

- 1) 在安装或使用本产品时，使用者必须彻底并仔细研读本操作手册。
When installing or using this product, the user must thoroughly and carefully read the manual.
- 2) 所有标上符号之指示，必须特别注意或执行，否则可能会导致身体伤害。
All instructions/symbols must be given special attention or execution, otherwise it may cause physical injury.
- 3) 本产品须由受过正确训练的人员来安装或操作。
This product must be installed or operated by properly trained personnel.
- 4) 为安全起见，禁止以延长线作电源座供应二项以上的电器产品使用。
For the sake of safety, it is forbidden to supply two or more electrical appliances with extension cord.
- 5) 当连接电源线到电源座时，必须确定此电压低于 AC 250V，且符合标在马达铭牌上的指定电压。
When connecting the power cord to the power base, it must be determined that the voltage is lower than AC 250V and that the specified voltage is specified on the motor nameplate.
※注意：电控箱电源规格如为 AC220V 时，请勿插接至 AC380V 的电源插座上，否则将出现异常且电机将无法动作。此时请立即关闭电源开关，重新检查电源。持续供应 380V 超过五分钟以上，将可能烧损电控箱上的保险丝 F2、电解电容（C58、C59）及电源模块 U14，而危及人身安全。
Note: if the power supply specification of the electric control box is AC220V, please do not plug it into the power socket of AC380V, otherwise it will be abnormal and the motor will not be able to move. Turn off the power switch immediately and recheck the power. Continuous supply of 380V for more than five minutes will likely damage the fuse F2, electrolytic capacitor (C58, C59) and power module U14, and endanger the safety of the person.
- 6) 请不要在日光直接照射的场所、室外及室温 45℃ 以上或 5℃ 以下的场所操作。
Please do not operate in direct sunlight place, outdoor and room temperature above 45 °C or below the 5 °C site .
- 7) 请不要在暖气（电热器）旁、有露水的场所及在相对湿度 30% 以下或 95% 以上的场所操作。
Please do not operate in places where the heating (electric heater) is nearby, where there is dew, or where the relative humidity is below 30% or above 95%.
- 8) 请不要在灰尘多的场所、具有腐蚀性物质的场所及有挥发性气体的场所操作。
please do not operate in dusty places, places with corrosive substances or places with volatile gases.
- 9) 请注意电源线不要受压或过度扭曲。
Please note that the power cord should not be subjected to pressure or excessive distortion.
- 10) 电源线的接地线须以适当大小的导线和接头连接到生产工厂的系统地线，此连接必须被永久固。
The grounding wire of the power cord shall be connected to the system ground wire of the production plant with a suitable size of wire and joint. This connection must be permanently fixed
- 11) 所有可转动的部分，必须以所提供的零件加以防范露出。
All rotatable parts must be guarded against the supplied parts.
- 12) 在第一次开机后，先以低速操作缝纫机并检查转动方向是否正确
After the first charge, operate the sewing machine at a low speed and check if the rotation

direction is correct.

13) 在操作以下动作前, 请先关闭电源?:

Before operating the following actions, turn off the power:

1. 在控制箱与马达上插或拔任何连接插头时。Insert or unplug any connection plug between the control box and the motor.

2. 穿针线时。 When Wearing a needle and thread

3. 翻抬车头时。 When turn up machine head

4. 修理或作任何机械上的调整时。 When adjust or repair machine

5. 机器休息不用时。 When machine rests

14) 修理或高层次的保养工作, 仅能由受过适当训练的机电技师来执行。

Repair or high level maintenance work performed only by properly trained electromechanical technicians.

15) 所有维修用的零件, 须由本公司提供认可, 方可使用。

15) All repair parts must be approved by the company before use.

16) 请不要以不当物体来敲击或撞击本产品及各装置。

保修期限

本产品保修期限为购买日期起一年内或出厂月份起两年内。

保修内容

Please do not knock or impact this product and devices with inappropriate objects. Warranty period of this product is within one year from the purchase date or in the factory within two years.

The content of the warranty

本产品在日常情况且无人失误的操作下, 于保修期间无偿的为客户维修使能正常操作。

但以下情况于保修期间将收取维修费用:

This product is in normal condition and without human error operation, during the warranty period free of charge for customer maintenance to be able to operate normally. The maintenance fee will be charged during the warranty period:

1. 不当使用包括误接高压电源、将产品移做其它用途、自行拆卸、维修、更改、或不依规格范围使用、进水进油及插入异物于本产品。

1. Improper use of the products shall include the misuse of the high voltage power supply, the removal of the product for other purposes, self-disassembly, maintenance, change, or the use of the product without the scope of specification, water inlet and insert foreign material.

2. 火灾、地震、闪电、风灾、水灾、盐蚀、潮湿、异常电压及其它天灾或不当场所造成的损害。

2. Damage caused by fire, earthquake, lightning, wind, flood, salt erosion, humidity, abnormal voltage and other natural disasters or inappropriate sites.

3. 客户购买后摔落本产品, 或客户自行运输 (或托付运输公司) 造成的损害。

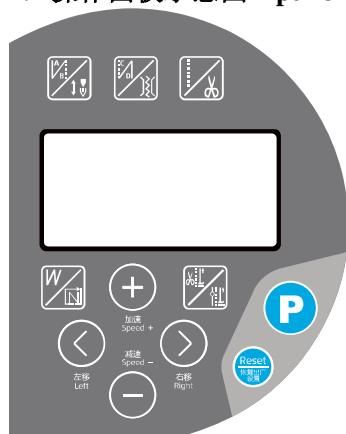
3. After customers buy this product, or customers to transport (or entrust the transport company) damage.

* 本产品在生产及测试上皆尽最大努力和严格控制使其达到高品质及高稳定的标准, 但外部的电磁或静电干扰或不稳定的供应电源, 仍可能对本产品造成影响或损害, 因此操作场所的接地系统一定要确实做好, 并建议用户安装故障安全防护装置 (如漏电保护器)

This product on the production and test all try our best and strict control to the standard of high quality and high stability, but external electromagnetic or electrostatic interference or unstable power supply, may affect or damage caused by our product, therefore the operation place of grounding system must do well, and suggested the user install fail safe protection devices (such as leakage protector)

1 按键显示及操作说明

1.1 操作面板示意图 panel introduction



1.2 按键说明 key introduction

名称 model	按键 key	注明 introduction
进入参数区功能键 Enter parameter key		1、一般模式下，长按 P 键进入用户参数设置模式； 2、在关机状态，按住 P 开机进入技术员参数模式； 3、对所选参数号内容进行查看和保存：选择好参数号后按此键可以进行查看和修改操作，修改参数值后按此键则退出并保存参数 1.After open machine, press P key long time to enter Users parameter mode 2.when machine off ,press P and turn on the machine to enter technician parameter mode. 3.check all the parameters context and save value, after choose one parameter, press this key to read and modify, after modify press this key exit and save the value
恢复出厂设置键 Factory reset		长按 3S 后恢复出厂设置 Press 3 seconds then back to factory reset
左移键 Left move key		向左选择内容参数 Move to left choose the parameters
右移键 Right move key		向右选择内容参数 Move to right choose parameters
速度加 Speed up key		1、若点击，增大当前运行速度； 2、参数内容区内当设定数值递增键 1.press it to increase the current speed 2.Increase all the parameter value
速度减 Speed down key		1、若点击，减小当前运行速度； 2、参数内容区内当设定数值递减键 1. Press it to reduce the current speed 2. Decrease all the parameter value
起始回缝键、上下停针位键 Start back tacking/needle position key		1、若点击，切换起始回缝（A、B 段）1 次、起始回缝（A、B 段）2 次或关闭； 2、若长按，切换缝制后机针的停止位置（上停针位/下停针位）。

		1. press it to set the start back-tacking 1time,2 times or off 2. press it long time, change the needle position (up needle position/down needle position)
终止回缝键、夹线功能键 End bar-tacking/nipper key		1、若点击，切换终止回缝（C、D 段）1 次、起始回缝（C、D 段）2 次或关闭； 2、若长按，切换自动夹线动作（有（相应图标亮）/无（相应图标灭））。 1. press it to set end back-tacking 1 time,2 times or off 2. press it long time,turn on nipper (with the mark on panel)or off(without the mark on panel)
自由缝键、剪线功能键 Free sewing/trimmer key		1、默认自由缝模式打开，一旦踏板往前踏下就正常车缝，当踏板回到中立时，立即停止车缝； 2、若长按，切换自动剪线动作（有（相应图标亮）/无（相应图标灭））。 1. free sewing is open by default setting, when press the pedal machine work, when pedal back to middle, stop sewing immediately. 2. If press it long time, turn on (with mark on panel)trimmer or off(without mark on panel)
连续回缝（W 缝）键、多段定针缝键 W sewing /multi-stitches sewing		1、若点击，切换为连续回缝（W 缝）模式； 2、若长按，切换为多段定针缝模式。 1. press it change to W sewing mode 2. press it long time, change it to multi-stitches sewing mode
剪线后自动抬压脚键、中途停车自动抬压脚键 Footer lift after trimmer/footer lift in middle sewing		1、若点击，切换剪线后自动抬压脚动作（有（相应图标亮）/无（相应图标灭））； 2、若长按，切换中途停车自动抬压脚动作（有（相应图标亮）/无（相应图标灭））。 1.press it to turn on footer lifter after trimmer(with the mark on panel) or off(without mark on panel) 2.press it long time,turn on footer lift in middle sewing(with the mark on panel) or turn off(without the mark on panel)

2 参数表 parameter sheet

参数项 number	中文说明 Chinese meaning	范围 Range	初始值 Default value	内容值名称说明与备注 Explanation
P01	最高转速（r/S） max speed	100-3500	2000	车缝时的最高转速设定 the maximum speed during sewing
P02	加速曲线调整（%） Speed curvilinear path adjust	10-100	80	控速器爬升斜率设定 斜率值愈大，速度愈陡；斜率值愈小，速度愈慢 Speed control slope setting Slope value bigger, speed faster, slope value smaller, speed slower
P03	针停定位选择 Needle position	UP/DN	DN	UP: 上停针 up needle position DN: 下停针 down needle position
P04	起始回缝速度（r/S）	200-3200	1000	前段回缝（起始回缝）时的速度设定

参数项 number	中文说明 Chinese meaning	范围 Range	初始值 Default value	内容值名称说明与备注 Explanation
	Start back tacking speed			Set the start bac –tacking sewing speed
P05	终止回缝速度 (r/S) End back-tacking speed	200-3200	1000	后段回缝 (终止回缝) 时的速度设定 Set the end bac-tacking sewing speed
P06	连续回缝速度 (r/S) Multi stitches sewing speed	200-3200	1000	连续回缝时的速度设定 Set Multi sewing speed
P07	慢速起缝速度 (r/S) Slow start sewing speed	200-1500	400	慢速起缝时的速度设定 Set slow start sewing speed
P08	慢速起缝针数 (针) Stitches	0-99	2	慢速起缝时的针数设定, 每一单位代表半针 Set the stitches, every unit means half stitch
P09	自动定针缝速度 (r/S) Automatic multi stitch sewing	200-4000	2000	定针缝【P34.SMP】设定在 A 状态的速度设定 (或选针盒 AUTO 键有按下时的速度设定) Under A situation set the speed
P10	定针缝后自动执行终止回缝功能 (不补针功能设定) After multi stitch sewing, stop add stitches function	ON/OFF	ON	ON: 在执行完最后一段定针缝后, 将自动执行终止回缝动作。After the last stitch, stop add stitch automatically 注: 亦即在任何缝制模式下, 不能作补针功能。 OFF: 在执行完最后一段定针缝后, 将无法自动执行终止回缝功能, 必须重新再作前或全后踏动作时可。 After the last stitch, continue add stitches, must press pedal backward to stop
P11	手按回缝时功能模式选择 Munal back sewing mode	J/B	J	手按车头回缝开关动作时机: press the back sewing holder J: JUKI 方式 (在车缝中或中途停止时具有动作 during sewing or stop in the middle have action) B: BROTHER 方式 (在车缝中始有动作 during sewing has action)
P12	起始回缝运动模式选择 Start back sewing mode	0-1	1	起始回缝段, 倒退电磁线圈动作时机: 0: 受踏板控制, 可任意停止与启动; 1: 轻触踏板, 自动执行回缝动作 ; Start back tacking solenoid action time 0:control by pedal, can stop and start easy 1:press pedal, automatic back sewing
P13	起始回缝结束点操作模式选择 Operation mode choose after back sewing	CON/STP	CON	CON: 起始回缝段完成后, 自动连续下一段功能 After start back sewing, continue to next function STP: 起始回缝段针数完成后自动停止 After finish the start back sewing stitches, then stop
P14	慢速启动 Slow speed start	ON/OFF	ON	ON: 慢速启动功能开启 Function open OFF: 慢速启动功能关闭 Function off
P15	补针方式 Add stitches mode	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 0:half stitch 1:1stitch 2:continue half stitch 3:continue 1 stitch 4:continue half stitch, then stop
P18	起始回缝补偿 1 Start back sewing compensation 1	0-200	164	起始回缝 A 段针迹补偿, 0~200 动作逐步滞后; 数值越大, A 短最后一针越长, B 段第一针越短 After A period, 0~200 means speed slowly gradually, value bigger, the last stitch of A is longer, the first stitch of B is shorter

参数项 number	中文说明 Chinese meaning	范围 Range	初始值 Default value	内容值名称说明与备注 Explanation
P19	起始回缝补偿 2 Start back sewing compensation 2	0-200	151	起始回缝 B 段针迹补偿, 0~200 动作逐步滞后; 数值越大, B 段最后一针越长 After B period, 0-200 means speed slowly gradually, value bigger, the last stitch of B is longer
P20	终止回缝运动模式选择 End back sewing mode	0-2	1	终止回缝段, 倒退电磁线圈动作时机: 0: 受踏板控制, 可任意停止与启动; 1: 轻触踏板, 自动执行回缝动作; 2: 停顿模式 End back sewing solenoid action time 0: control by pedal, can stop and start easy 1: press pedal, automatic back sewing 2: pause mode
P21	脚踏板前踏点电压 Press pedal forward voltage	30-1000	520	
P22	脚踏板中踏点电压 Press pedal middle voltage	30-1000	480	
P23	脚踏板半反踏点电压 Press pedal half backward voltage	30-1000	240	
P24	脚踏板反踏点电压 Press pedal backward voltage	30-1000	110	
P25	终止回缝补偿 3 End back sewing compensation 3	0-200	165	终止回缝 C 段针迹补偿, 0~200 动作逐步滞后; 数值越大, C 段第一针越短 After C period, 0-200 means speed slowly gradually, value bigger, the last stitch of C is shorter
P26	终止回缝补偿 4 End back sewing compensation 4	0-200	151	终止回缝 D 段针迹补偿, 0~200 动作逐步滞后; 数值越大, C 段最后一针越长, D 段第一针越短 After D period, 0-200 means speed slowly gradually, value bigger, the last stitch of C is longer, the first stitch of D is shorter
P28	连续回缝运动模式选择 Continuous back sewing mode	0-2	1	连续回缝段, 倒退电磁线圈动作时机: 0: 受踏板控制, 可任意停止与启动; 1: 轻触踏板, 自动执行回缝动作 ; 2: 停顿模式 Continuous back sewing solenoid action time 0: control by pedal, can stop and start easy 1: press pedal, automatic back sewing 2: pause mode
P29	切线后刹车力度 Braking force after trimmer	1-45	23	
P30	厚料加力 Add power for thick fabric	0-100	10	数值越大力度越大, 调整过大可能会引起电机异常。 Value bigger, more power, too big value may make motor abnormal.
P31	剪线加力 Add power for trimmer	0-100	40	数值越大力度越大, 调整过大可能会引起电机异常。 Value bigger, more power, too big value may make motor abnormal.

参数项 number	中文说明 Chinese meaning	范围 Range	初始值 Default value	内容值名称说明与备注 Explanation
P32	连续回缝补偿 5 Continuous back sewing compensation 5	0-200	164	起始回缝 A (C) 段针迹补偿, 0~200 动作逐步滞后; 数值越大, A (C) 段最后一针越长; B (D) 段第一针越短 After AⓈ period, 0-200 means speed slowly gradually, value bigger, the last stitch of A(C) is longer, the first stitch of B(D) is shorter
P33	连续回缝补偿 6 Continuous back sewing compensation 6	0-200	161	起始回缝 B (D) 段针迹补偿, 0~200 动作逐步滞后; 数值越大, B (D) 段最后一针越长, C 段第一针越短 After B(D) period, 0-200 means speed slowly gradually, value bigger, the last stitch of B(D) is longer, the first stitch of C is shorter
P34	定针缝运动模式选择 Multi stitches sewing mode	A/M	A	A: 轻触脚踏板, 即自动执行定针缝动作 M: 受脚踏板控制, 可任意停止与启动 A: press pedal, automatic enter multi stitches sewing M: control by pedal, can stop and start easy
P35	计件数模式选择 Counter mode	0-1	0	0: 手动计件数 1: 自动计件数 0:manual counter 1:automatic counter
P37	拨线出力功能设定 (夹线器力道设置) Nipper power setting	0-11	8	0: 无动作; 1 为拨线动作 2~11 夹线动作, 动作力度逐步变大 0:no action 1:spreading function 2~11:clamp thread, power stronger step by step
P38	切线出力功能设定 Trimmer power setting	ON/OFF	ON	ON: 有切线动作 OFF: 无切线动作 ON: trimmer OFF: no trimmer
P39	车缝途中停止时, 压脚出力选择 Footer lift power mode when stop sewing before trimmer	UP/DN	DN	同按键面板上之快速功能 UP: 车缝停止时, 自动抬起压脚 DN: 车缝停止时, 无自动抬压脚 (由踏板后踏控制) Same as panel button function UP: when stop sewing, footer lift DN: when stop sewing, No footer lift(control by pedal)
P40	切完线停止时, 压脚出力选择 Footer lift power after trimmer	UP/DN	DN	同按键面板上之快速功能键 UP: 切完线后, 自动抬起压脚 DN: 车切完线后, 无自动抬压脚 (由踏板后踏控制) Same as panel button function UP: after trimmer, footer lift DN: after trimmer, No footer lift(control by pedal)
P41	车缝完成件数显示 Pieces display		0	车缝完成件数显示; 长按减号键可进行计数清零; Display the fabric pieces, press mins key long time can clear value to 0
P42	信息显示 Information display		N-01	N01 电控版本号序列号 N02 选针盒版本号 N03 转速 N04 脚踏板 AD N05 上定位角度 N06 下定位角度 N07 母线电压 AD N01:control box version series No N02:panel version No N03:speed N04:pedal AD N05:up needle position angle

参数项 number	中文说明 Chinese meaning	范围 Range	初始值 Default value	内容值名称说明与备注 Explanation
				N06:down needle position angle N07:wire voltage AD
P43	马达转动方向设定（正反转） Motor rotate direction setting	CCW/CW	CCW	CW: 顺时针方向 CCW: 逆时针方向 CW: clock direction CCW: anti-clock direction
P44	刹车力度 Braking force	1-45	18	机器停车时的力度选择。 When machine stop, the force choose
P45	回缝出力的周期信号（%） Frequency signal for back sewing power	10-50	30	回缝动作时，以周期性省电输出 When back sewing, frequency output save electricity
P46	切线后，反转提针角度的功能选择 After trimmer,anti-clock needle up angle function	ON/OFF	OFF	ON: 切完线后，自动作反转的功能。（角度由【P47.TR8】调整决定） OFF: 无作用 ON: after trimmer, automatic start anti-clock OFF: No use
P47	切线后，反转提针角度的调整 After trimmer, anti-clock needle up angle adjustment	50-200	160	切完线后，由针上算起以反向运转作提针的角度调整。 After trimmer, as per anti-clock needle up angle adjustment
P48	低速（定位速度）（r/S） Low speed	100-500	210	定位速度设定 Needle position speed setting
P49	切线速度（r/S） Speed for trimmer	100-500	250	调整切线周期时的电机速度 Can adjust the speed for trimmer
P50	抬压脚提升时间（ms） The time that presser foot go up	10-990	250	压脚提升动作时调整项 Can adjust the time that it goes up
P51	压脚出力的周期信号 The signal cycle when presser foot work（%）	10-50	25	压脚动作时，以周期性省电输出，避免压脚发烫 When presser foot works, the power work as signal cycle, to sane power and avoid presser foot hot
P52	压脚下放时间（ms） The time that presser foot go down	10-990	300	压脚延时下放调整项 Can adjust the time
P53	半后踏取消抬压脚功能 Cancel the function when push the second half pedal	ON/OFF	OFF	ON: 半后踏时，无抬压脚出力 OFF: 半后踏时，有抬压脚出力 On: when push the second half pedal,presser foot no work Off: when push the second half pedal,presser foot work
P54	切线动作时间（ms） Cutter time	10-990	200	切线时序所需的动作时间 The time that cutter need when it works

参数项 number	中文说明 Chinese meaning	范围 Range	初始值 Default value	内容值名称说明与备注 Explanation
P55	拨 / 扫线动作时间/ Time that wiper work	10-990	30	拨 / 扫时序的动作时间 Time that wiper work
P56	开电后自动找上定位 Find needle position by itself when turn on	0-2	1	0: 始终不找上定位 1: 始终找上定位 2: 若电机已经处于上定位时不再找上定位（仅限于有磁钢电机） 0 : never find needle position 1: find needle position forever 2:when it is in up needle position, no need to find(just for the machine with Magnetic steel)
P57	抬压脚保护时间（s） Protect time for presser foot	1-60	10	抬压脚保持时间后强制关闭 Will make presser foot down after this time
P58	上定位调整 Adjust up needle position	0-1439	40	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 When adjust up needle position, the reduce the number means will stop in advance , add number means will stop later
P59	下定位调整 Adjust down needle position	0-1439	650	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（r/S） Test speed	100-3700	2000	设置测试速度 Set speed for testing speed
P61	A 项测试 A test	ON/OFF	OFF	A 项测试选项，设定后将按【P60. TV】所设定之速度持续运行 About A test, after setting, machine will work by itself under the speed as P60.TV set
P62	B 项测试 B test	ON/OFF	OFF	B 项测试选项，设定后将按【P60. TV】所设定之速度执行启动-车缝-停车-剪线的循环 About B test, after setting, machine will start-sew-stop-trimmer work under the speed as P60.TV set
P63	C 项测试 C test	ON/OFF	OFF	C 项测试选项，设定后将按【P60. TV】所设定之速度执行无定位动能的启动-车缝-停车的循环 About C test, after setting, machine will start-sew-trimmer work under the speed as P60.TV set
P64	测试 B、C 导通时间 Test B.C work time	1-250	20	B、C 项测试中，设置导通时间 When B.C test ,can set work time
P65	测试 B、C 停车时间 Test B.C stop time	1-250	20	B、C 项测试中，设置停车时间 When B.C test ,can set stop time
P66	机头保护开关检测 Test for safety switch	0-2	1	0: 不检测 1: 检测零信号 2: 检测正信号 0: no test 1: test 0 signal 2: test 1 signal
P67	剪线保护开关检测	ON/OFF	OFF	OFF: 不检测 ON: 检测

参数项 number	中文说明 Chinese meaning	范围 Range	初始值 Default value	内容值名称说明与备注 Explanation
	Test for trimmer protection switch			Off: no test on: test
P70	出厂机型选择 Machine mode choose		41	
P71	抬压脚释放缓冲(ms) The time when presser foot prepare	0-50	1	缓解压脚下放的力度 To buffer the power when presser foot down
P72	上停针位校正 up needle position correction	0-1439		调整上停针位，显示的数值会随手轮位置变化而变化，长按“P”键可保存当前位置（数值）为上停针位 When adjust up needle position ,the number will change from the position of hand wheel position, then press P to save the number you want
P73	下停针位校正 Down needle position correction	0-1439		调整下停针位，显示的数值会随手轮位置变化而变化，长按“P”键可保存当前位置（数值）为下停针位 When adjust Down needle position ,the number will change from the position of hand wheel position, then press P to save the number you want
P74	机器编码 1 Machine code 1			
P75	机器编码 2 Machine code 2			
P76	倒缝全额出力时间(ms) The time When back tack sews	10-990	250	
P77	自由缝连终止回缝停顿时间(ms) The time when sewing finishes	20-200	100	
P78	夹线器起夹角度 The angle when wiper begins working	1-990	100	起始夹线的定位角 The angle when wiper finishes working
P79	夹线器结束角度 The angle when wiper finishes working	1-990	270	夹线器结束的定位角 The angle when wiper finishes working
P80	剪线进刀角度 The angle When trimmer begin to work	0-359	18	剪线进刀角度设置（下定位为 0° 计算） Setting the angle when the trimmer begin to work(angle of needle position is 0)
P81	剪线加力角度 The angle When trimmer work	1-990	150	剪线加力角度设置（下定位为 0° 计算） Setting the angle when the trimmer work(angle of needle position is 0)
P82	剪线退刀角度 The angle When trimmer finishes work	1-990	185	剪线退刀角度设置（下定位为 0° 计算） Setting the angle when the trimmer finish and back(angle of needle position is 0)

参数项 number	中文说明 Chinese meaning	范围 Range	初始值 Default value	内容值名称说明与备注 Explanation
P83	剪线后停车距离 The distance after stopping trimmer	10-100	30	剪线后停车时的力度选择。 The power choice after trimmer work
P84	厚料开始加力角度 The angle of Add power for the beginning of sewing heavy fabric	0-330	9	
P85	厚料结束加力角度 The angle of Add power for the ending of sewing heavy fabric	0-330	57	
P86	上下定位距离 Distance between up and down position	100-1440	610	上下定位距离角度（每 4 个数值为 1 度） Angel Distance between Up and down needle position(every 4 number is 1 angle)
P89	交流过压值设定 Ac over voltage setting.	500-1023	880	
P92	编码器绝对位置校正 Absolute position correction of encoder.		160	读取编码器起始角度，出厂已设置，请勿随意更改（参数值不可手动更改，随意更改会导致控制箱、电机出现异常或损坏） Read the angle of encoder, Jack already made it correct, don't change .(if change the number, will damage the control box ,motor)
P119	电磁铁过流保护功能开关 Switch for protecting over current for coil	0-1	1	0: 开启 1: 关闭 0: on 1:off
P125	计件剪线次数 Count for trimmer time	1-9	1	剪线次数为设置次数时，计件数加 1 When setting the number from small, will add 1 from the beginning number.

3 错误代码表

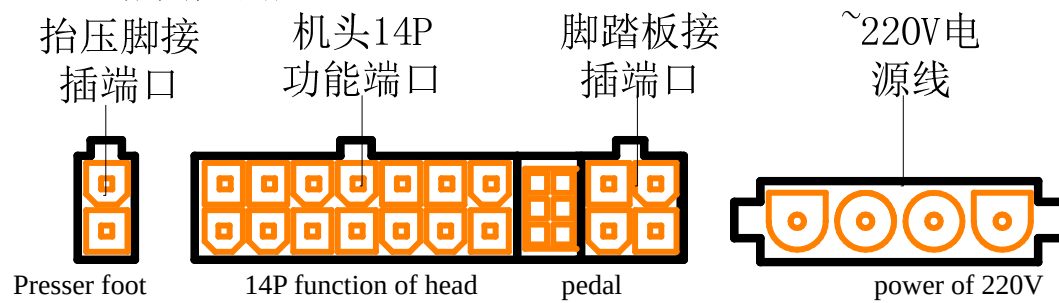
错误码	内容	对策
E01	1) 电源 ON 时，系统过压 when turn on, the voltage for machine is higher 2) 供电电源过压 power supply is higher	关闭系统电源，检测供应电源电压是否正确。（或是否超过使用规定的额定电压） 若正确，请更换控制箱并通知厂方。 Pls check the machine voltage,and check the power supply is higher or not.(maybe the voltage is higher than the standard one) restart the machine and see there is problem or not if still has problem, please change the control box and inform the supplier

E02	1) 电源 ON 时, 系统欠压 when turn on, the voltage for machine is lower 2) 供电电源欠压 power supply is lower	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。 Pls check the machine voltage, and check the power supply is lower or not. (maybe the voltage is higher than the standard one) restart the machine and see there is problem or not if still has problem, please change the control box and inform the supplier
E03	控制面板与 CPU 传输通信异常 The signal between panel and CPU has problem	关闭系统电源, 检查控制面板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, 请更换控制箱并通知厂方。 Turn off, check the plug of panel is loose or fall off, make the plug correct, then turn on, if still has problem, please change the control box and inform the supplier
E05	控速器接触异常 Problem for pedal	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。 Turn off, check the plug of pedal is loose or fall off, make the plug correct, then turn on, if still has problem, please change the control box and inform the supplier
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 a) The connection of motor is not good b) Stuck for machine head or there is some small fabric inside c) The fabric is too thick, it is difficult to sew d) Driven part of control box has problem	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。 See the hand wheel is stuck or not, if yes, solve it If no problem, check plug of motor and encoder is loose or not, if yes, please solve it If connection is good, please check the power is higher or the speed is too high or not if still has problem, please change the control box and inform the supplier
E08	连续手动倒缝超过 15 秒 Bartack by hand work for more than 15s	倒缝电磁铁吸合时间过长, 重启产品即可。 若重启产品后还是报 E-08, 请检查手动倒缝开关是否损坏。 The coil for back tack work time is too long, please restart If still has problem please check the switch of bartack is broken or not

E10	电磁铁过流保护 Protect for the current for electromagnet	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。 Turn off, check electromagnet is broken or not
E09 E11	定位信号异常 Needle position has problem	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。 Turn off, check the plug of encoder is loose or fall off, make the plug correct, then turn on, if still has problem , please change the control box and inform the supplier
E14	编码器信号异常 Signal of encoder has problem	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。 Turn off, check the plug of encoder is loose or fall off, make the plug correct, then turn on, if still has problem , please change the control box and inform the supplier
E15	电力模块不正常过流保护 Protect for high current for control box	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。 Turn off, turn on, if still has problem , please change the control box and inform the supplier
E17	机头保护开关没到正确位置 Safety switch	关闭系统电源，检查机头是否掀开，控制箱内滚珠开关是否移位或损坏。 Turn off, then check machine head is overturn or not, and check switch in control box is on or not
E20	开机电机启动失败 Motor does not work when turn on	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。 Turn off, check the plug of encoder is loose or fall off, make the plug correct, then turn on, if still has problem , please change the control box and inform the supplier

4 端口示意图 plug

4.1 各个端口名称



4.2: 14P 功能端口对应表

1. trimmer electromagnet: 1, 8
2. thread wiping electromagnet: 2, 9
3. LED: 4 (GND), 11 (+5V)
4. Switch for bartack by hand : 5, 12 (GND)
5. Batack electromagnet switch: 6, 13
6. Add stitch switch: 7, 14 (GND)

