

254裤袢机触摸屏说明书

254 TROUSER LOOP MACHINE TOUCHSCREEN MANUAL
7 Inch high resolution screen



清晰坚固 反应迅速

Crystal clear, Ultra-durable, Lightning-fast response.

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1. Introduction to electronic control system

1.1.1 Introduction to basic operations

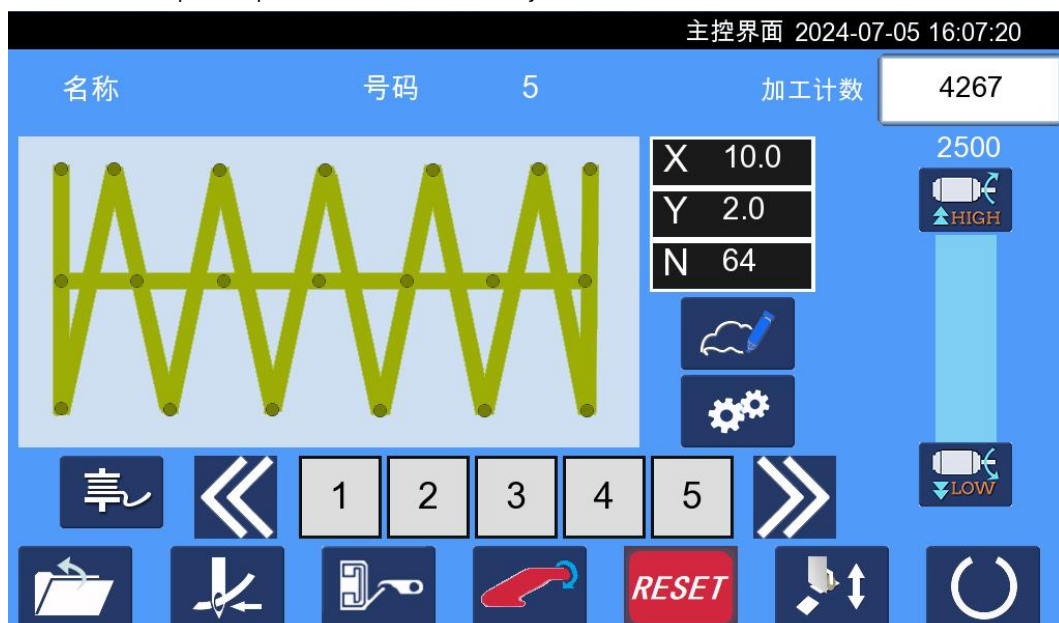
1. After turning on the power switch, the boot interface is displayed. If you need to skipback to zero, you can clickon the red area of the picture below about 5 times to enter the main interface. After entering,

the password input interface will pop  up and you can click directly.



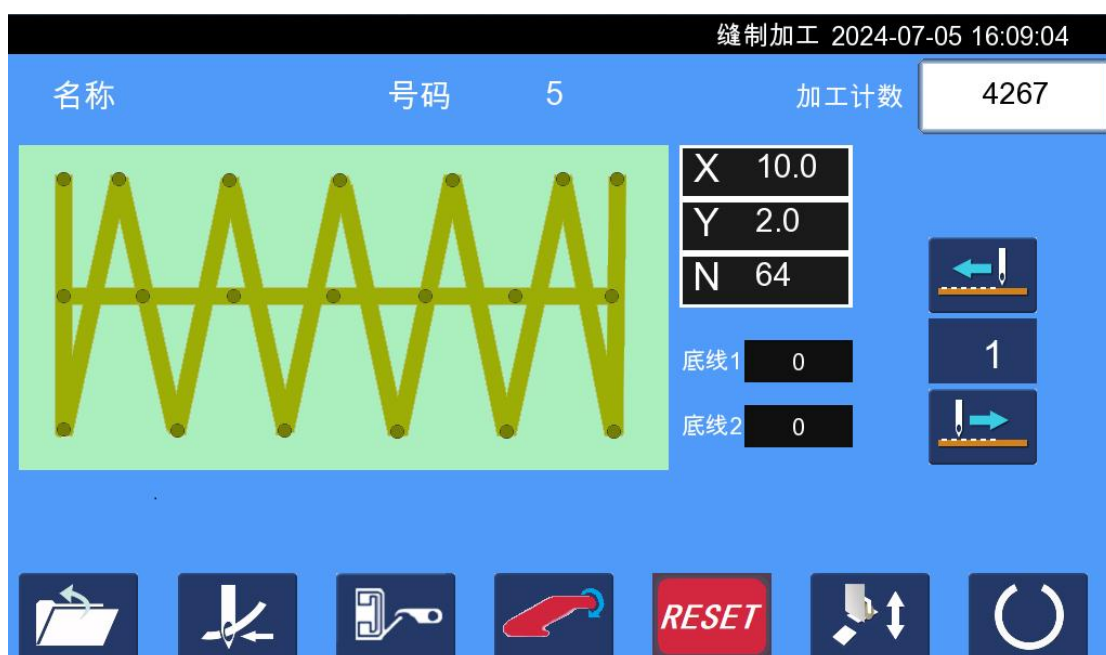
2. Main interface and sewing pattern

Patterns will be displayed in the central area of the current page, and there are multiple locations on the page where the required parameters can be adjusted.



3. Enter sewing

After setting the parameters to be stitched, you can press the sewing button in the lower right corner to enter the sewing processing interface to start sewing.



4. Sewing processing interface

Before actually sewing, please confirm the settings of the sewing conditions again before starting sewing

5. Emergency stop

If you want to stop running during sewing, please press the emergency pause button on the machine. The sewing machine will immediately stop in the upper stop position (factory standard setting) and enter the emergency stop state. If you want to release the emergency stop state, you must press the emergency stop button again before the emergency stop state will 急停 be released.

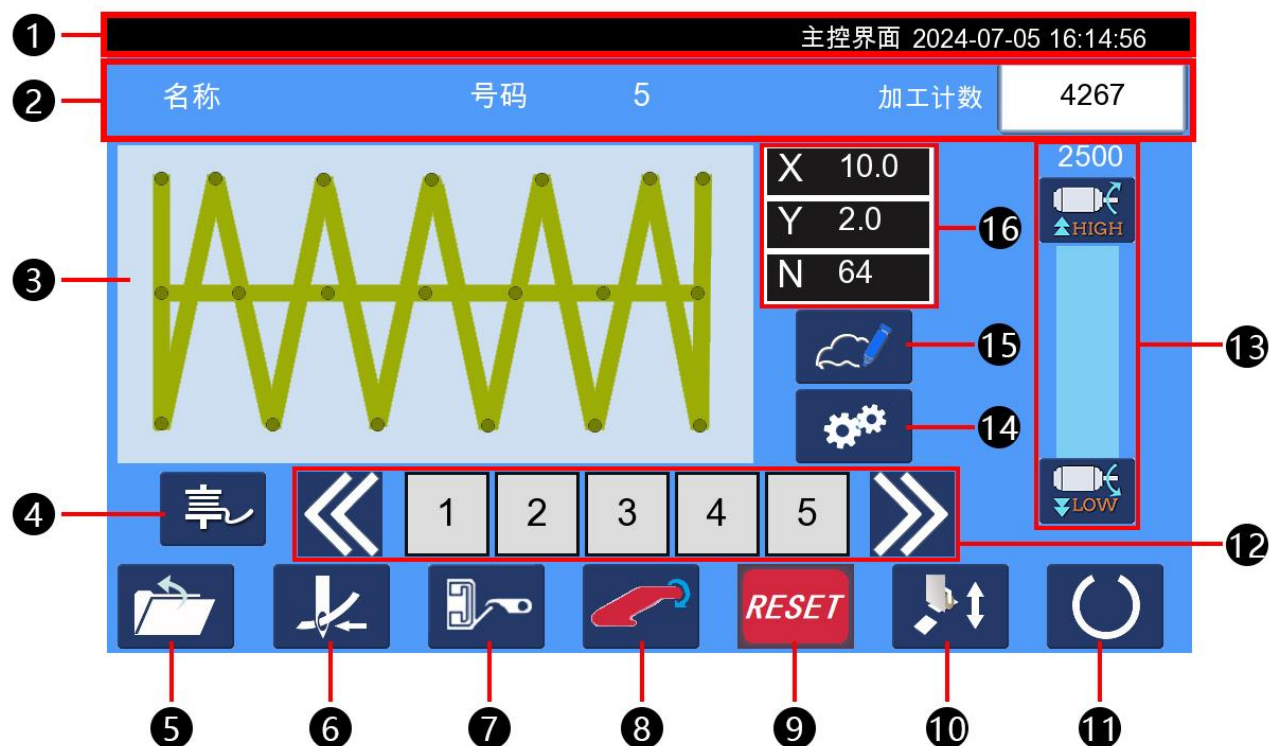
You can continue to do the following actions.





6. Continue sewing









After the emergency stop is lifted, you can press the start button to restart the sewing.

[Note] When threading, it is forbidden to start sewing, which will make the sewing machine run, which is very dangerous.


1.2.2 Introduction to the main interface





Serial	number name	function description
1	The title	bar displays the equipment manufacturer information, time and current interface name
2	The pattern name, number and processing count	Display the pattern name,pattern number and processing count of the current sewing pattern
3	The pattern display area	displays the shape of the pattern and the size of the current pattern
4	Winding <div></div>	click to enter the winding interface, step on You can start winding with a foot switch
. 5	After the main menu <div></div>	is opened, a variety of catalogs will be displayed
. 6	Threading switch <div></div>	, put down the presser foot of the sewing machine for threading operation
. 7	Replace the rotary hook switch <div></div>	. When replacing the bobbin, use



the 8	reclaiming switch 	to re-reclaiming and send it to the waiting position
. 9	Return to the origin 	, mechanical return to zero position
10	cut belt switch 	Belt ring cutter action once
11	Confirm the sewing button 	to enter the sewing processing interface
12	Quick pattern switching area	to quickly switch the sewing pattern
13	Motor governor 	click to perform motor acceleration and deceleration operation
14	Control parameters 	click to modify the control parameters
15	Pattern parameters 	click to modify the control pattern parameters
16	Pattern data 	click to adjust X (pattern length), Y(Pattern width) and N (number of pattern needles) specific data

1.3 Pattern parameter interface

To set the pattern data, press  on the main interface to display the following pattern parameter interface








When the function	setting range
<p>1. Redundant, position value setting</p>  	
<p>2. , feeding X position setting</p> 	<p>is changed to a belt ring with different widths, or to a belt ring with different materials, etc., the sewing position may be skewed, etc. , Please correct it when necessary.</p> <p>When positive, move to the right of the set value. When the value is negative, move to the left.</p>
<p>3. Joint thickness setting</p> 	
<p>4. , strip thickness setting</p> 	
<p>5. , cancel and return</p>	<p>Cancel the changes made on this page and return to the main page</p>



	
6. , save and return 	to save the changes made on this page and return to the main page

1.4 Device parameter interface


To set the pattern data, press [(password 4567) on the main interface to display the following pattern parameter interface







调整参数 2024-07-06 09:56:20



1		梭床与带宽度	57.00
2		预送带头长度	150
3		剪切前长度	0
4		剪切后长度	0
5		勾线持续时间	15
6		送料压脚下位置	1950
7		送带补偿	0




89

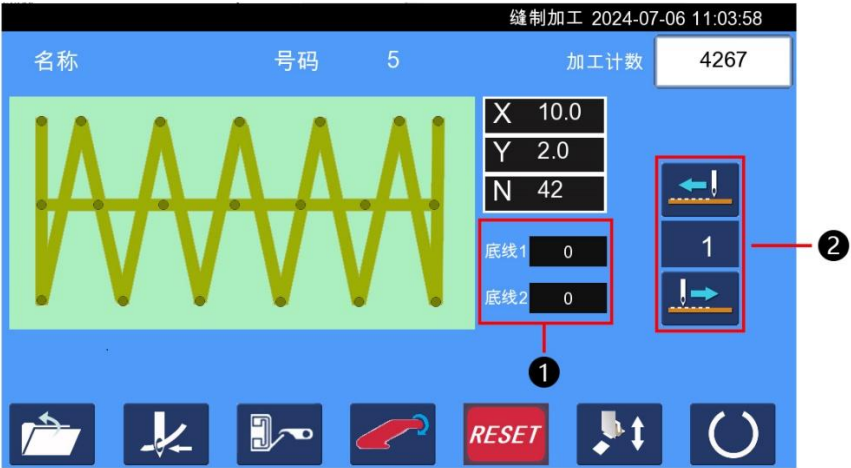
Function	setting range
<div>1. shuttle bed and bandwidth width,</div> <div></div>	<div>第一旋梭调整 2024-07-22 17:15:12</div> <div><div>旋梭及叉调整</div><div>57.00</div><div>(0.0-70.00)</div></div> <div><div>送料叉补偿</div><div>0</div><div>(-10.0 - 10.00)</div></div> <div><div>1</div><div>2</div><div>3</div><div>4</div><div>5</div><div>6</div><div>7</div><div>8</div><div>9</div><div>0</div><div>+/-</div><div>⊗</div><div>✕</div><div>↵</div></div>

<p>4. length after cutting,</p> 	
<p>5. hook line duration,</p> 	
<p>6. feeding pressure foot position,</p> 	
<p>7. belt feeding compensation</p> 	<p>adjustment, belt feeding compensation value (range- 200-200)</p>
<p>7. Cancel and return</p>	<p>Cancel the changes made on this page and return to the main page</p>

	
8. to save and return 	to save this page Make changes and return to the main page

1.5.5 Introduction to sewing interface

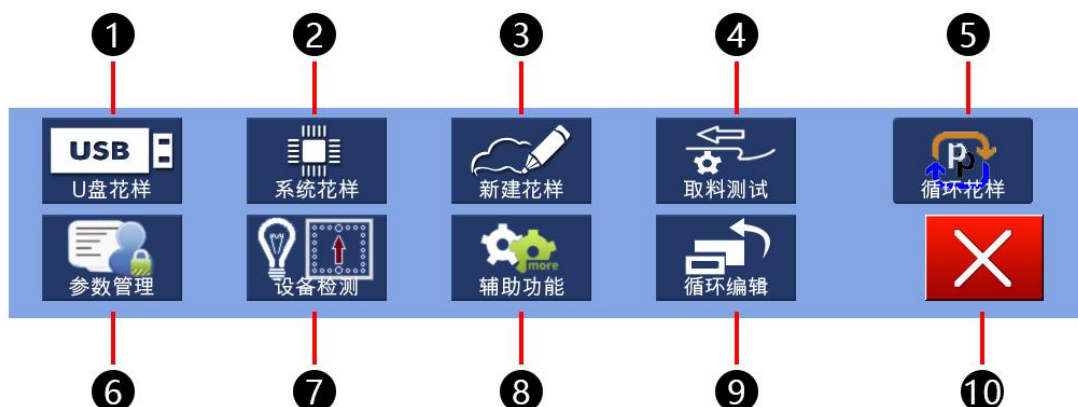
After setting the pattern data 后, press  on the main interface to enter the pattern sewing interface (only the parts that are different from the main page are described here).














Function	setting range
1. , bottom line, counter	<div data-bbox="427 338 1410 667"> </div> <p>○ The bottom line count can be set separately according to the first rotary hook and the second rotary hook.</p> <p>● It is very convenient to check that the usage is different at the same time.</p> <p>·The bottom line calculation is a subtraction calculation, and the remaining bottom line number needs to be modified after the rotary hook is replaced in the middle.</p> <p>Select set the remaining amount of the bottom line of the first rotary hook</p> <p>Select Set the total amount of the bottom line of the first rotary hook</p> <p>Select Set the remaining amount of the bottom line of the second rotary hook</p> <p>Select Set the total amount of the bottom line of the second rotary hook</p> <p>6 number keys, enter numbers</p> <p>Clear key</p> <p>Confirm save and exit</p> <p>Positive and negative sign modification</p> <p>Do not save and exit</p> <p>○ First select the setting item, and then enter the appropriate value.The remaining bottom line value cannot be greater than the total bottom line value.When all are set to 0, the bottom line count is turned off.</p>
2. , inch movement button	, presser foot, air delivery action, including forward and backward

1.6.6 Introduction to the main menu

Press  on the main interface to enter the main menu interface

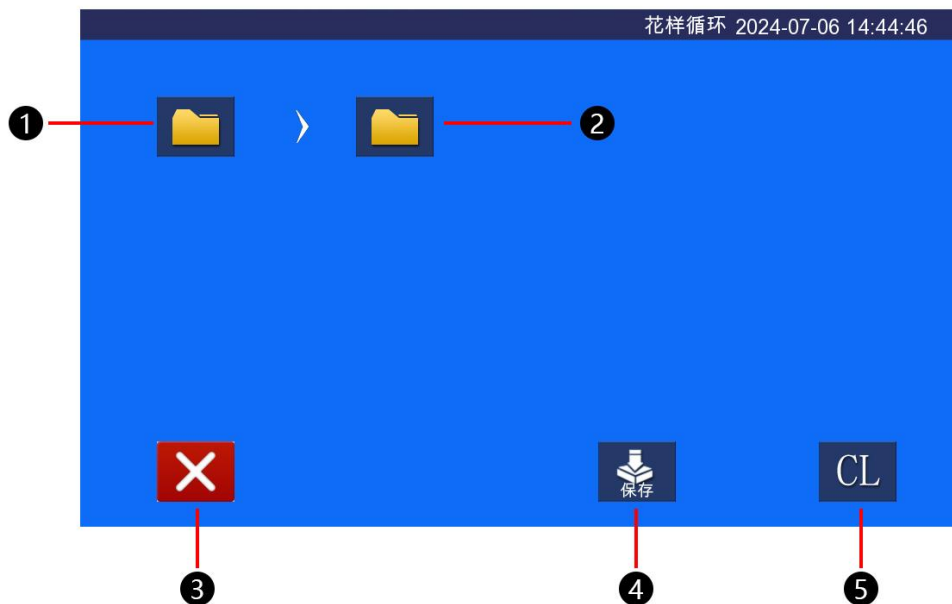




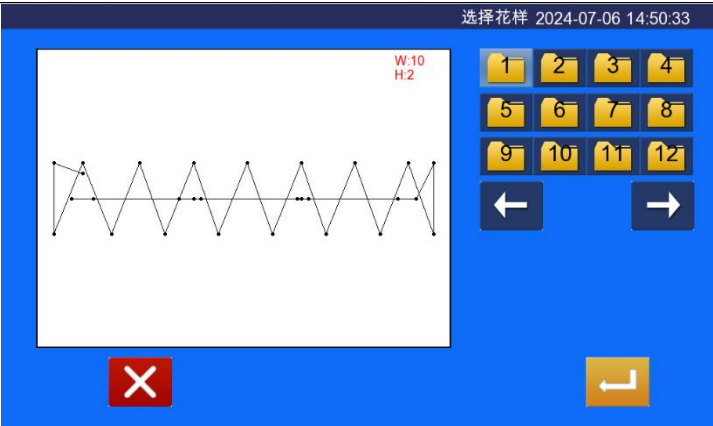



Number	name	function
1	U disk pattern 	<p>Click the button "USB" to enter the USB pattern management screen. Insert the U disk, when there is a PARAM file (.param) and SPF files (.When spf, the existing pattern number is displayed at @, and the white area on the left shows the pattern and some of its information. If the pattern display is incomplete, press the reverse key at ⑧ to turn the page for quick selection. You can select all or none with one key. D is whether to overwrite the original pattern when the name already exists. Delete the selected pattern, @Import the pattern in def format (the previous flower format). @Save the selected pattern to the touch screen and return without</p> <div data-bbox="845 1169 1294 1424"> </div> <p>operation</p>
2	System pattern 	<p>Click the button to enter the system pattern management interface, the operation method is the same as above, the touch screen patterns are saved here, there are 9 patterns stored by default, you can modify the data of each pattern, no new patterns will be added.</p>
3	The new pattern 	function is turned off
4	reclaiming test	<p>Click the button to enter the single-step test screen. Press the forward button ""The folding part will complete the first folding and reclaiming process step</p>









		by step for assembly testing and maintenance.
5	Cycle patterns 	Click the button to view the sorted cycle pattern groups (see 1.6 for details).
6	Parameter management 	<p>Click the button to enter the parameter management interface, there are a total of three levels of parameters. The first level is the commonly used parameters of customers (no password required), the second level is the commonly used parameters during maintenance (password 1234), and the third level is the manufacturer's customized parameters (password 123456).</p> 
7	Equipment inspection 	Click the button to enter the equipment inspection interface, which can perform targeted inspections of different parts of the machine for equipment assembly and maintenance
8	Auxiliary functions 	Click the button to enter the auxiliary function interface to set up and manage more small functions of the machine.
9	Cycle editing 	Click the button to enter the cycle editing interface and set the patterns that need to be stitched in a cycle (see 1.6 for details).
10	Close the main menu 	Click the button to exit the main menu


1.7.7 Loop editing, loop pattern selection, and pattern loop processing interface

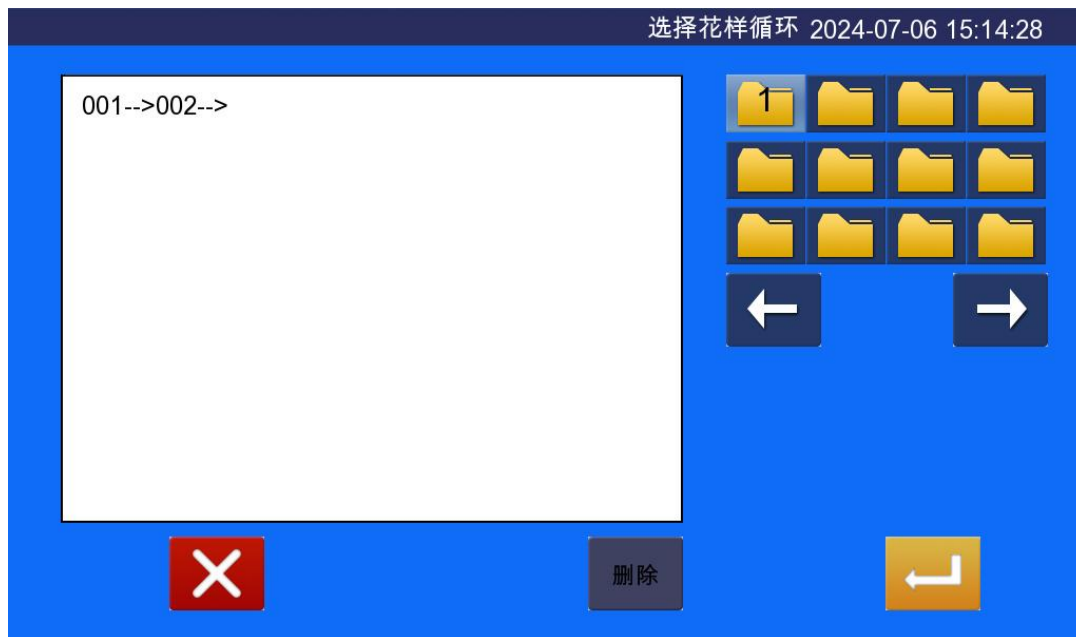
Press  on the main interface to enter the loop editing interface



Name	function
<p>1. pattern 1</p> 	<p>After clicking  the button, enter the pattern selection interface (consistent with the system pattern operation), select the first pattern</p>  <p>that needs to be cycled, after selecting, press  save to modify and return to the previous interface. After the pattern 1 will display the pattern number just selected (For example, the user selected the No. 6 pattern, 1 the corresponding The location will be displayed , if you don't want to save it, please click </p>

<p>2. on the pattern 2</p> 	<p>and click  the button to enter the pattern selection interface (consistent with the system pattern operation), select the first pattern that needs to be cycled, and then press  Save to modify. After returning to the previous interface, the pattern ① will display the pattern number you just selected (for example, the user selected the number 6).Pattern, the corresponding ① location will be displayed , if you don't want to save it, please click </p>
<p>3. Cancel and exit</p> 	<p>to cancel the creation of the loop pattern sequence</p>
<p>4. , save</p> 	<p>the save loop pattern sequence</p>
<p>5. clear</p> 	<p>, and clear the selected loop pattern sequence.</p>

Press  on the main interface to enter the loop pattern selection interface. The loop pattern sequence created above can be displayed and viewed in this interface(the operation method is the same as the system pattern).



After confirming the sequence, click  to enter the pattern cycle processing interface



The above function buttons are described earlier, and will not be repeated here.

1.8.8 Parameter management interface

Enter the electromagnet detection screen.

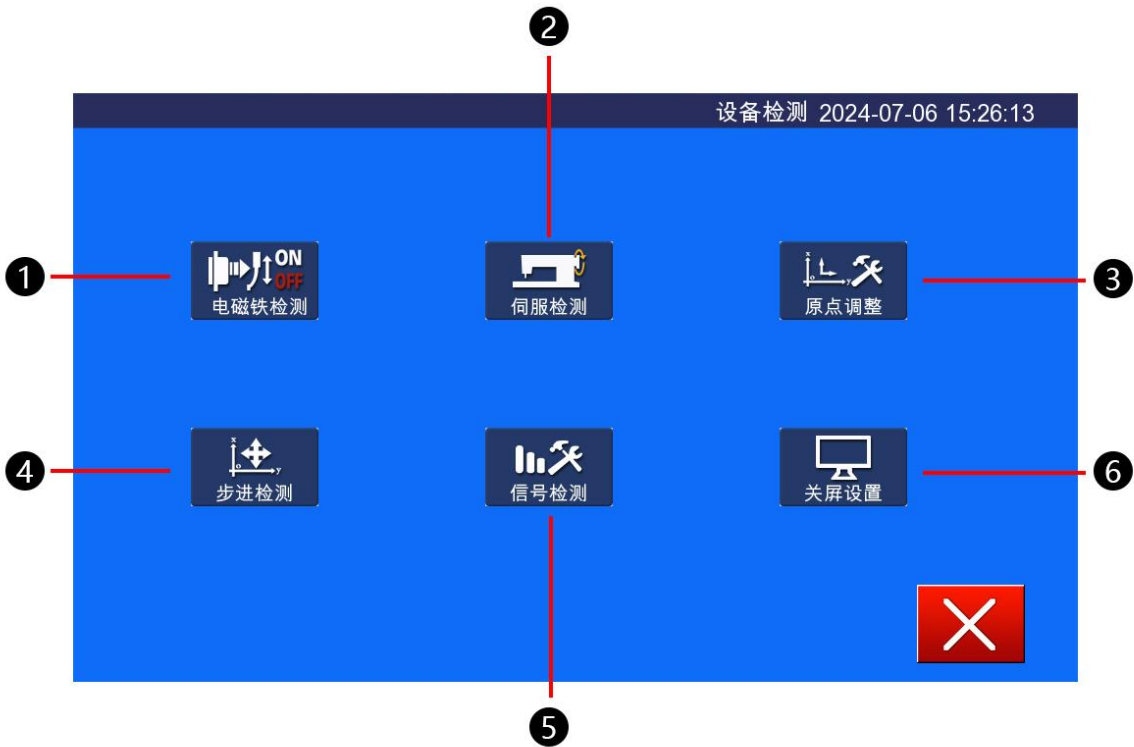
Press the key on the interface, the electromagnetic field corresponding to the name changes, and the cylinder will take corresponding actions at the same time.

Note: This function is used for maintenance and assembly. Some actions will be restricted to each other during operation. Please do not operate at will if you are not familiar with

参数 - (1级) 2024-07-06 15:22:32			
项目	值	项目	值
1.01 最高速度	2500	1.02 第1针速度	100
1.03 第2针速度	200	1.04 第3针速度	300
1.05 急停后剪线功能	关	1.06 主轴上停针位	3700
1.07 单步测试是否移到压脚	关	1.08 切带斜切功能	关
1.09 剪线开关	关	1.10 针杆回升角度	-120
1.11 勾线持续时间	100	1.12 回零速度	1
1.13 空送速度	1	1.14 启动开关次数	一次

it.

1.9.9 Device detection interface



Name	function
1. electromagnet detection	Enter the electromagnet detection screen. Press the key on the interface, the electromagnetic field corresponding to the name changes, and the cylinder will take corresponding actions at the same time.



Note: This function is used for maintenance and assembly. Some actions will be restricted to each other during operation. Please do not operate at will if



you are not familiar with it.

2. servo detection



Enter the servo detection screen.

Use the numeric keypad to enter the circle of the test. The speed bar enters the maximum speed of the test. Forward and reverse setting Whether the servo motor rotates forward or reverse during the test (when the motor can only rotate in one direction, the setting setting is invalid) U Press the start button to automatically stop after running the set number of laps and then



press "OK to exit."

3. origin adjustment



adjustment X, Y and Z axis electronic origin








4. step detection



Enter the step detection screen.




Test the motor part, click the button, and the motor should turn forward or reverse.








If the motor is not turned or the motor is turned wrong, please check whether the motor line is wrong, and whether the motor or the steering


	<div></div> <div>board is damaged.</div>
<div>5. signal detection</div> <div></div>	<div>Enter the signal detection screen.</div> <div>There is a signal description and a corresponding signal-like bear display box on the interface.The framed bear will be displayed in real time.</div> <div>Artificially change the sensor or switch shape of the bear, and the shape of the bear display frame will also change.</div> <div>Note: If the signal is not reflected on this page no matter how it is</div> <div></div> <div>numbered, the sensor must be checked.</div>
<div>6. off screen setting</div> <div></div>	<div>Automatically turn off the screen setting screen.</div> <div>Select whether to automatically turn off the screen when the screen operation is idle and there is no operation.</div> <div>If the screen is turned off, after setting the free time (s), the screen will be automatically turned off, and the time will be entered by</div> <div></div> <div>the numeric keypad.</div>

1.10.10 Auxiliary function interface



name	function
1. The name function modifies the second-level password to 	enter the password input interface, enter the correct original password for the second-level parameter (initial password 1234), and then enter the changed password twice. If the two times are the same, the modification is successful.
2. Modify the third-level password to 	enter the password input interface, enter the correct original password for the third-level parameter (initial password 123456), and thenEnter the changed password twice, and if the two times are the same, the
3. system password is successfully modified. 	Enter the password input interface, enter the correct original system password (initial password 888888), and then enter the changed password twice. If
4. the two times are the same, the touch screen	. The capacitive screen

<p>correction is successful</p>  <p>触屏校正</p>	
<p>5. does not need to be corrected. Modify other passwords</p>  <p>修改其他密码</p>	<p>for the time being. Open</p>
<p>6. recovery settings</p>  <p>恢复设置</p>	<p>Restore the factory settings to restore the first-level, second-level, and third-level parameters of the system and the controller to the factory default state</p> <p>. Note: The first-level parameters do not need to enter a password, the second-level parameters need to enter a password (initial password 1234) and the third-level parameter password (initial password 123456), the controller password (initial password 888888)</p>
<p>7. TimeCorrect</p>  <p>时间校正</p>	<p>Time correction screen.</p> <p>You can modify the year, month, day, hour, minute, and second of the touch screen.</p> <p>Note: After the staging setting is set, the time cannot be modified.</p>
<p>8. the boot LOGO</p>  <p>LOGO</p>	<p>settings and insert the boot screen into the U disk (a 1024x600 bmp format picture must be placed in the root directory of the U disk)</p> <p>. After entering the LOGO setting screen, the picture will be displayed. Press the cursor page to turn the page. After selecting the picture, press the save button to complete</p>
<p>9. the staging settings</p>  <p>分期设置</p>	<p>Enter the manufacturer number input screen.</p> <p>Enter the assigned manufacturer number to enter the staging setting screen. According to the given key sequence, click to set each option in turn. After the setting is complete, you can save and exit. Note: The machine number is used to facilitate the recording of the machine and the corresponding password. It is recommended to use the machine's own number when setting up. Once the super password is used, no matter how many installments are left before it arrives, the installment setting will be cancelled uniformly.</p>
<p>10. . The version information</p>  <p>ver. 版本信息</p>	<p>Enter the version information screen.</p> <p>The version and date of the touch-screen program (APP) are displayed. The motherboard program (MCU) version and date are displayed.</p>
<p>11. is upgraded and</p>	<p>up. Enter the touch screen upgrade page</p>

backed <div data-bbox="189 241 394 349">  升级备份 </div>	to insert U disk (Update App needs to be placed in the root directory of the U disk. exe and UPAPP. SRC file) Click the upgrade button to upgrade the touch-screen program. There can be no power failure during the upgrade process until the progress bar is full and the words Upgrade complete appear
12. . Language selection <div data-bbox="189 492 394 600"> 语言选择 Language </div>	The language selection interface can select Chinese, English, Portuguese, Turkish, and Vietnamese to display . Click on the displayed language to modify it.