

自动吸风剪线说明书（V:4.0）

AUTO TRIMMER AND SUCTION MANUALBOOK(V:4.0)

前言

Preface

欢迎使用本公司产品，制衣行的正确投资选择！

Welcome to use the our products, it is the right investment choices in garment industry!

本说明书为本公司新研发的“一体机自动吸风剪控制箱”产品参考手册，请认真阅读此手册以更好的运用本公司产品！

This user manual is for our newly developed “All-in-one control box” products reference manual, Please read this manual carefully, hope it can give you useful help!



阅读本说明前以下要求说明请注意

Before reading the manual, please note the following requirements:

1: 用户使用作业前必须可靠接地，保证人生安全！

The user must be reliably grounded before operating to ensure the safety of life!

2: 非专业人士请勿拆卸控制箱

Non-professionals do not disassemble the control box

3: 控制箱与电机远离强磁高辐射环境

The control box and motor away from the magnetic high radiation environment

4: 不要在过热环境中作业（请在室温 5° C 以上、 45° C 以下的场所操作）

Do not work in hot environment (Please operate at room temperature above 5 °C and below 45 °C)

5: 不要在过于潮湿环境中作业（请保持 30 % ~ 95 % 相对湿度（无凝露）

Do not work in humid environments (Please maintain 30% ~ 95% relative humidity (no condensation))

6: 供电电压范围如下：

The supply voltage ranges are as follows:

220V 电控：【220V 接入供电时电压稳定在（AC200V~240 单相）之间】

220V control box: [220V access power supply voltage stability in (AC200V ~ 240V single-phase)]

电源供电电压 Power supply Voltage	220V±15% 单相 single phase
频率 Frequency	50~60HZ
电机转速 motor speed	200-6500RPM
电机扭矩 motor torque	≤2.2N.M

110V 电控：【110V 接入供电时电压稳定在（AC100V~130/单相）之间】

110V control box: [110V access power supply voltage stability in (AC100V ~ 130V single-phase)]

电源供电电压 Power supply Voltage	110V±15% 单相 single phase
频率 Frequency	50~60HZ
电机转速 motor speed	200-6500RPM
电机扭矩 motor torque	≤2.2N.M

安全叮嘱：

Safety requirement:

1：电机电控接通电源时（开机状态）请不要把脚放在脚踏板上

Do not put your feet on the pedals when the control box and motor is switched on (boot status)

2：本产品请专业人士安装调试

Let professionals to install and debug this product

3：严禁在通电时打开控制箱与电机端盖

Do not open the control box and the motor cover when energized

4：换针，穿线或更换底线时请关闭电源

Please turn off the power when changing the needle,threading or replacing the bottom line

5：安装，拆卸维修时请拔掉电源插头

During installation and removal service,please turn off the power and pull the plug

6：翻抬缝纫机时请关闭电源

Please turn off the power when turn lift sewing machine

7：使用本产品请远离高频电磁波和电波发射器等，以免所产生的电磁波干扰伺服驱动器而发生错误动作。

When use this product, please stay away from high-frequency electromagnetic waves and radio wave transmitters, etc., in case the electromagnetic waves generated interfere with the servo drive to occur wrong action .

8：禁止在日光直接照射的场所或室外运作

Do not operate in direct sunlight or outdoors

郑重申明：

Solemnly Declare:

1：不遵守安全使用说明操作规章，发生意外后果自负。

Do not comply with the manual book operating regulations and the safety requirements, all accidental occurrence should be taken by yourself.

2：未经本公司授权，请勿擅自改动产品，由此而引起的后果本公司不负任何责任。

Without our authorization, please do not alter our products, our company is not liable for any consequences arising therefrom.

保修策略：

1：本产品自购买起免费保修___年，终身维护。保修期内除人为损坏外出现的任何质量问题可免费修

Since from the purchase of this product,the free 2-year warranty,lifetime maintenance. During the warranty period,any quality problems the product will be free repaired,except artificial damage.

2：未经本公司同意自行拆卸，改装造成损坏将不给予保修

Without our consent disassemble or modify,the damaged will not give in warranty.

3：但凡出现无法解决的问题可以联系本公司

Whenever find the problem can not be solved,you can contact with our company.

目录

Contents

1:显示屏常用操作介绍

Introduction of display screen common Operation

2:如何进入参数与如何修改参数

How to enter parameters and how to modify the parameters

3:控制箱端口说明

The control box Port Description

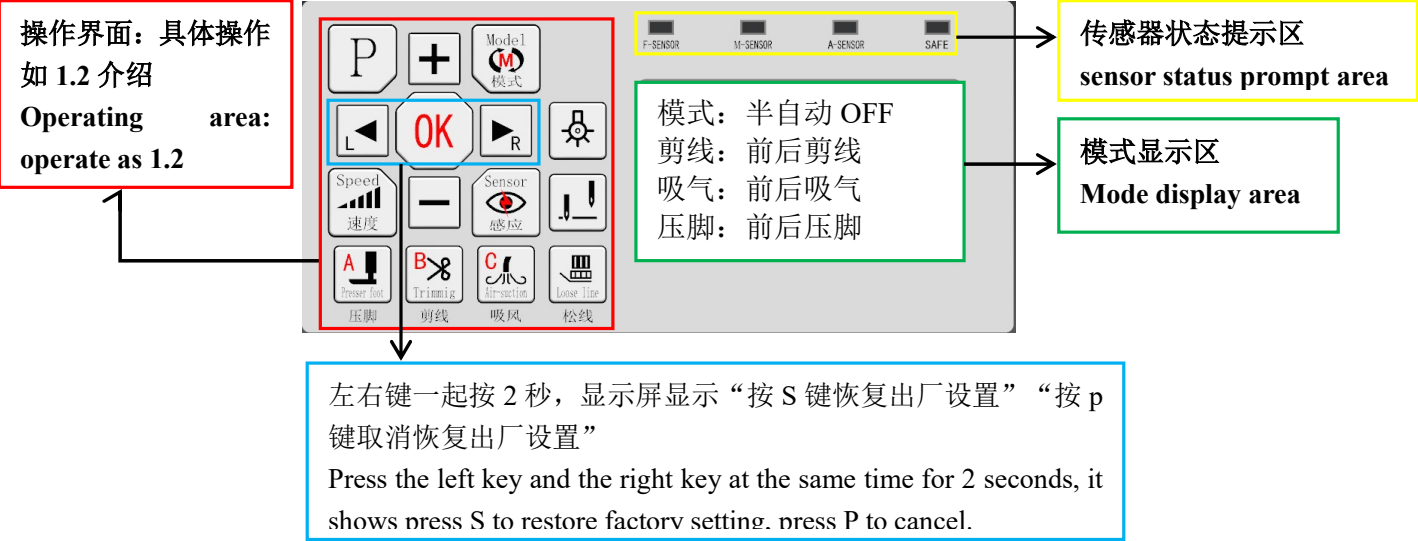
4:错误代码解析

Error code analysis

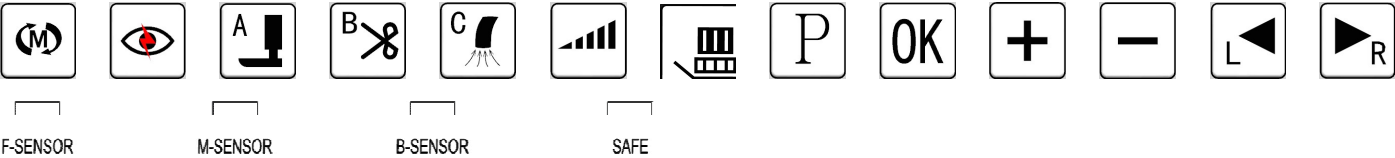
1: 显示屏常用操作介绍 Introduction of display screen common Operation

1.1、显示屏介绍：由两大部分组成（显示区域、操作界面）。

Display introduce: consist of two aspects(display area、operating interface)



1.2、操作界面功能键介绍:



序 号 The serial number	按键图标 Parameters of the code	功 能 说 明 function instruction
1	 (模式切换键) Mode switch	点动键: <u>全手工</u>→<u>自由缝</u>→<u>半自动</u>→<u>全自动</u>，之间切换; Press  key: <u>full manual</u>→<u>free sewing</u>→<u>semi-auto</u>→automatic 全自动：当布料盖住第一光眼时，机器会自动启动工作不需脚去踩踏调速器踏板； Automatic: the machine running itself without pushing the pedal when the cloth cover the first sensor 半自动：布料遮住第一光眼，脚踏调速器才能驱动机器工作； Semi-auto: pushing the pedal when the cloth cover the first sensor to run the machine 自由缝：无布料遮住第一光眼，脚踏调速器一样也能驱动机器工作； Free sewing: pushing the pedal without cover the first sensor to run the machine 全手工：剪线、抬压脚等所以动作需要人工去完成； Full manual: the action of trimming and lifting presser foot should be done by person ※:全自动、半自动、自由缝等安全开关断开情况下脚踏调速器无法驱动机器工作； The machine will not run when the safety switch is off under the mode of automatic, semi-auto or free sewing 全手工：安全开关断开情况下一样能使用脚踏调速器启动机器工作）。 Full manual: pushing the pedal to run the machine even the safety switch is off 长按模式键（需要密码）：

		Long press the mode key(enter password) S28 光眼模式 2 S28 sensor mode 2 S29 前光眼极性 0 S29 front sensor polarity 0 S30 后光眼极性 0 S30 rear sensor polarity 0 S35 后光眼开启 2 S35 rear sensor turn on 2 S43 网孔针数 06 S43 Mesh needle	
2	 (光眼功能键) Sensor function key	1.如何进入布料选择：点动键时进入布料选择;A:厚料、B:普通、C:薄料、D:透明、E:大网、F:小网；（选择厚料、普通、薄料时可以使用快捷按键（  ），也可以使用上下左右移动键选择布料模式，选择好布料按键确认并退出布料选择）。 How to enter cloth selection: press  key to enter cloth selection: A thick material, B normal material, C thin material, D transparent material, E big net, F small net (using the shortcut key    to select the thick material, normal material and the thin material), or select the clot mode with up, down, left and right key, press  key to confirm) 1. 如何进入光眼微调：在布料选择页面时，点动键进入当前光眼灵敏度和微调灵敏度参数； 如何进入光眼粗调：在布料选择页面时，按一下键、此时会出现“<u>****</u>布料选择****”，点动键进入当前光眼灵敏度和微调、粗调灵敏度参数； How to enter sensor adjusting: Press  key on the cloth selection interface, the display shows <u>****cloth choose****</u>, press  key to enter the sensor sensitivities, fine-tune it or rough adjust.	
3	 (压脚功能键) Presser foot	 点动键时进入压脚调整，重复点动切换：前抬压脚、后抬压	 长按键进入压脚参数调整（需密码：2014）：

	function key	脚、前后抬压脚、抬压脚关闭 Press  to switch presser foot sensor in turn :front lift,rear lift,fort rear and off lift.	Long press  key to enter presser foot parameter adjustment(enter password 2014): S19 前抬压脚保留时间 0220 Front presser foot lift keep time S20 后抬压脚延迟启动 0000 Rear presser foot lift delay start S21 抬压脚保留时间 006 Presser foot lift keep time S22 放压脚保护时间 020 Release presser foot protect time S31 压脚全力时间 180 Presser foot full time S32 压脚全力功率 100 Presser foot full power S33 压脚保持功率 20 Presser foot keep power P22 关闭手动抬压脚 0 Turn off the manual presser foot lift
4	 (剪刀功能键) Trimmer function key	点动  键时进入剪线调整，重复点动切换：<u>前剪线、后剪线、前后剪线、剪线关闭</u> Press  key to switch trimming in turn:front trimming,rear trimming ,fro+rear trimming and off trimming.	长按  键进入剪线参数调整： Long press  key to enter trimming parameter adjustment: S03 前剪线延迟针数 22 Front thread cutting delay stitches S04 前剪线延迟针数 06 Front thread cutting delay stitches S24 手剪线 1 Hand thread cutting S25 安全开关 3 Safety switch S26 切刀保留时间 25 Cutter keep time
5	 (吸风功能键) Suction function key	点动  键时进入吸风调整，重复点动切换：<u>前吸气、后吸气、前后吸气、吸气关闭</u> Press  button to enter the suction adjustment , repeat the point switch:front suction,back suction,front and back suction.	长按  键进入吸风参数调整： Long press  to enter suction parameter adjustment: S05 前吸延迟开启针数 02 Front suction delay opening stitch S06 前吸气关闭针数 14 Front suction closed the stitches S07 后吸气延迟开启针数 02 back suction delay opening stitches S08 后吸气延时关闭 0200 back suction delay off S13 中吸气延时开启针数 050

6	 (速度调整键) (Speed adjustment button)	点动键进入转速调整，再通 过, 键调整需要的转速，转速自动保存。 Press  button to enter the speed adjustment, and then press  and  keys to adjust the required speed, and the speed will be automatically saved.	长按键进入转速锁定调整(需要密码) Long press  to enter speed lock adjustment (need code)
7	 (松线功能调整键) (Thread loosen function adjustment button)	点动键进入松线模式调整，重复点动切换：前松线、后松线、前后松线、松线关闭。 Press  button to enter thread loosen mode adjustment, repeat the point switch: front thread loosen, back thread loosen, front and back thread loosen, thread loosen off.	
8	 (菜单键) (Menu)	点动进入用户参数 Enter user parameters	长按进入系统参数(需要密码) Long press to enter system parameters (password required)
9	 (确认键) (Identify)	参数确定键 Parameter determination	
10	 (数值调整键) Numerical adjustment key	向上键(修改数据时加) Add when modifying data	
11	 (数值调整键) Numerical adjustment key	向下键(修改数据时减) Subtract when modifying data	
12	 (左移键) Left shift key	点动键时进入机头LED灯亮度调节(1-5挡) Press  key to adjust the	长按键进入参数调整： P13 工作亮度 4 Long press  to enter the parameter:

		LED brightness(1-5)	the degree of the working P14 背光亮度的 0 the backlight degree
13	 (右移键) Right shift key	向右键 (在进入参数项时光标向右移)	
		点动  键时切换上针位、下停针位和下针位不回针、下停针自动回针 Press  to switch up needle stop position, down needle stop position	长按  键进入参数调整: Long press  to enter the parameter: S80 电机角度检测 Angle detection
14	F-SENSOR	前光眼指示灯 Indicator lamp of front sensor	当光眼被挡住时，此灯亮、未挡住时不亮；如未被挡住时，此灯亮起；则需要检查光眼灵敏度或发射是否损坏。 Light on when the sensor is covered, check the sensor sensitivity or the emitters if it light on without covered.
15	M-SENSOR	中光眼指示灯 Indicator lamp of middle sensor	当光眼被挡住时，此灯亮、未挡住时不亮；如未被挡住时，此灯亮起；则需要检查光眼灵敏度或发射是否损坏。 Light on when the sensor is covered, check the sensor sensitivity or the emitters if it light on without covered.
15	B-SENSOR	后光眼指示灯 Indicator lamp of rear sensor	当光眼被挡住时，此灯亮、未挡住时不亮；如未被挡住时，此灯亮起；则需要检查光眼灵敏度或发射是否损坏。 Light on when the sensor is covered, check the sensor sensitivity or the emitters if it light on without covered.
16	SAFE	安全指示灯 Safety switch indicator lamp	当安全开关断开时，SAFE 灯亮起时，则检查一下安全开关是否与感应磁感应到或感应磁极性反了。 Light on when the safety switch is off, check the interaction between the sensor and the houles.

2：如何进入参数与如何修改参数：

How to enter parameters and how modlfy the parameters

技术员系统参数列表如表 1：

2.1、长按（）键持续 2 秒钟进入 “系统参数”列表（需要密码进入调整）。（）（）键将选取修改的是参数值还是菜单值，点动后选取的地方将会出现闪烁。（）（）键将增加或减少闪烁区的数值，修改完毕参数后需要按（）键保存参数并退出系统参数。

注：以上是进入方法，具体参数号代表的参数意思详情如下：
出厂值密码：2014

工人参数列表如表 2：

2.2、点动键直接进入参数，（）（）键将选取修改的是参数值还是菜单值，点动后选取的地方将会出现闪烁，（）（）键将增加或减少闪烁区的数值，修改完毕参数后需要按（）键保存参数并退出系统参数。

2.1、Long press () button for 2seconds to enter “System Parameter” list (requires a password to enter the adjustment).

（）（） key to select to modify parameter value or menu value. Then,the selected value will be flashing .

（）（） key to increase or decrease the value.After completing modification,press () button to save parameters and quit system parameters.

技术员系统参数列表： Technician system parameter list 表 1

序号 System parame ter list	功能说明 Function description	功能参数默认 值 Parameter default values	功能参数范 围 Parameter Adjustmen t range	参数说明 Parameter description
S01	针迹 Thread track	3	1~4	

S02	两传感器间针数 Stitch number between two sensors	20	1~150	设定两个光眼之间的针数 Set stitch number between two sensors
S03	前剪线延时针数 Delay stitch number to cut thread after front sensors	022	0~150	后面光眼感应到布后延迟剪线的针数 Set delay stitch number after passing front sensors.Auto cut thread after stitches
※VTE	前松线开启延迟针数 needle count of front thread loosening delay open	01	0-150	布料盖住第一光眼启动针数 starting needle when cloth covering the first sensor
S04	双光眼模式 后剪线延迟针数 Delay stitch number to cut thread after two sensors	14	0~150	布离开第二光眼离开后延迟剪线的针数 Set delay stitch number after passing two sensors.Auto cut thread after stitches
	三光眼模式 后剪线延迟针数 Delay stitch number to cut thread after three sensors	0	0~100	布离开第三(後)光眼离开后延迟剪线的针数 Set delay stitch number after passing two sensors.Auto cut thread after stitches
※VTE	后松线开启延迟针数 needle count of rear thread loosening delay open	22		布料盖住第二光眼启动针数 starting needle when cloth covering the second sensor
S05	前吸延迟气开启针数 Delay stitch number for starting front air suction	2 VTE :1	1~150	布感应到第一个光眼后从第几针开始吸气 Set delay stitch number for starting front air suction after triggering first sensor
S06	前吸气针数 Front suction close stitches no.	14 VTE :25	1~150	吸气打开后, 计数几针后关闭吸气 Account how many stitches begin to close former suction
S07	后吸气延迟开启针数 back suction start stitches no.	2 VTE :8	1~150	离开后光眼后第几针开始吸气 After leaving latter photo-eye,how many stitches begin suck
S08	后吸气延时关闭 the delay of back suction close	200 VTE :300	50~5000MS	布离开光眼后, 计数几毫秒后关闭吸气 After leaving latter photo-eyes,count how many milliseconds off suction
S09	前松线延迟开启针数 front thread loose delay	00	0~150	
※VTE	前松线延迟关闭针数 needle count of front thread loosening delay close	002		
S10	前松线针数 Front thread loose stitches	12	0~150	VTE :保留
※VTE	后松线延迟关闭针数 needle count of rear thread loosening delay close	28		
S11	后松线延迟开启针数 Back thread loose start	00	0~150	
S12	停车延迟针数 machine stop delay stitches no.	002	1~150	後剪完线后多少针自动停车 How much stitches auto parking after trimmer
※VTE	停车延迟针数 machine stop delay stitches no.	35	1~150	後剪完线后多少针自动停车 How much stitches auto parking after trimmer
S13	中吸气延迟开启针数 middle suction start stitches no.	50	1~250	中吸气间隔针数 middle suction interval stitches
S14	中吸气针数 middle suction close stitches no.	20	1~150	中吸气针数 Middle suction stitches

S15	后剪光眼（第三光眼）延迟检测针数 the needle no. of the delay of back cutting line	25	1~100	三光眼模式：布离开中光眼经过多少针后没检测到第三光眼信号就开始剪线 Leave in the light eye after much after the needle cannot detect the third eye signal begins to cut the line
S16	前传感器响应时间 front sensor respond time	40	1~1000MS	前面光眼感应到后响应的的时间 The response time when former photo-eye sense
S17	前传感器灵敏度 front sensor sensitivity degree	55%	5~100	为适应不同布料设定前光眼的发射强度 Setting photo-eye through the fabric strength,to adapt to different fabrics
S18	后传感器灵敏度 Back sensor sensitivity degree	55%	5~100	为适应不同布料设定后光眼的发射强度 Setting photo-eye through the fabric strength,to adapt to different fabrics
S19	前抬压脚保留时间 front foot presser lift retaining time	700	100~2000MS	前光眼感应到布时压脚自动抬起维持时间 when front sensor feel the cloth, the foot presser lifter maintain time
S20	后抬压脚延迟启动 back foot presser lift start time	0	0~2000MS	脚踏板后踏压脚响应的的时间（毫秒） The lift foot response time after latter foot pedal(millisecond)
S21	抬压脚保护时间 foot presser protection time	6	1~120S	手动抬压脚持续多少时间后自动关闭压脚输出（秒） Lifter the foot presser by hand some time then Auto close foot presser output(second)
S22	放压脚保护时间 release foot presser protection time	20	20~800MS	压脚释放保护时间（毫秒）the foot presser release protection time (millisecond)
S23	连续送布吸气剪线 continue feed cloth suction cutting line	0	0~1	0: 关闭 1: 开启 0:Close 1:Open
S24	运转中手动开关动作 operate manual switch action	1	0~3	0: 电机运转时按手动剪线不剪, 1: 可以剪(全手工模式時有效) 2: 运行中禁止中光眼保护 3: 运行中禁止中后光眼保护 0:When the motor is running, touch manual switch no cutting, 1:Have cutting
S25	安全开关选择 safe switch choice	3	0~3	0: 关闭安全开关 1: 缝台安全开关 2: 压脚安全开关 3: 缝台+压脚安全开关开启 0:off safety switch 1:Seam safety switch 2:Foot safety switch 3:
S26	切刀保留时间 the knife retaining time	25	1~1000MS	切刀动作时间（基本不用调整） Cutting action time (basically no adjustment)
※VTE	剪刀运行时间 trimmer action time	135	1~1000MS	
S27	界面恢复时间 recover time	5	5~100S	控制面板在进入菜单后多少时间跳回主界面 After entering the control panel ,how much time to jump back to the main menu interface
S28	光眼模式（数量选择） sensor mode (number choice)	2	1~2	1:单光眼 2:双光眼（※:第三光眼需要单独开启 S35） 1:single photo-eye 2:double photo-eye
S29	前光眼极性选择 front sensor polarity	0	0~1	0 : 對射 1 : 反射 Opposite polarity opposite
S30	后光眼极性选择 back sensor polarity	0	0~1	0 : 對射 1 : 反射 Opposite polarity opposite
S31	压脚全力间 foot presser full power time	180	10~990MS	压脚全功率工作时的时间 Time of full power operation
S32	压脚全力功率 foot presser full power	100	20~100%	压脚开始动作时，瞬间的输出功率 When the foot starts to move, the

				instantaneous output power
S33	压脚保持功率 foot presser retaining power	20	10~90%	压脚抬起后维持住后的功率（不能超过 50） Pressure foot lift after the maintenance of the power to live (not more than 50)
S34	后剪光眼灵敏度（剪刀边上） 第三光眼 back cutting line sensor sensitivity degree	55	5~100%	第三光眼发射强度 the third sensor Emission intensity
S35	后剪光眼开启（剪刀边上） back cutting line sensor start	2	0~2	0: 关闭 2: 开启 0: closed 2: open
※VTE	后剪光眼开启（剪刀边上） back cutting line sensor start	0	0~2	0: 关闭 2: 开启 0: closed 2: open
S36	预留 obligate	0	0~9	
S37	语言选择 language choice	0	0~3	0: 中文 1: 英文 2: 土耳其 3: 越南文 0:Chinese 1:English 2: Turkish 3: Viet Nam
S38	最大速度锁定 the max speed locked	6500	200~7000	电机的最大可调速度限制 Maximum adjustable speed limit for motor
S39	参数复位 parameter reset	0	0~1	调到 1 长按 OK 键有效 Transferred to 1 long-press the OK button to effective
S40	参数密码 Parameter password	2014		
S41	点动速度 click to run speed	2500	250-4500	※VTE
S42	点动针数 click to runNeedl	008	1-100	※VTE
S43	网孔针数 Needle counts of mesh	04	0-15	
S44	布料选择 Cloth selection	1	0-7	0:厚料 1:普通 2:薄料 3:透明 4:大网 5:小 网 0: thick material 1: normal material 2:thin material 3:transparent material 4:big net material 5:small net material
S45	前光眼动作阈值 Front sensor action threshold value	50	5-200	
S46	中光眼动作阈值 Middle sensor action threshold value	50	5-200	
S47	后光眼动作阈值 Rear sensor action threshold value	50	5-200	
S48	电机运转方向 Motor rotation direction	1	0-1	0: 电机反转 1: 电机正传 0: motor reverse 1: motor positive rotation
S49	加速曲线 Acceleration curve	70	10-100	
S50	加速灵敏度 Acceleration sensitivity	6	1-6	
S51	光眼粗调启用 Sensor crude regulation opening	0	0-1	0: 关闭 1: 开启 0: close 1: open
S52	强自动剪线	3	0-4	0:剪线最强保护 1:剪线强保护 2:剪线一般保

	Strong automatic trimming			护 3:剪线弱保护 4:剪线无保护 0:strongest protection 1:strong protection 2:normal protection 3:weak protection 4:off protection
S53	光眼感应时间 Sensor reaction time	10	3-150	
S54	光眼解除感应时间 Sensor removing reaction time	10	3-150	
S81	机型选择 type selection	0	0-1	0:ECA/ECB 1:VTC/CTE (切换时长按 OK 2-3s) OK 2-3s Long press OK key for 2-3 seconds when switching

工人系参数列表：The workers system parameter list 表 2

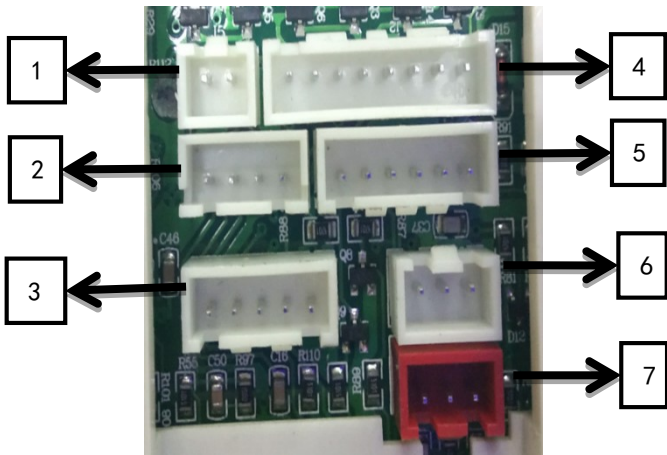
序号 System parameter list	功能说明 Function description	功能参数默认 值 Parameter default values	功能参数范围 Parameter Adjustment range	参数说明 Parameter description
P-01	操作模式 Operate mode	0	0~1	0: 半自动 1: 全自动 0: semi automatic 1: fully automatic
P-02	电眼开关 sensor switch	1	0~1	0: 关闭(全手工) 1: 开启(自由縫半自動全自動) 0:Closed 1:Open
P-03	剪线 cutting line	3	0~3	0: 关闭 1: 前剪线 2: 后剪线 3: 前后剪线 0: close 1: before the cut line 2: after the cut line 3: before and after the shear line
P-04	吸气 suction	3	0~3	0: 关闭 1: 前吸气 2: 后吸气 3: 前后吸气 0: closed 1: before the inspiration 2: after the inspiration of 3: before and after the inspiration
P-05	后拉布轮 back pulley wheel	0	0~2	0: 关闭 1: 缝制中 2: 缝制后 0: close 1: sewing in 2: after sewing
P-06	自动压脚 foot presser	3	0~3	0: 无抬压脚 1: 前抬压脚 2: 后抬压脚 3: 前后抬压脚 0: no lifting of the foot 1: front lifting foot 2: after the lifting of the foot 3: before and after the lifting of the foot
P-07	启动速度模式 start speed mode	1	0~1	0: 自动(依 P11 設定) 1: 脚踏板 0: automatic 1: pedal
P-08	停车针位 needle position	0	0~1	0: 上针位 1: 下针位 0:Upper pin position 1: a needle
P-09	停车自动抬压脚 machine stop auto foot presser lifting	0	0~1	0: 关闭 1: 开启(不限模式) 0:Closed 1:Open
P-10	手动吸气 suction by hand	1	0~1	0: 关闭 1: 开启 0:Closed 1:Open

※VTE	点动手动吸气 Press trimmer button to start suction	3	0~3	0: 关闭 1: 电机运转 关闭 手动吸气 开启 2: 电机运转 开启 手动吸气 关闭 3: 电机运转 开启 手动吸气 开启 0: closed 1: when motor running,it is closed Suction by hand is open 2: when motor running, it is open Suction by hand is closed 3: when motor running , it is open Suction by hand is open
P-11	启缝速度 start sewing speed	5500	200~5500	無説明
P-12	最大速度 Max speed	6500	200~7000	無説明
P-13	工作灯亮度 the degree of the working LED light	4	0~5	無説明
P-14	背光灯亮度 the backlight degree	1	0~1	0: 关闭 1: 开启 0:Closed 1:Open
P-15	半自动连续缝制 semi-auto continue sewing	0	0~1	0: 关闭 1: 开启 0:Closed 1:Open
P-16	半自动恒速剪线 semi-auto constant sewing	0	0~1	0: 关闭 1: 开启 0:Closed 1:Open
※VTE	半自动恒速剪线	1	0~1	0: 关闭 1: 开启
	semi-auto constant sewing			0:Closed 1:Open

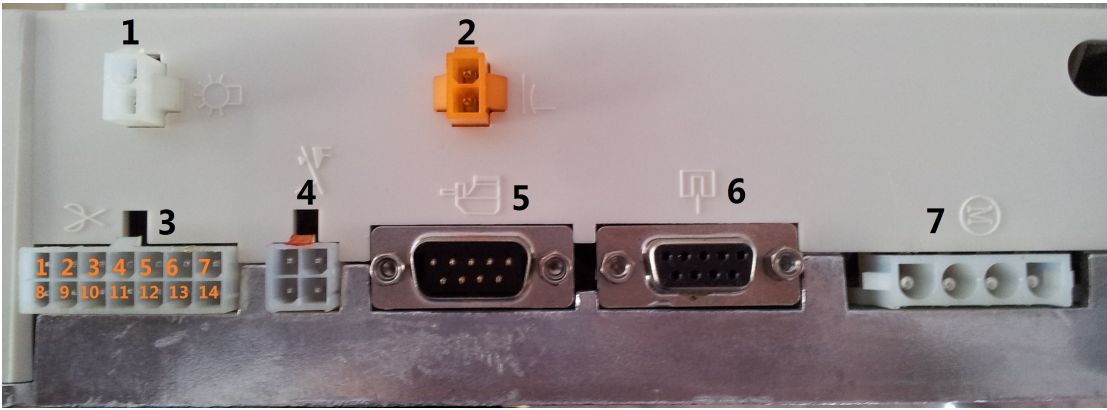
P-17	前放压脚 front foot presser lift	0	0~1	0: 自动模式 1: 手工模式 0: automatic mode 1: manual mode
P-18	脚控剪线 foot controller cutting line	0	0~2	0: 关闭 1: 全手工 2: 自由缝半自动(布離開中電眼後) 0: closed 1: full manual 2: free stitch semi-automatic
P-19	中吸气 middle suction	1	0~1	0: 关闭 2: 間隔吸 3: 長吸氣 0: Closed 2: interval suction 3. long suction
P-20	半后踏抬压脚 half back foot resser lift	0	0~1	0: 关闭 1: 开启 0: Closed 1: Open
P-21	剪线后抬压脚 foot presser lift after cutting	0	0~1	0: 关闭 1: 开启(後抬壓腳關閉時, 開啟無效) 0: Closed 1: Open
P-22	关闭手动抬压脚 close manual foot presser lift	0	0~1	0: 关闭 1: 开启 0: Closed 1: Open
P-23	自由缝开启 start free sewing	0	0~1	0: 关闭 1: 开启 0: Closed 1: Open
P-24	后剪线光眼延迟检测 back cutting line sensor delay check	1	0~1	0: 关闭 1: 开启 0: Closed 1: Open
P-25	松线 thread tension releasing	3	0~3	0: 关闭 1: 前松线 2: 后松线 3: 前后松线 0: close 1: front thread tension releasing 2: back thread tension releasing 3: front and back thread tension releasing
P-26	自动运行 auto running	0	0~1	0: 关闭 1: 开启 0: Closed 1: Open
P-27	自动跑合运行时间 auto running time	6	3~20	时间单位为: 秒 The time unit is: Second
P-28	自动跑合运行停止时间 auto running stop time	2	2~20	时间单位为: 秒 The time unit is: Second
P-29	电控版本			
P-30	显示屏版本			
P-31	音量调节 volume adjustment	020	0~25	
P-32	关闭开机语音 close the start voice	0	0~1	0: 关闭 1: 开启 0: close 1: open
P-33	网布模式 Net cloth mode	0	0-1	0: 关闭 1: 开启 0: close 1: open
P-34	禁止上停针 Forbidden up needle position	0	0-1	0: 关闭 1: 开启 0: close 1: open
P-35	剪线计数 Trimming counts	0	00000	一个流程计数一次, 在该参数状态下长按 OK 键清零或者从新开机即可。 Count for once time for a process, long press OK or restart to clear the value
P-36	止缝速度 Stop sewing speed	5500	200-6500	
P-37	恒线模式 Constant speed thread trimming mode	1	0-3	
P-38	自动控制模式 Automatic control mode	0	0-1	
P-39	开机自动上停针 Automatic up needle position after starting	0	0-1	
P-40	最低速度 Minimum speed	250	250-6500	

3：控制箱端口说明

Controller box port instruction



序号	端口名称	端口说明								
1	安全开关 safety switch		信号 signal	GND						
2	第一、二光眼（接收） First,second sensor(recieve)		IR 1 接收 recieve	5V	IR 2 接收 recieve	5V				
3	第三光眼发射+压脚壁 安全开关 Third sensor launch+ presser foot safery switch		GND	信号 Signal	5V	IR 3 发射 launch	5V			
4	上光眼发射（一、二） Up sensor launch(firsr, second)		5V	IR 1 发射 launch	5V	IR 2 发射 launch	剪线信 号 trimming signal	GND	LED 12V	GND
5	信号线端口 Signal wire port		2 光眼发 送信号 Sensor launching signal	2 光眼发 送信号 Sensor launching signal	TXD 接收 Recieve	TXD 发送 Launch	GND	12V		
6	第三光眼（接收） Third sensor(recieve)		5V	IR 3 接收 recieve	GND					
7	缝台安全开关 Sewing table safety switch		GND	信号 Signal	5V					



端口号码	端口连接的器件名称 port name
1	W500 绷缝机 LED 机头灯插孔 W500 Interlock LED light port,
2	抬压脚控制端口，连接压脚电磁铁或电磁阀（30V） Port of presser foot, connect to the electrical magnet or solenoid valve
3	14P 多功能端口 14P multifunctional port
4	脚踏板端口，连接调速器 pedal port, connect to the speed controller
5	连接吸风剪线显示控制面板 display port
6	连接电机相位信号线 motor phase signal port
7	连接电机 4 线驱动线 motor power port

3 号 14P 多功能端口 14P multifunctional port

3 号多功能端口标号	功 能 function
1, 8, 11	1: GND 8: 信号 1 11:5V
2, 9, 12	2: GND 9: 信号 2 12:5V
3, 10	3: 压脚输出 presser foot signal 10:30V
4, 2	4: 保护信号输入 protection signal input 2: GND
5	5: 大地 ground
6, 13	6: 吸风输出 air-suction output 13:30V
7, 14	7: 剪刀输出 trimmer output 14:30V

4：故障代码解析

故障代码 Error Code	故障描述 Error Description	故障产生原因 the reason of the Error	故障的解决方法 the resolution of the error
Er01	找不到停针位 not find needle position	电机信号线端子头接触不良 Poor connection of the motor signal wire	断电后检查电机信号线是否松动，然后重新上电，如果还不能解决，请联系售后服务人员 Turn off the controller and check the motor signal plug if it is poor connected, restart the controller. Contact with the after sales if the problem still occur.
Er02	调速器信号错误 Foot controller signal error	1: 开机时没插调速器 The pedal do not connect when boot on 2: 控速器线接触不良 Poor connection of the pedal wire 3: 后踩住控速器开机 Backward push the	断电后检查控速器连接或插头是否接触不良，然后重新上电，如果还不能解决，请联系售后服务人员 Turn off the controller and check the connection between the pedal and the controller, restart the controller. Contact with the after sales if the problem still occur.

		pedal when boot on	
Er03	电机相位信号错误 Motor phase signal error	电机信号线插头接触不良 Motor phase signal error	断电后检查电机信号线是否松动，然后重新上电，如果还不能解决，请联系售后服务人员 Turn off the controller and check the connection between the motor and the controller, restart the controller. Contact with the after sales if the problem still occur.
Er04	电机堵转保护 Motor locked rotor protection	1: 缝纫机过重或堵死 sewing machine is overweight or blocked 2: 电机过载 Overload of the motor 3: 电机 4 线驱动线没连接好或插反 Poor connection of the motor power wire	断电后检查: Turn off the controller 1、请检查机头是否被卡住 Check the machine if stuck 2、请检查电机是否被卡住 Check the motor if stuck 3、电机电源端子脱落或松动，然后重新上电，如果还不能解决，请联系售后服务人员 Poor connection of the motor power plug, restart the controller. Contact with the after sales if the problem still occur.
Er05	硬件过流保护 Hardware overload protection	1: 电机过载 Overload of the motor 2: 电机相位信号线没接好 Poor connection of the motor signal wire	断电后检查: Turn off the controller 1、请检查机头是否被卡住 Check the machine if stuck 2、请检查电机是否被卡住 Check the motor if stuck 3、电机电源端子脱落或松动，然后重新上电，如果还不能解决，请联系售后服务人员 Poor connection of the motor power plug, restart the controller. Contact with the after sales if the problem still occur.
Er07	显示屏和主板通讯超时 Serial communication timeout	1: 显示屏连接主板线连接不良 Poor connection of the display 2: 主板芯片损坏 Damage of the controller mainchip	1: 检查显示屏与控制器连接线 Check the wire between the display and controller 2: 检查控制器是否还可运行，如不能运行就是控制器损坏 Check if the pedal is good or not 3: 检查机器旁是否有高频机器干扰 Check if there is high frequency machine interference 4: 更换显示屏 Change the display
Er09	存储器不良 memory error	主板存储器损坏或不良 Memory on mainboard damage or error	控制器损坏，请联系售后服务人员 Contact with the after sales for the controller problem
Er10	光眼控制线路故障 Sensor control line error	显示屏连接光眼线路不良 Poor connection between the display and the controller	1: 显示屏损坏 The damage of the display 2: 显示屏背部光眼连接线接触不良,请联系售后服务人员 Poor connection of the sensor wire, contact with the after sales.
Er15	编码器故障 the motor board error		请联系售后服务人员 Contact with the after sales
Er16	过压 Over load	电压超出限制范围 The voltage is higher	请检查输入电源电压是否在额定范围内（AC260V），若上述无法解决，请联系技术人员

		than limited	Check if the voltage is higher than AV260V, contact with the after sales if the problem can not be solved
Er17	A 相电流检测故障 A current checking error		请联系售后服务人 Contact with the after sales 员
Er18	B 相电流检测故障 B current checking error		请联系售后服务人员 Contact with the after sales
Er19	AB 相电流检测故障 A&B current checking error		请联系售后服务人员 Contact with the after sales
Er20	欠压故障 Less volt error	电压低于限制范围 The voltage is lower than limited	请检查输入电源电压是否在额定范围内（AC 180V），若上述无法解决，请联系请联系技术人员 Check if the voltage is lower than AV180V, contact with the after sales if the problem can not be solved
Er22	控速器故障 Pedal error	1. 前踩控速器开机 Pushing the pedal when boot on 2. 控速器数值不对 The wrong value of the pedal	1. 重新前踏控速器解除 Push the pedal again to disengage 2. 按 P 键+剪刀剪进入维护参数，再按 OK 键查看（200±15%），数值大于则更换控速器 Press P and trimmer key to enter the maintenance parameters, press OK when on the pedal interface, check the value if it is 200±15% when the pedal do not work, change it if the value is abnormal