CONTROL PANEL MANUAL
V2

WALKER 6F

Automatic industrial lockstitch sewing machine with walking feed

HD texi

1. Safety instruction

Please read the operation manual and related sewing machinery datasheet carefully before correct use.

1.1 (1) Power voltage and frequence: please refer to motor and control box nameplate.

(2) Interference from electromagnetic wave:please keep far away strong magnetic or high radiation environment in order

to avoid obstructions and make to misoperation.

(3) Grounding: to avoid the noise obstructions or leakage of electricity accident(inculding sewing machine,motor,control

box and positioner) .

1.2 Please make sure power off at least 1min and then can open control box cover, because there are dangerous high voltage.

1.3 Please turn off the power while repairing or wearing needle in order to protect operater's safty.

1.4  Used where potential dangers exist.

 Used where high voltage and electric danger exist.

2. Control buttons description

Front Reinforcing-sewing (bartack)		Circulation: front reinforcing-sewing / front double reinforcing-sewing / front quad reinforcing-sewing / turn off
Back Reinforcing-sewing (bartack)		Circulation: back reinforcing-sewing / back double reinforcing-sewing / back quad reinforcing-sewing / turn off
Continuous Reinforcing-sewing / Debug mode		short press: circulation between W sewing and Free sewing long press: Debug mode shortcut key in free seam mode (long press for more than 3 seconds)
Thread cutting function key /Thread clamp function		short press: Thread cutting function on and off. long press: Thread clamp function on and off.
Needle position selection key /soft start function		short press: Up and down needle selection key long press: Starting function on and off
Add or reduce key		1. Speed adjustment key. Press continuously to increase/decrease the sewing speed, and the display screen will automatically switch to the speed setting value 2. According to several numerical and subtract 3. The parameter value plus or minus 4. Pattern edit value add and subtract
Presser foot function cycle key/ Trigger function key Settings		short press - Foot presser function cycle: middle stop lifting foot / cutting line after lifting foot / middle stop cutting line after lifting foot / closing long press: 1. Effective (on/off) in fixed-length seam mode (one-section seam / multi-section seam / multi-section self-knitting pattern) 2. W seam mode Open automatically

Parameters setting key		Short press P: To enter 1st level sewing parameters editing interface. Long press P: To enter 2nd level sewing parameters editing interface (the "password input interface"). After entering the correct maintenance password, press the "P" button to enter. NOTE: Dafault password: 1111
Save key		1. Save key 2. For the model with tape cutting function long press S button to display the thread clamp LCD display. Press the key again to exit.
Left and right key		Under the sewing interface, "3333" can be adjusted left and right.
Stitch length adjustment key		Adjust the stitch length
Half lift function + presser foot height adjustment key		Under the sewing interface, mid press to turn on and off the half lift function. + and – used to adjust the height of the press foot half-lift (during pause presser will make short lift to release the material).
Fixed length sewing mode key		Cycle: Single seam/Multi seam/Pattern Multi seam/Free seam
Dense stitch bartack		Dense stitch bartack function on and off.
Reset setting		Short press: Enter piece rate (JJ) mode Long press: Under the standby interface, press Reset key 1.5 seconds to enter the “restoration of the factory setting interface”, press the “+” button to change to “yes”, and then press “S” to confirm
Press foot lift switch		Turns On/Off the foot lift function
ART AUTO Decorative Pattern sewing key		Short press: Under the sewing interface, switch the pattern mode (d1~d9) Long press: Under the free sewing interface, enter the pattern editing mode

3. Mode Settings

Debug mode:

1. After entering the normal sewing mode, press the right side 4 seconds“ 𝕋 ”， enter debug mode.If you want this pattern to return to normal mode， press “ ℙ ”key to exit into normal mode Stitch length Adjustment Mode: After entering sewing mode normally, long press‘ 𝕋 ”3seconds， Entering debug mode， press“+”or“−”， switch to parameter P-6， 𝕊 ,then the machine can be zero position correction, switch to parameter P-7， press 𝕊 can correct the go-stitch lemgth；switch to parameter P-8， press 𝕊 can correct the reverse-stitch length， all the corrections are save to exit by press 𝕊 。

Restore Factory settings:

1. Long press “ ℙ ” enter parameter interface， enter“P79”will displays“0”， Press“+-”to“3”， press‘ 𝕊 ” display “no”， Then press “+-” to“yes”， press 𝕊 ”.

2. Under the standby interface, press Reset key 1.5 seconds to enter the “restoration of the factory setting interface”, press the “add-subtract key” to “yes”, and then press “S” to confirm.

Pattern editing settings interface:

After entering the normal sewing mode, press the “

” Key for 2 seconds, screen display show “d1” – decorative stitch type. Press“+-” to switch the seam type (pattern) from d1 to d9.

Select the pattern you want to edit and press “ 𝕊 ” to enter editing mode. Screen display “1 3.0 01”, In this case, first digit is the number of stitch, second is a stitch length and third is a quantity of repeats.

Press left or right to select the item to be set.

When the first digit is set up, press left or right to switch to the left or right, and edit the the number that flashes (stitch length or repeat quantity).

Press “+-” key to switch to other segments settings. If the first number of stitches is zero, the change of next digit can not be made.

After all the stitch length and stitch count settings are complete, press the “ ℙ ” key to save and return to the "d1" screen or press the “ 𝕊 ” key to exit without saving.

If you want this pattern to return to normal mode， press “ ℙ ” key to exit into normal mode.

4. Error codes

Error Code	Contents	Possible reasons	Checking and treatment
E011 E012	Motor signal error	Motor position sensor signal failure	If electric engine plug is well contacted; if electric engine signal detecting device has been broken; if sewing machine handwheel correctly installed.
E021 E023	Motor overload	motor stall motor overload	If electric engine plug is well contacted; if machine head or thread-cutting mechanism has been blocked completely;If materials are too thick; Electrical signal detection signal whether the normal.
E022	Thread cutter stuck	Thread cutter stuck	Check whether the head or cutting mechanism is stuck Check whether the timing and location of the Thread trimming are correct
E101	Hardware drivers fault	Current detection abnormal Driving hardware error	Current detection loop system is working properly;Whether the damage to the device driver.
E111 E112	Voltage too high	High input voltage Brake circuit fault Voltage detection error	System into line voltage is too high; Braking resistance are working properly; System voltage detection circuit are working properly.
E121 E122	Voltage too low	Actual low voltage Voltage detection is wrong	If the voltage on the inlet wire is too low Whether the system voltage detection circuit the normal work.
E131	Current circuit fault	Current detection abnormal	Current detection loop system is working properly.
E133	Oz circuit fault	Oz circuit fault	Oz circuit system is working properly.
E134	DBFLT malfunction	Automatic resistance circuit failure	Brake resistor plug is in good contact；Brake resistance is damaged
E201	over current	Current detection error	Current detection loop system is working properly Electrical signal is normal.
E211 、 E212	Abnormal motor operation	Current or voltage detection error	If electric engine plug is well contacted；If electric engine signal
E301	Communication error	Sci circuit error	if operation box plug is well contacted; if operation box components are damaged.
E302	Operation inner failure	Sci circuit error	check whether the operating box is damaged.
E303	SPI Communication breakdown	Sci circuit error	check whether the main control board is damaged.

Error Code	Contents	Possible reasons	Checking and treatment
E304	HMI From the main chip communication failure	Sci circuit error	check whether the operating box is damaged.
E402	Pedal ID fault	Pedal verification fault	Pedal connection is loosen.
E403	Pedal zero position fault	The pedal zero position over range	The pedal is damaged or it is not under stop state when correction
E501	Safety switch fault	Safety switch effective	Put down the head or check turned up switch.
E502	Fuel fault alarm	Fuel fault alarm	Add oil Tips
E601	Hardware overcurrent failure	Needle distance presser foot motor hardware overcurrent	Current detection loop system is working properly Whether the damage to the device driver.
E602	Software overcurrent failure	Needle distance presser foot motor software overcurrent	Current detection loop system is working properly Whether the damage to the device driver
E603	Current detection loop fault	Needle distance presser foot motor current detection circuit overcurrent	Current detection loop system is working properly Whether the damage to the device driver.
E604	Mechanical zero position finding fault	Initial mechanical angle of needle distance presser foot motor	Check if the needle distance presser foot motor plug is in good contacted
E605	Motor stall	Needle distance presser foot motor stall	Check if the needle distance presser foot motor plug is in good contact Is there any sticking point in the machinery
E606	Motor open circuit failure	Needle distance presser foot motor winding circuit	Current detection loop system is working properly Whether the damage to the device driver.
E607	Hardware overcurrent failure	Thread trimming motor hardware overcurrent	Current detection loop system is working properly Whether the damage to the device driver.
E608	Software overcurrent failure	Thread trimming motor software overcurrent	Current detection loop system is working properly Whether the damage to the device driver.
E609	Current detection loop fault	Thread trimming motor current detection loop failure	Current detection loop system is working properly Whether the damage to the device driver.
E610	Mechanical zero position finding fault	The Initial mechanical angle of thread trimming motor failure	Check if the thread trimming motor plug is in good contacted
E611	Motor stall	Thread trimming motor stall	Check if the thread trimming motor plug is in good contact; Is there any sticking point in the machinery

Error Code	Contents	Possible reasons	Checking and treatment
E612	Motor open circuit failure	Thread trimming motor winding circuit	Current detection loop system is working properly Whether the damage to the device driver.
E701	Bottom line detection alarm	The bottom line sensor does not detect the bottom line	Replace the bottom line or check the bottom line sensor
P.oFF	Power off Display	Power off	Wait for power supply to resume.
EvAL	Trial expired	Trial expired	Contact the dealer processing
L.bob	The bottom line tips	The bottom line count value is negative	After replacing the bottom line, press P to cancel the Alert Status
P.bob	Piece rate reminder	The number of counting is 0	Press S key to enter the interface, and long press "front seam" button for more than 2 seconds to cancel the prompt state To disable the piece rate function, change the P35 parameter value to 0

5.System Parameter Table:

No.	Parameter	Description	Setting range	Step	Default	Lvl
P-01	Sewing speed	Set sewing speed	200~3000 (rpm)	100	2400	I
P-02	Soft-start function	1~9: Soft start stitches	0~9	1	2	I
P-04	Fixed-length seam sewing speed	Set fixed-length seam sewing speed	200~3000 (rpm)	100	2200	I
P-06	Zero pitch correction value	When the needle pitch is set to 0mm, fine the value so that the actual sewing needle pitch is zero	50~150	1	100	I
P-07	Positive needle distance correction value	Magnification positive sewing distance (Sewing needle fixed distance)	50~150 (%)	1	100	I
P-08	Anti-needle distance correction value	Enlarge reverse stitches Distance Scale (Sewing needle fixed distance)	50~150 (%)	1	100	I
P-09	Back stitch speed limitation	can keep needle from breaking while backstitching	500~1500 (rpm)	50	1500	I
P-10	Set the length of the stitch from the set number	0:Set the number of stitches to set the value 1:When the length is set to self-made, the number is the number of the pattern, that is, the total number of stitches is the number of stitches × set the value	0/1	1	1	I
P-12	The first section angle of the presser foot lift	The first section angle of the presser foot lift	0~100	1	30	II
P-13	Maximum height of presser foot lifting(valid stepping)	Setting Maximum height of presser foot lifting after trimming	0~100	1	55	II
P-14	Speed of presser foot lifting(valid stepping)	Stepping speed of presser foot lifting	20~500 (rpm)	10	400	II
P-15	Speed of presser foot releasing(valid stepping)	Stepping speed of presser foot releasing	20~500 (rpm)	10	400	II
P-16	The first section angle of the presser foot down	The first section angle of the presser foot down	0~100	1	30	II
P-17	Cut and loosen duty cycle	Cutting line for electromagnet:When the shear line loose line duty ratio (too small will affect the shear line electromagnet suction strength) Cutting line for step:Loose line efforts to adjust the (light)	0~100	1	50	II

No.	Parameter	Description	Setting range	Step	Default	Lvl
P-18	Front reinforcing-sewing setting after the front fixed joint is connected	Immediately after the end of front reinforcing-sewing, step on the cutting line without the function setting of back reinforcing-sewing 0: unavailable 1: available	0/1	1	0	I
P-19	Solid after before sewing stop	0: unavailable 1: available	0/1	1	0	I
P-20	Function selection of machine head button	0: invalid 1: Manual thread cutting while standby 2: Manual presser foot after trimming	0/1/2	1	0	I
P-21	soft start speed 1	speed of the 1 st needle of soft start	100~3000 (rpm)	50	400	I
P-22	soft start speed 2	speed of the 2 nd needle of soft start	100~3000 (rpm)	50	1000	I
P-23	soft start speed 3	speed of the 3 rd~9 th needle of soft start	100~3000 (rpm)	50	1500	I
P-24	Presser foot soft lowering function	Setting to protect damaged the fabric to slow down the presser foot lowering speed	0/1	1	0	I
P-25	Presser foot lift function	0: unavailable 1: available	0/1/2	1	1	I
P-26	Function of over thickness	Setting the function of over thickness 0: unavailable 1: available	0/1	1	0	I
P-27	Power on and positioning	The function setting of automatically finding the needle position when the power is on 0: unavailable 1: available	0/1	1	0	I
P-28	signal mode for turn/lift switch	Setting of signal mode of turn/lift switch of machine head 0: always open 1: always close 2:forbid a protection	0/1/2	1	0	I
P-29	Presser foot soft lowering time	To set presser foot soft lowering time The longer time the lower speed of the presser foot	100~500 (ms)	5	300	II
P-30	Bottom line counting	0: unavailable 1: available	0/1	1	0	I
P-31	Bottom line initial value setting	Bottom line initial value setting	200~4000 (0.1m)	20	1600	I
P-33	Front fixed sewing ABA mode selection	0: unavailable 1: available	0/1	1	0	I
P-34	Standard joint speed mode selection	Select 0 automatic for standard joint speed mode; 1 pedal control	0/1	1	0	II

No.	Parameter	Description	Setting range	Step	Default	Lvl
P-35	multiple ratio of counting by piece	Setting of multiple ratio of counting by piece	0~50	1	0	I
P-36	Setting initial value of counting by piece	Setting initial value of counting by piece	0~1000	5	100	I
P-37	Time of thread wiper	Time of thread wiper	0~800 (ms)	10	40	II
P-38	Setting function of choosing counting by piece	0: add 1: subtract	0/1	1	0	I
P-39	Turn off time before presser foot soft drop	Turn off time before presser foot soft drop	0~50	1	12	I
P-41	Low speed	The lowest speed of pedal	100~500 (rpm)	10	200	I
P-42	Pedal curve selection	Pedal speed adjustment 0: normal 1: Slow acceleration 2: Quick acceleration	0/1/2	1	0	I
P-44	thread-cutting speed	thread-cutting speed	100~500 (rpm)	10	250	I
P-45	Back-tracking speed limit function	Back-tracking speed processing can prevent reverse sewing needle breakage 0:1: infinite speed limit 2: the speed limit	0/1/2	1	2	I
P-46	presser foot lifting delays sewing	delay with presser foot lowered	0~800 (ms)	10	100	II
P-47	When running, the knee presses the foot to judge the speed	When running, the knee presses the foot to judge the speed	200~1000 (rpm)	50	500	II
P-48	When running the knee is raised by the foot	When running the knee is raised by the foot	1~100	1	0	II
P-49	Press foot holding time	Lift the pressure foot after holding time to force off	1~60(s)	1	12	II
P-50	output time of total pressure of presser foot lifting	output time of total pressure of presser foot lifting	0~800 (ms)	10	150	II
P-51	output duty cycle of presser foot lifting hold time of presser foot lifting	output duty cycle of presser foot lifting hold time of presser foot lifting	0~100	1	40	II
P-53	starting reinforcing-sewing speed	starting reinforcing-sewing speed	100~3000 (rpm)	50	1200	I

No.	Parameter	Description	Setting range	Step	Default	Lvl
P-54	Compensation coefficient of front tacking sewing	Compensation coefficient of front tacking sewing	80~120	1	100	I
P-55	Compensation coefficient of front back tacking sewing	Compensation coefficient of front back tacking sewing	80~120	1	100	I
P-56	ending reinforcing-sewing speed	ending reinforcing-sewing speed	100~3000 (rpm)	50	1200	I
P-57	starting reinforcing-sewing of front tacking sewing	starting reinforcing-sewing of front tacking sewing	80~120	1	100	I
P-58	starting reinforcing-sewing of front back tacking sewing	starting reinforcing-sewing of front back tacking sewing	80~120	1	100	I
P-59	Continuous reinforcing-sewing speed	Continuous reinforcing-sewing speed	100~3000 (rpm)	50	1200	I
P-60	Bartack stitch cancel speed limit	0: The software has speed limited 1: No speed limited	0/1	1	0	I
P-61	A switch to cancel the angle limit when change stitch length	0: Change the stitch length within the limiting angle 1: Change stitch length at any angle(The stitch length may not coincide,or the needle may break)	0/1	1	0	I
P-62	Pedal travel upon start	Pedal position upon start (Travel relative to medium pedal)	10~50 (0.1°)	1	15	II
P-63	Pedal travel upon acceleration	Pedal position upon start acceleration (Travel relative to medium pedal)	10~100 (0.1°)	1	45	II
P-64	Pedal travel at highest rotation speed	Pedal position at highest rotating speed (Travel relative to medium pedal)	10~150 (0.1°)	1	100	II
P-65	Pedal travel upon presser foot lift	Pedal position upon pedal lift (Travel relative to medium pedal)	-100~-10 (0.1°)	1	-25	II
P-67	Pedal travel 1 upon thread trimming	Pedal position upon start trimming without presser foot function Travel relative to medium pedal	-100~-10 (0.1°)	1	-50	II
P-68	Pedal travel 2 upon thread trimming	Pedal position upon start thread trimming with presser foot function (Travel relative to medium pedal)	-100~-10 (0.1°)	1	-60	II
P-69	Down needle position	To adjust down needle position	0~240	1	175	I

No.	Parameter	Description	Setting range	Step	Default	Lvl
P-70	Sewing variable needle pitch mode	0: Close 1: Lift the needle after trimming 2: Release the presser foot to lift the needle 3: Lift the needle both after trimming and when releasing the presser foot	0~3	1	0	I
P-71	Reversal of needle lift angle	Reversal of needle lift angle	260~360°	1	340	I
P-72	Thread clamp strength adjustment	Adjust the thread clamp strength size 0: Clip line function is invalid 1~9: Three Intensity Adjustment	0~99	1	7	I
P-73	Thread pressing actuation angle	Thread pressing actuation angle	10~360°	5	100	I
P-74	Thread pressing release angle	Thread pressing release angle	160~360°	5	270	I
P-75	Needle position adjustment	Needle position adjustment	0~240	1	33	I
P-77	Setting of beauty sewing	0: unavailable 1: available	0/1	1	0	I
P-78	Beauty sewing(close sewing)mode setting	1: Close stitch on start sewing 2: Close stitch on end-sewing 3: Close stitch on both start nad end sewing	1/2/3	1	3	II
P-79	return to factory-set parameter	Special functional parameters 5/8: Restore factory parameters	0~15	1	0	I
P-80	Maximum sewing speed	The highest sewing speed	300~3000 (rpm)	100	2500	II
P-81	Pedal speed percentage	Pedal speed percentage	50~100	1	100	II
P-82	Trial period	Trial function 0: Invalid trial function 10-1000: Power on trial time	0~1000 (hour)	10	0	III
P-83	Strength function	Try if the needle can't penetrate the cloth. 0: invalid; 1~15: intensity adjustment	0~15	1	0	II
P-84	Function of cutting line and adding force	Effective when the cutting wire is an electromagnet; 0: invalid; 1~15: intensity adjustment	0~15	1	0	II
P-88	Loose line suction Angle	Loose line suction Angle	0~360	2	180	II
P-89	Loose line release Angle	Loose line release Angle	0~360	2	350	II
P-90	Language selection setting	Setting of language: 0: turn off 1: Chinese 2: English	0~2	1	1	II
P-91	Change pitch selection	Change pitch selection 0:Changes Allowed 1:Allowed to change	0~1	1	0	II

No.	Parameter	Description	Setting range	Step	Default	Lvl
P-92	Pedal presser foot lift confirm time	Pedal presser foot lift confirm time	10~300 (ms)	10	80	II
P-93	The neutral position of the pedal	Trimming the neutral position of the pedal	-15~15 (0.1deg)	1	0	II
P-95	Anti-nest function selection	Anti-nest function selection: 0: Thread clamp type 1: Anti-next type 2: thread wiper type	0/1/2	1	0	II
P-99	Machine mode selection	Machine mode selection	/	/	/	Ⅲ
P-100	Knee by function setting	Knee by function setting: 0: unavailable 1: available	0/1	1	1	II
P-101	The voltage at the zero position of the knee sensor	The voltage at zero position of knee by's presser foot(Unit:0.01V)	0~500	5	270	II
P-102	Knee sensor's voltage of maximun travel distance	Knee sensor's voltage of maximun travel distance(unit:0.01V)	0~500	5	60	II
P-103	Line tension / loose line function switch	0 :Line tension control 1 :Ordinary loose line electromagnet control	0/1	1	1	II
P-104	Pattern stop function enable	0: unavailable 1: Stop the needle need to go through the current number of pattern stitches	0/1	1	0	II
P-105	Presser foot height sensor function setting	Presser foot height sensor function setting 0: unavailable 1: available	0/1	1	1	II
P-106	The voltage adjustment at zero position of presser foot height sensor	The voltage adjustment at zero position of presser foot height sensor(unit:0.01v) (presser foot drop,feed dog is under the table)	0~250	1	215	II
P-107	Overthickness detection sensitivity setting	Presser foot height sensor's voltage setting of overthickness detection Unit:mv)(Relative to the zero position voltage)	0~500	5	100	II
P-108	Full pressure duty cycle of thread trimming	Full pressure duty cycle of thread trimming(Buffering during the thread trimming and closing)	50~100	1	80	II
P-109	Force adjustment of electromagnet for presser foot lifting	Force adjustment of electromagnet for presser foot lifting(Cushion when press foot is absorbed)	50~100	1	80	II

No.	Parameter	Description	Setting range	Step	Default	Lvl
P-110	Fabric thickness and tension control	Increase tension appropriately when sewing thick materials	0~10	1	0	II
P-111	Overthickness sewing speed	Limit speed of overthickness	500~3000 (rpm)	50	1500	II
P-112	Overthickness stitch offset coefficient	Overthickness stitch offset deals	50~150 (%)	1	120	II
P-113	Needle compensate stitch length mode	Needle compensate stitch length mode0: Invalid:valid(press P114 to set stitch length)	0/1	1	0	I
P-114	Needle compensate stitch length setting	Parameter range of Stitch length 5mm type(1.0mm~5.0mm)	10～50 (70)	1	40	I
P-115	Reverse sewing button function setting	0: reverse sewing 1: tightly sewn 2: reverse sewing 3:reverse sewing+reverse sewing	0~3	1	0	II
P-116	fill needle button function setting	0: reverse sewing 1: tightly sewn 2: reverse sewing 3:reverse sewing+reverse sewing	0~3	1	2	II
P-117	Dense needle pitch setting	Head button stitch stitch set	50~150	1	110	II
P-118	Number of pretty sewing needle setting	Number of pretty sewing needle setting	1~10	1	1	II
P-119	Pretty sewing needle distance setting	Pretty sewing needle distance setting	50~150	1	110	II
P-121	Start trimming angle of Paragraph 1	Start trimming angle of Paragraph 1	200~300	2	230	II
P-122	Paragraph 1 stroke of trimming	Paragraph 1 stroke of trimming	0~100	1	40	II
P-123	Start trimming angle of Paragraph 2	Start trimming angle of Paragraph 2	250~360	2	330	II
P-124	Paragraph 2 stroke of trimming	Paragraph 2 stroke of trimming	0~100	1	65	II
P-125	Stop and trimming during fixed-length sewing	0.invalid 1.valid	0/1	1	0	II
P-126	loose thread enable when start sewing	0.invalid 1.valid	0/1	1	1	II

No.	Parameter	Description	Setting range	Step	Default	Lvl
P-127	Delay before start-sewing loose thread	Delay before start-sewing loose thread	0~1000	10	100	II
P-128	Action time of loose thread when start-sewing	Action time of loose thread when start-sewing	0~1000	10	200	II
P-129	Display backlight brightness Setting	Display backlight brightness Setting	0~10	1	5	I
P-135	Midway reverse function selection	0: unavailable 1: available	0~1	1	0	I
P-136	The number of midway stitch set	Pin setting	1~50	1	4	I
P-137	Seam midway down the number of times back and forth set	Set times	1~10	1	1	I
P-140	Delay time before thread hooking of Anti-nest	The delay time between the end of trimming and the hook	0~500ms	5	50	II
P-141	Thread hooking time of Anti-nest	The action time of the hooked electromagnet	0~500ms	5	50	II
P-142	Delay after Anti-nest hook	The delay time of the hook electromagnet turning off	0~500ms	5	50	II
P-143	Thread hooking duty ratio of Anti-nest	Adjust the action force of the hooked electromagnet	0~100	1	100	II
P-144	Anti-nest suction work time	The work time of the suction valve	0~2000ms	10	250	II
P-145	Thread-straight work time of Anti-nest	The work time of a thread-straight solenoid	0~500ms	5	50	II
P-150	Maximum needle pitch setting	Maximum needle pitch setting	10~100mm	1	80	II
P-151	First off-line prevented stitch length	0.invalid 1.valid	0~1	1	0	II
P-152	First off-line prevented stitch length setting	Stitch length setting Parameter range (1.0mm~5.0mm)	10~50	1	40	II
P-153	Head button inching mode setting	0: Invalid 1: valid(Press once valid ,press again cancel, such as close sewing, over thickness, presser foot)	0~1	1	0	II

No.	Parameter	Description	Setting range	Step	Default	Lvl
P-154	Machine head reverse sewing button type selection	0: Normal switch 1: Travel switch	0~1	1	0	Ⅲ
P-158	Setting the number of the rear dense needle	Setting the number of the rear dense needle	1~10	1	1	II
P-159	Setting the needle spacing of the rear dense needle	Setting the needle pitch for back stitch sewing	50~150	1	110	II
P-161	1/2 Needle filling button function setting	0: Reverse sewing 1: Tight sewing 2:1/2 Needle filling 3: Foot lifting and pressing	0~3	1	2	II
P-162	1/4 needle filling button function setting	0: Reverse sewing 1: Tight sewing 2:1/2 Needle filling 3: Foot lifting and pressing	0~3	1	2	II
P-166	Front dense needle speed	Front dense needle speed setting	200~3000	100	1500	II
P-167	Rear dense needle speed	Rear dense needle speed setting	200~3000	100	600	II
P-169	Adjusting the position of the presser foot to be lifted	This parameter can be used to adjust the position of the presser foot crank when the presser foot is lowered	0~100	1	30	II
P-170	Compensate system enablement by speed	=0, P171~P176 Invalid parameter, =1, P171~P176 valid parameter	0～1	1	1	II
P-171	Speed clockwise sewing compensation	Speed clockwise sewing compensate system	50～150	1	100	II
P-172	Speed anti-clockwise sewing compensation	Speed anti-clockwise sewing compensate system	50～150	1	100	II
P-173	Starting reinforcing-sewing speed Clockwise sewing compensation	Speed Clockwise sewing compensation coefficient	50～150	1	100	II
P-174	Starting reinforcing-sewing speed Anti-clockwise sewing compensation	Speed Anti-clockwise sewing compensation coefficient	50～150	1	100	II

No.	Parameter	Description	Setting range	Step	Default	Lvl
P-175	ending reinforcing-sewing speed Clockwise sewing compensation	Speed Clockwise sewing compensation coefficient	50～150	1	100	II
P-176	ending reinforcing-sewing speed Anti-clockwise sewing compensation	Speed Anti-clockwise sewing compensation coefficient	50～150	1	100	II
P-177	Button needle filling mode	0: Continuous half stitch 1: Continuous one stitch 2: Half stitch 3: One stitch	0～3	1	3	I
P-178	Button 1/2 needle filling mode	0: Continuous half stitch 1: Continuous one stitch 2: Half stitch 3: One stitch	0～3	1	3	I
P-179	Button 1/4 needle filling mode	0: Continuous half stitch 1: Continuous one stitch 2: Half stitch 3: One stitch	0～3	1	3	I
P-180	Compensate system enablement by stitch length	=0, P181~P200 Invalid parameter =1, P181~P200 valid parameter	0~1	1	1	II
P-181	1mm Clockwise sewing compensation	1mm Clockwise sewing compensation coefficient	50～150	1	100	II
P-182	1mm Anti-clockwise sewing compensation	1mm Anti-clockwise sewing compensation coefficient	50～150	1	100	II
P-183	2mm Clockwise sewing compensation	2mm Clockwise sewing compensation coefficient	50～150	1	100	II
P-184	2mm Anti-clockwise sewing compensation	2mm Anti-clockwise sewing compensation coefficient	50～150	1	100	II
P-185	3mm Clockwise sewing compensation	3mm Clockwise sewing compensation coefficient	50～150	1	100	II
P-186	3mm Anti-clockwise sewing compensation	3mm Anti-clockwise sewing compensation coefficient	50～150	1	100	II
P-187	4mm Clockwise sewing compensation	4mm Clockwise sewing compensation coefficient	50～150	1	100	II
P-188	4mm Anti-clockwise sewing compensation	4mm Anti-clockwise sewing compensation coefficient	50～150	1	100	II

No.	Parameter	Description	Setting range	Step	Default	Lvl
P-189	5mm Clockwise sewing compensation	5mm Clockwise sewing compensation coefficient	50～150	1	100	II
P-190	5mm Anti-clockwise sewing compensation	5mm Anti-clockwise sewing compensation coefficient	50～150	1	100	II
P-191	6mm Clockwise sewing compensation	6mm Clockwise sewing compensation coefficient	50～150	1	100	II
P-192	6mm Anti-clockwise sewing compensation	6mm Anti-clockwise sewing compensation coefficient	50～150	1	100	II
P-193	7mm Clockwise sewing compensation	7mm Clockwise sewing compensation coefficient	50～150	1	100	II
P-194	7mm Anti-clockwise sewing compensation	7mm Anti-clockwise sewing compensation coefficient	50～150	1	100	II
P-195	8mm Clockwise sewing compensation	8mm Clockwise sewing compensation coefficient	50～150	1	100	II
P-196	8mm Anti-clockwise sewing compensation	8mm Anti-clockwise sewing compensation coefficient	50～150	1	100	II
P-197	9mm Clockwise sewing compensation	9mm Clockwise sewing compensation coefficient	50～150	1	100	II
P-198	9mm Anti-clockwise sewing compensation	9mm Anti-clockwise sewing compensation coefficient	50～150	1	100	II
P-199	10mm Clockwise sewing compensation	10mm Clockwise sewing compensation coefficient	50～150	1	100	II
P-200	10mm Anti-clockwise sewing compensation	10mm Anti-clockwise sewing compensation coefficient	50～150	1	100	II
P-246	Pattern fixed sewing function	Pattern fixed sewing function; 0: Off, 1: On	0~1	1	0	I

Note: The parameters in the table are standardized. May not reflect reality.

NOTES

Dealer: