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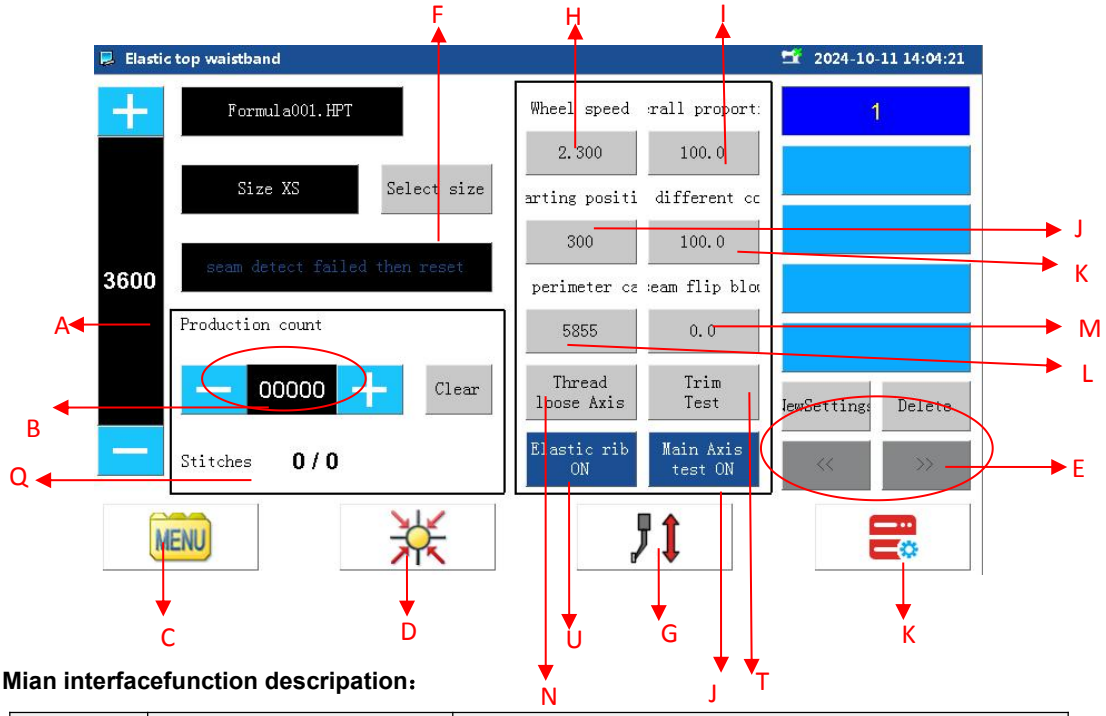
Chapter 1: Setings and functions related to large version style



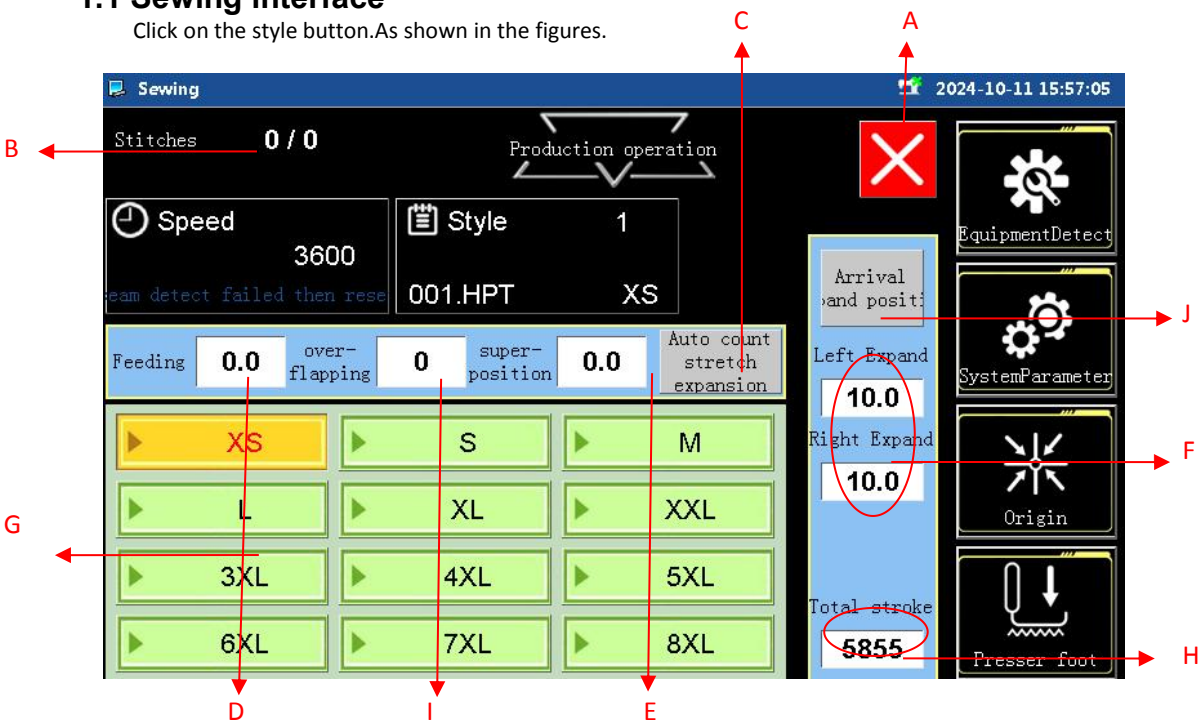
Mian interfacefunction description:

order	function	content
A	Speed	Set running speed prompt text displays
B	Production count	Count addition/subtraction, clear to zero, click to enter the count seting interface
C	System para	Click to enter the system para
D	Origin	Click o button back to origin
E	New and Delete	Create and delete style
F	Style information and sewing iterfacee	Click on the style number and size to enter the sewing interface
G	Presser foot	Lift /Raise Presser Foot
H	Wheel speed	Set wheel speed value
I	Automatic perimeter calculation	Set to obtain automatically calculated perimeter values
J	Overall proportion	E overall scale value
K	Segmented different coefficient	Different proportions of diplay breaak

order	function	content
L	Automatic perimeter calculation	In the Expand value inftere
M	Seam filp blow	Set Reverse Sitich Blowing Function
N	Thread loose Axis	Click on the threading and axi loosenging function
P	Main Axis test OFF\ON	Main Axis test OFF\ON
Q	Sititch	Click to enter the device detection
R	Style List	Style List, choose a larger style
T	Trim test	Click on the thread cutting test function
U	Elastic rib OFF\ON	Elastic rib OFF\ON

1.1 Sewing interface

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



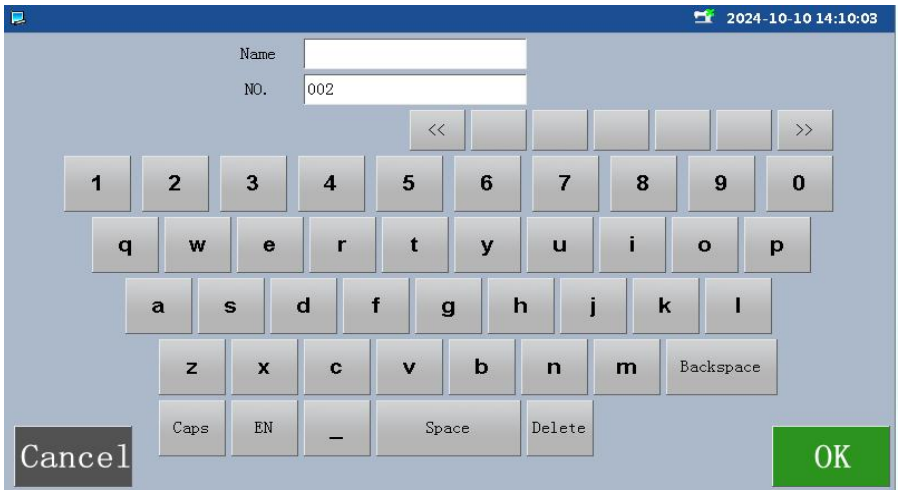
Function descripation:

order	function	content
A	Exit	Click to eixt and enter the main interface
B	Stitches	Display stitch count
C	Auto count strectch expansion	Click to automatically count and expand the self setting value
D	Feeding	The feed function controls the movement of materials within a system key feature include.

order	function	content
E	Super-position	Setting Super-position value
F	Left extension, righe extension, down extension	Ser left, right, and down values
G	Size Selection	Thare are twelve diffnet sizes avilable
H	Tatal journey	Set the total stroke, enter the expansion corresponding value.
I	Over-falapping	Set the number of sitches
J	Arrival expand position	Will set the expansion value calculation to reach the expansion.

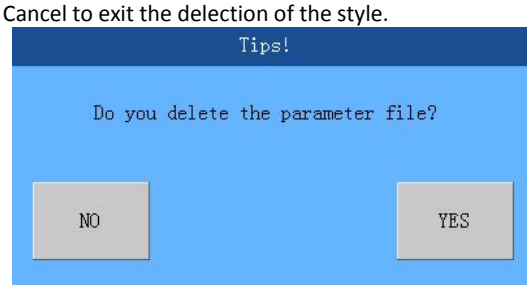
1.2 New style

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



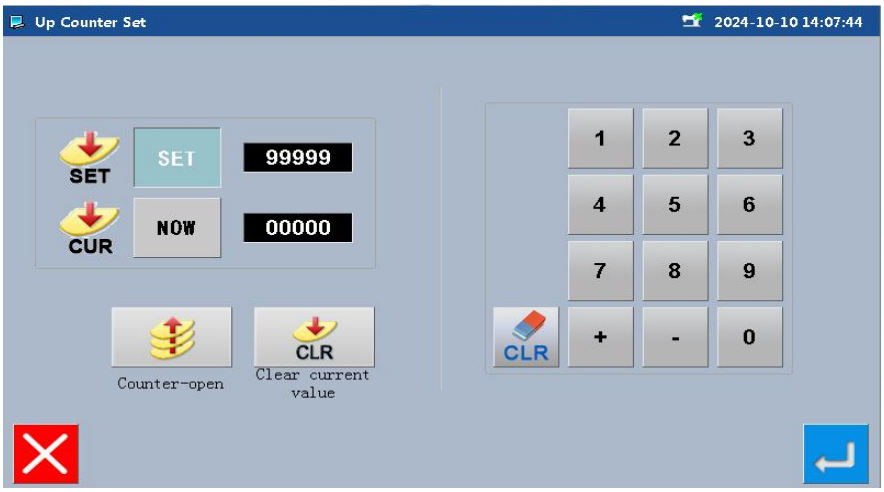
1.3 Delecte Style

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.



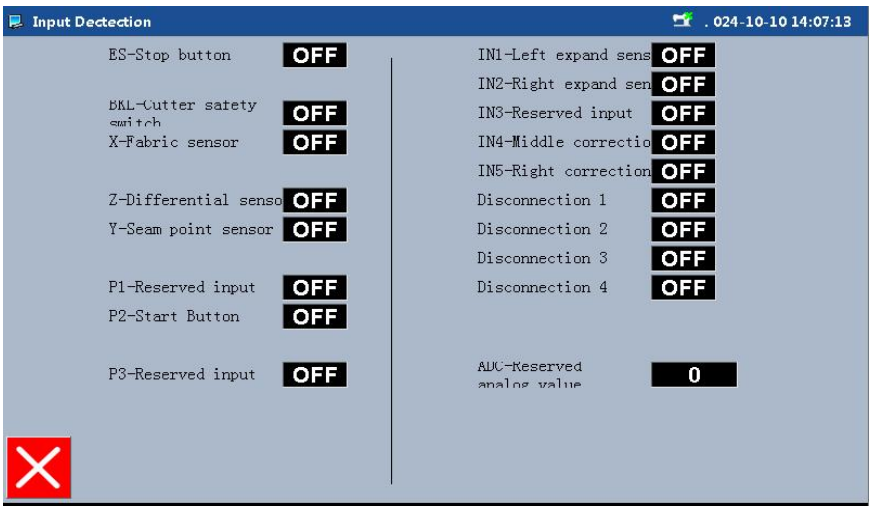
1.4 Productioncount

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



1.Production count setting value (total count seting).
2.Production Count Current Value Seting.
3.Counter function switch button.
4.Clear current value button.
Set target count:In the setting area,enter the desired production traget count ,After inpuuting the number target count.After inputting the number,click the confiremation button to initaiate the counting producess during production.It is essential to ensure that the target number you enter aligns accuately with the required prouction volume,thus maintaing the efficiency and accuracy of the manufacturing process.

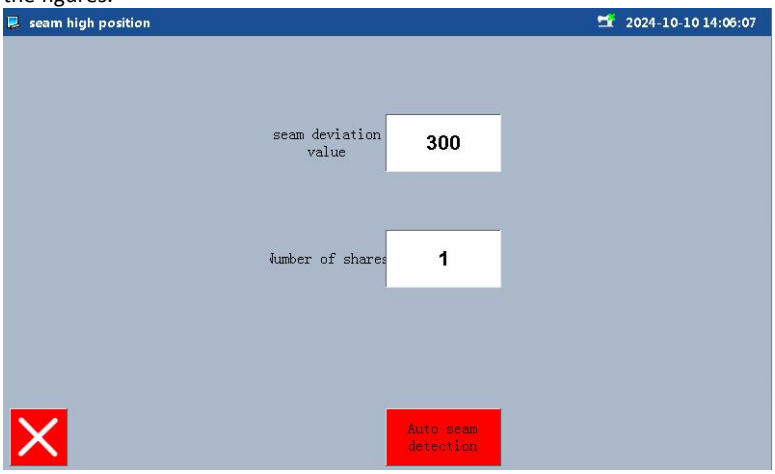
1.5 Input Deaction



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.

1.6 Seam high position

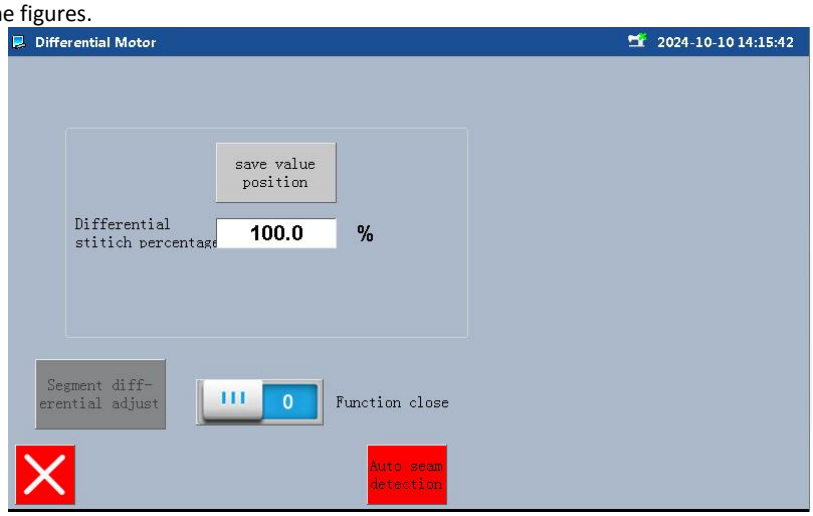
Click on the text box name start point on the main interface to enter the automatic expansion.As shown in the figures.



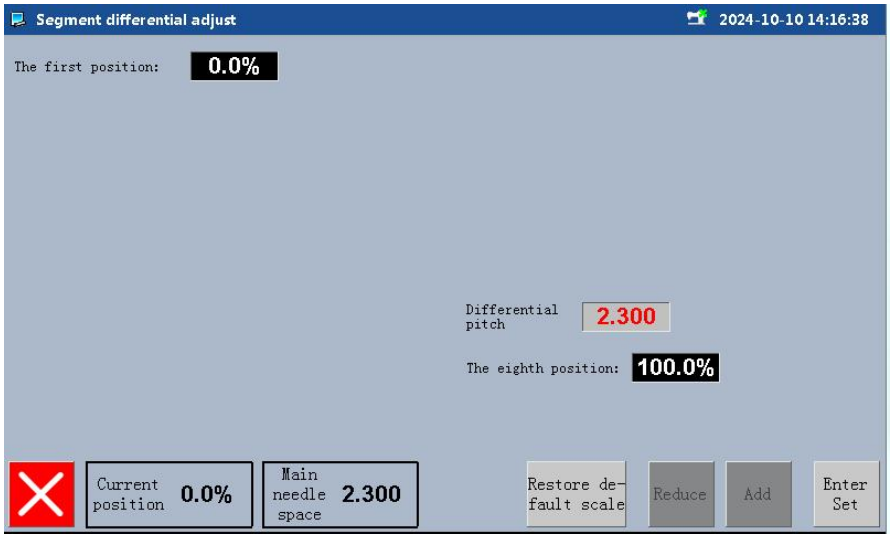
Contain：
1.seamdeviation value.Set seamdeviation value.
2.Number of shares,Seting Number of shares.
3.Auto seam detection,Click to automatically cjeck the stock function.

1.7 Differential motor

Click on the EditText box “Differnt Moto Prortions ” o themain interfaceet ent the sttock conversion.As shown in the figures.



1.Set target position:
2.unction:input the sepecific percentage value of the psotion you want to set.Descrription:For example.if you want the motor to operate at 50% differentail needle distance you need to input 50.This will adjust the motor to the specifed target postion to achieve the desired operational eeffect.
2.Automatic stock Detection:
3.Function:Click the “Automatic stock detection” button to active the automatic stock detectetion feature.
4.Description:This function allows the system automatically detct the currnet stock position ,ensuring that the device is in the correct location.Once activiated,the system will perform necessary measurements and adjustments.
5.Toggle switch button:1
6. Function:Clicking this button will display “1”,enabling the button segment differenial adjustment feature.
Description:After pressing this button,the system will show “1”,indic



Interface features:

1.Click to enter settings.A prompt will appear asking if you want to proceed to settings where you can configure vaious options.

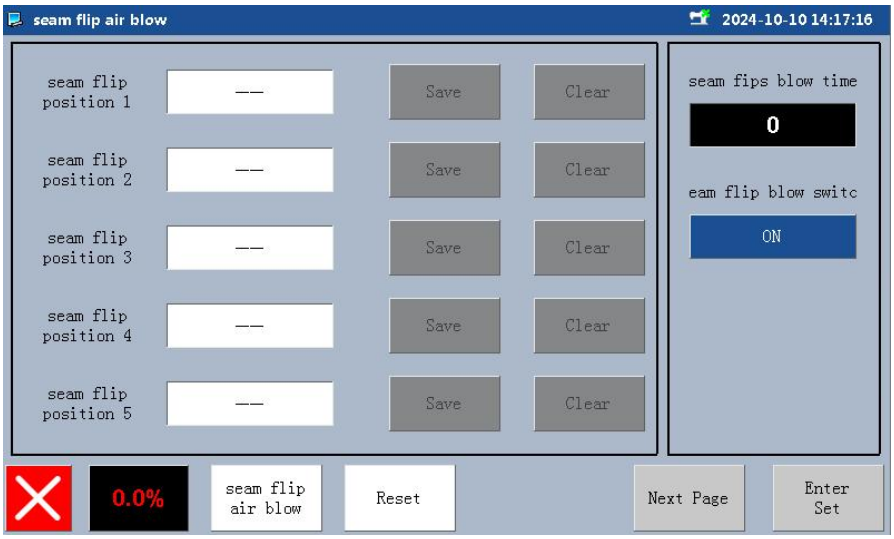
2.Differential spacing setting:Set the differential spacing to a specific size.Click on the differential spacing input field to enter the appropriate numerical value.

3.Position ratio setting:Based on the current position displayed by the main controller,set the position ratio for each point.

4.Restore default ratio button:Click to resore the default postion ratios.

1.8 Seam Flip Air Blow

Click on the edittext “seam flip air blow” on the main interface to enter the seam flip air blow interface .As shown in the figures.



Contain：

1.Click on[Enter Settings] to enter the settings button.Click this button to enter the settins interface,where users can save the settings parameters.

2.Go to position 1-5 for blowing air and reversing: Clickto sasve position value.

3.Save button : Click this button will retrieve the current stock psoition and save it ti the corresponding location wake up and remove the corresponding set reverse position.

4.Display position percentage:Set to display one hundred and forty percent of the current stock postion to allow users to understand the current work progres.

5.Click on the reverse blowing switch:Users can set the function of satrting or prohibiting reverse blowing

6.Inverted blowing duration setting:Users can set the blowing duration and input the required numerical value through this setting Click on reset and blow air to reset to the deault value.

1.9 Expand value

Click the ” automaic perimter calcultion value” button on the main interface toi enter the corresponding value expand interfae

1.Automactic deateted value: This feature allows users to input and display the total travel value that needs to be adjusted.it provides rel-time feddback on the current settings.enabling precise control over the system’s operation.

2.Start Detection:

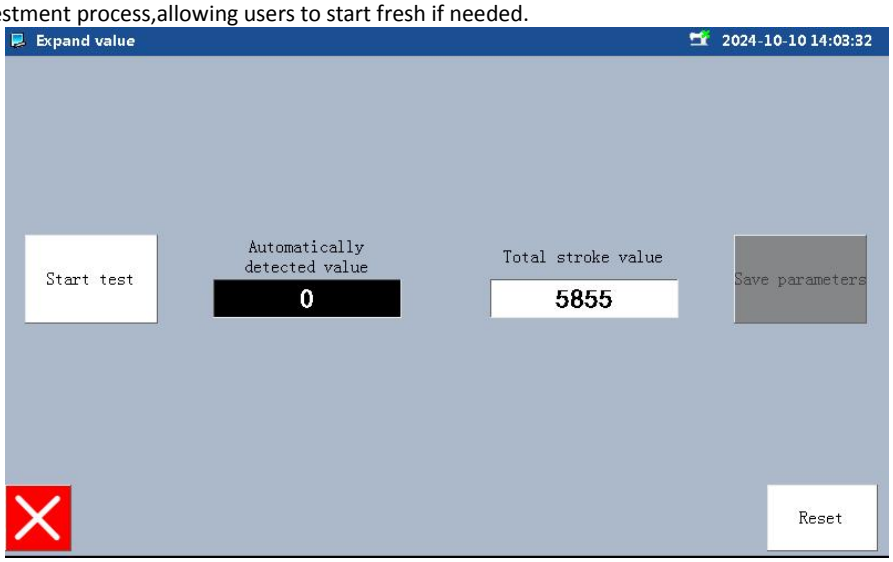
This button initates the motor’s detection process.Onec pressed,the will begin yo meansure the specified values,allowing for accurate adjustments based on the detected paramters.

3.Strat Prarmenset:

This function allows users to save the paramters that have been deemed suitable after adjustments.By saving there settings,users can ensure that the system retains the optimal configurations for future operations.

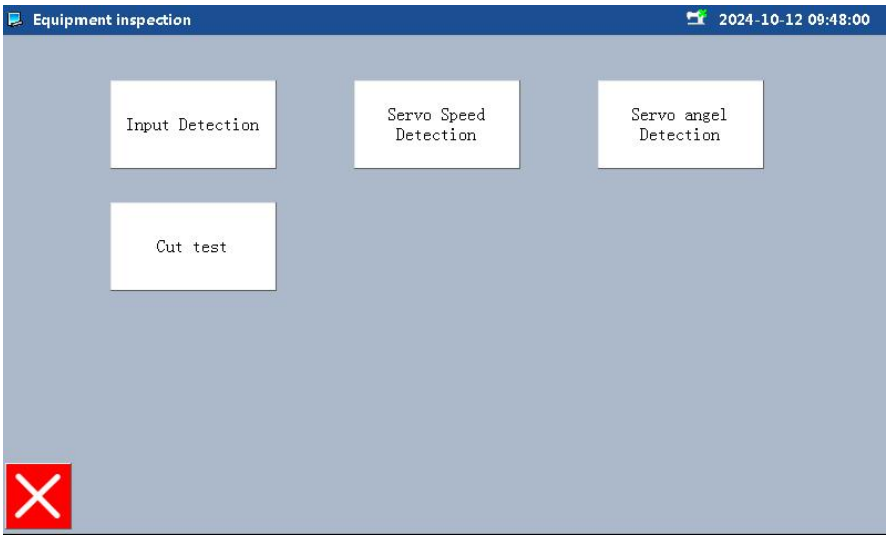
4.retset button:

This reset button restores the system to its deault settings.This is useful fro reverting any changes made durig the adjuestment process,allowing users to start fresh if needed.



Chanptr 2: Device detection

2.1 Equipment inspection



Testing interface of tje testomh interfce useage:

1.Enter the deivice testing infterface:

Function description:

users can center the [auto dirnk 1]device detecion description interface through the motor debugging interface through the motor debugging interfacee

2.Input Signal Detection

Function description:

This function is used to detect the status of input signal to ensure that the system receves the correct signals.

Usege Steps:

1.1 In the testing interface,locate the “input signal detection” option.

1.2 Click on this option ,and the system will begin detecting the input signals.

1.2 Observe the signal status displayed on interface to confirm whether the signals is normal.

3.Spindle Speed Detection

Function description:

This function is used to detect the spindle’s rotation speed to ensure that the spindle operates within the normal range.

4.Spindle Angular Veclocity detection:

Function description:

This function is used to detec the angular veclocity of the spindle to ensure that the angular changes of the spindle meet expectatios.

5.Cutter Test

Function description:

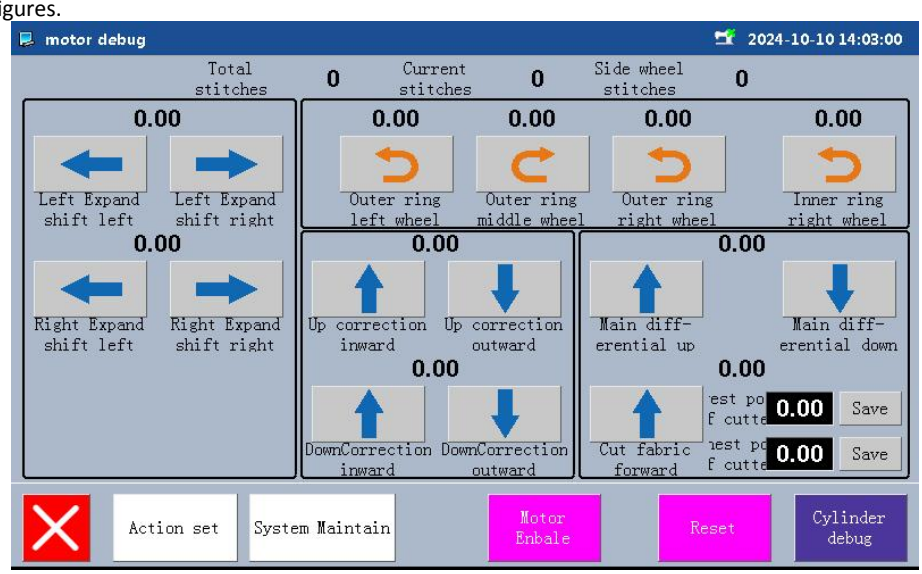
This function is used to test the working status of the cutter to ensure that it can cut normal.

6.Exiting the Testing interface:

Confirm the exit operation,and the system will return to the main interface.

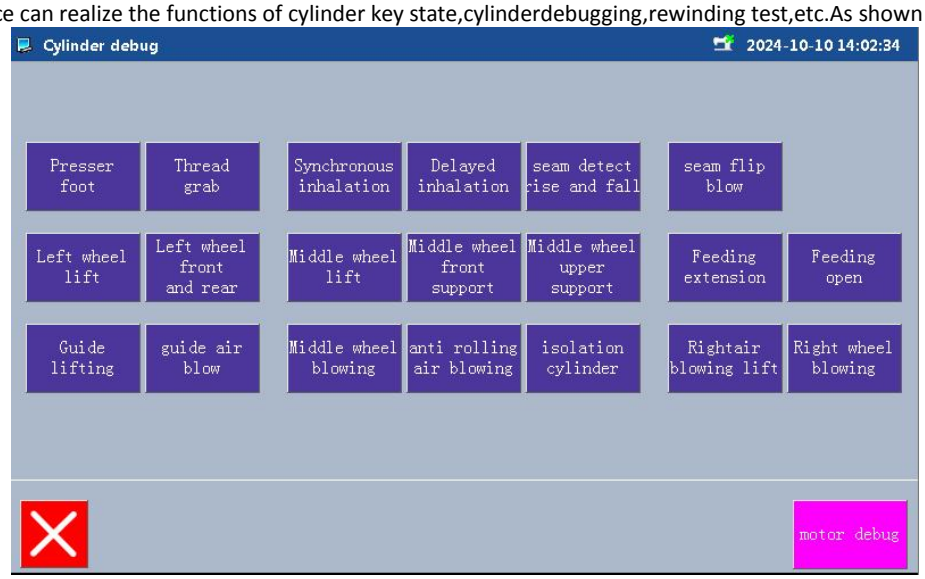
2.2 Motor debug

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.



2.3 Cylinder debug

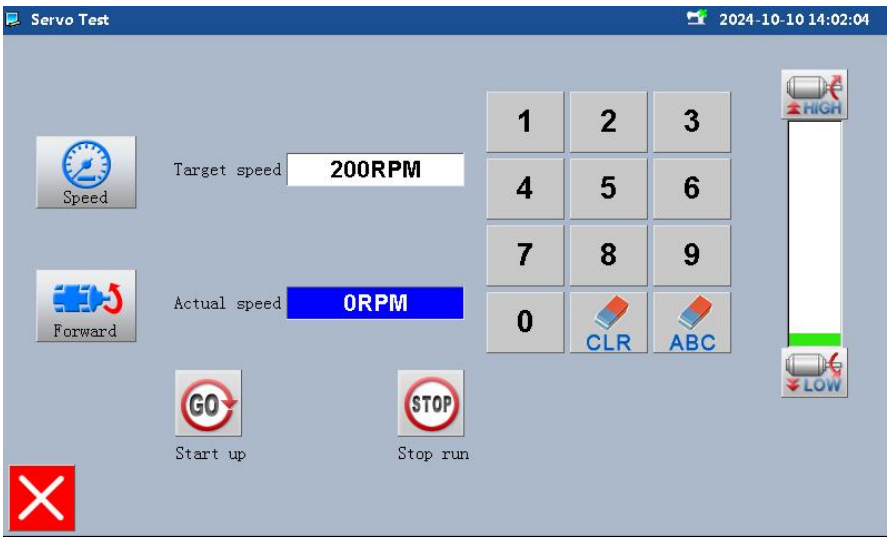
Click the motor debugging interface[Cylinder debug]button to enter the cylinder debugging interface.This interface can realize the functions of cylinder key state,cylinderdebugging,rewinding test,etc.As shown below.



2.4 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.

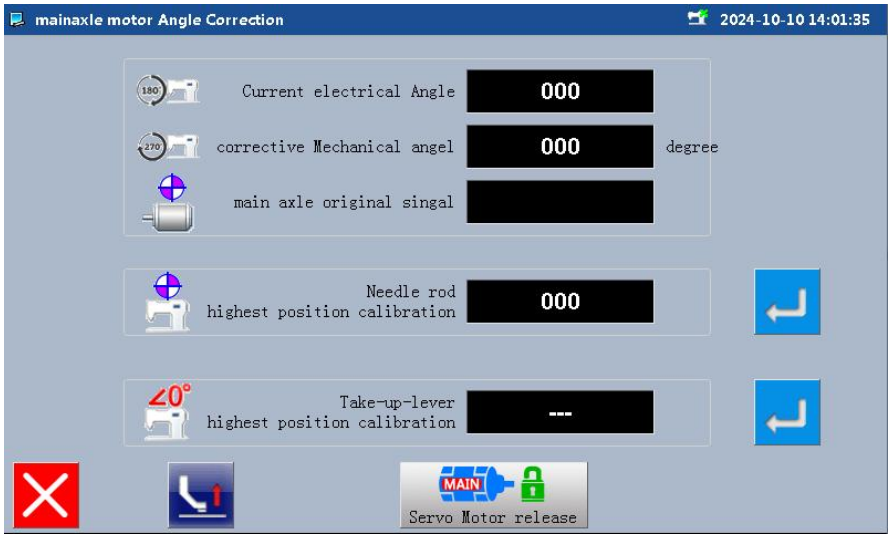
1.Disolay the actual speed and show the curent spindle’s actual speed(RPM).
2.Ste speed:Allow the useof input or buttons to reach the target speed.
3.Control buttons:Basic opeation buttons cuch as start,stop ,reset,etc.
4.Alarm:if a safe range is set ,an alarm message will be displayed.
5.Adjustment and optimization:If it is necessary to adjust the spindle speed,the target setting value can retset.



2.5 Mainaxle motor Angle Correction

Click the button named “ Servo angel Detection ” on the device detection and debug interfacen to enter Mianaxle motor angle correction .This interface allows ffor mainale motor Angle Correxion.As shown in the figure.

1.Determine necesary safety measures before making afjustments,Install the sensor correctky onto the spindle and refernce point.Confirm that they are secure and in the cirrect position.Exctyly Open the interface and complete the initlization settings;
2.Find the “Spindle Motor Release/Lock” button on the interface.Clicking this button can relase or lock th state ,allowing it to move freeky and conveniently.
3.Conduct measurements,rotate the spindle by a certain angle ,read data fron multiple postition
4.After adjusting to the satisfactory postion,find “Spindle Motor Lock” on the soft armor interface to prevent it from shifting during operation.
5.Final validation,perfrom a complete measurement again to ensure that all parameters are within the allowable tolerance range.


mainaxle motor Angle Correction
2024-10-10 14:01:35
Current electrical Angle
000
corrective Mechanical angel
000
degree
main axle original singal
Needle rod
highest position calibration
000
Take-up-lever
highest position calibration

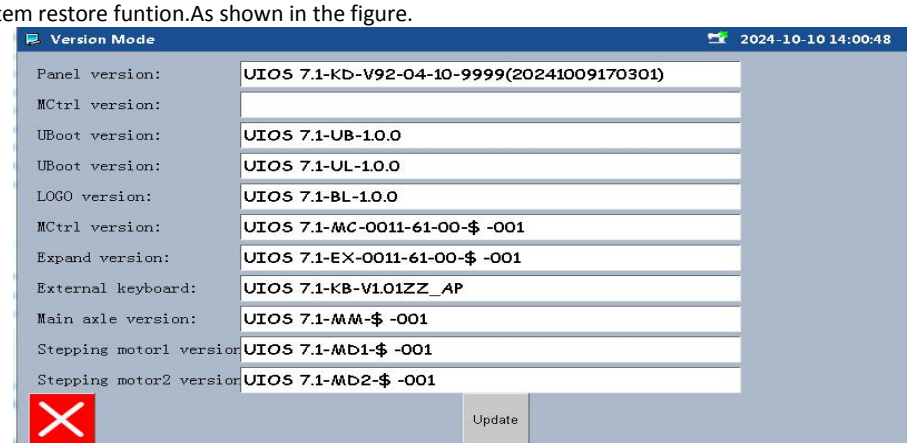
MAIN
Servo Motor release

Chapter 3: Systerm upgrade and functions

3.1 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.

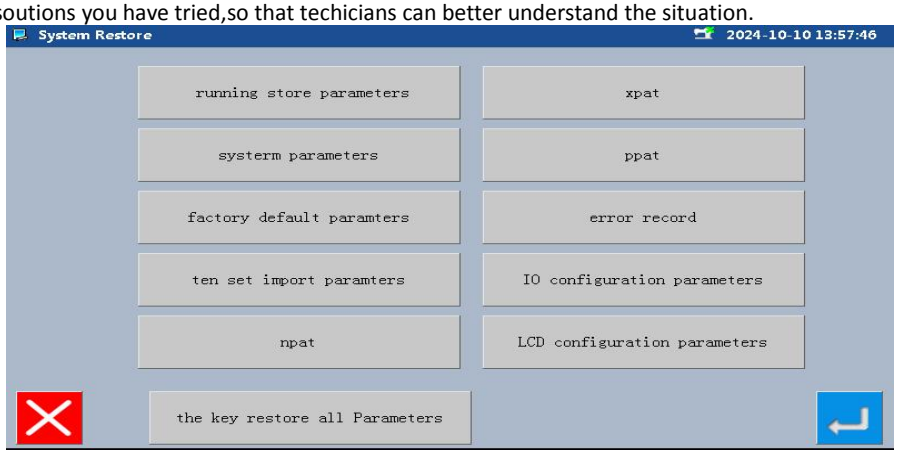


1.**Upgrade**:Serch for USB drive upgrade files and select the upgraded system,Click on the oneupgrade button to proceed with the updagrde process.Don’t turn off the power during the upgrade process.Afer upgrading , a prompt box will pop up ,please restart the power supply.

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.

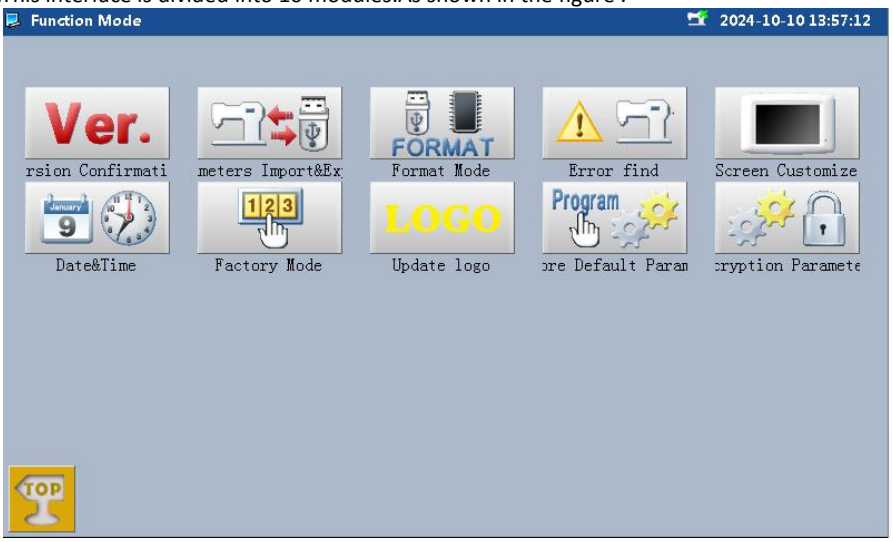
3.**System restore:**CLick the [the Clikc retstore] button to enter the sysytem retore interface ;As showm in the following figureinterface; As show in the follwing figure.You can restore all parameters with one click ,or select the paramenter items that needs to be restored.After the operation,restore to the orginal default value.After the system restoration is comleted,a prompt box will pop up,please restart the power suply.

4.**Troubleshooting:** if the upgrade issue persists.You can search for the technical supprot contact information previded by the company.Please make sure ti provide a detailed description of the proble you encountered and the soutions you have tried,so that techicians can better understand the situation.



3.2 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 .



Chapter 4: Systemparameters

Parameter List:

Parameter Name	Delault value	Range
Syncscale (1 Set)		
Side wheel sync scale	815	500-2000
Left wheel sync scale	863	500-2000
Middle wheel sync scale	9.9	500-1600
Middle wheel cylinder switch	ON	ON\OFF
Left Wheel lifting switch	ON	ON \ OFF
Left wheel cylinder switch	ON	ON \ OFF
Put on elastic (2 Set)		
How long to extend after retrcting close and open	350	1-30000
After the end of idling and the completion of bone collapse and a amount of time	100	
Sewing action (3 Set)		
Right wheel corection in the later stage of sewing	Stop correction	External correction
Sewing position 1	6000	1000-10000
Sewing position 2	7000	1000-10000
Sewing position 3	7500	1000-10000
Outer circle right wheel outward correction speed	0	0-9999
Speed of center corrention position 4	1	0-9999
Direction of action for position 4 of center correction	Outward	Outward、Indward
Correction method	Convential	Convential 、After the press foot falls
Trim sensor (4 Set)		

Parameter Name	Delault value	Range
Whether the disconnection 1 is effective	Valid	Valid 、Invalid
Whether the disconnection 2 is effective	Invalid	Valid 、Invalid
Whether the disconnection 3 is effective	Invalid	Valid 、Invalid
Number of breken thread 1 detection	50	1-1000
Number of breken thread 2 detection	50	1-1000
Number of breken thread 3 detection	50	1-1000
Number of breken thread 3 detection	50	1-1000
Trim (5 Set)		
Whether the hread trimming cylinder is valid	Invalid	Valid 、Invalid
Delay from thread trimming opening to closing	100	10-3000
Whether the hook line is effective	50	10-3000
The delay from hooking close to subsequnent action	Valid	Valid 、Invalid
Securty switch detection alarm	120	10-3000
Counter (6 Set)		
Sets function of Up counter	ED	--,ED,CY
Sets function of DOWN counter	ED	--,ED,CY
Method of clearing(UP)counter setting value	--	--,IT,CL
Method of clearing(DN)counter setting value	--	--,IT,CL
Initilize UP/DN counter or not at power on	HOLD	HOLD、CLEAR
Prohibition of UP counter current value correction	ALLOW	ALLOW、FORBID

Parameter Name	Delault value	Range
Prohibition of DOWN counter current value correction	ALLOW	ALLOW、FORBID
ON/OFF of stitch counter function 1	OFF	OFF、ON
Setting for warning stitch number of counter 1	1000	0-9999
ON/OFF stitch counter function 2	OFF	OFF、ON
Setting for warning stitch number of counter 2	1000	0-9999
Advanced para (7 Set)		
Servo enable sinal delay	100	100-999ms
Time delay after servo ban	100	100-999ms
HALT Switch type	NO	ON、NC
Trim switch type	NO	ON、NC
Pneumatic check switch type	NC	ON、NC
Set language(8Set)		
Language	English	Chinese 、 Englsh 、 Vietname、Korean、Turkish
Set language(9Set)		
Whether the cutter is valid	Effective	Effective、Invalid
Opening timeing of the cutter	1800	0-9999
Reserved Para	3000	200-3500
The position where the cutter is lifted	450	1-3000
Number of stitches that cutter stops in advance	1	0-50
Roller adjustment(10 Set)		
Speed of idling when start	600	50-600
The empty rotate speed in boneless postion	50	1-100
Roller adjustment(11 Set)		

Parameter Name	Delault value	Range
Start slow stitches	5	0-15
Start slow stitch speed	1000 rotate	200-4000
Fine-tuning the speed the left wheel slow start	100%	20-200
Fine-tuning the speed the right wheel slow start	100%	20-200
Tail stitch postion(12 Set)		
End slow stitches	5 stitches	
End slow stitch speed	1000 rotate	200-4000
Fine-tuning the speed the left wheel slow end	100%	20-200
Fine-tuning the speed the right wheel slow end	100%	20-200
Panel set(13 Set)		
Buzzeraction can set when fault	Once	
Null Move display or not display can be set	Display	Display,HIDE
Select the display area of pattern	Clamp	Clamp、ACT_PAT
Whether do support TPAT?	NO	NO,YES
Display Trim icon in main window	Show	Show、Hide
Pat ZOOM Multiple	1	1-25
Setting zoom style	Current Stitch	Current Stitch、origin
Sound Setting	ON	OFF、ON
Communication Setting	OFF	
Sound volume setting	100	0-100
Dircetion key and motor runls direction is unanimous or	unanimous	Unanimous、reverse
Whether save pattern to USB disk when save pattern to memory	NO	NO,YES
The display type of speed value	speed	Gear、speed
Whether suport long file name	Support	Don’t、 Support

Parameter Name	Delault value	Range
Whether support preious file name	Not	Not、Use
Whether display empty stitch	Don’t	Don’t、 Support
Next dialog mode	Normal mode	Normal mode、test Mode
Pat zoom way	Main Control	Main Control\Panerol
Main interface set(14 Set)		
Dispaly language of icon on the left of main interface	English	Chinese 、 Englsh 、 Vietname、Korean、Turkish
Receiving action(15 Set)		
Whether stacker is Used	Not used	Use、Not Use
Lifting distance of stacker	3000	100-30000
How long does the elastic band breacket retract after stacker descend	2000	20-20000
Automatic Start(16 Set)		
Whether to start sewing automatically	no automatic	no automatic、Automatic start
Delay time of automatic start	1000	100-30000
Left expansion and right expansion(17 Set)		
Whether the left expansion origin sensor is useful	Valid	Valid、Invalid
Left expansion range limit	1130x0.1	0-32767
Right expansion range limit	7700x0.1	0-32767
Seam flip blow(18 Set)		
Seam flip blow switch	ON	OFF、ON
Seam flip blow time	0ms	0-500m
First strand position switch	OFF	OFF、ON
Continuous(19 Set)		
Does it not stop during continuous testing	Stop	Stop 、 Continous operatiuon
Delayed inhalation(20 Set)		
Delayed inhalation time at the begin	200	1-1000