

# 使用说明书

User Guide

工业绷缝机

Industrial seaming machine

**NEW!**

感谢您购买本公司的产品。

为了您的使用安全，请您在使用之前一定仔细阅读本使用说明书。

请您保管本使用说明书，以便随时查阅。

**Thank you for purchasing our products.**

**For your use safety, please must read the instruction manual before use.**

**Please keep this instruction manual for easy reference.**

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# 用户操作手册

本操作指南的用途：

本操作指南基于用户的要求提供相关指导信息；  
本操作指南主要面向用户和技术人员。

- 使用本机器前以下要求说明请注意：
  1. 用户使用作业前必须**可靠接地**，保证人身安全！
  2. 非专业人士请勿拆卸控制箱；
  3. 请在室温 5℃ 到 45℃ 之间的场所使用；
  4. 请在 30%~90% 相对潮湿环境中作业；
  5. 额定电压 220V $\pm$ 10%，额定频率 50/60HZ；110V 电控：额定电压 110V $\pm$ 10%，频率 50/60HZ；请根据对应型号输入相应电压。
  
- 安全须知：
  1. 电机接通时请不要把脚放在脚踏板上；
  2. 本产品请专业人士安装调试；
  3. 严禁在通电时打开控制箱；
  4. 换针，穿线或更换底线时请关闭电源；
  5. 安装，拆卸维修时请关闭电源；
  6. 翻抬缝纫机时请关闭电源；
  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。
  
- 保修策略：
  1. 未经本公司同意自行拆卸，改装造成损坏将不给予保修；
  2. 若出现无法解决的问题可以联系本公司；
  3. 本公司对此说明书有最终解释权。

## 操作面板说明

图标	功能说明
	1: 工作模式下, 切换上、下停针位; 2: 参数模式下, 作参数设置。
	1: 工作模式下, 开关 LED 灯; 2: 参数模式下, 作参数保存。
	1: 工作模式下, 调节电机转速; 2: 参数模式下, 作参数的选择及调整。
	

### ●参数调整及示例

1.1 控制器操作面板显示方式为四位共阴数码管。

待机界面下, 按“+”、“-”键, 可以调节即时转速。

1.2 待机界面下, 按“P”键, 上针位指示灯亮时, 为上停针; 下停针指示灯亮时, 为下停针; 指示灯不亮, 关闭停针功能。

1.3 待机界面下, 按“S”键, 可以打开和关闭机头灯。

1.4 进入及修改系统参数:

- ① 先按住“P”键不放, 再按“+”键, 进入参数模式, 此时数码管显示“P-00”;
- ② 按“+”、“-”键可切换参数号;
- ③ 选择好参数后, 按“P”键进入参数, 使用“+”、“-”键修改参数值;
- ④ 修改完毕后, 按“S”键保存退出。

### 1.5 停针后抬压脚开关设置:

- ① 先按住“P”键不放，再按“+”键，进入参数模式，此时数码管显示“P-00”；
- ② 按“+”键切换参数号至“P-20”；
- ③ 选择好参数号后，按“P”键进入参数，使用“+”、“-”键修改参数值；
- ④ 修改完毕后，按“S”键保存退出。

### 1.6 恢复出厂设置:

- ① 先按住“P”键不放，再按“+”键，进入参数模式，此时数码管显示“P-00”；
- ② 长按“S”键3秒，即可恢复出厂设置。

## ● 错误代码及参数表

附表 1: 错误代码显示

错误代码	代表含义	可能出现的问题
Er00	上电保护	①上电初始化过程中脚踏处于加速状态
Er01	停针错误	①电机霍尔坏 ②手轮磁铁脱落 ③停车信号线接触不良或损坏
Er02	检测不到脚踏信号	①脚踏信号线接触不良或损坏 ②脚踏控制器型号不对
Er03	电机霍尔或相位错误	①电机信号线接触不良或损坏 ②电机霍尔坏
Er04	堵转保护	①电机过载 ②电机电源线接触不良
Er05	硬件过流	①电机过载 ②电机信号线接触不良
Er06	抬压脚电磁铁过流	①检查电磁铁是否损坏②主板损坏
Er07	串口通讯错误	①操控盒连接线接触不良或损坏
Er08	工作环境不佳	①周围有强磁场干扰②4P 通讯线接触不良

附表 2：用户参数内容详解

序号	名称	参数范围	出厂值	功能
P-01	最高转速锁定	200~5500	4000	
P-02	电机正反转设置	0~1	1	0 代表反转，1 代表正转
P-03	下停角度	0~23	12	基于上停针位置 180°
P-04	起缝速度	200~800	250	250 转
P-05	加速快慢	1~20	20	值越大加速越快
P-06	定针缝	0~999	0	0:表示关闭
P-07	电机功率	50~1000	170	550W
P-08	下停找上停功能	0~1	1	0: 关闭 1: 打开
P-10	自动跑合测试	0~1	0	该参数改为“1”时自动跑合，设置为“0”或关闭电源，跑合停止
P-11	停机区	185~285	235	
P-12	加速区	710~810	760	
P-14	最大加速电流	50~1000	300	
P-19	抬压脚开关	0~1	1	0: 关闭 1: 打开
P-20	停针后抬压脚开关	0~1	0	0: 关闭 1: 打开
P-21	电磁铁吸合时间	1~60	3	单位/秒 (S)
P-22	电磁铁全额时间	10~1000MS	350	压脚全功率工作时的时间
P-23	抬压脚保持功率	20~50%	30	压脚抬起后维持住后的功率
P-24	抬压脚下放功率	0~25%	15	抬压脚软放下功能

# User manual





The use of this operation guide:

This operation guide provides guidance information based on the requirements of the user.

This operation guide is mainly for users and technicians.

- Please Take Note The Following Requirements Before Using This Machine:
  1. Users must be reliably grounded before using the operation to ensure the safety of the person.
  2. Non professional persons do not disassemble the control box;
  3. At room temperature from 5 to 45 degrees C;
  4. Please work in 30%~90% relatively humid environment.
  5. The rated voltage is  $220V \pm 10\%$ , and the rated frequency is 50/60HZ.  
110V electronic control: Rated voltage  $110V \pm 10\%$ , frequency 50/60HZ.  
Please enter the proper voltage according to the matched model.
  
- Safety Notice:
  1. When the motor is connected, please do not put your foot on the foot pedal.
  2. This product will be installed and debugged by the professional.
  3. It is strictly prohibited to open the control box at the time of electricity.
  4. Change the needle, wear line or replace the bottom line, please turn off the power supply.
  5. Installation, when dismantling maintenance, please turn off the power supply.
  6. Turn off the power supply when you turn up the sewing machine.
  7. Use this product to keep away from high frequency electromagnetic wave and radio wave launcher, so as to prevent the electromagnetic wave from disturbing the servo drive.
  
- Warranty Strategy:
  1. without the consent of the company, the damage will not be given to the warranty.
  2. if there is a problem that can not be solved, we can contact our company.
  3. the company has the final explanation right to this instruction.

## ● Operation panel description

Icon	Function
	1:Working model,switch the up-down needle position. 2:Parameter model: setting the parameter.
	1:Working model:switch the LED light. 2:Parameter model,save the parameter.
	1:Working model,adjust the motor speed. 2:Parameter model ,choice and adjust for parameter.
	

## ● Parameter adjusting and example

1. 1 The panel is four digital Nixie Tube display

Adjust the speed by press the “+” 、 “-” key when in standby interface

1. 2 In standby interface ,press the “P” key ,when the up needle position indicator light is on ,it is on up needle stop , when the down needle position indicator light is on , it is on down position stop, when the indicator light is off ,the needle position function turn off.

1. 3 In standby interface , press the “S” key , can turn on/off the machine head light.

1. 4 Enter in and change the system parameter: :

⑤ When the power is on ,press the “P” key for some seconds ,then press the “+” key , it enters into the parameter mode. The Nixie Tube shows “P-00” ;

⑥ Press the “+” 、 “-” key ,can change the parameter

⑦ After choose the parameter , press the“P”key ,enter into the parameter ,then can change

the value of the parameter by “+” 、 “-” key;

- ⑧ Press the “S” key save the value

1.5 After the needle to stop the foot switch setting :

⑤ First, hold down the "P" key, and then press the "+" key to enter the parameter mode, and the digital tube displays "P-00" at this time.

- ⑥ Switch the parameter number to "P-20" according to the "+" key.

⑦ After selecting the parameter number, the parameter is entered according to the "P" key, and the parameter value is modified with the "+" and "-" keys.

- ⑧ After the modification, press the "S" key to save and exit.

1.5 Reset:

③ When the power is on ,press the “P” key for some seconds ,then press the “+” key , it enters into the parameter mode. The Nixie Tube shows “P-00”

- ④ Press the “S” key for three seconds to reset.

## ● Error code and parameter

**List 1: Error Code**

<b>Error Code</b>	<b>Representative Meaning</b>	<b>Possible Problems</b>
<b>Er00</b>	Power protection	1)The foot is in a state of acceleration during the initialization process
<b>Er01</b>	Stop needle error	1) motor Hall bad . 2) hand wheel magnet shedding. 3) parking signal line contact bad or damage
<b>Er02</b>	No foot signal was detected	1) the foot signal line contact is bad or damaged. 2)the model of the foot pedal controller is incorrect
<b>Er03</b>	Motor Hall or phase error	1)Motor signal line contact bad or damage. 2 )motor Hall bad
<b>Er04</b>	Plugging protection	1)Motor overload. 2) Poor contact of motor power line
<b>Er05</b>	Hardware overflow	1)Motor overload. 2)Poor contact of the motor signal line



<b>Er06</b>	Overflow of pressure foot electromagnet	1)Check whether the electromagnet is damaged or the damage of the main board
<b>Er07</b>	Serial communication error	1)Bad or damage to the connection line of the control box
<b>Er08</b>	Poor working environment	1)There is a strong magnetic field interference around it, 2)Poor contact of Communication line.

### List 2: Parameter

Serial Number	Name	Parameter range	Factory Default	Function
<b>P-01</b>	Maximum speed lock	200~5500	4000	
<b>P-02</b>	Positive and reverse setting of motor	0~1	1	0 represents reversal, 1 represents positive rotation
<b>P-03</b>	Down stop angle	0~23	12	180 degrees based on the position of top stop needle
<b>P-04</b>	The starting speed	200~800	250	250.
<b>P-05</b>	Speed up speed	1~20	20	The greater the value, the faster the faster
<b>P-06</b>	Set the needle sewing	0~999	0	0: closed
<b>P-07</b>	Motor power	50~1000	170	550W
<b>P-08</b>	Stop and stop function	0~1	1	0: close 1: open
<b>P-10</b>	Automatic running in test	0~1	0	The parameter is changed to "1" automatically running in, set to "0" or turn off the power, run in and

				stop
<b>P-11</b>	Downtime	185~285	235	
<b>P-12</b>	Acceleration zone	710~810	760	
<b>P-14</b>	Maximum acceleration current	50~1000	300	
<b>P-19</b>	Lift foot switch	0~1	1	0: close 1: open
<b>P-20</b>	Foot switch after stopping needle	0~1	0	0: close 1: open
<b>P-21</b>	Electromagnet absorption time	1~60	3	Unit / second (S)
<b>P-22</b>	Full time of electromagnet	10~1000MS	350	Time of full power working
<b>P-23</b>	Lift the foot to keep power	20~50%	30	The power after the lift is raised.
<b>P-24</b>	Underfoot discharge power	0~25%	15	Soft down function of lifting and pressing foot