# Computerized special stitch pattern lockstitch sewing machine

#### 1. Safety precautions

Before use, please read this technical data and the manual of the matching sewing machine in detail, and use it correctly

- 1.1 (1) Power supply voltage and working frequency: please follow the specifications marked on the nameplate of the motor and control box.
- (2) Electromagnetic wave interference: Please stay away from high-frequency wave equipment or radio wave transmitters, etc., so as to avoid the generated electromagnetic waves from interfering with the drive device and thus operating in a wrong way
- (3) Grounding: To prevent noise interference or leakage accidents, please do a grounding project (including sewing machine, motor, control box, positioner).
- 1.2 When disassembling the motor or control box, do not pull it out with power on; there is dangerous high voltage inside the control box, so after turning off the power, wait 1 minute or more to open the control box cover
- 1.3 In order to ensure personal safety, please turn off the power when servicing machinery or performing needle insertion work.
- 1.4 This mark is consistent with that when the machine is installed, if it is wrong, it may hurt the human body or the machine will be damaged.

So there is this sign on the machine where there is danger.

This sign conforms to the sign that there is high voltage electricity, etc., where there is danger in electrical aspects.



DO1	Parameter Function	Range	Default	Description	-	+ # -	Stitches I	ength se	etting				M
P01	Maximum sewing speed (r/S)	100-3700	3500		╟	A~D	5 5						\$ V
P04 P05	Start back-tacking speed (r/S)  End back-tacking speed (r/S)	200-3200	2000		╢	A-D	Pattern B	<b>Backing</b> -t	acking	Key			+ 🖤
P06	Bar-tacking speed (r/S)	200-3200	2000		lL		Beautiful	seaming					<u>‡</u>
P07	Soft start speed (r/S)	200-1500	400			Patt	Pattern F	reedom	Sewing	Кеу			1
P08	Stitch numbers for soft start Automatic constant-stitch	0-99	2			25 ~ 204	Pattern C	`onstant-	-Stitch Se	ewing Key		ſ	<b>4</b>
P09	sewing speed (r/S)	200-3700	2500	Constant-Stitch sewing speed adjustment when one shot signal us active.  Range (0-4) stitch correction mode:	╟							(	
P15	Stitch correction mode	0-4	2	O: Half stitch 1: One stitch 2:Continuous correct half stitch 3:Continuous correct one stitch 4:Continuous correct stitch and quickly stop machine.		80	Speed in	crease					5120
17	Automatic count mode selection	0-1	0	O: P41 parameter value increase auto-count 1: P41 parameter disable auto-count.	l	<b>€</b>	Speed de	ecrease				ľ	1
228	Mode selection for bar- tacking	0-2	1	O: Manual, Pedal- control can stop and start.     Start: Automatic, One shot to pedal, it can automatic execute bar-tacking action.	(	+)[-	Paramete	r increas	se/Paran	neter decrease		1	М
P32	Stitch balance for bar-tacking	0-200	167		╟	P	Function	naramete	er adit			ſ	515
P35	Loose thread output	0-1	1	O: The output function of loose thread is closed 1: The output function of the loose thread is turned on	1	$\underline{}$	Tariction	paramet	er eart				$\equiv$
P36	Tension release/ big clamp device shift	0-1	1	O: Thread tension release function off, big clamp device function on.     Thread tension release function on, big clamp device function off.	L	(S <sup>K2</sup> )	Confirm k	кеу					s838
237	Wiper, clamp function selection (Pressure setting of	0-11	3	O: No Action 1: Wiper/ wiper thread action		141	Start bac	k-tackin	g s <b>ewin</b> g	g			. <del>  ‡ </del>
P41	the thread clamp device) Display the sewing finished quantity	0-9999	0	2-11: Thread Clamp action and the pressure gradually increased)	4.	Monitor	mode						
P49	Trimming speed (rpm)	100-350	250	Adjusting trimming speed	_	Under no display re	rmal circumstance lated monitoring p	s, press the ' parameters.	Press P to r	to adjust the paramet return to sewing mod	er to 42, pr e.	ess "S" to o	confirm an
P53	Cancel foot lifting when half- heeling the pedal	ON/OFF	OFF	0: OFF 1: Pedal heeling and pedal half heeling with foot lifting function 2: Pedal heeling with foot lifting function. Pedal half heeling without foot lifting function.		erial number	name	Defaults	Serial number	name	Defaults	Serial number	n
54	Trimming time (ms) Thread wiping/Thread	10-990 10-990	200 380	Action time of thread trimming sequence	$\ $	N01	Electronic control version serial numbe	er 7	N04	Foot pedal AD value	345	N07	Bus volt value
55 58	sweeping time  Up position adjustment	0-1439	84	Dial/scan time sequence action time  Up positioning adjustment, the needle will stop in advance when the value decreases, and the needle will stop when the value increases.	$\ [$	N02	Selector box version number	6803	N05	Upper positioning angle	84	N08	Error co
559	Down position adjustment	0-1439	752	will stop when the value increases  Down Position AdjustmentThe needle will advance stop when the value decreased.  The needle will delay stop when the value increased.		N03	Sewing speed	0	N06	Lower positioning angle	1403	N09	operatio
60	Testing speed (r/S)	100-3700	2000	Test function speed setting		Mode s		1					-
261	Testing A	OFF/ON	OFF	Test item A, after setting, press [P60.] to set  Test item B, after setting, the cycle of start-sewing-stop-trimming will be executed at the speed set by	5.1 exit	Debug m Into the n		the sewing		ally, press and hold th	ne "M" key f		ds to ente
P62 P63	Testing B Testing C	OFF/ON	OFF OFF	[P60.] Test item C, after setting, the start-sewing-stop cycle without positioning kinetic energy will be executed		erial number	name	Defaults	Serial number	name	Defaults	Serial number	, n
P64	Test B, C conduction time	1-250	20	at the speed set by [P60.]  In the B and C tests, set the conduction time		72	Correction of needle position	84	92	Encoder starting angle		128	Scissor
P65	Test B, C parking time	1-250	20	In B and C tests, set the parking time	" k	ey, the mo	tor will turn a few	times, then t	the LCD	e "M" key for 3 secon			
P66	Machine protection switch testing	0-2	0	O: no detection; 1: detection of zero signal; 2: detection of positive signal	mo	de, press "	P" key to exit into	normal mod	le	at the installation ang ld the "M" key for 3 s			•
P68	Maximum speed limit	4000	3700	Maximum speed limit	the (va	mechanic lue) as the	al zero adjustment upper stop needle	t interface, to e position. To	urn the hand o return to r	dwheel, the displayed normal mode from thi	value will b s mode, pre	e handy T ss the "P"	he wheel p key to exit
72	Upper needle stop position adjustment	0-1439		Adjustment up needle stop position, the value will changed according to the hand-wheel position, press S key to save current position(value) as up needle stop position.	trin	nming acti	the sewing mode on test interface, a rmal mode.	normally, lo	ng press the ss " 🔆 "	e "M" button for 3 sec , the scissors will act	onds, the L once accord	CD screen ling to the	displays ": desired an
73	Down needle stop position	0-1439		Adjustment down needle stop position, the value will changed according to the hand-wheel			mode: Long press the "S" key to view			e password mode, the ers.	LCD displa	ys 0000, a	ınd the cor
	adjustment			position, press S key to save current position(value) as down needle stop position.	res	tore the fa	ctory parameters.		ctory parame	eters:Press and hold t	he " [ " ] "	key for 5	seconds to
774	Positive stitch pitch compensation Back-tacking stitch length	0-100	50			4. Patte	rn sewing ed	it:					
		0-100	50							e "Patt" key, the LCD			
	compensation The angle of trimming first	0-100 5-359	50 950	The first feed angle of the thread trimmer (calculated at the lower position of $0^{\circ}$ )	and bet	i press the ween stite	"S" key to enter the hes in the first seg	he setting, th gment. Press	ne liquidThe the corresp	crystal screen displa conding key below an	ys "1 1 3.0" d the 🕒 😃	. At this ting the left is the	me, you car set each pa
80				The first feed angle of the thread trimmer (calculated at the lower position of 0°)  Thread trimming angle of the second infeed (calculated at the lower position of 0°)	bet cor sec	d press the ween stite inpleted; presented; presented	"S" key to enter the hes in the first segress the " + + - e number of stitche	he setting, the gment. Press " key, the L es, repeat tin	ne liquidThe the corresp CD screen d nes and stitu	crystal screen display conding key below and displays n-01 02, pres ch length of the segment	ys "1 1 3.0" if the + # s the "S" ke ent, press t	At this ting the least to say to enter the corresp	me, you can set each pa the setting conding key
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+ # -	Stitches length setting		End back-tacking sewing
A-0	Pattern Backing-tacking Key	<b>‡ \"</b>	Needle stop position selection
	Beautiful seaming	<b>□</b>	Automatic presser foot lifting setting
Patt	Pattern Freedom Sewing Key		Free Sewing
35 ~ 354	Pattern Constant-Stitch Sewing Key	44	Consecutive reverse sewing
S	Speed increase	\$12	Slow launch setting
	Speed decrease	[71]	Manual Presser Foot Lifting Setting
+	Parameter increase/Parameter decrease	$\geq$	Multi-section Sewing
P	Function parameter edit	\$15	Auto Function
$\mathbb{S}^{\kappa_2}$	Confirm key	S8 S8	Thread trimming
141	Start back-tacking sewing	<u> ‡ </u>	Lift or fill up needle

and enter the monitoring mode. Press the corresponding plus and minus keys to

uispiay i	erated monitoring pa	rameters.	riess r wi	eturn to sewing mode	с.						
Serial number	name	Defaults	Serial number	name	Defaults	Serial number	name	Defaults	Serial number	name	Defaults
N01	Electronic control version serial number	7	N04	Foot pedal AD value	345	N07	Bus voltage AD value	630	N10	Scissor position sensing	0
N02	Selector box version number	6803	N05	Upper positioning angle	84	N08	Error code record	154	N12	Knee-sensory AD	500
N03	Sewing speed	0	N06	Lower positioning angle	1403	N09	operation hours	7	N13	Presser foot sensor AD	0

ter the debug mode. To exit from this mode to the normal mode, press the "P" to

Serial number	name	Defaults	Serial number	name	Defaults	Serial number	name	Defaults
72	Correction of needle position	84	92	Encoder starting angle		128	Scissor action test	

displayed number. Press the S key to save. To exit from this mode to normal

ays "92", press the plus and minus keys to switch to "72", press the S key to enter bel position changes and changes. Press the "S" key to save the current position exit into normal mode. 's "92", the button switches to "128", press the S button to enter the thread it angle (Cycle), if you want to return to normal mode from this mode, press P key

corresponding addition and subtraction modify the value below. If the password is

to save the factory parameters. Press and hold the " key for 5 seconds to

ess the +-key to switch the n1-n9 pattern, select the pattern number to be set, can set the number of stitches, the number of repetitions and the distance parameter value. Press the S key to save.P key to exit, a period of setting is ing, the LCD screen displays "1 1 3.0", at this time you can perform the key and 🕂 😃 – key to set each parameter value, press the "S" key to save, P 03, press the "S" key to enter the setting, the LCD screen displays "1 1 3.0", if ot be performed during sewing; the setting is completed Then press S to save

Long press	the Patt key to enter	, the interface displays	Press S to enter, the interface displays			Long press	the Patt key to enter	, the interface displays	Press S to enter, the interface displays			
Pattern number	N-01	01	1	1	3.0	Pattern number	N-01	02	1	1	3.0	
meaning	Pattern number	No. 1 first pattern	Contacts	repeat times	Stitch size	meaning	Pattern number	No. 1 first pattern	Contacts	repeat times	Stitch size	
the way	Add and subtract keys below	- <del></del>	Plus minus keys	Plus minus keys	+ # -	the way	Add and subtract keys below	1 <b>4</b> -	Plus minus keys	Plus minus keys	+ # -	

screen displays "n0", press the plus and minus keys to switch the n1-n9 cted pattern Perform sewing; when exiting the pattern sewing, adjust the

$\dashv$	6. Err	or Code List	
	Error Code	Problem	Status / Measurement
	E01	Over-voltage	Turn off the system power supply, and detect whether the supply voltage is correct. (Or exceed the rated voltage.) If correct, please replace the control box and inform the factory
$\dashv$	E02	Low-voltage	Turn off the system power supply, and detect whether the supply voltage is correct. (Or exceed the rated voltage specified in use.) If correct, please replace the control box and inform the factory
ıs)	E03	Abnormal transmission communication between the operation panel and the CPU	Turn off the system power and check whether the interface of the operation panel is loose. If the contact is good, replace the operation panel. If it is not the operation panel, the control box is damaged, please replace it.
	E05	Speed control unit connection is abnormal	Turn off the system power supply, please check the speed control unit connector if loose or fall off, Will resume normal after the restart system If you still can not work normally, please replace the speed control unit and notify the manufacturer.
	E07	Motor locked-rotor error b) The front head mechanism is deadlocked or the motor belt foreign body is caught and stuck. c) The workpiece is too thick and the motor torque is insufficient to penetrate. d) Module drive output is abnormal.	Turn the hand motor of the machine head to see if it is stuck. If it is stuck, first remove the machine head mechanical failure. If the rotation is normal, check whether the motor encoder connector and the motor power cable connector are loose. Please fix if loose. If the contact is good, check whether the power supply voltage is abnormal or the speed is set too high. If any, please adjust. If it is normal, please replace the control box and notify the manufacturer.
	E08	Abnormal function stepper motor	Check the value of N14 in the parameter of item P42, 0: communication abnormality, 2: reverse stitch step overcurrent 4: reverse stitch step cannot be found at startup Origin 16. Thread trimming step overcurrent 32: Thread trimming step cannot find the origin. Turn off the system power and observe whether the stepper motor is stuck. If it is stuck, first remove the machine head mechanical failure. If it is till does not work, please replace the control box and notify the manufacture. If it is normal, check whether the stepper motor interface is loose or falling off, and restore it to normal, then restart the system.
1	E10	Solenoid overcurrent protection	Turn off the power of the system and check whether the solenoid (solenoid valve) cable or solenoid (solenoid valve) is damaged.
	E09 E11	Abnormal positioning signal	Turn off the system power, check whether the motor encoder interface is loose or falling off, and restore it to normal, then restart the system. If it still does not work, please replace the motor and notify the manufacturer.
_	E13	Power module overheat protection	Turn off the system power and check whether the power module and heat sink are in good contact.
$\dashv$	E14	Encoder signal is abnormal	Turn off the system power, check whether the motor encoder interface is loose or falling off, and restore it to normal, then restart the system. If it still does not work, please replace the motor and notify the manufacturer.
	E15	Power module abnormal over-current protection	Turn off the system power, and then turn it on again. If it still does not work, please replace the control box and notify the manufacturer.
	E16	Abnormal deviation of thread trimming motor	Turn off the system power and check whether the thread trimming mechanism returns to the correct position; check whether the thread trimming setting is wrong.
$\dashv$	E17	The head protection switch is not in the correct position	Turn off the system power, check whether the machine head is opened, and whether the machine head switch is damaged.
$\dashv$	E20	Motor failed to start	Turn off the system power, check whether the motor encoder interface and motor power interface are loose or fall off, restore it to normal and restart the system. If it still does not work, please replace the control love and notify the regular terms of the system.

# 花样缝电脑平缝机

#### 1. 安全上的注意事项

使用前请详细阅读本技资料与所搭配的缝制机械说明书,配合正确使用。

- 1.1 (1) 电源电压与工作频率:请遵照马达与控制箱铭牌所标之规格。
  - (2) 电磁波干扰:请远离高频波机器或电波发射器等,以免所产生的电磁波干扰本驱动装置因而方式错误动作

内容值名称与备注

- (3)接地:为防止杂讯干扰或漏电事故,请做好接地工程(包括缝纫机、马达、控制箱、定位器)。
- 1.2 拆除马达或控制箱时,勿带电拔插;控制箱里面有危险高电压,所以关闭电源后等1分钟以上方可打开控制箱盖
- 1.3 为保证人身安全,请在维修机械或进行穿针作业时关闭电源。
- 1.4 这个标示符合表示机器安装时,如有错误恐会伤害到人体或机器会受到损坏。

所以机器方面有危险性的地方会有此标志。

容

这个标识符合表示有高压电等,电气方面有危险性的地方会有此标志。

调整范围

100-3700

初始值

3500 车缝时的最高转速设定

#### 2. 系统参数表

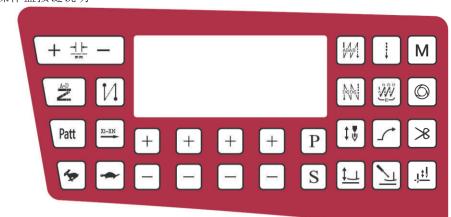
内

最高转速 (rpm)

参数项

	最高转速 (rpm)	100-3700	3500	车缝时的最高转速设定
P04	起始回缝速度 (rpm)	200-3200	2000	前段回缝(起始回缝)时的速度设定
P05	终止回缝速度 (rpm)	200-3200	2000	后段回缝(终止回缝)时的速度设定
P06	连续回缝速度(rpm)	200-3200	2000	连续回缝时的速度设定
P07	慢速起缝速度 (rpm)	200-1500	400	慢速起缝时的速度设定
P08	慢速起缝针数(针)	0-99	2	慢速起缝时的针数设定
P09	自动定针缝速度	200-3700	2500	定针缝自动触发功能打开的速度设定
P15	补针方式	0-4	2	0: 半针, 1: 一针, 2: 连续补半针, 3: 连续补一针, 4: 连续补针, 快速停车
P17	自动计件选择	0-1	0	0: P41项参数一针数递增自动计数 1: P41项参数不自动计数
P28	连续回缝运动模式选择	0-2	1	0: 人工,受踏板控制,可任意停止与启动 1: 自动,轻触踏板,自动执行回缝动作
P32	加固缝针迹补偿	0-200	167	2: 停顿
P35	抬压脚时松线出力功能设定	0-1	1	0: 抬压脚时松线出力功能关闭 1: 抬压脚时松线出力功能开启
P36	松线/大夹线器切换	0-1	1	0: 松线功能关闭,大夹线器功能开 1: 松线功能开启,大夹线器功能关(松线力度由P103调节)
P37	夹线器力道设置	0-11	3	0; 功能关闭 1: 拨线功能开启 2~11: 夹线功能开启,数值越大动作力度越大
P41	车缝完成件数显示	0-9999	0	
P49	剪线速度(rpm)	100-350	250	调整剪线周期时的电机速度
P53	半后踏抬压脚取消	ON/OFF	OFF	ON: 半后踏时无抬压脚 OFF: 半后踏时有抬压脚
P54	剪线动作时间(ms)	10-990	200	剪线时序的动作时间
P55	拨 / 扫线动作时间	10-990	380	拨 / 扫时序的动作时间
P58	上定位调整	0-1439	84	上定位调整,数值减少时会提前停针,数值增加时会延迟停针
P59	下定位调整	0-1439	752	下定位调整,数值减少时会提前停针,数值增加时会延迟停针
P60	测试速度 (spm)	100-3700	2000	测试功能的速度设置
P61	A项测试	OFF/ON	OFF	A项测试选项,设定后将按【P60.】所设定之
P62	B项测试	OFF/ON	OFF	B项测试选项,设定后将按【P60.】所设定之速度执行启动-车缝-停车-剪线的循环
P63	C项测试	OFF/ON	OFF	C项测试选项,设定后将按【P60.】所设定之速度执行无定位动能的启动-车缝-停车循环
P64	测试B、C导通时间	1-250	20	B、C项测试中,设置导通时间
P65	测试B、C停车时间	1-250	20	B、C项测试中,设置停车时间
P66	机头保护开关检测	0-2	0	0: 不检测; 1: 检测零信号; 2: 检测正信号
P68	车头最高速度限制	4000	3700	最高速度总限制
P72	上停针位校正	0-1439		调整上停针位,显示的数值会随手轮位置变化而变化,按"S"键保存当前位置(数值)为上停针位位置
P73	下停针位校正	0-1439		调整下停针位,显示的数值会随手轮位置变化而变化,按 "S"键保存当前位置(数值)为下停针位位置
P74	正缝针距补偿	0-100	50	
	倒缝针距补偿	0-100	50	
P75	MACHALIIA	0 100	30	
P75 P80	剪线第一次进刀角度	5-359	950	剪线第一次进刀角度(下定位为0°计算)
	127.2277727712			剪线第一次进刀角度(下定位为0°计算) 剪线第二次进刀角度(下定位为0°计算)
P80	剪线第一次进刀角度	5-359	950	
P80 P82	剪线第一次进刀角度 剪线第二次进刀角度	5-359	950	剪线第二次进刀角度(下定位为0°计算)
P80 P82 P92	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度	5-359 5-359	950 1412	剪线第二次进刀角度(下定位为0°计算)
P80 P82 P92 P101	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度	5–359 5–359 1–359	950 1412 30	剪线第二次进刀角度(下定位为0°计算)
P80 P82 P92 P101 P102	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度	5-359 5-359 1-359 1-359	950 1412 30 180	剪线第二次进刀角度(下定位为0°计算)
P80 P82 P92 P101 P102 P103 P112	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时	5-359 5-359 1-359 1-359 0-300 0-999	950 1412 30 180 3 100	剪线第二次进刀角度(下定位为0°计算)
P80 P82 P92 P101 P102 P103 P112 P113	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线动作时间	5-359 5-359 1-359 1-359 0-300 0-999	950 1412 30 180 3	剪线第二次进刀角度(下定位为0°计算)
P80 P82 P92 P101 P102 P103 P112 P113 P114	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线动作时间 无鸟巢钩线返程时间	5-359 5-359 1-359 1-359 0-300 0-999 0-990	950 1412 30 180 3 100 30 30	剪线第二次进刀角度(下定位为0°计算)
P80 P82 P92 P101 P102 P103 P112 P113 P114	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线动作时间 无鸟巢钩线返程时间 无鸟巢钩线运程时间	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990	950 1412 30 180 3 100 30 30 30	剪线第二次进刀角度(下定位为0°计算)
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线动作时间 无鸟巢钩线返程时间 无鸟巢钩线运程时间	5-359 5-359 1-359 0-300 0-999 0-990 0-990 0-100 0-5000	950 1412 30 180 3 100 30 30 30 1000	剪线第二次进刀角度(下定位为0°计算)
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线动作时间 无鸟巢钩线返程时间 无鸟巢钩线运程时间 无鸟巢钩线运程时间	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990	950 1412 30 180 3 100 30 30 30	剪线第二次进刀角度(下定位为0°计算)
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线或程时间 无鸟巢钩线返程时间 无鸟巢钩线运程时间 无鸟巢吹气时间 膝靠启动AD值 针距大小限制	5-359 5-359 1-359 0-300 0-999 0-990 0-990 0-100 0-5000	950 1412 30 180 3 100 30 30 30 1000	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线动作时间 无鸟巢钩线运程时间 无鸟巢钩线占空比 无鸟巢吸气时间 膝靠启动AD值 针距大小限制 剪线功能测试	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-100 0-5000 0-1023	950 1412 30 180 3 100 30 30 1000 600	剪线第二次进刀角度(下定位为0°计算)
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128 P129	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线动作时间 无鸟巢钩线远程时间 无鸟巢钩线运程时间 无鸟巢吸气时间 膝靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正	5-359 5-359 1-359 0-300 0-999 0-990 0-100 0-5000 0-1023	950 1412 30 180 3 100 30 30 1000 600	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128 P129	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线或作时间 无鸟巢钩线返程时间 无鸟巢吸气时间 膝靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正	5-359 5-359 1-359 0-300 0-999 0-990 0-100 0-1023 0-100 0-100 0-100	950 1412 30 180 3 100 30 30 1000 600 50	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128 P129 P130 P131	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线运程时间 无鸟巢钩线运程时间 无鸟巢吹气时间 膝靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正 压脚电机零点较正	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-100 0-1023 0-100 0-100 0-100 0-74	950 1412 30 180 3 100 30 30 1000 600 50 50 52	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128 P129	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线或作时间 无鸟巢钩线返程时间 无鸟巢吸气时间 膝靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正	5-359 5-359 1-359 0-300 0-999 0-990 0-100 0-1023 0-100 0-100 0-100	950 1412 30 180 3 100 30 30 1000 600 50	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128 P129 P130 P131 P131	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线运程时间 无鸟巢钩线运程时间 无鸟巢吸气时间 膝靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正 压脚电机零点较正 正常针距 加密针距	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-100 0-5000 0-1023  0-100 0-100 0-74 0-74	950 1412 30 180 3 100 30 30 30 1000 600 50 50 52 36 74	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128 P129 P130 P131	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线运程时间 无鸟巢钩线运程时间 无鸟巢切气时间 膝掌启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正 压脚电机零点较正 正常针距	5-359 5-359 1-359 0-300 0-999 0-990 0-100 0-1023 0-100 0-100 0-100 0-74	950 1412 30 180 3 100 30 30 1000 600 50 50 52 36	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128 P129 P130 P131 P131	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线前延时 无鸟巢钩线运程时间 无鸟巢钩线运程时间 无鸟巢吸气时间 膝靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正 压脚电机零点较正 正常针距 加密针距	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-100 0-5000 0-1023  0-100 0-100 0-74 0-74	950 1412 30 180 3 100 30 30 30 1000 600 50 50 52 36 74	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128 P129 P130 P131 P132 P133 P134	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线动作时间 无鸟巢钩线返程时间 无鸟巢钩线返程时间 无鸟巢吸气时间 膝靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正 压脚电机零点较正 正常针距 加密针距 加宽针距	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-1023 0-100 0-100 0-104 0-74 0-74 0-74	950 1412 30 180 3 100 30 30 1000 600 50 52 36 74 145	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128 P129 P130 P131 P132 P133 P134 P136	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线动作时间 无鸟巢钩线远程时间 无鸟巢钩线运程时间 无鸟巢钩线占空比 无鸟巢吸气时间 膝靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正 压脚电机零点较正 正常针距 加密针距 加宽针距	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-100 0-1023 0-100 0-100 0-74 0-74 0-74 0-200 0-150	950 1412 30 180 3 100 30 30 1000 600 50 50 52 36 74 145	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128 P129 P130 P131 P131 P132 P133 P134 P136 P137	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线动作时间 无鸟巢钩线达吞空比 无鸟巢钩线适空比 无鸟巢吸气时间 膝靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正 压脚电机零点较正 正常针距 加密针距 加宽针距 最高压脚的度 最高压脚的度	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-100 0-5000 0-1023  0-100 0-74 0-74 0-74 0-200 0-150 0-200	950 1412 30 180 3 100 30 30 1000 600 50 52 36 74 145 145 110	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P113 P114 P115 P116 P122 P123 P128 P129 P130 P131 P131 P132 P133 P134 P136 P137 P141	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线开始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线动作时间 无鸟巢钩线返程时间 无鸟巢钩线返程时间 无鸟巢吸气时间 膝靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正 压脚电机零点较正 正常针距 加宽针距 加宽针距 加宽针距 第二次剪线距离 最高压脚的线距离	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-1023 0-100 0-100 0-74 0-74 0-74 0-200 0-150 0-200 20-400	950 1412 30 180 3 100 30 30 1000 600 50 52 36 74 145 145 110 200	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P114 P115 P116 P122 P123 P128 P129 P130 P131 P132 P134 P136 P137 P141	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线纤束角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线动作时间 无鸟巢钩线边程时间 无鸟巢钩线近径时间 形鸟巢顿的线近程时间 聚靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正 压常针距 加宽针距 加宽针距 最高压脚电距 第二次的更高度 第一次的变变 切线速度1	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-1023 0-100 0-100 0-74 0-74 0-74 0-200 0-150 0-200 20-400	950 1412 30 180 3 100 30 30 1000 600 50 52 36 74 145 145 110 200 150	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P122 P123 P128 P129 P130 P131 P132 P134 P136 P137 P141 P142 P146 P149	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线线动作时间 无鸟巢钩线线占空比 无鸟巢钩线线占空比 无鸟巢切代时间 膝靠启动AD值 针距大小限制 剪线功能测试 倒缝电机零点较正 压脚电机零点较正 压常针距 加密针距 加宽针距 为高压脚剪线距离 最高压脚剪线速度2 切线速度2 切线速度1 抬压脚速度	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-5000 0-1023	950 1412 30 180 3 100 30 30 1000 600 50 52 36 74 145 145 110 200 150 200	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P130 P130 P131 P132 P134 P136 P137 P141 P142 P149 P149 P150	剪线第一次进刀角度 剪线第二次进刀角度 编码器起始角度 松线结束角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线线动作时间 无鸟巢钩线返程时间 无鸟巢倾气时间 膝靠启动AD值 针距大小限制 剪线由机零点较正 压脚电机零点较正 压常针距 加密针距 加密针距 第二次剪线距离 最高压脚或的 最高度 第一次或度2 切线速度1 抬压脚速度	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-5000 0-1023	950 1412 30 180 3 100 30 30 1000 600 50 52 36 74 145 110 200 150 200 6 8	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P130 P130 P131 P134 P136 P137 P141 P142 P146 P149 P150 P151	剪线第一次进刀角度 剪线第三次进刀角度 编码器起始角度 松线结束角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线线动作时间 无鸟巢钩线线适程时间 无鸟巢等的线返程时间 形鸟巢吸气时间 膝靠启动AD值 针距大小限制 剪线电机零点较正 压脚电机零点较正 压常针距 加宽针距 加宽针距 第二次的高度 第一次的高度 第一次度2 切线速度1 拍压脚的保持电流 电机1的最大电流	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-1023 0-100 0-100 0-100 0-74 0-74 0-74 0-200 0-150 0-200 20-400 20-400 20-250 1-12 1-12	950 1412 30 180 3 100 30 30 1000 600 50 52 36 74 145 110 200 150 200 6 8 12	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P114 P115 P116 P122 P123 P128 P129 P130 P131 P136 P137 P141 P142 P146 P149 P150 P151	剪线第一次进刀角度 剪线第二次进刀角度 编码器是如角度 松线结束角度 大夹线器起夹电流 无鸟巢钩线动作时间 无鸟巢钩线动作时间 无鸟巢钩线适程时间 无鸟巢钩线适程时间 形。	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-5000 0-1023	950 1412 30 180 3 100 30 30 1000 600 50 50 52 36 74 145 110 200 150 200 6 8 12	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P116 P122 P123 P128 P129 P130 P131 P131 P132 P134 P136 P137 P141 P142 P146 P149 P150 P151 P152	剪线第一次进刀角度 剪线第三次进刀角度 编码器是如角度 松线结果起来电流 无鸟巢钩线线远程时时 无鸟巢钩线线远程时时 无鸟巢钩线线适空比 无鸟巢钩的线线适空比 无鸟巢等的线点空比 无鸟巢域的线点空比 无鸟巢域的线点空比 无鸟巢域的线点空比 无鸟巢域域的侧侧 脚瓣成侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧侧	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-5000 0-1023	950 1412 30 180 3 100 30 30 1000 600 50 52 36 74 145 110 200 150 200 6 8 12 8	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P122 P123 P128 P129 P130 P131 P132 P134 P136 P137 P141 P142 P146 P149 P150 P151 P152 P153	剪线第一次进刀角度 剪线第三次进刀角度 编码器是始角度 松线结束角度 大夹线额 钩线动作时间 无鸟巢钩线线远程时间 无鸟巢领的线近右时间 无鸟巢领的线近右时间 无鸟巢域的线近右时间 形。	5-359 5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-1023	950 1412 30 180 3 100 30 30 1000 600 50 52 36 74 145 110 200 6 8 12 8 25 500	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改  剪线测试,按一下剪刀剪键即可执行测试过程(剪线会有两次动作)
P80 P82 P92 P101 P102 P103 P113 P114 P115 P116 P122 P123 P128 P129 P130 P131 P134 P136 P137 P141 P142 P146 P149 P150 P151 P152 P153 P154	剪线第一次进刀角度 剪线第三次进刀角度 编码器是如角度 松线结果和度 大夹线等的线动作时间 无鸟巢镇钩线动作时间 无鸟巢领约线方间 医鼻头吸气时间 医鼻头吸气时间 医鼻头吸气时间 医鼻头吸气时间 医鼻鼻吸气时间 医鼻鼻吸气时间 医鼻肿电机零点较正 正常针距 加宽针距 医甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-1023	950 1412 30 180 3 100 30 30 1000 600 50 50 52 36 74 145 110 200 6 8 12 8 25 500 0	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改  剪线测试,按一下剪刀剪键即可执行测试过程(剪线会有两次动作)  0:补针功能; 1:密缝功能
P80 P82 P92 P101 P102 P103 P112 P113 P114 P115 P122 P123 P128 P129 P130 P131 P132 P134 P136 P137 P141 P142 P146 P149 P150 P151 P152 P153	剪线第一次进刀角度 剪线第三次进刀角度 编码器上的角度 松线结器上的通应 无鸟巢钩线线对作时间 无鸟巢钩线线对作时间 无鸟巢钩线线点空比 无鸟巢钩线线点空比 无鸟巢的线点可间 膝靠启动AD值 针距大小的侧侧或 倒缝电机零点较正 压脚电机零点较正 压脚常针距 加宽针距 加宽针距 加宽针距 加宽针距 切线速度 切线速度 切线速度 切线速度 切线速度 切线速度 切线速度 电机1的保持电流 电机1的保持电流 电机1的最大电流 电机2的最大电流 电机2的特距 漂亮缝速度 机头静距	5-359 5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-5000 0-1023	950 1412 30 180 3 100 30 30 1000 600 50 52 36 74 145 110 200 6 8 12 8 25 500 0	剪线第二次进刀角度(下定位为0° 计算) 读取编码器起始角度,出厂已设置,请勿随意更改 剪线测试,按一下剪刀剪键即可执行测试过程(剪线会有两次动作) 0: 补针功能; 1; 密缝功能 0为正方向 1为负方向0为正方向 1为负方向
P80 P82 P92 P101 P102 P103 P113 P114 P115 P116 P122 P123 P123 P128 P129 P130 P131 P134 P136 P137 P141 P142 P146 P149 P150 P151 P152 P153 P154	剪线第一次进刀角度 剪线第三次进刀角度 编码器是如角度 松线结果和度 大夹线等的线动作时间 无鸟巢镇钩线动作时间 无鸟巢领约线方间 医鼻头吸气时间 医鼻头吸气时间 医鼻头吸气时间 医鼻头吸气时间 医鼻鼻吸气时间 医鼻鼻吸气时间 医鼻肿电机零点较正 正常针距 加宽针距 医甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲甲	5-359 5-359 1-359 1-359 0-300 0-999 0-990 0-990 0-100 0-1023	950 1412 30 180 3 100 30 30 1000 600 50 50 52 36 74 145 110 200 6 8 12 8 25 500 0	剪线第二次进刀角度(下定位为0°计算) 读取编码器起始角度,出厂已设置,请勿随意更改  剪线测试,按一下剪刀剪键即可执行测试过程(剪线会有两次动作)  0:补针功能; 1:密缝功能

### 3. 操作盒按键说明



+ # -	针距大小调节键	M	后固缝按键
A~D	固缝花样按键	<b>‡</b>	停针位选择
N	漂亮缝纫设定按键	<b>□</b>	剪线抬压脚按键
Patt	花样编辑按键		自由缝模式按键
20 104	段式缝花样自编模式按键		W固缝模式按键
B	电机运行速度调节 (快)	512	软启动按键
<b>€</b>	电机运行速度调节 (慢)	71	手动抬压脚键
4	加减键		调试功能按键
P	功能键	S15	触发键
$\mathbb{S}^{\kappa_2}$	确定键	<b>3</b>	剪线设定键
141	前固缝按键	<u> ‡ </u>	补针键

#### 4. 监控模式

正常情况下,按"P"键,将参数调整到42,按"S"确认,进入到监控模式。按下方相对应的加减键显示相关的监控参数。按P键返回到缝纫模式。

显示	序号	项目名称	默认值	显示序号	项目名称	默认值	显示序号	项目名称	默认值	显示序号	项目名称	默认值
N	01	电控版本序列号	7	N04	脚踏板AD数值	345	N07	母线电压AD数值	630	N10	剪刀位置感应	0
N	02	选针盒版本号	6803	N05	上定位角度	84	N08	错误代码记录	154	N12	膝靠感应AD	500
N	03	车缝速度	0	N06	下定位角度	1403	N09	运行时间	7	N13	压脚感应AD	0

### 5. 模式设置

5.1. 调试模式: 正常进入缝纫模式后长按 "M"键3秒,进入到调试模式,若要从该模式退回到正常模式,需按键 "P"退出进入正常模式

显示序号	项目名称	默认值	显示序号	项目名称	默认值	显示序号	项目名称	默认值
72	上停针位较正	84	92	编码器起始角度		128	剪刀动作测试	

正常进入缝纫模式后长按"M"键3秒,液晶屏显示"92",按S键进入电机角度测试界面,按"旦"键,电机会转动几下,之后液晶屏显示角度数字,代表电机光栅片的安装角度为显示的数字,按S键保存。若要从该模式退回到正常模式,按"P"键退出进入正常模式正常进入缝纫模式后长按"M"键3秒,液晶屏显示"92",按下方加减键切换到"72"按S键进入机械零位调整界面,转动手轮,显示的数值会随手轮位置变化而变化,按"S"键保存当前位置(数值)为上停针位位置。若要从该模式退回到正常模式,按"P"键退出进

入正常模式。 正常进入缝纫模式后长按"M"键3秒,液晶屏显示"92",按键切换到"128"按S键进入剪线动作测试界面,再按"<sup>268</sup>",剪刀会 按照想对应角度动作一次(循环),若要从该模式退回到正常模式,按P键退出进入正常模式。

5.2. 密码模式:长按"P"键进入密码模式,液晶显示0000,按下方对应的加减修改数值,若密码正确,按"S"键后,可查看高级参数。

5.3. 保存出厂参数和恢复出厂参数:长按"厂"键5秒,保存出厂参数完成。长按"厂"键5秒,恢复出厂参数完成。

5.4. 花样缝编辑: 正常进入缝纫模型

J	长按	Patt键进入,界间	<b></b> 面显示	按S键进	入,界面显	下	长接	Patt键进入,界	11显示	按S键进	入,界面显为	17
l	花样编号	N-01	01	1	1	3. 0	花样编号	N-01	02	1	1	3.0
1	含义	花样号	1号第一段花样	针数	重复次数	针距大小	含义	花样号	1号第二段花样	针数	重复次数	针距大小
1	编辑方式	下方加减键	- 4-	下方加减键	下方加减键	+ # -	编辑方式	下方加减键	+ # -	下方加减键	下方加减键	+ # -

5.5. 花样缝纫方法; 正常进入缝纫模式后按 " [ Past ] "键, 液晶屏显示 "n0", 按下方加减键切换n1-n9花样, 选定要缝纫的花样号后按 "S"键确认,此时按选定的花样进行缝纫; 退出花样缝时,将参数调整到 "n0",按 "S"键确认,P键退出进入

## 6. 错误代码表

错误码	内 容	对 策
E01	1. 电源ON时,主电压检测过高 2. 供应电源电压过高时	关闭系统电源,检测供应电源电压是否正确。(或是否超过使用规定的额定电压)。 若正确,请更换控制箱并通知厂方。
E02	1. 电源ON时,主电压检测过低 2. 供应电源电压过低时	关闭系统电源,检测供应电源电压是否正确。(或是否低于使用规定的额定电压)。 若正确,请更换控制箱并通知厂方。
E03	操作面板与CPU传输通信异常	关闭系统电源,检查操作面板接口是否松动。如接触良好,请更换操作面板。 如不是操作面板,则为控制箱损坏,请更换。
E05	控速器接触异常	关闭系统电源,检查控速器接头是否松动或脱落,将其恢复正常后重启系统。 若仍不能正常工作,请更换控速器并通知厂方。
E07	a) 马达插头配线接触不良导致不转。 b) 车头机构死锁或马达皮带异物卷入卡死。 c) 加工物过厚,马达扭力不足无法贯穿。 d) 模块驱动出力异常。	转动机头电机手轮观察是否卡住。如卡住则先排除机头机械故障。 如转动正常,检查电机编码器接头和电机电源线接头是否松动。如有松动请修正。 如接触良好,检查供应电源电压是否异常或转速设置过高。如有请调整。 如正常,请更换控制箱并通知厂方。
E08	功能步进电机异常	查看P42项参数里N14的数值,0;通信异常,2;倒缝步进过流4;倒缝步进开机找不到原点16;剪线步进过流32;剪线步进找不到原点 关闭系统电源,观察步进电机是否卡住。如卡住则先排除机头机械故障。 如正常,,检查步进电机接口是否松动或脱落,将其恢复正常后重启系统。 若仍不能正常工作,请更换控制箱并通知厂方。
E10	电磁铁过流保护	关闭系统电源,检查电磁铁(电磁阀)连接线或电磁铁(电磁阀)是否损坏。
E09 E11	定位信号异常	关闭系统电源,检查电机编码器接口是否松动或脱落,将其恢复正常后重启系统。 若仍不能正常工作,请更换电机并通知厂方。
E13	电力模块过热保护	关闭系统电源,检查电力模块与散热片是否接触良好。
E14	编码器信号异常	关闭系统电源,检查电机编码器接口是否松动或脱落,将其恢复正常后重启系统。 若仍不能正常工作,请更换电机并通知厂方。
E15	电力模块不正常过流保护	关闭系统电源,再重新开启。若仍不能正常工作,请更换控制箱并通知厂方。
E16	剪线电机偏差异常	关闭系统电源,检查剪线机构是否回到正确位置;检查剪线的设置是否错误。
E17	机头保护开关没到正确位置	关闭系统电源,检查机头是否掀开,机头开关是否损坏。
E20	开机电机启动失败	关闭系统电源,检查电机编码器接口和电机电源接口是否松动或脱落,将其恢复正常 后重启系统。若仍不能正常工作,请更换控制箱并通知厂方。