

C7

C7 包缝机面板操作说明书 V1.0

Instructions of C7 overlock sewing machine panel
operation

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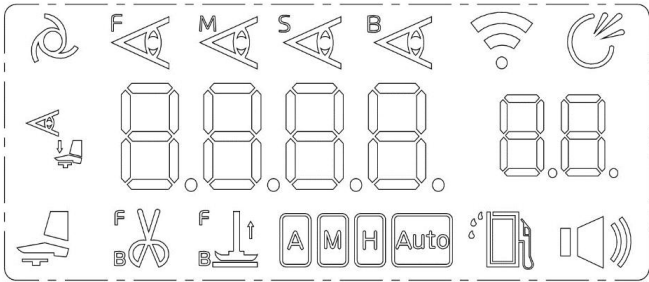
1. 显示及操作界面 Display and operation menu

1.1 显示界面介绍 Operation Panel Instructions



序号 No.	图标 Icon	说明 Description	备注 Remark
1		用户参数设置键 Customer parameter settings	
2		左移键 Left button	1、语音种类设置键 Voice language setting 2、参数内容区内，向左选择参数项 Towards the left to choose parameter 3、开机语播报开关 welcome voice broadcast switch
3		上移键 Up button	1、向上调速键 Increase speed button 2、参数内容区内，设定数值递增键 Increase the number within a parameter
4		下移键 Down button	1、向下调速键 Decrease speed button 2、参数内容区内，设定数值递减键 Decrease the number within a parameter
5		右移键 Right button	1、机头灯亮度调节 Control machine head LCD light brightness 2、面料切换 Material Switch 3、参数内容区内，向右选择参数项 Towards the right to choose parameter within a parameter
6		缝纫模式键 Sewing mode button	更改缝纫模式 Change the sewing mode
7		抬压脚功能键 Presser foot lifter function button	更改抬压脚模式 Change presser foot lifter mode
8		剪线参数设置键 Trimmer parameter setting button	更改剪线线头长短及剪线开关 Change the length of the thread and thread switch
9		复位键 Reset button	长按 2S 恢复出厂设置 Long press for 2 seconds restoring factory setting
10		吸风键 Suction button	吸风模式设置 Suction mode setting

1.2 液晶图标介绍 LCD icon introduction



序号 No.	图标 Icon	说明 Description	备注 Remark
1		全智能模式图标 Full smart mode icon	指示当前缝纫模式 Indicates the current sewing mode
2		半智能模式图标 Semi-smart mode icon	
3		全电脑模式图标 Full computer mode icon	
4		前感应器图标 Front sensor icon	指示当前感应器状态，图标点亮表示感应器被遮挡，未点亮表示传感器未遮挡 Indicates the current sensor status, the icon lights up to indicate that the sensor is blocked, and the unlit state indicates that the sensor is not blocked
5		后感应器图标 Rear sensor icon	
6		短线头感应器图标 Short thread sensor icon	
7		防切布感应器图标 Anti-cut cloth sensor icon	图标和字母 F 点亮表示前自动抬压脚功能开启 The icon lights up and F lights up to indicate that the front automatic presser foot function is turned on 图标和字母 B 点亮表示后自动抬压脚功能开启 The icon lights up and B lights up to indicate the back automatic presser foot function is turned on
8		抬压脚图标 Lifter icon	
9		剪线图标 Trimming line icon	图标, 与字母 F 点亮表示前自动前剪线功能开启 The icon lights up and the F lights up to indicate that the front automatic thread trimming function is turned on 图标表示与字母 B 点亮表示后自动剪线功能开启 The icon lights up and the B lights up to indicate the back automatic thread trimming function is turned on
10		吸风图标 Suction icon	图标点亮表示吸风功能开启 The icon lights up to indicate that the suction function is on
11		语音图标 Speech icon	图标点亮表示语音开启 Lights up to indicate voice on
12		油量图标 (预留) Oil quantity icon (Reserved)	图标点亮并闪烁表示当前无油，需添加白油 The icon lights up and flashes to indicate that there is no oil at present. White oil needs to be added
13		WiFi 联网图标 (选配) WiFi networking icon (Optional)	图标常亮表示联网正常，图标闪烁表示网络断开，不显示表示未联网 The icon is always on, indicating that the network is normal, the icon blinking indicates that the network is disconnected, and the non-display indicates that the network is not
14		牙齿档位图标 Tooth grade icon	预留 Reserve
15		第五、第六数码管 The fifth and sixth nixie tube	显示抬压脚电机相关参数或者感应器电压值 Display the relevant parameter of the lifting motor or the voltage value of the sensor

1.3 按键设置介绍 Button setting Instructions

长按P键 () 约1.5秒，将进入用户参数调整模式；通过左移键 (Language) 和右移键 (LED/Mesh) 修改参数项，按上移键 (Speed)

和下移键 () 修改相应参数的值, 按P键 () 确认并保存, 按左移键 () 或右移键 () 不保存并退到参数项设置界面, 再次按P键 () 退到待机界面。

Long press () for 1.5 seconds and machine will enter the user parameter adjustment mode. Press left button () and right button () to modify the parameter. Press up button () and down button () to modify the value of the corresponding parameter. Press enter button () to confirm and save, press left button () or right button () if user doesn't want to save and will return to the parameter setting interface. Press () again will return to standby interface.

2. 常用参数设置 Common parameters setting

2.1 全智能/半智能/全电脑模式设置 Automatic/Semi-automatic/Full manual mode settings

按下缝纫模式选择键 () 时, 即可修改缝纫模式; 连续按下此键时, 缝纫模式按以下三种模式循环: 全智能、半智能、全电脑。设置完后按P键 () 进行确认保存, 10S无按键则不保存退到待机界面。

Press sewing mode button (), sewing mode can be modified. Continuous press down this button, sewing mode will be cycled as following three modes: Automatic/ Semi-automatic/ Full manual. Press enter mode () to confirm and save after finishing setting, no pressing for 10 seconds return to standby interface if user doesn't want to save.

2.2 抬压脚模式的设置 Presser foot lifter mode setting

连续按下抬压脚模式调整键 () 时, 模式循环如以下几种: (抬压脚高度调节、抬压脚模式调节) 两个参数间切换, 在当前参数通过上键 () 或者下键 () 进入该参数值的调节, 在抬压脚高度调节的界面第五、第六数码管  显示压脚高度, 单位为毫米。设置完后按 P 键 () 进行确认保存, 10S 无按键则不保存退到待机界面。

Continuous press presser foot function button () to mode will be cycled as following modes: switch between two parameters of adjust foot height、adjust foot mode function, the current parameter enter the adjustment of the parameter value through the upper () or lower () key. When adjusting the lifting height, the fifth and sixth digital tubes show the height of the foot and feet in millimeters. Press enter button () to save and confirm after finishing setting, no pressing for 10 seconds return to standby interface if user doesn't want to save.

2.3 剪线参数的设置 Trimmer parameter setting

按下剪线参数设置键 (), P94 = 8时, 即可依次循环修改前剪线延迟针数和后剪线延迟针数参数。当P94 = 6或7时, 连续按此键时, 参数项循环如下: 剪线模式调节、前剪线长度调节、防切布感应器延迟针数、前感应器电压值调节、后感应器电压值调节、防切布感应器电压值调节。按上移键 () 和下移键 () 修改相应参数的值, 在感应器调节界面第五第六数码管  显示当前感应器的电压值, 设置完后按P键 () 进行确认保存 (前感应器电压值调节、后感应器电压值调节、防切布感应器电压值调节设置完后自动保存), 10S无按键则不保存退到待机界面。(每次按键先进入当前剪线状态, 按以上顺序循环)

Press trimmer parameter setting button () to modify parameter for trimmer status and the delay stitches number of trimmer before sewing or the delay stitches number of trimmer after sewing. Continuous press down this button, sewing mode will be cycled as followings: cut mode adjust、delay stitches number of trimmer before sewing、the delay stitches number of trimmer after sewing (the delay stitches number of sensor for anti-cutting the cloth)、front sensor voltage value adjustment、back sensor voltage value adjustment and anti fabric cutting sensor voltage value adjustment. Press up button () and down button () to modify the value of the corresponding parameter, when adjusting the sensor range, the fifth and sixth digital tubes show the sensor voltage feet in voltage enter button () to save and confirm after finishing setting (front sensor voltage value adjustment、back sensor voltage value adjustment and anti fabric cutting sensor voltage value adjustment, Save automatically after setting up),

no pressing for 10 seconds return to standby interface if user doesn't want to save (every press enter the current trimmer status firstly and cycled as below).

2.4 转速的修改 Modify speed

在待机界面按上移键 () 和下移键 () 可以快速调整最高转速值, 按上移键 () 递增 100 RPM, 按下移键 () 递减 100 RPM。设置完按 P 键 () 进行确认保存, 10S 无按键则不保存退到待机界面。

Press the up button () and down button () in standby interface can rapidly adjust the highest speed value. Press up button () increases 100 RPM while press down button () decreases 100 RPM. After finishing settings, press enter button () to save the parameter. If customer doesn't want to save, no pressing for 10 seconds back to standby interface if user doesn't want to save.

2.5 技术区参数的修改 Change technician parameter

按组合键P键 () + 抬压脚键 () 约1.5秒, 将进入技术员参数调整模式, 显示P26, 通过左移键 () 和右移键 () 修改参数项, 按上移键 () 和下移键 () 修改相应参数的值, 设置完按P键 () 进行确认保存, 10S 无按键则不保存退到待机界面。

Press button () and enter button () together for 1.5 seconds, the machine will enter the technician parameter adjustment mode and the panel will display P26. Press left button () and right button () to change the parameter. Press up button () and down button () to modify the value of corresponding parameter. Press enter button () to confirm and save, no pressing for 10 seconds back to standby interface if user doesn't want to save.

2.6 工艺区参数的修改 Change sewing process parameter

按组合键P键 () + 下移键 () 约1.5秒, 将进入工艺区参数调整模式, 显示U1, 通过左移键 () 和右移键 () 修改参数项, 按上移键 () 和下移键 () 修改相应参数的值, 设置完按P键 () 进行确认保存, 10S 无按键则不保存退到待机界面。

Press button () and enter button () together for 1.5 seconds, the machine will enter the sewing process parameter adjustment mode and the panel will display U1. Press left button () and right button () to change the parameter. Press up button () and down button () to modify the value of corresponding parameter. Press enter button () to confirm and save, no pressing for 10 seconds back to standby interface if user doesn't want to save.

2.7 恢复出厂设置 Restore factory setting

按复位键 () 约2秒参数将恢复用户保存参数, 参数范围为用户参数与技术员参数。按左移键 () 和右移键 () 约2秒, 恢复出厂参数、恢复关联参数。(P21 = 1时按P键保存一组用户常用参数, 复位键恢复用户保存参数, 未保存前出厂参数与用户保存区参数相同。P66/P67/P68转接板感应器强度参数、P73出厂默认转速参数、P90监控查看使能参数、P94/P95机型选择参数、P103强制电动抬压脚使能等不恢复出厂设置)。

Press reset button () for 2 seconds ,parameters will restore users saving parameters. Parameters range from uses parameter to technician parameter. Press left button () and right button () together for 2 seconds, parameter will restore factory parameters and associated parameters. When P21=1, P button for saving users common parameters, reset button for restoring users saving parameters, before saving, factory parameters are the same as users saving parameters. P66/P67/P68 adapter board duty cycle parameter, P73 Factory default speed parameter, P90 monitor view enable parameter, P94/P95 model selection parameter, etc. are not restored to factory settings).

2.8 语音种类设置 Voice Language Setting

按左移键 () 切换语音种类, 左键按下后, 播报当时所选的语音种类, 按 P 键 () 确定, 更改语音种类。长按

左移键 () 1.5s, 进行开机欢迎语音开关切换。

Press the left shift key () to switch the voice type. When the left button is pressed, the voice type selected at that time is broadcasted. Press the P key () to confirm and change the voice type. Long Press left shift key () for 1.5s, for welcome voice switch when start.

2.9 穿线灯开关的设置 LED light setting

穿线灯亮度分为六档, 在待机显示界面, 按右移键 () 穿线灯光亮度在6个档位间循环调节。(其中一个档位为关闭)

LED light is divided into six gears, on the standby interface ,press right button (), LCD light brightness will be cycled in six modes.(one is off)

2.10 按键锁定设置 Button lock setting

更改参数项P62为1时, 锁定按键后, 按键动作无响应。长按剪线参数设置键 () 约1.5秒解除锁定, 按键恢复使用。

When modifying parameter P62 to 1, button will be locked and no response. Long Press trimmer parameter () for 1.5 seconds will cancel the lock setting, press restore used.

2.11 面料选择 Fabric selection

待机界面下, 长按 LED 键 () 1.5s 以上, 进入面料选择设置, 并显示当前布料类型 (常规布料显示为 b0, 大网孔布料显示为 S, 网纱布料显示为 A), 短按 LED 键 () 进行 b0、S、A 切换, 短按 P 键 () 进行保存, 此时会重新自动校准感应器电压值, 显示 OK 表示选择成功。

In the standby interface, press and hold the LED button () for more than 1.5s to enter the fabric selection setting, and display the current fabric type (the normal fabric is displayed as b0, the big net hole fabric is displayed as S, the mesh fabric is displayed as A), short press the LED button () to switch between b0 / S / A, short press the P button () save it, the sensor voltage value will be automatically calibrated again, and OK will be displayed.

退出方式: 1、切换成功/失败后自动退出;2、10s 内无按键操作自动退回待机界面

Exit mode: 1. Automatically exit after successful/failed switch over;2, no button operation within 10s, automatically return to the standby interface

2.12 感应器自动校准 Sensor automatic calibration

长按 P 键 () + 左移键 () 约 1.5 秒便开始感应器自动校准, 校准结束后显示 OK 则说明识别成功, 否则识别失败。

Press and hold the P key () + left shift key () for about 1.5 seconds to start the sensor automatic calibration. When the calibration is finished, the OK is displayed, indicating that the recognition is successful, otherwise the recognition fails.

2.13 厚料电压阈值设定 Thick material voltage threshold setting

长按抬压脚键 () 约 1.5 秒进入厚料电压阈值设定界面, 显示压脚高度电压值, 若此时电机处于上停针, 则前踩一下脚踏, 电机自动运行至下停针, 调整压脚高度 (布料厚度), 长按 P 键 () 保存当前显示值到 U15 参数 (此数值即为厚料判断阈值), 成功显示 OK 且有语音提示 “厚料标准已设定成功”, 回到待机界面, 电机回到进入时的位置; 失败显示 Er。

识别过程中按 P 键 () 自动退出。

注: 当保存的值大于基值-50 时, 会导致保存失败。

基值重新设定方法: 将 P102 更改为 1, 确保压脚下无布料后, 长按抬压脚键 () 约 1.5 秒进入厚料电压阈值设定界面, 系统自动保存当前值为基值。

Press the presser foot lifter () for about 1.5 seconds to enter the thick material voltage threshold setting interface, display the presser foot height voltage value, if the motor is in the upper needle stop at this time, step on the foot pedal and the motor will automatically run to the lower needle stop ,adjust the presser foot height (cloth thickness), and press the P key () to save the current display value to the U15 parameter (this value is the thickness judgment threshold). The OK is successfully displayed and the

voice prompt "the thick material standard setting is successful" is returned. Standby interface, the motor returns to the position

when it entered; Failure display Er. Press P button () to exit automatically during recognition.

Note: When the saved value is greater than the base value - 50, the saved value will fail.

Based value reset method: Change P102 to 1, ensure that no cloth under the presser foot, press the presser foot button () for about 1.5 seconds to enter the thick material voltage threshold setting interface, and the system automatically saves the current value as the base value.

2.14 定期保养 Regular maintenance

当机器使用时间到达定期保养提醒时间后，面板会显示 A09/A10，并语音播报提示，10min 后再次播报提示且不再显示 A09/A10 直到下一个提醒时间到。可通过修改 P100/P101 的参数值设定提醒时间或关闭该提醒功能。

注：定期保养提醒过程中可正常缝纫。

When the machine use time arrives at the regular maintenance reminder time, the panel will display A09/A10, and voice broadcast prompt, 10 minutes later again broadcast prompt and no longer display A09/A10 until the next reminder time arrives. The alarm time can be set or the alarm function can be turned off by modifying the parameter values of P100/P101.

Note: Normal sewing can be done during regular maintenance reminder.

2.15 吸风参数设置 Suction parameter setting

短按吸风键 (), 即可修改剪线后吸气参数。按上移键 () 和下移键 () 修改相应参数的值, 设置完后按 P 键 () 进行确认保存, 10S无按键则不保存退到待机界面。

Short press Suction button () to modify parameter Inhale after thread cutting . Press up button () and down button () to modify the value of the corresponding parameter, short press the P button () to save it, no button operation within 10s, automatically return to the standby interface.

2.16 短线头模式快捷开关 Short thread mode quick switch

长按吸风键 () 1.5s, 进行前后短线头开关切换。

短线头模式开启时, 短线头感应器会自动关联开启, 且会重新自动校准感应器电压值, 显示 OK 表示选择自动校准成功。自动剪线补偿打开时, 剪线快捷键中的前剪线延迟针数 P27 更改为出厂针距 U25。

注意: 短线头模式开启时, 如果自动补偿针数无效, 则自动关闭短线头感应器。

Press the Suction button () for 1.5 seconds to switch the front and back short thread trimmer.

When the short thread mode is turned on, the Short thread sensor switch will be automatically turned on, and the sensor voltage value will be automatically calibrated again. The OK indicates that the selection of automatic calibration is successful. When automatic trimming compensation is opened, the number of delayed needles in the front trimming line P27 in the trimmer quick button is changed to the factory needle spacing U25.

Note: When the short thread mode is turned on, if the number of automatic compensating needles is invalid, the Short thread sensor will be automatically turned off.

2.17 物联网序列号设置和查看 Internet of Things serial number setting and viewing

短按 P 键 () + 上移键 () 进入研发参数密码输入界面, 输入密码后按 P 键确认, 进入研发参数界面, 通过右键 () 选择参数项 P116, 通过上移键 () 或下移键 () 将参数值改为 1, 短按 P 键保存, 面板进入物联网序列号设置/查看界面, 此时通过上移键 () 或下移键 () 可设置闪烁位的数值, 通过左键 () 或右键 () 可选择需要设置的位, 序列号长度为 11 位, 设置完成后, 可通过短按 P 键 () + 剪线键 () 保存, 如需放弃修改, 短按 P 键直接退出。

Short press P key () + up key () to enter the R&D parameter password input interface, press P key to confirm, enter the R&D parameter interface, select parameter item P116 by right key (), move up () or move down. The key () changes the parameter value to 1, short press the P key to save, the panel enters the IOT serial number setting/view interface. At this time, the value of the flashing bit can be set by the up key () or down key (). The key () or right button () can select the bit to

be set. The serial number length is 11 digits. After the setting is completed, you can save it by pressing the P key () + trimming key (). If you need to give up the modification, short press the P key. Exit directly.

2.18 断网报错查看 Broken network error report

当面板与物联网采集模块断开 1min 后，面板报错 A13，当采集模块与网关器断开，面板报错 A11，当网关器与服务器断开，面板报错 A12，此三个报错号不显示，可通过 M15 查看。
When the panel is disconnected from the IOT collector for 1 min, the panel reports A13. When the collector is disconnected from the gateway, the panel reports A11. When the gateway is disconnected from the server, the panel reports an error A12. The three error numbers are not displayed. View through M15.

2.19 快速绑定设备 Fast binding device

当需要将设备快速绑定到服务器上时，确认好物联网序列号并添加后，面板上操作上移键 () + 抬压脚键 ()，面板显示 OK，表示设定成功。此时设备可快速绑定到服务器上。
When you need to quickly bind the device to the server, after confirming the IOT serial number and adding it, operate the up key () + presser foot key () on the panel, and the panel displays OK, indicating that the setting is successful. The device can now be quickly bound to the server.

3. 数码管显示说明 Digital tube display instructions

(1) 数字部分: Digital part

实际数值 Actual numerical value	0	1	2	3	4	5	6	7	8	9
数码管显示 Digital tube display										

(2) 英文字母部分: English letter part:

英文字母 English alphabet	A	B	C	D	E	F	G	H	I	J
数码管显示 Digital tube display										
英文字母 English alphabet	K	L	M	N	O	P	Q	R	S	T
数码管显示 Digital tube display										
英文字母 English alphabet	U	V	W	X	Y	Z				
数码管显示 Digital tube display										

4. 参数列表 Parameters list

4.1. 操作参数说明表 Operating parameters Instructions

序号 No.	功能参数 Function parameter	范围 Range	默认值 Default	参数说明 Description
用户区: 按住“P”键 1.5 秒进入 User parameters: Press P button for 1.5seconds to enter				
P1	最高转速 Max rotate speed	500 - 7000	6000	RPM
P2	停针定位选择 Needle stop positioning selection	0 - 5	1	0: 不定位 No needle position 1: 上针位 Up needle position 2: 下针位 Down needle position 3: 下针位 Down needle position(rear tread will not to find up needle position) 4: 下针位(缝台上有无布后踩都可找上针); Down needle position(You can find a needle on the sewing table even if you step on it with or without fabric) 5: :下针位(停车时缝台上无布自动回到上针位); Down needle position(When parking, if there is no fabric on the sewing table, it will automatically return to the upper needle position)

P3	起缝速度 Start sewing speed	500 - 7000	5700(砍刀 Chopper) 4000(侧吸 Side suction)	RPM
P4	启动模式 Start up mode	0 - 1	0	0: 自动模式 Automatic mode 1: 脚控模式 Foot control
P5	模式选择 Sewing mode selection	0 - 2	1	0: 全电脑 Manual 1: 半智能 Semi-automatic 2: 全智能 full automatic
P6	语音音量调节 Voice volume adjustment	0 - 3	2 (TF 卡 T-flash card) 3 (FLASH 方案 Flash program)	0: 关闭 Off 1-3: 开启 On
P7	剪线模式调节 Trimming mode adjustment	0 - 3	3	0: 关闭 Off 1: 前剪 Trimmer before sewing 2: 后剪 Trimmer after sewing 3: 前后剪 Trimmer both before and after sewing
P8	自动后吸气 Automatic inhalation	0 - 3	1 (砍刀 Chopper) 3 (侧吸 Side draught)	0: 关闭 Off 1: 前剪线吸气开 Suction when trimmer before sewing 2: 后剪线吸气开 Suction when trimmer after sewing 3: 前后剪线吸气开 Suction when trimmer before and after sewing
P9	反踏剪线开关 Counter pedal trimmer	0 - 1	1	0: 关闭 Off 1: 开启 On
P10	抬压脚模式调节 Presser foot mode adjustment	0 - 3	0	0: 关闭 Off 1: 前抬 Lifter before sewing 2: 后抬 Lifter after sewing 3: 前后抬 Lifter both before and after sewing
P11	车缝中途停止时抬压脚 Press foot lifter when sewing stops	0 - 1	0	0: 关闭 Off 1: 抬压脚 Presser foot lifter
P12	剪完线停止时抬压脚 Press foot lifter after trimming	0 - 1	0	0: 关闭 Off 1: 抬压脚 Presser foot lifter
P13	半反踏抬压脚 Semi - counter presser foot lifter	0 - 1	1	0: 关闭 Off 1: 半反踏或反踏抬压脚 Semi-counter presser foot lifter
P14	手动吸气 Manual suction switch	0 - 2	2	0: 关闭 Off 1: 后吸 Rear suction 2: 前后吸 Front suction and rear suction
P15	机头灯开关 Head lamp switch	0 - 5	1	0: 关闭 Off 1-5: 开启 On
P16	休眠功能开关 Dormancy function	0 - 1	1	0: 关闭 Off 1: 开启 On
P17	半智能连续缝制 Semi - automatic constant rate trimming	0 - 2	2	0: 关闭 Off 1: 前踏可连续缝制 Front step continuous sewing 2: 连续缝纫, 忽略前感应器使能开关 Constant sewing and ignore the front sensor switch
P18	半智能恒速剪线 Semi - automatic constant rate trimming	0 - 1	1	0: 关闭 Off 1: 固定前剪线前运行速度 Fix the machine speed when front thread trimmer
P21	用户常用参数 User common parameters	0 - 1	0	0: 无操作 No operation 1: 保存参数为用户常用参数 Saving parameters into user common parameters
P22	前感应器开关 Front sensor switch	0 - 1	1	0: 关闭 Off 1: 开启 On
P23	前吸风打开时间 Opening time of manual suction	1 - 250	5	前吸风打开时间 (*100 ms) Opening time of manual suction
P24	吸风关闭时间 Turn off time of suction	0 - 250	0	前吸风关闭时间 (*100 ms) 0 表示无关闭 Time when front suction off, 0 means no shutdown
P25	后感应器开关 Back sensor switch	0 - 1	1	0: 关闭 Off 1: 开启 On
技术员区: 同时按住“P”键和“抬压脚”键进入 Technician parameter: Press P button and presser foot button at the same time to enter				
P26	前后感应器间针数 The stitch number between front sensor and back sensor	1 - 250	100	
P27	前剪线延迟针数 The delay stitches number of trimmer before sewing	0 - 50	1 (U22 = 0)	针数越大, 线头越短 The bigger of the value, the shorter of the thread length will be after cut
P28	后剪线延迟针数 Delay stitches number of anti - cutting the cloth	0 - 30	3	针数越小, 线头越短 The smaller of the value, the shorter of the thread length on the cloth will be
P29	前剪线吸风开启针数 Front trimming suction open thread number	1 - 50	1	电机运行后经过P29, 前剪线吸风开启 After the motor running to P29, front trimming suction opening

P30	前剪线吸风关闭针数 Front trimming suction close thread number	0 - 250	0 (砍刀 Chopper)	0: 前剪线吸风与前剪线同步关闭 其他: 前剪线吸风开启后经过P30针数关闭 0: Front trimming suction and front trimming synchronous closing Other: When after front trimming suction opening go by P30, thread number closing
			25 (侧吸 Side draught)	
P31	后剪线吸风关闭延时 Delay time after back suction off	1 - 50	15 (砍刀 Chopper)	(*100 ms)
			30 (侧吸 Side draught)	
P32	防切布感应器开关 Sensor for anti - cutting the cloth switch	0 - 1	1 (砍刀 Chopper)	0: 关闭 Off 1: 开启 On
			0 (侧吸 Side draught)	
P33	防切布感应器灵敏度Sensitivity of sensor for anti - cutting the cloth	200 - 400	330	灵敏度参数越大, 越能识别半透明材料 The bigger of the sensitivity parameter, the more capable to identify translucent materials
P34	后感应器与防切布感应器间针数 Stitch number between back sensor and sensor for anti-cutting the cloth	1 - 200	99	
P35	停车延迟针数 Delay stitch number when stop sewing	0 - 99	0 (砍刀 Chopper)	
			30 (侧吸 Side draught)	
P36	后剪线吸风开启针数 Back trimming suction open thread number	1 - 50	3	
P37	前感应器灵敏度 Sensitivity of front sensor	200 - 400	330	灵敏度参数越大, 越能识别半透明材料 The bigger of the sensitivity parameter, the more capable to identify translucent materials
P38	后感应器灵敏度 Sensitivity of back sensor	200 - 400	330	灵敏度参数越大, 越能识别半透明材料 The bigger of the sensitivity parameter, the more capable to identify translucent materials
P39	前抬压脚保持时间 Delay time before presser foot lifter	1 - 50	2	(*100ms)
P40	后抬压脚启动时间 Start time after presser foot lifter	0 - 20	0	(*100 ms)
P44	压脚保护时间 Time of presser foot protection	1 - 20	5	S
P45	剪线时间 Time of trimmer	1 - 100	10	
P46	连续送布吸气 Continuous feeding and suction	0 - 2	2	0: 关闭吸屑 Closed suction crumbs 1: 连续吸屑 Continuous suction crumbs 2: 吸屑与剪线吸气同步 Suction crumbs and trimming suction in sync
P47	手动剪线动作开关 Manual trimmer switch	0 - 2	1	0: 关闭 Off 1: 开启 On 2: 遮前感应器不能手动剪线 On
P48	开机自动找上定位 Automatically find up positioning	0 - 1	0	0: 关闭 Off 1: 开启 On
P50	防切布感应器延迟针数 The delay stitches number of trimmer after sewing	0-50	0	
P51	点针参数 Point needle parameter	0 - 511	87 (P122=1) 42 (P122=0)	大于 P111, 小于 P121-P123-25
P52	测试速度 Speed testing	500 - 7000	5500	RPM
P53	测试工作时间 Work time testing	1 - 60	3	S
P54	测试停止时间 Stop time testing	1 - 60	3	S
P55	A 项测试 Testing parameter A	0 - 3	0	0: 关闭 Off 1: 开启 On 2: 休眠 Dormancy 3: 只老化主轴和剪线 Only aging spindle and trimming
P56	B 项测试 Testing parameter B	0 - 1	0	0: 关闭 Off 1: 开启 On (老化抬压脚和剪线) Aging presser foot and trimming
P57	压脚保护开关 Presser foot safety switch	0 - 1	1	0: 关闭 Off 1: 开启 On
P58	缝台保护开关 Sewing plate safety switch	0 - 1	1	0: 关闭 Off 1: 开启 On

P59	针杆护罩保护开关 Needle bar cover safety switch	0 - 1	1	0: 关闭 Off 1: 开启 On
P61	休眠时间 Sleeping time	1 - 250	30	分钟 Unit: minutes
P62	面板按键锁定 Panel button lock	0 - 1	0	0: 不锁定 Unlock 1: 锁定 Lock (面板锁定后长按剪线键解除锁定)After the panel is locked, press and hold the trimming button to unlock it.
P63	降速开关 Slow down speed button	0 - 1	0	
P64	降速针数 Stitch number of slow down speed	1- 200	1	
P65	降速速度 The speed of slowing down	500 - 7000	3500	RPM
P66	前感应器电压值调节 Front sensor voltage value adjustment	1 - 180	80--	参数值越大, 感应器电压值越大 The greater the parameter values. The greater the voltage value of the sensor
P67	后感应器电压值调节 Back sensor voltage value adjustment	1 - 180	150--	参数值越大, 感应器电压值越大 The greater the parameter values, The greater the voltage value of the sensor
P68	防切布感应器电压值调节 Anti fabric cutting sensor voltage value adjustment	1 - 180	40--	参数值越大, 感应器电压值越大 The greater the parameter values, The greater the voltage value of the sensor
P69	计件数计数单位 Unit number counting	1 - 50	10	执行设置剪线次数, 计件数加 1 Execute the number of trimmings, the number of pieces is increased by one.
P70	计件数总数设定 Total counting setting	1-9999	100	
P71	计件数计数模式 Counting mode	0 - 5	0	0: 关闭; Off 1: 升序循环计数; Ascending cycle count 2: 降序循环计数; Descending cycle count 3: 升序计满报警; Ascending full alarm 4: 降序计满报警; Descending full alarm 5: 清除计满报警; Remove full alarm
P72	强制后剪线延迟针数 The stitches number of constraint back trimmer	0 - 20	9	布料前剪线后离开前、后感应器且未遮住防切布感应器经过设定针数后执行后剪线。Adjust the back trimmer function even the fabric does not cover the anti-cutting sensor, can adjust the stitches number before the trimmer function active
系统员参数 System member parameters				
P75	转接板报错使能 Adapter board error enable	0 - 1	1	0: 关闭; Off 1: 打开转接板检测功能; Open the adapter board detection function
P76	背光亮度调节参数 Backlight brightness adjustment parameter	1 - 3	3	
P78	显示模式 Display mode	0 - 4	0	0: 正常缝纫的模式和转向 Normal sewing mode and steering 1: 实时显示当前速度 Real-time display of current speed 2: 前感应器感应电压值 Front sensor induced voltage value 3: 后感应器感应电压值 Post sensor induced voltage value 4: 防切布感应器感应电压值 The third sensor induces a voltage value
P79	恢复出厂设置 Reset	0 - 1	0	0: 无操作; No operation 1: 恢复所有出厂参数; Restore all factory parameters;
P80	语言种类选择 Language type selection	0 - 11	0	0: 中文 1: 英文 2: 俄语 3: 阿语 4: 土语 5: 葡语 6: 西语 7: 印尼 8: 越南 9: 波兰语 10: 意大利语 11: 乌克兰语 0: Chinese 1: English 2: Russian 3: Arabic 4: Turkish 5: Portuguese 6: Spanish 7: Indonesia 8: Vietnam 9: Polish 10: Italian 11 Ukrainian
P81	同步吸气, 前吸屑关闭针数 Synchronous inspiratory, front suction crumbs close thread number	0 - 250	0	0: 前吸屑与前剪线吸气同步关闭 Front suction crumbs and front trimming inspiratory synchronous closing 其他: 前吸屑开启 P81 针数后关闭 When after front suction crumbs opening go by P18, thread number closing
P82	同步吸气, 后吸屑关闭针数 Synchronous inspiratory, back suction crumbs close thread number	0 - 250	0	0: 后吸屑与后剪线吸气同步关闭 Back suction crumbs and back trimming inspiratory synchronous closing 其他: 后吸屑开启 P82 针数后关闭 When after back suction crumbs opening go by P82, thread number closing
P83	前剪线松线电磁阀开启针数 Front trimming loose line solenoid valve open thread number	0 - 50	1	0: 前剪线松线电磁阀关闭 Front trimming loose line solenoid valve opening 其他: 前剪线松线电磁阀经(P83)-1 针数开启 Front trimming loose line solenoid valve go by (P83)-1 open thread number
P84	前剪线松线电磁阀关闭针数 Front trimming loose line solenoid valve close thread number	1 - 50	1	

P85	后剪线松线电磁阀开启针数 Back trimming loose line solenoid valve open thread number	0 - 50	12	0: 后剪线松线电磁阀关闭 Back trimming loose line solenoid valve closing 其他: 后剪线松线电磁阀经 P85 针数开启 Back trimming loose line solenoid valve go by P85 open thread number
P86	后剪线松线电磁阀关闭针数 Back trimming loose line solenoid valve close thread number	1 - 50	15	
P87	手动吸气持续时间 Duration time of manual suction	1 - 50	3	
P88	手动吸气电机转速 Speed of manual suction motor	500 - 7000	3500	
P89	点针功能使能 Enable One Pin	0 - 1	0	
P90	错误查看使能 Error viewing enable	0 - 1	0	
P91	薄料感应延时滤波延时针数 Thin material induction delay filter delay stitch	0 - 100	30	
P92	面料识别布料类型 Fabric identification fabric type	0 - 2	0	0: 常规布料模式 Normal fabric mode 1: 大网孔布料模式 Big net hole fabric mode 2: 网纱布料模式 Gauze fabric mode
P93	厚料感应延时滤波延时针数 Thick material induction delay filter delay stitch	0 - 100	0	
P94	机型选择 Model selection	6 - 8	6	6: 电动 Electric 7: 气动 Pneumatic 8: 侧吸 Side draught
P95	机型选择使能 Model selection enable	0 - 1	0	0: 不使能 Not enabled 1: 使能 Enabled
P96	三排的吸风模式 Three rows of suction mode	0 - 2	0	0: 前吸风与后吸风同步 1: 间歇吸风 (三排电磁阀) 2: 长吸风 (三排电磁阀) 0: The front suction is synchronized with the rear suction 1: Intermittent suction (three rows of solenoid valves) 2: Long suction (three rows of solenoid valves)
P97	间歇吸风开启针数 Intermittent suction opening number	1 - 100	50	
P98	间歇吸风关闭延时时间 Intermittent suction closing delay time	1 - 25	5	单位: 100ms Unit: 100ms
P100	定期清洁提醒时间 Regular cleaning reminder time	0 - 9999	60	0: 不使能 Not enabled 单位: 小时 Unit: hour
P101	定期更换白油提醒时间 Regularly change the white oil reminder time	0 - 500	6	0: 不使能 Not enabled 单位: 月 Unit: Month
P102	获取厚料基值使能 Get thick material base value enable	0 - 1	0	
P103	强制电动抬压脚使能 Force electric presser foot lift enable	0 - 1	0	
P107	抬压脚电机初始角 Foot motor first position angle	1 - 360	38	
P109	脚踏板半后踏电压值 Pedal half-back step voltage value	12-511	127 (P122=1) 和 99 (P122=0)	该参数小于 P123-25 (P122=0) 或 P123-33 (P122=1), 大于 12
P110	脚踏板全后踏电压值 Pedal back step voltage value	11-511	38 (P122=1) 和 55 (P122=0)	该参数小于 P109
P111	踏板前踩运行开始位置 (相对于回中位置) Step forward in running position	3-511	43 (P122=1) 和 30 (P122=0)	该参数小于 P51
P112	前剪线吸风中途停车吸风使能 Front cut line suction midway stop enable	0 - 1	0	
P116	物联网序列号设置使能 IOT serial number setting enable	0 - 1	0	接入物联网模块时, 此参数有效 This parameter is valid when accessing the Internet of Things module
P117	后剪线吸风加速速度 Acceleration speed of rear trimming suction	0-1000	0	RPM
P118	左右恢复内部限速使能 Restore internal speed limit enable	0 - 1	0	-

	left and right			
P119	剪线延迟针数 Number of stitches for thread trimming delay	0 - 9999	0	
P120	最低转速 Min rotate speed	200 - 500	300	单位: RPM Unit: RPM
P121	踏板最大速度位置 Pedal maximum speed voltage value	0-511	380 (P122=1) 和 320 (P122=0)	大于(P123+ P51+25)
P122	脚踏类型选择 Pedal selection	0-1	1	0: 包缝调速器 Overlock sewing pedal 1: 平缝调速器 Lockstitch sewing pedal
P123	脚踏回中电压值 Setting of reference value in pedal return	0-511	182 (P122=1) 和 175 (P122=0)	大于 P109+25(P122=0)或大于 P109+33(P122=1), 小于 P121-P51-25
工艺参数 (P+下键)				
U1	踏板报警检测使能 Pedal alarm detection enable	0-1	0	0-开启报警 Open alarm 1-关闭报警 Close alarm
U3	后剪线电机状态延时 delay motor status of trimmer after sewing	0-100	3	
U15	厚度检测零位阈值 Thickness detection zero position threshold	100 - 500	300	单位: 0.01V Unit:0.01V
U17	过梗后提速时间 Speed-up time after bone cross sewing	1 - 50	5	单位: 100ms Unit:100ms U20=2 时, 厚料降速后开始计时, U17*100ms 后提速 (如果是薄料, 则立即提速) When U20 = 2, the timing begins after the heavy material decelerates, and increases after U17 * 100ms (if it is thin material, it increases immediately).
U18	过梗降速速度 bone-cross decelerating speed	500 - 7000	5000	单位: RPM Unit:RPM
U19	薄厚料切换速度增量 Increment of switching speed for thin and thick materials	1 - 100	10	1RPM/ms 从厚料变为薄料时, 速度以 U19 的幅度从降速速度提速到正常速度 When changing from thick material to thin material, the speed increases from decreasing speed to normal speed in the range of U19.
U20	过梗降速开关 Switching speed reduction after bone cross sewing	0 - 2	0	0: 关闭; Close 1: 过厚降速模式; Thick material deceleration mode 2: 过梗降速模式; Bone cross slowdown speed mode
U21	短线头感应器灵敏度 Short thread sensor sensitivity	200 - 400	330	单位: 0.01V Unit:0.01V
U22	短线头感应器使能参数 Short thread sensor enabling parameter	0 - 1	1	
U24	剪线补偿功能使能参数 Compensation function of trimming enabling parameter	0 - 1	1	
U25	出厂针距设定 Out-of-factory Needle gauge setting	10 - 60	44	单位: 0.1mm Unit:0.1mm 使用手动设定针距 Use manual setting of needle gauge
U26	自动补偿面料类型选择 Selection of automatic compensation fabric types	0 - 2	0	0: 针织短线头模式 knitting short thread trimmer mode 1: 梭织短线头模式 woven short thread trimmer mode 2: 大针距短线头模式 large gauge short thread trimmer mode
U33	抬压脚高度调节 Presser foot height adjustment	1 - 20	20	档 Gear
U34	微抬高度调节 Slight Foot height	1 - 11	5	档 Gear
U35	抬压脚伺服零位角度	0-360	345	
U37	薄厚档位切换提醒开关 Thin and thick gear switch reminder switch	0 - 1	0	0: 关闭 Off 1: 开启 On
U40	特殊松线功能使能 Special release function enable	0 - 1	1	
U41	遮前不停车使能 No stop enable before cover	0 - 1	1	
U42	缓放压脚档位 Slowly release the presser foot gear	0 - 9	3	
U43	空缝降噪模式 Switch for noise reduction in front of sewing	0-2	0	0: 关闭 Off 2: 空缝压脚微抬 The pressure foot of the empty seam is slightly lifted
U47	空缝降噪延迟针数 Noise reduction delay needle	0 - 100	0	
U49	压脚保护开关损坏强制抬压脚 Presser foot safety switch damaged	0 - 2	1	0: 抬压脚时检测压脚安全开关状态 1: 抬压脚时不检测压脚安全开关状态 2: 电控不检测抬压脚电机状态

	and force presser foot lift			
U70	抬压脚最大高度补偿角度 Maximum height compensation angle for presser feet)	60 - 130	128	单位: 1 度 Unit:1 degree
U74	停机欠压报警使能 Enable the shutdown under voltage alarm	0 - 1	0	0: 关闭 Close 1: 开启 Open
U75	停机过压报警使能 Enable overvoltage alarm for shutdown	0 - 1	1	0: 关闭 Close 1: 开启 Open
U80	伺服剪线角度 Servo line cutting Angle	0 - 179	81	单位: 1 度 Unit:1 degree
U84	伺服剪线速度 Servo line cutting Speed	700-1200	1150	RPM
U85	开机自动校准 Automatic startup calibration	0 - 1	1	0: 关闭 Close 1: 开启 Open
U87	抬压脚高度限制使能 Enable not downwards height restriction for presser feet	0 - 1	1	0: 关闭 Close 1: 开启 Open
U89	控制下供时剪线角度 Control the cutting angle during supply	0-360	80	单位: 1 度 Unit:1 degree
U91	抬压脚电机速度 Foot motor Speed	600 - 1000	900	RPM
U92	下停针偏移 Lower needle stop position deflection	0 - 4	0	
U93	上停针角度微调 Up needle stop position angle adjustment	0,30 - 70	22	0: 关闭该功能
U94	转接板通讯开关 Enable the adapter board communication	0 - 1	1	0: 串口通讯 Normal serial communication 1: 高速串口通讯 High-speed serial communication
U95	面板灯带显示 Enable panel LED	0 - 1	1	0: 关闭 Close 1: 开启 Open
U96	主轴电机缺相检测开关 Spindle motor phase loss detection switch	0-1	0	
U101	中料阈值差值 Medium thick makings threshold	0 - 500	40	单位: 0.01V Unit:0.01V (最大值小于 U102 当前值)
U102	厚料阈值差值 Thick makings threshold	0- 500	80	单位: 0.01V Unit:0.01V (大于 U101 当前值, 小于 U15)
U103	抬压脚电机缺相检测开关 Pressure foot lifting motor phase loss detection switch	0-1	0	

4.2. 监控参数 Monitoring parameters

P+右键进入监控界面,左右键调节监控参数项, 按 P 键进入当前监控参数值。在监控 M00 项时按 P 键退出监控模式。

P+ right button enters the monitoring interface, left and right keys adjust the monitoring parameter item, press P key to enter the current monitoring parameter value. Press the P key to exit the monitor mode while monitoring the M00 item.

序号	内容	序号	内容
M0	退出监控模式 Exit monitor mode	M14	母线电压值 Bus voltage value
M1	当前件数 Current piece count	M15	物联网联网状态 IOT networking status
M2	机型类型 Model type	M16	程序识别号 Software number
M3	Q 轴电流 Q axis current	M17	转接板软件版本号 Adapter board software version number
M4	交流输入电压 AC input voltage	M18	主轴电机控制软件版本号 Main motor control software version number
M5	踏板电压值 Pedal voltage value	M19	工艺控制软件版本号 Craft control software version number
M7	前感应器电压值 Front sensor voltage value	M20	面板软件版本号 Panel software version number
M8	中感应器电压值 Medium sensor voltage value	M21	抬压脚电机控制软件版本号 Presser foot motor control software version number
M9	后感应器电压值 Post sensor voltage value	M22	老化 15 分钟完成标志 Complete the aging mark in 15 minutes 百位——厚料机型查看, 普通-0, 厚料-1 Hundreds digit --thick material models, normal models-0,thick material models-1
M10	实时速度值 Real-time speed value	M32	厚度检测电压值 Voltage value of thickness measurement
M11	物联网缝纫机工作状态 Working status of IoT sewing machines	M33	短线头感应器电压值 Voltage value of Short thread sensor
M12	防干扰中感应器电压值 (保留) Anti-interference sensor voltage value (reserved)	M34	抬压脚电机角度值 Presser foot motor angle value
M13	防干扰后感应器电压值 (保留) Anti-interference	M35	抬压脚电机电流 Presser foot lifter motor current

	sensor voltage value (reserved)		
M36	面板版本日期 Panel Version Date	M37	电控版本日期 Electric control version date
M38	主轴运行时最大电流 Maximum current during spindle operation	M39	抬压脚电机角度 Electric angle of the presser foot motor

备注 1: (0-普通缝纫机状态; 1-物联网分期状态; 2-物联网锁机状态; 3-物联网锁机线速) IOT sewing machine working status (0-normal sewing machine status; 1 - Internet of Things staging status; 2 - Internet of Things lock machine status; 3 - Internet of Things lock line speed)

5. 错误码说明表 Error code description table

机器出错报警时，语音播报当前故障，如面板显示 E03 时，语音播报“操作面板与控制器箱通讯异常”，按下左移键（ 语音 Language）播报故障原因及解决办法“请检查操作面板和控制箱连接线是否松动；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或拨打 4008876858”。在播报时按下 P 键（）或语音键将停止当前播报内容。（故障恢复，语音停止播报）

When the machine error alarm occurs, the voice broadcasts the current fault. If the panel displays E03, the voice broadcast “Operation panel and controller box communication is abnormal”, press the left button ( Language) to broadcast the fault cause and solution “Please check the operation panel and control box. Whether the cable is loose; please try to restore the factory settings or restart the power; if you still can't solve the above, please contact your local service provider or call 4008876858. Pressing the P key () or voice button during the broadcast will stop the current broadcast content. (failure recovery, voice stop broadcast)

序号 NO	内容(故障时播报)Content(when there is a failure, broadcast)	对策（按下语音导航键播报）Countermeasure (press the voice navigation button broadcast)
E1	主轴电机堵转 Main motor stall	请检查机头是否卡死或者转动困难；请检查电机插头、电机感应器接头是否松动或脱落；上述如仍无法解决请联系当地服务商或拨打 400887685。Please check if the machine head is stuck or difficult to turn; Please check if the motor plug and motor sensor connector are loose or loose; If you still can't solve the above, please contact your local service provider or call 4008876858.
E2	主轴电机软件过流 Main motor software over current	请检查使用电压是否正常；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check if the voltage used is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 4008876858.
E3	操作面板与控制箱通讯异常 The operation panel and the control box communicate abnormally	请检查操作面板和控制箱连接线是否松动；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please turn off the system power, check if the motor Hall signal connector is loose or disconnected, return it to normal and restart the system. If you still can't solve the above, please contact your local service provider or call 4008876858.
E4	主轴电机霍尔错误 Motor Hall error	请关闭系统电源，检查电机霍尔信号接头是否松动或脱落，将其恢复正常后重启系统。上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check if the operation panel and control box cable are loose; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 4008876858.
E5	停针信号异常 Abnormal needle stop signal	请关闭系统电源，检查电机停针信号接头是否松动或脱落，将其恢复正常后重启系统。上述如仍无法解决请联系当地服务商或拨打 4008876858。Please turn off the system power, check if the motor stop signal connector is loose or fall off, return it to normal and restart the system. If you still can't solve the above, please contact your local service provider or call 4008876858.
E6	压脚保护功能开启 Presser foot protection is on	请检查压脚是否推回到正确位置；仍无法解决需要临时使用请将 P57 项参数里的 1 改为 0；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check if the presser foot is pushed back to the correct position; Still can not solve the need to temporarily use, please change the 1 in the P57 parameter to 0; If you still can't solve the above, please contact your local service provider or call 4008876858.
E7	缝台保护功能开启 Slot protection function is on	请检查缝台是否推回到正确位置；仍无法解决需要临时使用请将 P58 项参数里的 1 改为 0；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check if the sewing table is pushed back to the correct position; Still can not solve the need for temporary use, please change the 1 in the P58 parameter to 0; if the above still can not be resolved, please contact the local service provider or call 4008876858.
E8	针杆护罩保护功能开启 Needle bar shield protection function is on	请检查针杆护罩是否放回到正确位置；仍无法解决需要临时使用请将 P59 项参数里的 1 改为 0；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check that the needle bar guard is placed back in the correct position; If you still can't solve the problem, please change the 1 in the P59 parameter to 0. If you still can't solve the problem, please contact your local service provider or call 4008876858.
E9	脚踏板连接异常 Abnormal foot pedal connection	请检查脚踏板插头是否连接控制箱或者松动；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check if the pedal plug is connected to the control box or loose; If you still can't solve the above, please contact your local service provider or call 4008876858.
E10	主轴电机硬件过流 Main motor hardware overcurrent	请检查供电电压是否正常；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check if the power supply voltage is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 4008876858.

		4008876858.
E11	主轴电机停机时过压 Main motor overpressure during shutdown	请检查供电电压是否正常；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check if the power supply voltage is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 4008876858.
E12	主轴电机系统欠电压 Main motor system under voltage	请检查供电电压是否正常；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check if the power supply voltage is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 4008876858.
E13	主轴电机制动回路异常 Main motor abnormal brake circuit	请联系当地服务商或拨打 4008876858。Please contact your local service provider or call 4008876858.
E14	参数读写异常 Parameter read and write exception	请尝试关闭电源重启如仍无法解决请联系当地服务商或拨打 4008876858。Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 4008876858.
E19	主轴电机电流检测回路异常 Main motor current detection loop is abnormal	请尝试关闭电源重启如仍无法解决请联系当地服务商或拨打 4008876858。Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 4008876858.
E20	电源关闭 Power off	
E21	主轴电机或 IGBT 缺相 Lack of phase In Main motor or IGBT	请检主轴电机动力线是否缺相、电控硬件驱动回路是否异常；请尝试关闭电源重启如仍无法解决请联系当地服务商或拨打 4008876858；Please check if the power line of the spindle motor is out of phase and if the electronic control hardware drive circuit is abnormal; Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 4008876858.
E24	语音芯片工作异常 The voice chip works abnormally.	请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 4008876858.
E26	转接板与控制器通讯异常 The adapter board communicates abnormally with the controller.	请检查转接板与控制器连接线是否松动；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check if the connection between the adapter plate and the control box is loose; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 4008876858.
E27	恢复出厂设置错误 Factory reset error	关机重启后，重新恢复出厂设置。After the shutdown is restarted, the factory settings are restored.
E31	抬压脚电机软件过流 Foot motor soft overcurrent	请检查使用电压是否正常；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check if the voltage used is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 4008876858.
E32	抬压脚电机电流检测回路异常 Foot motor current detection loop is abnormal	请尝试关闭电源重启如仍无法解决请联系当地服务商或拨打 4008876858。Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 4008876858.
E33	抬压脚电机堵转 Foot Motor stall	请检查机头是否卡死或者转动困难；请检查电机插头、电机编码器接头是否松动或脱落；上述如仍无法解决请联系当地服务商或拨打 400887685。Please check if the machine head is stuck or difficult to turn; Please check if the motor plug and motor encoder connector are loose or loose; If you still can't solve the above, please contact your local service provider or call 4008876858.
E34	抬压脚电机动力线或编码器信号故障 Foot Motor of Encoder signal abnormally	请检查电机插头、电机编码器接头是否松动或脱落；上述如仍无法解决请联系当地服务商或拨打 400887685。Please check if the motor plug and motor encoder connector are loose or loose; If you still can't solve the above, please contact your local service provider or call 4008876858.
E35	抬压脚电机找初始位置故障 Foot motor find first position abnormally	请检查机头是否卡死或者转动困难；请检查电机插头、电机编码器接头是否松动或脱落；上述如仍无法解决请联系当地服务商或拨打 400887685。Please check if the machine head is stuck or difficult to turn; Please check if the motor plug and motor encoder connector are loose or loose; If you still can't solve the above, please contact your local service provider or call 4008876858.
E36	抬压脚电机硬件过流 Foot motor hard overcurrent	请检查供电电压是否正常；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或拨打 4008876858。Please check if the power supply voltage is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 4008876858.
E37	抬压脚电机超速 Foot motor is overspeeding	请检查编码器光栅是否有灰尘或损坏；请尝试关闭电源重启如仍无法解决请联系当地服务商或拨打 4008876858；Please check if the encoder grating is dusty or damaged; Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 4008876858.
E38	抬压脚电机或 IGBT 缺相 Lack of phase In foot motor or IGBT	请检抬压脚电机动力线是否缺相、电控硬件驱动回路是否异常；请尝试关闭电源重启如仍无法解决请联系当地服务商或拨打 4008876858；Please check if the power line of the foot motor is out of phase and if the electronic control hardware drive circuit is abnormal; Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 4008876858.
E40	抬压脚电机过载 Foot motor is overloaded	请检测抬压脚电机编码器是否有松动或者未插牢固；请尝试关闭电源重启如仍无法解决请联系当地服务商或拨打 4008876858；Please check if the encoder of the presser foot motor is loose or not securely inserted; Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 4008876858.
E41	抬压脚电机位置偏差计数器溢出 foot motor position deviation counter is overflowing	请检测抬压脚电机编码器光栅是否有灰尘、编码器是否故障或负载较大；请尝试关闭电源重启如仍无法解决请联系当地服务商或拨打 4008876858；Please check if there is dust on the encoder grating of

		the presser foot motor, if the encoder is faulty, or if the load is too high ; Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 4008876858.
E43	抬压脚电机超速 Foot motor is overspeeding	请检查编码器光栅是否有灰尘或损坏；请尝试关闭电源重启如仍无法解决请联系当地服务商或拨打 4008876858； Please check if the encoder grating is dusty or damaged； Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 4008876858.
E57	转接板高速串口通讯故障 High speed serial communication failure of the adapter board	请检查转接板与控制箱连接线是否松动，或设置 U94 项参数为 0；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或拨打 4008876858。 Please check if the connection between the adapter plate and the control box is loose, or set the U94 parameter to 0.; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 4008876858.
EA1	计件数升序计数满 Counting counts in ascending order	按 P 键清除，或设置 P71 项参数为 5。 Press the P key to clear, or set the P71 parameter to 5.
EA2	计件数降序计数满 Counting counts in descending order	按 P 键清除，或设置 P71 项参数为 5。 Press the P key to clear, or set the P71 parameter to 5.

 **注意：**当系统报 E06（压脚安全保护）时，在压脚放到正确位置后，在缝纫模式为 A 模式时，按 P 键（）清除 E06 错误。

Note: When the system reports E06 (presser foot protection), after the presser foot is placed in the correct position, When sewing mode is A mode, press the P key () to clear the E06 error.

注：计件数计数满，暂无对应语音，报错时播报“预留”。

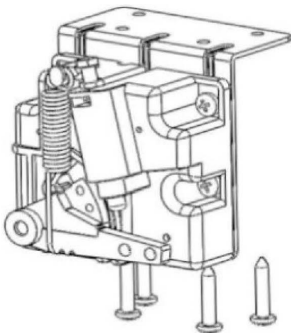
Note: The count of the number of pieces is full, there is no corresponding voice, and the message is “reserved” when the error is reported.

6. 警告码说明表 Warning code description table

序号 Serial number	内容 Content	对策 Countermeasures
A-01	前感应器自动校准失败 Front sensor auto calibration failed	检测前感应器的接收和发送器表面是否干净 Receive sensor and transmitter surface before inspection
A-02	中感应器自动校准失败 Mid-sensor automatic calibration failed	检测后感应器的接收和发送器表面是否干净 The sensor's receiver and transmitter surface are clean during inspection
A-03	后感应器自动校准失败 After the sensor auto calibration failed	检测后感应器的接收和发送器表面是否干净 After receiving the sensor, the receiver and transmitter surface are clean.
A-04	自动校准超时 Automatic calibration timeout	检测三个感应器接收和发送器表面是否干净 Detect three sensor receiver and transmitter surfaces are clean
A-08	面板和电控机型不匹配 Panel and electronic control models do not match	将电控与面板程序升级为匹配的程序 Upgrade electronic control and panel programs to matching programs
A-09	白油定期保养警告 White grease regular maintenance warning	
A-10	定期清洁警告 Regular cleaning warning	
A-11	采集模块与网关断开 The acquisition module is disconnected from the gateway	
A-12	网关与服务器断开 The gateway is disconnected from the server	请检测网关的联网情况 Please check the gateway's networking situation.
A-13	面板和采集模块断开 Panel and collector disconnected	请检测面板与采集模块连接是否正常 Please check if the connection between the panel and the collector is normal.
A-14	无油警告 Oil free warning	请检测缝纫机油量 Please check the oil of sewing machine
A-21	普通/厚料切换提醒 Normal/Thickness switch warning	

7. 调速器 Speed controller

将调速器（件 1）按 下图所示的方向，使用 4 颗 ST4.8 自攻螺钉（件 2）将调速器安装到台板下方合适的位置。
 Use four pieces ST4.8tapping screw(Part No.2)to install the above speed controller under the stand & table to the right position.



序号 No.	名称 Parts description	数量 pcs
1	调速器 Speed controller	1
2	十字槽盘头自攻螺钉 ST4.8*22 Tapping Screw ST4.8*22	4