

Technician Parameter P

Parameter	Parameter Range(V0.5)	Default Value (V0.5)	Parameter Definition (V0.4)
P01	200-5000	3800	Free sewing speed
P02	1-100	56	Reserved
P03	0~1	1	Needle stop position selection (0 for upper needle stop, 1 for lower needle stop)
P04	200~3000	1800	Front reinforcement stitch speed
P05	200~3000	1800	Rear reinforcement stitch speed
P06	200~3000	1800	W-seam maximum speed
P07	200~4000	3800	Multi-seam maximum speed
P08	0~1	0	Function switch for raising the presser foot during starting the seam
P09	0~1	0	Slow starting seam switch
P10	1~9	2	Number of needles for slow starting seam
P11	200~800	400	Speed of slow starting seam
P12	0-6	0	Selection of needle spacing in the electronic wrench gear mode
P13	200~4000	3200	Fastest speed for reverse sewing
P14	200~800	200	Speed of patching needle insertion
P15	0~3	1	Filling needle mode 0: Off 1: Controlled by time 2: Fill half needle 3: Fill one needle
P16	0~4095	3200	Zero position value for thickness detection
P17	0~4095	2700	Thick and thin detection cutting thickness trajectory threshold
P18	0~50	5	Number of over-rod needles
P19	200~4000	3000	Maximum speed of thick material in thickness detection
P20	(-50~50)	5	Compensation value for over-rod needle distance

P21	0~50	0	Sensitivity of over-rod mode
P22	1~4	4	Trajectory of thick material in thickness detection
P23	0~4095	1100	Analog quantity of foot pedal cutting line position when over-rod mode is turned off
P24	0~4095	350	Analog quantity of foot pedal cutting line position when over-rod mode is turned on
P25	0~1	0	Reserved
P26	0~1	0	Reserved
P27	10~100	36	Reserved
P28	0~359	130	The starting angle of the binding line when the front reinforcement seam and the W seam are opened
P29	0~359	320	The ending angle of the binding line when the front reinforcement seam and the W seam are opened
P30	0~359	130	The starting angle of the binding line when the front tight seam is opened
P31	0~359	340	The ending angle of the binding line when the front tight seam is opened
P32	0~100	80	Reserved
P33	0~80	55	The duty cycle of the wire-wound electromagnet holding stage
P34	0~1	0	Reserved
P35	0~3000	800	The fastest speed for starting the first stitch
P36	0~3000	1500	The fastest speed for starting the second stitch
P37	0~3000	0	The fastest speed for starting the third stitch (0 has no effect)

P38	0~4000	1000	The speed limit for the first stitch when the reinforcement stitch is activated
P39	0~4000	0	The speed limit for the second stitch when the reinforcement stitch is activated
P40	0~4095	900	The position of the pedal in the rear half of the stroke (when the presser foot is lifted)
P41	0~4095	1650	The position of the pedal in the middle
P42	0~4095	400	The starting position of the pedal when it is pressed low-speed for the first time (relative to the middle position)
P43	0~4095	800	The ending position of the pedal when it is pressed low-speed for the first time (relative to the middle position)
P44	0~4095	4000	The maximum value of the pedal analog quantity
P45	1~100	1	Reserve
P46	0~1	0	Function switch for reverse pulling after wire cutting
P47	200~360	359	Reverse pulling angle after wire cutting Reserve
P48	0~1	0	Reserve
P49	200~300	250	Cutting line speed Reserve
P50	100~500	200	Reserve
P51	0~4095	3200	Reserve
P52	0~500	80	Reserve
P53	0~1	1	Raise the foot brake switch
P54	0~255	5	Automatic test running time
P55	0~255	3	Automatic test stopping time
P56	0~1	1	Reserve
P57	1~60	10	Hold the lifted foot for a certain period of time

P58	260~280	275	Upper needle stop angle
P59	140~180	160	Lower needle angle
P60	200~5000	3800	Automatic test running speed
P61	0~1	0	Main shaft encoder zero position correction flag
P62	0~15	0	Special operation mode selection: 0: Normal sewing mode, 1: Simple sewing, 2: THETA0 test, 3: Automatic test
P63	0~1	0	Start tight sewing switch
P64	0~1	0	End tight sewing switch
P65	60~990	65	Reserve
P66	0~1	1	Safety switch enabled
P67	0~3000	0	Reserve
P68	200~5000	4000	Maximum speed limit for free sewing
P69	0~360	0	Synchronous angle for electronic feeding
P70	0-3	0	Call parameters
P71	50~350	50	Reserved
P72	0~1	1	Reserved
P73	0-99	0	IoT channel selection
P74	200~2500	1000	Starting stitch speed
P75	0~12	2	Starting stitch count
P76	200~2500	1800	Ending stitch speed
P77	0~12	2	Ending stitch count
P78	10~359	130	Start angle of thread clamping
P79	0~359	320	End angle of thread clamping
P80	0~359	130	Start angle of thread clamping when opening the small nest
P81	0~359	320	End angle of thread clamping when opening the small nest
P82	0~359	335	
P83	0~359	359	
P84	200~3000	2000	The maximum speed of the pattern sewing machine

P85	0~1	0	
P86	0~50	8	Starting stitch spacing
P87	0~1	1	Starting stitch direction: 1 - Forward stitch 0 - Backward stitch
P88	0~50	5	Ending stitch spacing
P89	0~1	1	Ending stitch direction: 1 - Forward stitch 0 - Backward stitch
P90	0~1	0	Locking stitch spacing switch
P91	0~50	50	Maximum stitch spacing
P92	-99~99	0	Reduction at the beginning of the W-stitch
P93	-99~99	0	Reduction at the end of the W-stitch
P94	0-1	0	Reserved
P95	0	0	Reserved
P96	0-80	55	Reserved
P97	0~2	0	Reserved
P98	0~31	25	Reserved
P99	0-6	0	Electronic wrench repair mode needle spacing selection
P100	0~9999	0	Reserved
P101	0~9999	0	Reserved
P102	0-1	1	After the reinforcement stitch is completed, walk one more stitch forward.
P103	100-250	250	Maximum speed of the first stitch for reduced bird's nest
P104	0~9999	0	Reserved
P105	0~9999	0	Reserved
P106	1~50	1	Reserved
P107	0~9999	9999	Reserved
P108	0~6	0	Reserved
P109	1~50	1	Reserved
P110	0~9999	9999	Reserved

P111	0~6	0	Reserved
P112	80-120	100	M Trajectory Forward Seam Needle Distance Compensation
P113	80-120	100	M Trajectory Reverse Seam Needle Distance Compensation
P114	80-120	100	Reserved Trajectory Forward Seam Needle Distance Compensation
P115	80-120	100	Reserved Trajectory Reverse Seam Needle Distance Compensation
P116	80-120	100	A Trajectory Forward Seam Needle Distance Compensation
P117	80-120	100	A Trajectory Reverse Seam Needle Distance Compensation
P118	80-120	100	H Trajectory Forward Seam Needle Distance Compensation
P119	80-120	100	H Trajectory Reverse Seam Needle Distance Compensation
P120	1~180	100	Delay Judgment Time for Half Stitch Addition
P121	150~250	200	Delay Judgment Time for One Stitch Addition
P122	100~800	200	Starting Sewing Speed
P123	0~999	500	Reserved
P124	0-9999	100	Reserved
P125	0-9999	100	Reserved
P126	1~60	10	Reserved
P127	1~200	4	Thread clamping electromagnet full output time
P128	0~359	100	Reserved
P129	1~500	500	Thread clamping electromagnet protection time
P130	0~1	0	Safety switch logic

P131	1~500	300	Safety switch alarm confirmation time
P132	1~200	50	Safety switch alarm recovery time
P133	0~1	1	Reserved
P134	0~1	0	Powerful feeding switch
P135	0~500	50	Reserved
P136	0~3	0	Foot pedal speed control curve mode
P137	0~1	0	Power speed control curve auxiliary parameter
P138	0~1	0	Reserved
P139	0~1	0	Multi-segment stitch reinforcement function switch after midway thread trimming
P140	0~359	0	Reserved
P141	0~359	100	Reserved
P142	0~359	196	Reserved
P143	0~359	20	Reserved
P144	0~359	110	Reserved
P145	0~359	0	Start angle of micro-lifting presser foot at start of sewing
P146	0~359	200	End angle of micro-lifting presser foot at start of sewing
P147	0~1000	200	Duration limit of presser foot lifting at start of sewing
P148	1~500	150	Foot pedal presser foot lifting confirmation time

P149	0~4000	1500	Two-segment slope: Interruption turning point speed
P150	0~4095	2700	Two-segment slope: Middle foot pedal analog quantity
P151	0~900	90	Reserved
P152	0~1	1	Reserved
P153	0~359	0	Thread releasing start angle
P154	0~359	196	Thread releasing end angle
P155	1~60	10	Thread tension pre-holding time
P156	1~200	120	Reserved
P157	0~200	60	Thread tension set value
P158	0~359	150	Thread releasing end angle at start of sewing
P159	1~20	2	Reserved
P160	0~300	150	Reserved
P161	0~100	60	Factory calibrated value of electronic thread tension
P162	0~80	37	Reserved
P163	0~80	10	Reserved
P164	0~9999	0	Machine lock password
P165	0~100	0	Reserved
P166	100~200	100	Reserved
P167	100~200	100	Reserved
P168	100~200	100	Reserved
P169	100~200	100	Reserved
P170	100~200	100	Reserved
P171	100~200	100	Reserved
P172	100~200	100	Reserved
P173	100~200	100	Reserved

P174	0~2	0	Pattern Multi-Segment Stitch
P175	0~9999	0	Current Operating Hours of Machine Lock Function
P176	0~130	20	Height Setting of Micro-Lifting Presser Foot at Start of Sewing
P177	0~9999	0	Machine Lock Countdown
P178	0~9999	0	Reserved
P179	0~1	0	No stop during nest run
P180	0~1000	30	Force Application Time for Low Thread Tension
P181	0~120	60	Force Intensity for Low Thread Tension
P182	0~9999	0	Reserved
P183	0~9999	0	Reserved
P184	0~9999	0	Reserved
P185	0~4000	2000	Fan Start-Up Speed
P186	0~1	0	Reserved
P187	0~99	4	Reserved
P188	0~9999	0	Reserved
P189	0~9999	0	Reserved
P190	0~9999	0	Reserved
P191	0~9999	0	Reserved
P192	0-255	127	IoT Event Upload
P193	0~9999	0	Reserved
P194	0~9999	0	Reserved
P195	0~9999	0	Reserved
P196	0~9999	0	Reserved
P197	0~9999	0	Reserved
P198	0~9999	0	Reserved
P199	0~9999	0	Reserved