

# 步进罗拉车操作说明书

## USER MANUAL FOR STEP ROLLER FEED MACHINE

### 1：开机界面 Boot interface



开机画面图标说明：Boot screen icon description:



缝制确认键。点击此键，**主轴电机及摆针电机**将找原点，之后系统将进入缝制模式。 Sewing confirmation key. Click this key, the spindle motor and the pendulum motor will find the origin point, and the system will enter the sewing mode.



厂家设置键。长按此键，系统将进入厂家设置模式。（单独说明）。 Factory setting key. Press and hold this key, the system will enter the factory setting mode. ( it will state individually).



系统信息按键。长按此键，系统将进入信息模式。信息模式中

包括系统的上下位机软件版本查询，以及上下位机软件升级功能。进入此模式后，系统不能返回。如需进入其他模式请关机重新上电。System information key. Long press this key will enter to the system information mode. The information mode includes the system software version for the panel and control box, and the software upgrade function for the panel and control box. Enter to this mode, the system cannot return. If you need to enter other modes, please turn off the power and restart the machine.

## 2: 缝制界面      Sewing interface

缝制界面分为三类：自由缝，重叠缝以及编程缝。The sewing interface is divided into three categories: free sewing, overlapping sewing, and programmed sewing.



图 1 自由缝界面 Free sewing interface



图2 重叠缝界面 overlapping sewing interface



图3 编程缝界面 programmed sewing interface

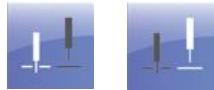
## 2. 1: 按键说明 Key description



前加固。白色字体图标表示此功能被激活，深灰色字体图标表示此功能被无效。Start back-tacking.the white font icon indicates that this function is activated and the dark gray font icon indicates that this function is invalid.



后加固。白色字体图标表示此功能被激活，深灰色字体图标表示此功能被无效。End back-tacking.the white font icon indicates that this function is activated and the dark gray font icon indicates that this function is invalid.



停车时，机针的位置。前一个图标表示停车后机针在布下，后一个图标表示停车后机针在布上。The position of the needle when stop. The previous icon indicates that the needle is under the cloth after stop, and the latter icon indicates that the needle is on the cloth after stop.



停车时，压脚是否抬起。白色字体图标表示此功能被激活，深灰色字体图标表示此功能被无效。The presser foot is lift or not when stop the machine. the white font icon indicates that this function is activated and the dark gray font icon indicates that this function is invalid.



剪线停车后，压脚是否抬起。白色字体图标表示此功能被激活，深灰色字体图标表示此功能被无效。当激活时，停车剪线后压脚位置在上位。未激活时停车剪线后压脚位置在下位。默认状态未激活。The presser foot is lift or not after trimming stop machine. the white font icon indicates that this function is activated and the dark gray font icon indicates that this function is invalid. When activated, the presser foot position is in the upper position after stop trimming. When not activated, the presser foot position is in the lower position. The default state is not activated.



剪线**功能**。白色字体图标表示此功能被激活，深灰色字体图标表示此功能被

无效。当激活时，当前缝纫段可以剪线。未激活则当前缝纫段不可剪线。Trimming function. the white font icon indicates that this function is activated and the dark gray font icon indicates that this function is invalid. When activated, the current sewing section can be trimming. If not activated, the current sewing section cannot be trimming.



转速设置。白色字体图标表示此功能被激活，深灰色字体图标表示此功能被无效。当激活后，点击“滚动键”，找到转速设置项。按对应位置的“+”，“-”键，可以更改转速。在自由缝状态下可以更改“前加固”，“后加固”以及当前段的转速。在重叠缝和编程缝纫模式下只能修改当前段转速。Rotational speed setting. the white font icon indicates that this function is activated and the dark gray font icon indicates that this function is invalid. When activated,

click the "scroll key"，find the speed setting item. Press corresponding the "+" and "-" keys, it can adjust speed. Under the free sewing mode, you can change speed of "start back-tacking", "end back-tacking" and the current segment. Under the overlapping sewing and programmed sewing it just can change current segment speed.

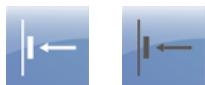


倒缝设置。白色字体图标表示此功能被激活，深灰色字体图标表示此功能被无效。此按键用于编程缝纫以及花样编辑中。在编程缝纫中，用于即时更改当前缝纫段的方向。在花样编辑中用于设置当前编程段的缝制方向，激活为反方向缝纫，未激活为正常缝制方向。Back-tacking setting. the white font icon indicates that this function is activated and the dark gray font icon indicates that this function is invalid. This key is used for programming sewing and pattern editing. In the programming sewing, it is used for instantly change the current sewing segment direction. In the pattern editing, it used for setting current programming segment sewing direction, the reverse direction is activated, the normal sewing direction is not

activated.



定针位置设置。白色字体图标表示此功能被激活，深灰色字体图标表示此功能被无效。需要使用定针位置功能时，首先要将主轴参数中的第 12 项参数“定针位置功能”设置为 1，开启此功能。然后激活定针位置设置键。定针角度的设置参见“定针角度设置方法”，说明书后续章节说明。Needle position setting. the white font icon indicates that this function is activated and the dark gray font icon indicates that this function is invalid. When it need to use needle position function, please setting the spindle parameter P12 “Needle position function” setting value to 1, turn on this function. Then activate the needle position setting key. Needle position angle setting ref to “ needle position setting method”, user manual will describe on subsequent chapter.



膝控开关功能。当在重叠缝和编程缝纫模式下开启此功能后，使用膝控开关可以在编辑好的花样中，依次切换缝制段。Knee-control switch function. Under the overlapping sewing and programmed sewing after turn on this function, use knee-control switch can shift sewing segment in turn in the edited pattern.



加固缝纫临时取消功能。当前缝纫花样中设置了前加固或者后加固后，如果当前临时不需要加固，则可激活此键，缝制的下一加固状态即可取消。此后加固依然后效。Back-tacking temporary cancel function. After setting start back-tacking or end back-tacking in current sewing pattern, if current temporary no need to back-tacking then can active this key, and sewing next backing-tacking can cancel. And end back-tacking also can effective.



程序中断按键。此键用在编程缝纫状态下。在编程缝制状态下按下此键后，当前缝纫程序中断不再计数，此后踩踏板机器将按照中断时缝制段的数据进行自由缝。取消激活，则程序将继续进行。The program interrupt key. This key is used in the programmed sewing state. Under the programmed sewing state press this key, the current sewing program interruption it will not counted, after that tread the pedal machine will be free sewing according to the data of the sewing segment at the time of interruption. Cancel activation, the program will continue.



在自由缝模式下激活此键，用于绕底线，此时上下滚轮不动作。Under the free sewing mode activate this key used for coiling bottom thread, at this time the upper and lower rollers not action.



在编程缝制中激活此键，则表示当前段在缝制结束后将自动停车。如未激活，则编制的花样将连续缝纫，直到整个程序结束。Under the programming sewing activate this key, it will automatic stop machine after sewing is completed for current segment. If not activated, then the editing pattern will continuously sewing until the end of program.



在编程缝制模式中按激活此键，则踩踏板一下，机器将自动缝制完整个花样。Under the programmed sewing mode activated this key, then tread the pedal machine will be automatic sewing complete pattern.



在编程模式中激活此键，再使用“滚动键”找到对应设置项，则可以更改当前缝制段的缝制针数。Under the programmed mode activated this key,

and use the “scroll key” find the corresponding setting item, then can change the current sewing stitches for sewing segment.



激活此键则软启动功能开启。Turn on the soft start function then can activated this key.

## 自由缝

自由缝，重叠缝和编程缝切换按键。在程序结束状态下，或者强制剪线结束状态下。按此键可以在自由缝，重叠缝以及编程缝制模式中来回切换。Free sewing, overlapping sewing and programmed sewing shift key. At the end of program or at the end of force trimming state, press this key can shift free sewing ,overlapping sewing and programmed sewing mode.



滚动按键。在缝制模式下可以使用此键来切换不同的设置项。前提条件是设置项需要被激活。Scroll key. Under the sewing mode can use this key to shift between different setting item. But the prerequisite is setting item need to be activated.

功能。Function



在对应位置按此键，参数加。Press this key on correspond position, parameter plus.



在对应位置按此键，参数减。Press this key in correspond position, parameter minus.



长按此键，将进入花样编辑模式。详细操作方式见后边章节。Long press this key, it will enter to pattern editing mode. See the following section for detailed operation.



长按此键，将进入参数设置模式。详细操作方式见后边章节。Long press this key, it will enter to parameter setting mode. See the following section for detailed operation.



上锁，解锁键。前一个图标表示触摸屏上锁，此时触摸屏除解锁键外，其他按键无效，点击解锁键后，触摸屏其他按键恢复功能。后一个按键图标表示解锁键，在此状态下，液晶面板上显示的图标均可用。手动点击解锁键后，触摸屏将上锁。或者在参数设置中设置了自动上锁时间，在时间值到达后，系统将自动上锁。Lock and unlock key. The previous icon indicates that the touch screen is locked. At this time, other keys on the touch screen are invalid except the unlock key, after clicking the unlock key, other keys on the touch screen resume function. The latter key icon indicates the unlock key, and in this state, the icons displayed on the LCD panel are all available. After manually clicking the unlock key, the touch screen will be locked. Or the automatic lock time is set in the parameter setting. After the time

value is reached, the system will automatically lock.



计件显示及设置按键。在计件功能开启后，此图标将显示计件初始值。设置方法见后边章节。Record stitches number and setting key. After counting stitches function turn on, this icon will display initial value. Setting method see following chapter.



底线显示及设置按键。在底线计数器功能开启后，此图标将显示剩余底线。设置方法见后边章节。Bottom thread display and setting key. This icon will display the remaining bottom thread when the bottom thread counter function is turned on. Setting method see the following chapter.



返回按键。Return key.

## 2. 2: 图标说明 Icon description



上滚轮标志 Upper roller icon



下滚轮标志 Lower roller icon



此图标下对应数字表示当前花样号。This icon corresponding number

indicates current pattern no.



图标下对应数字表示当前段的缝制转速。This icon corresponding number indicates current sewing speed.



图标下的对应数字表示当前段的缝制针数。This icon corresponding number indicates current sewing stitches.

**S - 1**

此图标中的数字，表示当前正在缝制的段号。This icon number indicates current sewing segment.

### 3: 基本操作 Basic operation

#### 3. 1 自由缝 Free sewing



图 4 自由缝界面-滚轮值设置

### 3. 1. 1 滚轮值的调整 Adjustment of roller value

如上图所示，在此界面下，点击或者长按“+”，“-”键将改变当前的上下滚轮值。红色方框表示“上滚轮”调整键。黄色方框表示“下滚轮”调整键。上下滚轮值的间隔不超过 1.0 毫米。As shown in the figure above, click or long press "+" in this interface, and the "-" key will change the current value of up and down rollers. The red box indicates the "up roller" adjustment key. The yellow box indicates the scroll wheel adjustment key. The interval between the upper and lower roller values shall not exceed 1.0 mm.

### 3. 1. 2 前加固设置 Start back-tacking setting



图 5 自由缝界面-前加固设置 Free sewing screen- start back-tacking setting

如需设置前加固，首先激活前加固按键 。然后，点击滚动按键 ，切换设置界面，如上图。红色方框设置“A”段，黄色方框设置“B”段，黑色方框，设置重复次数“R”。R 值为 2 和 4, 当为 2 时表示缝制 AB, 为 4 时表示缝制 ABAB。if you need to set up start back-tacking, activate the

back-tacking key first . Then, click the scroll key , shift settings interface, as shown above. Red box set "A" section, yellow box set "B" section, black box, set repeat number "R". R value is 2 and 4, when 2 indicates sewing AB, and as 4, it means sewing ABAB.



图 6 自由缝界面-后加固设置 Free sewing interface- End back-tacking setting

如需设置后加固，首先激活后加固按键 。然后，点击滚动按键 , 切换设置界面。设置方法与前加固设置方法相同。If need to set end back-tacking, first to activated back-tacking key . and then click scroll key , shift setting interface. Setting method same as the start back-tacking.

### 3. 1. 3 转速设置 Speed setting



图 7 自由缝界面-转速设置 Free sewing interface - speed setting

如需设置转速,首先激活转速设置按键 。然后,点击滚动按键 ,切换设置界面。红色方框可以设置前加固转速,黄色方框设置后加固转速。黑色方框设置自由缝缝纫部分的转速。If need to setting speed, first to activated speed setting key . and then click scroll key shift setting interface. Red box can setting start back-tacking speed, yellow box can setting end back-tacking speed, black box can setting speed of free sewing segment.

### 3. 1. 4 定针位置设置 Needle position setting



图 8 自由缝界面-定针角度设置 Free sewing interface  
- needle position angle setting

如需使用定针功能。首先要将主轴参数中的第 12 项参数“定针位置使能”设  
置为 1，开启此功能。然后激活定针位置设置键 。长按此键进入定针角度  
设置界面。如图 8 所示。界面当前显示主轴的位置，使用手轮将针杆转动到需要  
进行定针的位置，然后按“OK”键，保存当前设置值，然后按返回键  返回即可。If need to use needle position function. First to setting the spindle parameter  
P12 “needle position function” setting as 1, turn on this function. And then activated

 needle position setting key . long press this key to enter needle position angle  
setting interface. As shown in figure 8. Interface current display spindle shaft position,  
use the hand-wheel to turn the needle bar to requirement position, press “OK” key to  
save the current setting value, and then press return key  to turn back.

### 3.2 重叠缝 Overlapping sewing



图9 重叠缝界面-滚轮值设置 overlapping sewing interface - scroll value setting

如需修改某一段的数据，则点击对应段的针数位置。此时对应位置显示黑底白字，表示当前段被选中。当某段被选中后，页面中的相关按键和数据都属于当前段。如上图所示，“A”段被选中，此时右侧区域显示的是“A”段的上下滚轮数值。通过红色方框中的“+”，“-”按钮，可以增加或减少滚轮数值。针数与转速的设置与自由缝相同，都是需要先激活对应按键，然后按滚动键进行修改。

If you require to modify the data of one section, then click position of corresponding segment stitches number. At this time corresponding position display black background white word that indicates current segment is selected. After selected one section, the relevant keys and data in this page is belong current segment. As shown in the above figure, “A” segment is selected, at this time right side area display the upper and lower scroll value for “A” segment. Through red box “+”, “-” key, it can add or reduce the scroll value. Stitches and speed setting same as the free sewing , all need to activated the corresponding key then press scroll key to modify.

当 **STOP** 键被激活后，则每段缝制结束后，系统都自动停车。将脚踏板返回中立位置，再向缝纫位置踩下才能继续缝制下一段。如果无此需要则，将此键设

  置为无效状态。 after  key is activated , the system stops automatically after complete each segment sewing. Return the pedal to a neutral position and tread sewing position then can continue sewing next segment. If no need then set this key as invalid state .

 当  键被激活后，踩一下脚踏板，则系统自动缝制全部花样，直至结束。如果无此需要则，将此键设置为无效状态 。 After  key is activated, tread the pedal, system will automatically sewing all pattern till to finished. If no need the to set this key as invalid state .



图 10 重叠缝界面-定针设置 Overlapping sewing interface-needle position setting

如果需要在重叠缝中使用定针功能，则激活  键。按滚动键 ，切换到定针设置页面，使用“+”，“-”键，手动修改需要的角度值。所需的角度值可以通过进入自由缝中定针角度设置页面，通过转动手轮，观察当前主轴位置，进行确定。If need to use needle position function in the overlapping sewing,

please activated  key. Press scroll key  shift to needle postion setting page, use “+”, “-” key modify to require angle value. As require needle postion value can through free sewing needle position angle setting page, by turn over hand-wheel, obverse current spindle shaft position to confirmation.

**注意：**重叠缝中的每一段都是可以单独设置的，包括：转速，针数，剪线，停車位置以及是否剪线等。在编程前务必确认需要缝制的花样方式与设置是否一致，否则将产生不同的缝制效果。Noted: each section of the overlapping sewing can be set separately, including speed, stitches count, trimming, needle position, and whether trimming or not. please confirm the pattern of sewing method and setting is same as your requirement or not before programming, otherwise it will make different sewing effects.

### 3.2 编程缝 Programmed sewing



图 10 编程缝界面-说明 Programmed sewing interface - description

如上图所示，编程缝界面中红色方框表示的是当前缝制的花样的编号。右侧蓝色方框中上边的数字表示当前花样的总段数。下边的数字表示液晶屏当前显

示的段号。在程序缝制结束的情况下，可以通过使用红色方框下的“+”，“-”键选择系统中存储的不同花样。如果所选则的花样有多个段，则可以通过蓝色方框下的“+”，“-”进行选择。在缝制界面下，可以修改除了增加段，删除段以及循环缝功能以外的所有数据。修改后，参数实时生效。As shown in the above figure, in the programmed sewing interface red box indicates the current code of pattern. Right side blue box at the top of number indicates current pattern total segment. The below number indicates segment no. of currently displayed on the LCD. Under the programmed sewing finished, it can use in the red box "+" and "-" keys to select different patterns stored in the system. If the pattern selected has more than one segment, it can be selected by "+" and "-" in the blue box. Under the sewing interface, you can modify all the data except adding section, deleting section and circular sewing function. After modification, the parameters will be available.

需要说明的是编程缝纫中的前两个花样，也就是 1 号和 2 号花样是固定花样，不可删除。每个花样可以增加为 3 段。每一段的缝制都是自由缝模式，增加多段后，可以通过机头按键，膝控开关以及液晶面板在多个段中来回切换。如果需要在编程缝纫模式中使用机头按键或者膝控开关在段间来回切换的话，需要先

 激活  键，否则系统不执行切换动作。多个段可以设置为不同的针距。下面说明使用液晶面板切换不同段的方法。如下图是 1 号花样，被增加为 3 段。It need to noted the front two pattern in the programmed sewing, the pattern 1 and pattern 2 are fixed pattern can't to delete. Each pattern can add 3 segment. Each segment sewing is free sewing mode, after added multi-segment, it can through sewing machine head key, knee-control switch and LCD panel to shift between multi-segment.

 Please activated  key if you need to use sewing machine head keys or knee-control switch to shift between segment, otherwise the system will not perform shift action. Multi-segment can setting different stitches number. The following description is use LCD panel to shift different segment method. Such as below figure is no.1 pattern has been added as 3 segment.



图 10 编程缝界面-多段切换 Programmed sewing interface - multi-segment shift



使用液晶面板进行不同段的切换时，首先需要激活 键，然后使用红色方框内的“+”，“-”键选择需要缝制的段号。Use the LCD panel to shift different



segment, at first need to activated key, then use “+”, “-” key in the red box to select require sewing segment.



图 11 编程缝界面-多段切换 programmed sewing interface- multi-segment shift

如上图所示为切换为第二段后的界面，段号显示为第 2 段， 后的数



字与选择的段号相同，也为 2 号。只有在这种情况下，段切换成功。如果未激活



Break 键，则选择段号后，**S -** 后的数字与段号不一致。此时没有真正的切换花样数据，只是切换了段的数据页面，缝制信息没有下传到下位机控制器中。As shown in above figure is shift to the second segment interface, segment no is

display 2<sup>nd</sup> segment, after **S -** number and selected segment number is same number 2. only in this case, the segment shift succeed. If not activated break key



， after selected segment number, after **S -** number is different with segment number, at this time haven't shift the pattern data, just shift segment data page, sewing information not transmitted to control box .



图 12 编程缝界面-设置前加固 programmed sewing interface- setting start back-tacking

编程缝中，前加固，后加固的设置方式与自由缝相仿。不同的是，在编程模式中，不能修改前加固与后加固的转速和反复次数。如修改这些信息，需要进入程序编辑模式，选择对应花样进行编辑。On the programmed sewing, start back-tacking, end back-tacking setting method is similar as free sewing . the different is under programmed modem, it can't modify speed and repeat times for start back-tacking and end back-tacking. If modified this information need to enter program editing mode select corresponding pattern to edit.

#### 4. 参数设置 Parameter setting

长按  键，进入参数设置界面。Long press  key, enter to parameter setting interface.



图 13 参数选择界面 parameter selection interface

参数选择界面右下角显示有上下位机的软件版本信息。Parameter selection interface bottom right display software version information of operation panel and control box

以第一项参数为例：点击“面板参数”后，进入面板参数设置界面。Take the 1<sup>st</sup> parameter as an example : after click “panel parameter”, enter to panel parameter setting interface.



图 14 参数设置界面 parameter setting interface

如上图所示， 点击向左或者向右的白色按键，界面将跳转到前一个或者后一个参数的设置界面，同时 No 后的数字将跟着变化。选择好需要修改的参数项目后，使用右侧的“+”，“-”键更改参数值。修改完成后，点击“OK”键进行保存。未点击“OK”而切换参数项或者退出设置，则参数不会保存。其他参数的设置方法与此相同。As shown above figure,  click white key for turn left or turn right, interface will turn to previous or latter parameter setting interface, at the same time after No. Number will be change accordingly. After select the parameter item which want to modify, use right side “+” “-” key to modify the parameter value. After modified, click “OK” key to save. If not click “OK” key then to shift parameter item or exit setting, the parameter will not to save. Other parameter setting method same as this.

## 5. 程序编辑 program editing

 长按  键后，将进入程序编辑目录页面 after long press  key, it will enter program editing catalogue page.



图 15 程序编辑目录 Program editing catalogue

### 5. 1 添加花样 added pattern

点击“添加花样”项，显示界面 click “added pattern” item, it display interface.

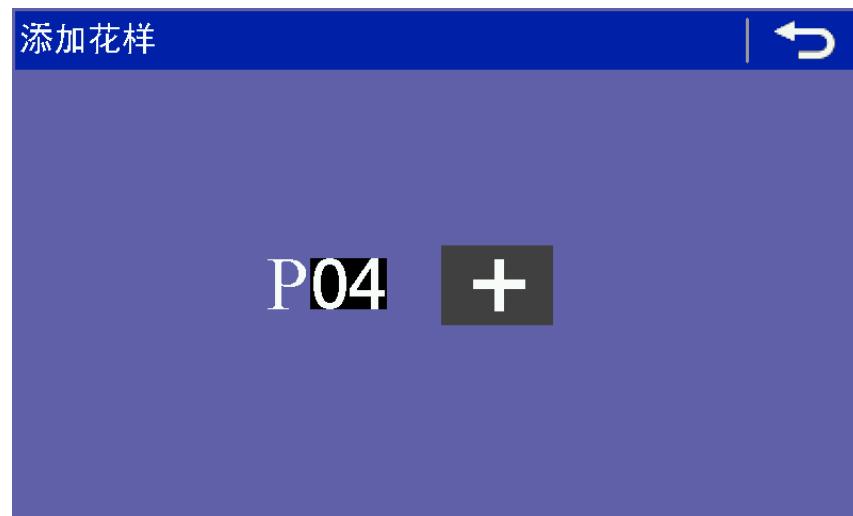


图 16 添加花样 Added pattern

如上图所示，P04 中的 04 表示将要添加的花样编号，点击右侧的“+”键，将添加第 04 号花样。添加完成后，待添加的花样号自动加 1，变成下一个待添

加花样。如果不需要继续添加，则按返回键，返回。As shown above figure, in the P04 the 04 indicates it will add pattern code, click right side “+” key will added 4<sup>th</sup> pattern. After complete added, waiting add pattern number will automatic add 1 to became next waiting for add pattern, if no need to continue add then press return key to back.

## 5. 2 删 除 花 样 Delete pattern

点击“删除花样”项，显示界面 Click “delete pattern” item, display interface

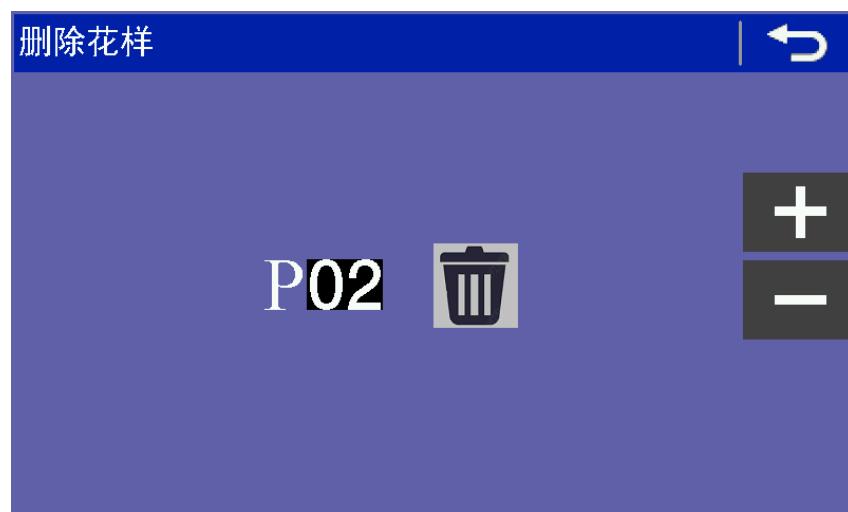


图 17 删 除 花 样 delete pattern



使用右侧“+”，“-”键选择待删除花样。然后按  键删除花样。第 1 号和 2 号花样不可删除。Use right “+”, “-”key to select waiting delete pattern. Then press  key to delete pattern. No.1 and No.2 pattern can't delete.



## 5. 3 花 样 编辑 Pattern editing

点击“选择要编程的花样号”项，显示界面 Click “select will

need to editing pattern no” item, display interface.



图 18 选择待编程花样 Select waiting editing pattern

按 键选择需要编程的花样号。选择好后按 键, 进入编程界面。

按 键退出选择。Press key to select need to editing pattern

number. After select press key, to enter editing interface.

### 5. 3. 1 编辑方法 Editing method



图 19 花样编辑方法 Pattern editing method

花样的编辑方法，与前边章节介绍的缝制界面下的设置方法类似。首先，需要考虑这个花样需要几段。如果多于 1 段，则需要添加段数。此时点击 键，切换到段增加，删除页面。Pattern editing method, it is similar with previous chapter introduction setting method in the sewing interface. At first it need to consider the pattern require how many segment. If more than 1 segment, then need to add the segment. At this time click key to shift segment added, delete page.



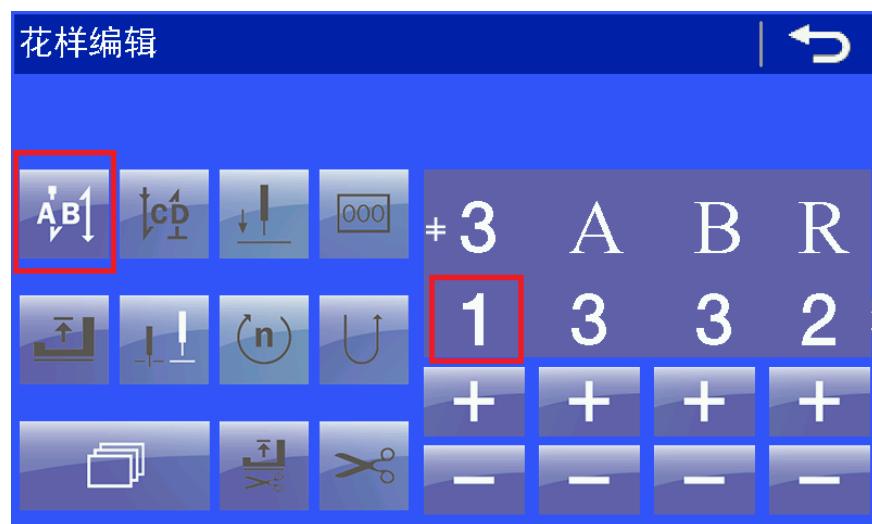
图 19 添加删除段 adding delete segment

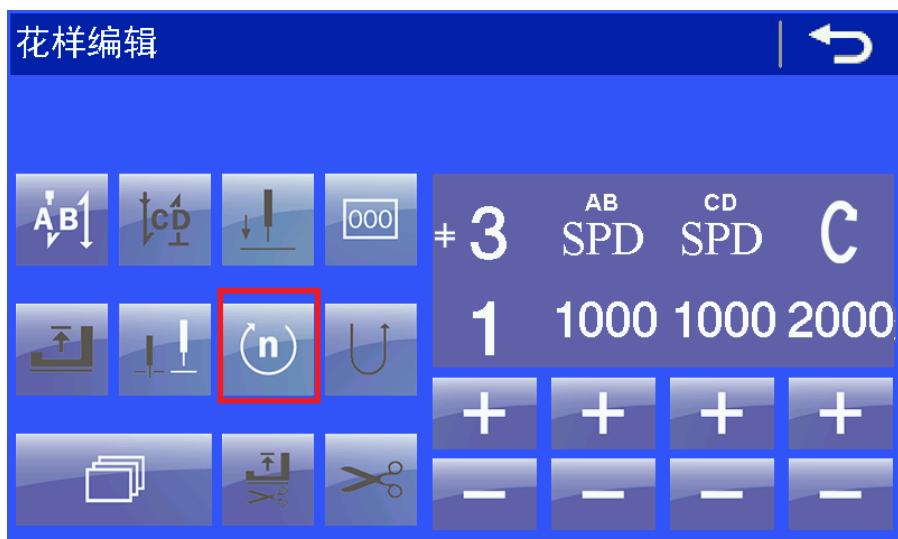
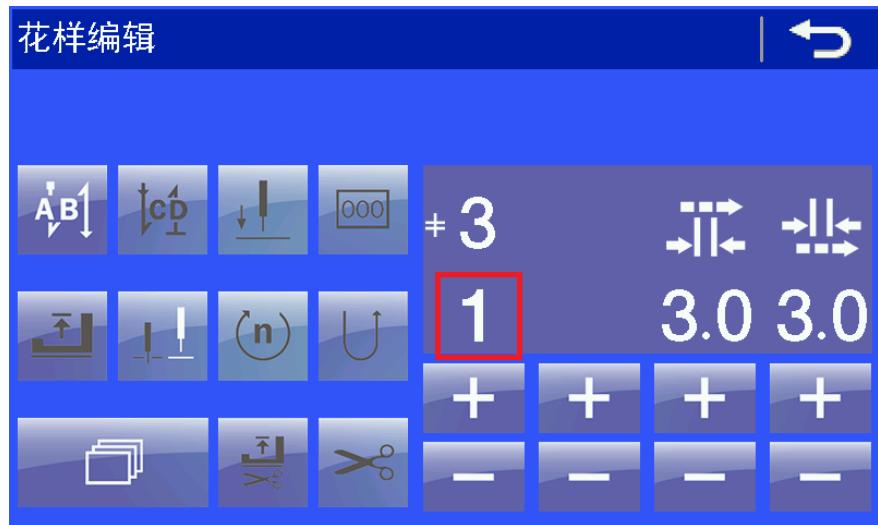
按白色字体“添加段”下方的“+”，“-”键，添加段。按白色字体“删除段”下方的“+”，“-”键，删除段。按白色字体“循环缝”下方的“+”，“-”

键，将花样设置为循环缝模式。注意：只有段数设置好后才能设置循环缝。Press “+”, “-” key white font below of the “add segment”, delete segment. Press “+”, “-” key white font below of the “cycle sewing”, the pattern setting as the cycle sewing mode. **Noted: only after the segment have been set then can setting cycle sewing.**

段数设置好后，按左侧段号下方的“+”，“-”键选择要编辑的段。after the segment have been set, press left “+”, “-”key below of the segment select need to editing segment.

举例：编辑一个 3 段花样，第一段 6 针，针距 3mm，起始有前加固，段转速 2000。第二段 8 针，针距 3.5mm，段转速 2100。第三段 10 针，针距 4.0mm，段转速 2200。有后加固，结束后剪线并抬压脚。For example: editing for one pattern of 3 segment, the one fist segment 6 stitches, the stitches length 3mm, start have start back-tacking, segment speed 2000. the second segment 8 stitches, the stitches length 3.5mm, segment speed 2100. the third segment 10 stitches, stitches length 4.0mm, segment speed 2200. trimming and foot presser lift after end back-tacking .





各设置之间使用滚动键切换 。第二段和第三段的设置方法与

第一段相同。只是需要改变待编程的段号。如下图： Shift between each

setting use scroll key  . the 2<sup>nd</sup> segment and 3<sup>rd</sup> segment setting method is same as 1<sup>st</sup> segment.



花样编程结束后，需要保存花样。It need to save pattern after pattern editing setting.

### Error code list

#### 1: 下位机错误代码 Control box error code

3100 软件未授权 Software unauthorized

3101 参数超出范围 Parameter out of range

**重新初始化参数 Reinitialize parameter**

3110 脚踏板设置错误/或脚踏板故障 Pedal setting error / or pedal malfunction

**脚踏板 AD 值不正确 Pedal AD value is not correct**

3111 编码器或基准点传感器故障或电机故障 Encoder or datum point sensor malfunction or motor malfunction

检查主轴是否被卡住，或者编码器有故障 please check the spindle shaft is stuck or not, or encoder malfunction.

3112 数据错误 Date error

**数据处理错误，重新设置缝制参数 Date process error, reset sewing parameter**

3113 零位传感器错误 Zero-position sensor error

检查主轴是否被卡住，或者编码器有故障 please check the spindle shaft is stuck or not, or encoder malfunction.

3114 机头打开 sewing machine head open

**机头被扳倒或者机头倾角传感器故障 Machine head is turn over or machine head sensor angle of inclination malfunction**

3118 电磁铁故障 Solenoid malfunction

**检查电磁铁是否有短路 please check the solenoid is short-circuit or not.**

3119 主轴异常 spindle shaft abnormal

**主轴堵转，或者编码器异常 spindle shaft stuck or encoder abnormal**

3120 摆针电机异常 Pendulum motor abnormal

**摆针堵转或者其他原因引起的未转动 Pendulum stuck or other caused can't rotate**

3121 通讯故障 communication malfunction

**未收到上位机的回传数据 it not received the panel return data**

3122 通讯数据验证错误 Communicate data verification error

**接收到的数据有错误 the data received was wrong**

3123 主轴驱动异常 spindle shaft drive abnormal

**主轴电机过流 spindle motor over-current**

3124 摆针驱动异常 Pendulum drive abnormal

**摆针电机过流 Pendulum motor over-current**

3125 花样传输错误 Pattern transfer error

**花样传输错误，通讯问题** Pattern transfer error, communicate problem

3126 参数传输错误 Parameter transfer error

**参数传输错误，通讯问题** Parameter transfer error, communicate problem

3127 膝控切换缝制段失败 Knee-control shift sewing failure

**切换缝制段时，上位机未响应** the panel no response when shift sewing segment

3128 摆针位置异常 Pendulum position abnormal

**摆针位置超过正常范围** the pendulum position is out of the normal range

3129 过电压 Over-voltage

**供电电压过高** Supply voltage is too high

3130 欠电压 Under-voltage

**供电电压过低**

1：上位机错误代码 panel error code

21：控制板未找到原点 the control box can't find original point

主轴或者摆针未找到原点。首先判断主轴是否正常工作，再判断摆针  
Spindle shaft or pendulum can't find the original point. At first please

check the spindle is running or not then check the pendulum.