

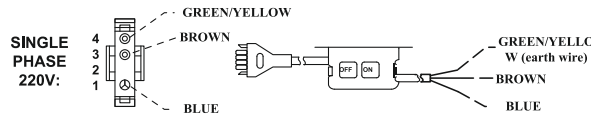
Manual Instruction for Panel for Texi Treccia Control box model: QD683G

1 Installation

1.1 Power Connection



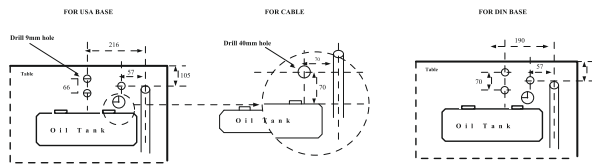
For countries or regions with unstable power supply, it is proposed to install a power stabilizer.



1.2 Motor Installation:

Installation of External Motor

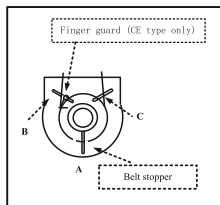
Recommended Drilling Diagram



As shown in the diagram above, after drilling 3 - Φ 9mm holes and 1- Φ 40mm hole on the machine table, install and fix the motor under the table, and NOTICE::

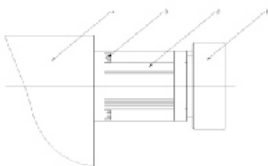
- 3) Pulleys of motor and machine must properly align.
- 4) Cable pass through under the working table must be secured to avoid the V-belt to be rubbed.

Installation and Adjustment of Belt Cover



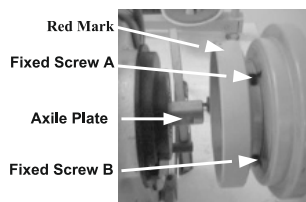
- a) Adjust the stopper A on the cover properly and leave about 5-10mm space from the v-belt.
- b) As factory defaults, [Finger Guard] is set at position B to avoid rubbing with the v-belt and pulley.

Installation of Internal Motor



1-wheel 2-Motor 3-Screw 4-Sewing machine tail
and wheel installation and adjustment please refer to "1.3 Installation and Adjustment Synchronizer".

1.3 Installation and Adjustment of Synchronizer



- a) Installation: Mount the synchronizer onto the flange of machine pulley and fasten the rotor by fixed screws so that no vibration is found at rotating.
- b) Adjustment: Release the fixed screws on the top shell and remove the top shell.
- c) Needle Up/Down Positioning Adjustment: Aim the green mark toward the fixed point on the machine head. If it is not accurate, adjust the location magnets of Needle Up/Down. (Refer to Parameter Mode B [058. UA] / [059.DA])



Attention: Make sure the power is off before the installation.

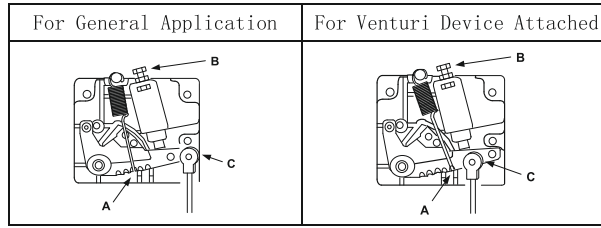
1.4 Adjust The Force Required To Operate The Foot Pedal

Spring A: Downward force adjustment

Bolt B: Heeling back force adjustment

Hole C: Pedal stroke adjustment

∴ In case of connecting with an air switch on the pedal rod to activate a Venturi Device, please shift the position for A and C as shown below.



1.5 Comparison Table of LCD Display Fonts and Actual Fonts

Arabic Numerals:

Actual	0	1	2	3	4	5	6	7	8	9
Display	0	1	2	3	4	5	6	7	8	9


Digital Display on the Key Board:

English Alphabet


Actual	A	B	C	D	E	F	G	H	I	J
Display	A	b	C	d	E	F	G	H	I	J
Actual	K	L	M	N	O	P	Q	R	S	T
Display	k	L	M	n	o	P	q	r	s	t
Actual	U	V	W	X	Y	Z				
Display	U	v	W	X	Y	Z				

1.6 Upper and lower stop debugging, Slow start joint debugging







In normal operating interface, when the button  on the screen the indicating lamp was lit in the parking position, the indicator light is off the time parking for lower needle stop



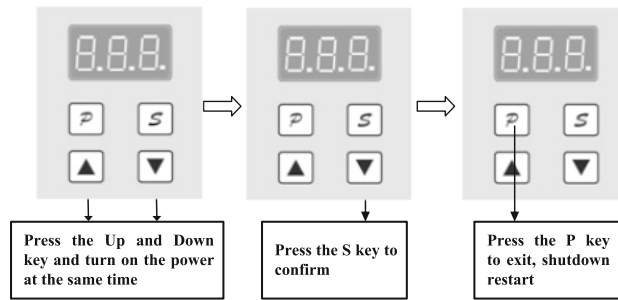
In normal operating interface, when the button  on the screen the indication lamp is lit up the slow play slot open, the indicating lamp is off the slow play play off the seam.

2: Keysfunction

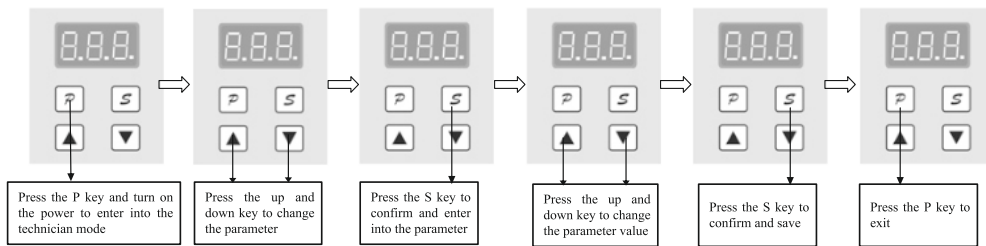
Entering and saving the parameter value		Enter into the parameter value and save the changed parameter values.
Entering the parameter mode		Press the P key in the Normal Mode can enter into the Users Parameter Mode(parameter value in Parameter Table 4.1)Press the P key and turn on the power can enter into the Technician Parameter Mode(parameter value in Parameter Table4.2)
Increase the value/increase the parameter		1、 Increase the parameter in Parameter Selection Area 2、 Increase the value in Parameter Value Area
Decrease the value/ decrease the parameter		1、 Decrease the parameter in Parameter Selection Area 2、 Decrease the value in Parameter Value Area

3 Operating instructions

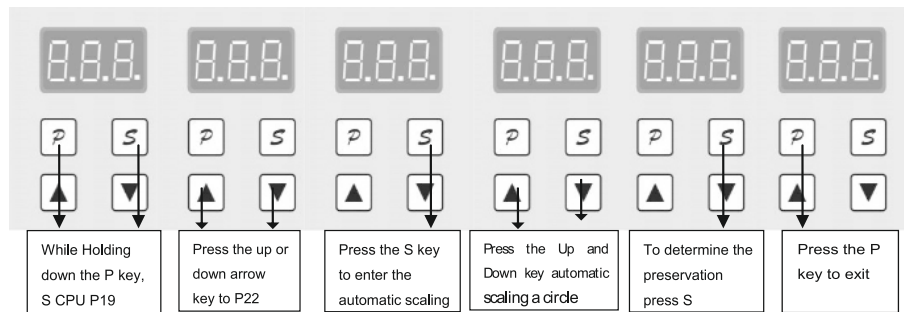
3.1: Reset the system



3.2: Enter into the Technician Mode and save the modification

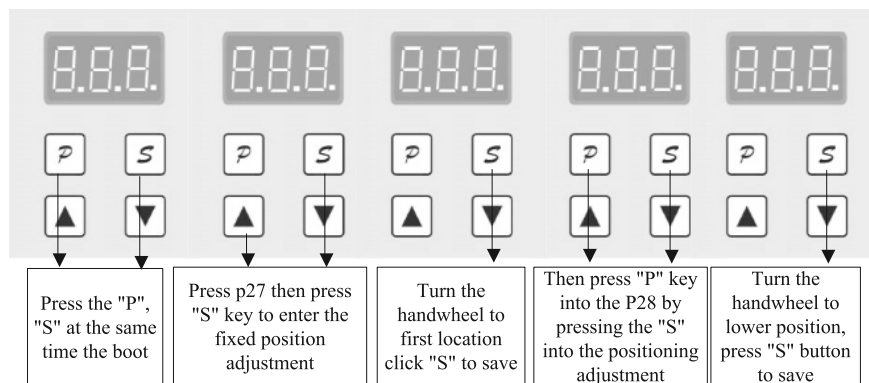


3.3: Automatic Scaling:



Note: under the hang machine model (fission) due to the size of the head pulley different proportion are not allowed to be out of control phenomenon for parking, after installed at this time to let control system automatically find proportion, shut electric restart

3.4: Positioning adjustment manual



4: User Parameter & Technician Parameter

4.1 User Parameter

Parameter Item	Parameter Function	Range	Default	Key	Description
P01	Maximum speed	100-6000	3700	▲▼	set the max sewing speed (show the actual number *10= speed)
P02	needle stop position selection	0-1	1	▲▼	Set the needle stop position(0: needle up 1:needle down)
P03	soft start switch	0-1	0	▲▼	soft start switch setting(0:OFF 1: ON)
P04	soft start sewing speed	100-1500	400	▲▼	soft start sewing speed setting(show the actual number *10= speed)
P05	stitches number of soft start	0-99	4	▲▼	set the stitches number of soft start, each unit is half stitch
P06	motor rotate direction	0-1	1	▲▼	motor rotate direction setting (0:clockwise 1:counter-clockwise)

4.2 Technician Parameter

Parameter Item	Parameter Function	Range	Default	Key	Description
P07	Rate				
P08	Synchronizer type selection	0-1	0	▲▼	Synchronizer type setting(0: single position 1:double position)
P09	auto running speed	100-6000	2000	▲▼	auto running speed setting(show the actual number *10= speed)
P10	auto running time	1-250	20	▲▼	set the auto running time in testing
P11	auto running stop time	1-250	20	▲▼	set the auto running stop time in testing
P12	Item A test	0-1	0	▲▼	Item A test setting(continue running with constant speed)
P13	Item B test	0-1	0	▲▼	Item B test setting(carry out the set loop running)
P14	Item C test	0-1	0	▲▼	Item C test setting(carry out the unset running)
P15	Machine Protection Switch Testing	0-2	1	▲▼	0: Disable; 1: Testing zero signal; 2: Testing positive signal
P16	No positioning mode selection	0-1	0	▲▼	0: the positioning mode 1: no positioning mode
P17	setting the up of location	40-250	40	▲▼	
P18	setting the down of location	40-250	40	▲▼	
P22	Automatic Scaling	0-1	0	▲▼	The parameter to 1 will automatically find the ratio of a circle parameters will be changed to 0
P23	Speed ratio	1-100	12	▲▼	
P24	Slowest	210-400	210	▲▼	

Parameter Item	Parameter Function	Range	Default	Key	Description
P25	Stop driving Intensity	001-031	15	▲ ▼	
P26	Pedal value display				

5 Error Code Table:

Error Code	Problem	Measurement
E1	Power Module is faulty. Abnormal over current or voltage. Resistor is damaged or F1 fuse is blown.	System will be shut down until the power resets on. Please check the power board in detail.
E7	a) Bad connection at the motor connector. a)Synchronizer signal error. b)Machine locked or object stuck in the motor pulley. c)Sewing material is too thick. d)Module output is abnormal.	Module driver output and sewing machine head output should be shut down until the power reset on. (Please check the sewing machine is jammed or synchronizer, motor, module driver single is abnormal.)
E8	Continuous manual back tacking over 15 seconds.	Module driver output and sewing machine head output should be shut down until the power reset on.
E9	Synchronizer signal error.	Please check the needle up and needle down position single is normal or the belt pulley is too loose.
E11	Auto needle position up when the power on. The synchronizer has connected to the control box, but the needle signal can't be sent out.	Motor still can run, but it automatically starts the no synchronizer mode. All constant-stitch sewing pattern and trimmer /wiper function is invalid.Please check the synchronizer.
E12	Power is turned on without the synchronizer signal.	Motor still can run, but it automatically starts the clutch mode. All constant-stitch sewing pattern and trimmer /wiper function is invalid.Please check the synchronizer.
E13	Overheat Protection for Power Module	Please check the connection between power module and heat sink
E14	Encoder signal error	Please check the encoder signal or change the encoder.
E15	Abnormal over current protection for Power Module	Module driver output and sewing machine head output should be shut down until the power reset on.Please check the power board in detail.
E16	Trimmer switch position error	Please check the trimmer switch position.
E17	Machine head switch position error	Please check if the machine head is raised or if the machine head switch is damaged.

6: Schematic diagram of port

6.1.1: QD683G Each port name:

