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I. 运转前的注意事项

CAUTIONS BEFORE OPERATION

运转前和每日开始工作前，请一定确认以下项目。

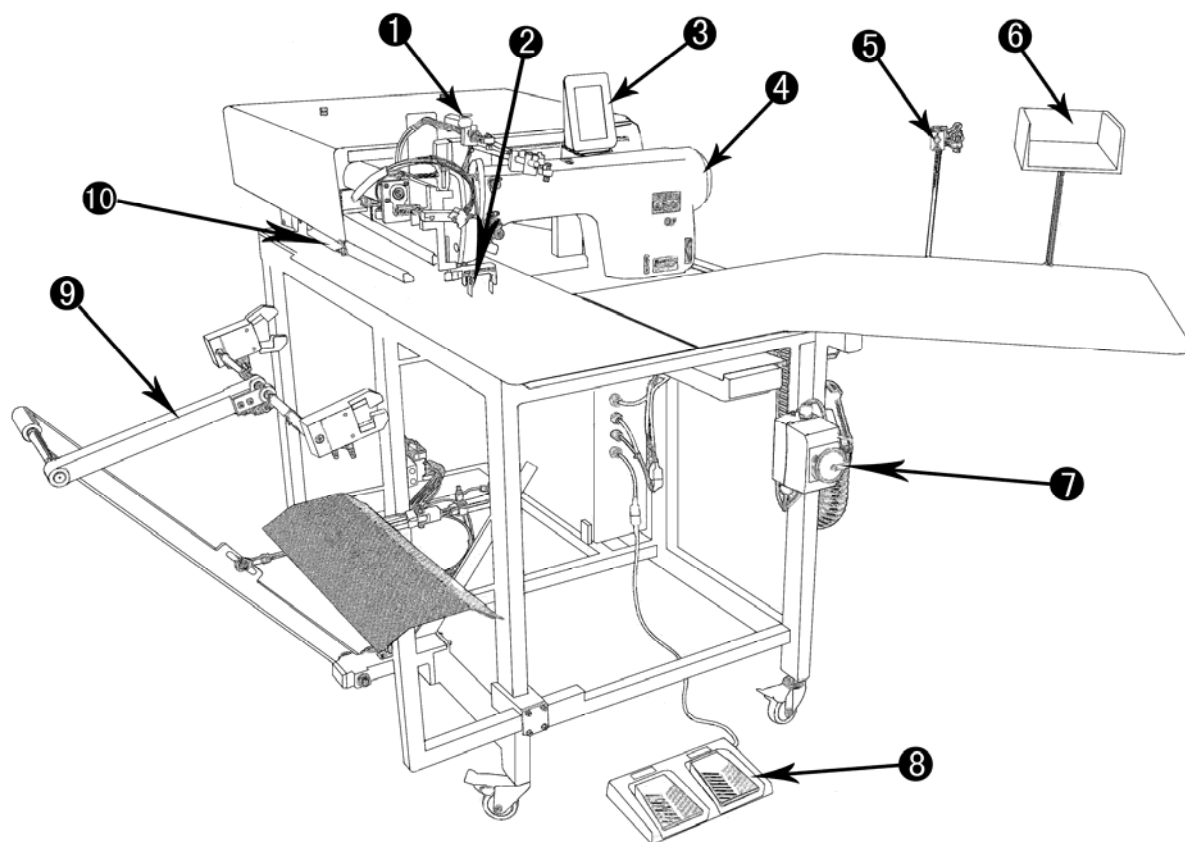
1. 请确认是否向缝纫机加入了规定量的缝纫机油。
2. 在没有向旋梭加油部加入机油的状态，请绝对不要运转缝纫机。
3. 请确认空气压力表的读数是否为0.6MPa。
※（特别是中午午休等情况停止空气压缩机后，请一定进行确认。）
空气压力在规定值以下时，有发生零件碰撞等危险，请加以注意。
4. 请确认缝纫机的上线、底线是否需要补充。
5. 打开电源开关开始缝制时，请一定进行试缝之后再正式缝制产品。

Following items have to be checked every working day before the operation of the machine and before the start of work hours.

1. Ascertain that the sewing machine is filled with the predetermined amount of oil.
2. Never operate the machine unless the lubricating part in the hook has been filled up with oil.
3. Ascertain that the pressure gauge indicates the designated air pressure of 0.6 MPa.
※ (This is necessary particularly when the compressor is stopped for a lunch break or the like.)
If the compressed air pressure is equal to or less than the designated value, troubles such as interference between the parts can occur. It is therefore necessary to carefully check the compressed air pressure.
4. Check whether the needle thread/bobbin thread need to be replenished.
5. To perform sewing immediately after turning ON the power switch, perform trial stitching first, then proceed with sewing of actual products after the test sewing.

II. 各部件的名称

CONFIGURATION OF THE MACHINE



本缝纫机由以下10个部分构成：

- ① 急停开关
- ② 中刀机构
- ③ 操作面板
- ④ 单针直驱缝纫机头
- ⑤ 激光定位灯
- ⑥ 布料盒
- ⑦ 主电源开关
- ⑧ 脚踏板
- ⑨ 堆叠器
- ⑩ 大压脚

只要把布料放到规定位置，踩脚踏板就可以缝制。另外，机器动作中，按了中途停止开关①之后，机器就停止。

The T5878-58G consists mainly of the following units.

- ① Emergency stop switch
- ② Center knife unit
- ③ Operation panel
- ④ Sewing machine head
- ⑤ Marking light
- ⑥ Pcs box
- ⑦ Main power switch
- ⑧ Foot pedal
- ⑨ Stacker unit
- ⑩ Clamp foot

With this machine consisting of the aforementioned 10 units, you can do desired work simply by push on the foot pedals. In addition, when temporary stop switch ① is pressed during operation of the device, the device stops.

III. 机器规格

1	机器型号	T5878-58G
2	转速	500~4000rpm
3	缝迹针距	平缝: 2.0 ~ 3.4mm(标准 2.5mm) 缩缝: 1.0 ~ 1.5mm(标准 1.0mm) 倒缝: 1.0 ~ 3.0mm(标准 2.5mm) 可以变换缩缝、倒缝。
4	加固缝针数	1~30 针(标准 3 针)
5	使用机针	DB*1 11#
6	缝纫宽度	1~50mm
7	缝纫长度	15~260mm
8	使用机线	缝纫机线 # 60(推荐)
9	送布机构	伺服马达驱动
10	控制	微电脑控制
11	安全功能	检测送布机构异常、断线检测等时自动停机
12	润滑油	缝纫机油
13	使用空气压力	0.6MPa
14	空气消费量	约 40dm ³ /min
15	机器尺寸	宽: 1,500mm 长: 1,800mm 高: 1,500mm
16	机器重量	200kg
17	输入电源	单相 220V 50/60Hz 电源电压变动 额定 ±5% 以内
18	消费电力	600W

MECHANICAL SPECIFICATIONS

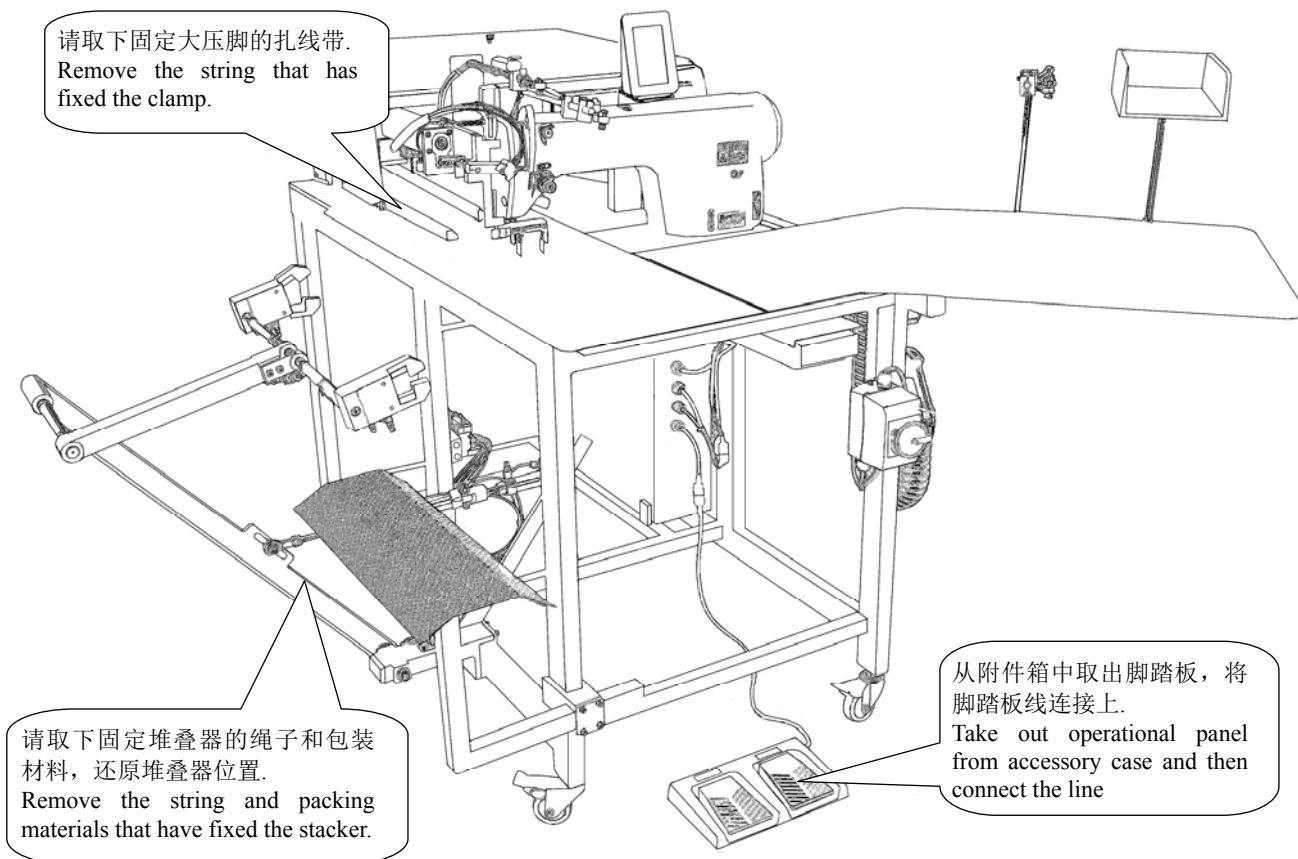
1	Machine type	T5878-58G
2	Sewing speed	500~4000rpm
3	Stitch length	Lockstitch:2.0 ~ 3.4mm(standard 2.5mm) Condensation stitch:1 ~ 1.5mm(standard 1.0mm) backstitch:1 ~ 3.0mm(standard 2.5mm) Condensation/Back stitch selectable
4	Spliced stitches	1~30 stitch (standard 3 stitches)
5	Needles	DB*1 11#
6	Sewing width	1~50mm
7	Sewing length	15~300mm
8	Thread	Spun thread #60 (Recommended)
9	Cloth feed mechanism	Driven by servo motor
10	Control	By a micro-computer
11	Safety mechanism	Machine operation is automatically stopped if the cloth feed mechanism error detector, the needle thread breakage detector or any of the various safety devices is actuated.
12	Lubricating oil	sewing-machine oil
13	Operating air pressure	0.6MPa
14	Air consumption	Approx 40dm ³ /min
15	Dimensions of machine	Width : 1,500 mm Length :1,800 mm Height : 1,500 mm
16	Weight	200kg
17	Input power	Single phase 220V 50/60Hz Supply voltage variation less than rated ±5%
18	Power consumption	600W

IV. 安装

INSTALLATION

1. 包装材料的拆卸

REMOVING PACKING MATERIALS



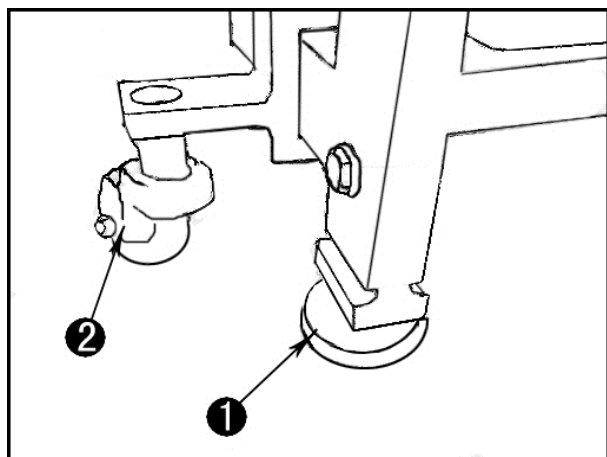
2. 固定主机

SECURING THE MACHINE



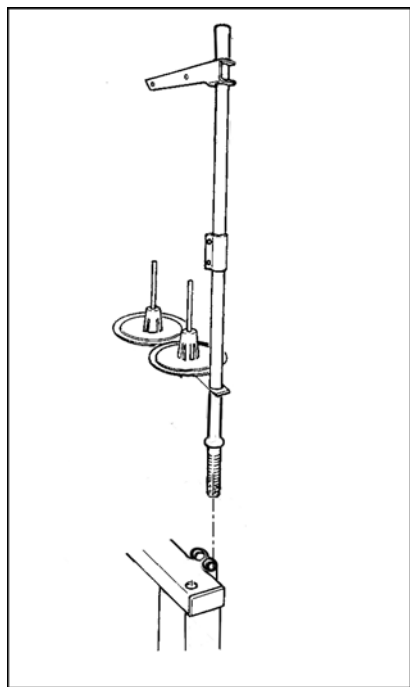
为了防止发生人身事故，将本机水平地移动到稳定的地点后，请放下脚垫①，升起脚轮②(4处)进行固定。

To prevent a fatal accident, lower and fix foot pads ① (4 places) and raise casters ② after moving the machine to the level and stabilized place.



3. 线架的安装

ASSEMBLING THE THREAD STAND AND ATTACHING IT

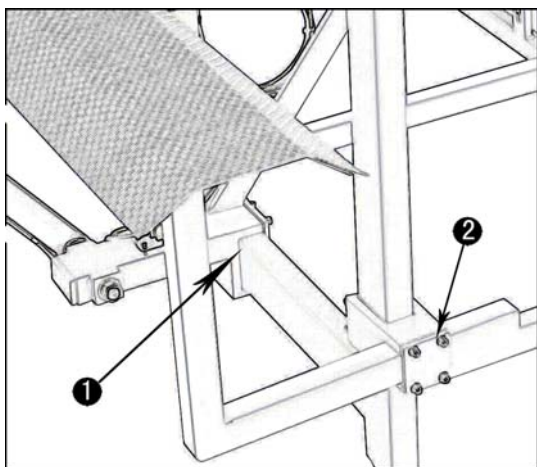


请按照左图所示那样，将线架插到主机机架上的圆孔中，调整好位置以后，用两个内六角紧定螺钉固定。

Putting the thread stand in one of the two holes on main unit frame and fix the thread stand with two hexagon without a head set screws as illustrated in the left-hand figure.

4. 夹杆堆叠器的安装(选购品)

INSTALLING CLAMP BAR STACKER (OPTIONAL)



安装了夹杆堆叠器出货时，是固定到机架内的状态出货的，因此必须变更安装到通常的使用位置。

- 1) 拆开包裹堆叠器的塑料，剪断扎带，然后松开固定堆叠器的螺钉。
- 2) 调整堆叠器位置。



此时，请注意不要夹到堆叠器电线和空气配管等。

- 3) 按照如图①、②所示，固定好堆叠器。



此时，请确认空气是否进入到里面。



Clamp bar stacker is delivered in the state that it is fixed in the frame at the time of delivery with the clamp bar stacker mounted. It is necessary to change the installing position to the normal using position

- 1) Remove the string and packing materials that have fixed the stacker, and then remove the screw.
- 2) Adjust the stack position.



At this time, take care to prevent the stacker cord, the air piping, etc. from being caught.

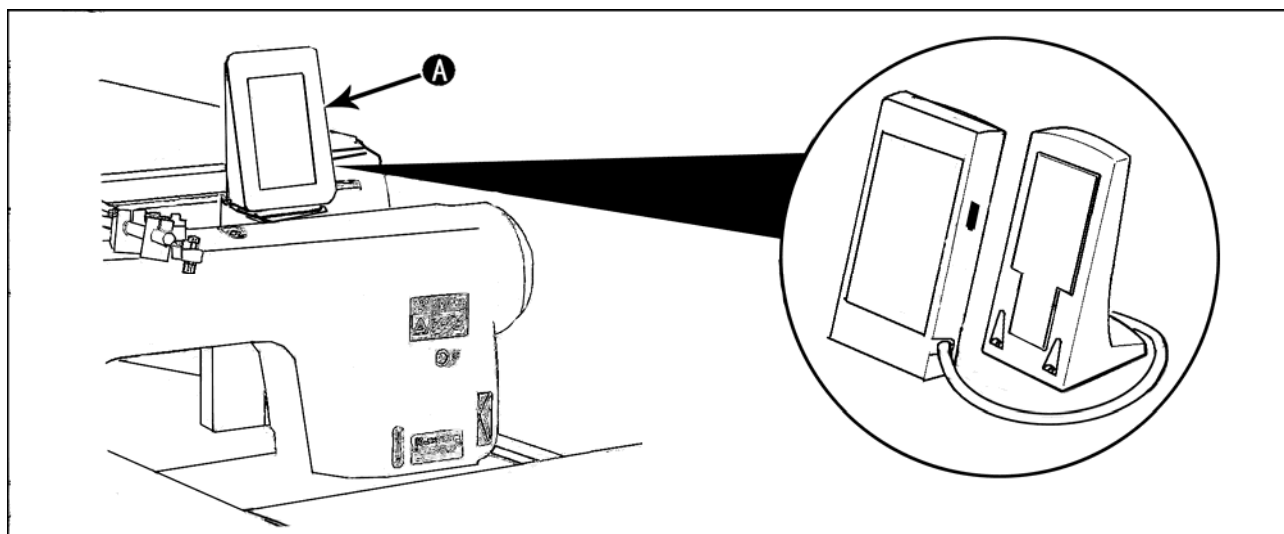
- 3) As shown in the fig ①、②, lock the whole stacker with screw and plate.



At this time, confirm that air is being supplied.

5. 操作面板的安装

INSTALLING OPERATION PANEL



如图所示，切断固定操作面板①的扎线带，然后除掉扎线带和包装材料。将操作面板按照如图所示固定到正确位置。

As shown in the figure above, cut and remove the packing material that has fixed the installing operation panel on frame.



为了防止操作面板因静电而发生误动作，安装到操作盘座进行使用时，请不要变更操作盘座的位置。

To prevent malfunction due to static electricity, install operation panel on the panel base to use and do not change the position of the panel base.

6. 往油槽加油

LUBRICATING THE OIL TANK



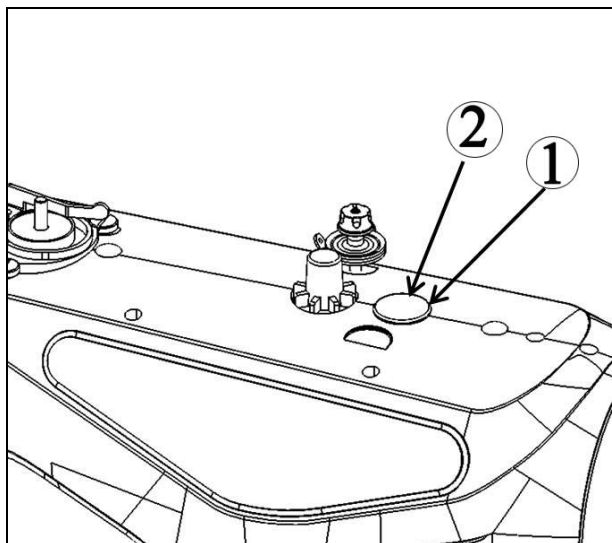
注意

1. 为了防止缝纫机的突然起动造成事故，加完油之前，请不要连接电源插头。
2. 为了防止炎症、斑疹，油粘附到眼睛、身体上，加完油之后，请立即进行清洗。
3. 误饮油之后，有可能发生泻肚、呕吐。请将油放到小孩拿不到的地方。



CAUTION

1. To prevent accidents caused by abrupt start of the sewing machine, do not connect the power plug until lubrication has been completed.
2. To prevent inflammation or rash, immediately wash the part when oil has stuck to your eyes or body.
3. If oil has been swallowed, diarrhea or vomiting may occur. Put oil to the place where children cannot reach.



为了防止灰尘侵入，请一定安装上盖子之后再使用。

- 2) 在机器上电绿色画面下加油，请根据显示屏提示进行加油，油量不易过多及过少，请注意。

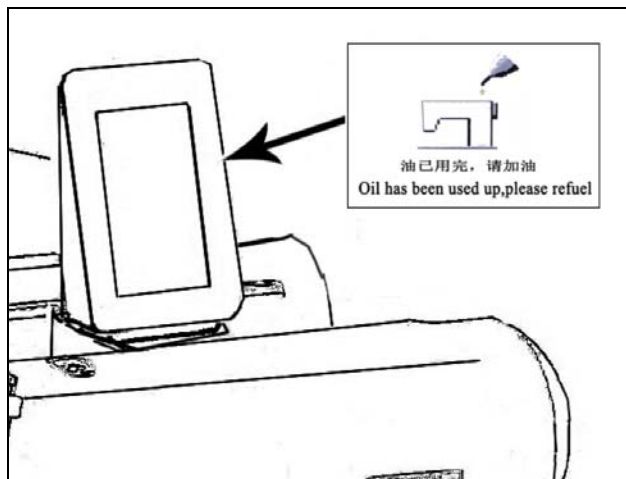
Fill the oil tank ① with the oil for hook lubrication before operating the sewing machine.

- 1) Remove oil cap ② and fill the oil tank with the oil for hook lubrication by using the oiler supplied with the machine as accessories.



To prevent entering of dust, be sure to attach the cap for use.

- 2) Fill the oil tank at the green screen . please according to the screen display, Oil should not be too much or too little, be careful.



运转缝纫机之前，请向油槽①里加入旋梭加油用的油。

- 1) 卸下加油口盖②，使用附件里的油壶，加入缝纫机白油。

V. 缝纫机的准备

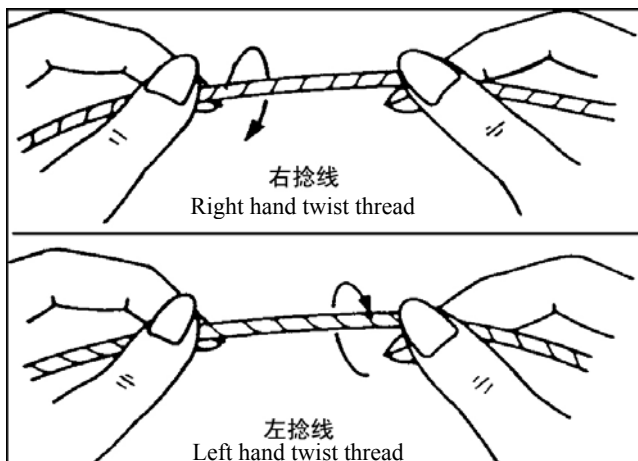
PREPARATION OF THE SEWING MACHINE

1. 缝纫机机头的使用

HOW TO OPERATE THE SEWING MACHINE HEAD

(1) 使用机线

Thread used



- * 上线请使用左捻线。
- * 底线左捻线和右捻线均可以使用。

- * Use the left hand twist thread for the needle thread
- * Either twist thread will do for the bobbin thread.



使用的机线，请使用拧得整齐的新线。

Use a new thread which is uniformly twisted.

(2) 上线的穿线方法

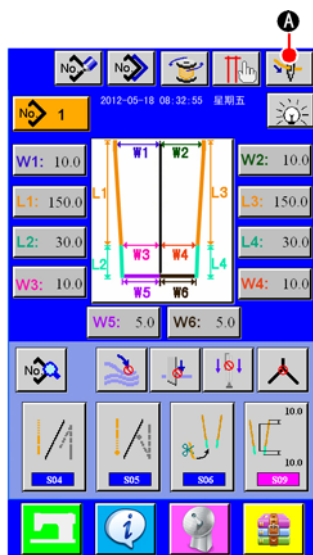
How to pass the needle thread



注意
CAUTION

为了防止突然的起动造成事故，请关掉电源之后再进行操作。

Turn OFF the power before starting the work so as to prevents accidents caused by abrupt start of the sewing machine.



- 1) 在输入画面，按下穿线按钮  ①后，显示穿线画面（画面A）。



按下穿线按钮后，机头会向右移动，同时，小压脚会压下，注意安全。

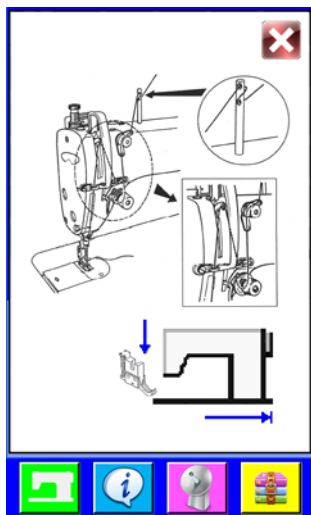
- 2) 然后，请按图上所示的顺序穿上线。穿好上线以后，按下按钮 ，机头和小压脚归位。

When threading button  ② is pressed in the input screen ,threading screen (screen A) displayed.



After press the threading button,the nose will move to the right,and at the same time , the small press foot will depress. so ,pay attention!!.

Then pass needle thread in the order as shown in the figure below.After that ,press the button  and the nose and the small press foot will be homing



2. 底线的卷绕方法

HOW TO WIND THE BOBBINS

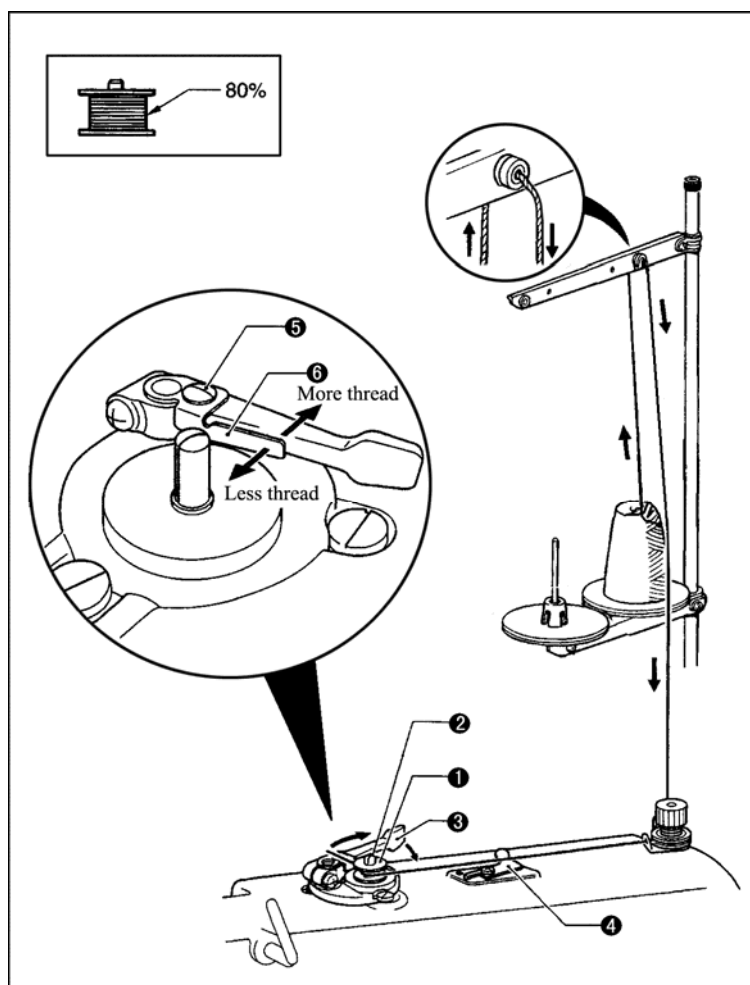


为了防止受伤，运转中请不要触摸。

To prevent damage, avoid contact with bobbins while the machine is in operation.

(1) 放置梭芯

Place bobbin



- 1) 将梭芯①置于梭芯卷线轴②上。
- 2) 按箭头所示的方向将线在梭芯①上卷绕几次。
* 请确认各部分的机线没有松弛。
- 3) 将梭芯压臂柄③推向梭芯①。

Place the bobbin ① onto the bobbin winder shaft ② .

Wind the thread several times around the bobbin ① in the direction indicated by the arrow.

* Check that the thread is not loose anywhere along the thread path .

Push the bobbin presser arm ③ toward the bobbin ① .

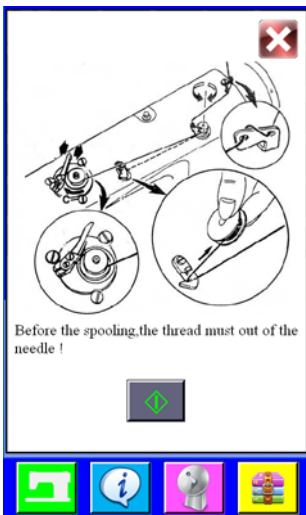
(2) 开始绕底线方法

Winding the lower thread



- 1) 将梭芯放置完成后，按下缝制画面中的按钮  ①，显示绕底线画面（画面 A）。

After complete the first step , Press the button  ① in the sewing screen, Then the lower thread winding screen (screenA) is displayed.



绕底线画面（画面 A）

Lower thread winding screen (screenA)

- 2) 确认线已经从针里面取出后，按下中间的按钮  开始绕底线。
- 3) 底线卷绕一旦完成，梭芯压臂柄 ③ 将自动返回。
- 4) 此时，按下按钮停止绕底线。然后将梭芯拆下，用切刀 ④ 将线剪断。

Make sure the thread is out of the needle ,and then press the button  ,lower thread winding will start.

Once winding of the lower thread is completed,the bibbin presser arm ③ will return automatically.

Then ,press the botton ② to stop and remove the bobbin,cut the thread with the knife ④.



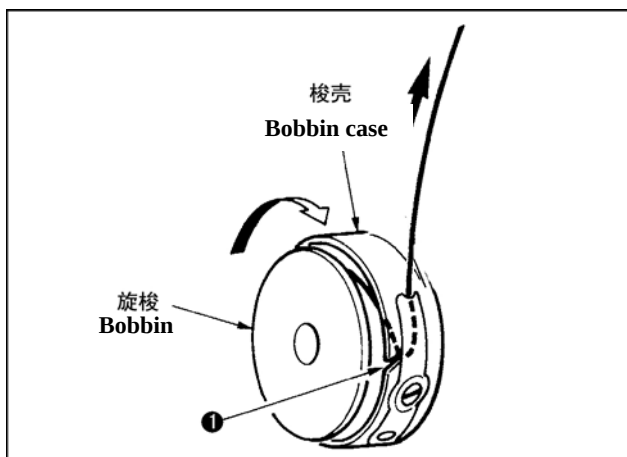
1. 为了稳定地确保底线的残量，旋梭上的线必须均匀地卷绕。特别是要注意开始卷绕的部分。
2. 底线最适合的卷绕量是卷绕旋梭外径的80%左右。
* 调节卷绕量方法：松开螺钉 ⑤，移动梭芯压杆 ⑥ 即可调节卷绕在梭芯上的底线量。
3. 不卷绕机线时请不要拨压杆 ⑥。



1. To ensure the appropriate remaining amount of bobbin thread, it is important to wind the bobbin uniformly. Be sure to check that the bobbin is uniformly wound particularly at the start of bobbin winding.
2. It is most suitable to wind the bobbin with thread to approximately 80% of the outer diameter of the bobbin.
* Loosen the screw ⑤ and move the bobbin presser ⑥ to adjust the amount of thread wound onto the bobbin .
3. Do not press lever ① except when winding bobbin thread ⑥.

3. 梭壳的穿线方法

HOW TO THREAD THE BOBBIN CASE



- 1) 手拿旋梭，在线右卷的状态下放入梭壳里。
- 2) 把线放入梭壳穿线槽①。
- 3) 然后把线从线张力弹簧下面穿过。

Hold in hand a bobbin in the way that it spins clockwise and put it into the bobbin case.

Pass the thread through slot ① in the bobbin case.

Pull the thread to pass it under the tension spring.

4. 梭壳的安装

HOW TO INSTALL THE BOBBIN CASE

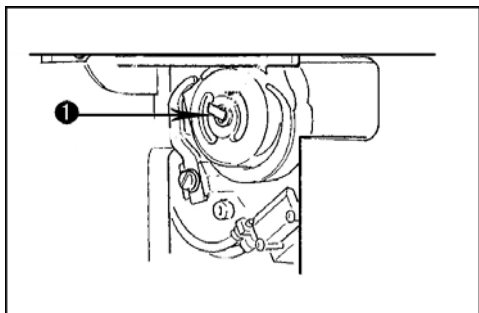


注意

CAUTION

为了防止突然的起动造成事故，请关掉电源之后再进行操作。

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



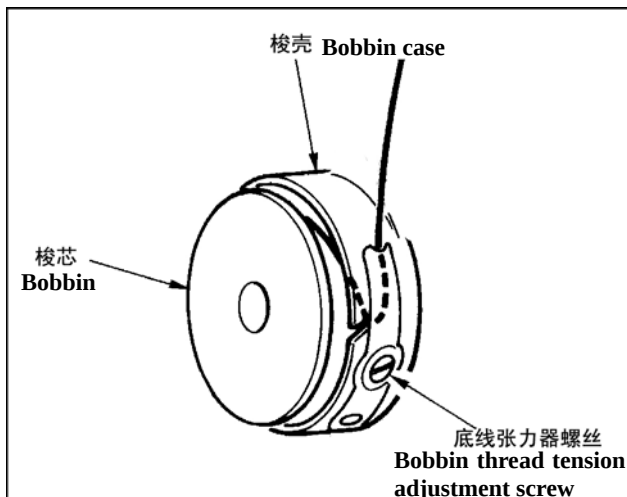
- 1) 请拔起旋梭拨杆①，把梭壳和旋梭一起取出来。
- 2) 放入时，请正确地插入旋梭轴，然后放倒拨杆①。

Raise hook levers ① and take out the bobbin cases together with the bobbins.

When fitting, fit the bobbin cases into the hook driving shaft and tilt levers ①.

5. 线张力器的取下方法

HOW TO ADJUST THE THREAD TENSION



底线张力的调整

向右转动底线张力器螺丝张力变强，向左转动则张力变弱。

Adjusting bobbin thread tension

Turn bobbin thread tension adjustment screw clockwise to increase the bobbin thread tension or turn the screw counterclockwise to decrease it.

VI. 操作盘的使用方法

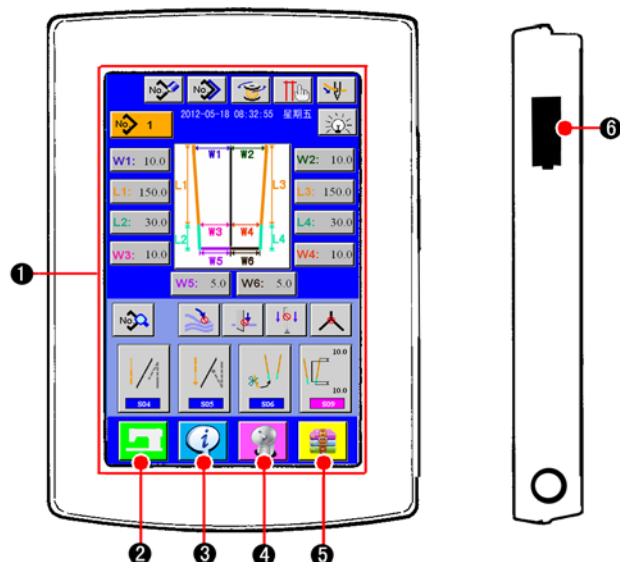
HOW TO USE THE OPERATION PANEL

1. 操作面板的基本操作

BASIC OPERATION OF THE OPERATION PANEL

(1) 操作面板各部件的名称

Configuration of the operation panel



符号 Symbol	名称 Name	说明 Description
1	触摸操作盘液晶显示部 TOUCH PANEL, LCD display section	
2	 准备完了键 READY key	进行数据输入画面和缝制画面的变换。 Change-over of the data input screen and the sewing screen is performed.
3	 信息键 INFORMATION key	进行数据输入画面和信息画面的变换。 Change-over of the data input screen and the information screen is performed.
4	 通讯键 COMMUNICATION key	进行数据输入画面和通讯画面的变换。 Change-over of the data input screen and the communication screen is performed.
5	 模式变换键 MODE CHANGEOVER key	进行数据输入画面和进行各种详细设定画面的模式变换画面的变换。 Change-over of the data input screen and the mode change-over screen which performs various details setting
6	USB接口 USB PORT	请打开盖子后再使用。 Open the lid before use.



打开电源后，第一次按下准备完了键时，进行大压脚马达的原点检索。
此时，大压脚可以移动，请注意。

**When READY key is pressed first after turning ON the power, origin retrieval of the clamp foot is performed.
At this time, the clamp foot moves. So, be careful.**

(2) 通用的按钮

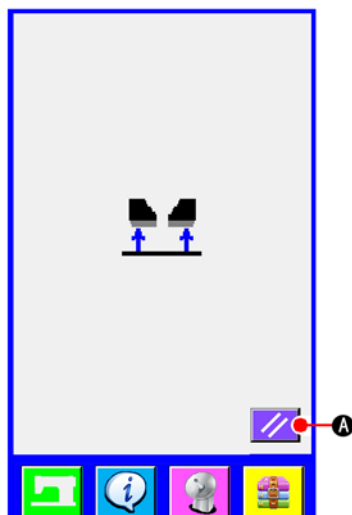
Buttons used in common

在操作面板的各画面上通用操作的按钮如下所示。

Buttons that perform common operation in the respective screens of the operation panel are as described below.

图标 Pictograph	名称 Name	说明 Description
	取消按钮 CANCEL button	关闭凸起画面。 变更数据画面时，取消变更中的数据。 Pop-up screen is closed. In case of the data change screen, the data during changing can be cancelled.
	确定按钮 ENTER button	确定变更的数据。 Data changed are determined.
	上滚动按钮 UP SCROLL button	向上方滚动按钮或显示。 This button scrolls button or display upward.
	下滚动按钮 DOWN SCROLL button	向下方滚动按钮或显示。 This button scrolls button or display downward.
	复位按钮 RESET button	解除异常错误等。 This button releases error and the like.
	数字输入按钮 NUMBER INPUT button	显示十数字键，可以进行数字的输入。 Ten keys are displayed and input of number can be performed.

(3) 基本操作 Basic operation



1) 打开电源开关

请首先打开电源开关。
欢迎画面显示后，复位凸起画面显示出来。请按复位按钮



Turn ON the power switch.

First, turn ON the power switch.

Reset pop-up screen is displayed after displaying WELCOME screen.

Press RESET button (A).



按了复位按钮之后，机头会移动，因此请注意安全。

When RESET button is pressed, the binder goes up. So, be careful.

2) 选择想缝制的图案 No.

按了图案No.按钮 之后，可以选择图案No.。

有关图案No.的选择方法，请参阅“VI-5-(1).选择图案”。

购买时，图案 No.1 ~ 11 被登记着，因此请根据缝制规格的情况变更缝制数据之后使用。（没有登记的图案号码不显示。）

Select pattern No. you desire to sew.

When PATTERN NO. button (B) is pressed, the pattern No. can be selected. For the selecting procedure of pattern No., see “VI-5-(1) Performing the selection of pattern”.

At the time of your purchase, pattern Nos. 1 to 11 have been registered. Change the sewing data in accordance with the sewing types for use. (The number to which the pattern has not been registered is not displayed.)



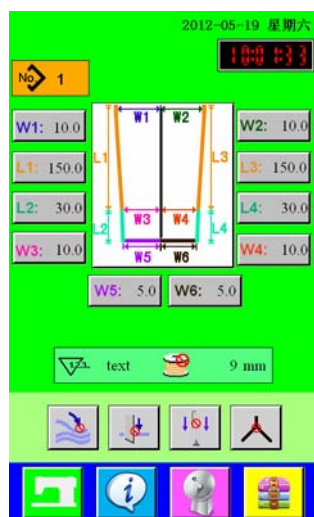
有关缝制画面的详细说明，请参阅“VI-2.基本画面的说明”。

For the detailed explanation of input screen, see “VI-2. EXPLANATION OF THE BASIC SCREEN”.



单独缝制输入画面(画面A)

The independent sewing input screen (screen A)



缝制画面(画面B)

Sewing screen (screen B)

3) 开始缝制

在单独缝制输入画面(画面A)按了准备完了键 之后，绿色的缝制画面(画面B)被显示出来，一踩踏板就可以开始缝制。

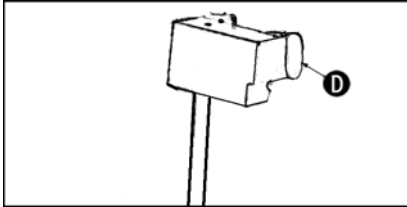
Start sewing

When READY key (C) is pressed in the independent sewing input screen (screen A), the green sewing screen (screen B) is displayed and the sewing operation is started by the pedal operation.



有关缝制画面的详细说明，请参阅“VI-2.基本画面的说明”。

For the detailed explanation of input screen, see “VI-2. EXPLANATION OF THE BASIC SCREEN”.



4) 操作中途停止装置时

缝制中按了中途停止开关①之后，可以让装置停止。
此时，错误画面被显示出来，通知停止开关被按。按了复位按钮②之后，错误被解除，然后返回到输入画面。



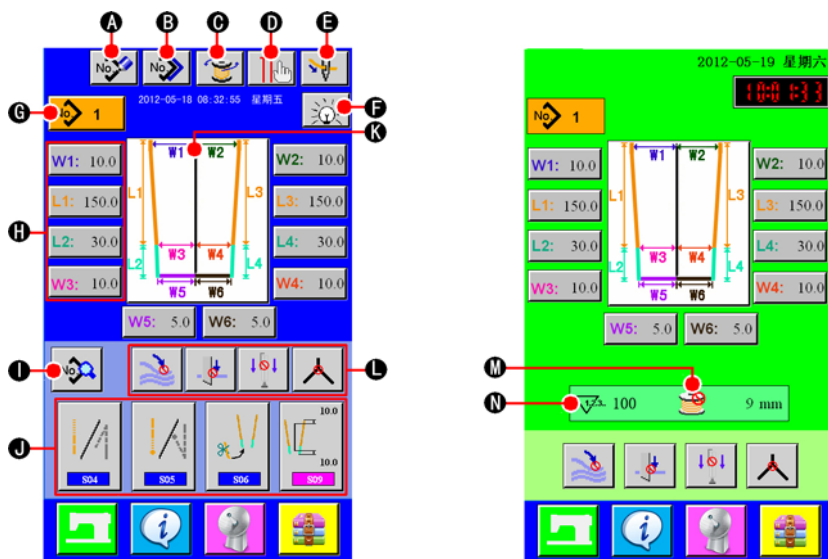
To stop the device during operation

When temporary stop switch ① is pressed during sewing, the device can be stopped.

At this time, the error screen is displayed to inform that stop switch is pressed. When RESET button  ② is pressed, the error is released and the screen returns to the input screen.

2. 基本画面的说明

EXPLANATION OF THE BASIC SCREEN



符号	按钮名称	内容
A	新编制按钮	显示单独缝制图案新编制画面，可以新登记图案数据。
B	复制按钮	显示单独缝制复制原图案一览画面，可以复制图案数据。
C	绕梭芯按钮	按下按钮开始自动绕梭芯
D	激光灯设定按钮	显示出标记灯设定画面，进行标记灯照射位置的变换和标记灯设定值的变更的设定。
E	穿线保护	按了按钮之后，机器调整到穿线状态。
F	穿线灯按钮	按一下穿线灯亮，再按一下穿线灯灭。
G	图案 No. 一览按钮	显示图案 No. 一览画面，可以选择图案数据。
H	缝纫尺寸设定按钮	设定缝制的长度。
I	显示缝制数据按钮	显示缝制图案编辑画面。选择在输入画面上没有显示的详细缝制数据，可以进行编辑。
J	常用缝纫功能按钮	显示常用缝纫功能的按钮
K	缝制模式设定按键	选择缝制模式。
L	功能设定	开启/禁止某项功能
M	底线余量	显示剩余底线长度
N	缝纫件数计数器	显示缝纫件数

* 可以随机设定各按钮的显示/不显示。
详细内容请参照“VI-9. 管理数据输入画面”。

Symbol	Name of button	Description
A	NEW CREATION button	Independent sewing pattern new creation screen is displayed and new register of the pattern data can be performed.
B	COPY button	Independent sewing copy source pattern list screen is displayed and the pattern can be copied.
C	WIND BOBBIN button	lower thread winding will start automatically while this button is pressed.
D	MARKING LIGHT SETTING button	When this button is pressed, Marking light setting screen is displayed, and setting of marking light.
E	THREADING PROTECTION button	When this button is pressed, The machine adjust to the threading state .
F	PATTERN NO. LIST button	Pattern No. list screen is displayed and the pattern data can be selected.
G	PATTERN NO. LIST button	Pattern No. list screen is displayed and the pattern data can be selected.
H	THREADING LIGHT button	Click the button ,the threading light turn on;Click it again,the threading light turn off
I	DISPLAY SEWING DATA button	Display sewing design edit screen. Select the detailed sewing data that not shown in the input screen, can edit it.
J	COMMONLY USED SEWING FUNCTION button	Display the function of the commonly used
K	SEWING MODE SETTING button	Sewing mode is selected.
L	FUCTION SETTING button	Enable/disable a fuction
M	BOBBIN THREAD REMAINING AMOUNT COUNTER	Display remaining amount of bobbin thread
N	SEWING NUMBER COUNTER	Display the number of sewing pieces

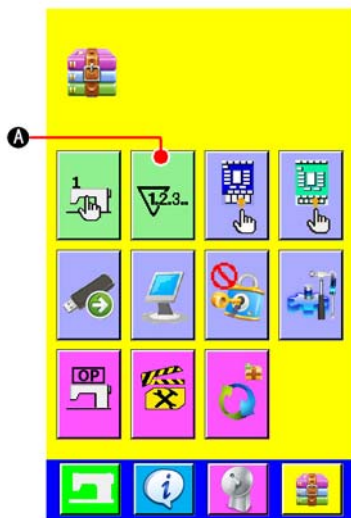
- * It is possible to customize display/non-display of the respective buttons.
For the details, refer to **"VI-9. CUSTOMIZING THE DATA INPUT SCREEN "**.

3. 计数器的使用

USING THE COUNTER

(1) 计数器的设定方法

Setting procedure of the counter



1) 显示设定计数器画面

在输入画面按了模式变换键之后，画面上计数器设定按钮



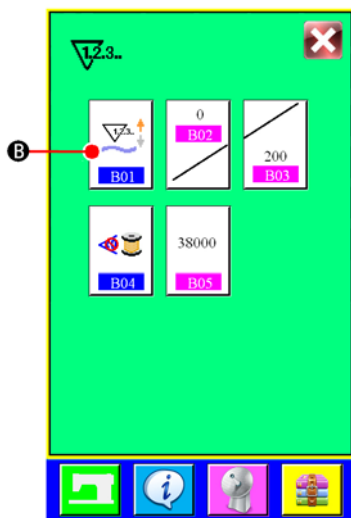
Ⓐ显示出来。按了此按钮之后，“设定计数器画面(画面A)”显示出来。

Display the counter setting screen.

Press MODE CHANGEOVER key  from the input screen and

COUNTER SETTING button  Ⓐ is displayed on the screen.

Press this button and "COUNTER SETTING screen (screen A) " is displayed.



2) 选择计数器种类

本缝纫机上安装有件数计数器、底线残量调整计数器2种计数器。

在“设定计数器画面(画面A)”上按了件数计数器按钮Ⓑ之后，“设定件数计数器画面(画面B)”显示出来，可以设定计数器的种类。

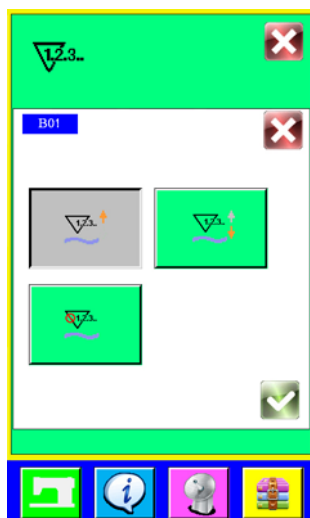
Select the kind of counter.

There are two kinds of counters with this sewing machine, number of pcs counter and bobbin thread remaining amount adjustment counter.

Press sewing counter button  Ⓑ in "counter setting screen

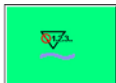
(screen A)", and "number of pcs counter setting screen (screen B) "is displayed. Then the kind of counter can be set.

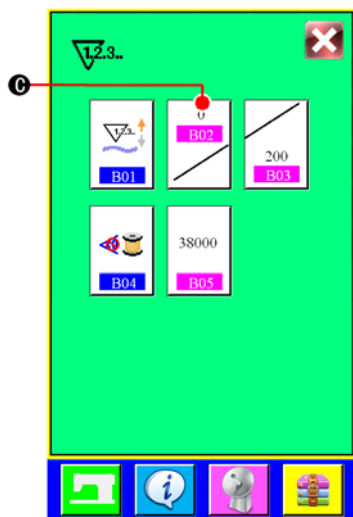
设定计数器设定画面(画面A)
Counter setting screen (screen A)

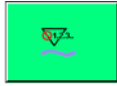


设定件数计数器画面(画面B)

Number of piece counter setting screen
(screen B)

【件数计数器】	
	加数计数器： 每缝制1件，对现在值进行加算计数。现在值和设定值相等之后，显示计数器画面。
	减数计数器： 每缝制1件，对现在值进行减算计数。现在等于0之后，显示计数器画面。
	未使用计数器： 设定为禁止使用的件数计数器。



【Number of pcs counter】	
	UP counter Every time one piece sewing is performed, the existing value is counter up. When the existing value is equal to the set value, the count- up screen is displayed.
	DOWN counter Every time one piece sewing is performed, the existing value is counted down. When the existing value is reached to “0”, the count-up screen is displayed.
	Counter unused Sewing counter is set to the prohibition.

3) 变更计数器现在值

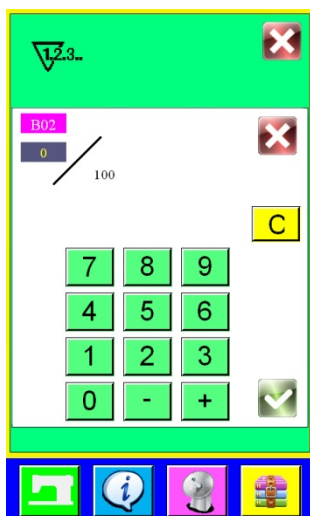
件数计数器时，按了按钮  之后，设置设定凸起画面(画面C)被显示，可以设定计数器现在值。

Changing the existing value of the counter

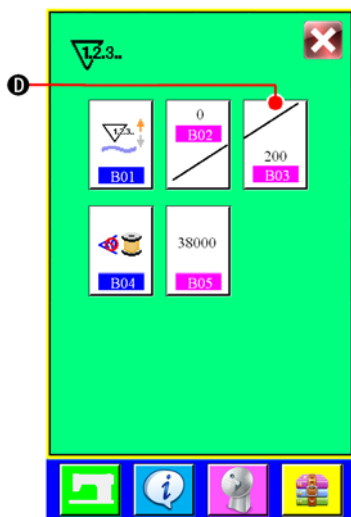
In case of the number of pcs. counter, press  “Numerical setting pop-up screen (screen C)” is displayed. Then the existing value of counter can be set.

在这里，请输入计数器现在值。

Here, input the existing value of counter.



数值设定凸起画面(画面C)
Numerical setting pop-upscreen
(screen C)

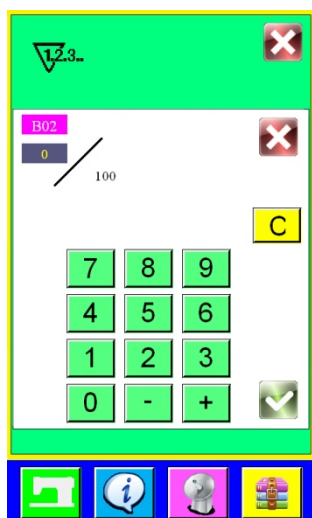


4) 变更计数器目标值

件数计数器时，按下按钮 ①之后，设定凸起画面(画面D)被显示出来，可以设定计数器现在值。

Change the target value of counter

In case of the number of pcs counter, press button ① and “Numerical setting pop-up screen (screen D)” is displayed. Then the target value of counter can be set.



数值设定凸起画面(画面D)

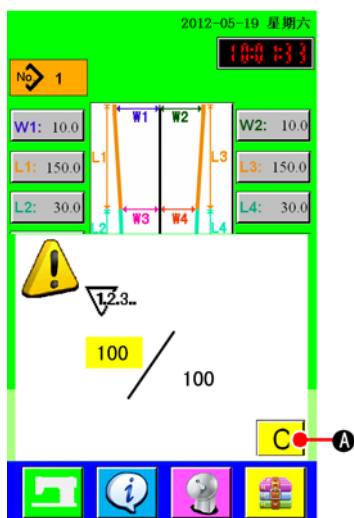
Numerical setting pop-up screen
(screen D)

在这里，请输入计数器目标值。向计数器目标值输入0之后，缝制中仅显示现在值，不显示计数器加数画面。

Here, input the target value of counter. When “0” is inputted to the target value of counter, only the target value is displayed during sewing and the count-up screen is not displayed.

(2) 计数的解除方法

Releasing procedure of count-up



在缝制中，达到了计数条件之后，显示计数画面，蜂鸣器鸣响。按了清除按钮 ①之后，复位计数器，返回缝制画面。然后重新开始计数。

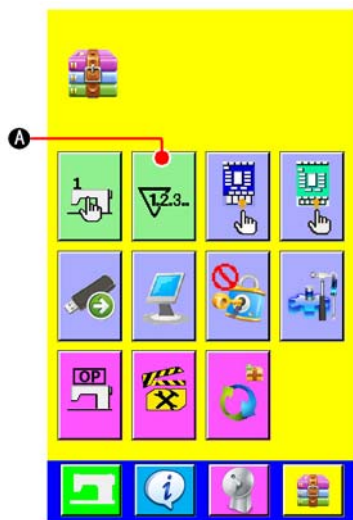
During the sewing work, the count-up condition is reached the count-up screen is displayed and the buzzer sounds. Press CLEAR button ① to reset the counter, and the screen returns to the sewing screen. And, counting starts again.

4. 底线余量计数器

USING THE BOBBIN THREAD AMOUNT ADJUSTMENT COUNTER

(1) 底线余量计数器的设定方法

Setting procedure of the bobbin thread remaining amount adjustment counter



1) 显示设定计数器画面

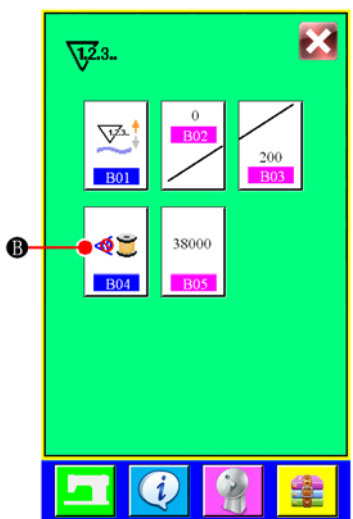
在输入画面按了模式变换键之后，在画面上显示出设定计数器按钮①。按了此按钮之后，设定计数器画面(画面A)被显示出来。

Display the counter setting screen

Press MODE CHANGEOVER key  from the input screen ,

COUNTER SETTING button ① is displayed on the screen .

Press this button and “Counter setting screen (screen A)” is displayed



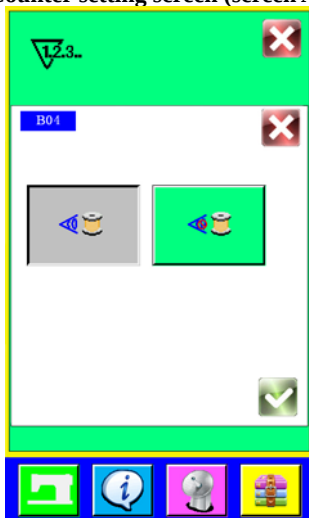
设定计数器画面(画面A)
Counter setting screen (screen A)

2) 把底线余量调整计数器设定为ON

按了底线余量调整计数器动作设定按钮②之后，底线余量调整计数器设定凸起画面(画面B)被显示出来，可以设定底线余量调整计数器的动作（ON/OFF）。

Set the bobbin thread remaining amount adjustment counter to ON.

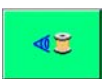
Press BOBBIN THRESD REMAINING AMOUNT ADJUSTMENT COUNTER MOTION SETTING button ②, and “bobbin thread remaining amount adjustment counter setting pop-up screen (screen B)” is displayed. Then the bobbin thread remaining amount adjustment counter motion (ON/OFF) can be set .

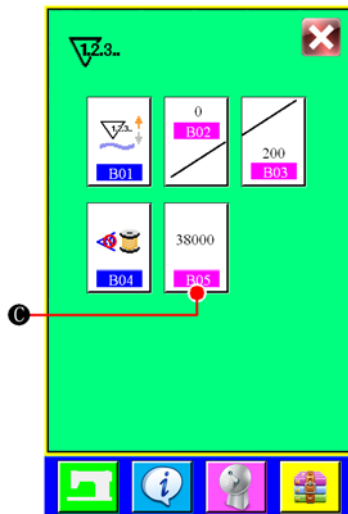


设定底线余量调整值计数器的凸起画面(画面B)

Bobbin thread remaining amount adjustment counter setting pop-up screen (screen B)

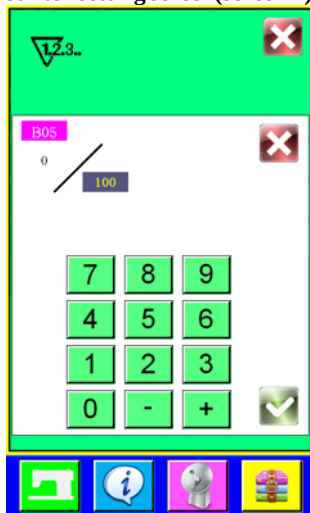
【检测底线余量】	
	底线余量调整计数器 ON: 每缝完1工件后计数器值减去当前的缝纫长度，达到0之后，显示计数器画面。
	底线余量调整计数器 OFF: 设定禁止底线余量检测。

【Bobbin thread remaining amount detection】	
	Bobbin thread remaining amount adjustment counter ON: The counter detects the reflecting light from bobbin and informs that bobbin thread remaining amount is running out. Every time one sewing is performed, the counter value is subtracted and the count-up screen is displayed when the existing value is reached to “0”.
	Bobbin thread remaining amount adjustment counter OFF Bobbin thread remaining amount detection is set to the prohibition.



设定计数器画面(画面A)

Counter setting screen(screen A)



设定底线余量调整值画面(画面B)

Bobbin thread remaining amount adjustment value setting screen (screen B)

3) 设定底线余量调整值

按了调整底线余量调整值按钮  ① 之后, 设定底线余量调整值画面(画面B)被显示出来。

Set the bobbin thread remaining amount adjustment value

Press BOBBIN THREAD REMAINING AMOUNT ADJUSTMENT

VALUE SETTING button  ① and the bobbin thread remaining amount adjustment value setting screen (screen B) is displayed.

这时, 请输入底线余量调整值 (50~57000)。



底线余量值是指一个梭芯绕满后上面线的总长。

• 余量发生下列情况时, 需要重新调整。

1. 更换新的梭芯时
2. 底线线号变更后

• 输入了底线余量调整计数器值之后原来的底线余量计数器值被清除。

Here, input the bobbin thread remaining amount adjustment value (50~57000)



The bobbin thread remaining amount refers to the overall length of thread when the bobbin is full.

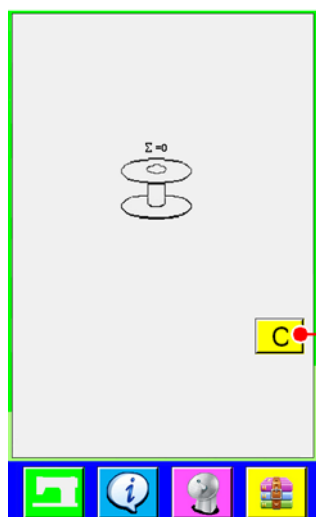
When any of the following conditions occurs, the bobbin thread remaining amount needs readjusting.

1. Replacement of the bobbin
2. Changeover the bobbin thread size

Inputting the new value, and the primary bobbin thread remaining amount value will be cleared.

(2) 解除底线余量调整计数器的计数的方法

Releasing procedure of the bobbin thread remaining amount detection count-up



缝制结束时, 底线余量计数器值达到0的话, 显示计数画面, 蜂鸣器鸣响。请更换梭芯。

按了清除按钮  ① 之后, 复位底线余量计数器值, 然后返回缝制画面。

When the bobbin thread remaining amount counter value becomes “0” at the sewing end, the count-up screen is displayed and the buzzer sounds. Replace the bobbin thread of the bobbin.

When CLEAR button  ① is pressed, the bobbin thread remaining amount counter value is reset and the screen returns to the sewing screen.

5. 缝制图案的使用

USING THE SEWING PATTERN

(1) 选择图案

Performing the selection of pattern

1) 显示输入画面

显示出输入画面之后，便可以选择图案。

2) 叫出图案一览画面

按了图案一览按钮  ① 之后，图案一览画面被显示出来。

Display the input screen

When the input screen is displayed, the selection of pattern can be selected.

Call the pattern list screen

Press PATTERN LIST button  ① and the pattern list screen is displayed.

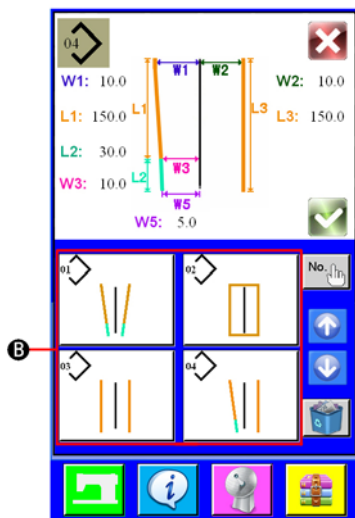


3) 选择图案

请按想选择的图案数据 ②。

Select the pattern

Press pattern data you desire to select ②.



4) 确定图案

按了确定按钮  之后，图案被选择，返回到输入画面。

Determine the pattern

When ENTER button  ③ is pressed, the pattern is selected and the screen returns to the input screen.

(2) 编制新图案

Performing the new creation of pattern

1) 显示输入画面

显示出输入画面之后，便可以编制新图案。

2) 叫出编制新缝制图案画面

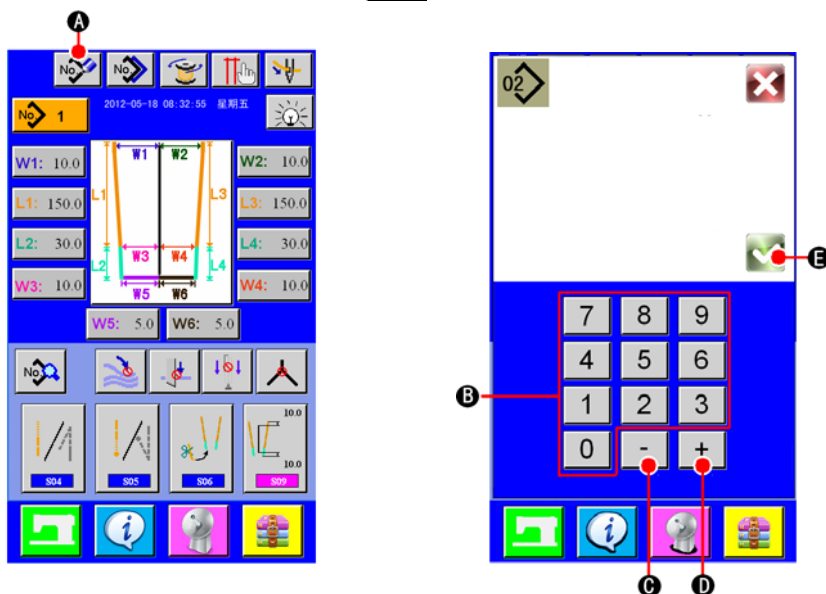
按了编制新按钮  (A) 之后，编制新图案画面被显示出来。

Display the input screen

When the input screen is displayed, the new creation of pattern can be performed.

Call the sewing pattern new creation screen

Press NEW CREATION button  (A) and the pattern new creation screen is displayed.



3) 输入图案No.

请用十数字键  ~  (B) 输入想新编制的图案No.。也可以用-、+按钮 ( (C) ·  (D)) 检索未登记的缝制图案No.。

4) 确定图案No.

按了确定按钮  (E) 之后，确定新编制的图案No.，然后返回输入画面。

Input the pattern No.

Input pattern NO,you desire to newly create with the keys  to  (B). It is possible to retrieve pattern NO.which has not been registered yet with “-,”+” button  (C) and  (D).

Determine the pattern No.

When ENTER button  (E) is pressed, the pattern NO.to newly create is determined and the screen returns to the input screen

(3) 复制图案

Copying the pattern

可以把已经登记的图案复制到为登记的缝制图案里。因为禁止图案改写复制，所以想改写时，请事先删除该图案。

→有关图案的删除方法请参阅“VI-5.(4)删除图案”。

The pattern which has been already registered can be copied to the sewing pattern which has not registered yet. Copying of overwriting of pattern is prohibited. So, when you desire to overwrite, perform it after erasing the pattern once.

→For the erasing procedure, see "VI-5.(4) Erasing the pattern".



想要向已经登记完了的图案 No.复制时，不能复制错误(E43)会显示出来。

When performing copying the pattern No. which has been already registered, copy disapproved error (E43) is displayed.

1) 显示输入画面

显示出输入画面之后，便可以复制图案。

2) 叫出复制原图案 No. 一览画面

按了复制图案按钮 (A) 之后，复制原图案一览画面被显示出来。

Display the input screen

When the input screen is displayed, it is possible to copy.

Call the pattern No. list screen of the copy source

Press PATTERN COPY button  (A) and the copy source pattern list screen is displayed .



3) 选择复制原图案

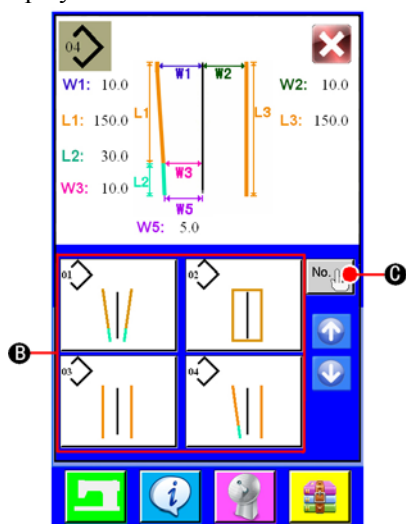
请从图案一览按钮 ② 中选择复制原图案。

接着，按了复制原图案No. 输入按钮  ③ 之后，复制原图案No. 输入画面（画面B）被显示出来。

Select the pattern of copy source

Select the pattern of copy source from PATTERN LIST button ②.

Next, press COPY DESTINATION NO. INPUT button  ③ and the copy destination input screen(screen B) is displayed.

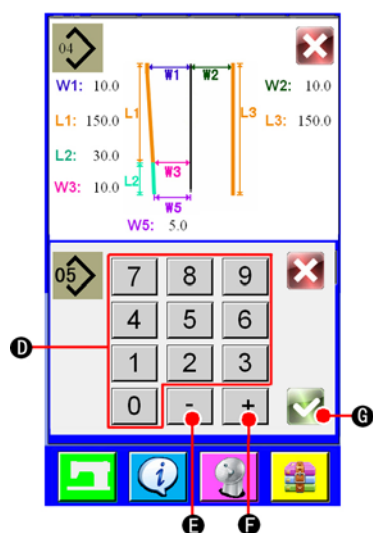


4) 输入复制处的图案No.

请用十数字键  ~  ④ 输入复制原图案 No.。也可以用-、+按钮（ ⑤ ·  ⑥）检索未使用的图案。

Input the pattern No. of copy destination

Input the pattern No. of copy destination with ten keys  or  ④. It is possible to retrieve the pattern No. which has not been used yet with -, + buttons  ⑤ and  ⑥.



复制原图案No.输入画面(画面B)
Copy destination No. input screen (screen B)

5) 开始复制

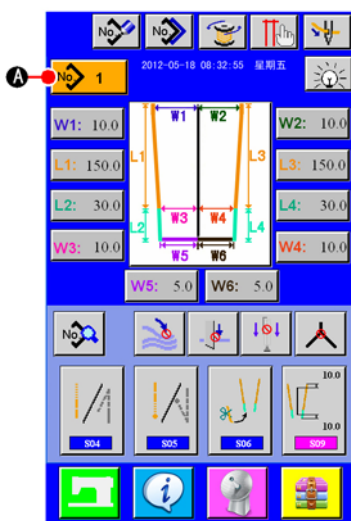
按了确定按钮  ⑦ 之后开始复制。被复制的图案No. 在选择状态将返回复制原图案一览画面(画面A)。

Start copying

When ENTER button  ⑦ is pressed, copying start. The pattern No. which has been copied is in the selection state and returns to the copy source pattern list screen (screen A).

(4) 删除图案

Erasing the pattern



1) 显示输入画面

显示出输入画面之后，便可以删除图案。

2) 叫出图案一览画面

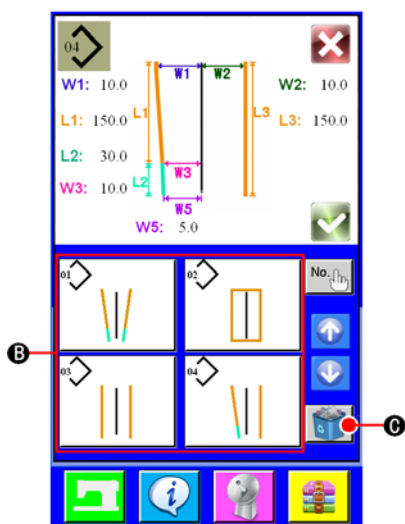
按了图案一览按钮  (A) 之后，图案一览画面被显示出来。

Display the input screen

When the input screen is displayed, it is possible to erase the pattern.

Call the pattern list screen

Press PATTERN LIST button  (A) and the pattern No. list screen (screen A) is displayed



3) 选择删除的图案

请从图案一览按钮 (B) 中选择删除的图案。

接着，选择了删除按钮  (C) 之后，确认图案删除画面被显示出来。

Select the pattern to be erased

Select the pattern to be erased from pattern list button (B).

Next, press ERASE button  (C) and the pattern erase confirmation screen is displayed

图案 No. 一览画面(画面A)

Pattern No. list screen (screen A)

4) 确定删除的图案

在确认图案删除画面上，按了确定按钮  之后，图案被删除。如果按取消按钮  的话，则不删除返回到原来的画面A。

如果当前只剩 1 个花样，那么删除按键不使能。

Determine the pattern to be erased

Press ENTER button  in the pattern erase confirmation screen and the pattern is erased. When CANCEL button  is pressed, the screen returns to the original screen A without erasing the pattern.

If it is the last pattern, the ERASE button will be disabled.

6. 变更缝制数据

CHANGING THE SEWING DATA

(1) 缝制数据的变更方法

Changing procedure of the sewing data

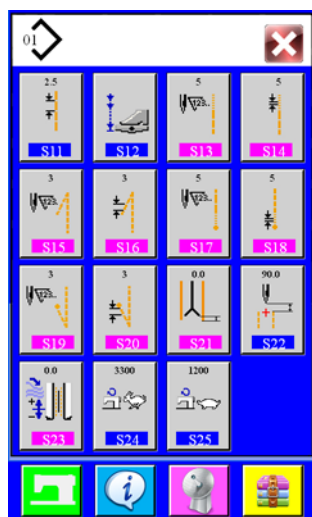
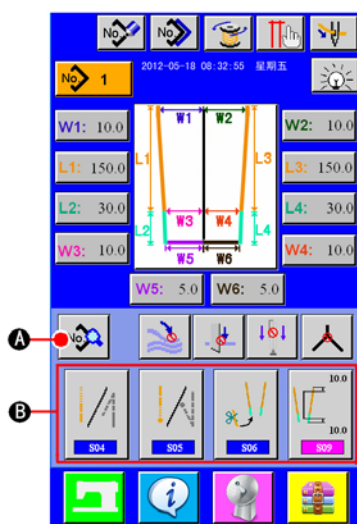
1) 显示输入画面

显示出输入画面之后，便可以变更缝制数据。经常使用的缝制数据已经显示输入画面的下方区域⑧，并可以直接设定。而且，详细的缝制数据，按了  ⑨ 之后，也可以设定。

Display the input screen

When the input screen is displayed it is possible to change the swing data.

The sewing data which are frequently used can be registered to SEWING DATA SHORTCUT button ⑧ in the input screen and be set directly. In addition, the detailed sewing data can be set by pressing  ⑨.



缝制数据一览画面(画面 A)
Sewing data list screen (screen A)

2) 选择变更的缝制数据

按了  ⑨ 之后，缝制数据一览画面(画面 A)被显示出来，请选择想变更的数据。

Select the sewing data to be changed

Press  ⑨ and the sewing data list screen (screen A) is displayed. Then select the data you desire to change.

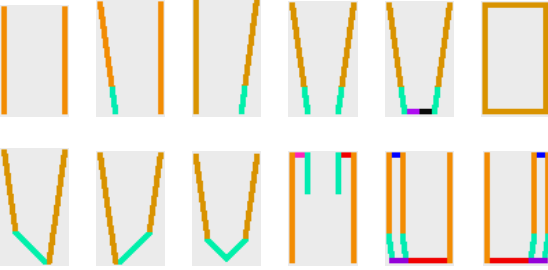


有的形状，不能使用的数据项目不能显示，请注意。

Data items which are not used due to the shape are not displayed. So, be careful.

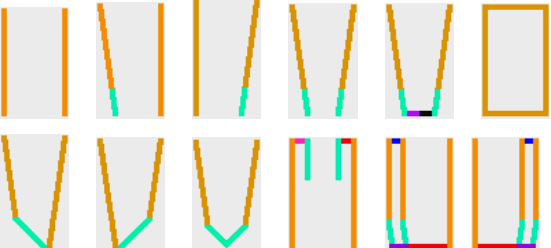
(2) 缝制数据一览

1) 在数据输入画面显示的项目

No.	项目	设定范围 / 编辑单位	初期值
S01	变换中刀选用/不选用 选择中刀选用/不选用  不选用  选用	---	
S02	变换夹杆堆叠器停止/动作 选择夹杆堆叠器的停止/动作 * S01 仅设定夹杆堆叠器安装时显示。  停止  动作	---	
S03	变换缝纫样式 选择缝纫样式 	---	
S04	选择开始缝制缩缝/ 倒缝 选择开始缝制缩缝 / 倒缝  缩缝  倒缝	---	
S05	选择结束缝制缩缝 / 倒缝 选择结束缝制缩缝 / 倒缝。  缩缝  倒缝	---	
S06	变换转角剪线模式 选用/不选用转角剪线模式  不选用  选用	---	
S07	变换对条对格装置 选用/不选用对条对格装置  不选用  选用	---	
S08	变换角刀 选用/不选用角刀 (此功能需要机械附件支持)  不选用  选用	---	
S09 S10	设定中心刀动作位置 进行中心刀动作位置的设定 * S09 设定中刀收刀位置； S10 设定中刀落刀位置。 	S09: ±50mm S10: 0~30mm	S09: - 20mm S10: 5mm

Sewing data list

1) Items that are displayed in the data input screen

No.	Item	Setting range / Edit unit	Initial value
S01	Center knife stop/motion change-over Stop/motion of center knife is selected.  Stop  Motion	---	
S02	Clamp bar stacker stop/motion change-over Stop/motion of clamp bar stacker is selected. * It is displayed only when SP-01 is set to clamp bar stacker mounting.  Stop  Motion	---	
S03	Sewing pattern change-over Sewing pattern is selected. 	---	
S04	Selection of condensation/back tack at sewing start Condensation/back tack at sewing start is selected  Condensation  Back tack	---	
S05	Selection of condensation/back tack at sewing end Selection of condensation/back tack at sewing end is performed.  Condensation  Back tack	---	
S06	Selection of corner cut pattern Choose /not choose corner cut pattern.  Not choose  Choose	---	
S07	Selection of alignment unit Choose /not choose alignment unit  Not Choose  Choose	---	
S08	Selection of corner knife Choose /not choose corner knife (This function need machinery accessories support)  Not Choose  Choose	---	
S09	The center knife action position setting Set the center knife action position * S09 set the ending position of the center knife; S10 set the starting position of the center knife 	S09: ±50mm	S09: - 20mm
S10		S10: 0~30mm	S10: 5mm

2) 在缝制数据一览画面显示的项目

No.	项目	设定范围 / 编辑单位	初期值
S11	平缝间距 设定平缝部分的缝制间距 	1.0~3.4 / 0.1mm	2.5mm
S12	设定脚踏板动作模式 选择脚踏板动作模式  单步模式  连续模式	---	
S13	开始缝制缩缝针数 设定开始缝制缩缝针数。 * S04 仅选择缩缝时可以设定。 	3~30 / 1针	5针
S14	开始缝制缩缝间距 设定开始缝制缩缝间距。 * S04 仅选择缩缝时可以设定。 	1.0~1.5 / 0.1mm	1.0mm
S15	开始缝制倒缝针数 设定开始缝制倒缝针数。 * S04 仅选择倒缝时可以设定。 	1~30 / 1针	3针
S16	开始缝制倒缝间距 设定开始缝制倒缝间距。 * S04 仅选择倒缝时可以设定。 	1.0~3.0 / 0.1mm	2.0mm
S17	结束缝制缩缝针数 设定结束缝制缩缝针数。 * S05 仅选择缩缝时可以设定。 	3~30 / 1针	5针
S18	结束缝制缩缝间距 设定结束缝制缩缝间距。 * S05 仅选择缩缝时可以设定。 	1.0~1.5 / 0.1mm	1.0mm

No.	项目	设定范围 / 编辑单位	初期值
S19	结束缝制倒缝针数 设定结束缝制倒缝针数。 * S05 仅选择倒缝时可以设定。 	1~30 / 1针	3针
S20	结束缝制倒缝间距 设定结束缝制倒缝间距。 * S05 仅选择倒缝时可以设定。 	1.0~3.0 / 0.1mm	2.0mm
S21	转角针距 设定转角针距 	0.5~2.5 / 1mm	2.0mm
S22	标记光到机针距离 设定标记光到机针的距离。 	10~200 / 1mm	90mm
S23	设置堆叠器位置 缝纫动作完成后，让大压脚移动设定距离，堆叠器动作 	-200~200 / 1mm	0mm
S24	缝纫机高速转速 设定缝纫机头的转速。 	1900~ 4000 / 350rpm	3300rpm
S25	缝纫机低速转速 设定缩缝、倒缝部分缝纫机头的转速。 * S24 受缝纫机高速转速的限制。 	500~ 1550 / 350rpm	500rpm

2) Items that are displayed in the sewing data list screen

No.	Item	Setting range / Edit unit	Initial value
S11	Lockstitch pitch Sewing pitch of lockstitch section is set. 	1.0~3.4 / 0.1mm	2.5mm
S12	Pedal operation mode change-over * Mode to be used for foot pedal is set.  One step mode  Continuous mode	---	
S13	Number of condensation stitches at sewing start Number of condensation stitches at sewing start is set. * It is possible to set only when S04 is set to selection of condensation. 	3~30 / 1stitch	5stitch
S14	Condensation pitch at sewing start Condensation sewing pitch at sewing start is set. * It is possible to set only when S04 is set to selection of condensation. 	1.0~1.5 / 0.1mm	1.0mm
S15	Number of back tack stitches at sewing start Number of back tack stitches at sewing start is set. * It is possible to set only when S04 is set to selection of back tack. 	1~30 / 1stitch	3stitch
S16	Back tack pitch at sewing start Back tack sewing pitch at sewing start is set. * It is possible to set only when S04 is set to selection of back tack. 	1.0~3.0 / 0.1mm	2.0mm
S17	Back tack pitch at sewing end Back tack sewing pitch at sewing end is set. * It is possible to set only when S05 is set to selection of back tack. 	3~30 / 1stitch	5stitch
S18	Condensation pitch at sewing end Condensation sewing pitch at sewing end is set. * It is possible to set only when S05 is set to selection of condensation. 	1.0~1.5 / 0.1mm	1.0mm
S19	Number of back tack stitches at sewing end Number of back tack stitches at sewing end is set. * It is possible to set only when S05 is set to selection of back tack. 	1 ~ 30 / 1 stitch	3 stitch
S20	Back tack pitch at sewing end Back tack sewing pitch at sewing end is set. * It is possible to set only when S05 is set to selection of back tack. 	1.0 ~ 3.0 / 0.1mm	2.0mm

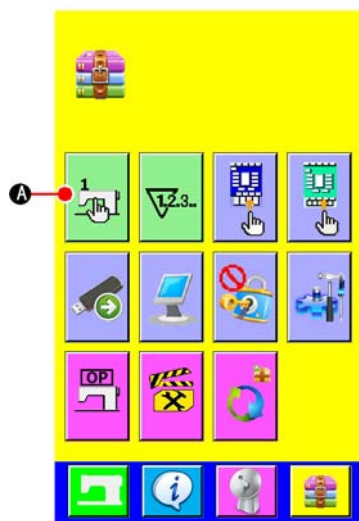
No.	Item	Setting range / Edit unit	Initial value
S21	Needle pitch at sewing corner Set the needle pitch at sewing corner. 	0.5~2.5 / 1mm	2.0mm
S22	The distance between marking light and needle Set the distance between marking light and needle. 	10~200 / 1mm	90mm
S23	Stacker position setting After complete sewing ,big foot move to the designated spot and stacker action 	-200~200 / 1mm	0mm
S24	Sewing speed under the high-speed mode Number of revolutions at lockstitch section is set. 	1900 ~ 4000 / 350rpm	3300rpm
S25	Sewing speed under the low-speed mode Number of revolutions at condensation and back tack sewing sections is set. It is limited by S24 sewing speed under the high-speed mode. 	500 ~ 1550 / 350rpm	500rpm

7. 变更存储器开关数据

CHANGING THE MEMORY SWITCH DATA

(1) 存储器开关数据的变更方法

Changing procedure of the memory switch data

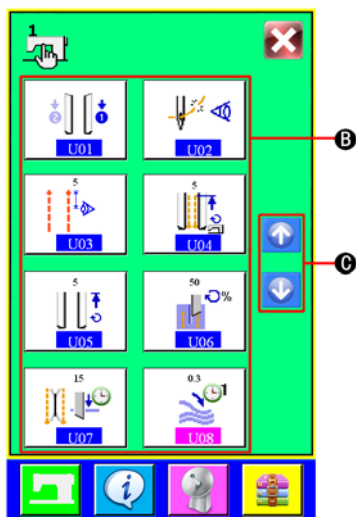


1) 显示存储器开关数据一览画面

按了模式变换键之后，画面上存储器开关按钮 ① 被显示。按此按钮之后，存储器开关数据一览画面(画面 A)被显示出来。

Display the memory switch data list screen

Press MODE CHANGE-OVER key  and the memory switch button  ① is displayed. When this button is pressed, the memory switch data list (screen A) is displayed.



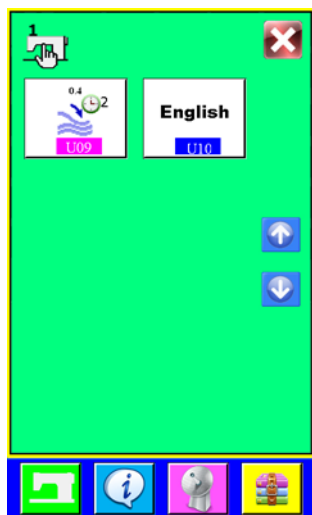
2) 选择想变更的存储器开关按钮

按了上下滚动按钮 ②，显示所有选项，选择想变更的数据项目按钮 ③。

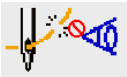
Select the memory switch button you desire to change

Press UP/DOWN SCROLL button  or  ② and select DATA ITEM button ③ you desire to change.

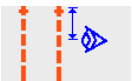
存储器开关数据一览画面(画面 A)
Memory switch data list screen
(screen A)



(2) 存储器开关数据一览

No.	项目	设定范围 / 编辑单位	初期值
U01	变换大压脚下降顺序 选择大压脚的下降顺序。 	---	
U02	选择断线检测 选择有/无断线检测。  有断线检测  无断线检测	---	
U03	断线传感器延时启动 设定缝制多长缝绉距离后传感器开始检测 	1~50mm / 1mm	15mm
U04	至开始缝制位置的空送速度 设定压脚至开始缝制位置的空送速度 	3~9 / 1	5
U05	大压脚返回速度 设定大压脚返回到后定位点的速度 	3~9 / 1	5
U06	中刀电机速度 设定中刀电机的速度 	30%~99% / 1%	60%
U07	中刀下降时间 设定中刀下降时间 	10~100 / 1	40
U08	堆叠器定时器1 从大压脚抬起到堆叠器开始夹布时间。 	0.0~9.9 / 0.1S	0.5S
U09	堆叠器定时器2 堆叠器开始拖布到堆叠器松布时间。 	0.0~9.9 / 0.1S	0.8S
U10	选择语言 选择在操作盘上显示的文字语言。 	---	---

Memory switch data list

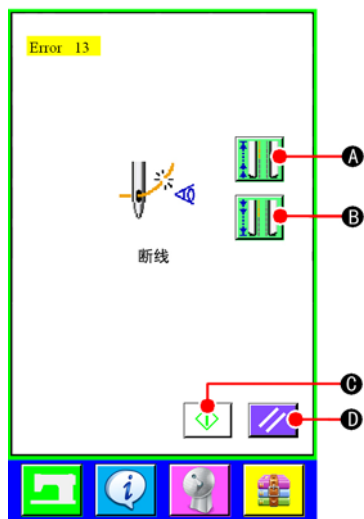
No.	Item	Setting range / Edit unit	Initial value
U01	Flap presser motion mode Motion order of flap presser is selected. 	---	
U02	Thread breakage detection With/without thread breakage detection is selected. 	---	
U03	Time delay activated of thread braskage sensor Time delay activated of thread braskage sensor is set. 	1~50mm / 1mm	15mm
U04	Jump feed speed up to the position of sewing starting Jump feed speed up to the position of sewing starting is set. 	3~9 / 1	5
U05	Return speed of clamp foot The speed of clamp foot returned to the backward setpoint is set. 	3~9 / 1	5
U06	The speed of center knife The speed of center knife is set. 	30%~99% / 1%	60%
U07	Falling time of center knife The falling time of center knife is set. 	10~100 / 1	40
U08	Stacker timer 1 Waiting time from lifting the clamp to the start of clamping piece. 	0.0~9.9 / 0.1S	0.5S
U09	Stacker timer 12 Waiting time from the start of pulling pse to release the piece. 	0.0~9.9 / 0.1S	0.8S
U10	Language selection Language to be indicated in the panel is selected. 	---	---

(3) 断线报警

Thread breakage alarm

当开启了断线检测功能时，如果缝纫过程中出现断线，机器停止动作，同时跳出断线报警画面（画面 A）。

Opening threadbreakage detection ,when When thread breakage has occurred during machine running,the machine will stop working and “thread breakage alarm screen (screen A) is displayed at the samne time.”



断线报警画面（画面 A）

Thread breakage alarm screen (screenA)

- 1) 穿好线以后，按下后补针按钮  ①,大压脚往后拖布；按下前补针按钮  ②，大压脚往前拖布。可以利用此功能将布送到断线点。
- 2) 如果按下开始启动按钮  ③，当前报警画面（画面 A）关闭，进入缝制画面继续缝纫。如果按下复位按钮  ④，当前报警画面（画面 A）关闭，进行错误复位，然后显示输入画面。

Press backward key  ① and the presser returns stitch by stitch,

Press forward key  ② and the presser advances stitch by stitch,and with this method, you can return the presser to the re-sewing position

Pressing START button  ③,the sewing screen is displayed and sewing starts again.

Pressing RESET button  ④ ,machine restarts and the input screen is displayed.

8. 设定选购项

PERFORMING OPTIONAL SETTING

(1) 选购项设定的变更方法

Changing procedure of the optional setting



1) 显示设定选购项一览画面

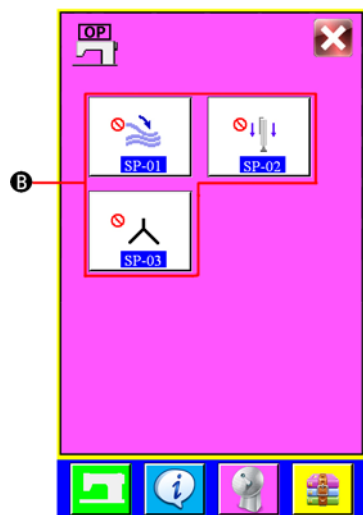
在画面上按设定选购项按钮  (A) 之后，设定选购项一览画面 (画面A) 被显示出来。

Displaying the optional setting list screen

Pressing MODE CHANGEOVER key  , OPTIONAL SETTING

button  (A) is displayed on the screen.

Press this button and the optional setting list screen (screen A) is displayed.



2) 选择想变更的选购项设定

请选择想变更的数据项目按钮 (B)。

Selecting the option setting you want to change

Select DATA ITEM button (B) you want to change.

设定选购项一览画面(画面A)

Optional setting list screen (screen A)

(2) 设定选购品一览

Optional setting list

设定选购品的安装状态之后，各选购品就可以动作。

No.	项目	设定范围 / 编辑单位	初期值
SP-01	设定安装/未安装夹杆堆积器  未安装  安装	---	 未安装
SP-02	设定安装/未安装对条对格装置  未安装  安装	---	 未安装
SP-03	设定安装/未安装角刀装置  未安装  安装	---	 未安装

By setting the optional mounted state, it is possible to perform the respective optional operations.

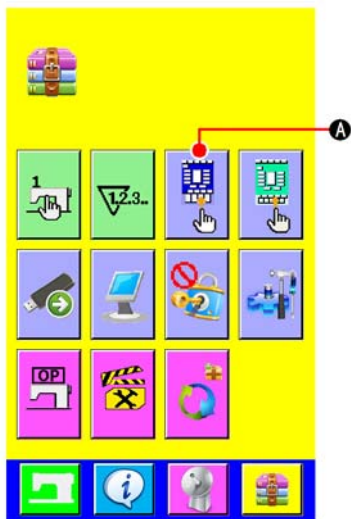
No.	Item	Setting range / Edit unit	Initial value
SP-01	Clamp bar stacker mounting/not mounting is set  Not mounting  Mounting	---	
SP-02	Alignment unit mounting/not mounting is set.  Not mounting  Mounting	---	
SP-03	Corner knife mounting/not mounting is set.  Not mounting  Mounting	---	

9. 管理数据输入画面

CUSTOMIZING THE DATA INPUT SCREEN

在数据输入画面上显示的按钮，可以根据用户的使用情况进行管理。

Buttons displayed in the data input screen can be customized in accordance with the customers' using conditions.

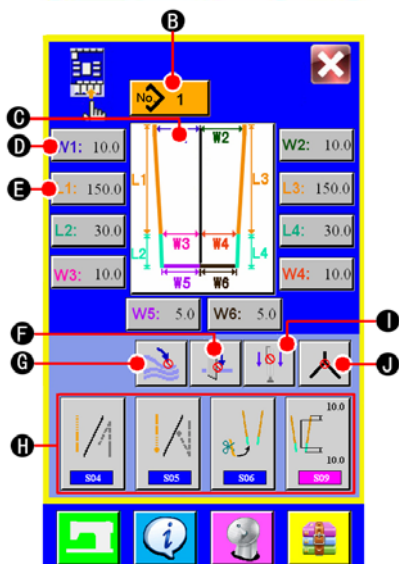


1) 显示输入画面的管理画面

按模式变换键之后，在画面上输入画面的管理按钮 (A) 被显示出来。按此按钮之后，输入画面的管理画面被显示出来。

Display the customizing screen of the input screen

Pressing MODE CHANGEOVER key , and CUSTOMIZE button  (A) is displayed on the screen. When this button is pressed, the customizing screen of the input screen is displayed.

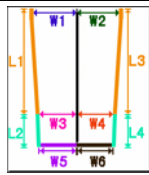
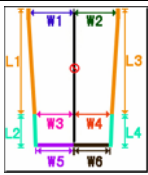
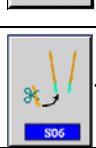
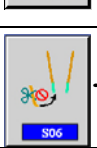


2) 选择按钮状态

⑧～⑪按钮，每按之后可以变换钮扣显示/不显示。请根据用户的使用情况进行管理使用。

Select the conditions of buttons

Every time the buttons from ⑧ to ⑪ are pressed, display/non display of the buttons can be changed over. Customize and use the buttons in accordance with the customers' using conditions.

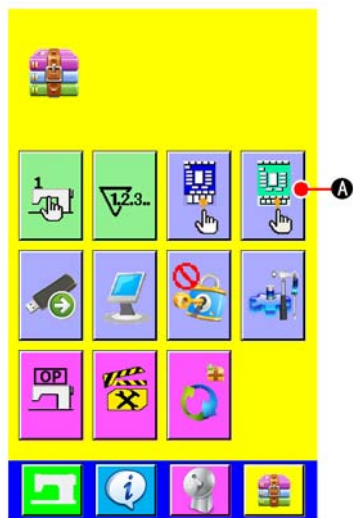
符号 Symbol	显示 Display	不显示 Non display	内容 Description	初期状态 Initial state
B			图案一览按钮 Pattern list button	显示 Display
C			变换缝制模式 Sewing mode change-over	显示 Display
D			设定W尺寸 W size setting	显示 Display
E			设定L尺寸 L size setting	显示 Display
F			变换中刀禁止/动作 Center knife change-over	显示 Display
G			变换堆叠器禁止/动作 Stacker motion mode change-over	显示 Display
H			快捷功能键设置组 Function Shortcut unit change-over	显示 Display
I			变换对条对格装置动作 Alignment unit change-over	显示 Display
J			变换角刀禁止/动作 Corner knife change-over	显示 Display

10. 设定缝制画面的管理

PERFORMING THE CUSTOMIZING SETTING OF THE SEWING SCREEN

输入数据画面上显示的按钮，可以根据用户的使用情况进行管理。

Buttons displayed in the data input screen can be customized in accordance with the customers' using conditions.

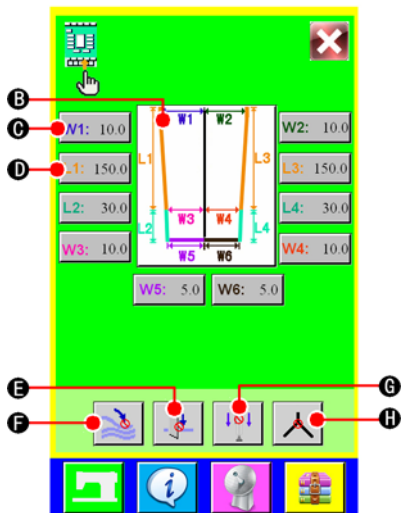


1) 显示缝制画面的管理画面

按此按钮  (A) 之后，缝制画面的管理画面被显示出来。

Display the customizing screen of the sewing screen

Pressing SEWING SCREEN CUSTOMIZING button  (A) which is displayed on the screen and then the customizing screen of sewing screen displayed.



2) 选择按钮状态

(B) ~ (H) 按钮，每按之后可以变换钮扣显示/不显示。请根据用户的使用情况进行管理使用。

Set the conditions of buttons

Every time the buttons from (B) to (H) are pressed, button display/non display can be changed over. Customize and use the buttons in accordance with the customers' using conditions.

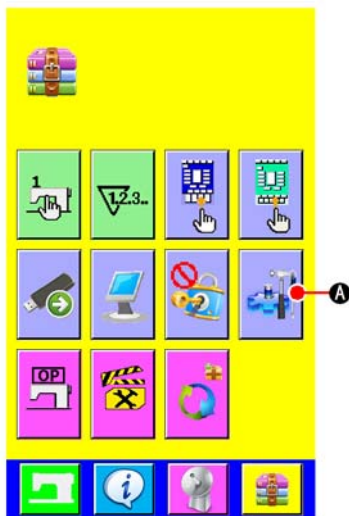
符号 Symbol	显示 Display	不显示 Non display	内容 Description	初期状态 Initial state
B			变换缝制模式 Sewing mode change-over	不显示 Non display
C			设定W尺寸 W size setting	不显示 Non display
D			设定L尺寸 L size setting	不显示 Non display
E			变换中刀禁止/动作 Center knife change-over	不显示 Non display
F			变换堆叠器禁止/动作 Stacker motion mode change-over	不显示 Non display
G			变换对条对格装置动作 Alignment unit change-over	不显示 Non display
H			变换角刀禁止/动作 Corner knife change-over	不显示 Non display

11. 测试

TEST

(1)测试方法

Test method



1) 显示测试画面

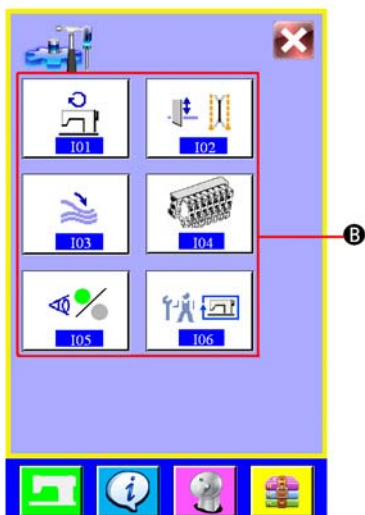
按了模式变换键之后，画面上测试按钮被显示。按此按钮之后，测试画面（画面 A）被显示出来。

※ 此功能为维修人员使用，所以进入此功能时需要输入密码。服务密码请与生产厂家联系。

Display test screen

Pressing I/O TEST button  and the test screen (screen A) is displayed.

* This function can only be used by maintainer,so, users need to enter a password to access, and you can get the password from manufacturer.



测试画面（画面 A）

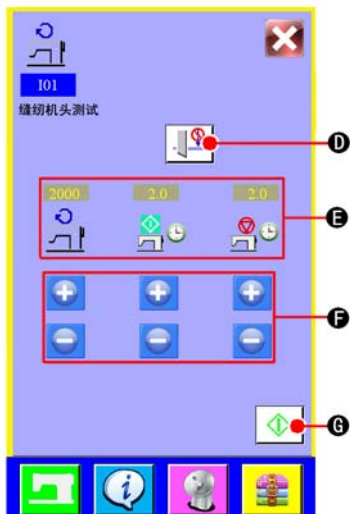
Test screen (screen A)

2) 在可选区域 ② 中选择想要测试的按钮

IO1	缝纫机头测试
IO2	中刀电机测试
IO3	堆叠器测试
IO4	输出端口测试
IO5	输入端口测试
IO6	整机自动测试

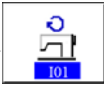
Select the IO port button you want to test in the selection area ②.

IO1	Sewing machine head test
IO2	Center motor test
IO3	Stacker test
IO4	Output port test
IO5	Input port test
IO6	Sewing machine running test



缝纫机头测试画面（画面 B）
Sewing machine head test screen
(screen B)

3) IO1 缝纫机头测试

按了缝纫机头测试按钮  之后，缝纫机头测试画面（画面 B）被显示。

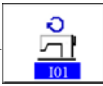
① 按了按钮 ① 之后，设定测试时中刀动作或不动作。

显示	内容
	中刀动作
	中刀不动作

② 按 ② 中的+、-键 、 设定 ② 中与之相对应的机头电机转速 、启动时间 、停止时间 。

③ 按启动键  ③ 开始测试。

IO1 sewing machine head test

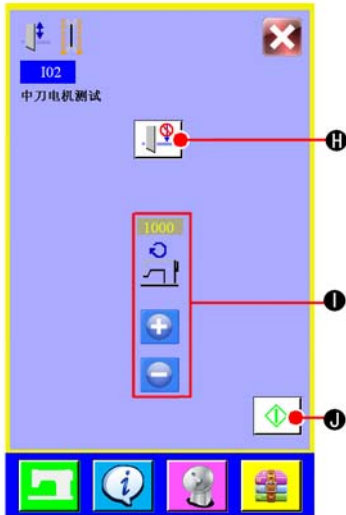
Press the sewing machine head test button  and the sewing machine head test screen (screen B) is displayed.

① Press button ①, and set whether to actuate middle knife action or not .

Display	Description
	To actuate
	Not to actuate

② Press up/down button   ② to adjust ② the motor speed of machine head , starting time  and stopping time .

③ Press START KEY  ③ to start testing.



4) IO2 中刀电机测试

① 按了按钮 **H** 之后，设定测试时中刀放下或中刀不放下。

显示	内容
	中刀放下
	中刀不放下

② 在 **I** 中按 、 键设置中刀电机速度。

③ 按启动键 **J** 开始测试。

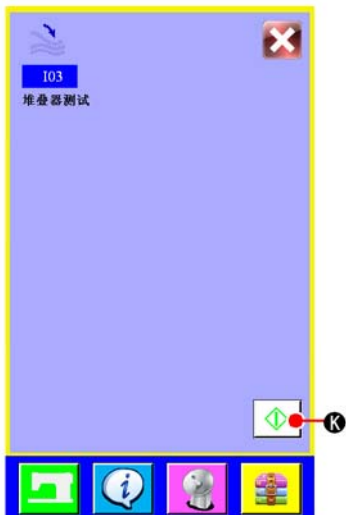
IO2 center motor test

① Press button **H**, and set whether to put down the center knife or not.

Display	Description
	To put down the center knife
	Not to put down the center knife

② Press up/down button **I** to adjust the motor speed of center knife.

③ Press START KEY **J** to start testing.

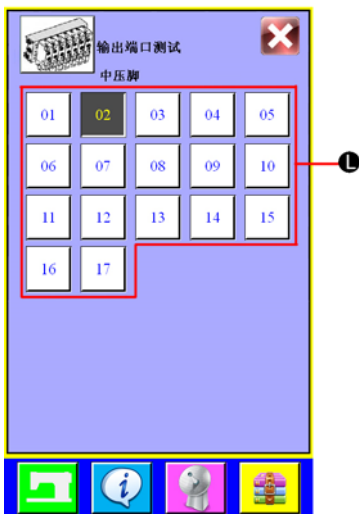


5) IO3 堆叠器测试

按启动键 **K** 直接开始堆叠器测试。

IO3 stacker test

Press START KEY **K** to start testing.



6) IO4 输出端口测试

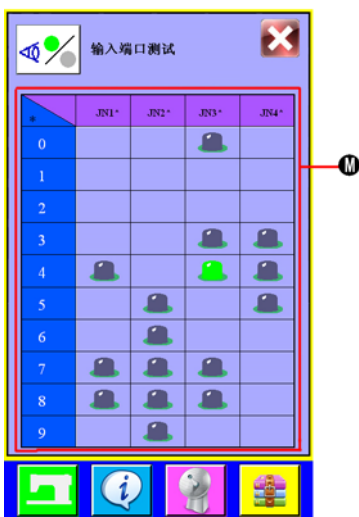
在 ① 中选择想要测试的输出端口（即电磁阀）。

显示	内容
	电磁阀动作
	电磁阀不动作

IO4 output port test

Select the output port (magnetic valve) button ① you want to test.

Display	Description
	To actuate
	Not to actuate



7) IO5 输入端口测试

在 ② 中选择想要测试的输入端口（即传感器），如左图测试的是传感器 JN34

显示	内容
	传感器有信号
	传感器无信号

IO5 input port test

Select the input port (sensor) button ② you want to test. The test port number is JN34 as at left.

Display	Description
	Signal
	No signal

8) IO6 整机测试

按启动键 ③ 直接开始整机自动测试。

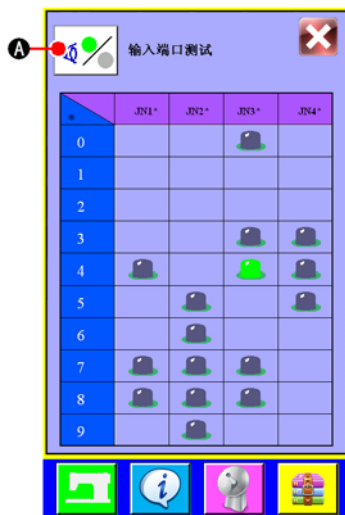
IO6 sewing machine running test

Press START KEY ③ to start testing.



(2) 显示输入/输出端口一览表

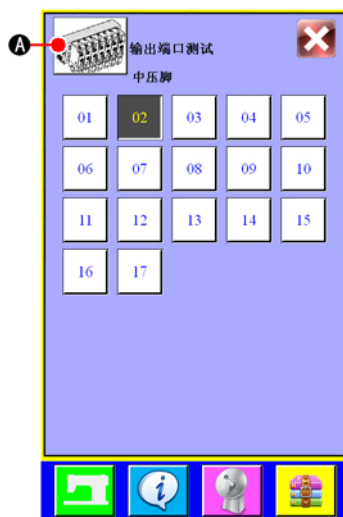
Display the input/output port list



输入测试画面（画面 A）
Input test screen (screen A)

在输入测试画面（画面 A），按下按钮  A，显示输入端口一览表。

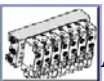
Press button  A in the input test screen, and then input list will displayed.



输出测试画面（画面 B）
Output test screen (screen B)

同理，

在输出测试画面（画面 B），按下按钮  A，显示输出端口一览表。

Press button  A in the output test screen, and then output list will displayed.

输入端口（传感器）一览表

上针位检测	JN14
脚踏板前进	JN17
脚踏板后退	JN18
检测针离开针板的位置	JN25
检测大压板前移动行程	JN26
检测大压板后移动行程	JN27
检测中刀位置	JN28
检测机头原点位置	JN29
检测中间位置	JN30
检测左边宽度	JN33
检测右边宽度	JN34
送布电机左位置检测	JN37
送布电机右位置检测	JN38
断线传感器	JN45

Input port (sensor) list

Needle upper position detection	JN14
Foot pedals forward	JN17
Foot pedals backward	JN18
The distance between needle and needle plate detection	JN25
Clamp foot forward movement detection	JN26
Clamp foot backward movement detection	JN27
Center knife position detection	JN28
Initial point of machine head detection	JN29
Middle position detection	JN30
Left widen detection	JN33
Right widen detection	JN34
Pull motor left position detection	JN37
Pull motor right position detection	JN38
Thread breakage sensor	JN45

输出端口（电磁阀）一览表

控制中刀下降电磁阀	EC01
控制压脚上下电磁阀	EC02
固定切刀电磁阀	EC03
角刀切断电磁阀	EC04
三角刀电磁阀	EC05
控制吹气使布料平整电磁阀	EC06
对条对格中压布电磁阀	EC07
对条对格左压布电磁阀	EC08
对条对格右压布电磁阀	EC09
辅助堆叠器送料气缸上下动作电磁阀	EC10
辅助堆叠器送料气缸前后运动电磁阀	EC11
左大压板压下电磁阀	EC12
右大压板压下电磁阀	EC13
堆叠器抓取衣物电磁阀	EC14
堆叠器短气缸电磁阀	EC15
堆叠器长气缸电磁阀	EC16
吸气装置电磁阀	EC17

Output port (magnetic valve) list

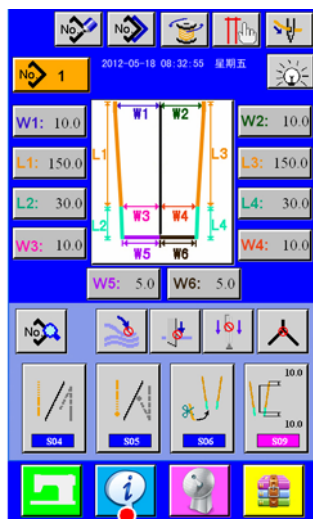
Center knife up/down	EC01
Clamp foot up/down	EC02
Fix cutting knife	EC03
Cutting knife	EC04
Corner knife	EC05
Blow cylinder	EC06
Middle presser of alignment unit	EC07
Left presser of alignment unit	EC08
Right presser of alignment unit	EC09
Assist stacker feed cylinder up and down	EC10
Assist stacker feed cylinder move back and forth	EC11
Left clamp foot press down	EC12
Right clamp foot press down	EC13
Gripper of stacker	EC14
Short cylinder of stacker	EC15
Long cylinder of stacker	EC16
Getter device	EC17

12. 使用信息方法

USING THE INFORMATION

在信息功能中有以下5种功能。

There are five functions below, in the information function.

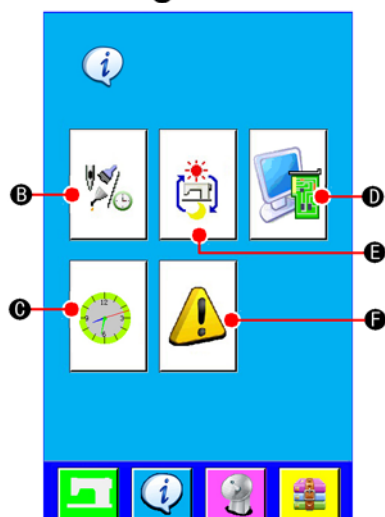


显示信息画面

在输入画面，按了信息键之后，信息画面(画面 A)被显示出来。

Display the information screen

Press INFORMATION key  ① of the switch seat section in the input screen and the information screen (screen A) is displayed.



信息画面(画面 A)
Information screen (screen A)

② 维修检查信息

指定机油更换(加润滑脂)时间、机针更换时间、清扫时间等，经过指定时间之后，可以发出通知警报。

③ 时钟显示信息

设置当前日期时间。

④ 主控制结构图

⑤ 机器运转信息

⑥ 错误记录信息

记录机器从运行以来发生过的错误。

② Maintenance inspection information

Oil replacement (grease-up) time, needle replacement time, cleaning time, etc. are specified, and when the specified time has passed, the warning notice can be performed.

③ Clock display information

Current date/time is set.

④ Control structure diagram

⑤ Operation information

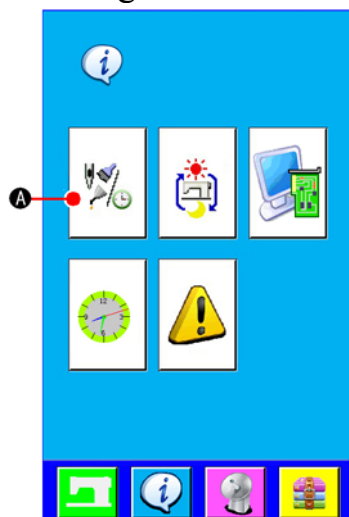
⑥ Error record information

Records the mistake happened in the machine since operation

(1) 查看维修检查信息

Observing the maintenance inspection information

1) 显示维修信息画面

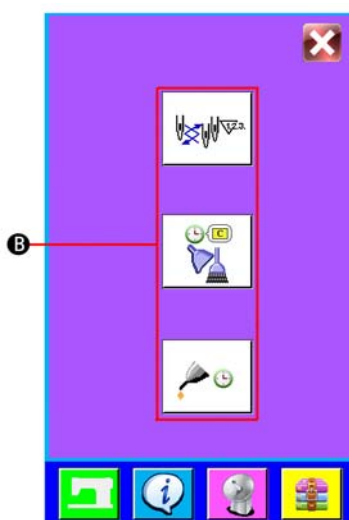


请按显示信息画面的维修检查信息画面按钮  ①。

Display the maintenance information screen

Press MAINTENANCE INSPECTION INFORMATION SCREEN

DISPLAY button  ① of the information screen.



在维修检查信息画面上显示以下3种信息。

- 机针更换
- 清扫时间
- 机油更换时间

Three items of the information below are displayed in the maintenance inspection information screen.

- Needle replacement
- Cleaning time
- Oil replacement time

2) 清除更换时间

按了想清除的项目按钮 ② 之后，清除更换时间画面被显示出来。上面显示的是上次此项目的更换时间。按了清除按钮  ③ 之后，更新当前的更换时间。



Clear the replacement time

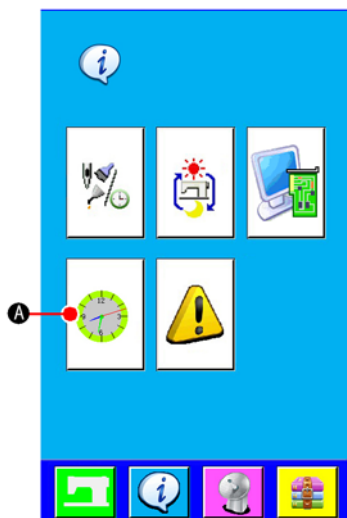
Press ITEM button ② you desire to clear and the replacement time clear screen is displayed. Press CLEAR button  ③ and the remaining time up to the replacement is cleared.

(2) 时钟显示信息

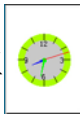
Clock display information

当显示的当前时间不准确时，可以通过时钟显示信息进行调整。

Date/Time can be adjusted when it is incorrect.



1) 显示时钟信息画面

请按信息画面的时钟显示信息画面按钮  ①。显示时间调整画面(画面 A)。

Display the clock information screen

Pressing CLOCK DISPLAY INFORMATION button  ① in the information screen, and date/time adjustment screen (screen A) is displayed.



时间调整画面(画面 A)
Date/Time adjustment screen
(screen A)

2) 修改日期时间

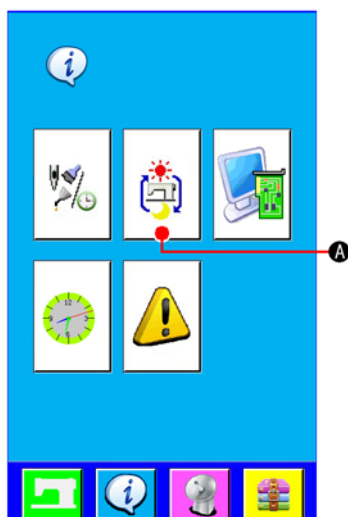
点击想要修改的信息，按下确定键修改，按下取消键取消修改。

Modify date/time

Click the information you want to modify. Press ok key to save the alteration and Press the cancel button cancel the revise.

(3) 机器运转信息

Operation information of the machine

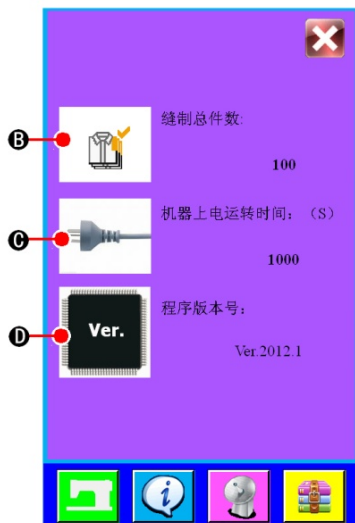


1) 显示机器运转信息画面

请按信息画面的显示机器运转信息画面按钮  ①。显示机器运行画面(画面 A)。

Display the operation information

Press OPERATION INFORMATION SCREEN DISPLAY button  ① in the information screen. The operation information screen (screen A) is displayed.



机器运行画面(画面 A)
The operation information screen
(screen A)

2) 在机器运转信息画面上显示着以下 3 种信息。

① : 自动显示机器自运转以来的缝制总件数。

② : 自动显示机器上电运转时间。

③ : 显示当前程序版本号。

Information on the following 3 items is displayed in the operation information screen.

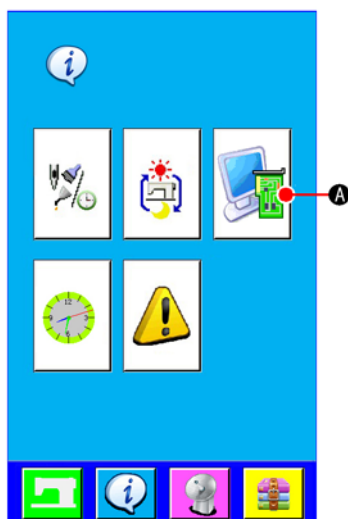
① : This item automatically displays the total number of pieces.

② : This item automatically displays the operation time.

③ : This item automatically displays the program version number.

(4) 控制结构图

Control structure diagram



显示控制结构图画面

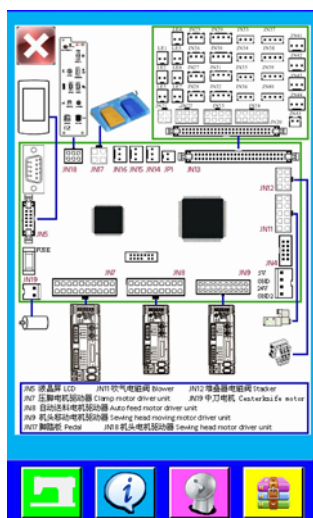
请按信息画面的显示控制结构图画面按钮 ①。显示控制结构图画面(画面 A)。



Display the control structure diagram

Press CONTROL STRUCTURE DIAGRAM SCREEN DISPLAY

button ① in the information screen. The control structure diagram screen (screen A) is displayed.



13. 使用通讯功能

使用通讯功能，可以把其他缝纫机编制的缝制数据下载到此缝纫机。另外，还可以把上述数据加载到U盘中。作为通讯的媒体，本机备有USB通讯接口。

Communication function can download the sewing data created with other sewing machine . In addition, the function can upload the aforementioned data to the USB. As the means of communication, USB are prepared.

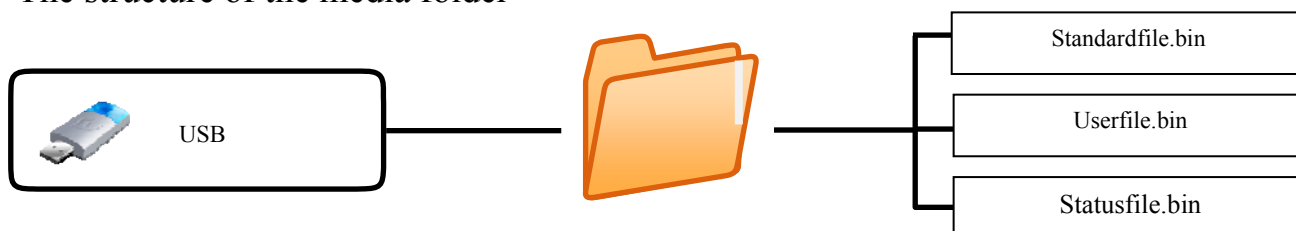
(1) 关于可以使用的数据

Handling possible data

数据名称 Data name	后缀 Extension	数据内容 Description of data
缝制数据 Sewing data	***.BIN	用缝纫机编制的专用缝制数据 Sewing data created by the sewing machine exclusive

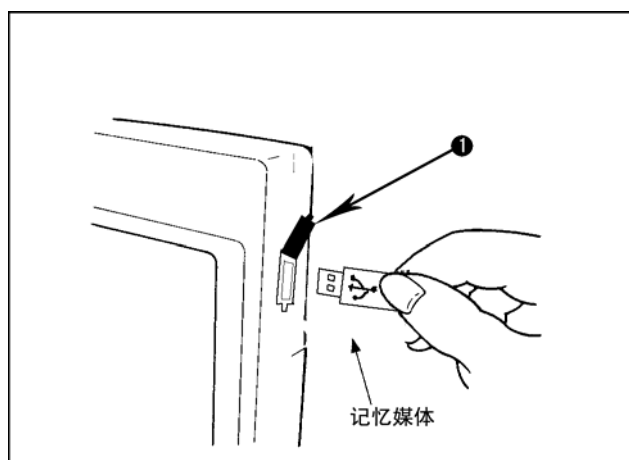
(2) 媒体文件夹的构成

The structure of the media folder



(3) 使用媒体进行通信时

Performing communication by using the media



揭开黑色橡胶护罩①，将记忆媒体如右图所示，插入通信接口中。

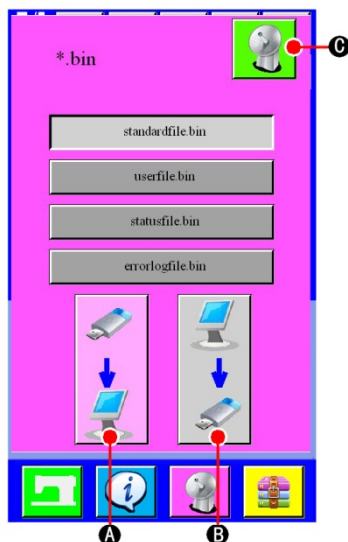
- * 通信完成后，请关闭护罩，以防灰尘等进入通信接口，影响下次通信。

Uncover the black rubber cover ①, and insert USB into communication port just as pictured at left.

- * After communication, close the cover ,so that dust, oil or other foreign material does not adhere to it. If the contact part becomes dirty, failure of contact will be caused.

(4) 装入数据时

Take-in of the data



1) 显示通讯画面

在输入画面，按了开关部的通讯键之后，通讯画面(画面 A)被显示出来。

2) 选择通讯方法

通讯方法有以下 2 种：

① U盘→液晶屏写入数据

② 液晶屏→U盘写入数据

请选择希望的通讯方法按钮。

3) 开始通讯

按了开始通讯按钮 ③ 之后，开始数据通讯。

Display the communication screen

When COMMUNICATION key  of switch seat section is pressed in the input screen, the communication screen (screen A) is displayed.

Select the communication method

There are two communication method as described below:

① Writing data from USB to operation panel.

② Writing data from operation panel to USB.

Select the button of communication method you desire.

Start communication

When COMMUNICATION START button  ③ is pressed, the data communication starts.

14. 更新操作面板程序

UPDATING PROGRAM OF OPERATION PANEL

显示程序更新画面

Display the screen of updating program .



按参数变换键之后，在画面上显示出程序更新按键Ⓐ。按了此按键之后，就会跳出通过 U 盘更新系统或更新用户应用程序的画面。

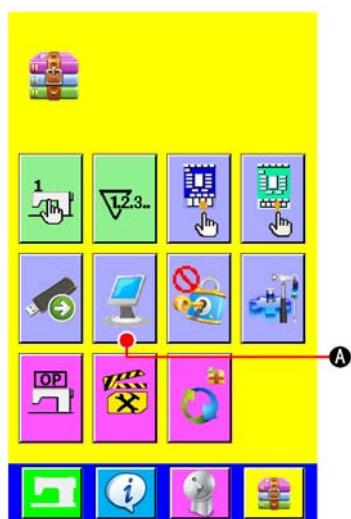
Press MODE CHANGEOVER key  and PROGRAM UPDATE button Ⓐ is displayed on the screen. When this button is pressed, the screen of updating program by USB is displayed.

15. 系统设置

SYSTEM SETUP

更改系统设置

Changing the system Settings.



按参数变换键之后，在画面上显示出系统设置按键Ⓐ。按了此按键之后，就会显示系统设置画面（画面 A）。

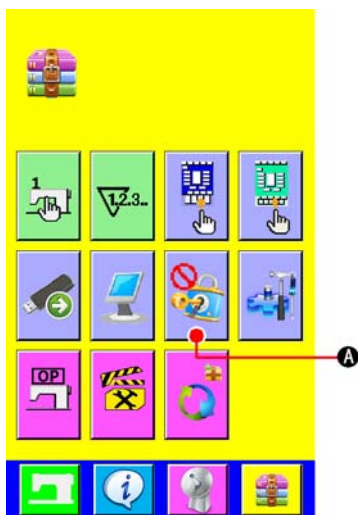
Press MODE CHANGEOVER key  and SYSTEM SETUP button Ⓐ is displayed. When this button is pressed, the system setup screen (screenA) is displayed.



系统设置画面（画面 A）
System setup screen (screenA)

16. 锁定复制和新建功能

LOCK COPY AND NEW FUCTION



按参数变换键之后，在画面上显示出锁定复制和新建功能按键



Ⓐ。按此按键可切换锁定或不锁定，锁定时，在主缝制画面上的

的复制和新建按钮将如图 A 所示转变为Ⓑ样式

显示	内容
	不锁定
	锁定



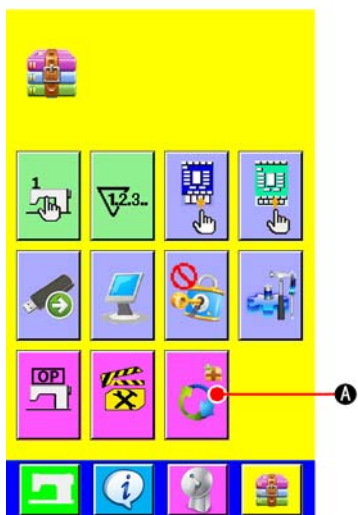
图 A
Picture A

Press MODE CHANGEOVER key  and LOCK COPY AND NEW FUCTION button  Ⓐ is displayed. Press this button ,you can set lock or unlock. The copyand new fuction button of the sewing screen will convert to type Ⓑ in the lock state.

Display	Description
	Unlock
	Lock

17. 参数初始化

PARAMETER INITIALIZATION



按参数变换键之后，在画面上显示出参数初始化按键Ⓐ。

按了此按键之后，就会跳出参数初始化画面。

Press MODE CHANGEOVER key  and PARAMETER INITIALIZATION button  Ⓐ is displayed. Press this button ,you can initialize the parameter.

VII. 维修

MAINTENANCE

1. 检查

INSPECTION

为了保持本机的功能，请一定定期地实施以下的维修检查。如果不进行维修检查的话，就有可能发生机械故障，因此请一定定期地实施维修。

Be sure to periodically execute the maintenance and inspection to keep the performance of this machine. Be sure to periodically execute the work since machine trouble may be caused unless the maintenance and inspection are performed.

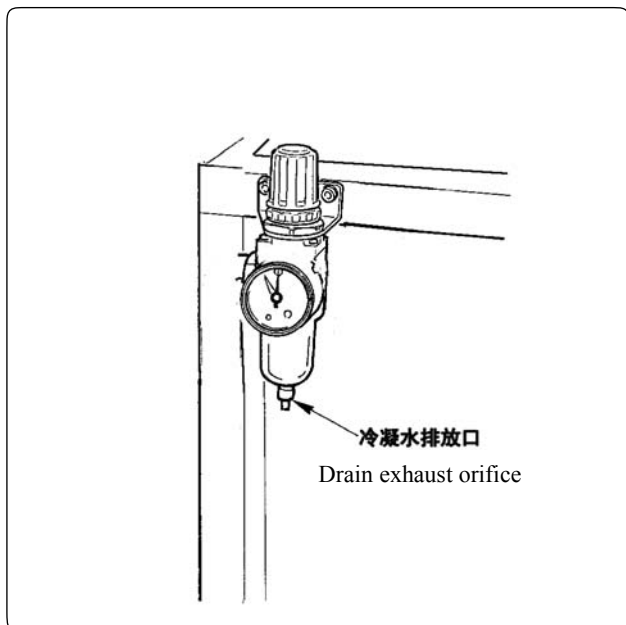
(1) 压缩空气装置的维修检查

Maintenance and inspection of the pneumatic device



为了防止突然的起动发生事故，请不要把手、脚、脸、工具放到上面。

To prevent accidents caused by abrupt start of the sewing machine, do not place hand(s), foot, face or tools on the machine moving part.



- 请每日排放出冷凝水。请打开过滤器下部的冷凝水排放口，排放冷凝水。

Discharge the drain of filter every day.

Open the drain exhaust orifice located at the bottom of filter to exhaust the drain.

(2) 有关缝纫机的维修检查

Maintenance and inspection related to the sewing machine



为了防止突然的起动造成事故，请关掉电源之后再进行操作。

Turn OFF the power before starting the work so as to prevents accidents caused by abrupt start of the sewing machine.

- 在大压脚等机器零件上如果粘附了灰尘之后，会影响机器的正常动作，因此工作前请一定进行清扫。另外，旋梭护罩内的线屑，请每星期一定清扫一次。
- 工作前，请一定检查中心切刀、角切刀的切割状态，发现切割不良时，请尽快更换。
- When dust adheres to the small places of the machine such as clamp foot or the like, normal operation is disturbed. Be sure to perform cleaning before the work. In addition, be sure to clean the thread waste in the hook cover once a week.
- Check the sharpness of center knife and corner knife before the work, and try to replace it in good time.

2. 激光灯

MARKING LIGHT

 警告	1. 激光直接照射到眼睛之后，会造成视力障碍。请不要窥视激光出光孔。 2. 接通电源的状态下，请绝对不要装卸激光灯。同时也不要使用于标记以外的用途。
 WARNING	1. If the laser light directly enters the eye, eyesight trouble may be caused. Do not look into the laser inlet/outlet. 2. Never perform installing/removing of the marking lamp with the power turning ON. In addition, do not use the light other than marking.

设定缝制标准用的激光灯

Marking light for sewing reference setting



按了输入画面的按钮 (A) 之后，显示设定激光灯画面，可以设定激光灯的开/关。

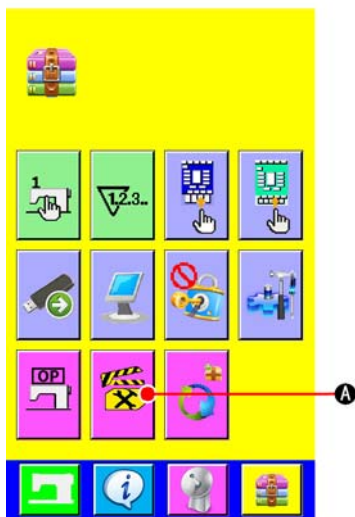
Press button (A) in the input screen and the marking light setting screen is displayed. Then the ON/OFF of marking light is set.

3. 维修视频

MAINTENANCE VIDEO

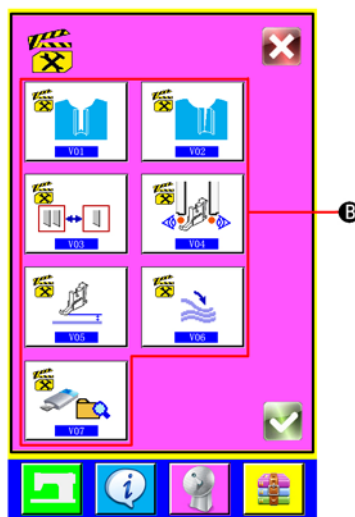
当机器发生故障时，可进入维修视频播放界面，观看机器自带的维修视频或者 U 盘里的视频。

When the machine has a failure, you can repair it by watching the maintenance video within the panel or the video in usb flash disk .



- 1) 按下参数变换键  之后，在画面上显示维修视频按键  ①。按了此按键之后，就会跳出维修视频的画面。

- 1) Press MODE CHANGEOVER key  and MAINTENANCE VIDEO button  ① is displayed on the screen. When this button is pressed, the screen of maintenance video is displayed.



- 2) 在可选区域 ② 中选择想要播放的视频，按下  进入播放画面

V01	明筒缝纫工艺
V02	暗筒缝纫工艺
V03	单刀/双刀更换方法
V04	大压脚与机头小压脚发生碰撞解决办法
V05	小压脚高度调整方法
V06	堆叠器调整方法
V07	U 盘

- 2) Select the video you want to play in the selection area ② .

Press the button  to enter the player screen.

V01	Placket sewing process
V02	Hidden placket sewing process
V03	Single knife/double knife change method
V04	The solution for the clamp foot and the sewing head foot take place the collision
V05	Adjust the sewing head foot height
V06	Adjust the stacker
V07	U flash disk

维修视频画面（画面 A）
Maintenance screen (screen A)



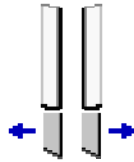
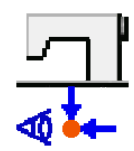
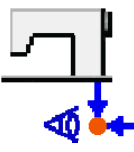
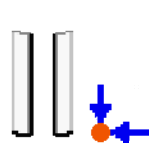
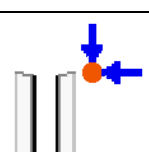
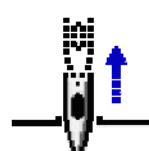
3) 视频播放画面各按键功能

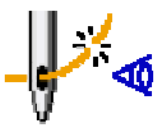
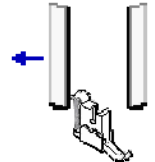
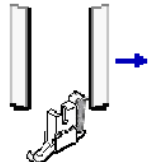
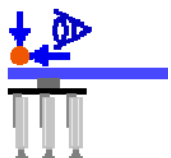
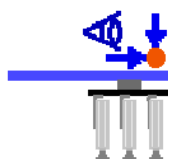
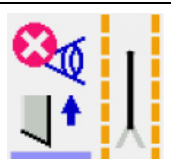
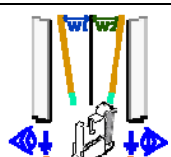
	播放/暂停按钮	按下时，视频播放；再按一下，视频暂停
	快退按钮	每按一下，视频后退 10s
	快进按钮	每按一下，视频前进 10s
	停止按钮	按下后，视频停止，如果按下播放键，视频从头开始播
	退出按钮	退出当前画面

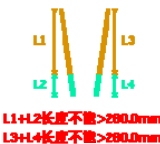
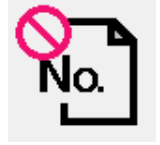
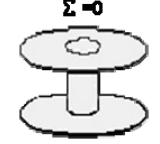
3) The key function in the player screen

	Play button /pause button	When pressed, video broadcast; Press again, video pause
	Rewind button	Each click, video back 10s
	Fast forward button	Each click, video fast forward 10s
	Stop button	After press this button, the video stopped, and then press the play button, the video broadcast from the very beginning
	Exit button	Exit from the current screen

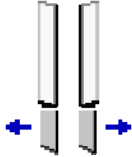
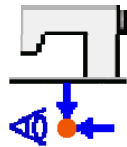
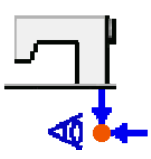
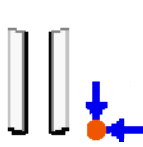
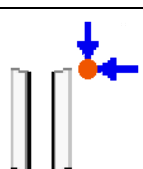
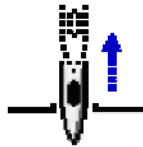
4. 错误代码一览

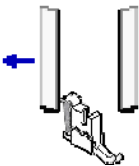
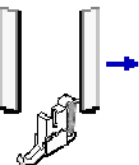
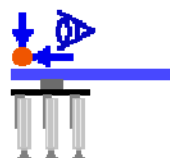
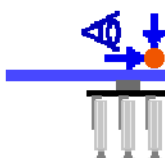
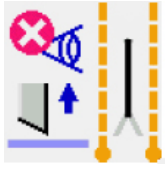
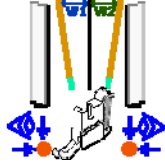
错误代码		错误说明	原因	复位方法
E01		数据写入成功，是否重启系统	---	---
E02		左右压脚可能会与左右中刀相撞	左右压脚与中刀的间距不够大	如果确认没问题请按复位键继续，如果有问题，请关闭电源,更换合适的中刀配件
E03		指定图形不存在	登记的缝纫程序中没有此编号的程序	新建此编号程序
E04		机头中定位传感器异常	机头不在正确位置上	检测传感器和机头移动电机信号线后，按复位键
E05		机头右定位点传感器异常	机头不在正确位置上	检测传感器和机头移动电机信号线后，按复位键
E06		数据写入U盘错误	不能将数据写入 U 盘	检查 U 盘是否工作正常后重试
E07		大压脚前定位传感器异常	---	按复位键，可重新启动
E08		大压脚后定位传感器异常	---	按复位键，可重新启动
E09		数据写入液晶屏失败	不能向屏中用户目录下写数据	检测目录是否正确
E10		针未归上针位	针杆偏离机针上位置	按下复位键

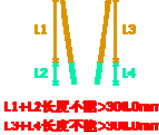
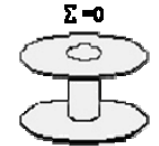
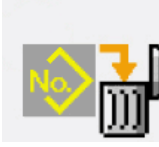
错误代码		错误说明	原因	复位方法
E12		停止开关	按了停止开关	复位后，可以重新启动
E13		断线	1、线张力调节不好 2、过线部位有毛刺	穿好线以后用前后补针按钮可以让布回到断线点，然后按下继续缝纫按键，可以继续缝纫。如果需要结束缝纫过程请按复位键
E14		左边大压脚会与机头上小压脚相撞	当前设置的缝纫宽度大于两个大压脚之间的间距	需要重新调整机械位置或者修改缝纫宽度参数 复位后，可以重新启动
E15		右边大压脚会与机头上小压脚相撞	当前设置的缝纫宽度大于两个大压脚之间的间距	需要重新调整机械位置或者修改缝纫宽度参数 复位后，可以重新启动
E16		对条对格装置左定位错误	---	复位后，可以重新检测
E17		对条对格装置右定位错误	---	复位后，可以重新检测
E18		确定参数初始化吗？	---	---
E21		中刀没有抬起	中刀抬起气缸卡住	复位后，可以重新启动
E22		缝纫宽度错误	缝纫宽度值被修改	需要自动检测宽度
E23		缝纫宽度设定错误	设定的缝纫宽度值不符合	关闭此画面重新设定宽度值

错误代码		错误说明	原因	复位方法
E24		缝纫长度设定错误	设定的缝纫长度值不符合	关闭此画面重新设定长度值
E43		不能复制	想要向已经登记的图案No.改写复制时	按取消按钮
E45		该号码已被使用	在新编制图案No选择已经登记的图案时	按取消按钮
E46		没有指定号码的数据	媒体和服务器里没有指定No.的数据	按取消按钮可以复位
E64		底线用完	底线余量计数器为0	1、更换底线； 2、按清除按钮，复位底线余量计数器值
E66		确认删除吗	---	---

ERROR CODE LIST

Error code		Description of error	Reason	How to recover
E01		Copy file ok,Do you want to reset system?	---	---
E02		Clamp foot may collided with center knife	The space between left and right clamp foot and center knife edge is not enough.	If there is no problem,press Reset-key to continue.Otherwise turn off the power and choose suitable spare parts of center knife
E03		Pattern NO.error	This numbers does not exist in the registered program	Create a new number to this program
E04		Sewing head center point sensor error	Sewing head is not in the right position.	Please check the sensor and signal cable of servo motor which control the movement of machine head,then press reset key.
E05		Sewing head right point sensor error	Sewing head is not in the right position.	Please check the sensor and signal cable of servo motor which control the movement of machine head,then press reset key.
E06		Data write from U-disk cannot be performed	Cannot write data to the Udisk	Check out whether the digital U disk is working fine
E07		Clamp foot stepping motor origin retrieval error	---	Possible to re-start after reset
E08		Clamp foot motor step-out error	---	Possible to re-start after reset
E09		Data write from LCD cannot be performed	Data write from the user list of screen cannot be performed.	Check out whether the list is right.
E10		Needle bar upper position failure	Needle drifts off upper position	Turn the handwheel, let needle return to the upper position.

Error code		Description of error	Reason	How to recover
E12		Stop switch	When stop switch is pressed.	Possible to re-start after reset
E13		Thread breakage detection error	1 、 Thread tension adjustment is bad 2 、 Pass thread parts have the burr.	Possible to re-start after reset
E14		The left clamp foot and the sewing head may take place the collision	The current set of sewing width greater than the distance of two clamp foot	Need to adjust the mechanical position or Modify sewing width parameters Possible to re-start after reset
E15		The right clamp foot and the sewing head may take place the collision	The current set of sewing width greater than the distance of two clamp foot	Need to adjust the mechanical position or Modify sewing width parameters Possible to re-start after reset
E16		Stripe matching left point sensor error	---	Possible to re-test after reset
E17		Stripe matching right point sensor error	---	Possible to re-test after reset
E18		Initialize parameter?	---	---
E21		Center knife upper sensor cannot detect	Center knife cylinder stuck	Possible to re-start after reset
E22		Width value error	Width value be changed	Need to detect width automatic
E23		Width value setting error	The width values do not accord with sewing specifications.	Close the screen and set again

Error code		Description of error	Reason	How to recover
E24		Length value setting error	The width values do not accord with sewing specifications.	Close the screen and set again
E43		Copy disapproved	When trying to perform overwriting copy on the pattern No. which has been already registered	Possible to recover with CANCEL button
E45		New creation disapproved	When the registered pattern is selected to the new creation pattern No.	Possible to recover with CANCEL button
E46		Data of designated No. does not exist	When data of designated No. does not exist in media or server	Possible to recover with CANCEL button
E64		Spool empty	Bottom line residual counter for 0	1、Changing base line; 2、Press CLEAR button, and reset the bottom line residual counter.
E66		Are you sure delete?	---	---