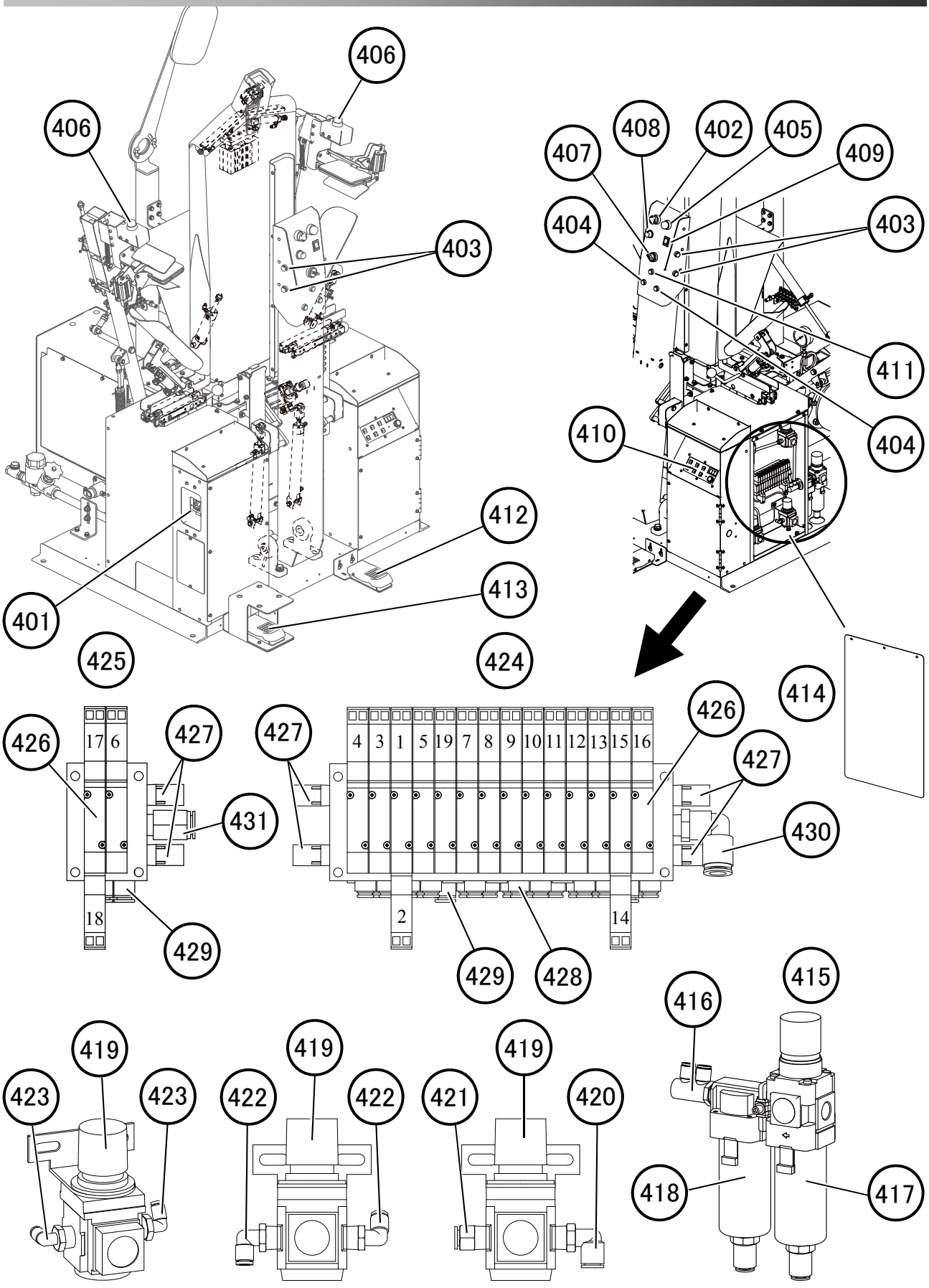


Shoulder expander　　Sleeve arms open　　Sleeve arm close / Front clamps

4： Switch/Solenoid Valve Diagram（1/2）REV ： 1

No.	Part Name	Part Number	Q'ty	Remark
401	Breaker Switch	21C027	1	Power
402	Push Button Switch	21I151	1	Emergency
403	Push Button Switch	21I008	4	Sleeve Open/Close,Cuff Up/Down
404	Push Button Switch	21I138	2	Left/Right Side Clamp
405	Push Button Switch	21I150	1	Reset
406	Push Button Switch	21I148	2	Left/Right Cuff Clamp
407	Selection Switch	20O007	1	Mode Selection
408	Volume	21D010	1	Adjust the air volume
409	Switch	21G011	1	Short Sleeved Selection
410	Panel Sheet	20U140	1	
411	Push Button Switch	21I006	1	Neck Release
412	Foot Pedal Unit	FP-UNT-023	1	Feed Process
	Micro Switch	21E035	1	
	Foot Pedal Spring	H0D019	1	
413	Foot Pedal Unit	FP-UNT-023	1	Steam
	Micro Switch	21E035	1	
	Foot Pedal Spring	H0D019	1	
414	Solenoid Valve Cover	S1D158	1	
415	Filter Regulator	D0F002	1	
416	Joint	C0C158	1	
417	Filter Element	D1F002	1	
	Diaphragm Element	D1H004	1	
	Case Assembly	D1J007	1	
418	Element Assembly	D1G002	1	
	Case Assembly	D1J007	1	
419	Regulator	D0H037	3	
420	Joint	C0C020	1	
421	Joint	C0C008	1	
422	Joint	C0C019	1	
423	Joint	C0C017	1	

4： Switch/Solenoid Valve Diagram（2/2）REV ： 1

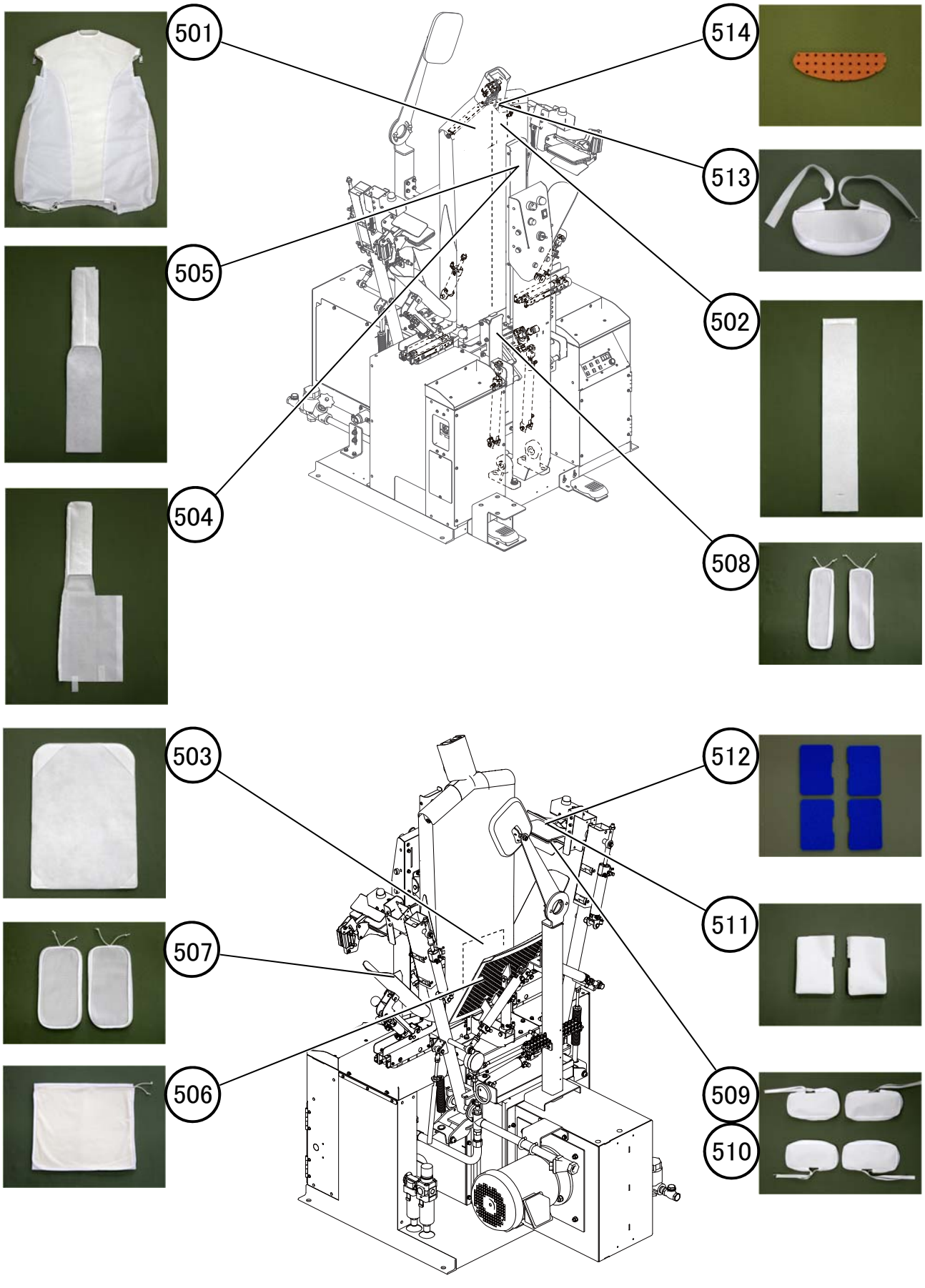


Shoulder expander　Sleeve arms open　Sleeve arm close / Front clamps

4 : Switch/Solenoid Valve Diagram（ 2/2 ）REV:1

No.	Part Name	Part Number	Q'ty	Remark
424	Manifold Valve	A0M050	1	
425	Manifold Valve	A0M051	1	
426	Solenoid Valve	A0N022	1	No.1,No.2
	Solenoid Valve	A0N026	1	No.3
	Solenoid Valve	A0N026	1	No.4
	Solenoid Valve	A0N026	1	No.5
	Solenoid Valve	A0N026	1	No.6
	Solenoid Valve	A0N026	1	No.7
	Solenoid Valve	A0N026	1	No.8
	Solenoid Valve	A0N026	1	No.9
	Solenoid Valve	A0N026	1	No.10
	Solenoid Valve	A0N026	1	No.11
	Solenoid Valve	A0N026	1	No.12
	Solenoid Valve	A0N026	1	No.13
	Solenoid Valve	A0N003	1	No.14,No.15
	Solenoid Valve	A0N026	1	No.16
	Solenoid Valve	A0N003	1	No.17,No.18
	Solenoid Valve	A0N026	1	No.19
427	Silencer	C0A018	6	
428	Joint(φ4)	C0I001	21	
429	Joint(φ6)	C0I002	7	
430	Joint	C0H026	1	
431	Joint	C0H031	1	

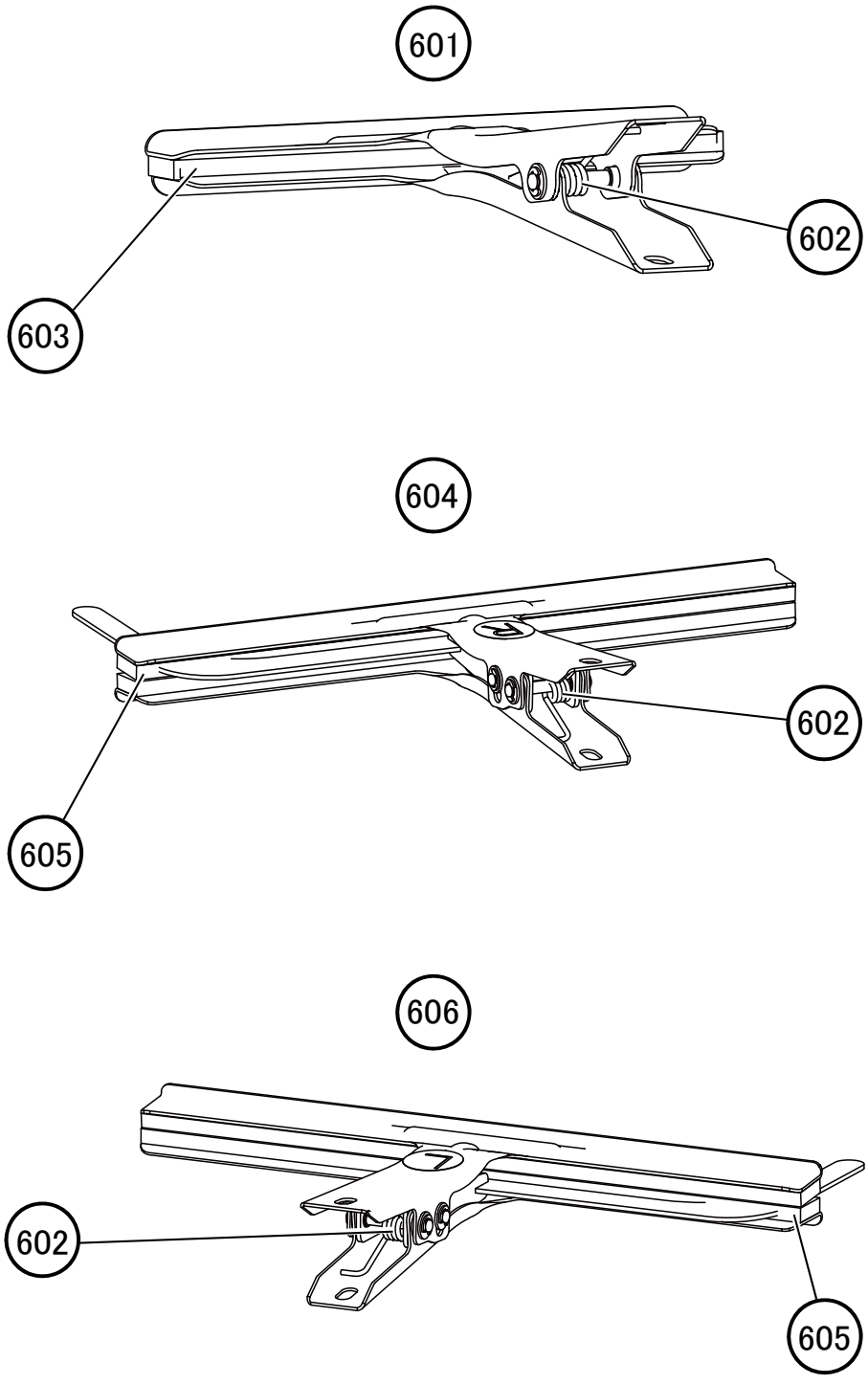
5 : Cover Diagram REV : 1



5 : Cover Diagram REV : 1

No.	Part Name	Part Number	Q'ty	Remark
501	Body Cover	S1D173	1	
502	Front Clamp Reciever Pad 8mm	S1D174	1	
503	Tail Clamp Reciever Pad 5mm	S1D147	1	
504	Front Clamp Cover	S1D175	1	
505	Front Clamp Felt Pad 5mm	S1D176	1	
506	Rear Clamp Cover	S1D150	1	
507	Side Clamp Cover	S1D177	2	
508	Front Lower Clamp Cover	S1D178	2	
509	Cuff Clamp Cover No.2 (Right Upper , Left Lower)	S1B040	2	
510	Cuff Clamp Cover No.2 (Left Upper , Right Lower)	S1B041	2	
511	Cuff Middle Cover	S1D179	2	
512	Cuff Middle H Silicone 6mm	S1D180	4	
513	Neck Clamp (Small) Cover	S1B022	1	
514	Neck Clamp (Small) Orange Silicone	S1B023	1	

6 : Accessories REV : 1



6 : Accessories REV : 1

No.	Part Name	Part Number	Q'ty	Remark
601	Small Clip Unit	AP-05-AA37820	2	
602	Short Sleeved Clip Spring	H0D056	4	
603	Packing	E5V042	2	150mm
604	Large Clip Right Unit	AP-05-AA37822	1	
605	Packing	E5V042	4	240mm
606	Large Clip Left Unit	AP-05-AA37823	1	

Diagram

Push Button drawing

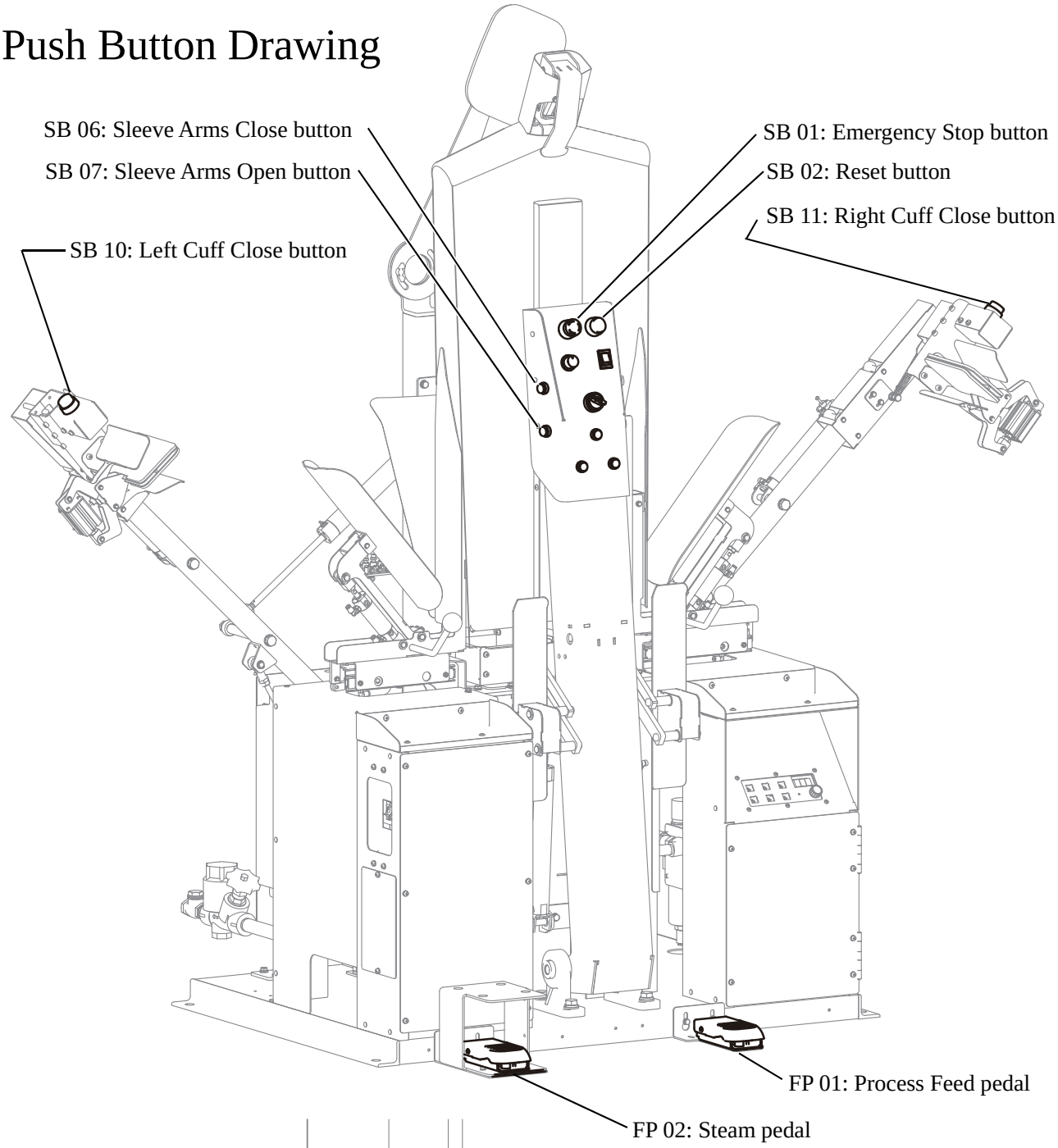
Electric Connection Diagram　1/4～4/4

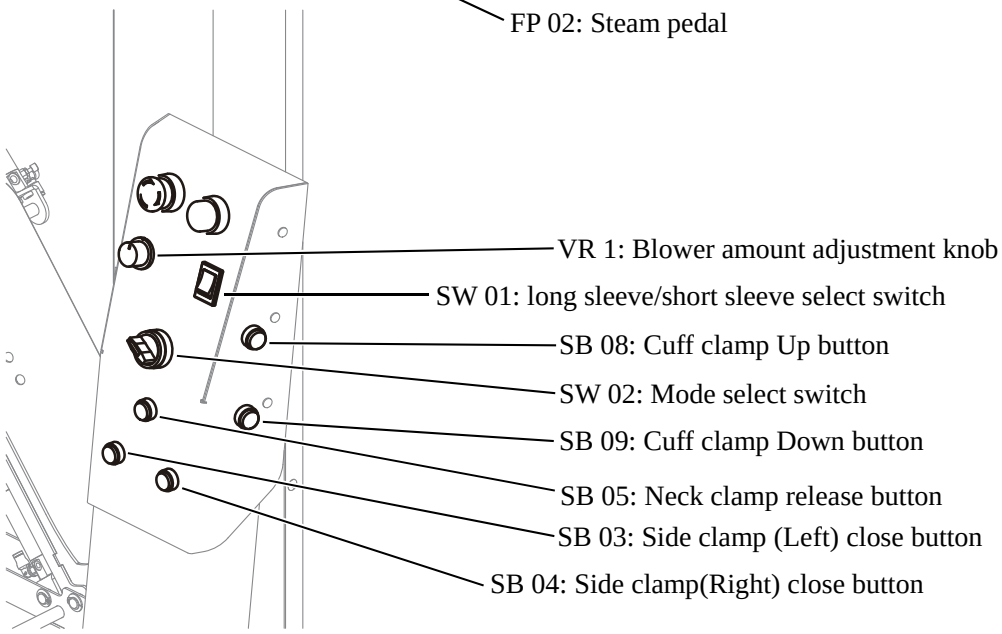
Steam Piping Diagram

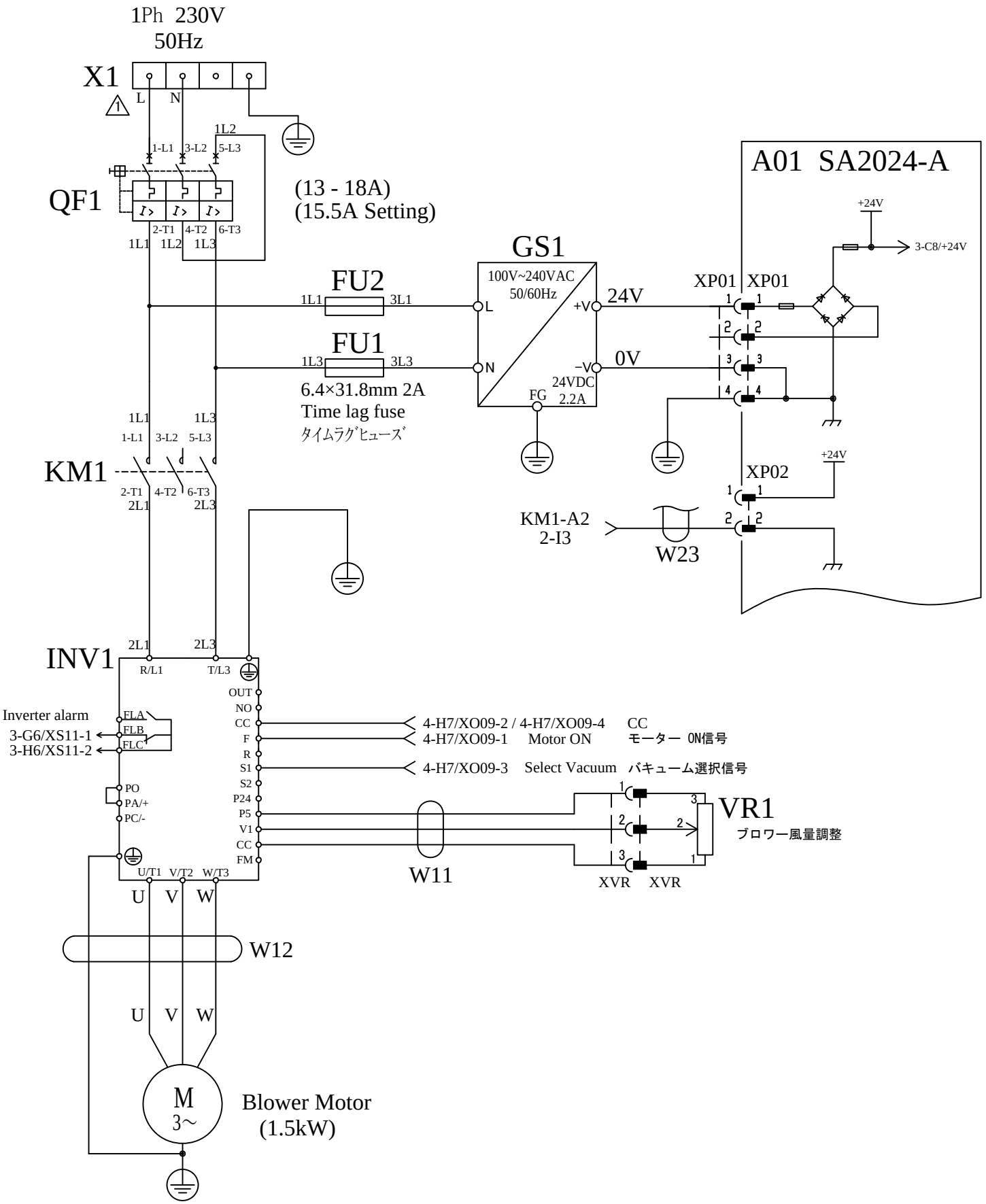
All Air System

Operation Process by Mode

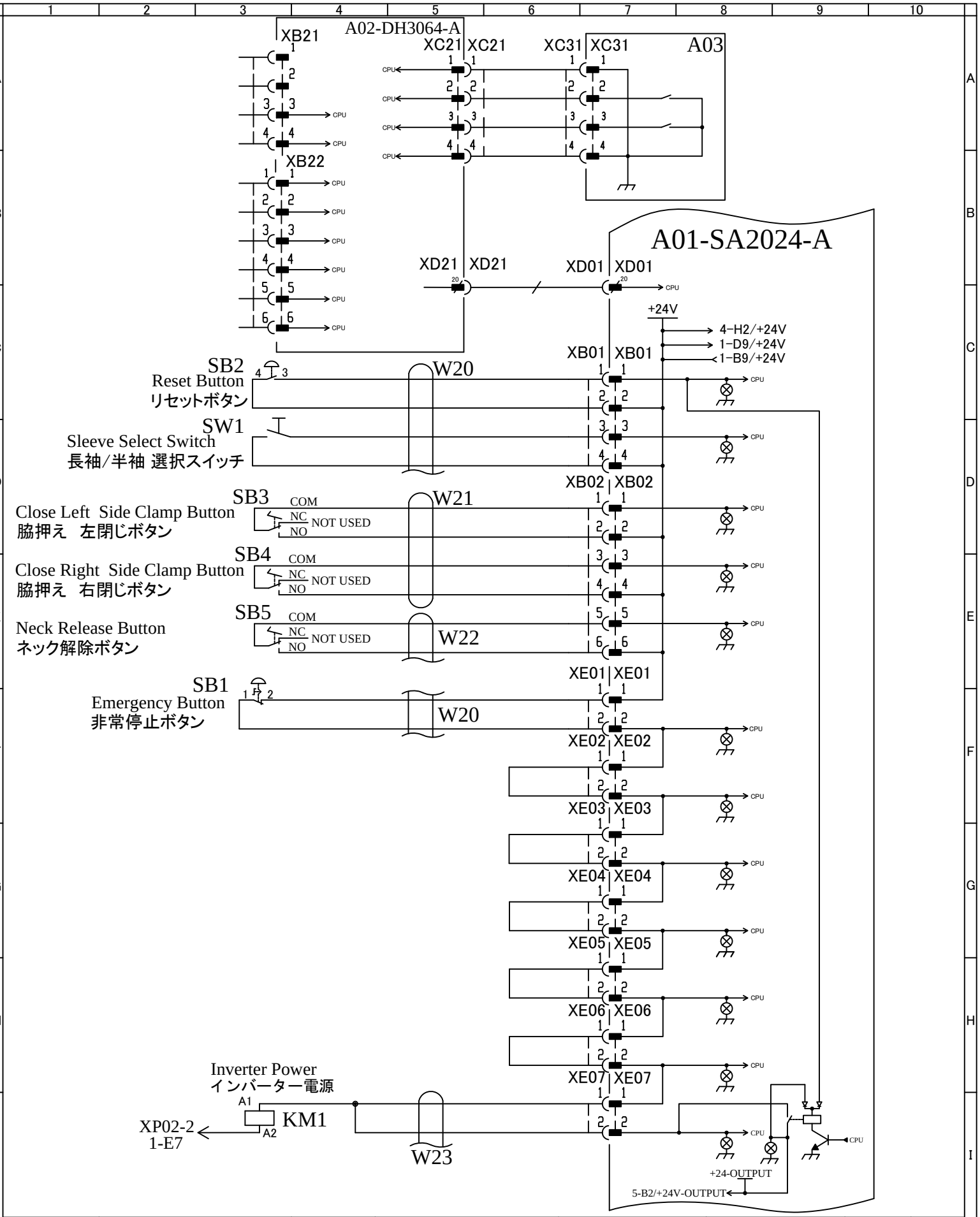
Push Button Drawing







Model	MF-350E		Type	MF350E-V1	Date(YYYY/MM/DD)	2016/03/28	Page	1 / 4
Approved	Checked	Designed	①	端子記号変更	Software	～		
Maki	Kouzu	Maki	②	-	Serial No.	～		
			③	-	Drawing No.	01-0		
			Revision		SANKOSHA 三幸社			



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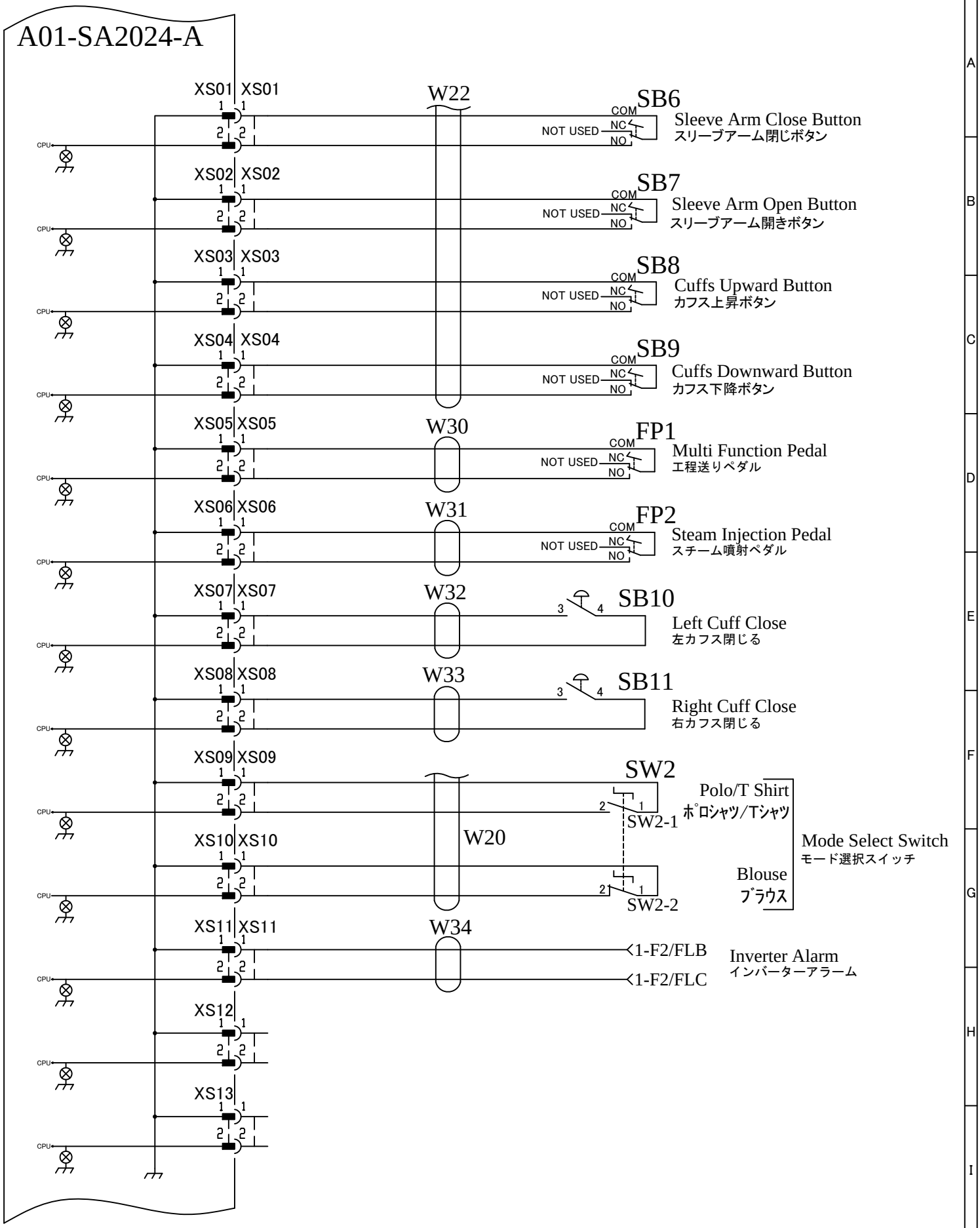
Approved	Checked	Designed	②	-	Software	～		
Maki	Kouzu	Maki	③	-	Serial No.	～		
			△		Drawing No.	01-0		
			Revision		SANKOSHA 三幸社			



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Approved	Checked	Designed	②	-	Software	～		
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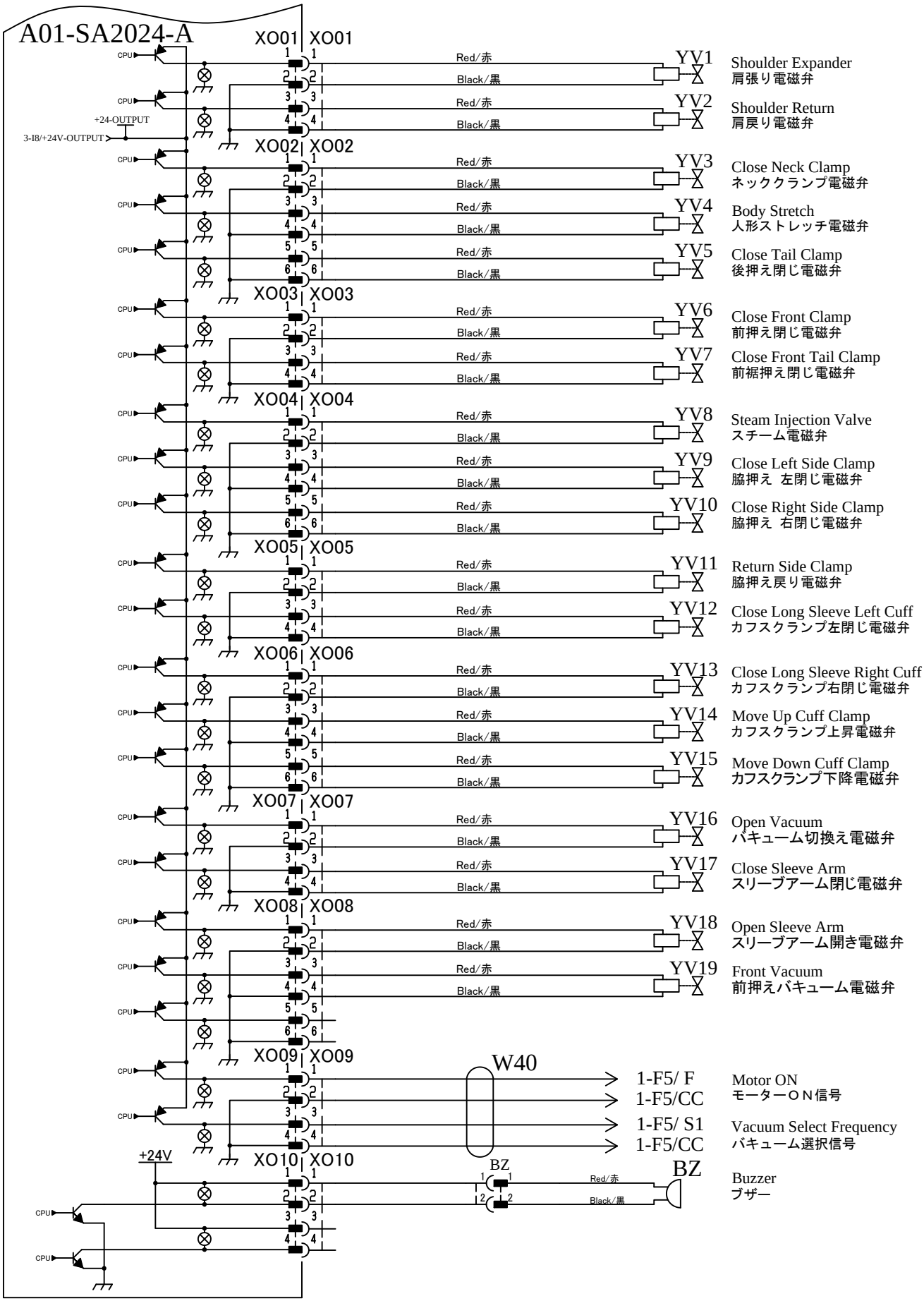
			Revision		SANKOSHA 三幸社			



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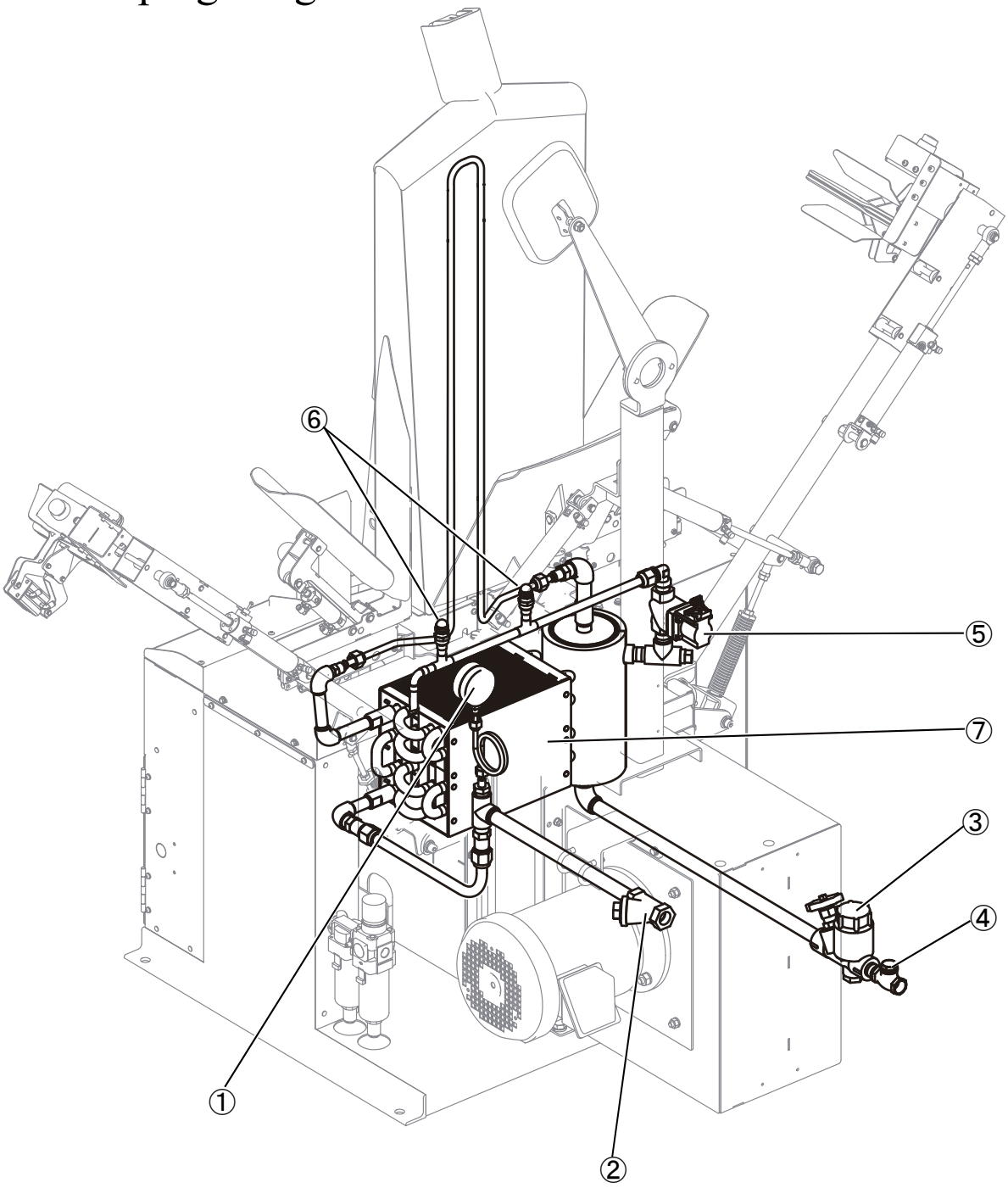
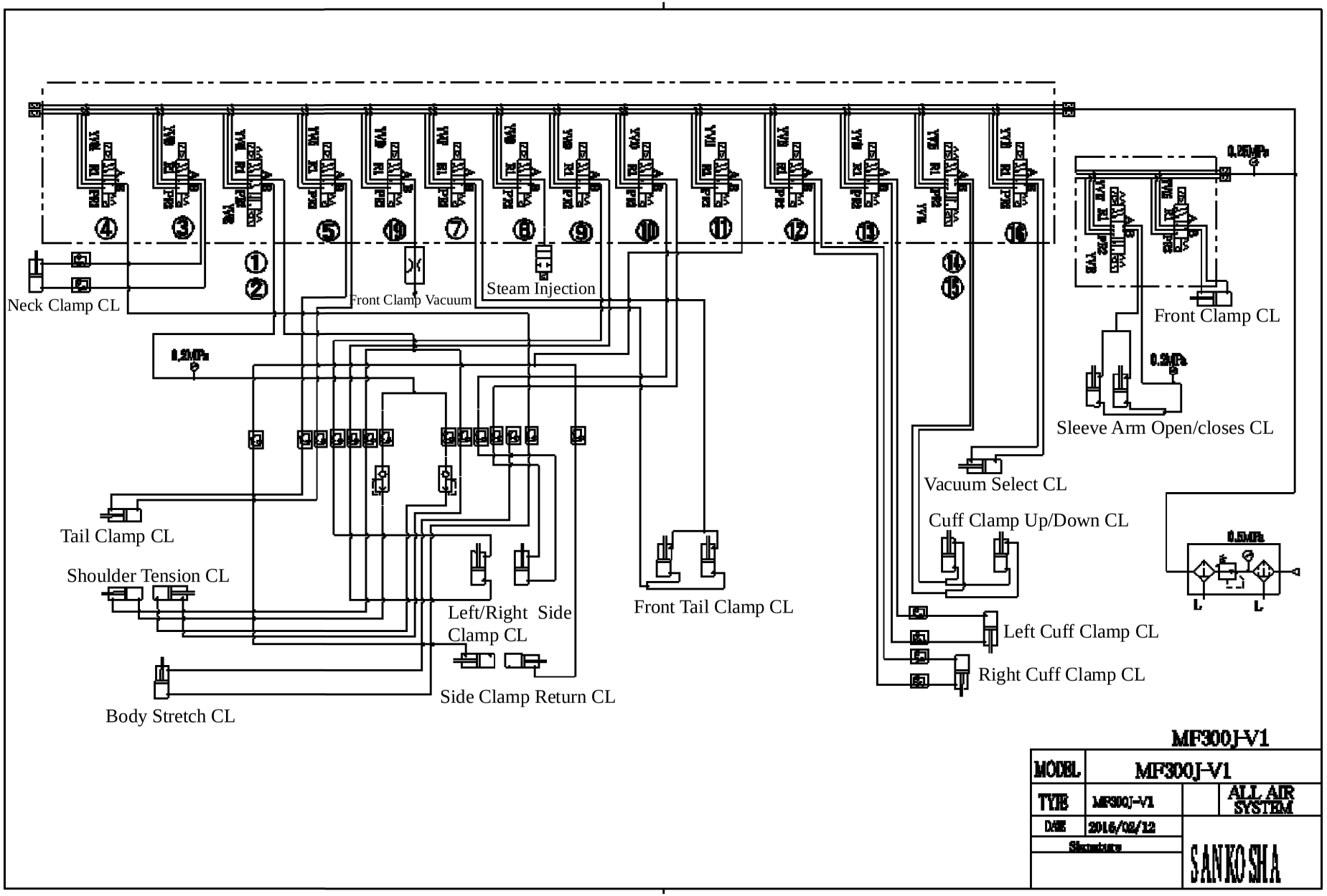
Approved	Checked	Designed	②	-	Software	～		
Maki	Kouzu	Maki	③	-	Serial No.	～		
			△		Drawing No.	01-0		
			Revision		SANKOSHA 三幸社			

Steam Piping Diagram



①.	Pressure Gage	: AMT7/16 60φ 1.6Mpa
②.	Y Strainer	: SY-5 15A 100Mesh
③.	Steam Trap	: YH-15A
④.	Lift Chuck	: 1/2
⑤.	Piston Valve	: SAB1S-15A-C
⑥.	Silencer	: SBN-38
⑦.	Radiator	: RD320


Neck Clamp CL
Front Clamp Vacuum
Steam Injection
Front Clamp CL
Sleeve Arm Open/closes CL
Vacuum Select CL
Cuff Clamp Up/Down CL
Tail Clamp CL
Shoulder Tension CL
Left/Right Side Clamp CL
Front Tail Clamp CL
Left Cuff Clamp CL
Right Cuff Clamp CL
Side Clamp Return CL
Body Stretch CL
MF300J-V1
MODEL
MF300J-V1
TYPE
MF300J-V1
ALL AIR SYSTEM
DATE
2016/02/12
Signature
SANKOSHA

Finishing process by mode

Process number	Machine operation	Mode select: Polo shirt T-shirt	Mode select: Shirt	Mode select: Blouse	Operation	Remarks
Counter	Neck clamp / Shoulder tension	○	○	○	Foot pedal	To free the sholder after vol.9(standard:1.5s)
2	Tail clump	×	○	○	Foot pedal	
3	Vacuum	×	○	○	automatic	Start the vacuum after vol.10(stadard:0.5s)
3	Center clamp	×	○	○	Foot pedal	
4	Lower front clamps	×	○	○	Foot pedal	
5	Cuff clamp (right)	Long sleeve: ○ Short sleeve: ×	Long sleeve: ○ Short sleeve: ×	Long sleeve: ○ Short sleeve: ×	Right cuff button or foot pedal	
5	Cuff clamp (left)	Long sleeve: ○ Short sleeve: ×	Long sleeve: ○ Short sleeve: ×	Long sleeve: ○ Short sleeve: ×	Left cuff button or Foot pedal	
6	Side clamps	×	○	Long sleeve: ○ Short sleeve: ×	Foot pedal	It can be operated in the right/left side clamp button
automatic operation	steam	○ （Standard：4s）	○ （Standard：5s）	○ （Standard：5s）	automatic	Max:10s
	Body extension	×	○	○	automatic	
	Blower	○ （Standard：30s）	○ （Standard：55s）	○ （Standard：40s）	automatic	Max:300s
	Tail clamp/Lower front clamp release ("shirt" mode only)		○	×	automatic	

○: Implement processes

×: Skip process