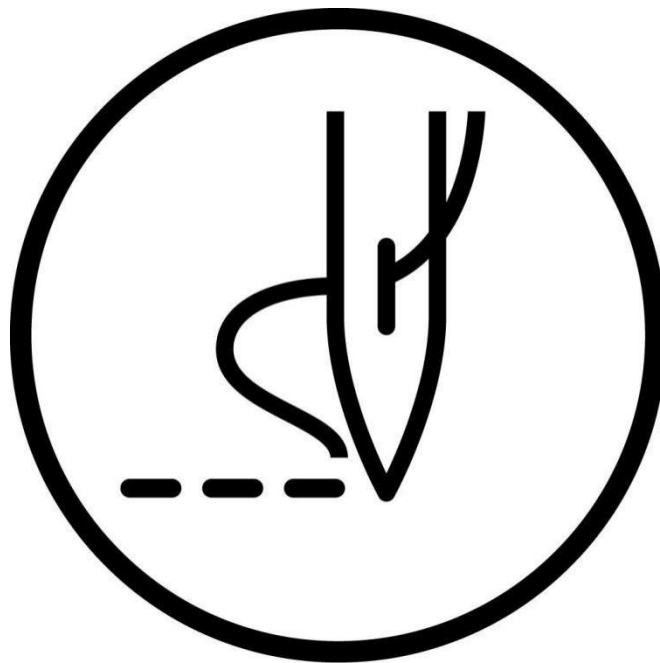

Bag opening machine

Electronic control system instructions



Please read this instruction manual before using the machine. Please keep this instruction manual in a place where it is easy to refer to.

VER:202312A

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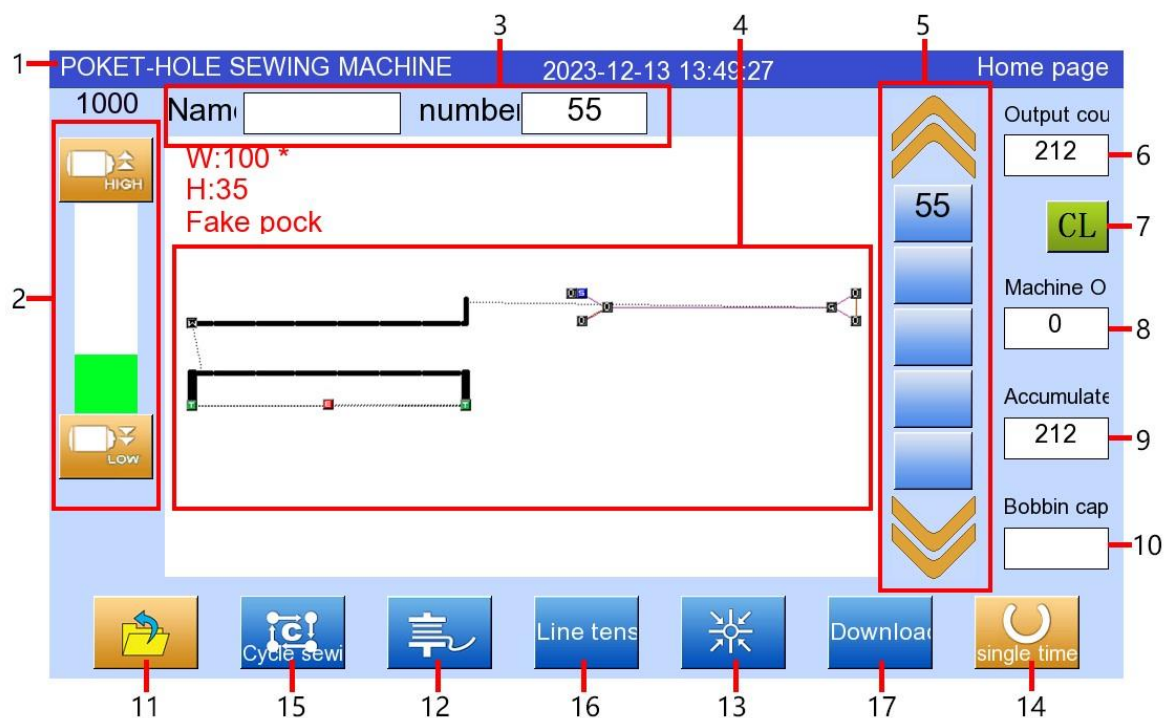
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In this interface, you can select the operating language, set the time, upgrade the screen program, initialize the machine, view version information, and set up installment payments, etc. Here is a brief description of this:	22
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1 Interface description

1-1 Main interface description

The touch screen operation panel adopts the industry's advanced touch operation technology. The clear interface and simple control bring innovative changes to users' daily use. Users can touch the screen with their fingers to complete corresponding operations. Users should be careful not to touch the screen with sharp objects during use, so as not to cause permanent damage to the screen and affect the use. The following is a description of the main control interface:



1. Title

Display device manufacturer information, time and current interface name.

2. Governor

The speed is incremented/decremented by 100.

3. Tricks

Current pattern name and number.

4. Pattern display area

Display the size of the current pattern in the upper right corner of the pattern diagram.

5 . Pattern selection area

Change the page to select the desired pattern.

6. Processing counter

Display the current number of pieces and enter the piece counter setting screen.

7. Clear key

Clear current piece count.

8. Power-on counter

Count from the current power on, press the button to enter the workpiece counter setting screen.

9. Cumulative counter

Display the total number of pieces and total number of pieces prompts.

10. Bottom line count

Enter the bottom thread counter setting screen.

11. Menu

Function list: 〈U disk pattern〉 〈System pattern〉 〈New pattern〉 〈Modify pattern〉 〈Pattern conversion〉

<Parameter Management> <Equipment Detection> <Auxiliary Functions>

12. Winding

Click to enter the winding interface and press the folding start switch to wind

the wire.

13. Return to origin

Mechanical reset

14. Confirm sewing key

Enter the sewing processing interface.

15. Pattern loop

Patterns can be combined for cycle sewing.

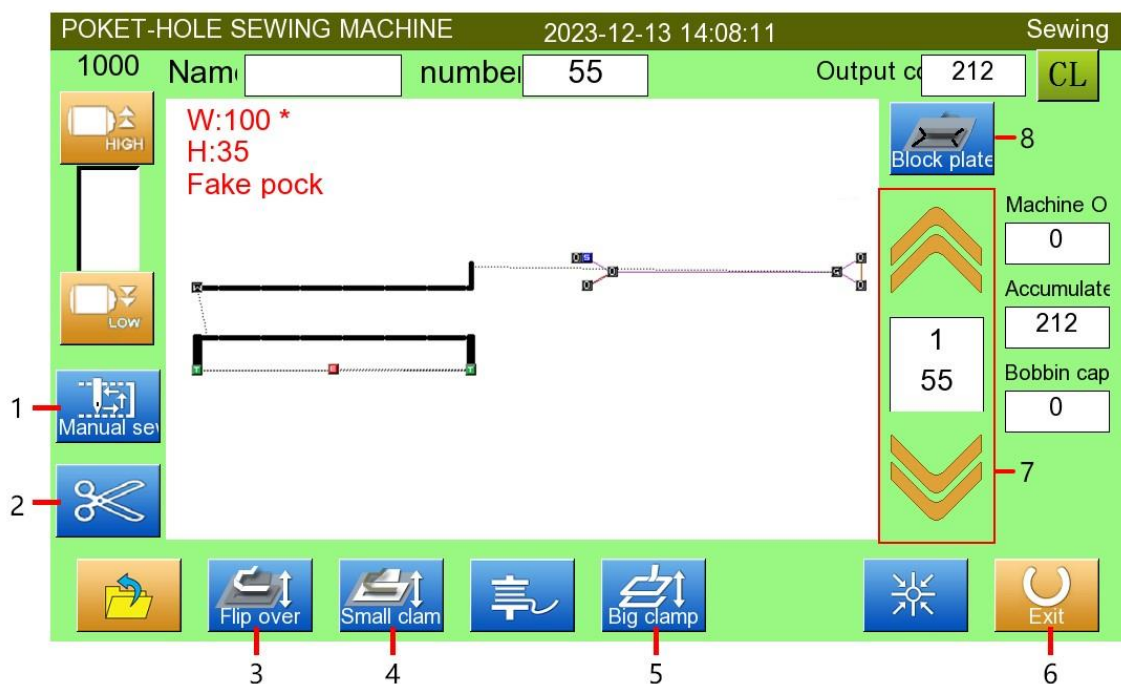
16. Line tens

Adjust line tens.







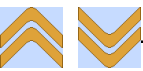

17. Download

Download patterns

1-2 Processing interface description



Most of the buttons in this interface are the same as those in the main control interface. Now we only explain the different parts:


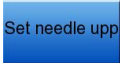
1.  — Manual sewing key is used to start the machine head to start sewing operation;
2.  — Scissor key is used for manual thread trimming and testing whether the scissors are normal;
3.  — Flap used for fixation during sewing;
4.  — Small pressure plate is used to manually lift and lower the small pressure plate.;
5.  — Large pressure plate is used to manually lift and lower the large pressure plate.;
6.  — Return key is used to exit the processing page;
7.  — Jog key is used to move the needle point forward and backward.;
8.  — Baffle is used to position the fabric when folding to form folded edges.;

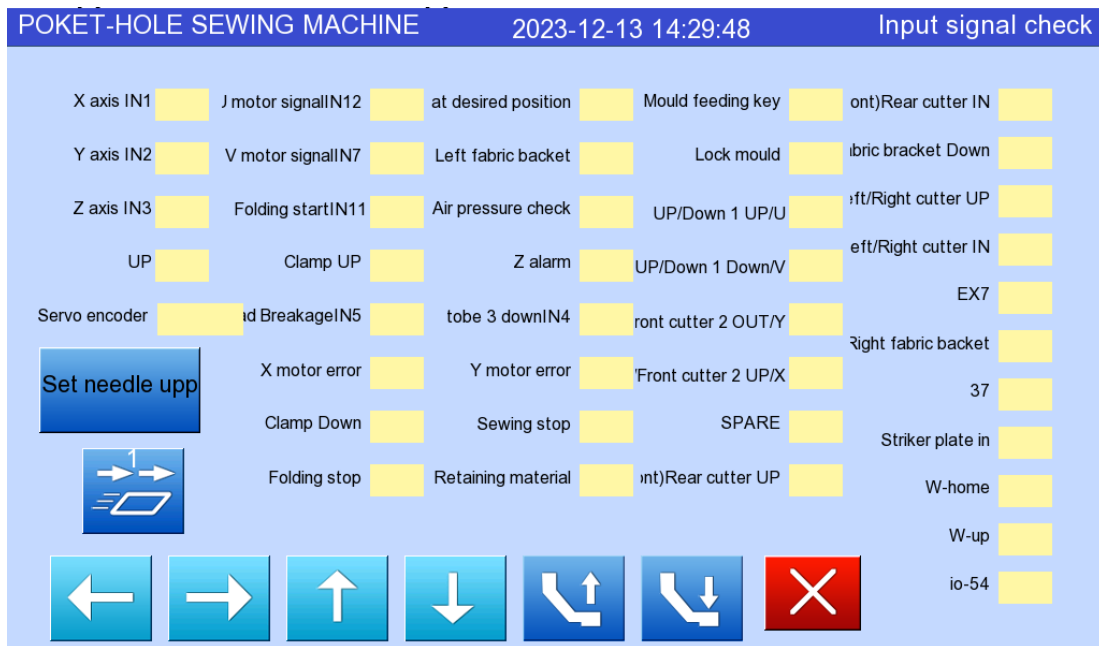
2 Instructions

2-1 Adjust zero position

Before powering on the machine, make sure that the gas source and power supply are connected, and then turn on the power switch. After the power-on self-test is completed, the screen enters the main control interface.

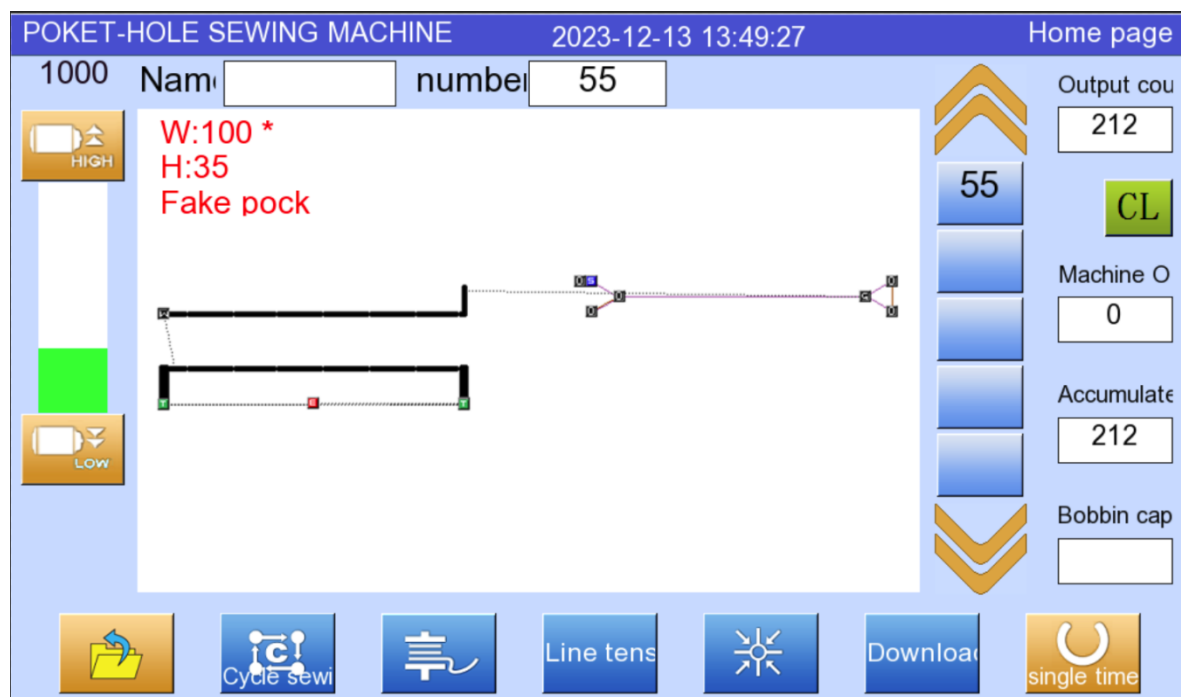
1.2-1-1 Needle position adjustment on spindle

(1): Press the [Function Menu] key to enter the main menu, press  Enter the [Signal Detection] interface, set the needle position on the machine head, turn the handwheel clockwise to turn the needle bar to the desired height, and press  You can complete the needle position setting shown in Figure 1.6 below.

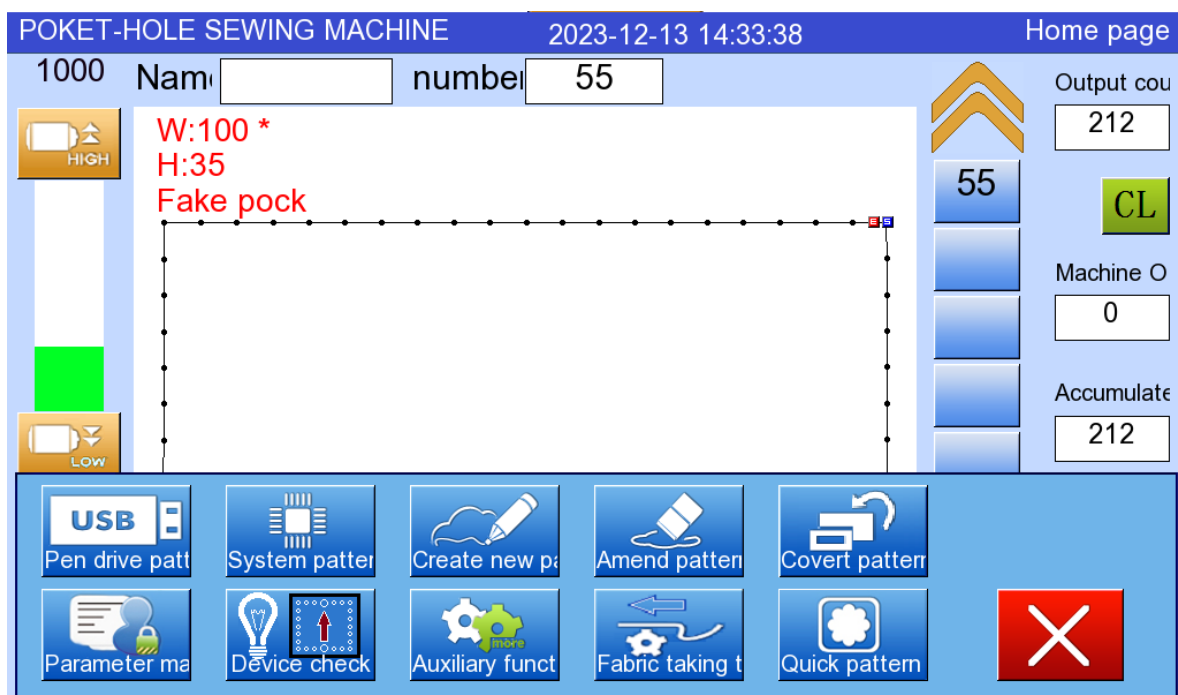


2-2 Main function menu

After booting, enter this interface ;



In this interface, touch  Press the button to expand the function button list (as shown below:).



Select from them to enter the corresponding functions: :



< U disk pattern>: Edit U disk pattern.



< System patterns> :Edit patterns in the system.



< Create a new pattern>: Immediately create a pattern.



< Modify pattern>: Edit the current pattern.



< Parameter Management>: System parameter items.



< Equipment detection>: Used to detect whether various equipment and signals are correct or not.



<Auxiliary functions>: System upgrade, time setting, usage period and other functions.



< Pick-up test>: Used to set the relevant position of the pick-up motor.



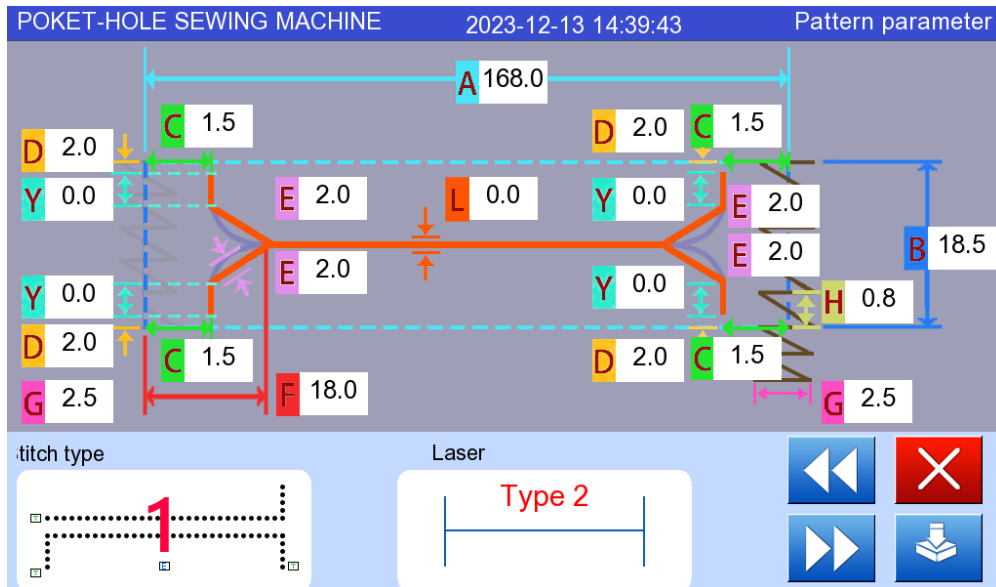
< Data Patterning>: Used to quickly generate patterns [Pocket Data Patterning].


2-3 Data layout

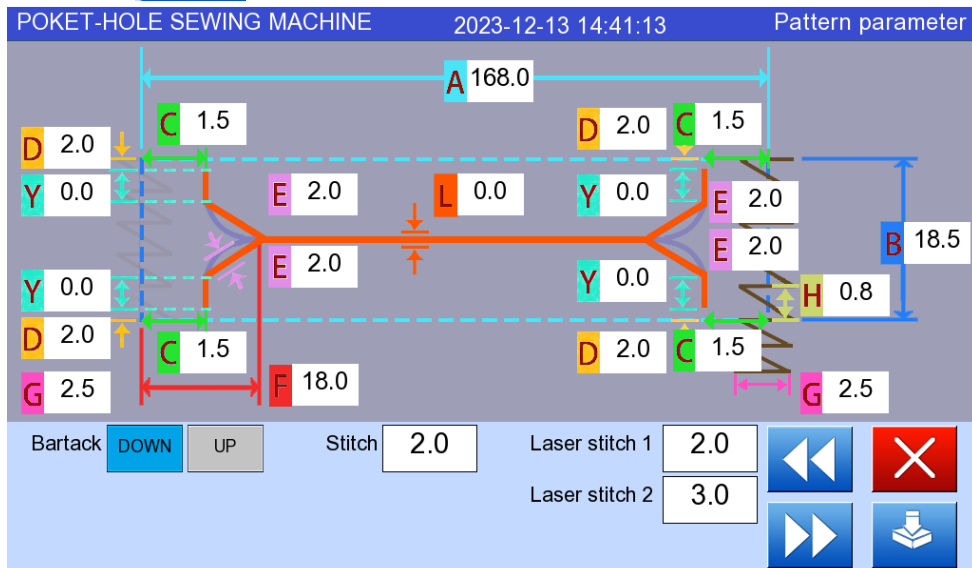
Click




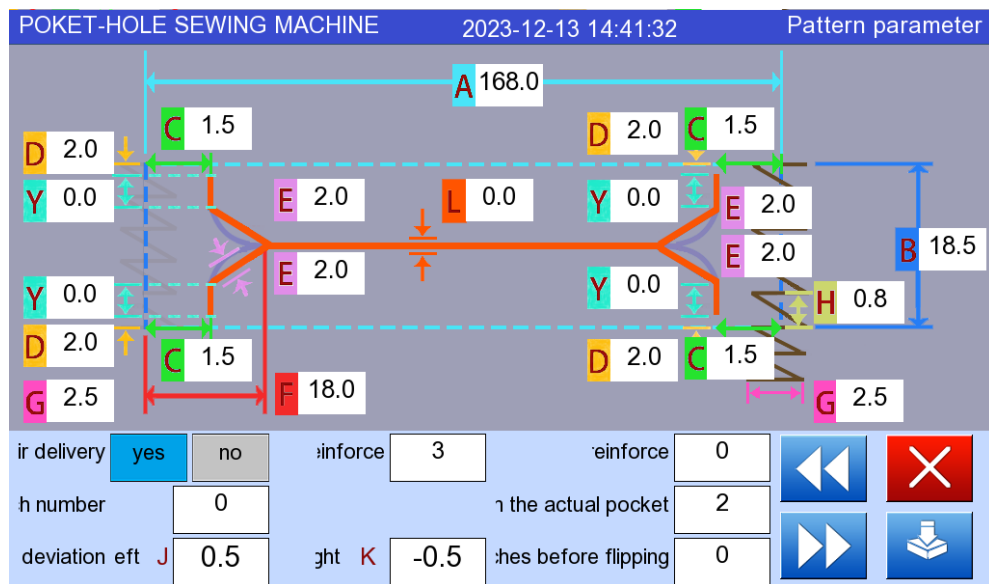
button to enter the following interface :



Press  button to enter the next interface :








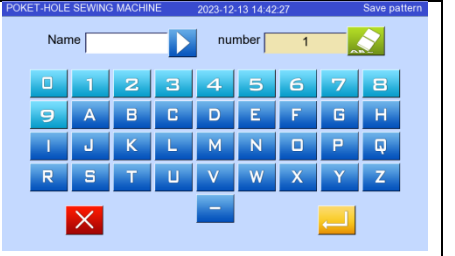
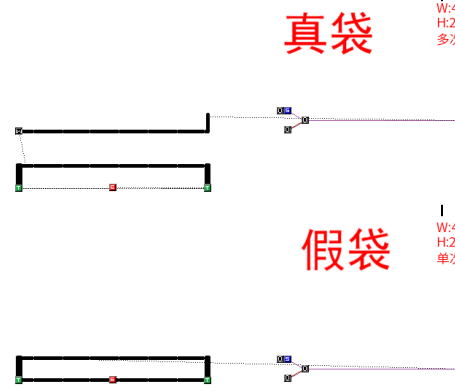
Press  button to enter the next interface :



Function Description

serial number	Function	Content
A	Pocket seam length	
B	Pocket seam width	
C	Laser cutting to left and right suture distance	
D	Laser cutting to upper and lower seam distance	
E	Laser cutting arc measurement adjustment	
F	Distance from left and right stop to suture line	
G	Bark height adjustment	
H	Bartack stitch length	

Y	<p>Laser cutting edge style selection.</p> <p>Figure 1 shows a Y shape (when Y is not 0)</p> <p>Figure 2 shows an arc (when E is not 0)</p> <p>Figure 3 is a straight line (when Y is 0)</p>	  
J	<p>Tacking X offset left is left tacking adjustment,</p> <p>When 0, it is evenly distributed on the left and right of the vertical line. Enter a positive number to move the tack to the right of the vertical line, and a negative number to move the tack to the left of the vertical line.</p>	

K	<p>Tacking X offset The right is the right tacking adjustment.</p> <p>When 0 is clicked, it is evenly distributed on the left and right sides of the vertical line. Enter a positive number to move the tack to the right of the vertical line, and a negative number to move the tack to the left of the vertical line.</p>	
L	<p>Save the pattern [When saving the pattern, you can edit the pattern number and name, fill in the pattern and save it]</p>	
L	<p>Type selection</p> <p>Multiple times (real bags)</p>	



	Single (fake bag)	
Beat dates	<p>Type 1: Beat dates from top to bottom</p> <p>Type 2: Live from the bottom and beat the date from the top</p>	
<p>Needle pitch: It is the needle pitch of sewing thread;</p> <p>Laser needle pitch 1: It is the needle pitch at the branches at the left and right ends of the laser line (a small needle pitch is conducive to straight cutting);</p> <p>Laser needle pitch 2: It is the needle pitch of the straight line in the middle of the laser line (larger needle pitch is beneficial to faster speed).</p>		
<p>Number of needles advanced by the flap: To prevent the flap from colliding with the needle, this number of stitches can be set (usually set to 0);</p>		
<p>Laser type 1: For the four corners of the laser, the laser is fired from the midline each time;</p> <p>Laser Type 2: Open the laser from the outside to the midline for the lower left and right corners of the laser.</p>		

Pattern center XY offset: used to compensate for the relative position difference between the pattern data and the needle;

Pattern center XY offset: used to compensate for the relative position difference between laser data and laser;

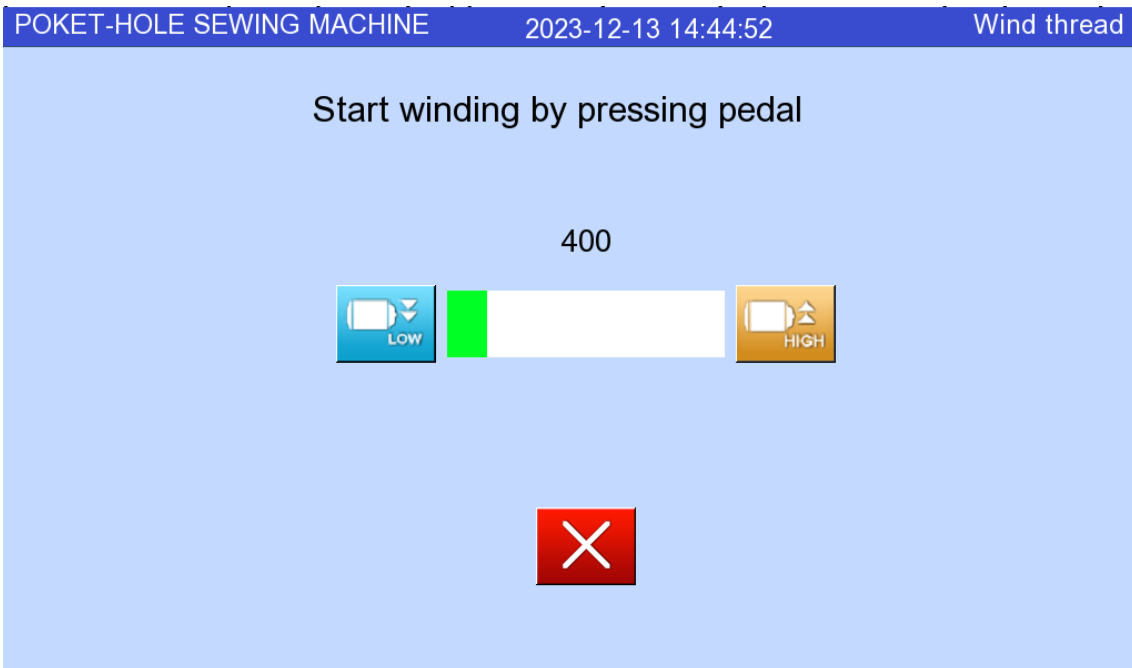
2-4 Sewing data setting

2-4-1 Maximum speed limit setting

In the main control interface and sewing processing interface, you can press  or  Can be adjusted up or down. However, the maximum speed limit value is the value set by the system parameters.


2-4-2 bottom line counter

This count is an estimate of the number of times a lock cylinder can be sewn. The total number of bottom threads can be set according to the actual working situation, as shown in the figure:



During the sewing process, the current bobbin thread number is subtracted by one for each piece of sewing. When the final bobbin thread number is 0, "E046 The remaining bobbin thread length is not enough, please change the bobbin" will be reported. If the total number of bobbin threads is set to zero, the bobbin thread will be turned off. counting function. Since the bobbin number is an estimate and is related to the bobbin winding length, the remaining bobbin thread is not exactly the same every time.

3 . Equipment detection and parameter setting

From the main menu touch  button to enter the main menu interface as follows:



< Electromagnet detection>: Test each electromagnet solenoid valve.



< Stepper Test>: Test stepper motors and stepper drives.



< Servo Test>: Test the spindle motor (servo).



< Signal detection>: Test the switch signals of each sensor



< Origin adjustment>: Set mechanical origin



< Test >: Only aged tractors, prohibited from use



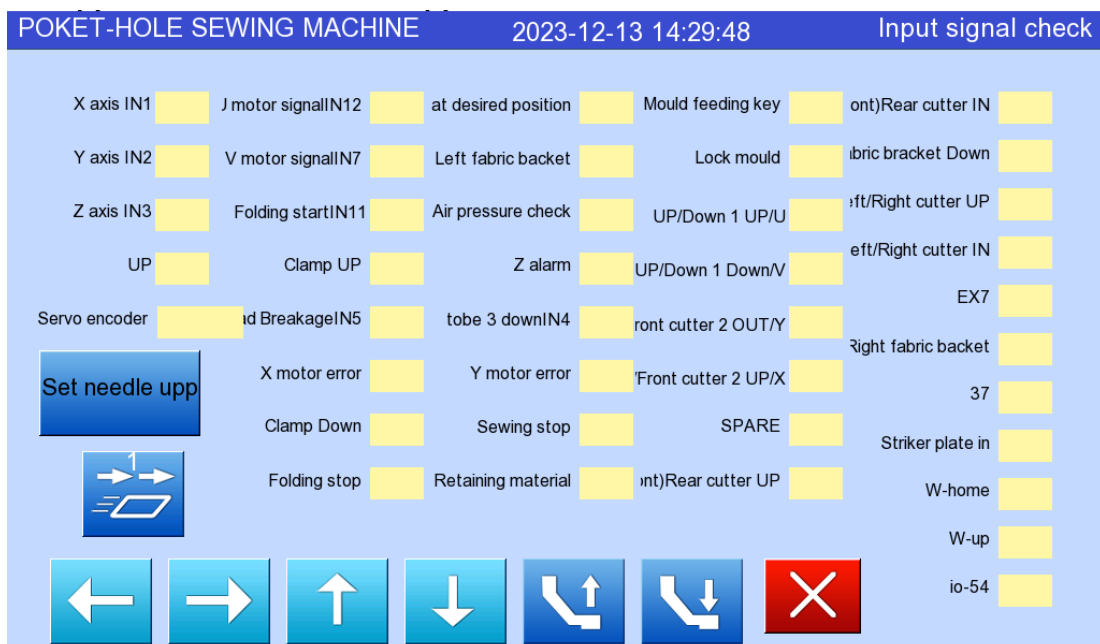
< Screen off settings >: Display backlight settings.

Only some functions are explained below.

3-1 Sensor/switch signal detection



touch Press the key to enter the input signal detection interface to display the sensor signal and switch signal..



1. When the respective sensors sense, there are changes in L/H, ON/OFF, and 0/1. Note that the light on the sensor indicates that the power supply is normal, but it does not mean that the signal is normal. Only when the corresponding position changes can the test be normal.

2. For push button switches, there are two types: normally open and normally closed, inching and self-locking. Pay attention to the distinction.


3. When the spindle rotates normally, the spindle code will increase and


decrease cyclically from 0 to 4320 (some models). When the spindle rotates once, the needle position will change from on to off.

4. For wire breakage detection, the pulling force of the jumping spring may be variable if the pulling wire changes.

5. After pressing the reset button, enter the signal detection interface and all sensing states are as shown in the picture above.

3-2 Electromagnet detection


press  Test each solenoid valve.

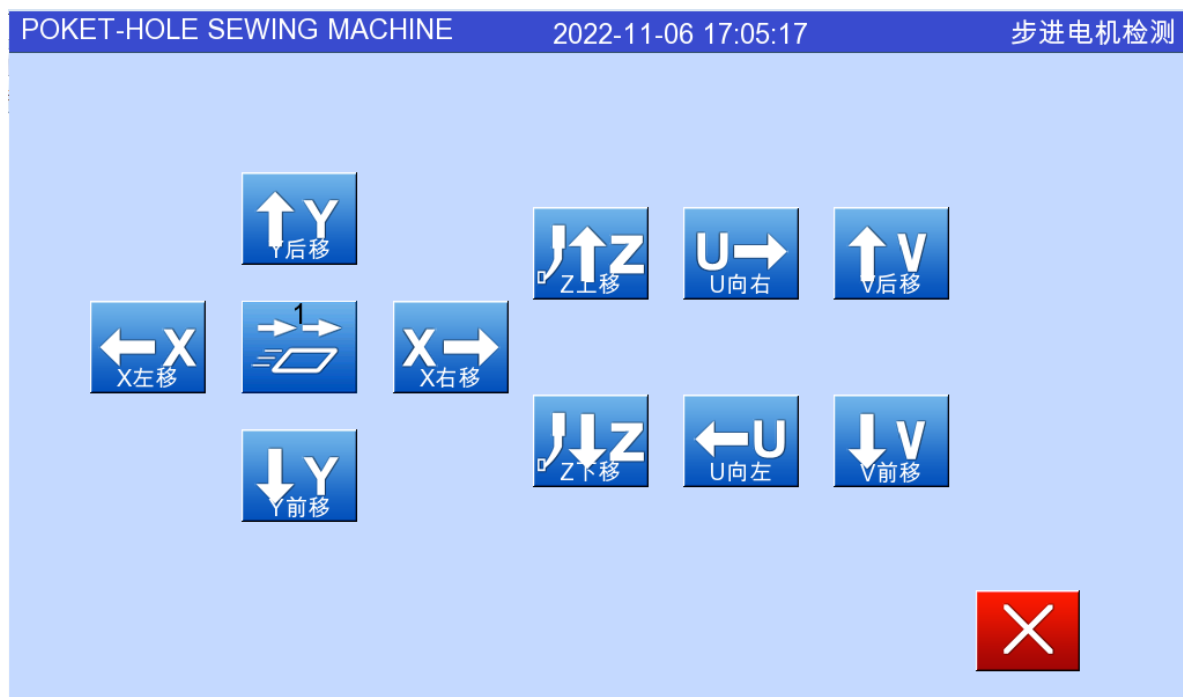
POKET-HOLE SEWING MACHINE				2023-12-13 14:52:31	Cylinder check	
Big frameJ1	Left/Right cutt	Laser switch	presser up/dow	Small cylinderJ3	J37	JC2
Alignment plate	Left/Right cutt	Laser UP/Down	presser in/out	Alignment plate	J38	JC6
Flip UP/Down	Front/Rear cutt	Tray UP/Down	tobe up/dw 3	Fabric bracket	Laser 1	Reserve
Flip Out/Back	Front/Rear fold	Tray clamp 1	Suction	Front/Rear cutt	Laser 2	Trimmer
Small clamp	UP/DOWN 1	Tray UP/Down	Flip UP/Down 2	Front/Rear fold	Laser 3	Release threac
Small clamp UP	UP/DOWN 2	Tray clamp 2	Flip OUT/BACK	Fabric bracket	Laser 4	Thread wiper
Small clamp OU	SPARE J15	Fix tray	Flip2	Fabric bracket		

Notice:

1. During inspection, pay attention to the action relationship between each machine to avoid irreparable problems.
2. The electromagnet cannot be opened for a long time and should be closed promptly after the test is completed to prevent the electromagnet from getting hot and burning out.
3. If there is no response in the test, check whether the fuse connection and the solenoid valve/electromagnet are normal.

3-3 step test

press  Test stepper motors and stepper drives.



4 Accessibility settings

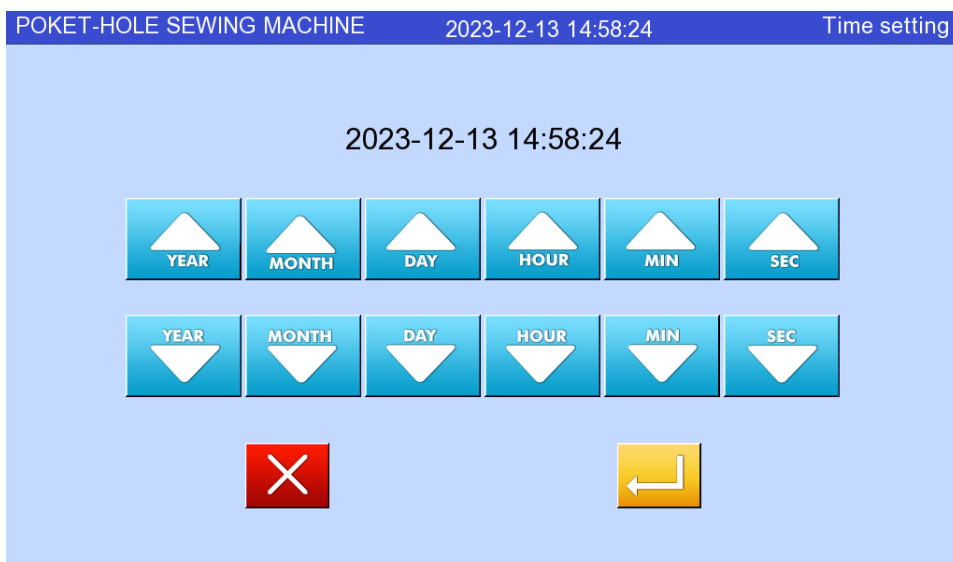
Touch on the main control interface  button to enter the main menu interface as follows:



In this interface, you can select the operating language, set the time, upgrade the screen program, initialize the machine, view version information, and set up installment payments, etc. Here is a brief description of this:

4-1 Time setting

Click  key to enter the following interface :



When your screen is used for a long time and the battery power is low, or the battery (CR2032) is replaced, the screen displays

The displayed date will be incorrect, and you need to make a date correction through



the above   button to set the date

time  save and exit.

4-2 language selection

Click  key to enter the following interface :




In this interface, you can select the operating language of the screen. Currently, only Chinese and English are supported. If this is displayed  icon, it means that every time you turn on the computer, you will be asked whether to switch the operating language. If you do not want to display this question, just press this icon to change to  This state is enough.


4-3 Upgrade backup

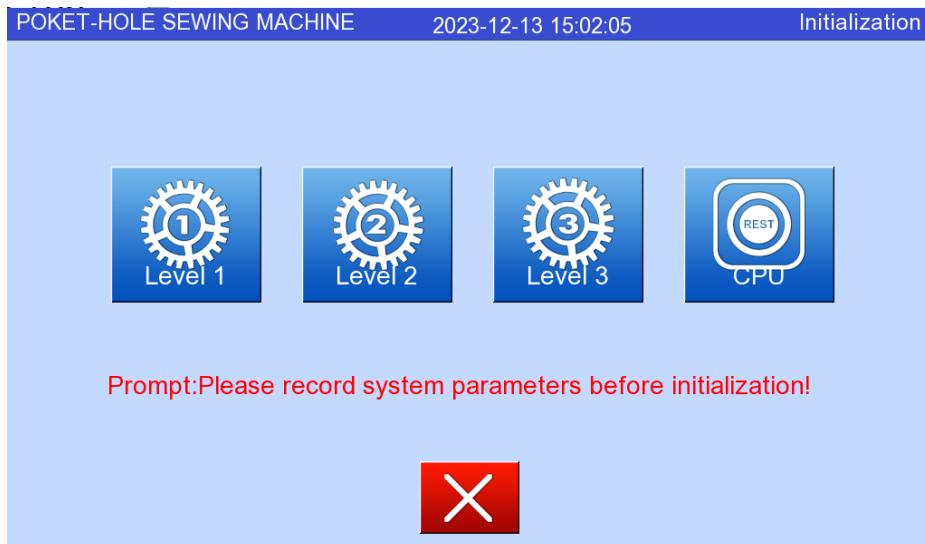
Click  button to enter the following interface :



When you plug the USB flash drive into the touch screen USB socket, click  button, the system will upgrade your touch screen program to the version number you need. After the upgrade is completed, you will be prompted to turn off the computer and unplug the USB flash drive, and then turn it on again to use the new version.。

4-4 Restore settings

Click  button to enter the following interface :




1 : After the new installation of the machine is completed, an initialization action needs to be performed before starting debugging. When the parameters of the machine are increased or decreased,


And when there are obviously incorrect timing actions during use, the equipment needs to be initialized;

2: When initializing, proceed from right to left, that is, starting from the controller, then level three, level two, and level one;

3: After the initialization is completed, you need to shut down the computer once. For

example: press  button, the following interface will be displayed:

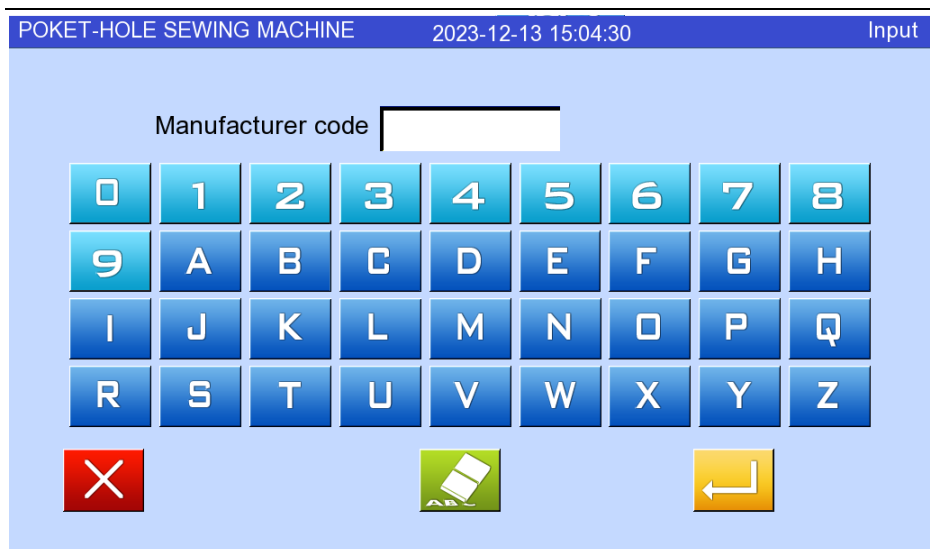


After entering your password, click  button, the screen will display: "E1013 controller initialization successful", which means the initialization of the controller is completed. Also initialize the third-level, second-level, and first-level parameters, and then shut down; if the initialization is not successful, prompt, the communication between the screen and the motherboard may have been disconnected, so you need to shut down and restart the computer before initializing it.

4-5 Installment setting interface

In the setting interface, press , enter the following interface:

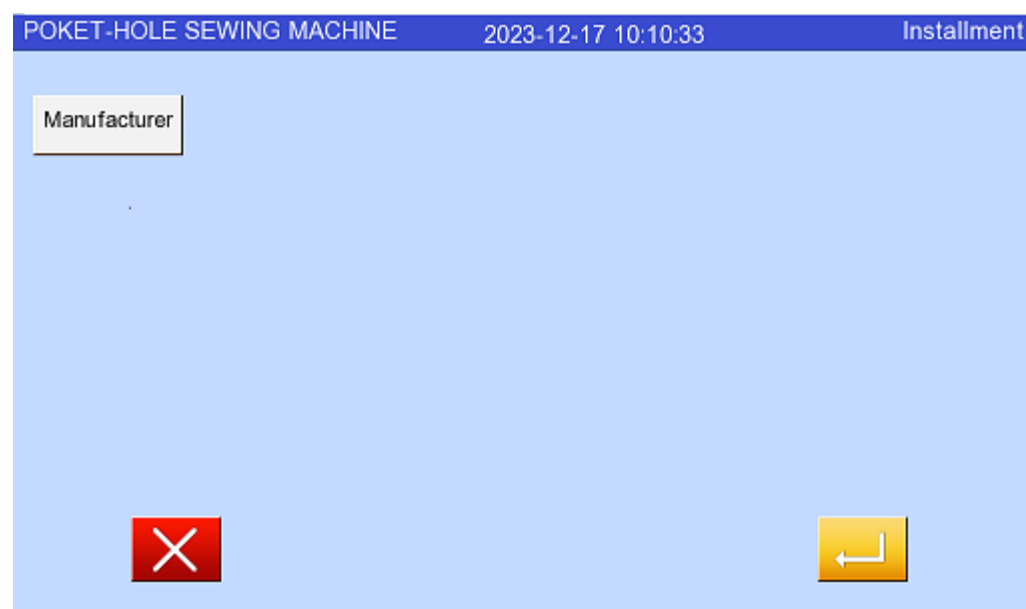
Note: Please proofread the date and time on the screen before setting up installment payment.



Enter the correct manufacturer number to enter the installment setting interface, press



button :



according to  button to enter the next interface :


POKET-HOLE SEWING MACHINE				2023-12-17 10:13:08				Input	
Manufacturer code				<input type="text" value="*****"/>					
<input type="button" value="□"/>	<input type="button" value="1"/>	<input type="button" value="2"/>	<input type="button" value="3"/>	<input type="button" value="4"/>	<input type="button" value="5"/>	<input type="button" value="6"/>	<input type="button" value="7"/>	<input type="button" value="8"/>	
<input type="button" value="9"/>	<input type="button" value="A"/>	<input type="button" value="B"/>	<input type="button" value="C"/>	<input type="button" value="D"/>	<input type="button" value="E"/>	<input type="button" value="F"/>	<input type="button" value="G"/>	<input type="button" value="H"/>	
<input type="button" value="I"/>	<input type="button" value="J"/>	<input type="button" value="K"/>	<input type="button" value="L"/>	<input type="button" value="M"/>	<input type="button" value="N"/>	<input type="button" value="O"/>	<input type="button" value="P"/>	<input type="button" value="Q"/>	
<input type="button" value="R"/>	<input type="button" value="S"/>	<input type="button" value="T"/>	<input type="button" value="U"/>	<input type="button" value="V"/>	<input type="button" value="W"/>	<input type="button" value="X"/>	<input type="button" value="Y"/>	<input type="button" value="Z"/>	
<input type="button" value="✖"/>			<input type="button" value="📶"/>			<input type="button" value="↩"/>			

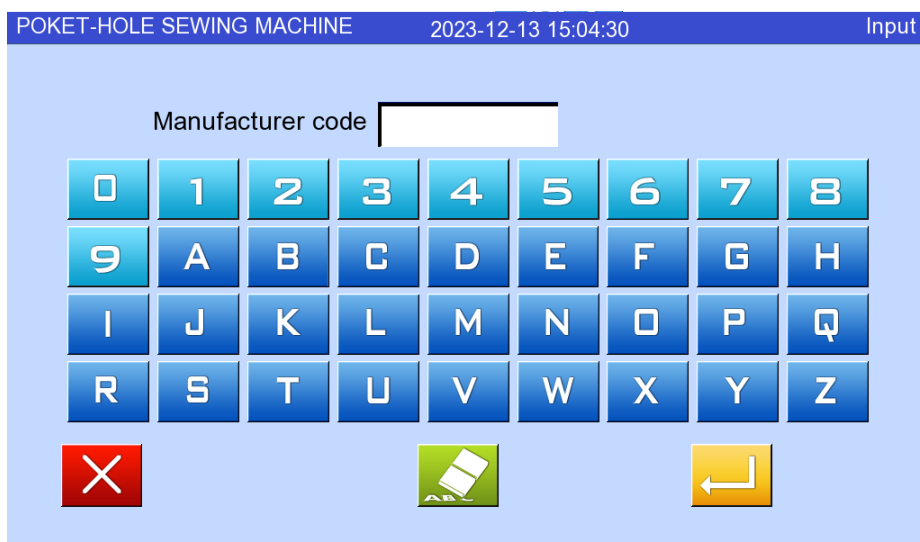
In this interface, enter the password and press button :


POKET-HOLE SEWING MACHINE				2023-12-17 10:15:36				Installment	
Manufacturer		<input type="text" value="SMD001"/>							
<input type="button" value="✖"/>			<input type="button" value="↩"/>						

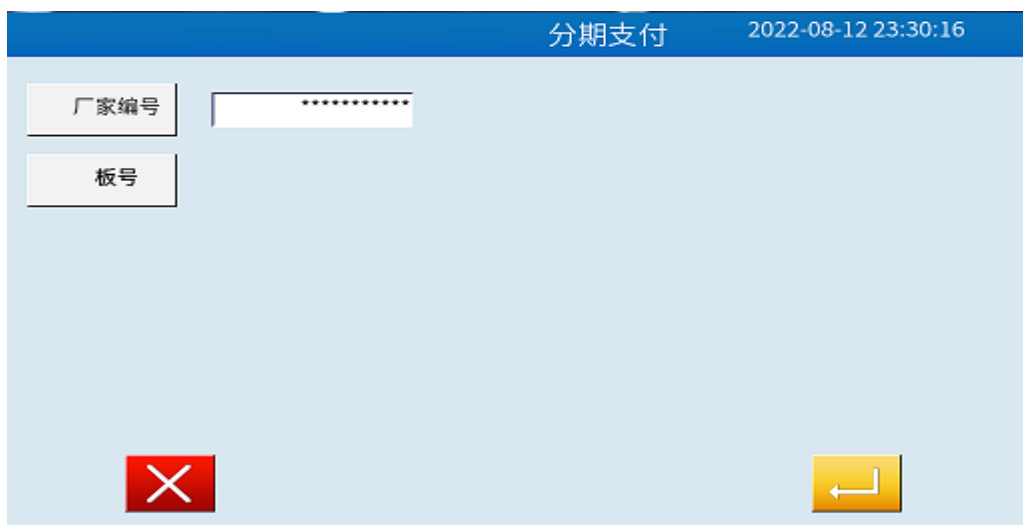
In this interface, enter the password and press button :



Press  button, enter the following interface:



After entering the manufacturer number, press  button :







Click Set the version number, that is, the machine number.

POKET-HOLE SEWING MACHINE 2023-12-17 10:18:39 Input

Board number

0	1	2	3	4	5	6	7	8
9	A	B	C	D	E	F	G	H
I	J	K	L	M	N	O	P	Q
R	S	T	U	V	W	X	Y	Z



  

After entering the board number, press  button,

POKET-HOLE SEWING MACHINE 2023-12-17 10:19:02 Installment

Manufacturer

Machine number

Click clock button to set the start time of the installment.

分期付款
2022-08-13 13:09:42

厂家编号

板号

SMD001

时钟

2022-08-13 13:09

超级密码

X

↩

Then click 超级密码 button to set a super password. This password can unlock all usage rights of installment payment.

POKET-HOLE SEWING MACHINE
2023-12-17 10:20:20
Input password

Password

Confirm password

X

ABC

↩

In this interface, press ↩ button,



POKET-HOLE SEWING MACHINE 2023-12-17 10:21:05 Installment

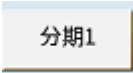
Manufacturer ***** Installment 1

Machine number 001

Clock 2023-12-17 10:19

Ultra password *****


according to  button to enter the following page :

POKET-HOLE SEWING MACHINE 2023-12-17 10:21:26 Date

2023 12



日 Sun	一 Mon	二 Tue	三 Wed	四 Thu	五 Fri	六 Sat
26	27	28	29	30	1	2
3	4	5	6	7	8	9
10	11	12	13	14	15	16
17	18	19	20	21	22	23
24	25	26	27	28	29	30
31	1	2	3	4	5	6




After selecting the date to be set, press  button :

Enter the password. This is the password for the first period. Remember it and press

 button,

POKET-HOLE SEWING MACHINE		2023-12-17 10:22:07		Installment	
Manufacturer	*****	Installment 1	2023-12-18		
Machine number	001	Installment 2			
Clock	2023-12-17 10:19				
Ultra password	*****				
					

In the same way, you can set installments 2, 3.... A total of ten installments can be set..

POKET-HOLE SEWING MACHINE		2023-12-17 12:54:52		Installment	
Manufacturer	*****	Installment 1	2023-12-18		
Machine number	001	Installment 2	2024-1-19		
Clock	2023-12-17 12:54:00				
Ultra password	*****				
					

In this way, the installment payment is successfully set up..

Appendix 1: Parameter default values

Parameter item	Function and description	Predetermined area	Initialization value
1.01	top speed	400 ~ 3200	2300
1.02	1st stitch speed	100 ~ 2000	200
1.03	2nd stitch speed	200 ~ 2500	300
1.04	3rd stitch speed	300 ~ 3000	400
1.05	Whether to trim the thread after emergency stop	1 allow , 0 prohibit	Don't cut
1.06	Needle stop position on spindle	0 ~ 4319	4000
1.07	Return the secondary origin path		Return the same way

1.08	Alternate parameters		850
1.09	Alternate parameters		200
1.10	Thread trimming switch	0 off, 1 on	on
1.11	Needle bar lifting angle	-120--120	0
1.12	Alternate parameters		170
1.13	Return to zero speed	1~ 4	3
1.14	Retrieval speed	1~ 18	10
1.15	Playing speed	1~ 5	3
1.16	Delay before press telescopic closing		60
1.17	Air pressure detection switch	0 off 1 on	detection
1.18	Air pressure detection switch polarity		constant
1.19	Automatic thread addition and trimming during empty feeding	0 no 1 yes	Don't add
1.20	Folding knife sensor switch		Detection
1.21	Press material lifting function switch		closure
1.22	Spindle optocoupler type		high speed
1.23	Emergency stop switch polarity	0 constant 1 Negate	Negate

1.24	Whether to detect the pallet sensor when taking the mold		Do not detect
1.25	loose wire switch		open
1.26	Z-axis speed	50---2000	80
1.27	Automatic thread trimming at the end of sewing	0 no, 1 add	do not add
1.28	Alternate parameters		6
1.29	Disconnection detection switch	0 off 1 open	open
1.30	operation counts		twice
1.31	Winding speed	1300-2500	1350
1.32	Whether to calibrate the spindle when inching	0 Not test. 1 test	no test
1.33	Suction switch		open
1.34	Disconnection detection frequency	1-45	35
1.35	Circulation board switch		open
1.36	Alternate parameters		0
1.37	Disconnection detection polarity		constant
1.38	Laser cutting speed		1680
1.39	Y reverse feeding	100-100	0

	synchronization verification		
1.40	X reverse feeding synchronization verification	-100-100	0
1.41	Y forward feeding synchronization verification	-100-100	0
1.42	X forward feeding synchronization verification	-100-100	0
2.01	X origin		0
2.02	Y origin		0
2.03	Trim opening angle	1000-----3000	110
2.04	Loose thread opening angle	2000-----4096	280
2.05	Clamp electromagnet PWM	10-----700	175
2.06	Large pressure plate electromagnet PWM	10-----700	350
2.07	Medium presser foot electromagnet PWM	10-----700	350
2.08	Pressure plate 2 electromagnet PWM	10-----700	350
2.09	x sensor polarity	0 constant , 1 Negate	constant
2.10	Y sensor polarity	0 constant-1 Negate	constant
2.11	Laser point time		100

2.12	Clamp opening angle	0-----1000	100
2.13	turning point speed		1500
2.14	Alternate parameters	0-----4	1
2.15	speed limit	400-----2700	2500
2.16	Alternate parameters	-300-----300	100
2.17	Turning method		Telescopic
2.18	Alternate parameters	0-----2000	0
2.19	Laser air feed speed		45
2.20	Maximum height of intermediate presser foot	30-----200	160
2.21	Medium presser foot motor sensor polarity	0 constant 1 Negate	constant
2.22	Alternate parameters	0constant 1negate	constant
2.23	Support board in place detection switch		Open
2.24	Alternate parameters		lay down
2.25	Alternate parameters	0 constant 1 negate	Negate
2.26	Horizontal sewing range	500-10000	8000
2.27	Longitudinal sewing range	400-10000	6500
2.28	Alternate parameters	0-350	300
2.29	Loose thread 0 Clamp thread 1		1
2.30	How long does it take for the		200

	laser head to lower to turn on the laser?		
2.31	How long does it take for the laser to start moving?	300---300	10
2.32	How long should the pressing plate be pressed down for cutting when taking out materials?		80
2.33	How long does it take for the laser to lift after the ironing is completed?	500---1500	10
2.34	Trim solenoid PWM		560
2.35	Loose Wire Solenoid PWM		175
2.36	Alternate parameters		Negate
2.37	How long does it take for the laser head to be raised?	0---250	100
2.38	Opening time of front and rear knives when descending	0-1000	200
2.39	Left and right knife opening time	0-1000	260
2.40	Left and right knife lowering opening time	0-1000	200
2.41	Left and right knife opening time	0-1000	260

2.42	Alternate parameters	0-1000	0
2.43	Left and right knife retraction time	0-1000	260
2.44	Left and right knife lifting time		260
2.45	Front and rear knife retraction time	0-20000	260
2.46	Front and rear knife lifting time		260
2.47	Overall hem rising time		260
2.48	flap opening time	0-1000	200
2.49	Flip plate pressing time		200
2.50	Pallet fixed opening time		260
2.51	Pallet 2 closing time		200
2.52	Pallet lifting time 2		350
2.53	U-axis movement time		80
2.54	Small pressure plate retraction time		100
2.55	Tray 2 opening time		300
2.56	Tray 1 closing time		200
2.57	Pallet lifting time 1		300
2.58	Enter the pattern modification interface XY delay time		1000
2.59	Bag type selection		fake bag

2.60	How long does it take for the large pressure plate to return after being pressed down?		300
2.61	flip switch		Open
2.62	Flip switch when modifying patterns		Open
2.63	Retrieval and return method		ordinary
2.64	Z first falling pulse		0
2.65	Z second falling pulse		0
3.01	Trimming speed	200-----500	250
3.02	Processing/testing switch	0 processing ',1 Test machine	processing
3.03	Delay before platen moves to the right	0-----60	100
3.04	There is a delay before the small plate is pressed and transferred to the laser point.		250
3.05	How long should the large pressure plate be lifted and pressed after sewing?	0---250	50
3.06	Positioning shutter opening		100

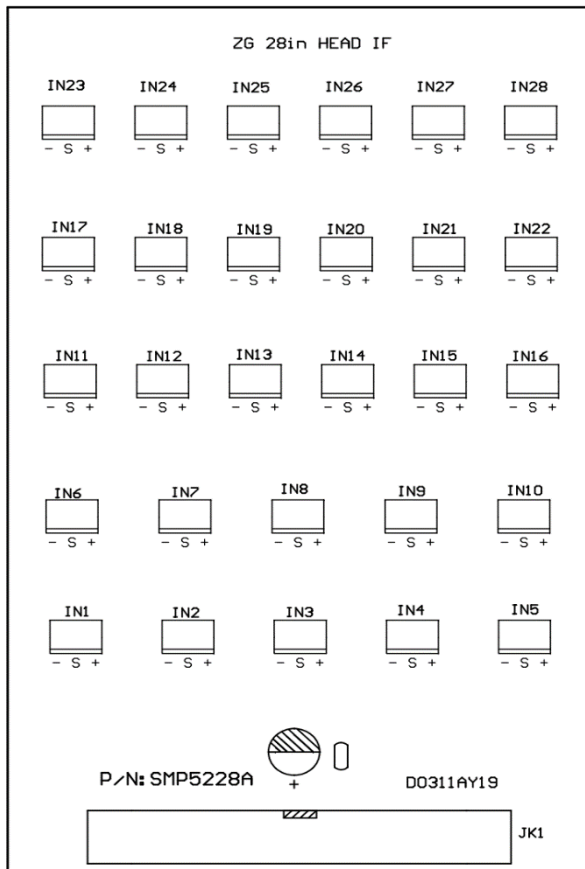
	time		
3.07	Alternate parameters	0 Don't lift, 1lift	lift
3.08	Folding switch		Open
3.09	Support board J32 function switch		open
3.10	Delay before closing of pressing material lifting		60
3.11	V-axis takes pallet position	10-----500	30310
3.12	U-axis feeding pallet position	0-----1000	80
3.13	Alternate parameters	0-----9000	2500
3.14	Alternate parameters		545
3.15	X Motor transmission ratio		384.0
3.16	Y Motor transmission ratio		320.0
3.17	V-axis extension position		30310
3.18	U-axis takes the pallet position		32384
3.19	Medium presser foot motor type		0
3.20	Safe distance waiting for V-axis retraction		5000
3.21	500 pulse width	100-----950	500
3.22	1000 pulse width	100-----950	520

3.23	1500 pulse width	100-----950	540
3.24	2000 pulse width	100-----950	560
3.25	2500 pulse width	100-----950	580
3.26	3000 pulse width	100-----950	600
3.27	safe location X		-749
3.28	safe location Y	100-----950	527
3.29	Picking position X		20520
3.30	Picking position Y		0
3.31	Receiving position X	100-----950	0
3.32	Receiving position Y	100-----950	0
3.33	U-axis moving speed to the right		9
3.34	V-axis extension and retraction speed		9
3.35	J31 Function switch		Open
3.36	Accelerate the number of stitches		1
3.37	Pattern center point X offset		288.6
3.38	Pattern center point Y offset		-0.2
3.39	Laser center point X offset		54.5
3.40	Laser center point Y offset		0
3.41	ADC detection switch		关闭

3.42	ADC reference value		0
3.43	How long does it take to press the large platen down to press down the Z axis?		0
3.44	How long does it take for the small pressing plate to close and the large pressing plate to press down?		200
3.45	ADC detection alarm switch		Off

Appendix 2 Input and output wiring table:

Input signal table



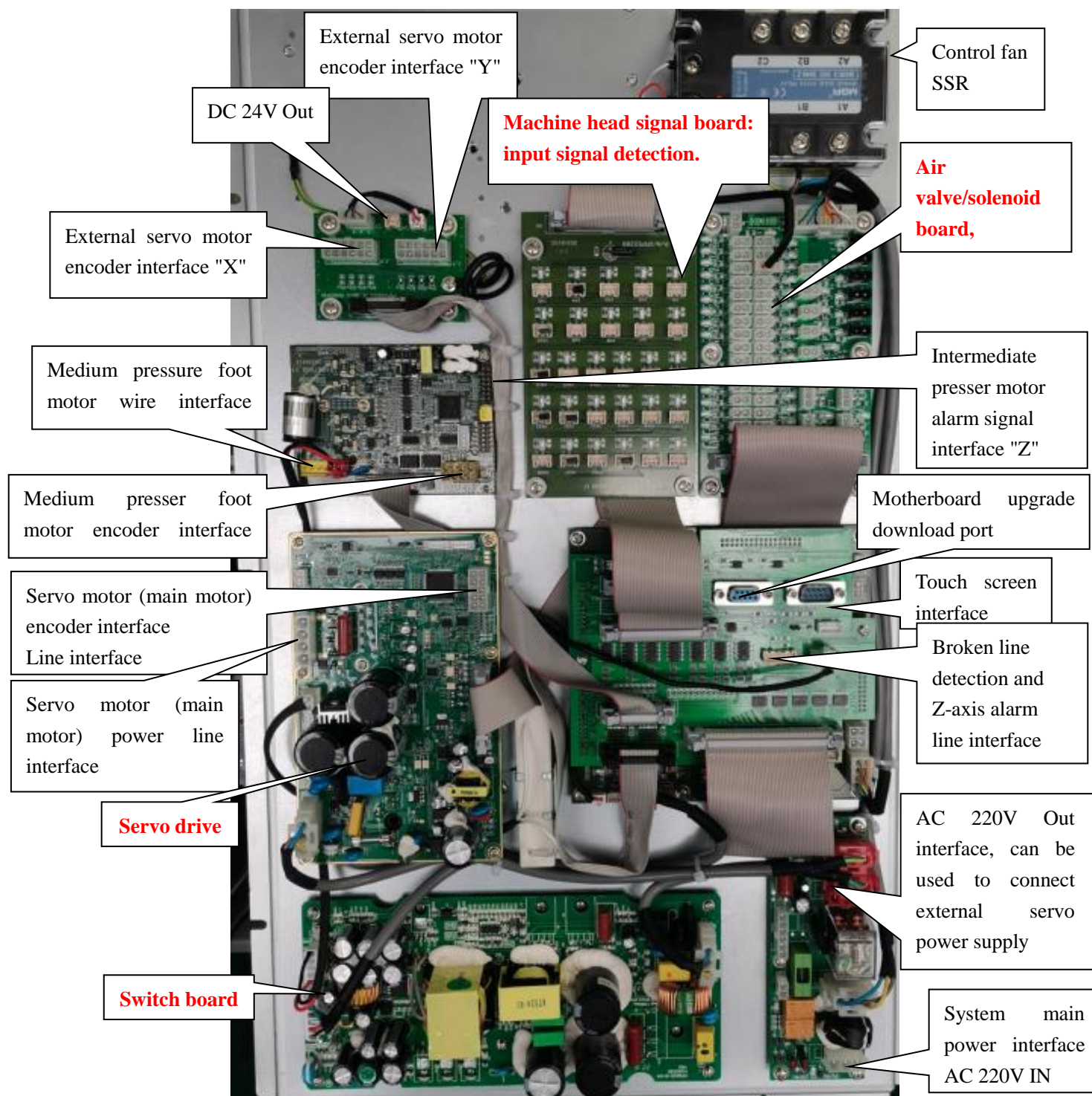
Signal name	Socket number	Socket specifications	State after returning to zero
X origin	IN1	1*3P	on
Y origin	IN2	1*3P	off
	IN3	1*3P	NC
Sewing start	IN4	1*3P	off
Disconnection detection	IN5	1*3P	off
Air pressure detection	IN6	1*3P	off
V axis signal	IN7	1*3P	off
Sewing emergency stop	IN8	1*3P	off
Under the pressure plate	IN9	1*3P	on
	IN10	1*3P	NC
Folding starts	IN11	1*3P	off
U-axis signal	IN12	1*3P	off
Pallet in place	IN13	1*3P	off
Lift and lower 2 times	IN14	1*3P	off
Lift 2 up	IN15	1*3P	on
pressure plate	IN16	1*3P	off
Send mold button	IN17	1*3P	off
Clamping button	IN18	1*3P	off
Lift 1 up	IN19	1*3P	on
Under Tob	IN20	1*3P	
Emergency	IN21	1*3P	on

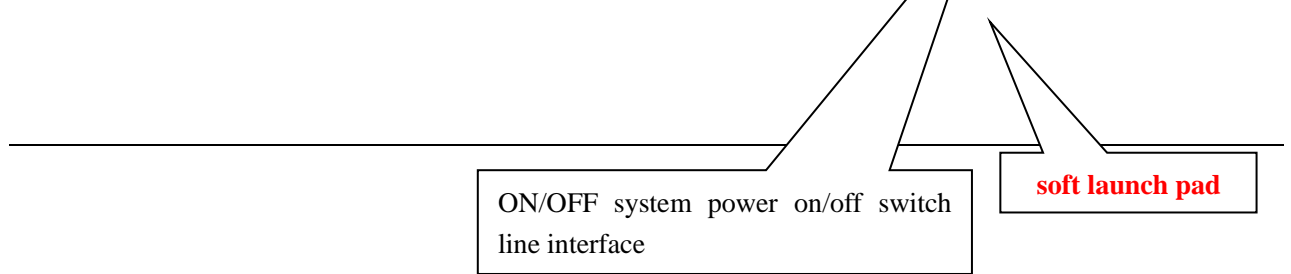
stop for folding materials			
Tobzuo	IN22	1*3P	NC
Lift and lower 1 time	IN23	1*3P	off
On the front and back knives	IN24	1*3P	on
Before and after the knife	IN25	1*3P	off
On the left and right knives	IN26	1*3P	on
Right and left knife	IN27	1*3P	off
Tob right	IN28	1*3P	
	mother board	JK2	
	mother board	JK2	
	mother board	J6	4P
	mother board	J6	5
	mother board	J6	6
		J6	3

Folding knife front and rear	J12	off
Lift and lift 1	J13	off
Lift and lift 2	J14	off
NC	J15	
laser switch	J16	off
laser lift	J17	off
Pallet lifting 1	J18	off
Pallet 1	J19	off
Pallet lifting 2	J20	off
Pallet 2	J21	off
Pallet fixing	J22	off
Press material lifting	J23	
Press material telescopic	J24	
Tob	J25	off
Suction	J26	
NC	J27	
NC	J28	
NC	J29	
NC	J30	
Positioning baffle 2	J31	

Tob Lift 2	J32	(Use this air valve when using a lift)
NC	J33	
NC	J34	
Tob lift 1	J35	
About Tob	J36	
NC	J37	
NC	J38	
NC	JC1	off
NC	JC2	off
Trimming	JC3	off
Loose line	JC4	off
NC	JC5	
NC	JC6	off

Appendix 3 Electronic control configuration diagram





Appendix 4 Alarm code table

<item number="03" value="E003 The telescopic board is not retracted in place " />

<item number="06" value="E006 Please select a pattern " />

<item number="07" value="E007 The expiration date has expired, please contact
the manufacturer ! " />

<item number="08" value="E008 The spindle is overloaded, please shut down
the machine " />

<item number="09" value="E009 The spindle does not move to the specified position "
/>

<item number="10" value="E010 Out of sewing range 1" />

<item number="11" value="E011 Please press the confirm button " />

<item number="12" value="E012 The system is locked, please check the
emergency stop switch " />

<item number="13" value="E013 System is unlocked " />

<item number="14" value="E014 X-axis zero return failed " />

<item number="15" value="E015 Y axis zero return failed " />

<item number="16" value="E016 Z axis zero return failed " />

<item number="17" value="E017 U-axis zero return failed " />

<item number="18" value="E018 The number of stitches is enough, we need to
finish it first " />

<item number="19" value="E019 Emergency stop switch is stuck " />

<item number="20" value="E020 The current operation has not ended yet " />

<item number="21" value="E021 Extra long single-step stitch length " />

<item number="22" value="E022 Overall mobile operation not confirmed " />

<item number="23" value="E023 Invalid operation " />

<item number="24" value="E024 The press frame has not been put down. Please
check the system parameters for the number of press
frames. " />

<item number="25" value="E025 Thread trimming is disabled " />

<item number="26" value="E026 The lifting motor does not turn to the right
position " />

<item number="27" value="E027 Spindle encoder failure " />

<item number="28" value="E028 Execute first and then test " />

<item number="29" value="E029 The number of consecutive seam jumps exceeds
the limit " />

<item number="30" value="E030 Operation canceled, exiting " />

<item number="31" value="E031 Return to zero failed " />

<item number="32" value="E032 Length and width cannot be zero at the same
time " />

<item number="33" value="E033 Please do not press the launchpad " />

<item number="34" value="E034 Tricks don't exist " />

<item number="35" value="E035 The number of stitches in the pattern exceeds the
standard " />

<item number="36" value="E036 Returning to zero position, please wait..."
/>

<item number="37" value="E037 Beyond sewing range 2" />

<item number="38" value="E038 Alarm when the bottom thread runs out, press the
bottom thread transfer key or cancel key " />

<item number="39" value="E039 There are too few needle points and the save
is invalid. " />

<item number="41" value="E041 Processing, please wait..." />

<item number="42" value="E042 The data format on the USB disk does not meet
the requirements of this system " />

<item number="43" value="E043 Reading USB flash drive, please wait..." />

<item number="44" value="E044 Air pressure is too low or no air " />

<item number="45" value="E045 The output has reached the set value and will
be counted again " />

<item number="49" value="E049 U-axis zero return failed " />

<item number="50" value="E050 V-axis zero return failed " />

<item number="51" value="E051 W-axis zero return failed " />

<item number="54" value="E054 V-axis origin cannot be detected " />

<item number="57" value="E057 The large pressure plate is not lifted or the sensor
cannot detect it. Please check the sensor. " />

<item number="61" value="E061 X-axis failure, please shut down and check "
/>

<item number="62" value="E062 Y-axis failure, please shut down and check "
/>

<item number="64" value="E064 The large pressure plate is not put down or
cannot be detected by the sensor. " />

<item number="65" value="E065 The folding emergency stop is in progress.
Please check the folding emergency stop button. " />

<item number="68" value="E068 The pressure plate is not in the zero return
position. Move the pressure frame position after shutting
down the machine. " />

<item number="78" value="E078 Folding material in emergency stop " />

<item number="80" value="E080 The pressure plate is not at the origin
position. Return to zero before starting again. " />

<item number="96" value="E096 Please press the return to zero button first
" />

<item number="97" value="E097 Z(presser foot lift) axis failure, please
shut down and check. " />

<item number="98" value="E098 The V-axis is not at the origin, please shut down
and check. " />

<item number="100" value="E100 Threading in progress, press the Enter key
after threading. " />

<item number="102" value="E102 Please press OK button when finished " />

<item number="113" value="E113 The intermediate presser foot (Z axis) is
not raised to the upper sensing position " />

<item number="116" value="E116 Please confirm that the upper shaft is at
the needle stop position before returning to zero. " />

<item number="133" value=" E133 Cannot sense on the pressure plate " />

<item number="208" value="E208 The material retrieval is in emergency stop.
Please pay attention or shut down when resetting. " />

<item number="401" value="E401 The sensor on the pressure plate does not
sense " />

<item number="402" value="E402 The sensor under the pressure plate does not
sense " />

<item number="403" value="E403 Lift 1 is not detected when it reaches the upper
position. " />

<item number="404" value="E404 Lifting and lowering 1 time to reach the position but
not detected " />

<item number="405" value="E405 Lift 2 is not detected when it reaches the
upper position. " />

<item number="406" value="E406 Lifting and lowering 2 times to reach the position
but not detected " />

<item number="407" value="E407 The small pressure plate is not put down "
/>

<item number="408" value="E408 The flap is not put down " />

<item number="409" value="E409 The big pressure plate is not put down " />

<item number="410" value="E410 The small pressure plate is not lifted " />

<item number="411" value="E411 The front and rear knives are not in place " />

<item number="412" value="E412 The front and rear blades are not in place " />

<item number="413" value="E413 The left and right knives are not in place "

/>

<item number="414" value="E414 The left and right knives are not in place "

/>

<item number="415" value="E415 Do not hold down the start button for a long time "

/>

<item number="416" value="E416 Do not hold down the clamp button " />

<item number="417" value="E417 Do not press and hold the mold feed button " />

<item number="418" value="E418 Top right position is not detected " />

<item number="419" value="E419 The support is in place but not detected. "

<item number="420" value="E420 Top left position is not detected " />

<item number="421" value="E421 Please finish inching the laser data " />

<item number="422" value="E422 Flip and lift without retracting " />

<item number="423" value="E423 The pressing material is turned over but not

retracted " />

<item number="424" value="E424 If the ADC value of the large platen is abnormal,

please check. " />

<item number="720" value="E720 Please check V-axis or sensor " />

<item number="1000" value="E1000 Are you sure you want to delete the selected

pattern? ? " />

<item number="1001" value="E1001 Are you sure you want to delete the selected
system pattern? ? " />

<item number="1002" value="E1002 Are you sure you want to delete the selected U
disk pattern? ? " />

<item number="1003" value="E1003 deleted ! " />

<item number="1004" value="E1004 Save completed ! " />

<item number="1005" value="E1005 Saving, please wait..." />

<item number="1006" value="E1006 Deleting, please wait..." />

<item number="1010" value="E1010 First-level parameter initialization successful ! " />

<item number="1011" value="E1011 Secondary parameter initialization successful ! "
/>

<item number="1012" value="E1012 Level three parameters initialized successfully ! "
/>

<item number="1013" value="E1013 Controller initialization successful ! " />

<item number="1014" value="E1014 First-level parameters saved successfully ! " />

<item number="1015" value="E1015 Secondary parameters saved successfully ! "

<item number="1016" value="E1016 Level 3 parameters saved successfully ! "

<item number="1020" value="E1020 Pattern saved successfully ! " />

<item number="1021" value="E1021 Pattern saving failed ! " />

<item number="1022" value="E1022 The second origin point of the pattern is saved
successfully ! " />

<item number="1023" value="E1023 Whether to exit the board ? " />

<item number="1024" value="E1024 Whether to exit pattern editing ? " />

<item number="1025" value="E1025 There was pattern data that was not saved
before the last shutdown. Do you want to save it? ? " />

<item number="1030" value="E1030 Transferring files, please wait...." />

<item number="1031" value="E1031 Calculating, please wait..." />

<item number="1032" value="E1032 Calculation completed " />

<item number="1033" value="E1033 Transfer completed " />

<item number="1050" value="E1050 old password " />

<item number="1051" value="E1051 New Password " />

<item number="1052" value="E1052 Confirm the new password " />

<item number="1053" value="E1053 Password reset complete " />

<item number="1054" value="E1054 wrong password " />

<item number="1055" value="E1055 The new password entered twice is not the
same " />

<item number="1056" value="E1056 password can not be blank " />

<item number="1057" value="E1057 The new password is the same as the old
password " />

<item number="1058" value="E1058 Whether to exit pattern conversion ? " />

<item number="1060" value="E1060 Disconnection or disconnection detection
frequency does not match " />

<item number="1061" value="E1061 Bottom line or bottom line detection
frequency does not match " />

<item number="1070" value="E1070 Some solenoid valves do not meet current
exit requirements " />

<item number="1080" value="E1080 Use period modified successfully " />

<item number="1081" value="E1081 Installment payment is set, but the time cannot
be set " />

<item number="1100" value="E1100 Incorrect selection location。 " />

<item number="1101" value="E1101 Logo set successfully!" />

<item number="1102" value="E1102 Failed to set logo!" />

<item number="1103" value="E1103 Are you sure to upgrade the touch screen
system??" />

<item number="1104" value="E1104 No upgrade file found, please confirm that the
upgrade file exists on the USB flash drive。 " />

<item number="1200" value="E1200 There are %d days left before the license
expires, please contact the manufacturer for payment.
" />

<item number="1201" value="E1201 Please turn off the power and turn it on
again " />

<item number="1300" value="E1300 Upgrading, please wait...." />

<item number="1301" value="E1301 Upgrade completed, please power off and
then on again " />

<item number="1302" value="E1302 Upgrade failed, please check the upgrade
file " />

<item number="1303" value="E1303 Please turn off the power first and then
on again " />

<item number="1304" value="E1304 Please turn off the power first and then

on again to complete the screen calibration. " />

<item number="1305" value="E1305 Please insert the USB flash drive

containing the logo image file first. " />

<item number="1306" value="E1306 BMP image file not found in USB flash

drive, please confirm " />

<item number="1307" value=" E1307 Program backup completed..." />

<item number="1308" value="E1308 Program recovery is complete, please turn

off the power first and then\npower on again " />

<item number="1309" value="E1309 Parameter backup completed..." />

<item number="1310" value="E1310 Parameter recovery completed " />

<item number="1311" value="E1311 Backup file not found, please check " />

<item number="1312" value="E1312 Capacitive screen, no correction required

" />

<item number="1313" value="E1313 Calibration failed " />

<item number="1314" value="E1314 Backup failed " />