

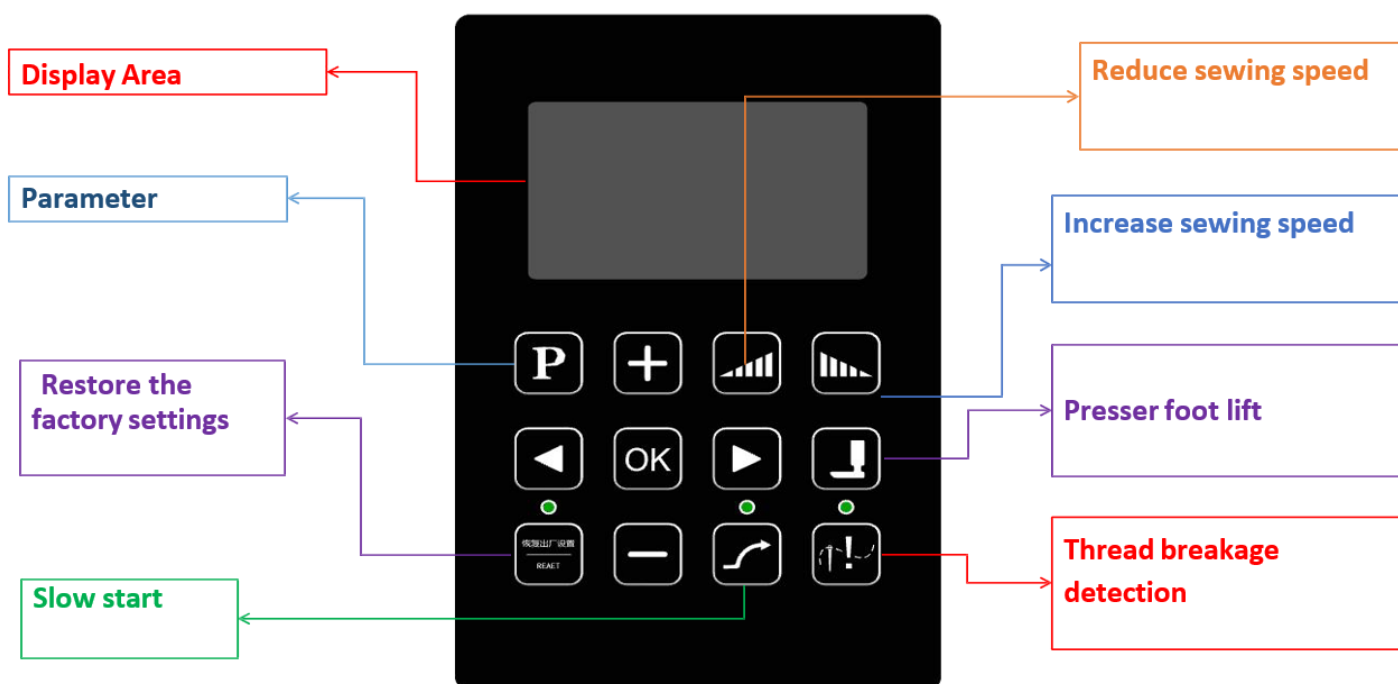
CONTROL PANEL MANUAL

781F

Automatic industrial buttonhole sewing
machine



1. Control panel introduction:



2. Parameter edition:

- 1) Use P to enter parameter edition mode.
- 2) Use < and > buttons to switch between digits in parameter edition mode
- 3) Use + and - buttons to increase or decrease values
- 4) Use OK to enter the parameter and to confirm the value change.

3. Main parameters:

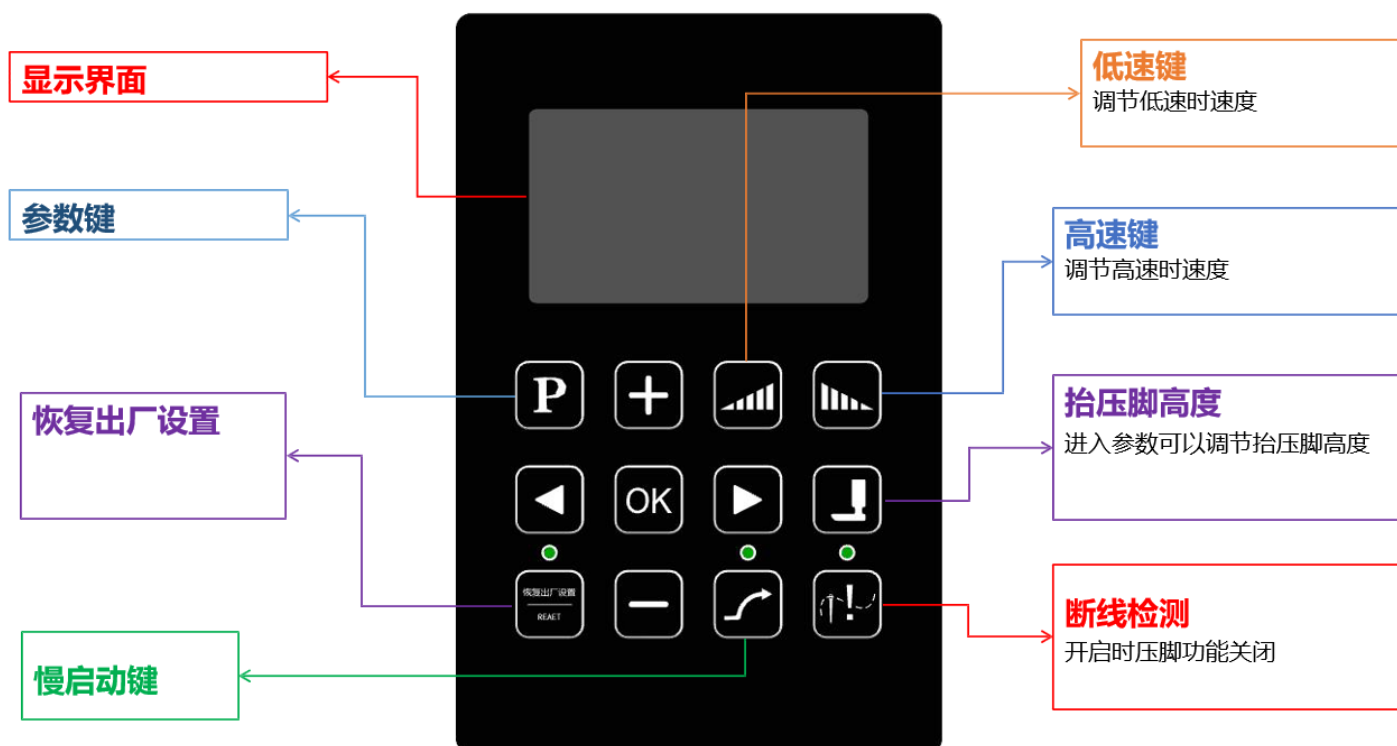
Parameter	Range	Default value	Instruction
P001	100-3500	2800	Current speed
P002	100-3000	600	The front starting speed
P006	100-2000	700	Slow start speed
P007	0-99	7	Slow start stitch numbers
P013	0-100	20	sensor trigger spaced stitches number
P021	0-2	0	safety switch
P029	0-359	80	Up needle stop position(press the presser foot key to update when turning the handwheel to the up needle position)
P032	100-3500	3000	Maximum speed
P035	1022	1022	Version
P042	0-1	0	Automatic motor angle calibration
P098	300-700	500	Presser foot stepper mechanical zero point
P099	0-300	80	Clamping trip
P100	0-1500	580	Presser foot lifting trip
P122	100-1240	850	Maximum working current of trimming stepping motor
P123	100-1240	750	Maximum working current of presser foot stepping motor
P124	0-500	0	The value of the pedal
P125	30-200	90	Number of stitches at the beginning of continuous cutting 3/4
P126	5-50	20	Number of stitches at the between of continuous cutting
P127	0-1	1	Turn on the safety switch setting
P128	0-1	0	Knife protection switch
P129	0-1	0	Thread broken stop switch
P130	0-1	1	Switch of the back step emergency stop function
P133	50-800	750	Cutting speed
P134	10-3000	300	Maximum number of running stitches
P136	40-600	450	Stepper motor lifting presser foot speed
P137	40-400	80	Stepper motor releasing presser foot speed
P138	10-600	100	Stepper motor claming thread speed
P139	10-600	200	The mid-position of stepper motor releasing
P140	10-400	80	The mid-speed of stepper motor releasing
P141	0-200	50	Delay time of the presser foot lifting when spindle motor finishing work
P142	0-5000	80	Delay time of the spindle motor starting
P143	1-5000	140	The delay of the stepper presser foot releasing
P143	1-5000	140	The delay of the stepper presser foot releasing
P144	0-9999	0	Current thread trimming count

4. Error codes and troubleshooting

Error code	Error instruction	Solution(please turn off the power before operating)
ER01	positioner signal abnormal	1.check the connection of motor encoder plug, reconnect it and restart the controller to test 2. change the motor 3. change the controller
ER02	abnormal connection of speed controller	1. check the connection of the speed controller 2. change the speed controller 3. change the controller
ER04	poor connection of the motor plug machine stuck, the clothe is too thick to be penetrated abnormal of the controller	1. check the connection of motor power wire, reconnect it and restart the controller to test 2. check the machine if it is stuck 3. check if the cloth is too thick 4. change the spindle motor 5. change the controller
ER05	1) spindle motor power module error code 2) abnormal overcurrent or overvoltage of spindle motor	restart the controller change the controller
ER07	CPU abnormal transmission communication between display and CPU	1. reconnect the connection between display and controller 2. change the display 3. change the controller
ER15	spindle motor encoder error	1. check the connection of motor encoder plug, reconnect it and have a test 2. change the spindle motor
ER16	overvoltage when the system is not running	1. check the input voltage if it too high 2. change the controller
ER20	system undervoltage	1. check the input voltage if it too low 2. change the controller
ER31	spindle motor origin detection error	1. check the connection between the spindle motor and controller
ER32	machine overturn protection	1. check the machine if it is overturn
ER33	reverse sewing timeout protection	1. the closing time of reverse sewing electromagnet is too long, restart the controller 2. check if the manual reverse sewing switch is broken
ER34	trimming stuck	turn around the handwheel to return the moving knife, clean the table and check the knife set
ER36	overvoltage during system operation	1. check the input voltage if it too high 2. change the controller
ER81	presser foot stepper motor origin detection error	check if the installing of the stepper motor mistake or not, release the fixing screws, restart the controller to check if it is still error
ER84	presser foot stepper motor stuck	1. check the connection of stepper motor encoder plug 2. , check whether the feeding mechanical structure is stuck or overloaded, restart the controller when recover it 3. change the stepper motor 4. change the controller

ER85	1) presser foot stepper motor power module error code 2) abnormal overcurrent or overvoltage of presser foot stepper motor	1. check if the stepper motor plug not good connected 2. check if the feeding mechanical structure is stuck, restart controller after troubleshooting 3. change the controller
ER87	the terminals of presser foot stepper motor and spindle motor are wrongly inserted	1. change the terminals of the stepper motor and spindle motor 2. restart controller, if still not work, change it
ER88	presser foot stepper motor cannot reach the position	1. check if the feeding mechanical structure is stuck or overloaded 2. check if the swing amplitude of the connecting rod exceeds the limit, restart after troubleshooting 3. change the controller
ER61	slicer stepper motor origin detection error	check if the installing of the stepper motor mistake or not, release the fixing screws, restart the controller to check if it is still error
ER64	slicer stepper motor stuck	1. check the connection of stepper motor encoder plug 2. check whether the feeding mechanical structure is stuck or overloaded, restart the controller when recover it 3. change the stepper motor 4. change the controller
ER65	1. slicer stepper motor power module error code 2. abnormal overcurrent or overvoltage of slicer stepper motor	1. check if the stepper motor plug not good connected 2. check if the feeding mechanical structure is stuck, restart controller after troubleshooting 3. change the controller
ER67	the terminals of slicer stepper motor and spindle motor are wrongly inserted	1. change the terminals of the stepper motor and spindle motor 2. restart controller, if still not work, change it
ER68	slicer stepper motor cannot reach the position	1. check if the feeding mechanical structure is stuck or overloaded 2. check if the swing amplitude of the connecting rod exceeds the limit, restart after troubleshooting 3. change the controller

1. 控制面板介紹：



2. 參數編輯：

- 1) 使用 P 鍵進入參數編輯模式。
- 2) 在參數編輯模式下，使用 < 和 > 鍵切換數字。
- 3) 使用 + 和 - 鍵增加或減少參數值。
- 4) 使用 OK 鍵輸入參數並確認修改。

3.主要參數：

範圍	範圍	預設值	操作說明
P001	100-3500	2800	目前速度
P002	100-3000	600	前部起動速度
P006	100-2000	700	啟動速度慢
P007	0-99	7	慢啟動針數
P013	0-100	20	感測器觸發間隔針數
P021	0-2	0	安全開關
P029	0-359	80	上針停止位置（轉動手輪到上針位置時按壓腳鍵更新）
P032	100-3500	3000	最大速度
P035	1022	1022	版本
P042	0-1	0	自動馬達角度校準
P098	300-700	500	壓腳步進機械零點
P099	0-300	80	夾緊行程
P100	0-1500	580	壓腳抬升行程
P122	100-1240	850	微調步進馬達最大工作電流
P123	100-1240	750	壓腳最大工作電流 步進馬達
P124	0-500	0	踏板的價值
P125	30-200	90	起始針數 連續切割 3/4
P126	5-50	20	針數 連續切削
P127	0-1	1	打開安全開關設定
P128	0-1	0	刀保護開關
P129	0-1	0	斷線停止開關
P130	0-1	1	後退步急停功能開關
P133	50-800	750	切割速度
P134	10-3000	300	最大運行針數
P136	40-600	450	步進馬達抬壓腳速度
P137	40-400	80	步進馬達鬆壓腳速度
P138	10-600	100	步進馬達夾線速度
P139	10-600	200	步進馬達鬆開中位
P140	10-400	80	步進馬達中速釋放
P141	0-200	50	主軸馬達完成工作時抬壓腳延時時間
P142	0-5000	80	主軸馬達啟動延時時間
P143	1-5000	140	步進壓腳釋放延遲
P143	1-5000	140	步進壓腳釋放延遲
P144	0-9999	0	目前剪線數

4. 錯誤代碼及排除方法

錯誤代碼	錯誤指令	解決方法（操作前請關閉電源）
ER01	定位器訊號異常	1.檢查馬達編碼器插頭連接情況，重新連接後重新啟動控制器測試 2.更換電機 3.更換控制器
ER02	調速器連接異常	1.檢查速度控制器的連接 2.更換速度控制器 3.更換控制器
ER04	馬達插頭接觸不良機器卡住，衣服太厚，無法穿透控制器異常	1.檢查馬達電源線連接是否正確，重新連接後重新啟動控制器測試 2.檢查機器是否卡住 3.檢查布料是否太厚 4.更換主軸電機 5.更換控制器
ER05	1) 主軸馬達功率模組錯誤代碼 2) 主軸馬達異常過流或過壓	3. 重新啟動控制器 4. 更換控制器
ER07	CPU 顯示器與 CPU 之間的傳輸通訊異常	1.重新連接顯示器和控制器之間的連接 2.更改顯示 3.更換控制器
ER15	主軸馬達編碼器錯誤	1.檢查馬達編碼器插頭連接情況，重新連接測試 2.更換主軸電機
ER16	系統未運轉時過壓	1.檢查輸入電壓是否過高 2.更換控制器
ER20	系統欠壓	1.檢查輸入電壓是否過低 2.更換控制器
ER31	主軸馬達原點偵測錯誤	1.檢查主軸馬達與控制器之間的連接
ER32	機器傾覆保護	1.檢查機器是否翻倒
ER33	倒縫超時保護	1.倒縫電磁鐵閉合時間太長，重啟控制器 2.檢查手動倒縫開關是否壞
ER34	修剪卡住	旋轉手輪，使動刀返回，清潔工作台，檢查刀組
ER36	系統運作期間過壓	1.檢查輸入電壓是否過高 2.更換控制器
ER81	壓腳步進馬達原點偵測錯誤	檢查步進馬達安裝是否錯誤，鬆開固定螺絲，重新啟動控制器檢查是否仍錯誤
ER84	壓腳步進馬達卡住	1.檢查步進馬達編碼器插頭連接是否正確 2.檢查送料機械結構是否卡住或過載，恢復正常後重新啟動控制器 3.更換步進電機 4.更換控制器
ER85	1) 壓腳步進馬達電源模組錯誤代碼 2) 壓腳步進馬達異常過流或過壓	1.檢查步進馬達插頭是否接觸不良 2.檢查送料機械結構是否卡住，排除故障後重新啟動控制器 3.更換控制器
ER87	壓腳步進馬達和主軸馬達的端子插錯	1.更換步進馬達和主軸馬達的端子 2.重新啟動控制器，如果還不行，更換
ER88	壓腳步進馬達無法到達位置	1.檢查送料機械結構是否卡住或超載 2.檢查連桿擺動幅度是否超過極限，排除故障後重新啟動 3.更換控制器

ER61	切片機步進馬達原點偵測錯誤	檢查步進馬達安裝是否錯誤，鬆開固定螺絲，重新啟動控制器檢查是否仍錯誤
ER64	切片機步進馬達卡住	1.檢查步進馬達編碼器插頭的連接 2.檢查送料機械結構是否卡住或過載，恢復正常後重啟控制器 3.更換步進電機 4.更換控制器
ER65	1.切片機步進馬達電源模組錯誤代碼 2.異常過流或過壓 切片機步進電機	1.檢查步進馬達插頭是否接觸不良 2.檢查送料機械結構是否卡住，排除故障後重新啟動控制器 3.更換控制器
ER67	切片機步進馬達和主軸馬達的端子插錯	1.更換步進馬達和主軸馬達的端子 2.重新啟動控制器，如果仍然不起作用，請更換它
ER68	切片機步進馬達無法到達位置	1.檢查送料機械結構是否卡住或超載 2.檢查連桿擺動幅度是否超過極限，排除故障後重新啟動 3.更換控制器

NOTES

[illegible]

Dealer:

The Texi logo, featuring a stylized purple flower icon followed by the word "texi" in a lowercase, italicized, purple serif font.