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目录

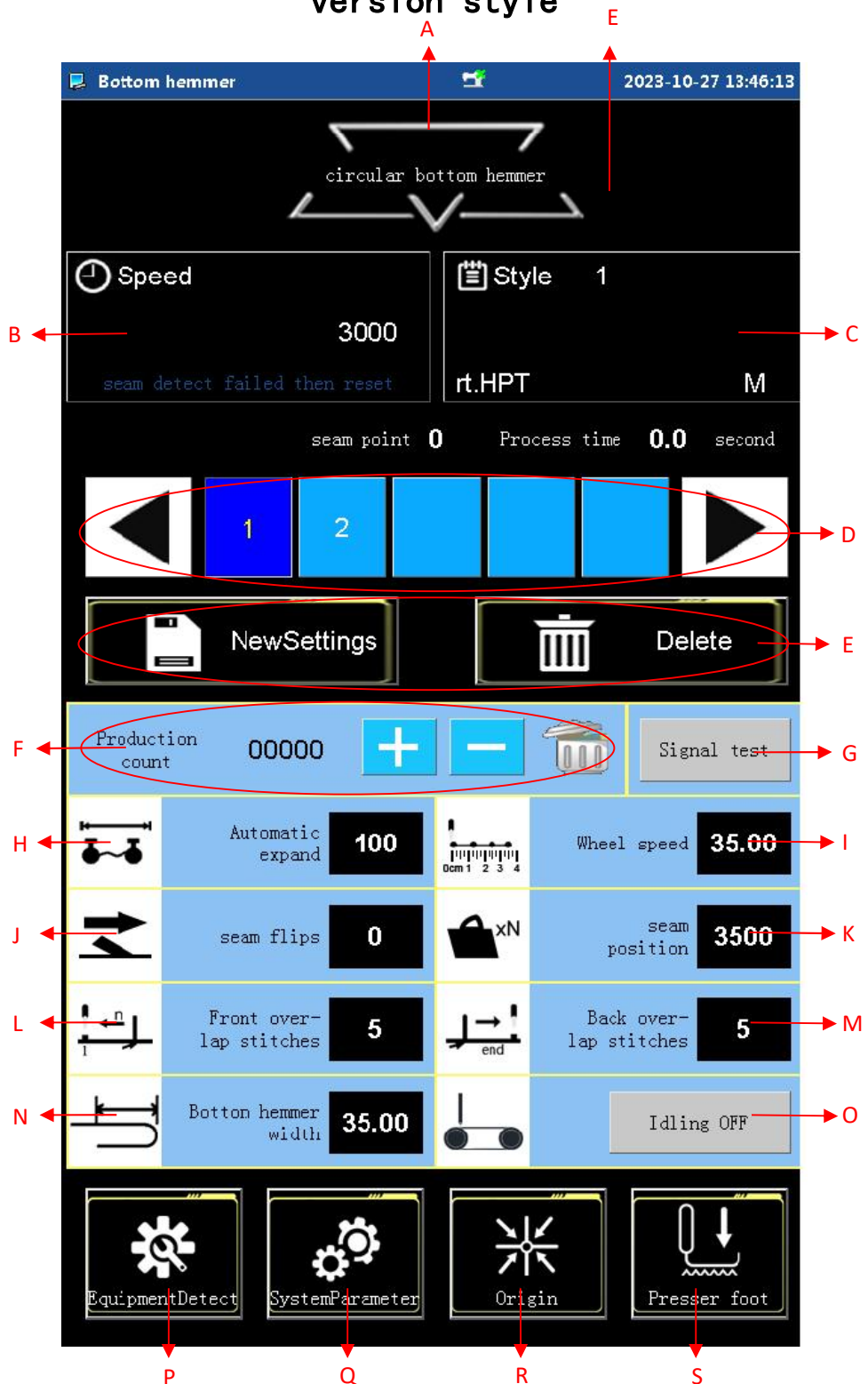
Chapter 1: Boot interface

This machine supports multiple langugesand cn switch system langhuages accordi to the user。After turning on the power ,click on the foreigin or Chinese button accoding to user needs to enter the opation interface.

Function Descrption:

order	function	content
A	Foreigin language	This dispaly cna be dispalyed in the system parameters->Main interface set->Parameter 1
B	Chinese	Display Chinese

Chapter 2: Setings and functions related to large version style

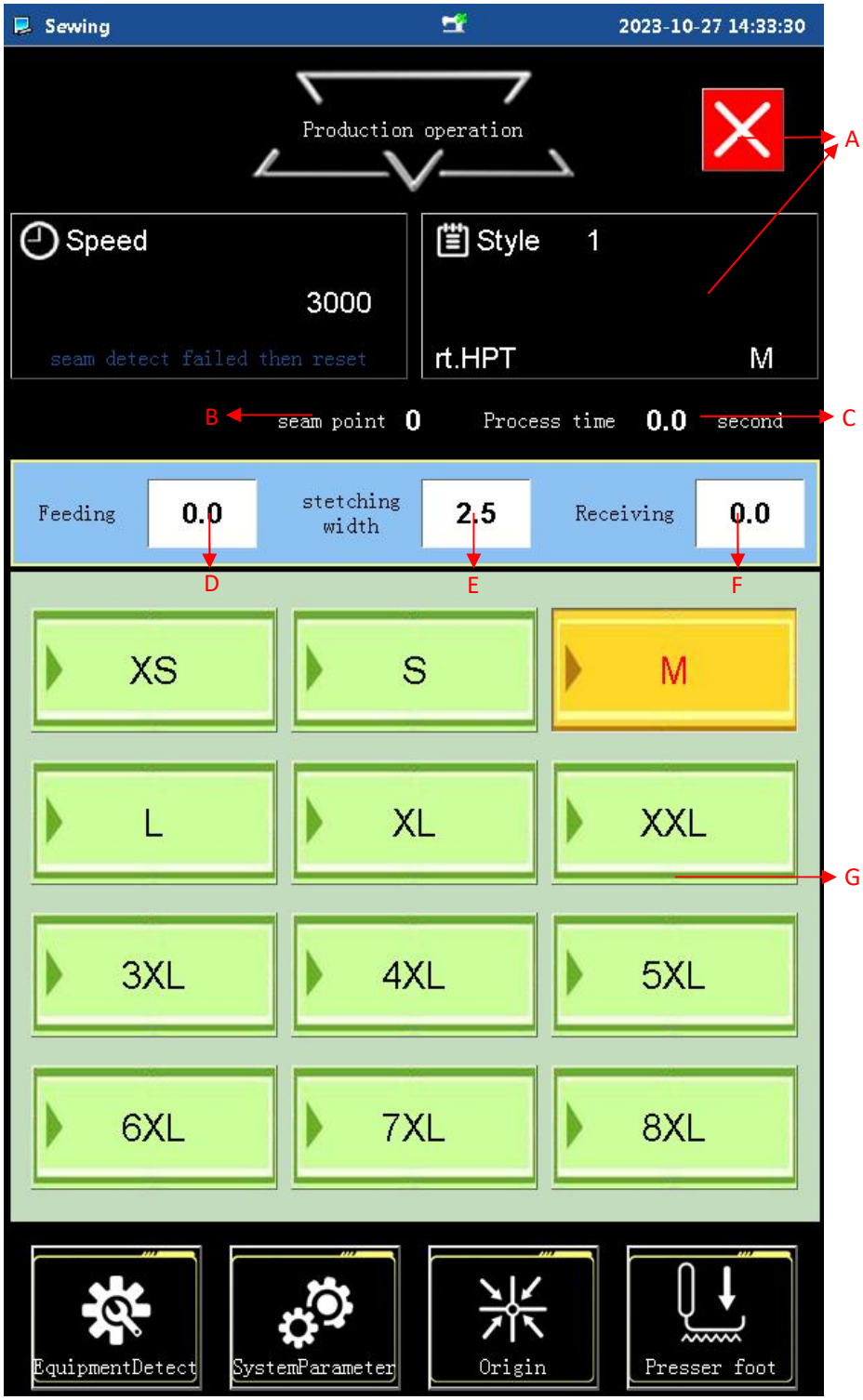


Mian interface function description：

order	function	content
A	circularbottomhemmer	Click here to enter the startup interface
B	Speed and its prompt text	Set running speed prompt text displays
C	Style information and sewing iterfacee	Click on the style number and size to enter the sewing interface
D	Style List	Style List, choose aa larger style
E	New and Delete	Create and delete style
F	Production count	Count addition/subtraction,clear to zero,click to
G	Signaltest	Input or output signal interfaces
H	Automatic expansion	Display Automatic expansionof the naddage ,chilk to enter the interface
I	Wheel speed	Ste hel speeds value
J	Inverted stock	Display the duration of inverted blowing,click to enter intered interface
K	Seam postion	Display the detected stock posttion value and enter the stock position interface
L	Frontoverlapstitches	Set running speed prompt text displays
M	Ackover lapstitches	Set value Ackover lapstitches
N	Bottomhemmer widt	Display the bottonhemmer width value,click to enter the hem width setting interface
O	Idling	Idling: OFF\ON
P	Device detect	Click to enter the device detection
Q	SystemParameter	Click to enter the system para
R	Origin	Home return funtion
S	Presser foot	Reewer the presser foot

2.1 Sewing interface

Click on the style button。As shown in the figures。



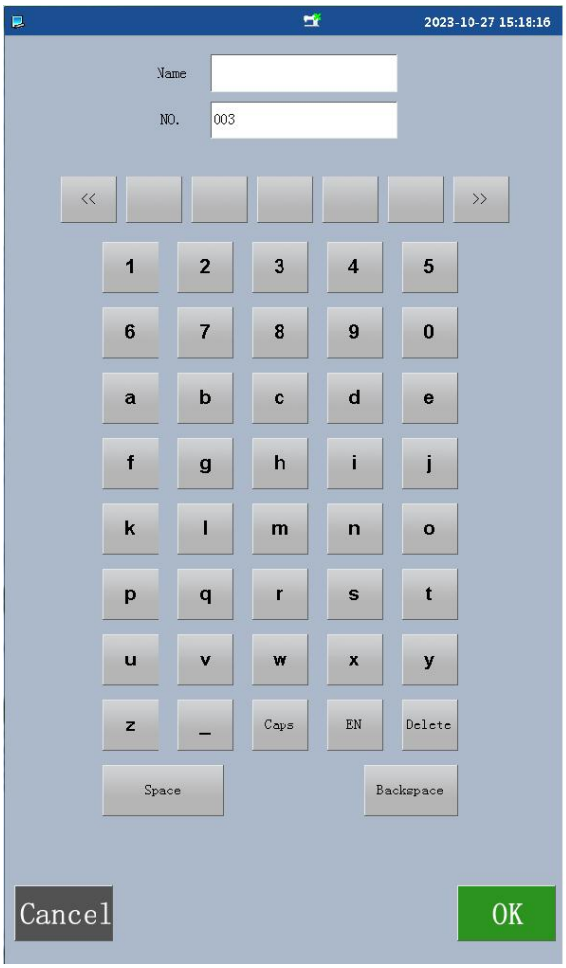
Function Descriptions：

order	function	content
A	Exit	Click to eixt and enter the main interface

B	Sean point	Display sean point
C	Process time	Display Preocess time
D	Feeding	Set material placement values,with different size parameter values tips:Automatic expansion->Whether to open automatic stretch mode /Turn on control parameter display and hide
E	Stetching width	Set hetension value,different sizes have different
F	Feeding	Set feed values continuoush adh
G	Automatic expansion	Automatic expansion

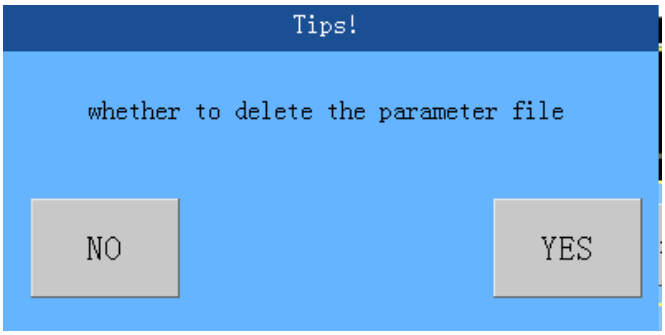
2.2 New style

Click the button “New Settings ” on the main interface to enter the interface and set the style and number，Click Cancel to exit the New Style interface。As shown in the figures。



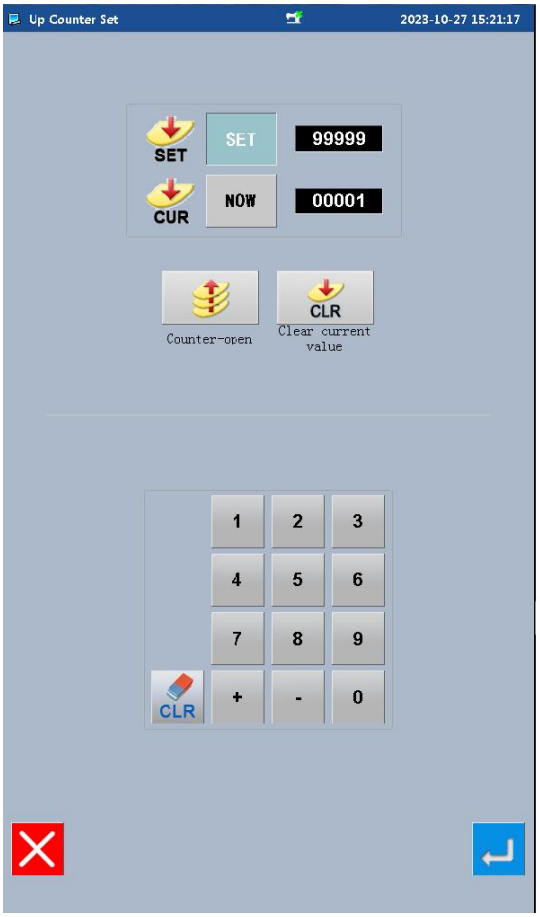
2.3 Delecte Style

Click the delete button on the main interface and a prompt box will popup。 Click to confirm the successful deletion the style ,click Cancel to exit the delection of the style。



2.4 Productioncount

Click the button on the main interface called Production count value， enter the countup setting interface。 As shown in the figures。



Contain：

1.Production count setting value (total count seting)。

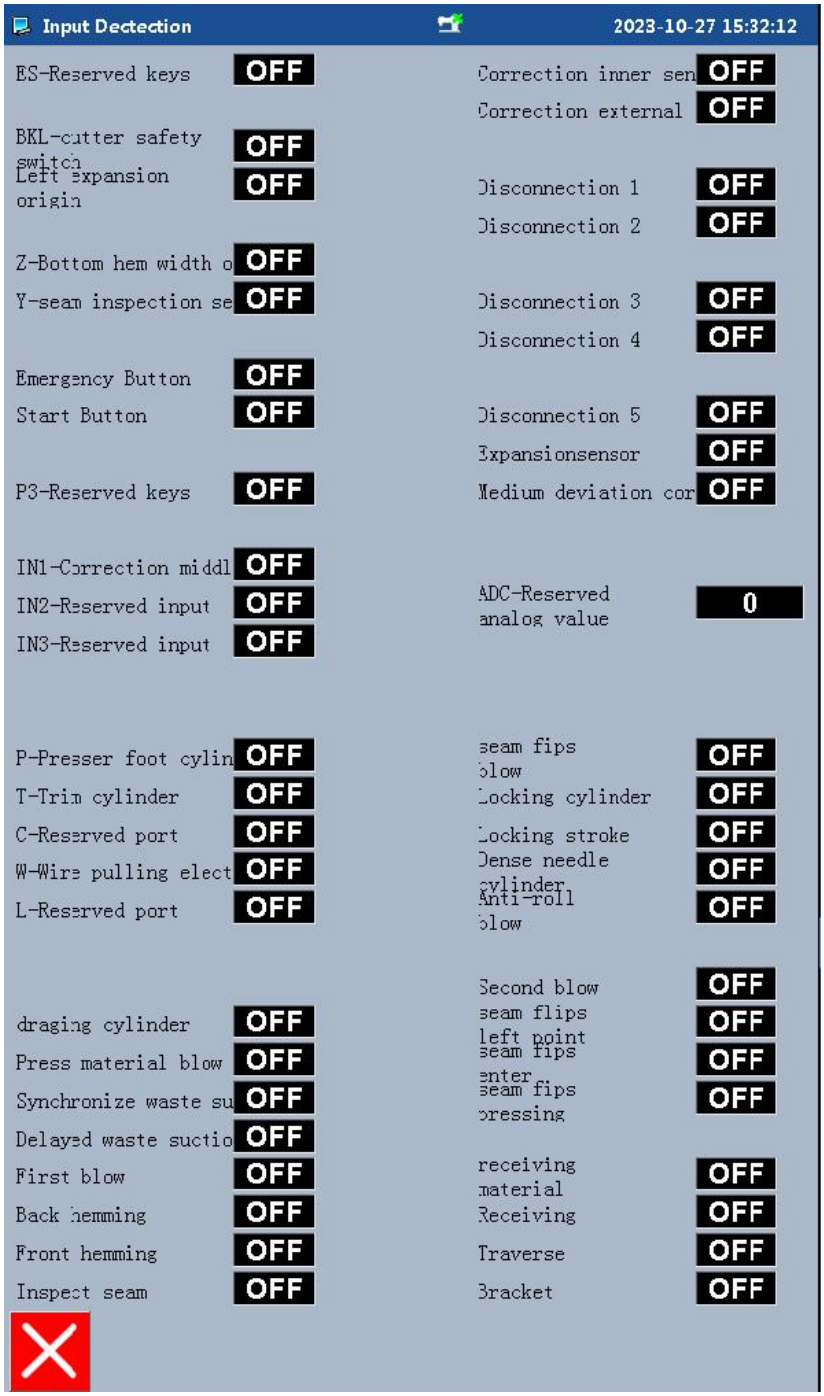
2.Production Count Current Value Seting。

3.Counter function switch button。

4.Clear current value button。

2.5 Input Deaction

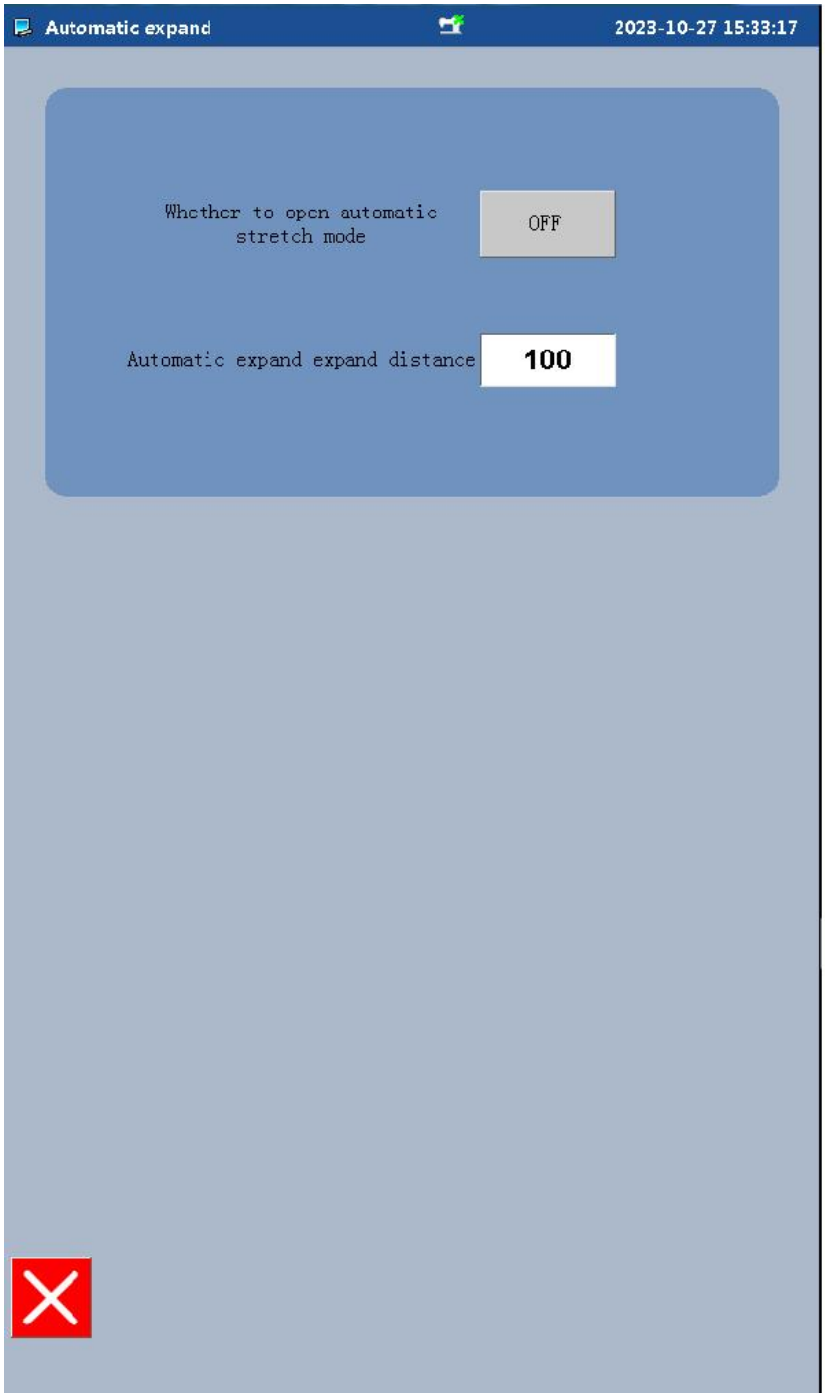
Click the input deaction button on the main interface the to enter the signaal detection interface。 Ask for communication to cpntrol signal off/on。As shown in the figures。



S

2.6 Automatic perimeter calculation

Click on the main intn toenter the textedit fotmtice perimer calculation ,and enter the corresponding value of relativeprinting expansion。As shown in the figures。



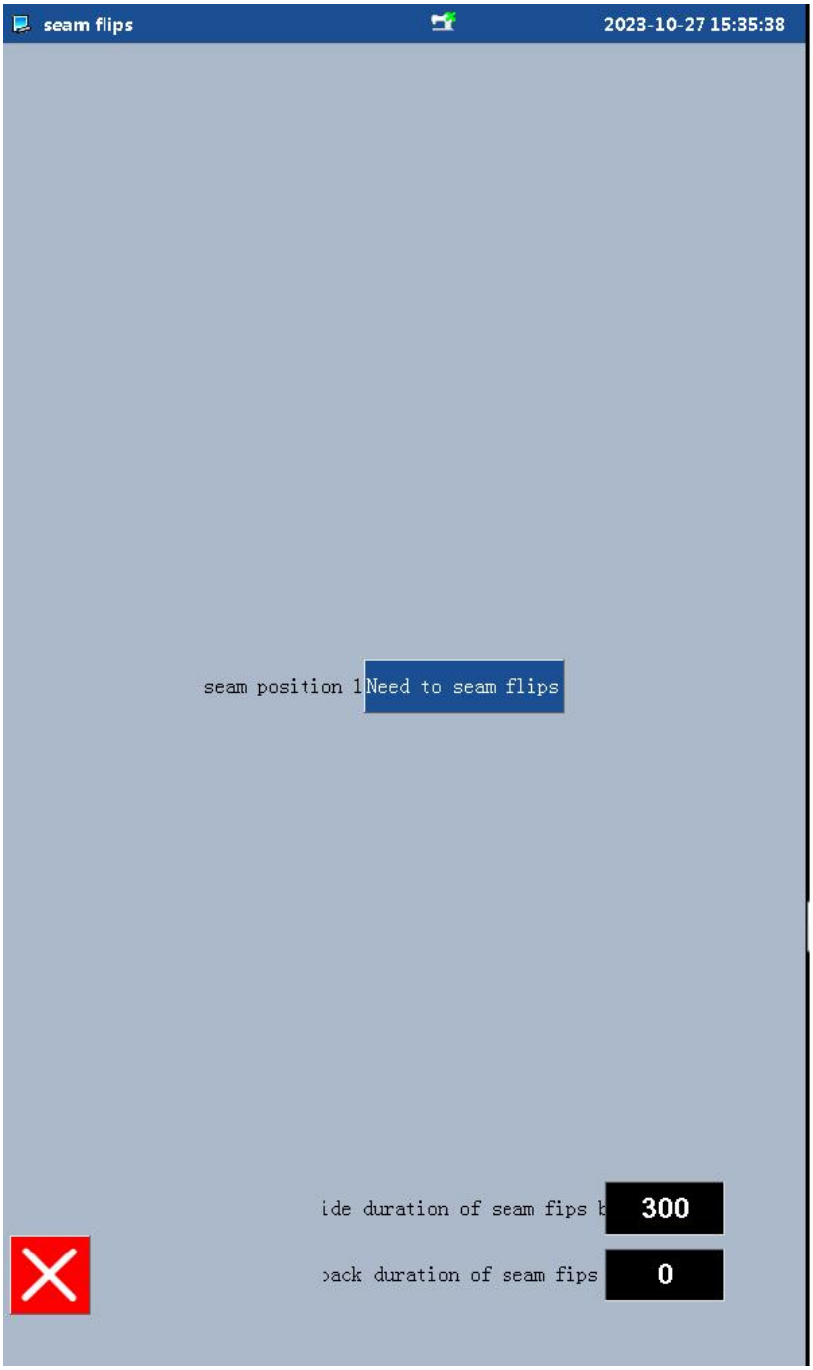
contains：

1.Automatic expansion->Whether to open automatic stretch mode /Turn on control parameter display and hide

2.Automatic strecching andepansion parametr settingss

2.7 Seam flips

Click the Seam flips button on the main interface the to enter the seam flips interface。As shown in the figures。

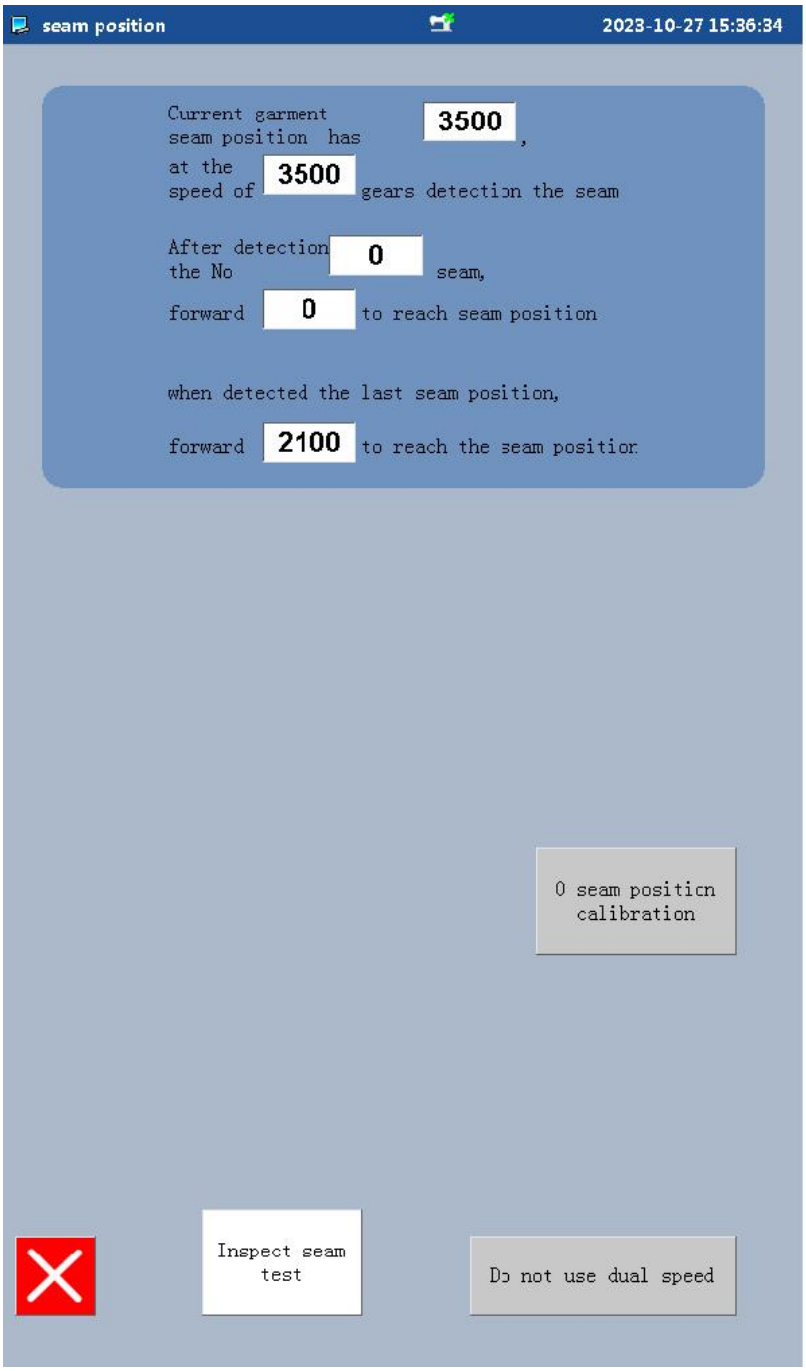


contains：

1.Seam position switch 1。No seam flips/Need to seam filipss。
2.Inside duration of seam fips blow。

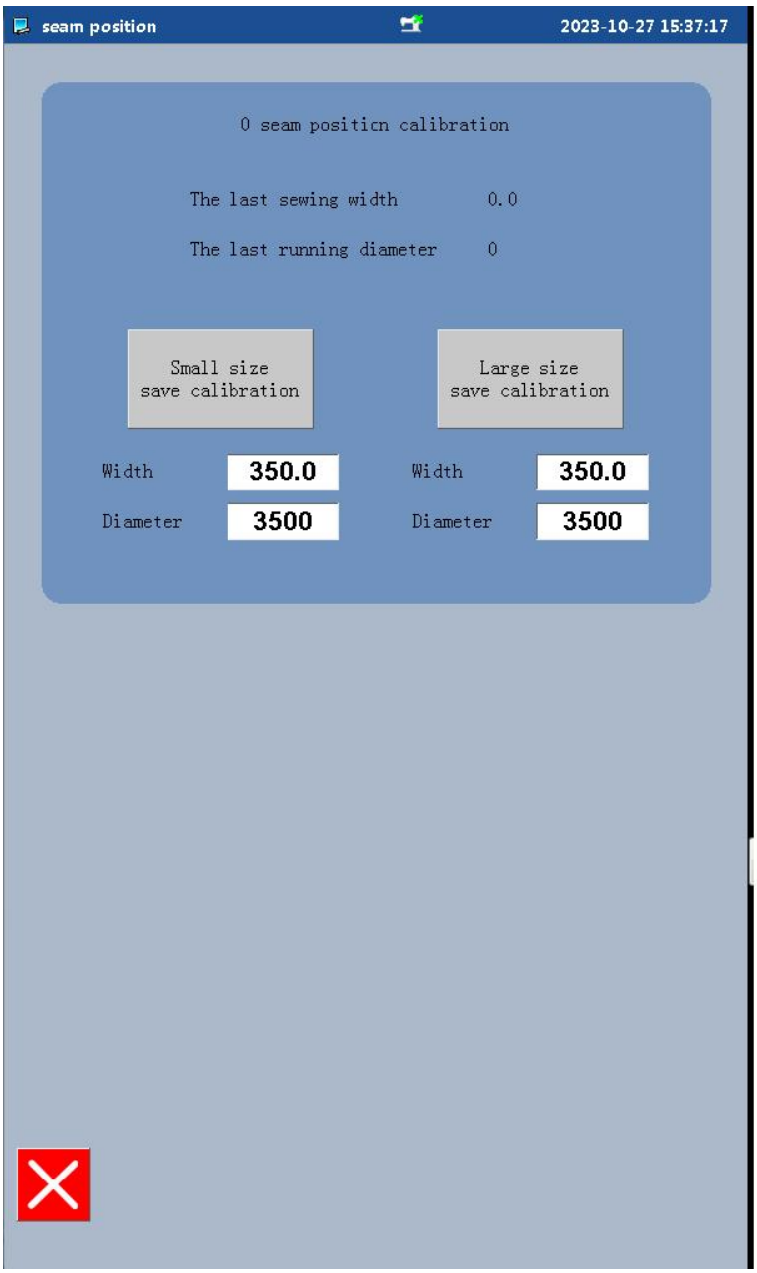
2.8 Seam postions

Click the stock position button on the main interface to enter the stock position interface。As shown in the figure.



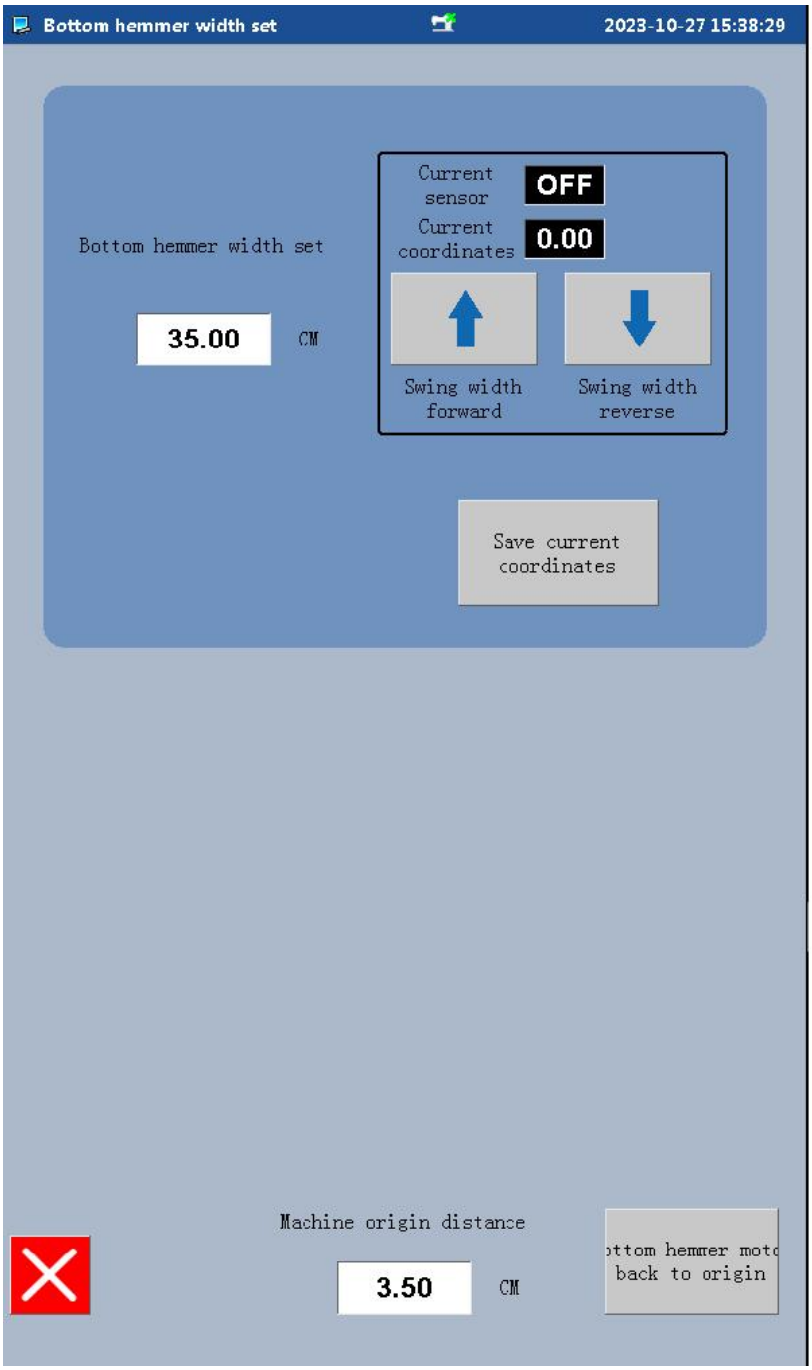
contains：

1.Series parameters of stock positons。
2.Inspace seam test。
3.Dual speed switch。Control the wheel speed display on the main interface。
Do not use dual speed：The main interface displays a wheel speed parameter；Use dual speed：
The main interface displays the speed parameters of the front and rear wheels。
Chilck on the [0 stock postion calibartion]　button to enter the sub interface。This interae allows you to save samll size save calibration and large size save caliation。As shown in the figure.



2.9 Bottom hemmer with sets

Click on the bottom width buttons ， enter the bottom hemmer withs sets.sAs shown in the figure.



contains：

1.Lower pendulum。Bottom swing width motor sensor switch，Bottom swing width motor forward rotation reverse control current coordinates。

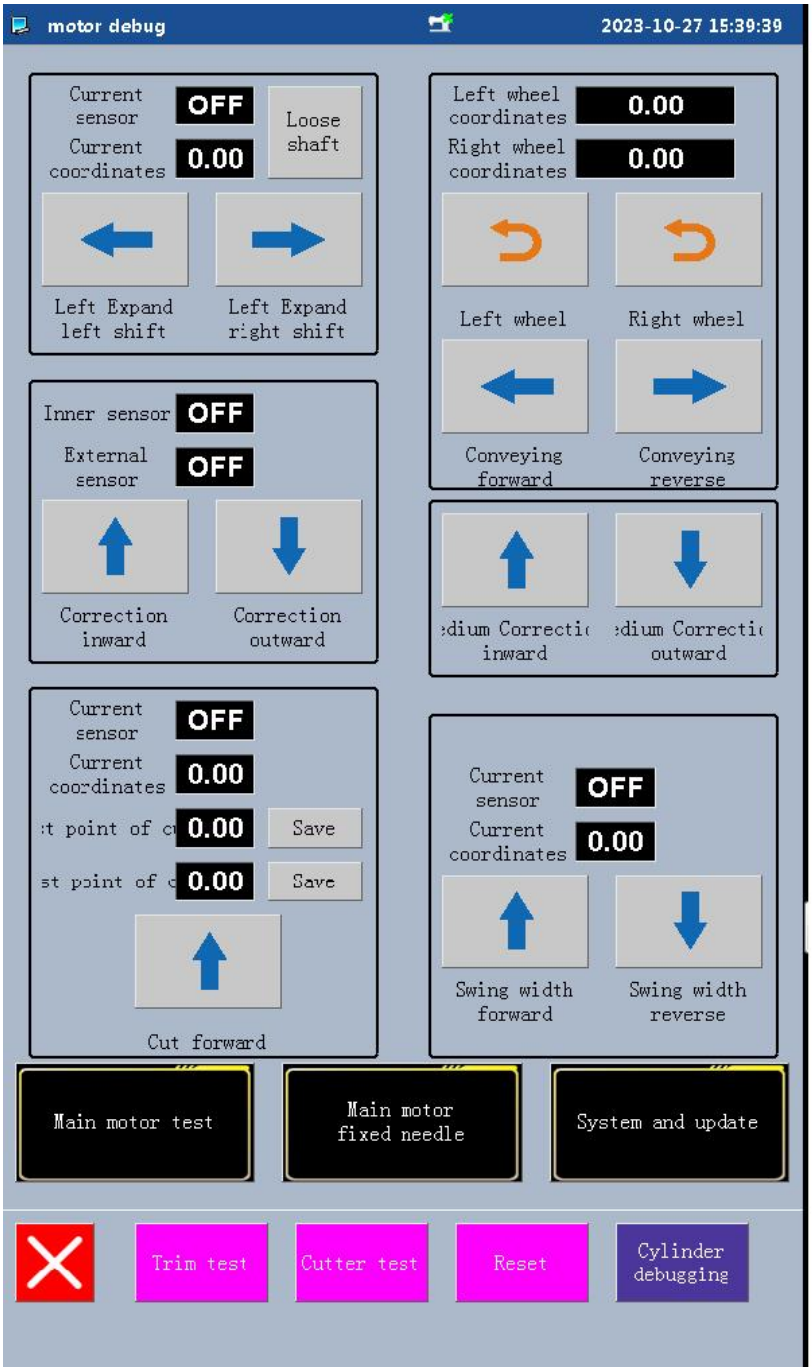
2.Setting parameters for hem width。Click on “Save current coordinates”，Save the current coordinates of the swing width motor to the loswer swing width setting parameter。

3.Machine origin distace。

Chanptr 3:Device detection

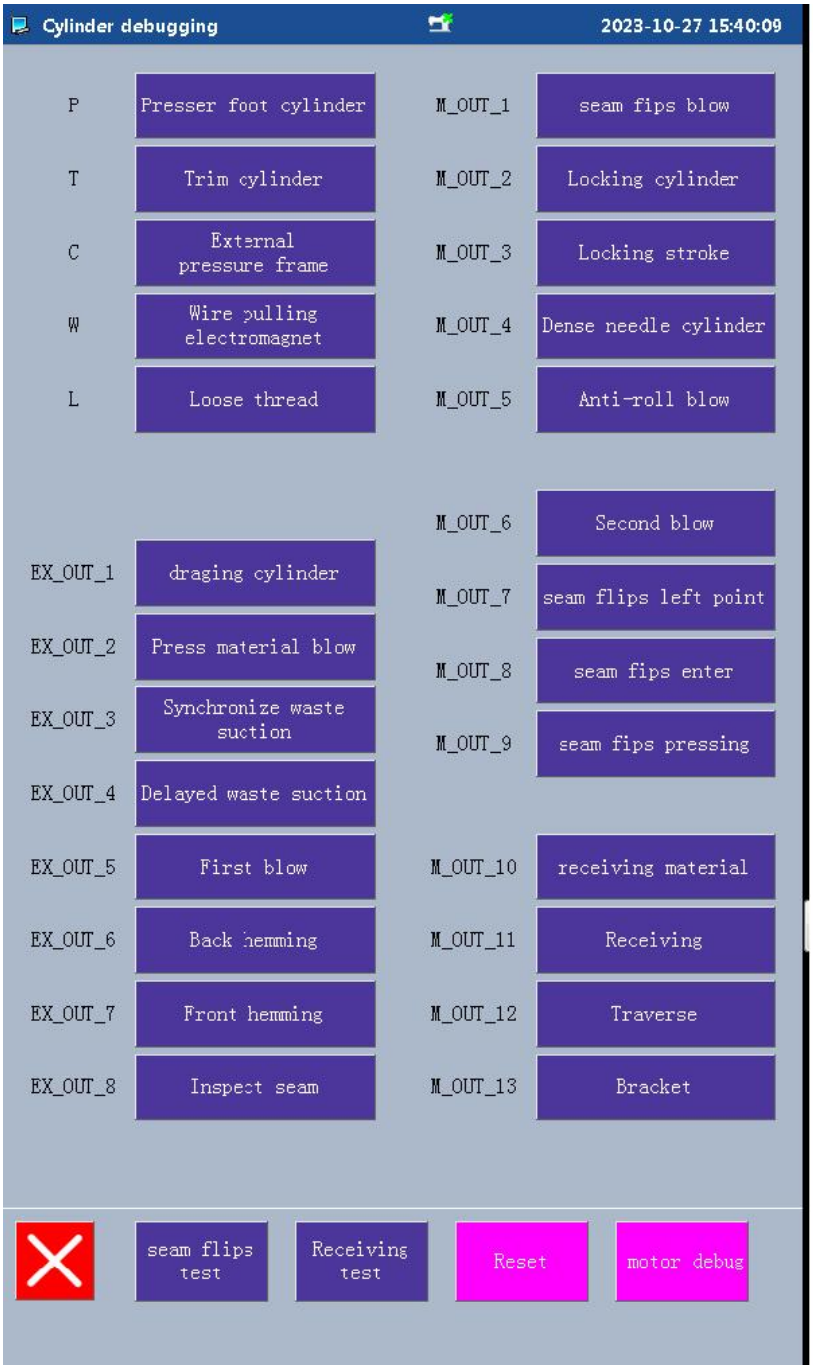
3.1 Motor debug

Click the button named Device Detection on the main intserface to enter motor configuration interface。In this interface ,functions such as motor debuge ,thread cutting cutter testing and reset cna be acheved。 As shon in the figures。



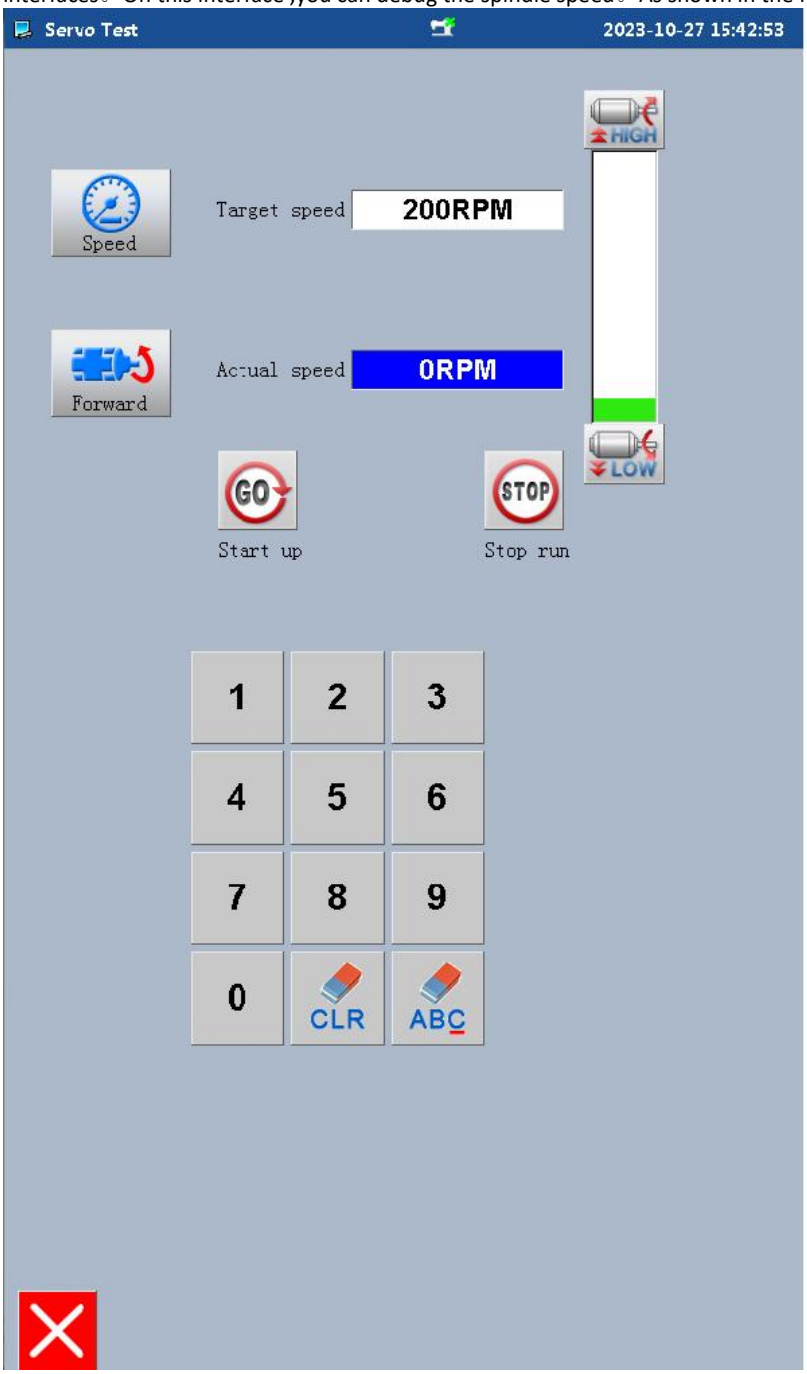
3.2 Cylinder debug

Click the “Cylinder debug”button on the motor debug tface to enter the debug infterface。In this interface ,the cylinder button status ,cylinder debugging ,strand inversion material receiving test,reset,and other functions cna be achieveds。As shown in the figure。



3.3 Servo Speed Detection

Chick the “Servo Speed Detection” button on the motor debugging interface to enter the spindle testingf interfaces。On this interface ,you can debug the spindle speed。As shown in the figure。



3.4 mainaxle motor Angle Correction

Click the button named “ Servo angel Detection ” on the device detection and debug interfacen to eenter

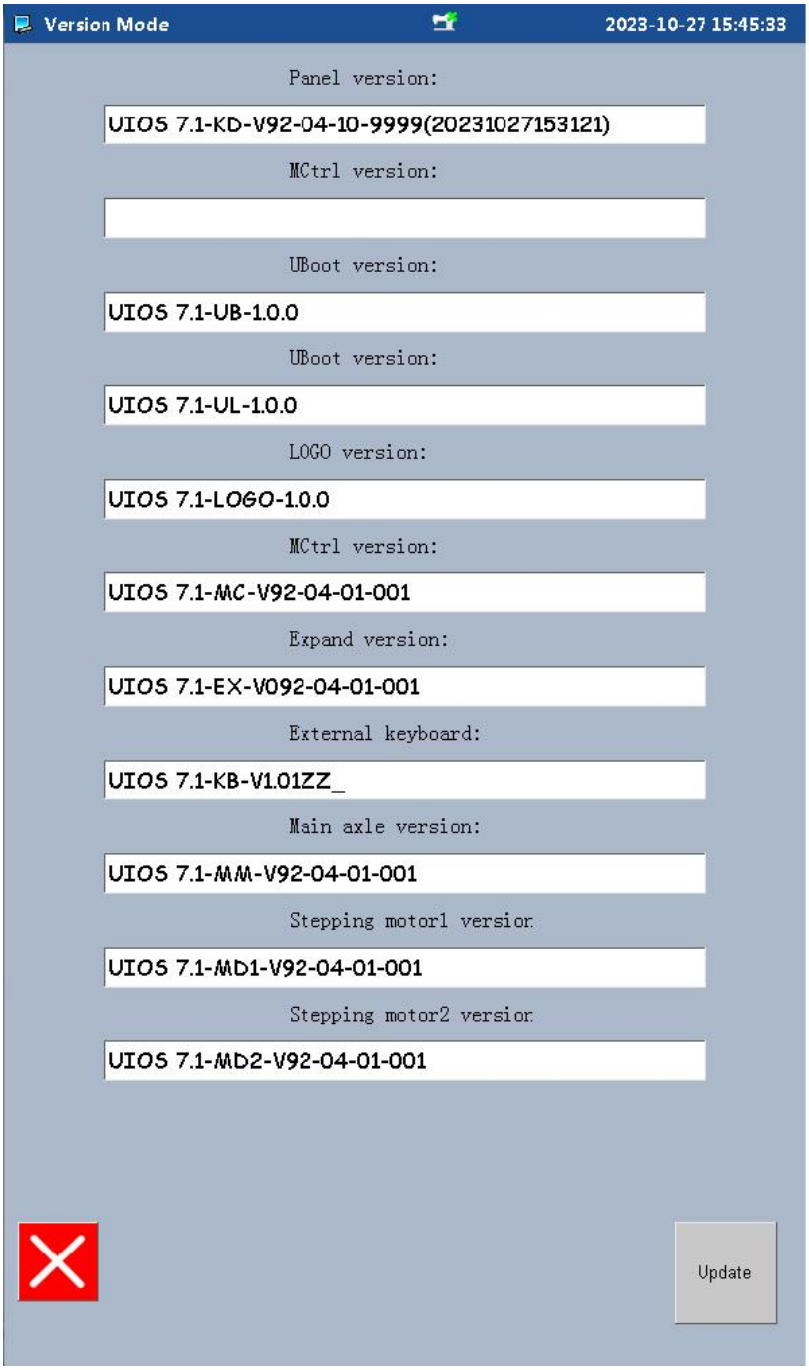
Mianaxle motor angle correction 。This interface allows ffor mainale motor Angle Correxion。As shown in the figure。

Chapter 4:Systerm upgrade and functions

4.1 System upgrade Mode

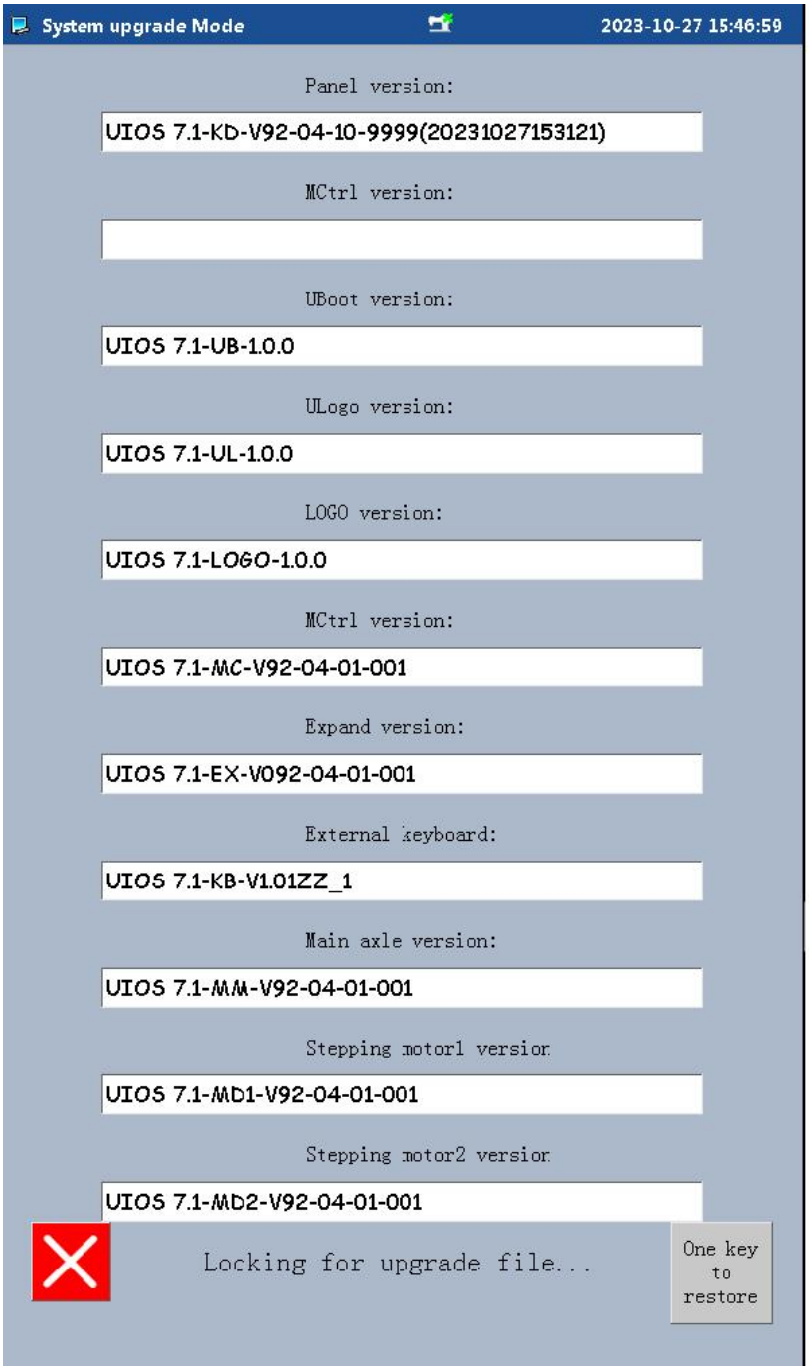
Clink on the tsesting interface【System update】->【Upate】，enter the Version Mode interface。Used to view the version number of the control ststem。For exmple：MCtrl version、Panel information、LOGO version、Stepping motor1 version ,etc information。

Click the upgrade btton to enter the system upgrade interface。This interface allows for version upgrader and system restore funtion。As shown in the figure。



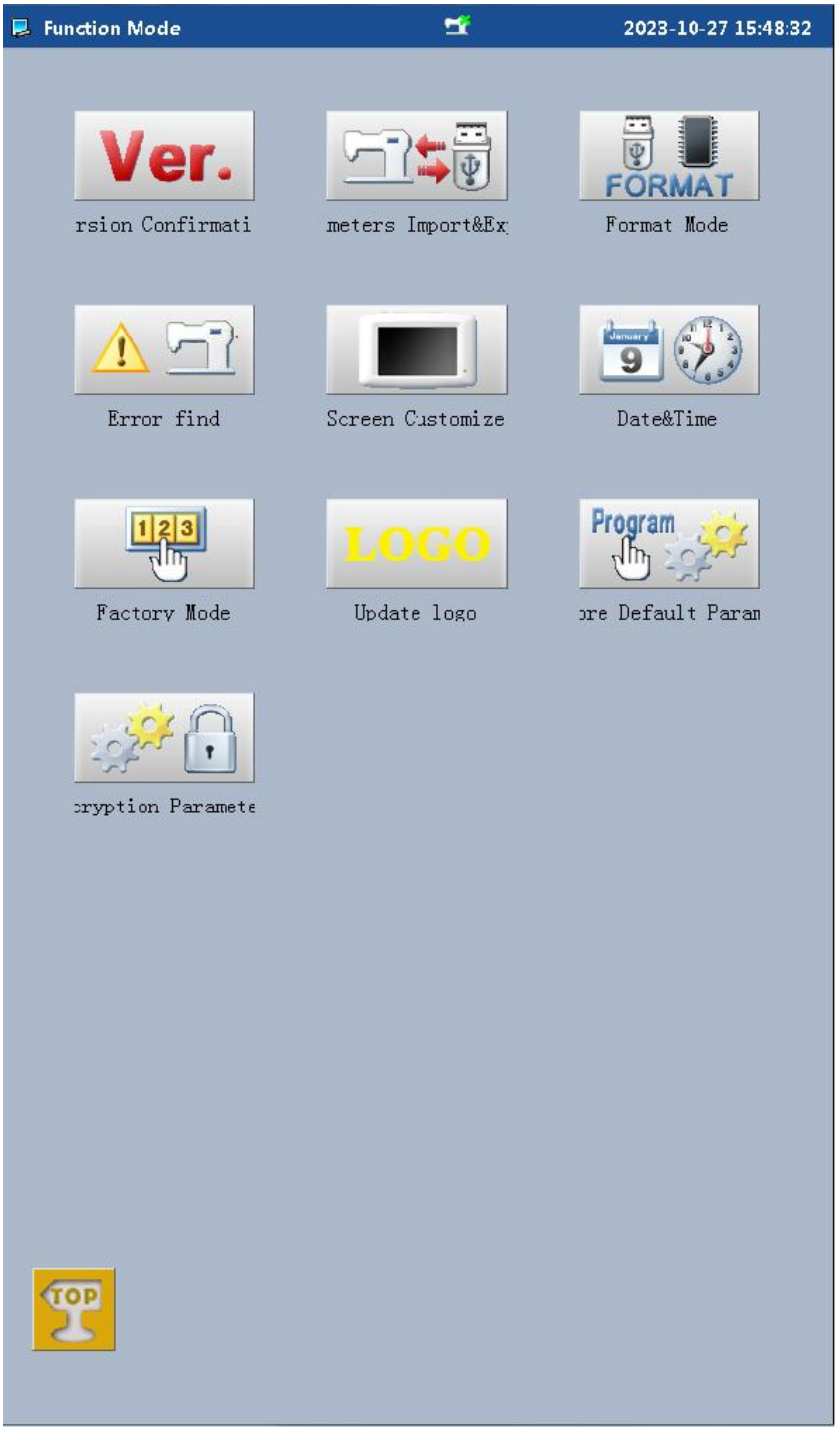
1.Upgrade:Serch for USB drive upgrade files and select the upgraded system，Click on the oneupgrade button to proceed with the updagrde process。Don't turn off the power during the upgrade process。Afer upgrading , a prompt box will pop up ,please restart the power supply。

2.Restore：Click the one click recovery buttonto enter the system restore。As shown in the figure。You can restore all parameters with ine click or sekect the parameter items that need to br restored。Restore the operation to the original defualt values.After the system is restored ,a prompt box will pop up,please restart the power supplys。



4.2 Functionmode

Click on the motor debug【system Maintain】->【Function mode】button，enter the function mode interface。This interface is divided into 10 modules。As shown in the figure 。


Function Mode
2023-10-27 15:48:32
Ver.
rsion Confirmati
meters Import&Ex
FORMAT
Format Mode
Error find
Screen Customize
Date&Time
Factory Mode
LOGO
Update logo
ore Default Param
cryption Paramete
TOP

Chapter 3:Systemparameters

Parameter List:

Parameter Name	Delault	Range
Syncscale (1 Set)		
Whether automatic start avaiable	OFF	OFF、ON
How long does it start	350	1-3000ms
Switch sensor timing	5800	100-15000
Switch children's wear equipment	Adult	Adult、Children's wear
Switch the deviation correction method	Sensor switching	Sensor switching、Formula switching
Cutter (2 Set)		
Whether the cutter is used	Use, Not used	Use, Not used
Cutter origin signal polarity	0	0,1
Advance cutter position	0	0-100%
Number of stitches to stop the cutter in	0	0-50
Port (3 Set)		
Automatic expansion port replacement with IN2	Notenabled	Notenabled, Enabled
Locking cylinder (4 Set)		
Whether ocking cylinder is ok	Invalid	Invalid、Valid
Needle high position angle	10 deg	0-500
Delayed of needle high locking wire	10 ms	0-500
Locking wire mechanical angle	125 deg	0-360
Needle low position delay	0ms	0-500ms
Lock wire travel delay	200ms	0-500ms
Receive material(5 Set)		
Whether material receipt is open	OFF	OFF,Method1,Method 2
Receiving delay	350ms	100-2000ms
Material receiving delay	700ms	100-4000ms
Pallet delay	1500ms	0-5000ms

Rectification motor(6 Set)		
Deviation correction motor default	Forward	Forward,Reverse
End idling distance(7 Set)		
End idling distance	1000	1-30000
Boneless end error compensation	OFF	OFF、ON
Size code error value for boneless endings	200	-500-500
Speed of left and right wheel idling and retraction after bone turnover	50	0-100
Setlanguage (8 Set)		
Language	Chinese	Chinese、English、
Advancedpara (10 Set)		
Servo enable signal delay	100	100-999ms
Time delay after servo ban	100	100-999ms
HALT switch type	ON	OFF、ON
Trim switch type	ON	OFF、ON
Pneumatic check switch type	ON	OFF、ON
Trim (11 Set)		
Whether the thread trimming cylinder is	Valid	Invalid、Valid
Delay from thread trimming opening to	350	10-3000ms
Delay from thread triming closing to hook	50	10-3000ms
Whether the hook line is effective	Invalid	Invalid、Valid
The delay from hooking on to hooking off	120	10-3000
The delay from hooking close to subsequent	120	10-3000
Swing width motor (12 Set)		
Whether the swing width motor is used	0: Use 1:Not used	0
Default direction of swing width motor	Forward	Forward,Reverse
Dense needle (13 Set)		
Dense needle switch	0	OFF,conventice,DAHE
Dense needle stitches	3	1-10
Main interface setting (14 Set)		

Display language of icon on the left of main interface		Chinese、English、Vietnamese、korean、Turkish
Starting to suck waste (15 Set)		
Initial waste suction duration	200	0-1000
Slow start stitch (16 Set)		
Start slow needle	2needle	OFF, 1needle,2needle,3needle.
Slow stitch first stitch speed	200	0-9999
Slow stitch second stitch speed	400	0-9999
Slow stitch third stitch speed	600	0-9999
Slow stitch four stitch speed	800	0-9999
Slow stitch five stitch speed	1000	0-9999
Slow stitch six stitch speed	1200	0-9999
Counter (17 Set)		
Sets function of UP counter	ED	--、ED、CY
Sets function of DOWN counter	ED	--、ED、CY
Method of clearing (UP) counter setting	--	--、IT、CL
Method of clearing (DN) counter setting	--	--、IT、CL
Initialize UP/DN counter or not at power on	HOLD	HOLD、CLEAR
Prohibition of UP counter current value	ALLOW	FORBID、ALLOW
Prohibition of DOWN counter current value	ALLOW	FORBID、ALLOW
ON/OFF of stitch counter function 1	OFF	OFF、ON
Setting for warning stitch number of counter	1000	0-9999 x100000 stitches
ON/OFF of stitch counter function 2	OFF	OFF、ON
Setting for warning stitch number of counter 2	1000	0-9999 x100000 stitches
Reserved Para5 (18 组)		
Reserved Para6 (19 组)		
Reserved Para7 (20 组)		
Reserved Para8 (21 组)		
Reserved Para9 (22 组)		
Reserved Para10 (23 组)		

Reserved Para (24 Set)		