系统参数

Version statement

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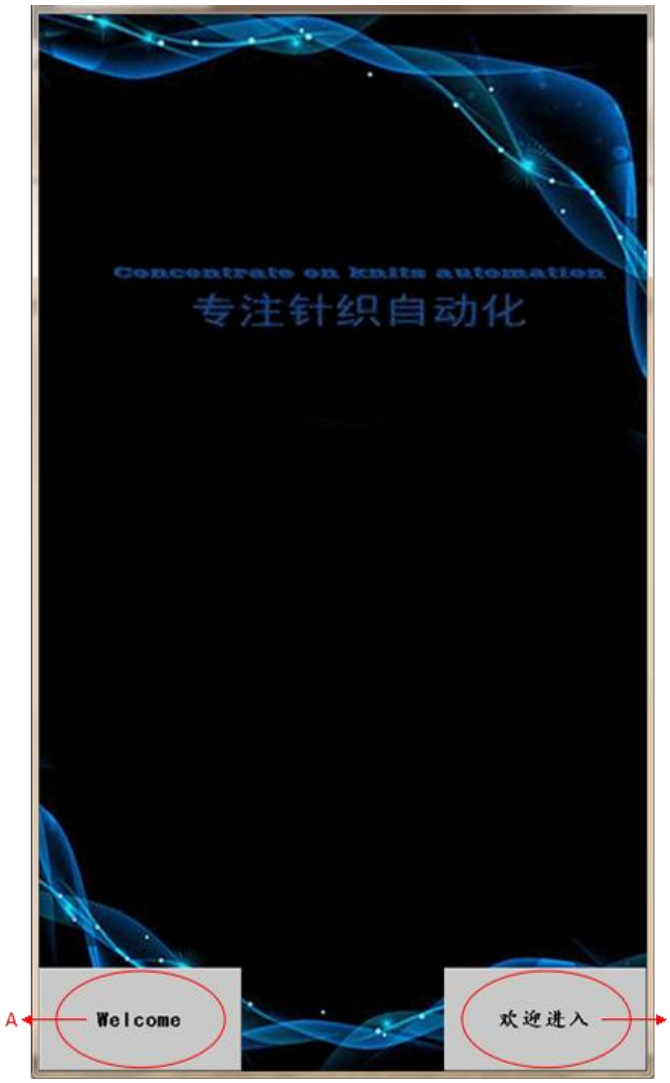
Chapter 1: Boot interface

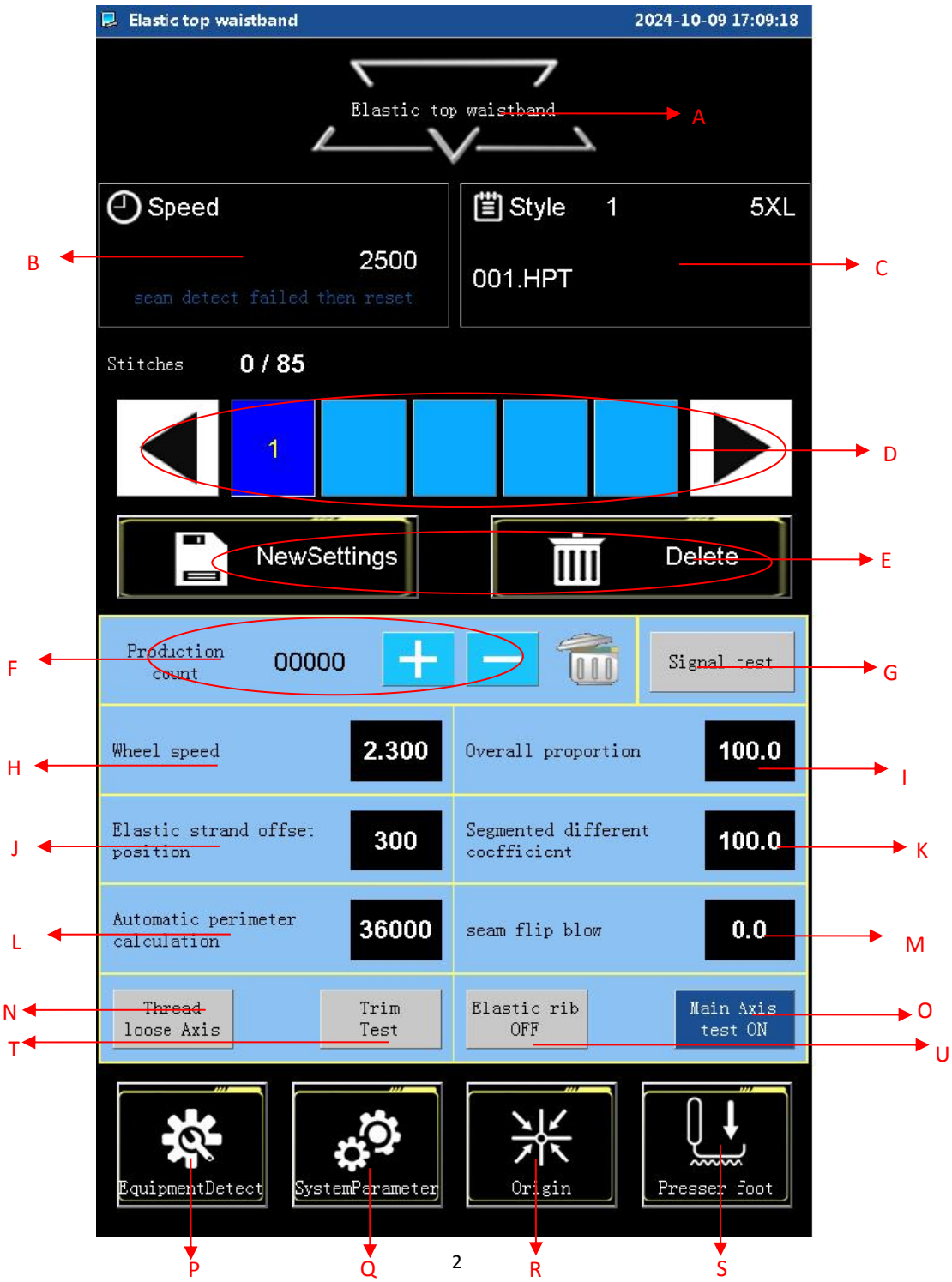
This machine supports multiple langugesand cn switch system langhuages accordi to the user。After turning on the power ,click on the foreigin or Chinese button accoding to user needs to enter the opation interface.



Function:

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

Chanptr 2: Setings and functions related to large version style



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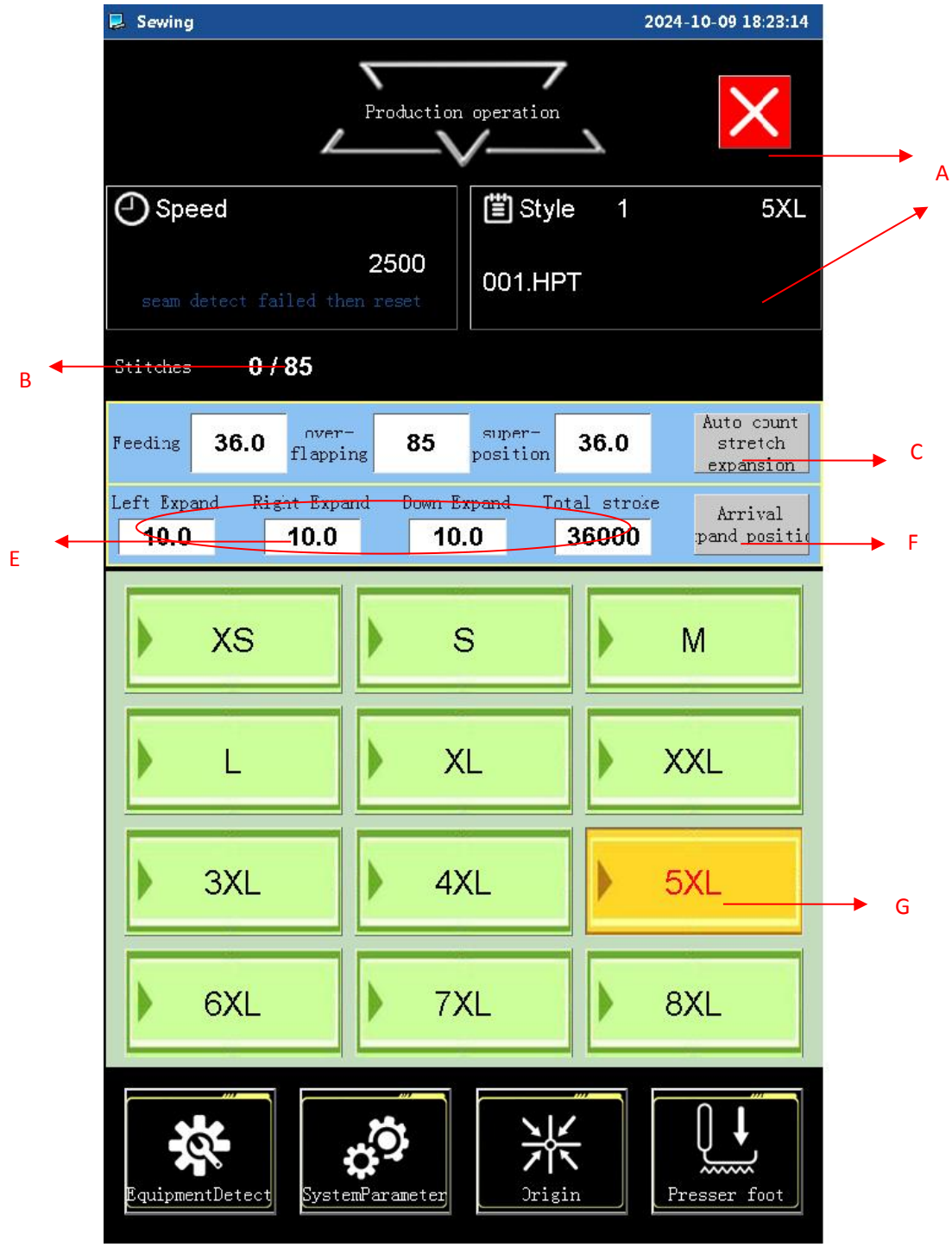
Mian interface function description：

order	function	content
A	Elastic top waistband	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 a larger style
E	New and Delete	Create and delete style
F	Production count	Count addition/subtraction,clear to zero,click to enter the count seting interface
G	Signal test	Input and output signal detection interface
H	Wheel speed	Set wheel speed
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
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
O	Elastic rib OFF\ON	Elastic rib OFF\ON
P	Main Axis test OFF\ON	Main Axis test OFF\ON
Q	Device detect	Click to enter the device detection
R	SystemParameter	Click to enter the system para
S	Presser foot	Lift /Raise Presser Foot
T	Trim test	Click on the thread cutting test function
U	Elastic rib OFF\ON	Elastic rib OFF\ON

2.1 Sewing interface

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



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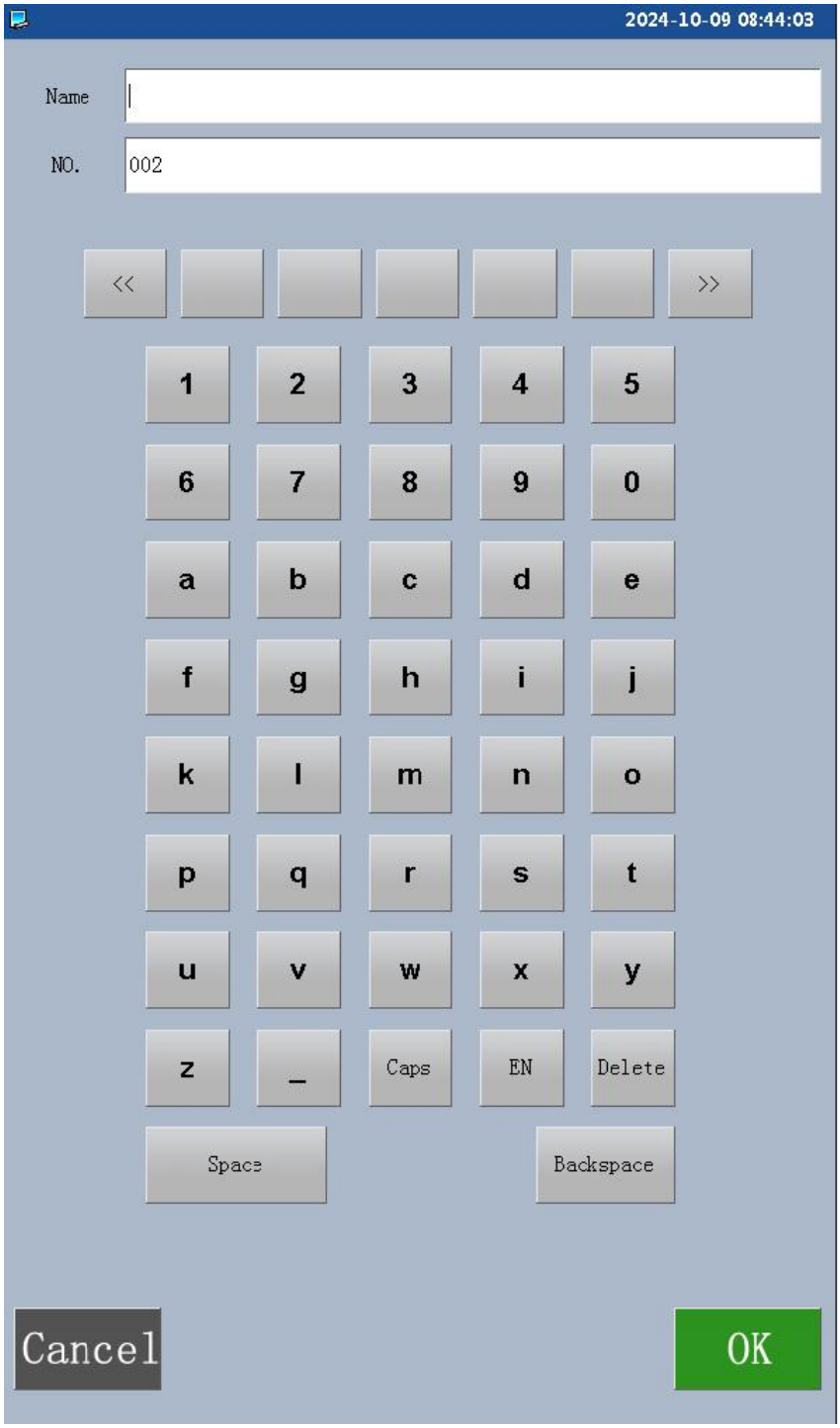
Function descripation:

order	function	content
A	Exit	Click to eixt and enter the main interface
B	Stitches	Display stitch count
C	Over flapping	Set the repeat needle value,different values vary
D	Super position	Set overlay values ,different sizes have different values
E	Auto count strectch expansion	Click to automatically count and expand the self setting value
F	Feeding	The feed function controls the movement of materials within a system key feature include.
G	Size Selection	Thare are twelve diffnet sizes avilable

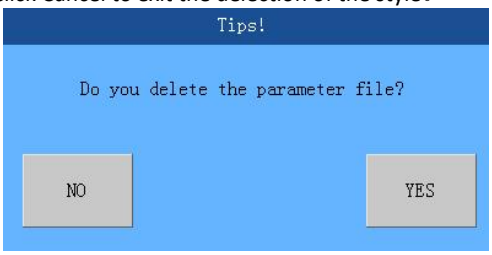
2.2 New style

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



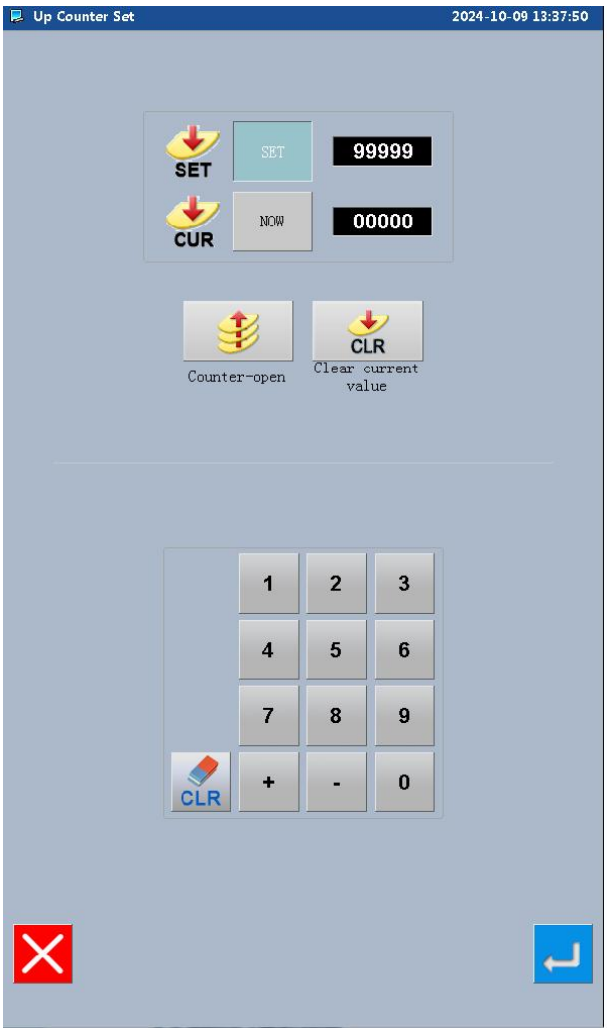
2.3 Delecte Style

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

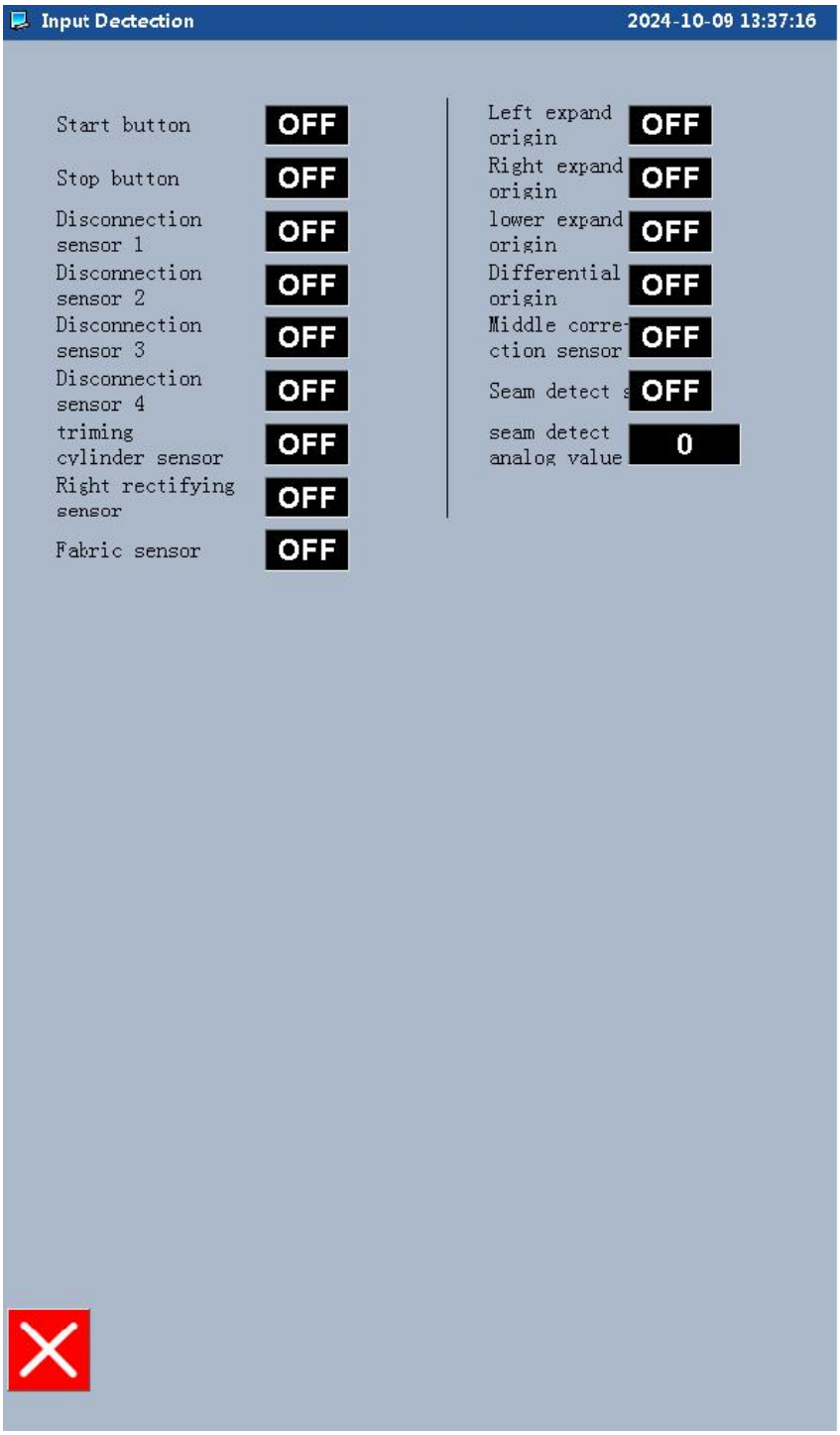
Click the button on the main interface called Production count value， enter the countup setting interface。As shown in the figures。



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.

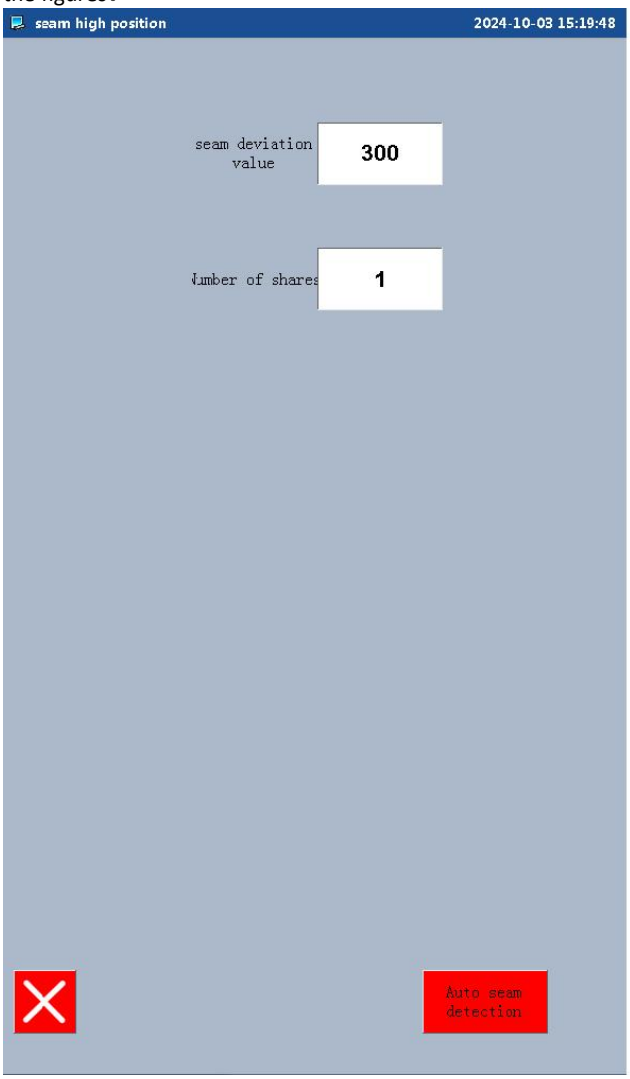
2.5 Input Deaction

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。



2.6 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：

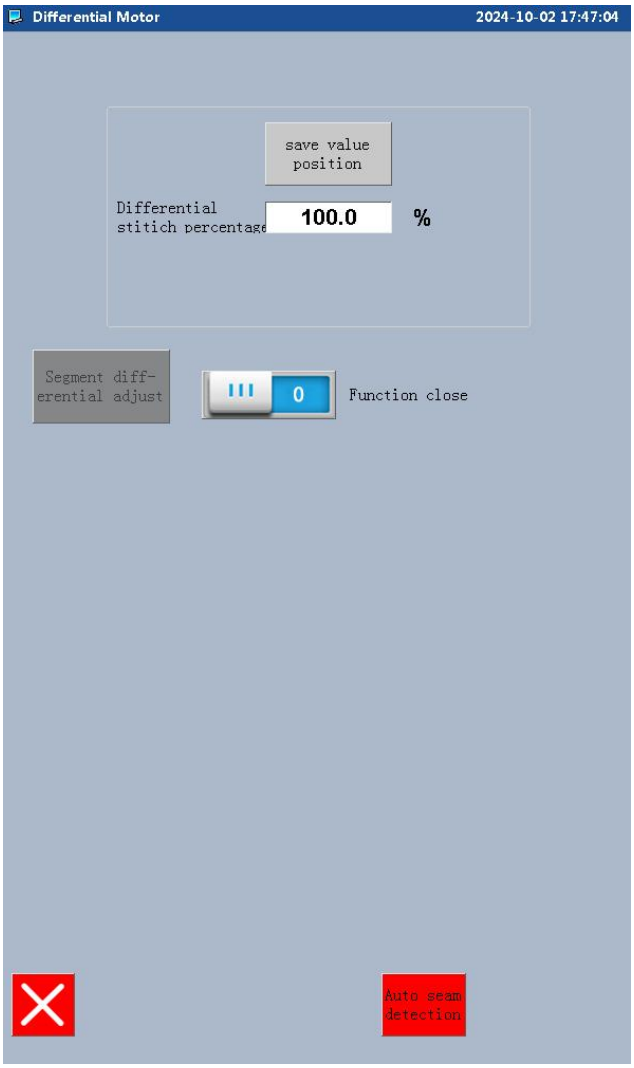
1.seamdeviation value。Set seamdeviation value。

2.Number of shares， Seting Number of shares。

3.Auto seam detection， Click to automatically cjeck the stock function.

2.7 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.

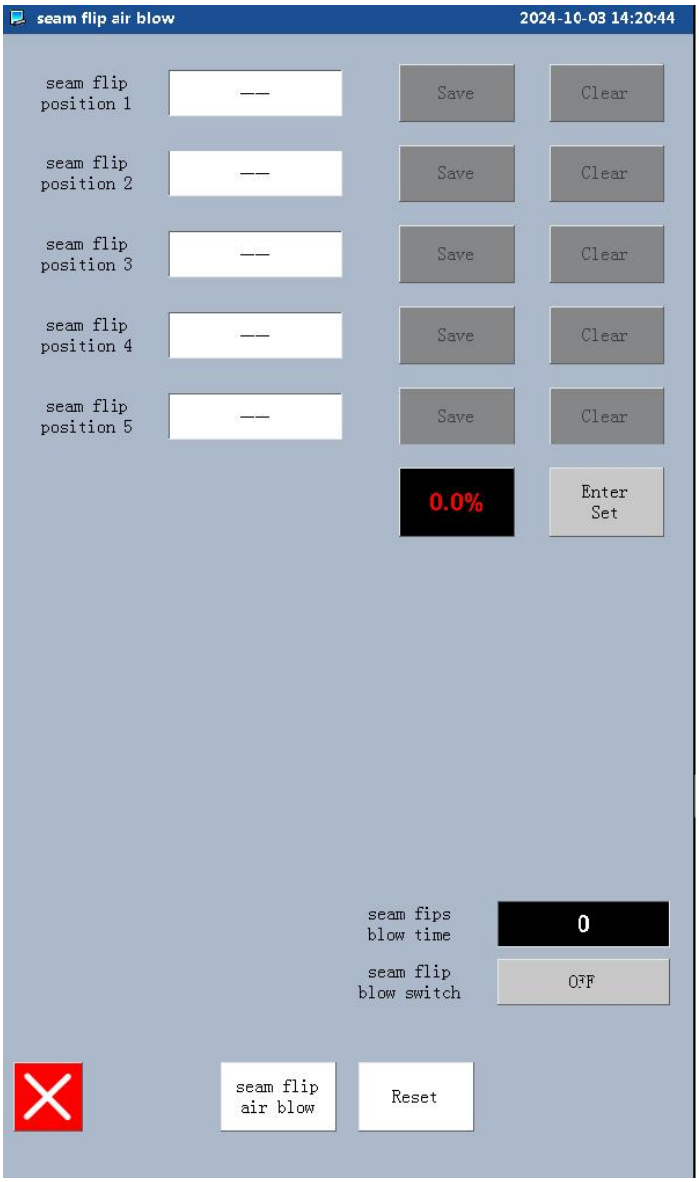
2.Differential spacing setting:Set the differential spacing to a specific size.Click on the differential spacing input field to enter the appropriate numerical value.

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.

2.8 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.Set the percentage ratio 1to 5 for the iverter position ,and click to save the current value,or clear value。

2.Reset,click to reset the inverted postion

2.9 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:

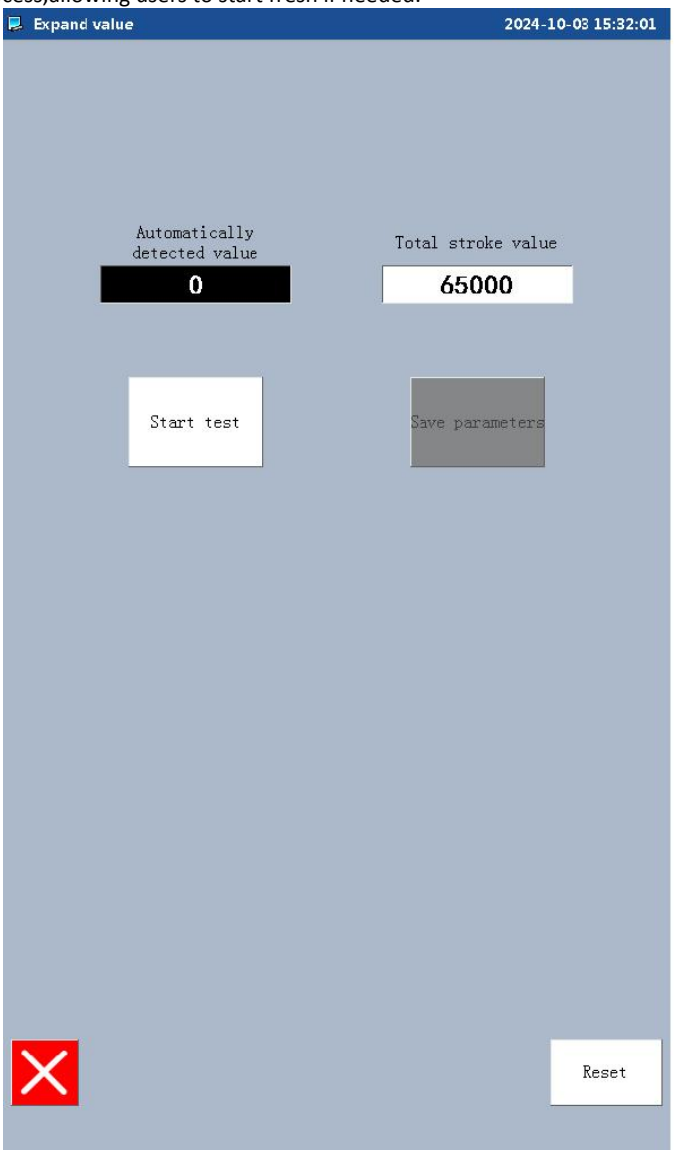
This button initates the motor’s detection process.Onec pressed,the will begin yo meansure the specified values,allowing for accurate adjustments based on the detected paramters.

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:

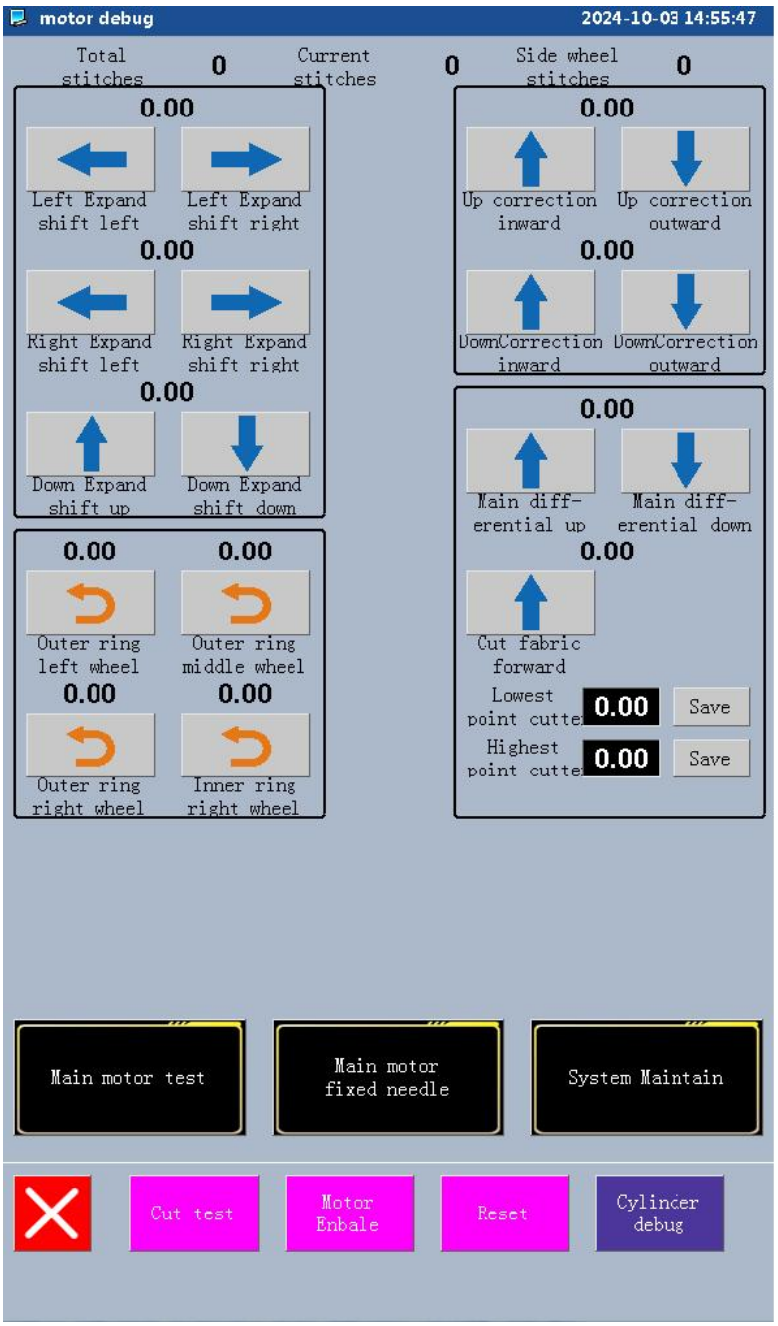
This reset button restores the system to its deault settings.This is useful fro reverting any changes made durig the adjuestment process,allowing users to start fresh if needed.



Chanptr 3:Device detection

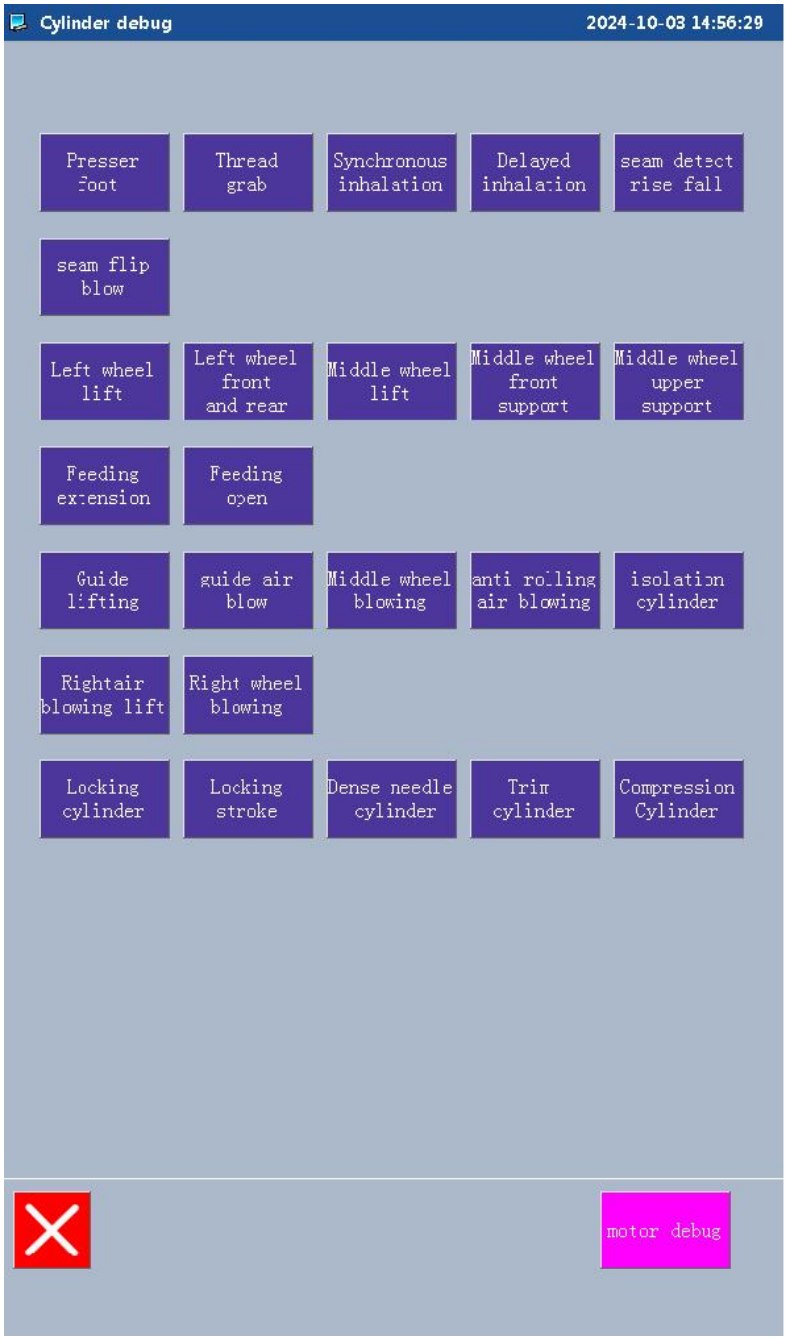
3.1 Motor debug

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

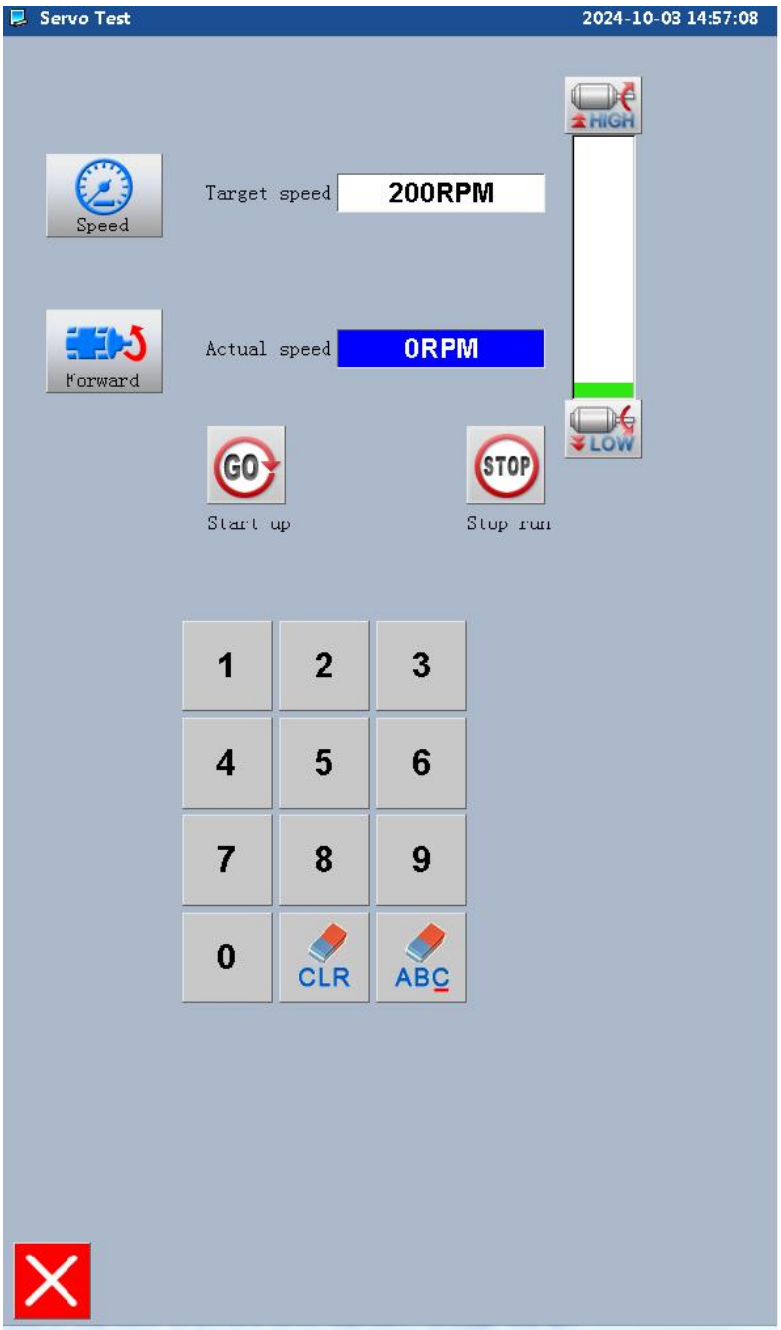
Click the “Cylinder debug”button on the motor debug tface to enter the debug infterface。 In this interface ,the cylinder button status ,cylinder debugging ,strand inversion material receiving test,reset,and other functions cna be achieveds。 As shown in the figure。



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。

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.



3.4 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。

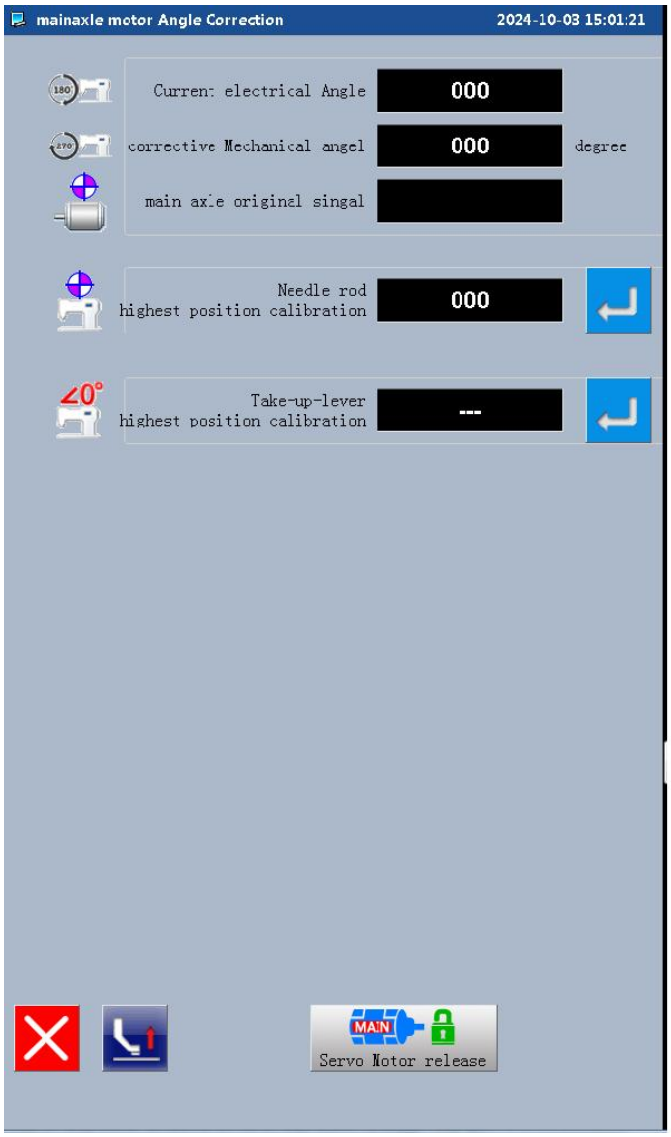
1.Determine necesary safety measures before making afjustments,Install the sensor correctky onto the spindle and refernce point.Confirm that they are secure and in the cirrect position.Exctyly Open the interface and complete the initlization settings;

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.

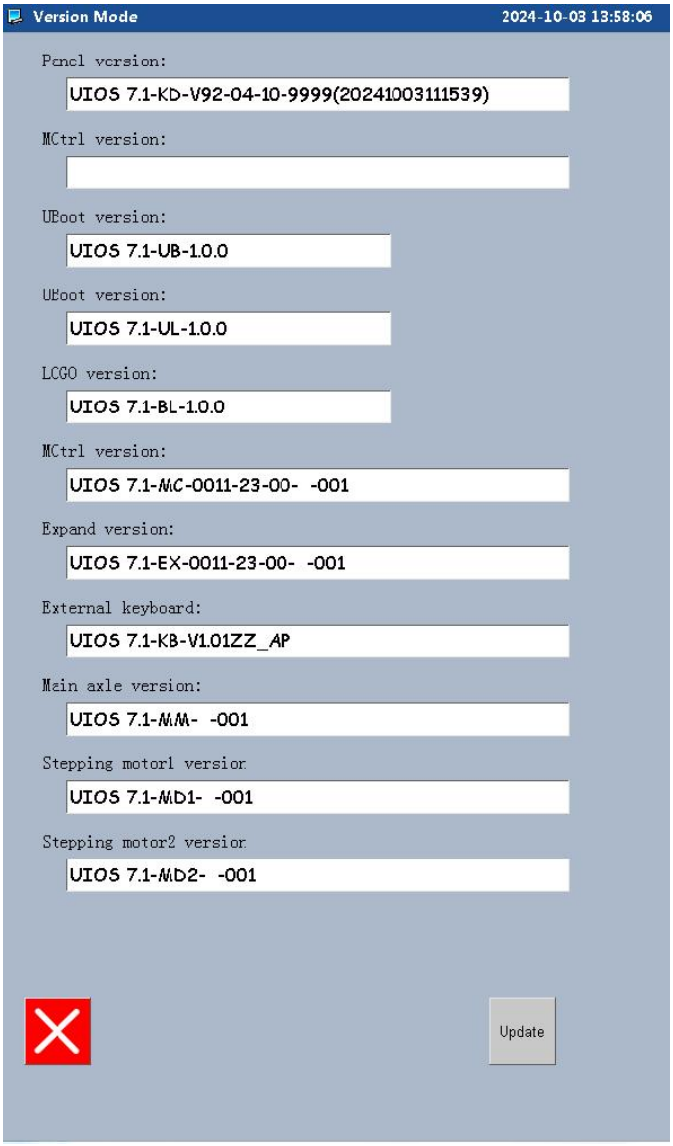


Chapter 4:Systerm upgrade and functions

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。



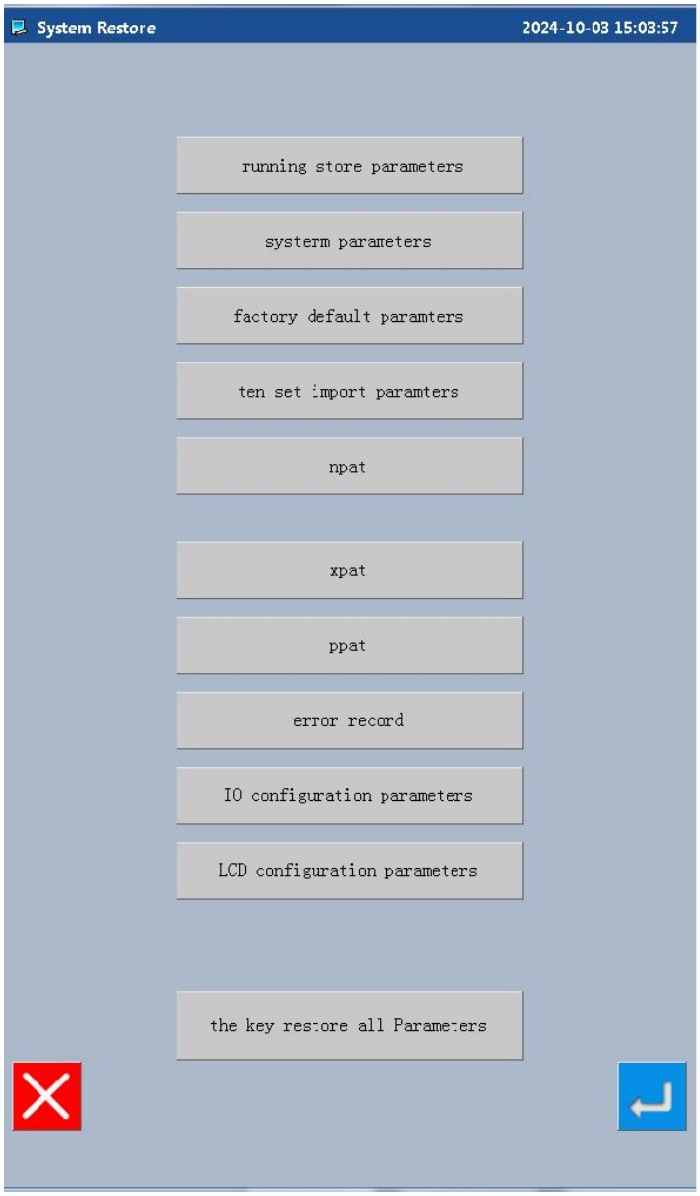
1.**Upgrade:**Serch for USB drive upgrade files and select the upgraded system， Click on the oneupgrade button to proceed with the updagrde process。Don't turn off the power during the upgrade process。Afer upgrading , a prompt box will pop up ,please restart the power supply。

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。

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.

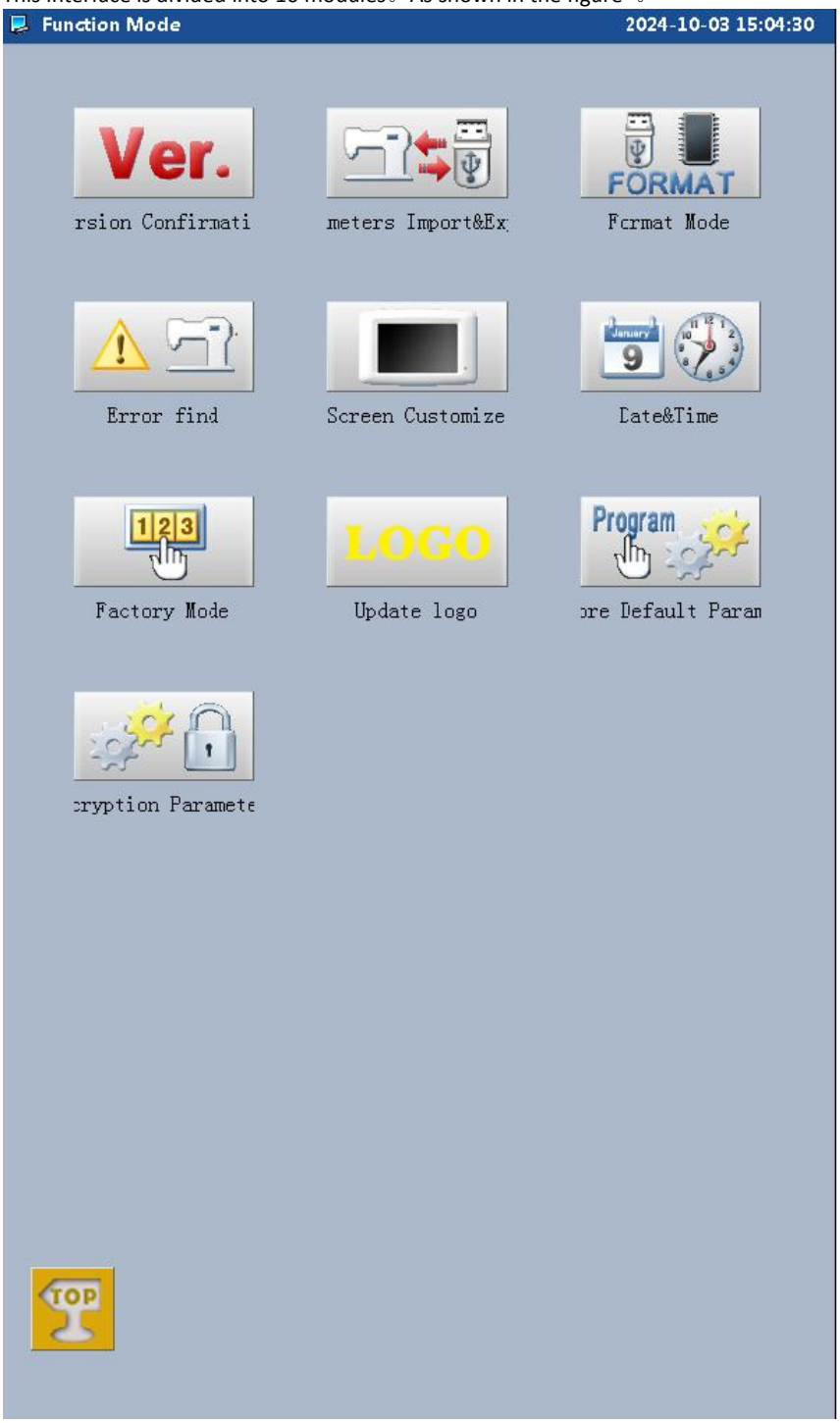
4.**Troubleshooting:** if the upgrade issue persists.You can search for the technical supprot contact information previded by the company.Please make sure ti provide a detailed description of the proble you encountered and the soutions you have tried,so that techicians can better understand the situation.

系统参数


System Restore
2024-10-03 15:03:57
running store parameters
systerm parameters
factory default paramters
ten set import paramters
npat
xpat
ppat
error record
IO configuration parameters
LCD configuration parameters
the key restore all Parameters

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 。



Chapter 5:Systemparameters

Parameter List:

Parameter Name	Delault value	Range
Syncscale (1 Set)		
Side wheel sync scale	350	500-2000
Left wheel sync scale	1500	500-2000
Middle wheel sync scale	1600	500-1600
Differential secondary orig in position	0	-1000-1000
Middle wheel cylinder switch	ON	ON\OFF
Left Wheel cylinder switch	ON	ON \ OFF
Put on elastic action(2 Set)		
How long to extend after retracting close and open	350	1-30000
Sewing action(3 Set)		
Right wheel correction in the later stage of sewing	Stop correction	Stop correction\ Extenernal correction
Sewing postion 1	6000	1000-10000
Sewing postion 2	6500	1000-10000
Sewing postion 3	7000	1000-10000
Sewing postion 4	1000	1000-10000
Outer cicle right wheel outward correction speed	0	0-9999
Speed of center correction position 4	2000	0-9999
Direction of action for position 4 of center correction	Outward correnction	Outward correnction\ Inward correction
Extension of differntial pulse interval time before sewing	0	0-1000
Extension of differetial pulse interval time between sewing	0	0-500

Parameter Name	Delault value	Range
Correctin method	Ather the pressse	Ather the pressse 、Conventional methos
Trim sensor(4Set)		
Whether the disconnection 1 is effective	Ivalid	Ivalid、valid
Whether the disconnection 2 is effective	Ivalid	Ivalid、valid
Whether the disconnection 3 is effective	Ivalid	Ivalid、valid
Whether the disconnection 4 is effective	Ivalid	Ivalid、valid
Broken wire detection needles	1	1-20
Trim (5Set)		
Whether the thread trimming cylinder Is valid	valid	valid、valid
Delay from thread trimming opending to closing	350ms	10-3000
Delay from thread trimming closing to hool thead opening	50ms	10-3000
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 action	120	10-3000
Advanced(6Set)		
Servo enable signal delay	100ms	100-999
Time delay after servo ban	100ms	100-999
HALT switch type	ON	ON、NC

系统参数

Parameter Name	Delault value	Range
Trim switch type	NC	ON、NC
Pneumatic check switch type	NC	ON、NC
Set language(7Set)		
Language	English	Chinese 、 Englsh 、 Vietname、Korean、Turkish
Cutter(8 Set)		
Whether the cutter is valid	Effective	Effective、Invalid
Start position	1	0-9999
Number of stitches that the cutter stops in advance	0	0-50
Roller adjustment(9 Set)		
Speed of idling when start	600	50-600
Main interface(10 Set)		
Display langage of icon on the left if main interface	English	Chinese 、 Englsh 、 Vietname、Korean、Turkish
Automatic Start 11 Set)		
Whether to start sewing automatically	No automatic	No automatic、Automatic start
Delay time for automatice start	200	100 -30000
Security switch detection a larm	ON	ON 、OFF
Expand Setting (12 Set)		
Whether the left expansion origin sensor is useful	Valid	Valid、Invalid
Down Expansion Device Options	General	General 、Ration
Sean filp blow (13 Set)		
Seam flip blow switch	OFF	ON 、 OFF
Seam fips blow time	0	0-5000ms
First strand position switch	OFF	ON、OFF
Continus testing	Stop	Stop 、 Continous
Delayed Inhalation (14 Set)		

Parameter Name	Parameter Name	Parameter Name
Delayed inhalation time at the begin	200	1-1000
Delayed inhalation time at the end	1000ms	1-5000
Locking cylidner (15 Set)		
Whether locking cylinderi is ok	Invalid	Invalid\pagasus
Dense needle (16 Set)		
Dense needle switch	OFF	OFF,Conventive、DAHE
Dense needle stiches number	3	Dense needle stitches