

CONTROL PANEL MANUAL

WALKER 6F

Automatic industrial lockstitch sewing
machine with walking feed

HD *texi*

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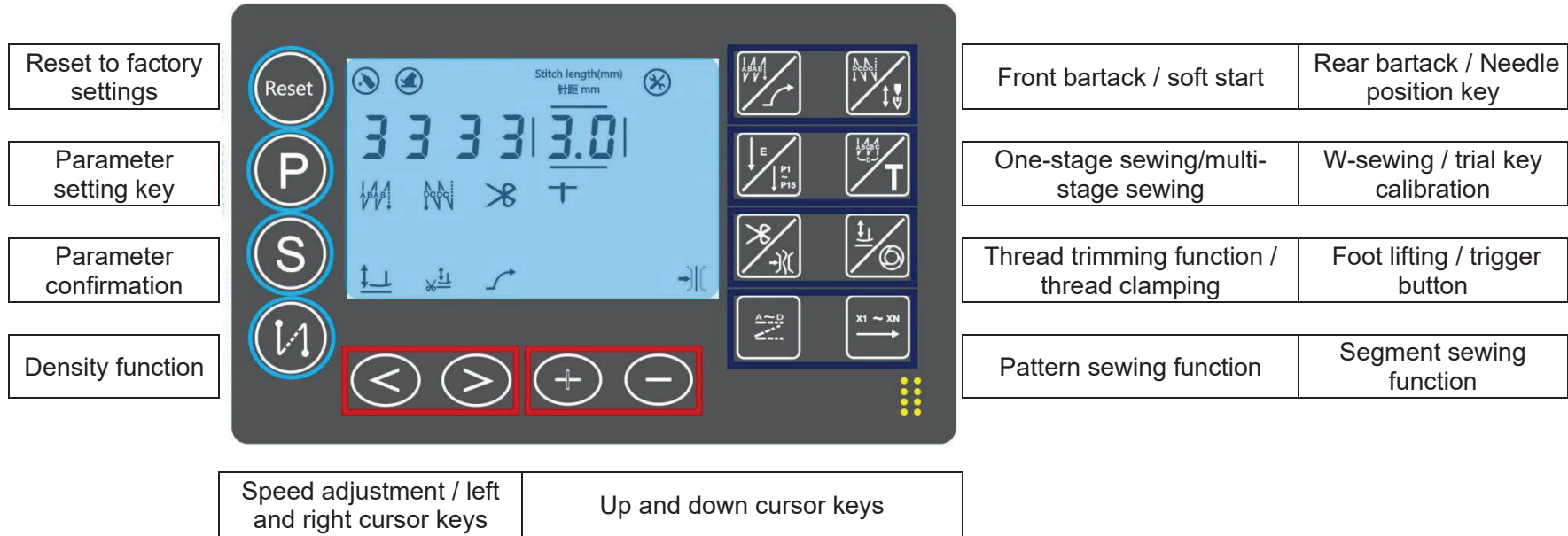
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1. Panel and operation introduction

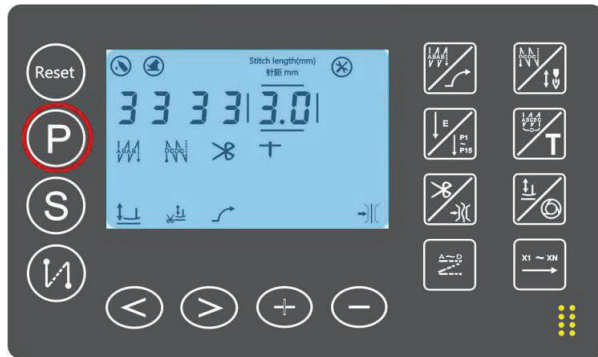


2. Introduction to basic parameter functions

No.	Parameter description
1	Parameter adjustment
2	Speed adjustment
3	Front and back seams
4	Thread trimming/clamping function
5	Presser foot lift function
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7	Restore factory settings
8	Modification of the fastening pattern
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10	A seam
11	Multi-section seam
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13	Continuous seam
14	Self-editing mode for segment seam patterns
15	Close stitch/machine head button function
16	Adjustment of needle stop position for thread trimming
17	Monitoring/piece counting mode
18	Spindle motor angle adjustment
19	Stepper motor zero adjustment
20	How to adjust the presser foot
21	Fault Codes
22	Parameter Introduction
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2. Introduction to basic parameter functions

2.1 Parameter adjustment

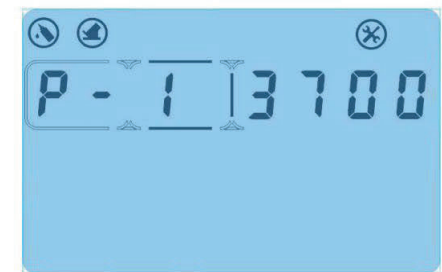


Parameter adjustment

Enter different parameter levels
(parameters are divided into 2 levels)

1.Normal parameters :

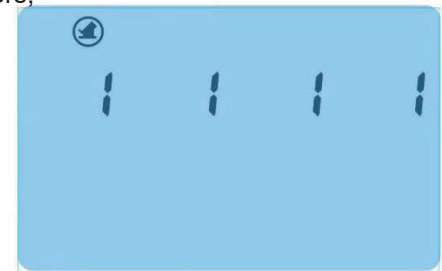
- Long press P key to enter parameter mode,
- **Press + -** key to select parameter,
- Press S key to confirm parameter



- After modifying the parameters with **the + -** key,
- Press the S key to save
- Press P to exit

2.Advanced parameters:

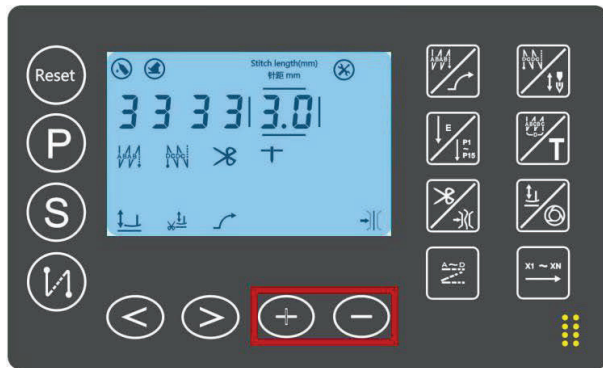
- Press and hold the P key for 5 seconds to enter the advanced parameters,
- **Enter the password 1111,**
- **press the S key to confirm.**
- **Press + -** key to select the parameter
- Press S key to confirm the parameter



- After modifying the parameters with the +- keys,
- press S to save Press P to exit

2. Introduction to basic parameter functions

2.2. Stitch length adjustment



Needle length/pattern adjustment

Enter different parameter levels (parameters are divided into 2 levels)

1. Needle length adjustment

- Normal mode
- Press + - to adjust the stitch length,
- the stitch length is 0-10mm.
- When the stitch length is increased to the maximum setting, enter the pattern sewing mode.



Note: Enter the password to enter the parameters: P-91:
Stitch length is locked, the stitch length cannot be modified
P-150: Maximum needle distance setting, 0-10mm At this time: set according to the factory regulations of the machine

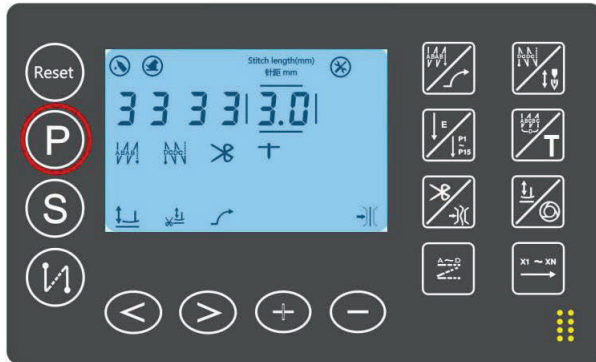
2. After the pattern

- adjustment stitch length is increased to 10mm,
- continue to press the + key to select pattern d1-d9
- press the S key to confirm.



2. Introduction to basic parameter functions

2.3. Speed adjustment

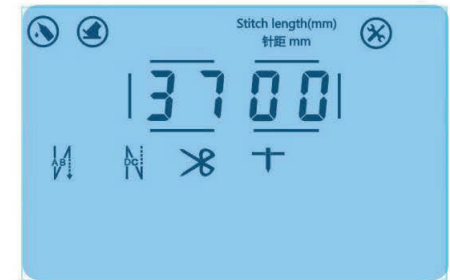


Speed adjustment

- Normal mode: Directly adjust by increasing or decreasing the speed.
- P-1 parameter: Normal mode maximum speed setting
- P-80 advanced parameters: maximum speed lock

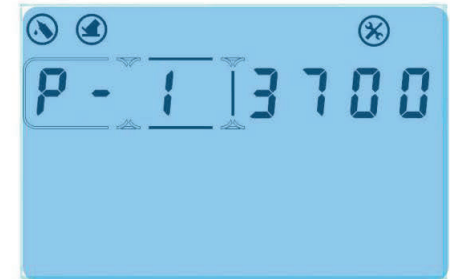
1.Speed adjustment

- Operation panel
- Press the <> key to increase or decrease the speed



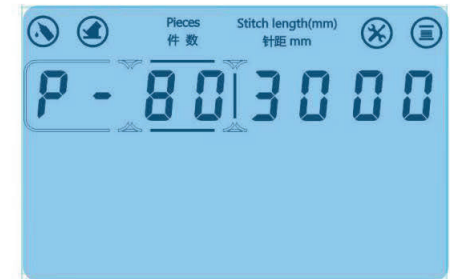
2.Maximum speed setting:

- Long press the P key
- Select P-1
- Press S key to confirm
- Set the maximum speed in normal mode
- Press S to save, press P to exit



3.Maximum speed lock

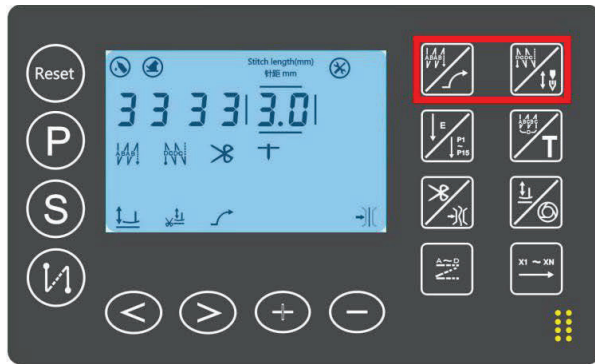
- Press and hold the P key for 6 seconds
- Enter the password 1111
- Press S to confirm
- Select P-80 - maximum speed lock.
- Press S to confirm the maximum speed lock.
- Press S to save, press P to exit



Note: After modifying the P-80 speed, you need to modify the P-1 speed. Then, in the normal operation interface, press the speed key to adjust the speed.

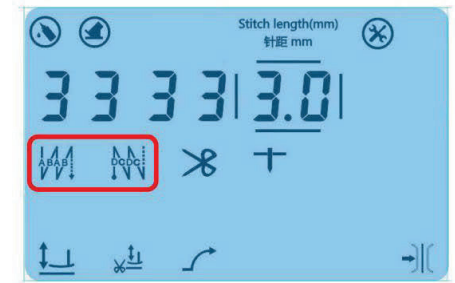
2. Introduction to basic parameter functions

2.4. Front and back seams



1. Front/rear bartacking

There are four front bartack types for front and rear fixation seam. Press bartack button to switch model



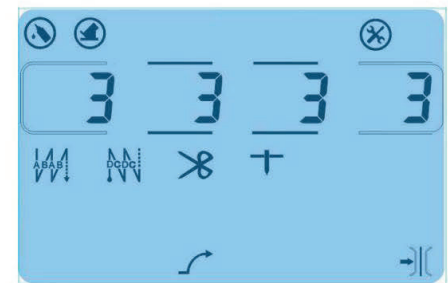
Front and back seams

1. The front and rear sewing modes can be modified, and the corresponding number of sewing stitches can be changed.

2. The stitches do not overlap. Please refer to the following page to adjust the P-8 parameter.

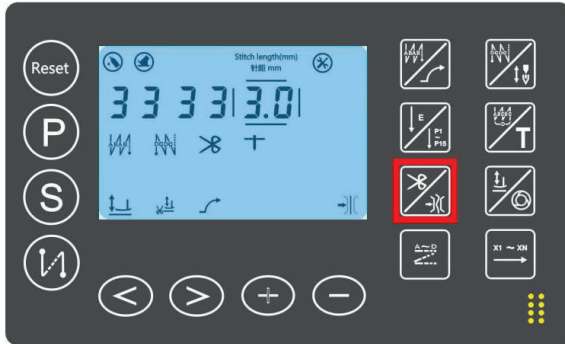
2. Setting the number of stitches for sewing

- Press the S key to enter the settings interface
- Press the < > key Select segments A, B, C and D in sequence
- Press the + - key
- Modify the number of needles in segments ABCD in sequence
- After changing, press S to return to the normal interface.



2. Introduction to basic parameter functions

2.5. Thread trimming/clamping function

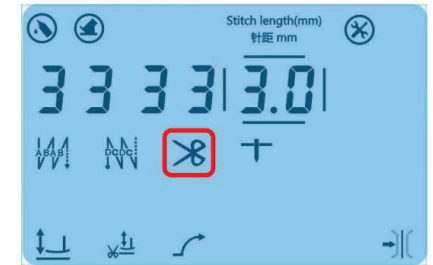


**Thread trimming
/thread clamping function**

1. Short press: scissor function on and off
2. Long press: Turn the clamp function on and off
3. Long press the S key: Adjust the clamp strength

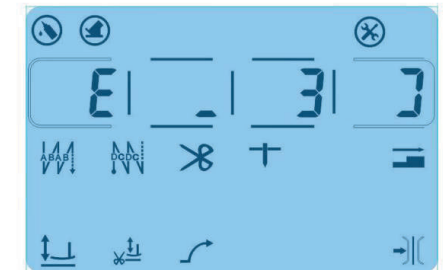
1. Thread trimming/thread clamping

- Short press to turn the thread trimming function on or off
- Long press to turn the clamp function on or off



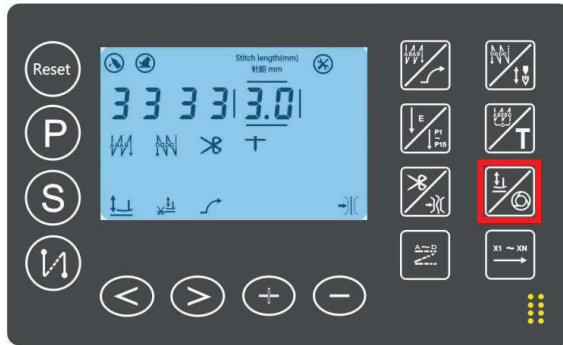
2. Adjustment of the clamping force

- For models with clamp function, long press S key to display the clamp strength 1-9.
- The larger the number, the greater the strength.
- Press S key again to exit.



2. Introduction to basic parameter functions

2.6. Presser foot lift function



2. Introduction to basic parameter functions

- Long press the P key
 - select parameter P-25
 - change parameter value to:
- 0: No presser foot lift
 1: Presser foot lift
 2: Presser foot lift is prohibited during sewing, but can be lifted when trimming



Presser foot lift function

1. Adjust the pressure of the sewing machine pressure regulating nut to obtain different
2. Short press cycle: pause in the middle and lift the presser foot/Lift the presser foot after trimming/Lift the presser foot after trimming/Close

2. Introduction to basic parameter functions

Long press the P key, enter the password 1111, and select the parameters related to the presser foot adjustment:

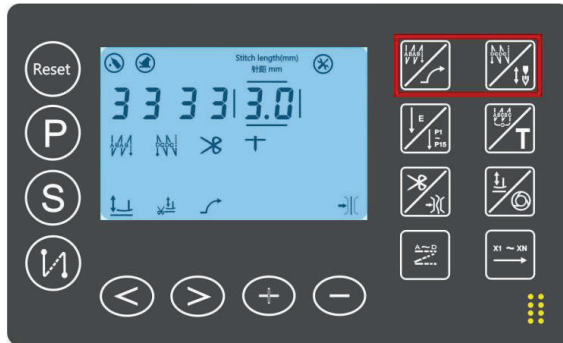
P-12: Presser foot lifting first angle (sound adjustment)
 P-13: Presser foot height adjustment
 P-14: Presser foot lifting speed
 P-15: Presser foot release speed
 P-16: The first angle of the presser foot

Note: Depending on the sewing fabric, the sound of the presser foot, the height of the presser foot, etc. can be adjusted by combining parameters.

2. Introduction to basic parameter functions

2.7. Soft start/up and down needle position

2. Introduction to basic parameter functions



1. Soft start

- Long press:
- soft start function on and off
- P-2 sets the number of soft start stitches
- P-21~23 set soft start speed



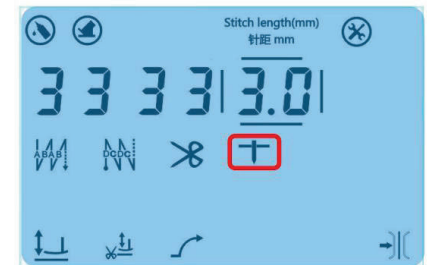
Soft start/up and down needle position



1. Turn on the soft start function to effectively avoid the thread from coming off when sewing. If not needed, turn it off.
2. Try to adjust the needle stop position appropriately. Solve the problem of seam derailment.

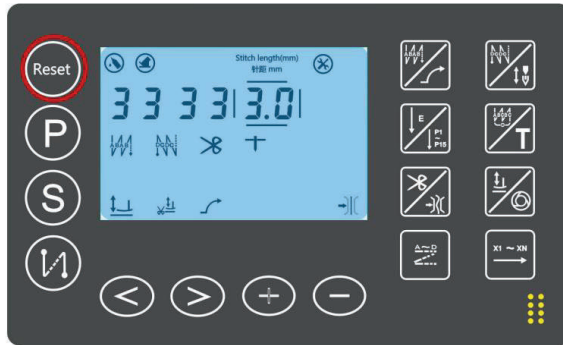
2. Upper and lower needle positions

- Long press the up/down needle stop button to select up needle stop or down needle stop
- P-69 Set the lower needle stop position



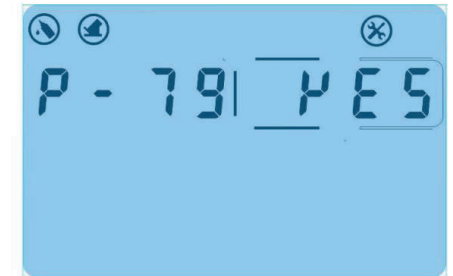
2. Introduction to basic parameter functions

2.8. Restore factory settings



1. One-click recovery

- Long press the Reset button to restore all parameters in the parameter table.

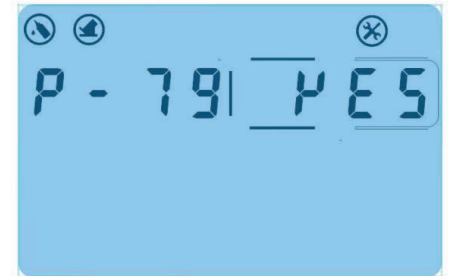


Restore factory settings

1. Fully restore the function parameters set on the operation screen and the parameters set in the parameter table
2. If you need to make all-round adjustments to the machine and confirm the best state, you can use P-131 parameter saving to restore to this state later

2. Secondary parameter recovery

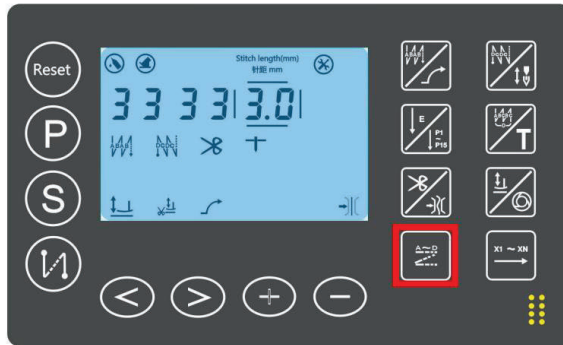
- In the normal operation interface:
- long press the P key
- enter the parameter mode, select P-79,
- Press S to confirm
- Change 0 to 8.
- When the screen displays YES, press S to confirm and P to exit.



3. Special seams and functions

3.1. Pattern editing mode

2. Introduction to basic parameter functions



Pattern Editing Mode

1. Customized modifications can be made to the factory preset H1-H9 patterns

Brief description:

① Consider each pattern first, how many stitches should be taken, reverse stitch, and how many times should be repeated back and forth?

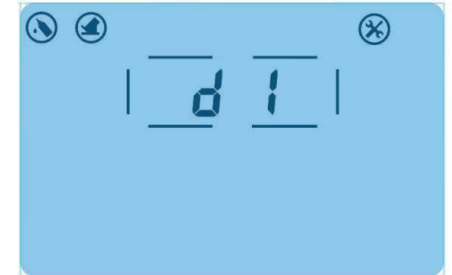
② Normally, the number of repetitions is 3 or 5. If the pattern is not full enough, try 7, 9, 11...

If you want to go straight, you don't need to reverse stitch the pattern, and select 1 for the number of repetitions

③ Enter the appropriate stitch length for each pattern

1. Pattern selection

- In the normal operation interface, long press the pattern editing key
- press +-key to select the pattern you want to modify
- press S key to confirm.

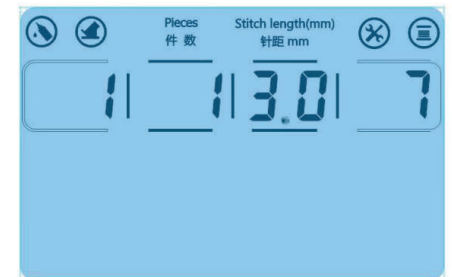


2. Set the pattern parameters

From left to right:

- set the number of segments
- number of needles, stitch length
- number of repetitions.

1 represents the first sewing content
1 represents 1 stitch
3.0 represents 3mm stitch length
7 represents reverse stitching and forward stitching repeated 7 times



1 = represents the number of segments
1 = represents the number of stitches
3.0 = represents the sewing stitch length
7 = repeat 7 times

3. Special seams and functions

3.1. Pattern editing mode

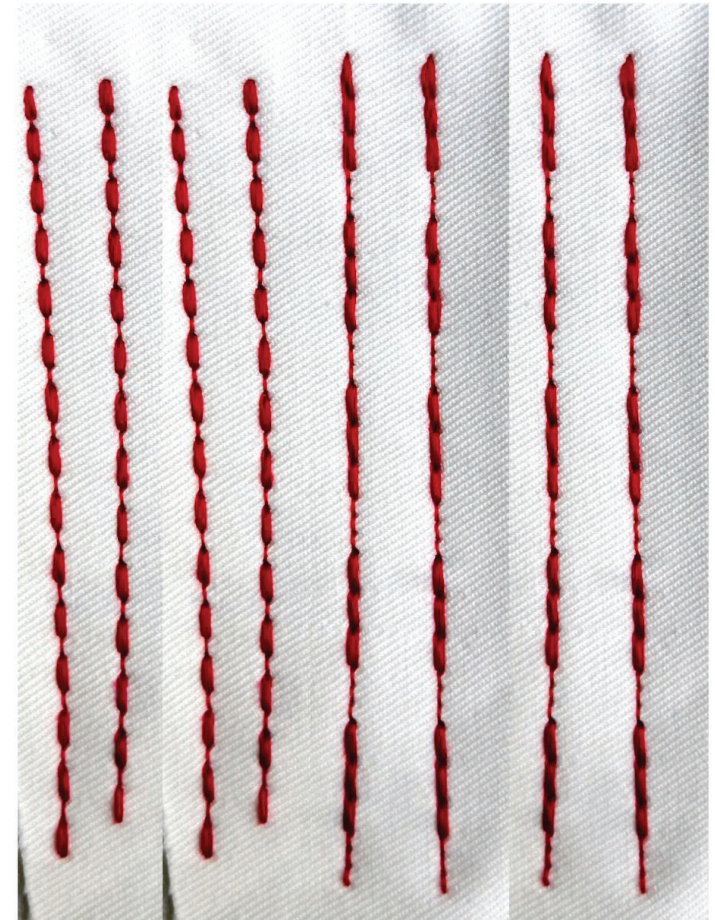
D2 pattern before modification (left)

Segments	Stitch length	Stitches	Repeat times
1	4mm	1	7
2	2mm	1	1



Modified D2 pattern (right)

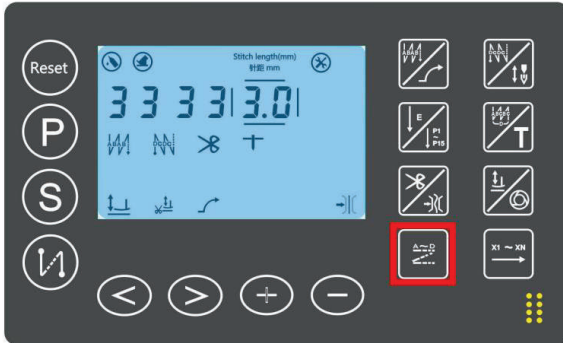
Segments	Stitch length	Stitches	Repeat times
1	4.2mm	3	7
2	2mm	3	1



3. Special seams and functions

3.2. Front and rear tacking pattern settings

2. Introduction to basic parameter functions

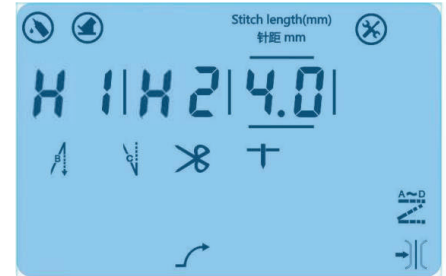


Front and rear tacking pattern settings

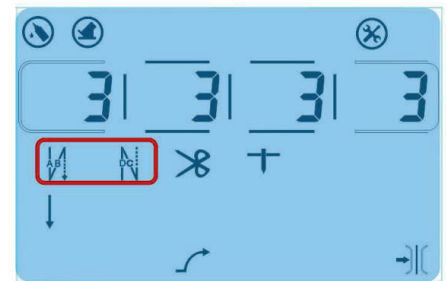
1. When this function is turned on, the front and back seams are sewn according to the self-edited pattern.

1. Front and rear bartacking patterns

- In the normal operation interface
- short press the tacking pattern key, and the selected pattern can be used as the front tacking and rear tacking
- Press S to enter
- < > to select front and back tacking.
- Press + - to modify the front and back tacking patterns. Press S to save after selection.
- Press S to exit.



The front tacking uses the H1 pattern and the rear tacking uses the H2 pattern

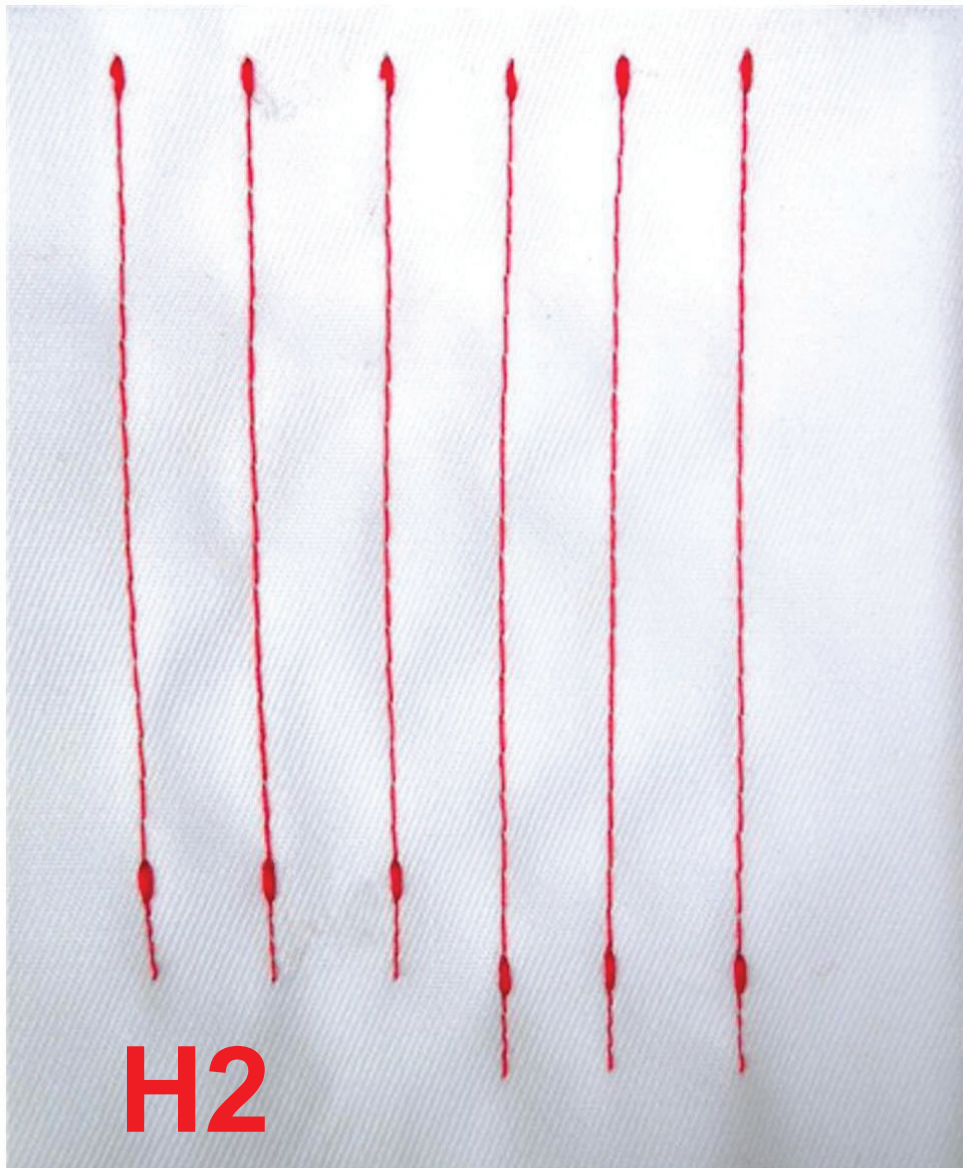


3. Special seams and functions

3.2. Front and rear tacking pattern settings

- Note: 1. For front fixing, use H1 pattern (pattern sewing)
2. Use H2 pattern (pattern sewing) for rear fixing

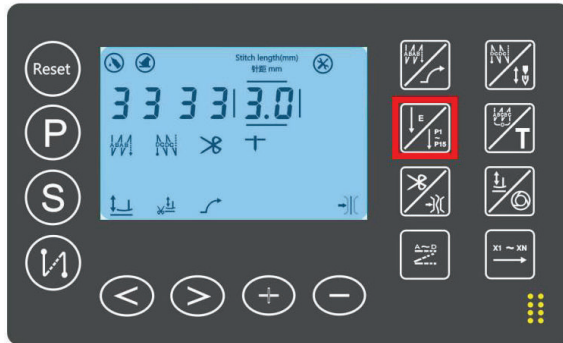
H1



H2

3. Special seams and functions

3.3. One-stage sewing



One-stage sewing

Cycle: One-stage sewing/Multi-stage sewing/Free sewing

Set the number of stitches for one stage, the range can be set from 0 to 99 stitches

Note: Press  to automatically sew a single stage.

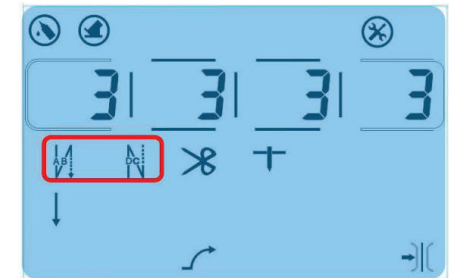
1. Needle length setting

Press the segment sewing key once to enter a segment sewing.
Use the + - key to set the fixed needle distance.



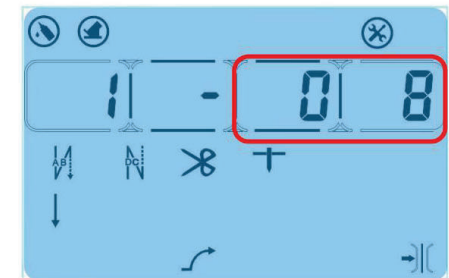
2. Backstitch stitch number setting

Press the S key to set the number of stitches for the reverse sewing in this mode.



3. Setting the number of fixed needles

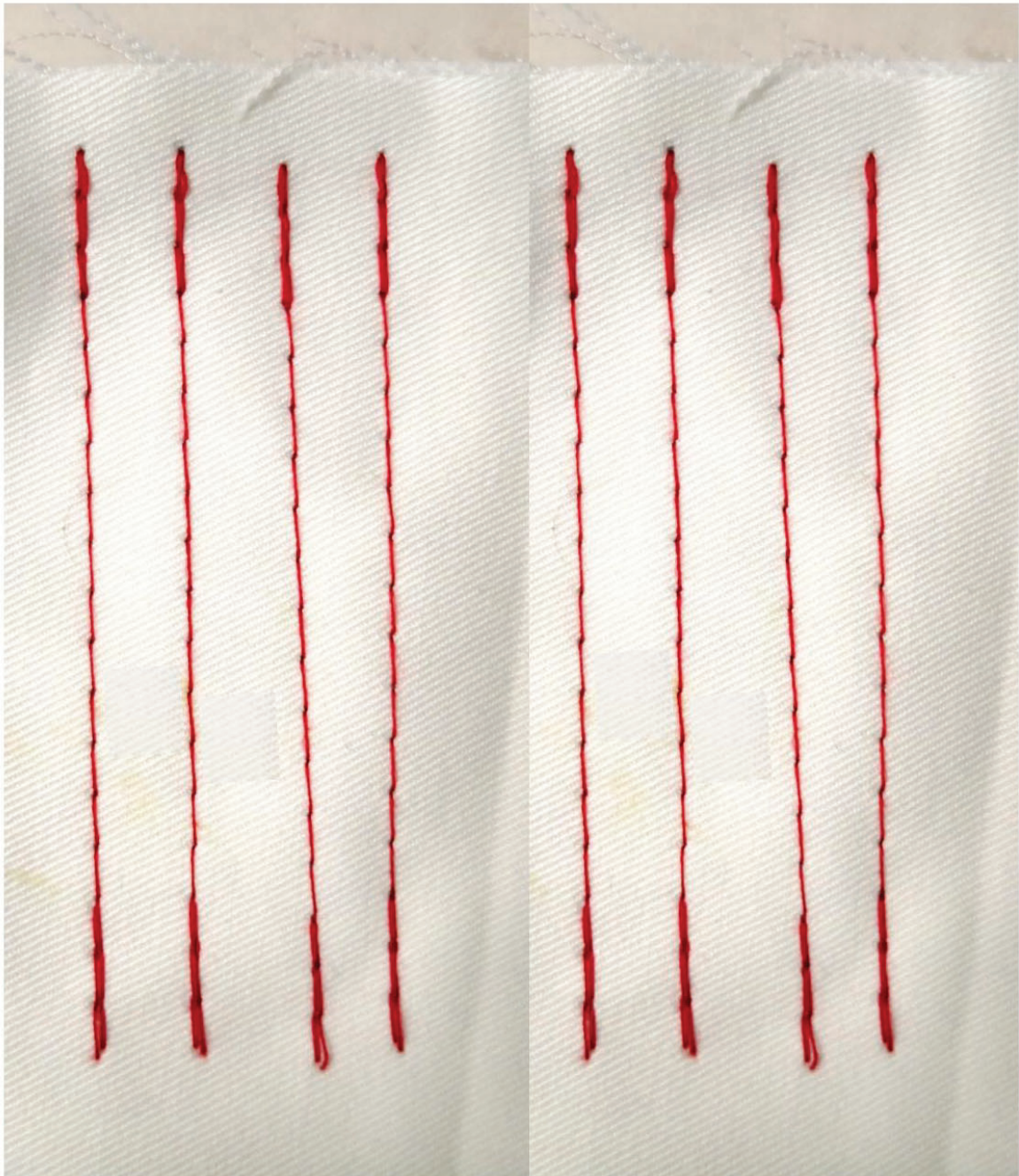
Press the S key to set the number of sewing stitches in this mode.



3. Special seams and functions

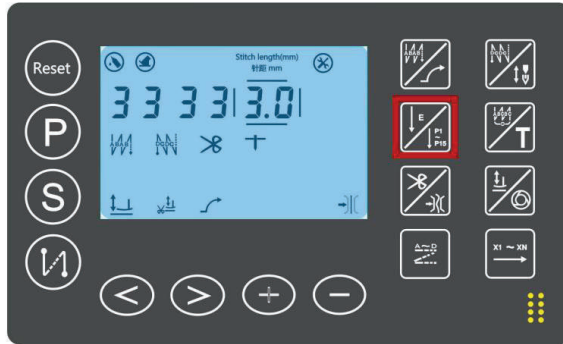
3.3. One-stage sewing

Note: 1) 3 stitches for front and rear bartack seams
2) Fixed stitch seam 18 stitches



3. Special seams and functions

3.4. Multi-section seam

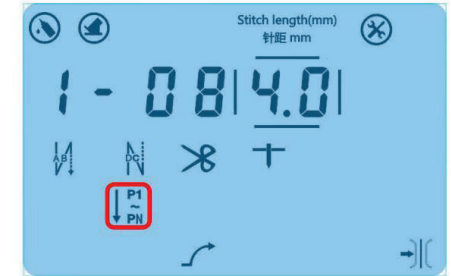


Multi-section seam

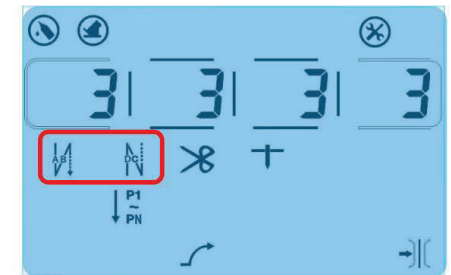
Cycle: One-stage sewing/multi-stage sewing/free sewing.
Set the number of stitches for multiple stages, and set the range for each stage 0-99 stitches

Note: Press  button to sew automatically

1. Needle length setting Press the segment sewing key twice to enter the multi-segment sewing mode. Use the + - key to set the fixed needle length.

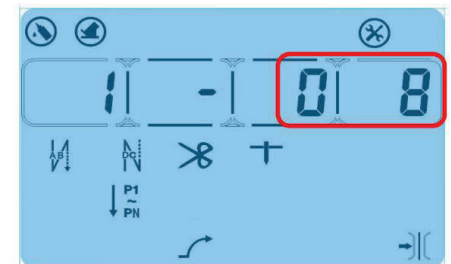


2. Backstitch stitch number setting Press the S key to set the head-to-tail reverse sewing mode and the number of stitches in this mode.



3. Setting the number of fixed needles

Press the S key to set the number of stitches per section in this mode.



3. Special seams and functions

3.4. Multi-section seam

Pattern Introduction:

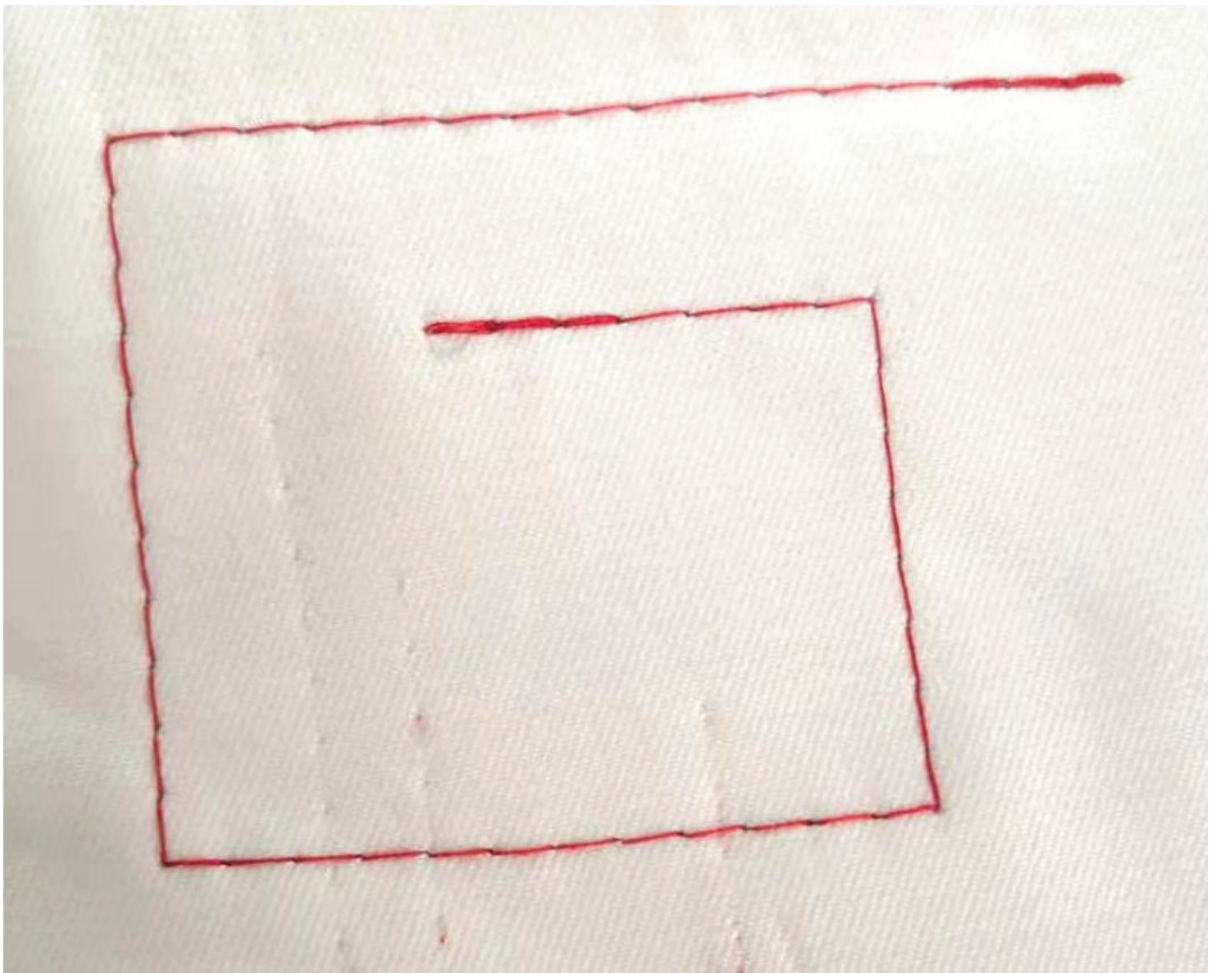
Section 1: Front bartack (3 stitches) + 16 stitches x 7mm

Stage 1: 11 stitches x 7mm

Stage 2: 12 stitches x 7mm

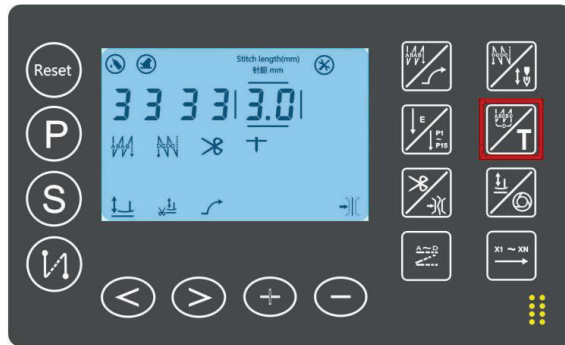
Section 4: 8 stitches x 7mm

Section 5: 12 stitches x 7mm + Rear bartack (3 stitches)



3. Special seams and functions

3.5. W-seam / test mode



W-seam / test mode

In multi-segment mode (long press the T key), 1–15 segments can be freely set—convenient and fast.

Simple Description:

With this method, you can perform a trial sewing once, and the electronic control will automatically record the number of stitches in each segment. You don't need to count the stitches one by one after the trial and then input them manually, which greatly improves efficiency.

1. Trial calibration mode

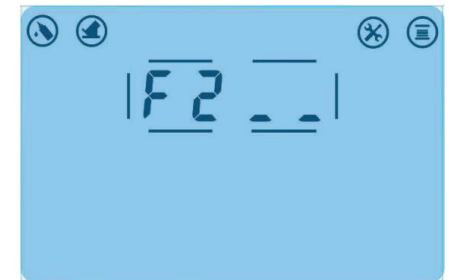
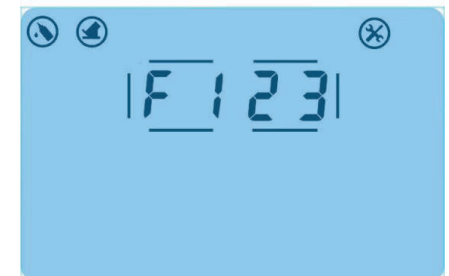
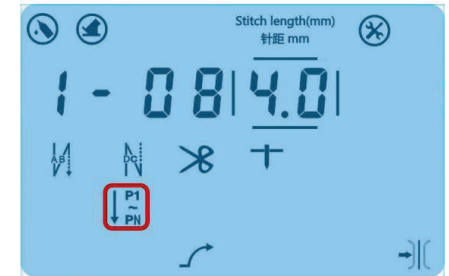
In the multi-segment sewing operation interface, long press the T key to enter the trial calibration mode.

2. Test the number of stitches.

Press the pedal to run until the required stitch length. The electronic control will automatically record the number of stitches. As shown in the figure, the number of stitches recorded in F1 is 23. You can use the + - key to modify the number of stitches as needed.

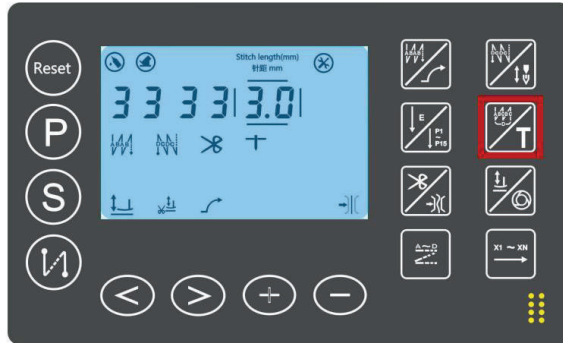
3. Multi-stage test calibration

Press the **> key to set the number of needles in the T2 stage**. Set the number of needles in each stage in turn. After setting the required number of stages, press the foot pedal to trim the thread and end the test calibration mode.



3. Special seams and functions

3.5. W-seam / test mode



W-seam / test mode

Short press cycle: W stitch/free stitch, mostly used for sewing labels

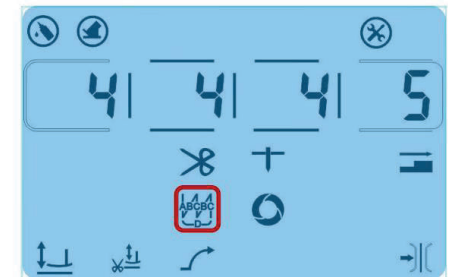
1. Stitch length for fastening

In the normal operation interface, short press the continuous sewing key + - to select the stitch length and press this key again to return to the free sewing interface.



2. Setting the number of stitches

Press the S key to switch to the adjustment of the number of stitches and the number of times of sewing. As shown in the figure, the number of stitches is 4, and the number of times of sewing is 5.

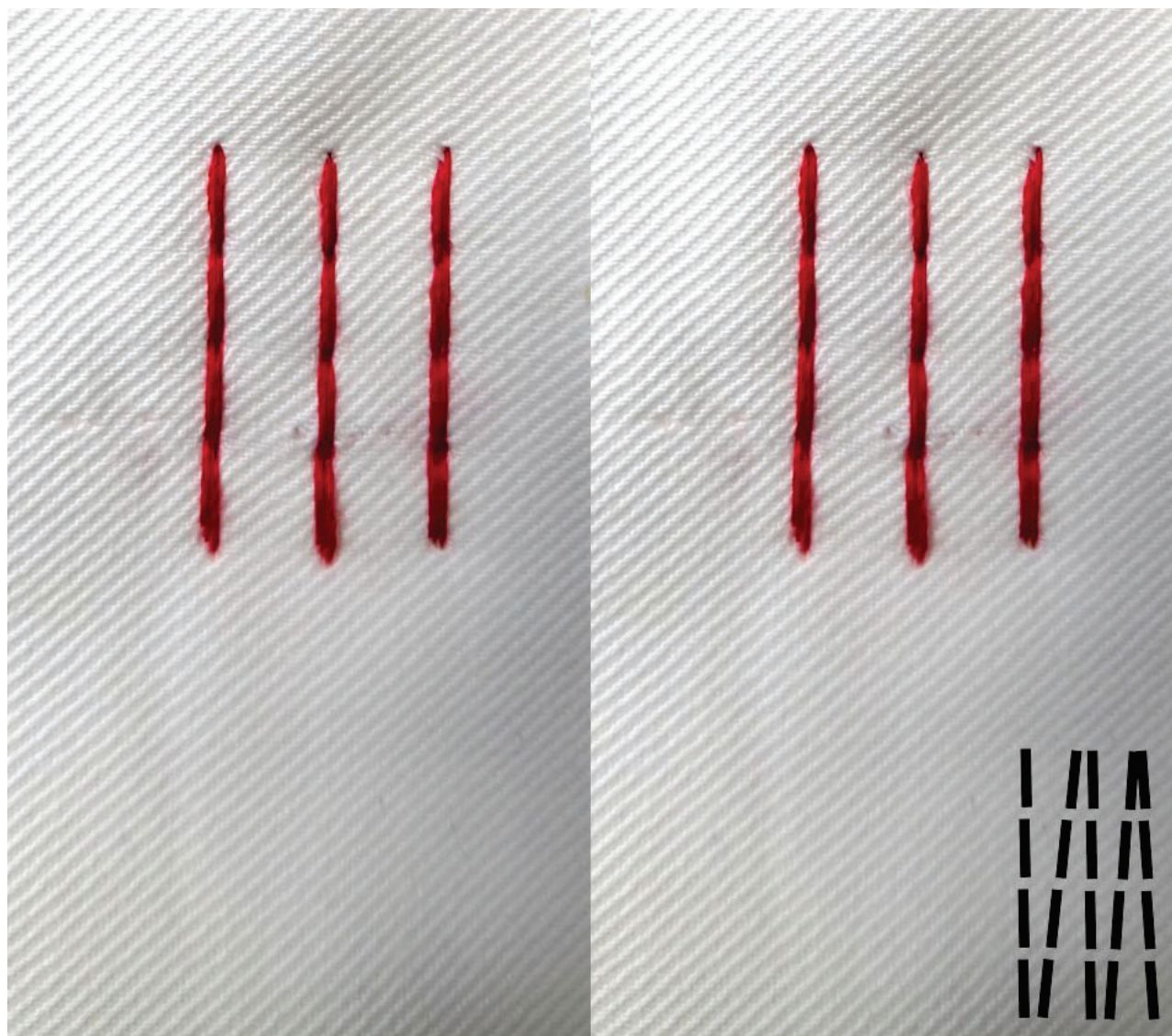


3. Special seams and functions

3.5. W-seam / test mode

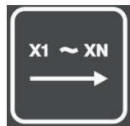
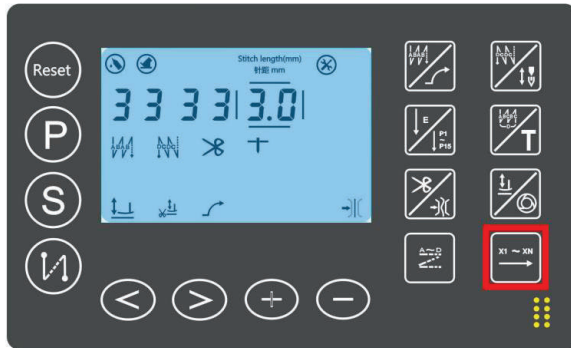
Note: 1) 4 stitches bartack

2) Go back and forth 5 times



3. Special seams and functions

3.6. Multi-section pattern seam

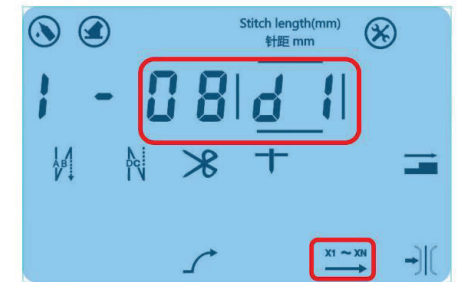


Multi-section pattern seam

1. Cycle: multi-section self-made pattern sewing/free sewing
2. Multiple sections of sewing can be set, and each section can be set with different pattern sewing or normal stitch length sewing.

1. Pattern setting

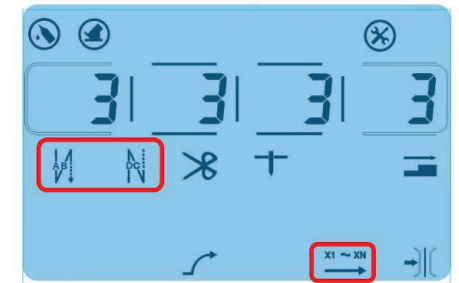
In the normal operation interface, press the segment seam pattern mode key to set the segment seam pattern. As shown in the figure, set the first segment to pattern D1 and sew 8 segments of pattern



2. Set the number of reverse stitches

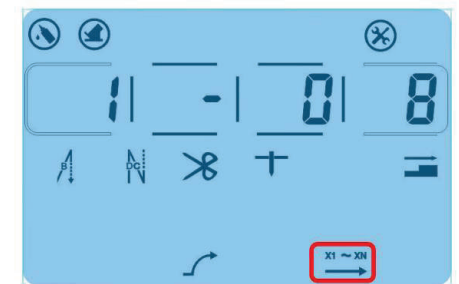
Press the S key to set the number of reverse stitches at the beginning and end of this mode.

If you do not need this function, please turn off the reverse stitching function.



3. Setting the number of stitches for each section

Press the S key to set the number of sewing stitches for each pattern segment in this mode.



3. Special seams and functions

3.6. Multi-section pattern seam

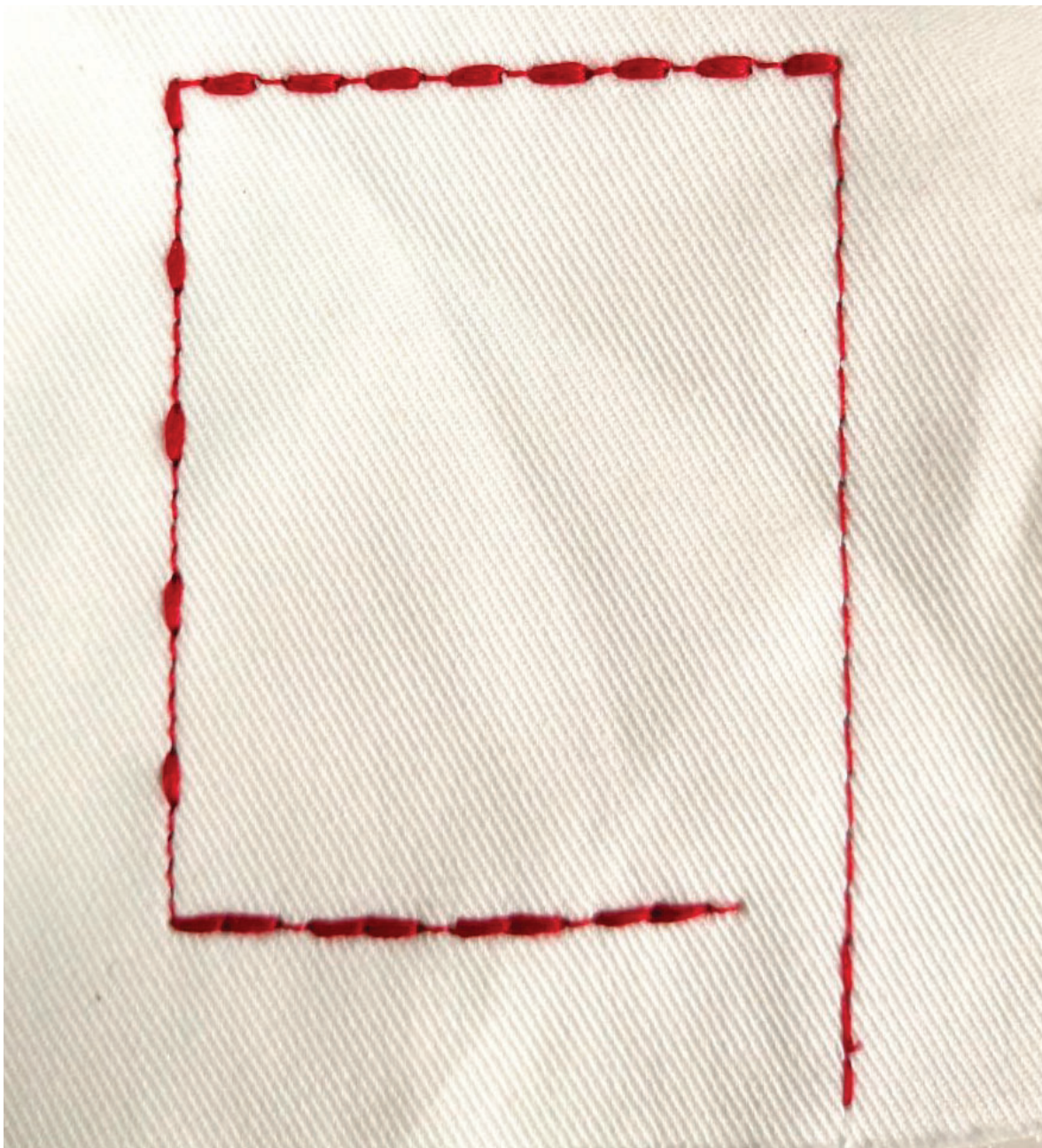
Pattern Introduction:

Section 1: Front bartack (3 stitches) + 18 stitches x 6mm

Section 2: Pattern type D1 x8 stitches

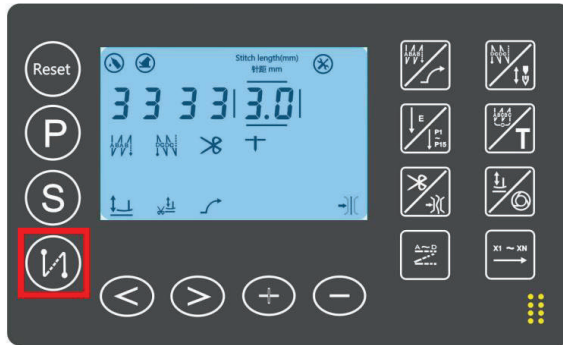
Section 3: Pattern type D2 x5 stitches

Section 4: Pattern type D3 x4 stitches



3. Special seams and functions

3.7. Dense stitch



1. Dense stitch function

In the normal operation interface, press the Dense Stitch key to turn the Dense Stitch function on or off.

Parameter P-78 – Dense Stitch mode setting

Parameter P-118 – Dense Stitch stitch number setting

Parameter P-119 – Dense Stitch distance setting



Dense stitch/machine head button function

Front reinforcement and mid-way dense stitches, beautiful stitches;

Reinforced dense stitches at the back, thread ends are short and thread will not fall off

2. Machine head button function

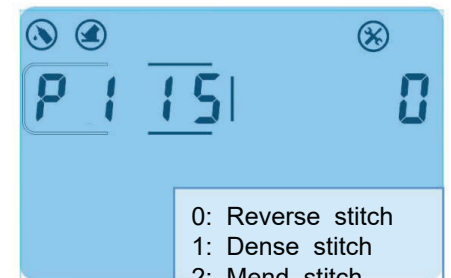
The machine head button can be configured as needed.

Function Parameter P-115 – Reverse stitch button function

Function Parameter P-116 – Filling needle button function setting

Function Parameter P-117 – Mid-way dense stitch distance setting

The original button can be assigned to any function.



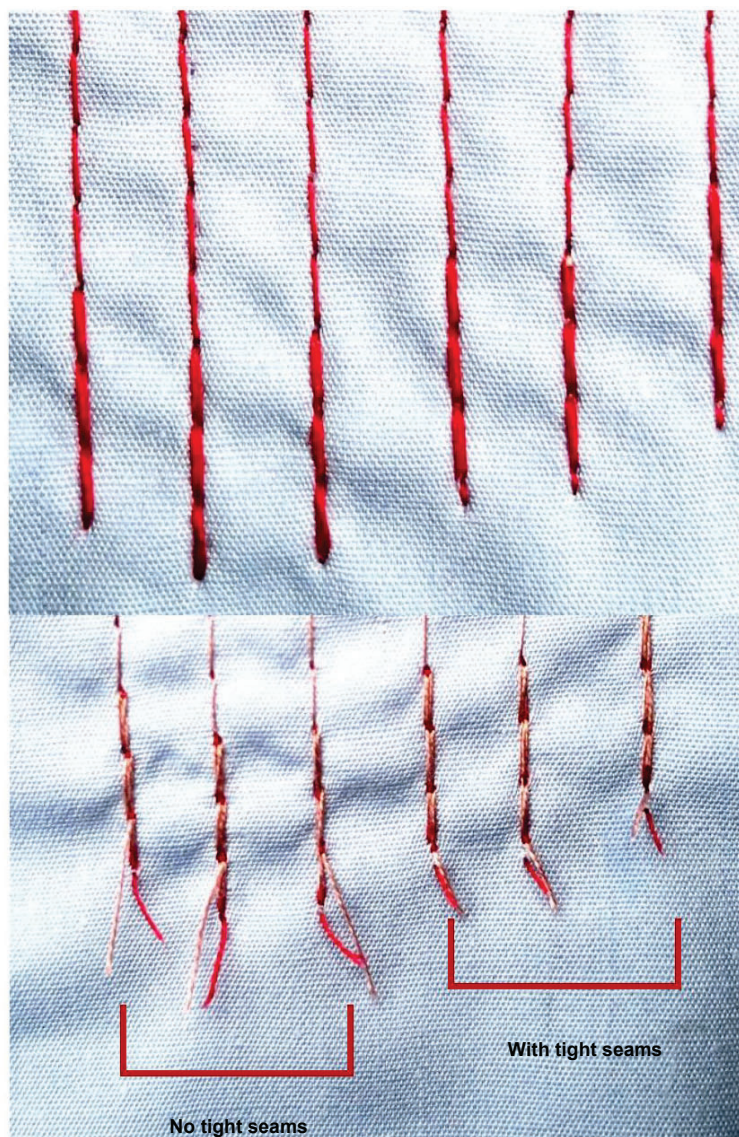
- 0: Reverse stitch
- 1: Dense stitch
- 2: Mend stitch
- 3: Reverse stitch + mend stitch

3. Special seams and functions

3.7. Dense stitch

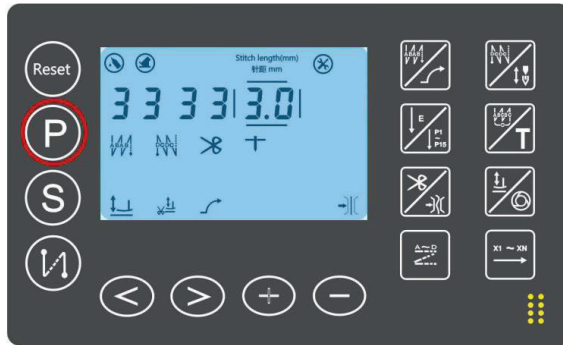
Compared to the normal sewing mode, the beautiful seam will be densely stitched after the post-fixing seam (with adjustable length between 1-1.5mm).

The thread end of the cutting line is less than 3mm



4. Main adjustments

4.1. Adjustment of needle stop position for thread trimming



Adjustment of needle stop position for thread trimming
Enter debugging through parameters and adjust the
needle stop position after thread trimming

1. Debugging Thread Trimming and Needle Stop Position

After completing the thread trimming action, follow these steps to enter the parameter mode and adjust the needle stop position:

1) Enter Parameter Mode:

Press and hold the P key to enter parameter mode.

Select P-75.

Press the S key to confirm.

2) Activate the Machine:

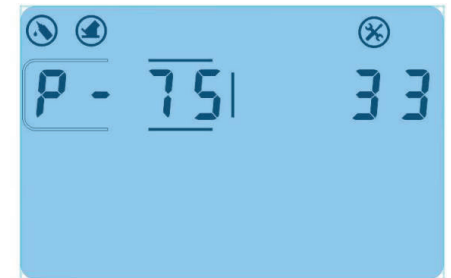
Press the pedal forward to run the machine.

3) Adjust Thread Trimming and Needle Stop Position:

Turn the handwheel for two full rotations.

Stop when the machine reaches the correct thread trimming and needle stop position:

- The thread take-up lever should be at its highest position.
- Then, rotate the handwheel backward until the take-up lever drops to 1 mm below the highest point.



4) Set the Needle Tip Position (depending on material):

For thin materials (DBx1): the needle tip should be 10 mm above the needle plate.

For thick materials (DPx5): the needle tip should be 12 mm above the needle plate.

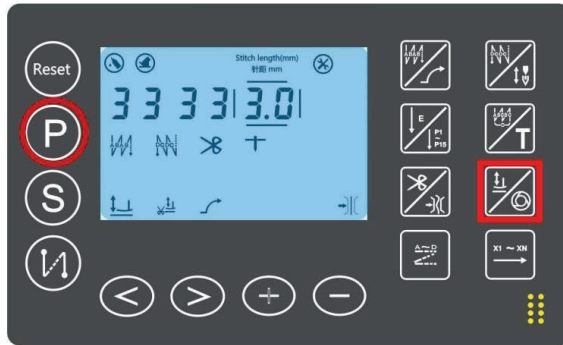
5) Save and Exit:

Press S to save the settings.

Press P to exit parameter mode.

4. Main adjustments

4.2. Monitoring/piece counting mode

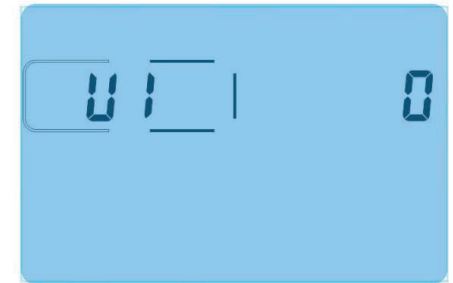


Monitoring/piece counting mode

Use monitoring and piece counting through key combinations and bottom line detection mode

1. Monitoring function

Press P key + trigger key at the same time, and use the combination function to monitor the current machine usage status



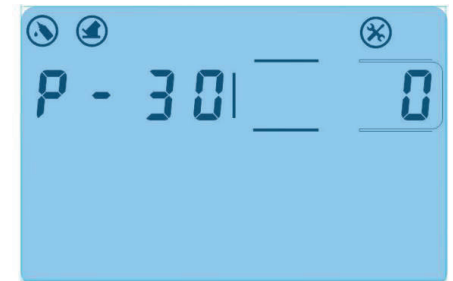
2. Piece counting function

Counts the number of jobs according to the number of thread trimmings. JJ piece counting increases
JP piece counting decreases



3. Bottom line monitoring function

Sets the length of the bottom line, and alarms when the line is used up. Parameter P-30
Bottom line counting on/off parameter
P-31 Bottom line initial value setting



4. Main adjustments

4.2. Monitoring/piece counting mode

1. General monitoring items

The system will monitor the current machine usage status at any time

For the manufacturer to provide technical support

3. Bottom line detection mode

2. Select the JJ or JP function in the list

Remarks: 1. Press and hold the  key for 3 seconds to clear the piece count (valid in monitoring mode)

2. P-35 parameter piece count multiplier (based on the number of thread trimmings)

3. P-38 parameter select piece count plus JJ / piece count minus JP function

4. Piece count error: PBOB

2. Piece count mode: count plus JJ / count minus JP

3. Select the DX function in the list

Remarks: 1. Press and hold the  key for 3 seconds to clear the bottom line count (valid in monitoring mode)

2. Parameter P-30 turns on the bottom line detection function

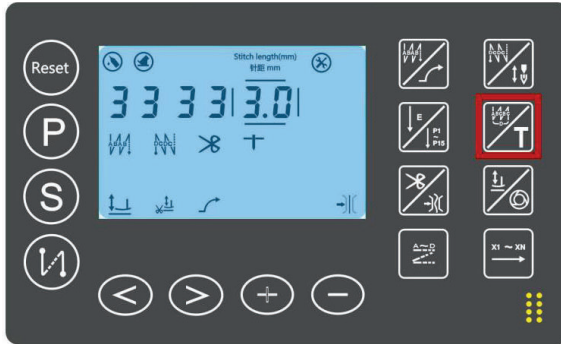
3. Parameter P-31 sets the bottom line initial value

4. Bottom line error: LBOB

Index No.	Description	Unit
U1	Motor Speed	rpm
U2	Chip Model (Factory Use)	GD/AT
U3	Bus Voltage	V
U4	Board Voltage	0.01V
U5	Head Mechanical Angle	degree
U6	Initial Motor Angle	degree
U7	Machine Head Model	JIA
U8	DSP Version	V100
U9	DSP Model	F73
U10	Stepper Version	V1xx
U11	Stepper Foot Current	0.01A
VER	HMI Main Chip Version	V1xx
TYPE	HMI Model	C104
AD1	Knee Sensor Voltage	1mV
AD2	Foot Pressure Sensor Voltage	1mV
H1	HMI Sub-Chip Version	V1xx
H2	Model	
JJ	Stitch Count (Increase)	pcs
JP	Stitch Count (Decrease)	pcs
DX	Baseline Detectioncm	

4. Main adjustments

4.3. Spindle motor angle adjustment



Spindle motor angle adjustment

1. Replacement of the spindle motor and encoder requires a running-in angle
2. The wrong angle of the motor will affect the performance.
3. There are runaway, errors, motor heating, and impact on use

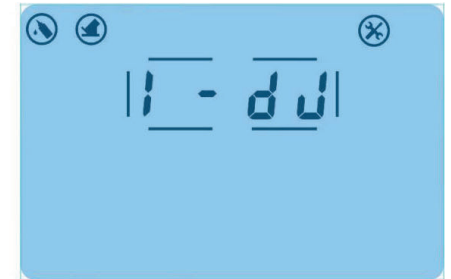
1. Run-in motor angle

In the normal operation interface, press and hold the T key to select 1-DJ running-in motor angle mode.

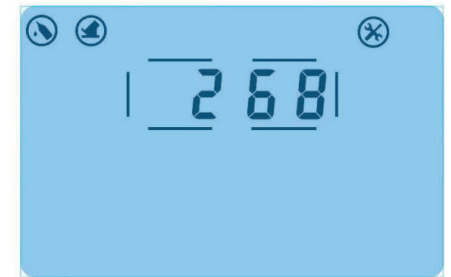
Step on the pedal to run in the motor angle.

The motor angle should be $268\pm5^\circ$.

After running in, press "P" to exit.



2. If the angle of the grating motor is abnormal, remove the rear cover and adjust the position of the motor grating. Adjust it once and run it once until it reaches within the range of $268\pm5^\circ$.



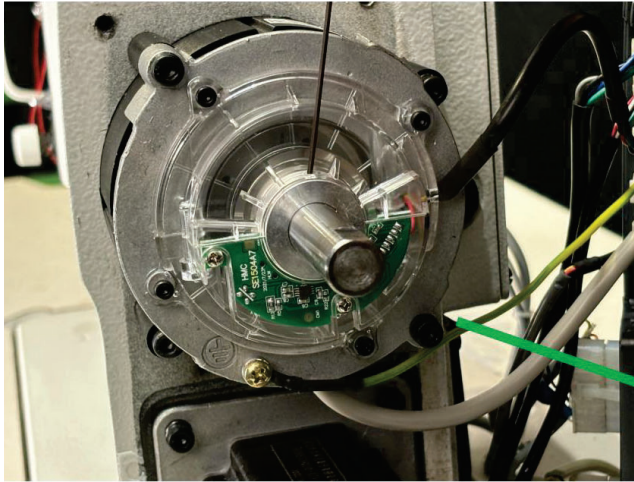
4. Main adjustments

4.4. Main motor zero adjustment

Adjust the angle of encoder disc (grating plate) of the motor positioner

The motor angle is abnormal. Remove the rear cover and adjust the motor grating position.

Adjust once and run once until it reaches the range of $268 \pm 5^\circ$



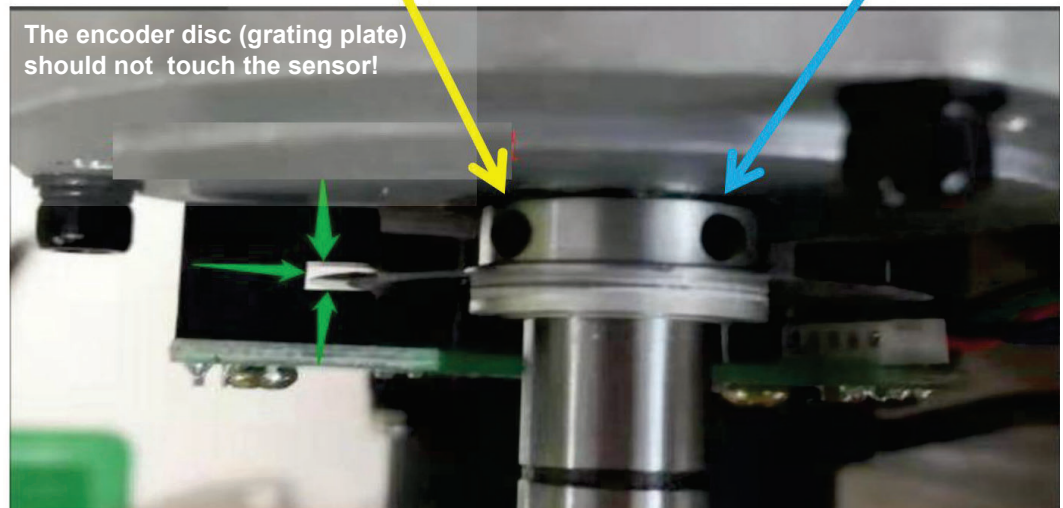
Grating rotates left

Grating rotates right

Angle becomes smaller

Angle becomes larger

The encoder disc (grating plate) should not touch the sensor!

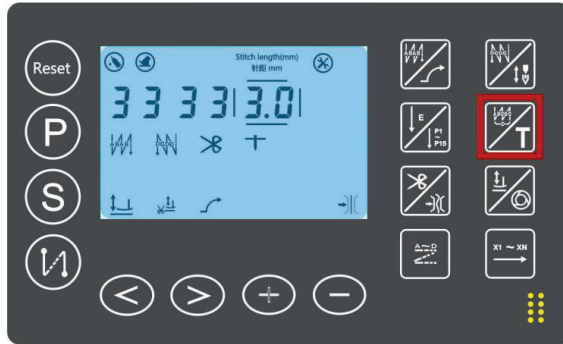


Run-in motor angle

1. Replacement of the spindle motor encoder requires running-in angle
2. Incorrect motor angle will affect performance, occasionally causing overshoot and error, affecting use.

4. Main adjustments

4.5. Feed motor zero adjustment



Step feed zero position adjustment

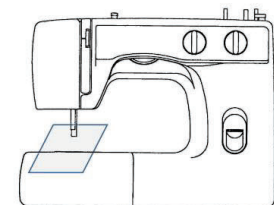
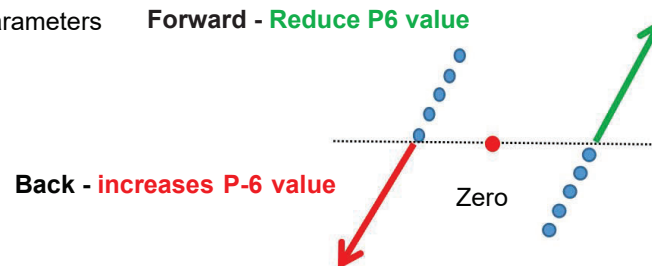
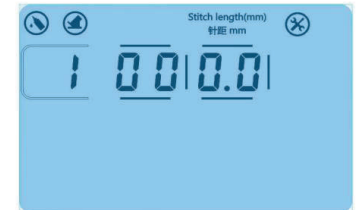
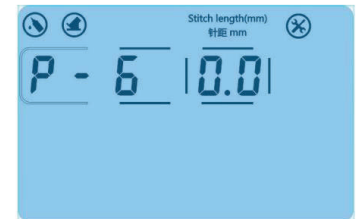
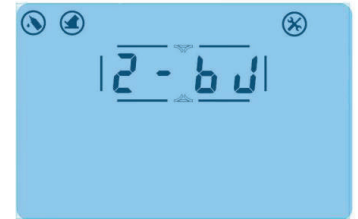
1. Incorrect step feed mechanical zero position will lead to uneven overall stitch lengths, misaligned stitches, and serious impact on sewing results
2. In the actual sewing process, the stitches may be unsightly due to fabric, operating habits, mechanical adjustments, etc., and can be fine-tuned with parameters

1. Step-feed zero position parameter debugging method:

- ① In the normal operation interface, press and hold the T key to select 2-BJ, press the S key
- ② Select P-6, 0.0 means the step-feed motor is zero at this time. Is the machine zero? Need to test.
- ③ Take a piece of white paper, put it on the presser foot, and step lightly on the 20 needles. The needle holes must overlap.
- ④ The needle holes do not overlap → adjust the percentage parameters and press the S key to save
- ⑤ The best percentage is between 90-110

As shown in the figure:

Paper moves backward, ↑ increases the P-6 percentage
Paper moves forward, ↓ decreases the P-6 percentage



4. Main adjustments

4.5. Feed motor zero adjustment

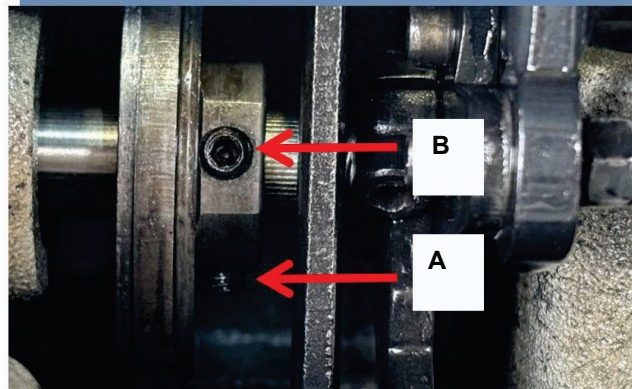
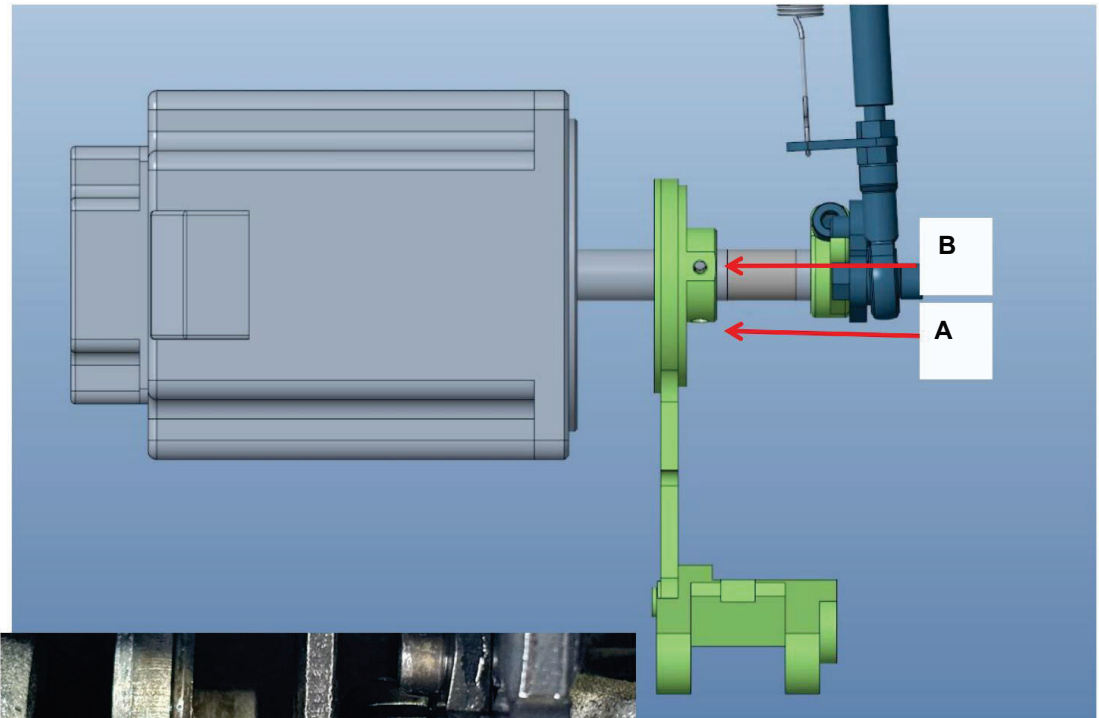
Mechanical adjustment method for stepping feed zero position

- ① Select P-6, press S key, adjust the percentage to 100, press S
- ② Open the rear window, first loosen screw A, step forward on the pedal to loosen screw B, and use screw B as the zero position adjustment screw.

Note: Screw B has a flat surface as an adjustment screw

Move the eccentric wheel up and down, and observe the feeding situation while the pedal keeps running

- ③ When the feed shaft does not feed (the needle is stuck in the same hole), slightly tighten screw B and test
- ④ Test multiple times until the zero position is accurate, tighten screw B. In the same way, tighten screw A



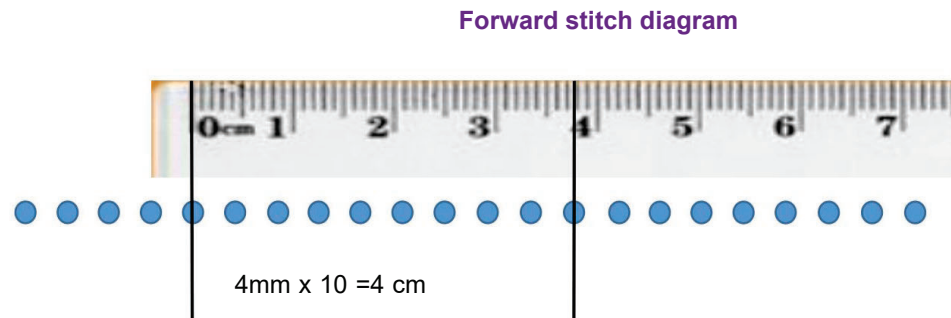
Note: After completing the mechanical rough adjustment, use the P-6 parameter for fine adjustment.

4. Main adjustments

4.6. Stitch length correction

P-7 stitch length correction value

- ① In the normal operation interface, press T to select 2-BJ, and press S
- ② Select P-7, 4.0 means the stitch length is 4mm,
- ③ Take a piece of white paper, put it under the presser foot, and press 20 stitches
- ④ Take the middle 10 sections and measure with a ruler. At this time, $4\text{mm} \times 10 = 4\text{ cm}$
- ⑤ Press S, modify the percentage, and press S to save



The actual test is larger than 4 cm $\uparrow$, appropriately reduce the P-7 percentage

The actual test is smaller than 4 cm $\downarrow$, appropriately increase the P-7 percentage

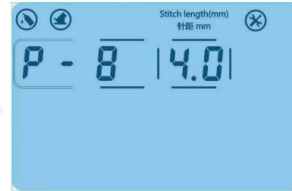
Reasonable range: 4CM~4.3CM



4. Main adjustments

4.7. Reverse stitch length correction

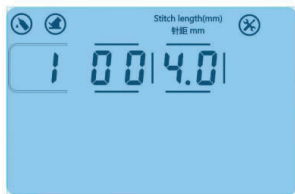
P-8 reverse stitch correction value.



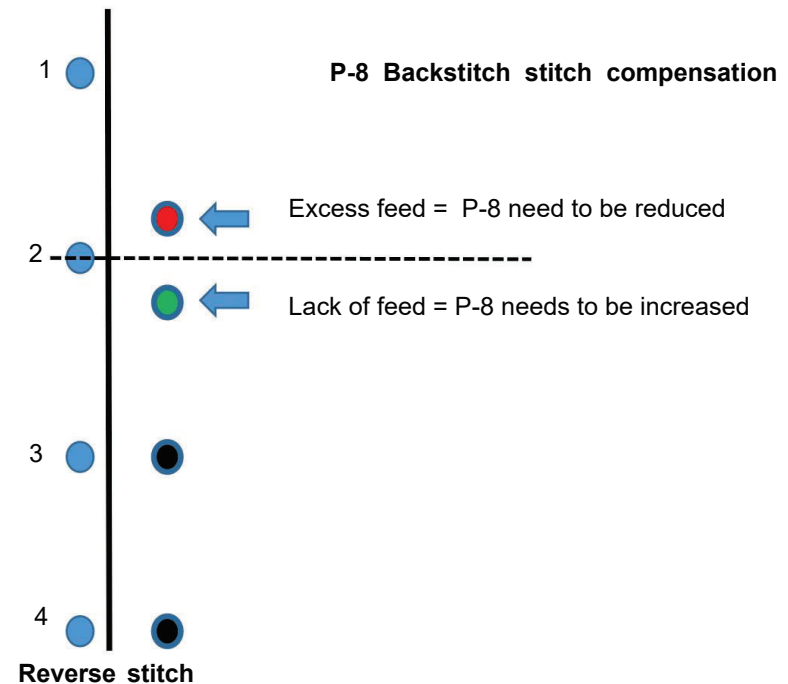
- ① In the normal operation interface, press the T key to select 2-BJ, and press the S key.
- ② Select P-8, 4.0 means the stitch length is 4mm, select the stitch length you need to correct, and use the left and right keys to modify the stitch length.
- ③ Take a piece of white paper, put it on the presser foot, step on 10 stitches, stop and press the reverse stitch switch, and lightly step on it.

As shown in the right figure, observe the overlap between the reverse stitch and the forward stitch. If it is fast, reduce the percentage, and if it is slow, increase the percentage.

- ⑤ Press the S key, modify the percentage, and press S to save.



Forward seam



4. Main adjustments

4.8. Pedal adjustment

1. Adjustment of the mechanical position of the presser foot

① Debugging method:

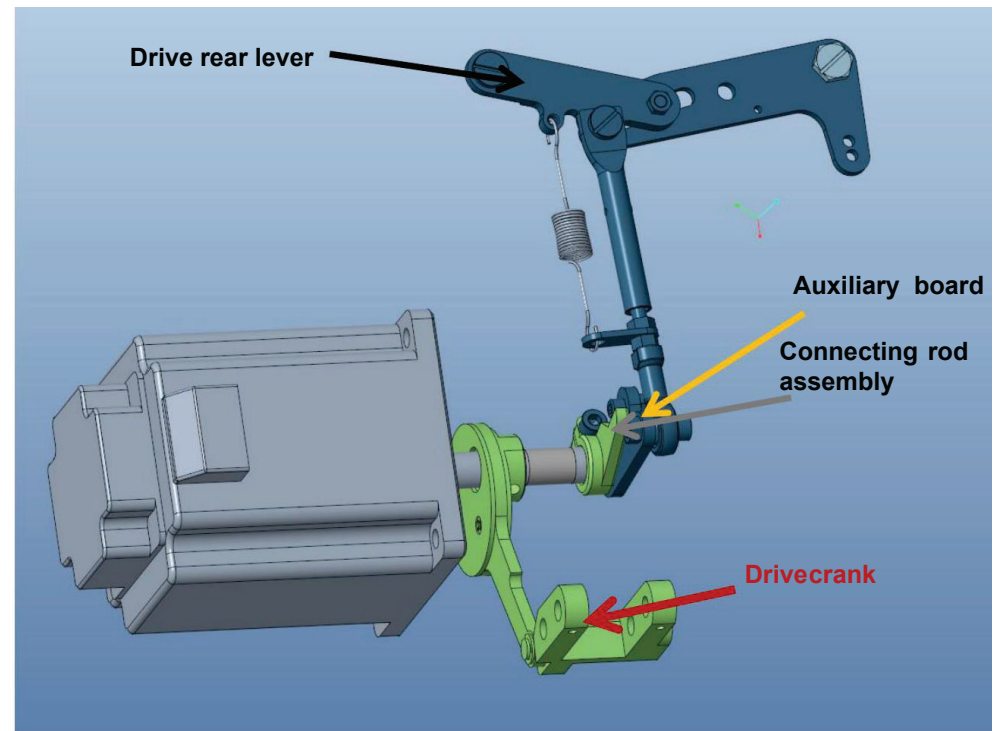
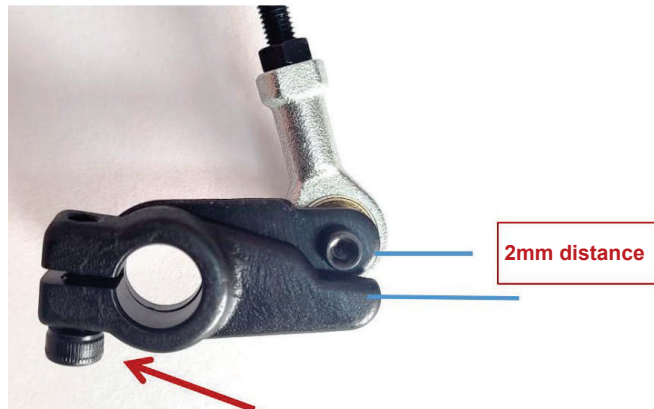
1: Left and right position:

The presser foot lift crank must be to the right of the presser foot auxiliary plate

2: Up and down position:

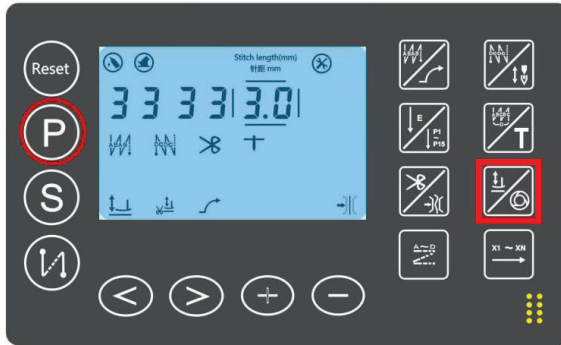
The presser foot lift crank distance to the presser foot auxiliary plate rod is 2MM

(the distance must be maintained, the smaller the better)



4. Main adjustments

4.8. Pedal adjustment



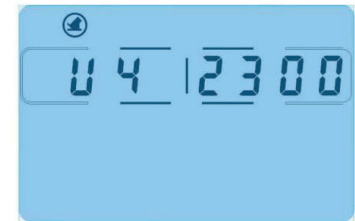
Pedal zero adjustment

1. Pedal zero position adjustment

1. Pedal zero position adjustment:

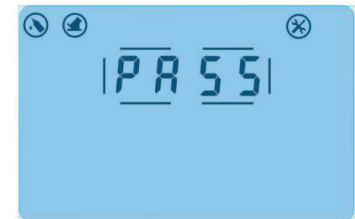
Press P key + trigger key at the same time, use the combination function
Select U4 and confirm, then the pedal voltage is displayed.

The normal value of pedal voltage is $-2300 \pm 30^\circ$
If abnormal, please adjust the pedal magnet



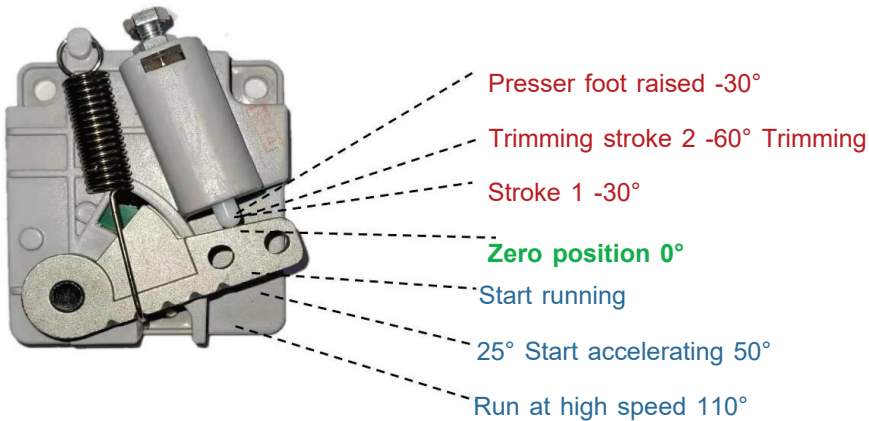
2. Pedal zero position correction:

Press and hold T key, select parameter 3-pd, press S key to confirm, PDL is displayed, press the pedal to start correction, and PASS is displayed after correction is completed



4. Main adjustments

4.8. Pedal adjustment



Pedal stroke adjustment

1. Pedal zero position - parking position
2. Start running - the position where the machine starts to move slowly
3. Start accelerating - the position where the machine starts to accelerate
4. Presser foot rise - the position where the presser foot starts to work
5. Thread trimming stroke 1 - the position where the presser foot is not raised and the thread is trimmed
6. Thread trimming stroke 2 - the position where the presser foot is raised and the thread is trimmed

Command time for presser foot lift: after the pedal is pressed, the presser foot lift function needs to wait x milliseconds to start working

1. Pedal travel adjustment:

In the normal operation interface, long press the P key to enter the parameter mode, press the + - key to select the parameter, and press the S key to confirm the parameter

Note: The angle of the pedal can be adjusted at different positions to obtain different foot feel

The most popular foot feel parameters:
P-42 (modified 2), P-62 (15)
P-63 (modified 30), P-64 (modified 85)
P-68 (modified -70), P-92 (modified 300)

Experienced foot feel parameters:
P-42 (modified 2), P-62 (15)
P-63 (modified 30), P-64 (changed to 85)
P-68 (changed to -55), P-92 (changed to 200)
This set of parameters is suitable for long-piece processes (placket)

Beginner's foot feeling (feeling that the pedal is too sensitive):
P42 (changed to 1), P62 (changed to 15),
P63 (changed to 60), P64 (changed to 150)
P-68 (changed to -70), P-92 (changed to 300)

Master's foot feeling parameters:
P42 (changed to 2), P62 (changed to 15),
P63 (changed to 25), P64 (changed to 70)
P-68 (changed to -55), P-92 (changed to 150)

Code	Item Description	Setting Range	Default Value
P-41	Minimum Pedal Speed	100 ~ 500	200
P-63	Pedal Acceleration Curve	0: Normal 1: Slow Acceleration 2: Fast Acceleration	2
P-62	Pedal Stroke to Start Operation	10 ~ 50	25
P-63	Pedal Stroke to Start Acceleration	10 ~ 100	50
P-64	Pedal Stroke for High-Speed Operation	10 ~ 150	110
P-65	Pedal Stroke for Presser Foot Lifting	-100 ~ +100	-30
P-67	Pedal Stroke for Thread Trimming Action 1	-100 ~ +100	-60
P-68	Pedal Stroke for Thread Trimming Action 2	-100 ~ +100	-90
P-92	Pedal Press Command Hold Time	30 ~ 300	80

5. List of parameters

Code	Item	Description	Setting Range	Step	Default Value	Level
P-01	Max Pedal Speed	Set max pedal rotation speed	200–3000 (rpm)	100	2400	I
P-02	Soft Start Function	Low-speed needle entry function at seam start (1–9: soft start stitches)	0–9	1	2	I
P-04	Max Speed for Fixed Stitch	Set max fixed stitch speed	200–3000 (rpm)	100	2200	I
P-06	Zero Needle Position Correction	Adjust actual needle position to zero	50–150	1	100	I
P-07	Forward Stitch Distance Correction	Distance ratio for forward fixed stitch	50–150 (%)	1	100	I
P-08	Reverse Stitch Distance Correction	Distance ratio for reverse fixed stitch	50–150 (%)	1	100	I
P-09	Reverse Start Max Speed	Max speed when reverse starts	500–1500 (rpm)	50	1500	I
P-10	Fixed Stitch Needle Count Mode	Set fixed stitch count as numeric or pattern	0/1	1	1	I
P-12	Presser Lift Step 1 Angle	Angle of first presser foot lift	0–100	1	30	I
P-13	Max Presser Lift Height	Max lift height after cutting	0–100	1	55	II
P-14	Presser Lift Speed	Speed of stepwise presser lift	20–500 (rpm)	10	60	II
P-15	Presser Release Speed	Stepwise presser release speed	20–500 (rpm)	10	100	II
P-16	Presser Release Angle 1	Angle of first presser release	0–100	1	30	I
P-17	Thread Trimming Solenoid Duty	Solenoid duty cycle for thread trimming	0–100	1	50	II
P-106	Presser Height Sensor Zero Voltage Adjustment	Adjustment of zero voltage for presser height sensor (unit: 0.01V)	0–250	1	215	II
P-107	Thick Fabric Detection Sensitivity	Voltage setting of the presser sensor during thickness detection (unit: mV)	0–500	5	100	II
P-108	Thread Trimming Solenoid Duty	Duty ratio of thread trimming solenoid (during vacuum)	50–100	1	98	II
P-109	Presser Foot Solenoid Duty	Duty ratio of presser foot solenoid (during vacuum)	50–100	1	80	II
P-110	Fabric Thickness & Tension Control	Apply extra tension while sewing thick material	0–10	1	0	II
P-111	Thick Seam Max Speed	Speed limit for thick seam processing	500–3000 (rpm)	50	1500	II
P-112	Thick Seam Compensation Ratio	Compensation ratio for thick seam stitch length	50–150 (%)	1	120	II
P-113	Compensating Stitch Mode	0: Disabled, 1: Enabled (set by P-114)	0/1	1	0	I
P-114	Compensating Stitch Length	Set compensating stitch length (1.0–5.0mm or 1.0–7.0mm depending on model)	10–50 (70)	1	40	I
P-115	Reverse Stitch Button Function	0: Reverse stitch, 1: Bartack, 2: Compensation, 3: Reverse+Compensation	0–3	1	0	II
P-116	Compensation Button Function	0: Reverse stitch, 1: Bartack, 2: Compensation, 3: Reverse+Compensation	0–3	1	2	II
P-117	Bartack Stitch Length	Bartack stitch length set by button	50–150	1	110	II
P-118	Pre-Bartack Stitch Count	Number of stitches before bartack	1–10	1	1	II

P-119	Pre-Bartack Stitch Length	Length of stitches before bartack	50–150	1	110	II
P-121	Thread Trim Start Angle 1	Starting angle for thread trim step 1	200–300	2	230	II
P-122	Thread Trim Stroke 1	Stroke setting for thread trim step 1	0–100	1	40	II
P-123	Thread Trim Start Angle 2	Starting angle for thread trim step 2	250–360	2	330	II
P-124	Thread Trim Stroke 2	Stroke setting for thread trim step 2	0–100	1	60	II
P-125	Thread Trim During Fixed Stitch	Enable thread trim during fixed stitch	0/1	1	0	II
P-126	Initial Thread Loosening Enable	Enable thread loosening at start	0/1	1	1	II
P-127	Initial Thread Loosen Delay	Delay time before thread loosen	0–1000	10	100	II
P-128	Initial Thread Loosen Time	Thread loosen operation time	0–1000	10	200	II
P-129	LCD Backlight Brightness	Backlight brightness setting	0–10	1	5	I
P-135	Mid-Reverse Stitch Enable	0. Invalid 1. Valid	0/1	1	0	I
P-136	Mid-Reverse Stitch Count	Number of stitches for mid-reverse	1–50	1	4	I
P-137	Mid-Reverse Stitch Repeat	Number of mid-reverse repetitions	1–10	1	1	I
P-140	Anti-Bird Nest Delay (Before)	Delay before anti-bird nest thread trim	0–500 ms	5	50	II
P-141	Anti-Bird Nest Action Time	Duration of solenoid action	0–500 ms	5	50	II
P-142	Anti-Bird Nest Delay (After)	Delay after solenoid stop	0–500 ms	5	50	II
P-143	Anti-Bird Nest Duty Ratio	Solenoid action power	0–100	1	100	II
P-144	Vacuum Time	Vacuum valve activation time	0–2000 ms	10	250	II
P-145	Clamp Action Time	Clamp solenoid action time	0–500 ms	5	50	II
P-150	Max Stitch Length	Maximum stitch length	10–100 mm	1	80	II
P-151	First Stitch Anti-Unravel	0. Invalid 1. Valid	0/1	1	0	II
P-152	First Stitch Anti-Unravel Length	Set the distance setting, parameter range (1.0mm~5.0mm)	10–50	1	40	II
P-153	Button Jog Mode	0: Off, 1: Jog (click to trigger)	0/1	1	0	II
P-158	Rear Bartack Stitch Count	Rear bartack stitch number	1–10	1	1	II
P-159	Rear Bartack Stitch Length	Rear bartack stitch length	50–150	1	110	II
P-161	1/2 Compensation Button Function	0: Reverse, 1: Bartack, 2: 1/2 Compensation, 3: Foot lift	0–3	1	2	II
P-162	1/4 Compensation Button Function	0: Reverse, 1: Bartack, 2: 1/4 Compensation, 3: Foot lift	0–3	1	2	II
P-166	Front Bartack Speed	Speed setting for front bartack	200–3000	100	1500	II
P-167	Rear Bartack Speed	Speed setting for rear bartack	200–3000	100	600	II
P-169	Presser Foot Lowered Position	Adjust foot height after lowering	0–100	1	30	II
P-170	Speed Compensation Enable	=0, P171~P176 parameters are invalid; =1, P171~P176 parameters are valid	0/1	1	1	II
P-171	Forward Stitch Speed Compensation	Speed compensation coefficient (forward)	50–150	1	100	II
P-172	Reverse Stitch Speed Compensation	Speed compensation coefficient (reverse)	50–150	1	100	II
P-173	Front Bartack Forward Speed Compensation	Speed compensation coefficient	50–150	1	100	II
P-174	Front Bartack Reverse Speed Compensation	Speed compensation coefficient	50–150	1	100	II
P-175	Rear Bartack Forward Speed Compensation	Speed compensation coefficient	50–150	1	100	II
P-176	Rear Bartack Reverse Speed Compensation	Speed compensation coefficient	50–150	1	100	II
P-177	Button Compensation Mode	0: Continuous half-stitch, 1: Continuous full-stitch, 2: Half-stitch + One-stitch	0–3	1	3	I

P-178	1/2 Compensation Mode	0: Continuous half-stitch, 1: Continuous full-stitch, 2: Half-stitch + One-stitch	0–3	1	3	I
P-179	1/4 Compensation Mode	0: Continuous half-stitch, 1: Continuous full-stitch, 2: Half-stitch + One-stitch	0–3	1	3	I
P-180	Stitch Length Compensation Enable	=0, P181~P200 parameters are invalid; =1, P181~P200 parameters are valid	0/1	1	1	II
P-181	1mm Forward Stitch Compensation	1mm Forward Stitch Compensation Coefficient	50–150	1	100	II
P-182	1mm Reverse Stitch Compensation	1mm Reverse Stitch Compensation Coefficient	50–150	1	100	II
P-183	2mm Forward Stitch Compensation	2mm Forward Stitch Compensation Coefficient	50–150	1	100	II
P-184	2mm Reverse Stitch Compensation	2mm Reverse Stitch Compensation Coefficient	50–150	1	100	II
P-185	3mm Forward Stitch Compensation	3mm Forward Stitch Compensation Coefficient	50–150	1	100	II
P-186	3mm Reverse Stitch Compensation	3mm Reverse Stitch Compensation Coefficient	50–150	1	100	II
P-187	4mm Forward Stitch Compensation	4mm Forward Stitch Compensation Coefficient	50–150	1	100	II
P-188	4mm Reverse Stitch Compensation	4mm Reverse Stitch Compensation Coefficient	50–150	1	100	II
P-189	5mm Forward Stitch Compensation	5mm Forward Stitch Compensation Coefficient	50–150	1	100	II
P-190	5mm Reverse Stitch Compensation	5mm Reverse Stitch Compensation Coefficient	50–150	1	100	II
P-191	6mm Forward Stitch Compensation	6mm Forward Stitch Compensation Coefficient	50–150	1	100	II
P-192	6mm Reverse Stitch Compensation	6mm Reverse Stitch Compensation Coefficient	50–150	1	100	II
P-193	7mm Forward Stitch Compensation	7mm Forward Stitch Compensation Coefficient	50–150	1	100	II
P-194	7mm Reverse Stitch Compensation	7mm Reverse Stitch Compensation Coefficient	50–150	1	100	II
P-195	8mm Forward Stitch Compensation	8mm Forward Stitch Compensation Coefficient	50–150	1	100	II
P-196	8mm Reverse Stitch Compensation	8mm Reverse Stitch Compensation Coefficient	50–150	1	100	II
P-197	9mm Forward Stitch Compensation	9mm Forward Stitch Compensation Coefficient	50–150	1	100	II
P-198	9mm Reverse Stitch Compensation	9mm Reverse Stitch Compensation Coefficient	50–150	1	100	II
P-199	10mm Forward Stitch Compensation	10mm Forward Stitch Compensation Coefficient	50–150	1	100	II
P-200	10mm Reverse Stitch Compensation	10mm Reverse Stitch Compensation Coefficient	50–150	1	100	II
P-246	Pattern Bartack Function	Pattern bartack enable setting; 0: Off, 1: On	0/1	1	0	I

6. Error codes and troubleshooting

EN

Error Code	Description	Troubleshooting
E011/E012	Motor Signal Error	Check motor plug connection; motor signal sensor damage; is the handwheel installed properly
E021/E023	Motor Overload	Check motor plug connection; check if the head or thread trimming mechanism is stuck; check if thick fabric is used over sewing spec; is the current sensor working correctly
E022	Thread Trimmer Jammed	Check head or thread trimming motor for jamming; check trimmer sequence and position
E101	Driver Component Error	Check if current detection circuit is working; check if the driver is damaged
E111/E112	System Overvoltage	Check if system input voltage is too high; check if resistor and voltage detection circuits are normal
E121/E122	System Undervoltage	Check if system input voltage is too low; check if voltage detection circuit is normal
E131	Current Detection Circuit Error	Check if system current detection circuit is working properly
E133	OZ Circuit Error	Check OZ circuit
E134	DBFLT Error	Check DBFLT plug connection; is DBFLT component damaged
E201	Motor Overcurrent	Check current detection circuit; motor signal
E211/E212	Motor Running Abnormal	Check motor plug; motor signal mismatch
E301	Control Panel Communication Failure	Check control panel plug connection; is the control board damaged
E302	Control Panel EEPROM Error	Check if control panel board is damaged
E303	SPI Communication Error	Check main control board
E304	HMI MCU Communication Error	Check if control panel is damaged
E402	Pedal ID Error	Check pedal plug
E403	Pedal Zero Position Calibration Error	Pedal damaged or not in stop position during calibration
E501	Presser Switch Error	Check if presser foot or switch is triggered
E502	Oil Level Warning	Refill oil
E601	Hardware Overcurrent	Check current detection circuit; driver damaged
E602	Software Overcurrent	Check current detection circuit; driver damaged
E603	Current Detection Circuit Error	Check current detection circuit; driver damaged
E604	Mechanical Zero Position Search Error	Check if feed presser motor plug is connected properly
E605	Motor Stalled	Check feed presser motor plug; mechanical blockage
E606	Motor Start Circuit Error	Check current detection circuit; driver damage
E607	Hardware Overcurrent	Check current detection circuit; driver damage
E608	Software Overcurrent	Check current detection circuit; driver damage
E609	Current Detection Circuit Error	Check current detection circuit; driver damage
E610	Zero Position Signal Error	Check if thread trimming motor plug is properly connected
E611	Motor Stalled	Check trimming motor plug; mechanical blockage
E612	Motor Start Circuit Error	Check current detection circuit; driver damage
E701	Bobbin Thread Detection Warning	Replace bobbin thread sensor or check wiring
PoFF	Power Off Display	Wait and reconnect power
EvAL	Trial Protection Error	Contact supplier
L.bob	Bobbin Thread Reminder	Press S to cancel reminder
P.bob	Piece Counter Reminder	Press S to enter settings. Hold 'Bartack' key for 2s to cancel reminder. To disable this, set P35=0

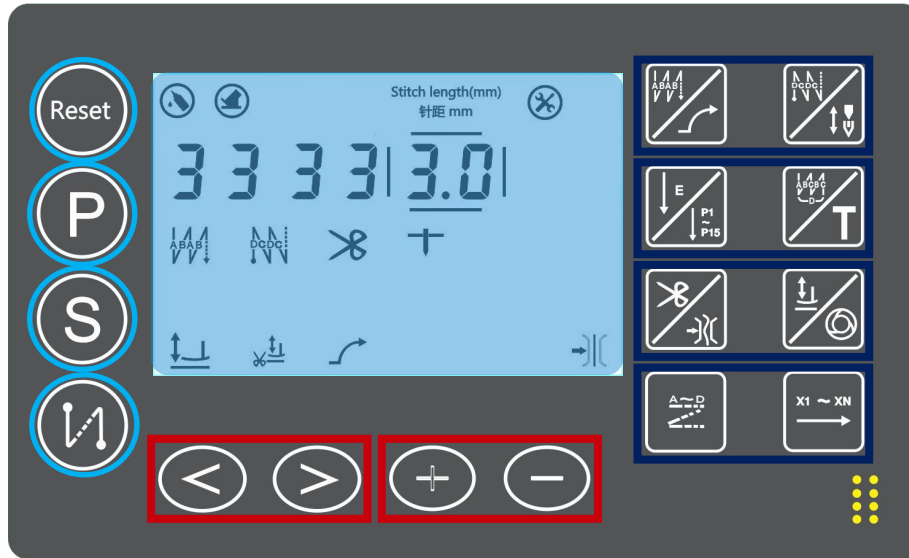
一、面板及操作介绍

恢复出厂设置

参数设定键

参数确认键

密针功能键



/速度调节/左右光标键/

上下光标键

前后固缝键/软启动/上下针位键

一段缝/多段缝/W缝/试校模式

剪线功能/夹线功能/压脚模式/触发键

花样固缝功能/ 段式缝功能

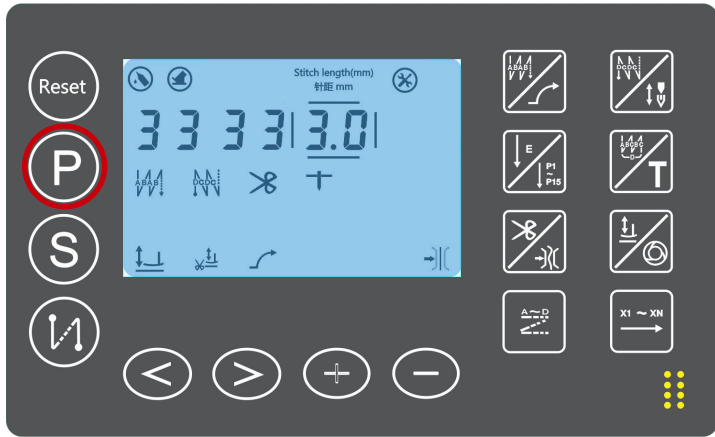


二、基本参数功能介绍

编号	项目
1	参数调节
2	速度调节
3	前后固缝
4	剪线/夹线功能
5	抬压脚功能
6	软启动/上下针位
7	恢复出厂设置
8	固缝花样修改
9	前后固缝花样设置
10	一段缝
11	多段缝
12	多段缝试校模式

编号	项目
13	连续固缝
14	段缝花样自编模式
15	密针缝/机头按键功能
16	剪线停针位置调整
17	监控/计件模式
18	主轴电机角度调试
19	步进电机零位调整
20	压脚如何调整
21	踏板零位调整
21	参数介绍
22	故障代码

二、基本参数功能介绍



参数调节

进入不同参数级别（参数分为2级）

1. 普通参数

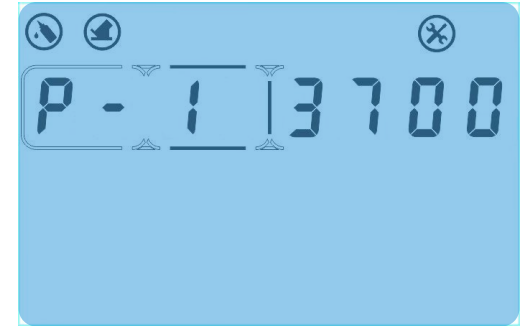
长按**P**键，进入参数模式，

+ - 键选择

参数，**S**键确认参数

+ - 键修改参数后，按**S**键保存

P键退出



2. 高级参数

长按**P**键**5秒**，进入高级参数

输入密码**1111**，**S**键确认

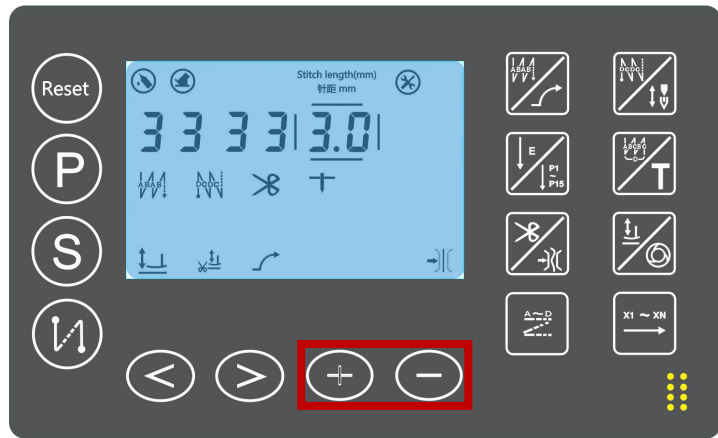
+ -键选择参数，**S**键确认参数

+ -键修改参数后，按**S**保存

P键退出



二、基本参数功能介绍



P 针距/花样调节

进入不同参数级别（参数分为2级）

1. 针距调节

普通模式：按+ - 键调节针距，针距为0-10mm可选
当针距加到设置最大后，
进入花样缝制模式。

注意：输入密码进入参数可：

P-91：针距锁定，不可修改针距

P-150：最大针距设定，0-10mm

此时：因根据机械出厂规定进行设置

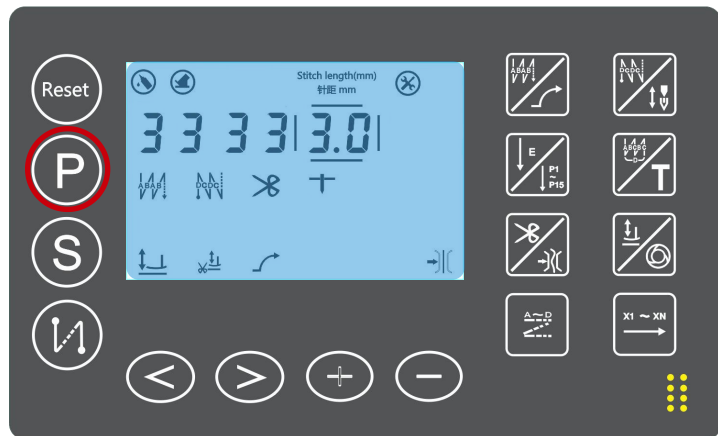


2. 花样调节

针距加到10mm 以后，
继续按 + 键选择d1-d9花样
选完按S键确认



二、基本参数功能介绍

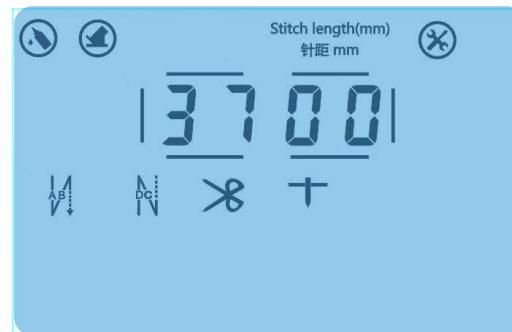


P 速度调节

1. 普通模式：按速度加减直接调节。
2. P-1参数：普通模式最高速度设定
3. P-80高级参数：最高速度锁定

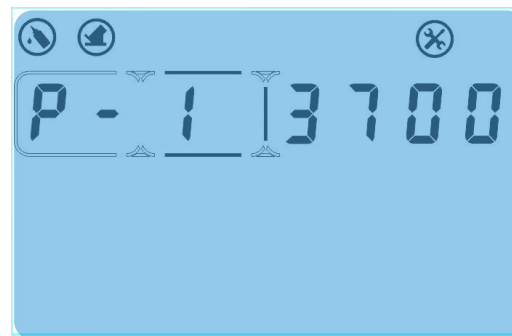
1. 速度调节

操作面板，按 **<>** 键
增减速度



2. 最高速度设定

长按**P**键，选择**P-1**
按**S**键确认
设定普通模式最高速度
S键保存，**P**键退出



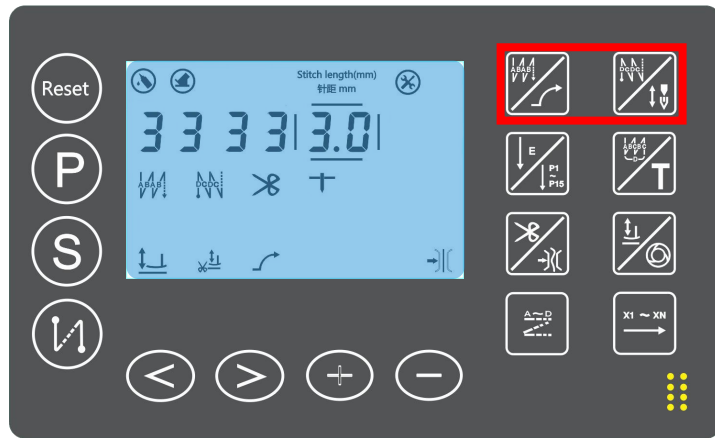
3. 最高速度锁定

长按**P**键**6秒**，输入密码**1111**
S键确认
选择**P-80**最高速度锁定
按**S**键确认
锁定最高速度
S键保存，**P**键退出



注意：修改完P-80速度后，需要修改P-1速度，
再在普通操作界面，按速度键调节速度

二、基本参数功能介绍



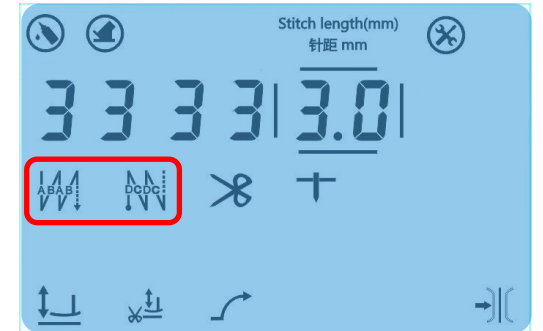
1. 前固缝

按前固缝

有前固缝/前双固缝/前四固缝
三种不同模式切换

按后固缝

有后固缝/后双固缝/后四固缝
三种不同模式切换



前后固缝

1. 可修改前后固缝模式，相应固缝针数
2. 针迹不重合，请参见后页调节P-8参数

2. 固缝针数设定

按**S**键，进入设置界面

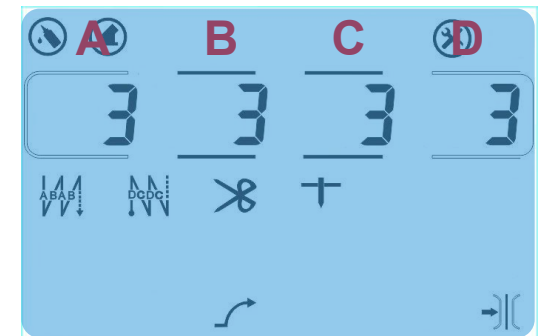
按 **< >** 键

依次选择**A B C D**段

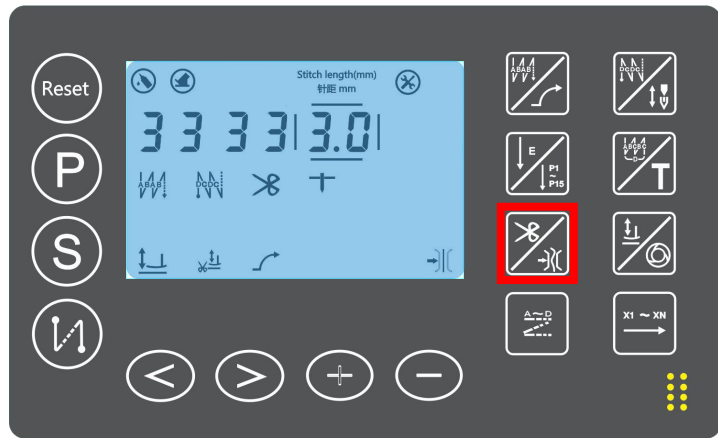
按 **+ -** 键

依次修改A B C D段针数

改完，按**S**键返回普通界面



二、基本参数功能介绍



剪线 / 夹线功能

1. 短按：剪刀功能开与关
2. 长按：夹线功能开与关
3. 长按S键：调节夹线力度

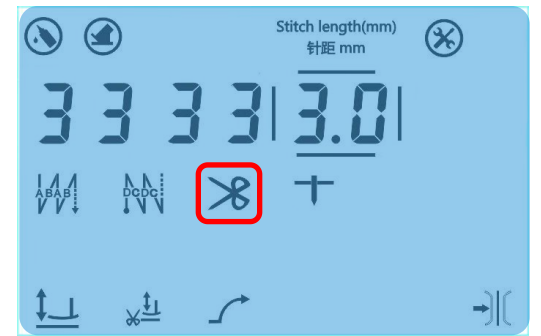
1. 剪线/夹线

短按

选择**剪线**功能开启或关闭

长按

选择**夹线**功能开启或关闭



2. 夹线力度调整

带夹线功能机型，

长按S键

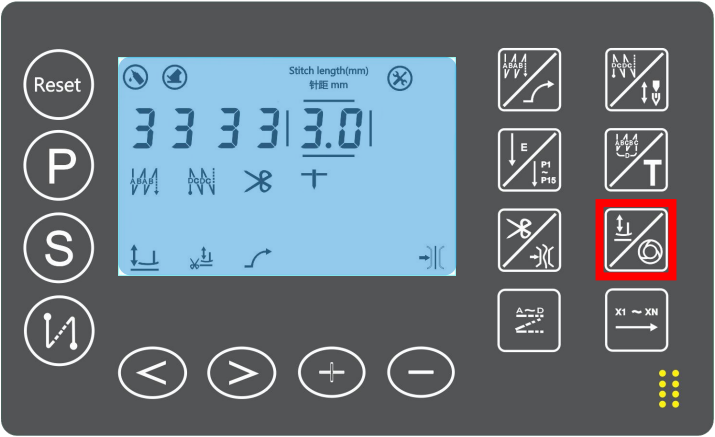
显示夹线力度**1-9**

数字越大，力度越大

再次按**S**键退出



二、基本参数功能介绍



1. 抬压脚功能

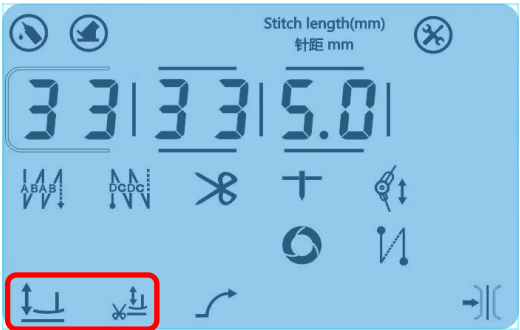
长按**P**键，选择参数**P-25**

选择参数

0：无抬压脚

1：有抬压脚

2：缝制途中禁止抬压脚，剪线能抬压脚



抬压脚功能

1. 调节缝纫机调压螺母压力，获得不同缝制体验。
2. 短按循环：中间停顿抬压脚 / 剪线后抬压脚/中间停顿剪线后抬压脚 / 关闭

2.抬压脚使能调节

长按**P**键，输入密码1111，选择参数压脚相关调节参数：

P-12：抬压脚第一段角度（声音响调节）

P-13：压脚高度调节

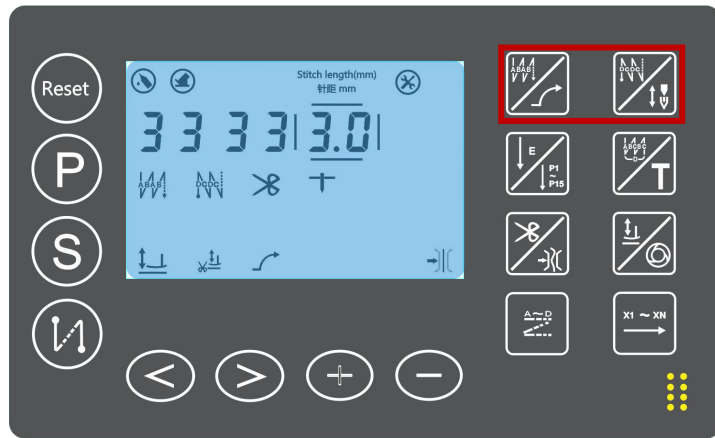
P-14：压脚抬升速度

P-15：压脚释放速度

P-16：放压脚第一段角度

注意：根据不同的缝制布料，可对压脚的声音，压脚的高度等进行组合参数调节

二、基本参数功能介绍

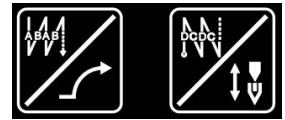
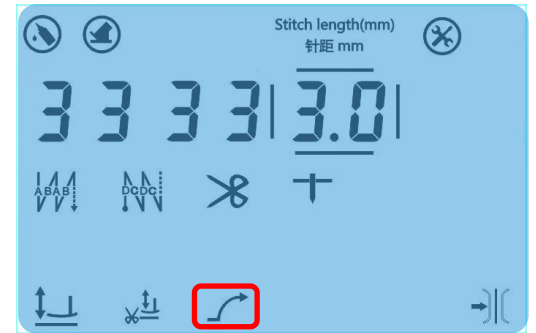


1. 软启动

长按：软启动功能开与关

P-2 设定软启动针数

P-21~23设定软启动速度



软启动/ 上下针位

1. 开启软启动功能，有效避免起缝不脱线
如不需要可关闭

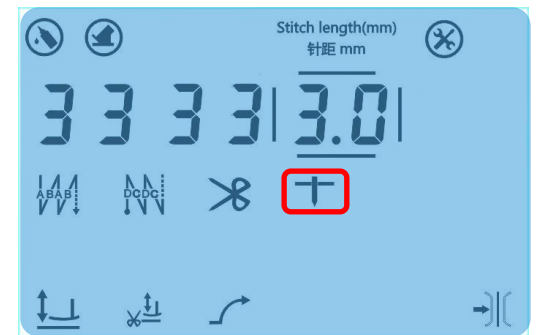
2. 尝试适当调节下停针位置，一定程度上
解决起缝脱线问题

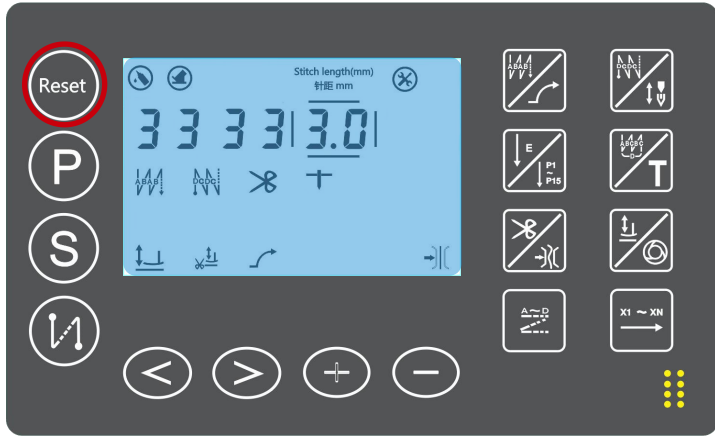
2. 上下针位

长按上下停针键，

选择上停针或下停针

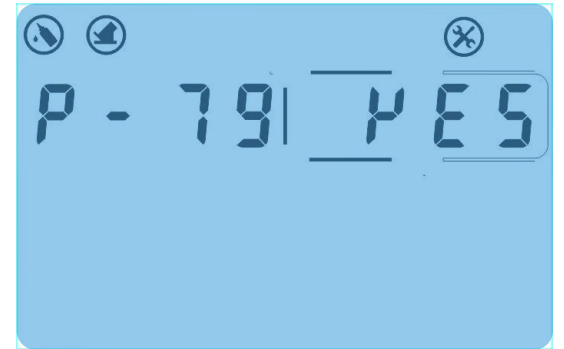
P-69 设定下停针位置





1. 一键恢复

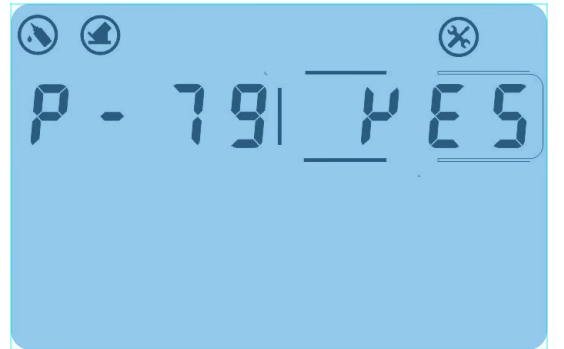
长按**Reset**按钮，即可完成
参数表参数全面恢复



2. 二级参数恢复

在普通操作界面，长按P键
进入参数模式，选择**P-79**，
S键确认参数

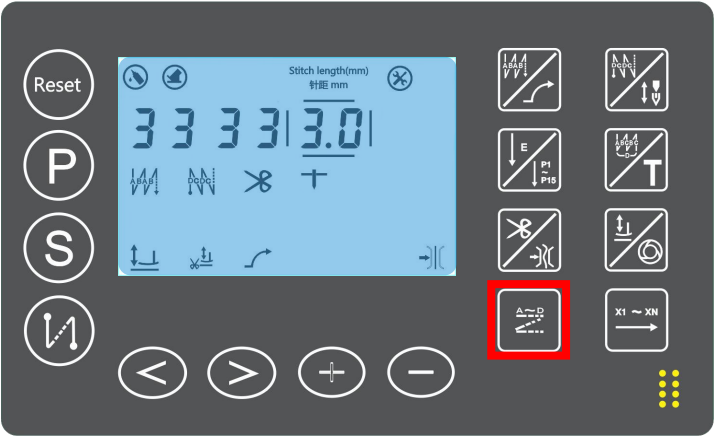
将**0改为8**，屏幕显示**YES**
按**S**键确认，**P**键退出



恢复出厂设置

1. 对操作操作屏幕设置功能参数，参数表设置参数进行全面恢复
2. 如果需要对机器进行全方位调整，确认最佳状态，可以使用P-131参数保存后续恢复可恢复到此状态

二、基本参数功能介绍



花样编辑模式

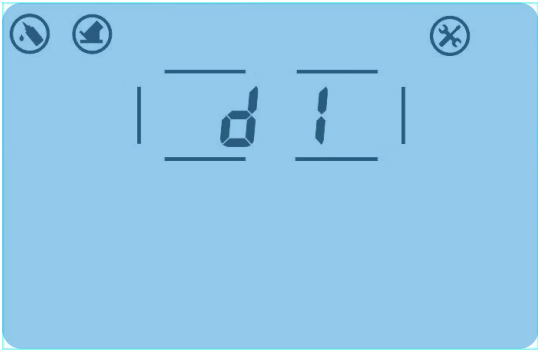
1. 对厂家预设H1-H9花样，可进行个性化修改

简单描述：

- ① 先考虑每段花样，要走几针，倒缝，要来回重复几次？
- ② 正常重复次数3或5，感觉花样不够饱满，选7,9,11...试试
如走直线，不需要倒缝缝花样，重复次数选1
- ③ 每段花样输入相应合适的针距

1. 花样选择

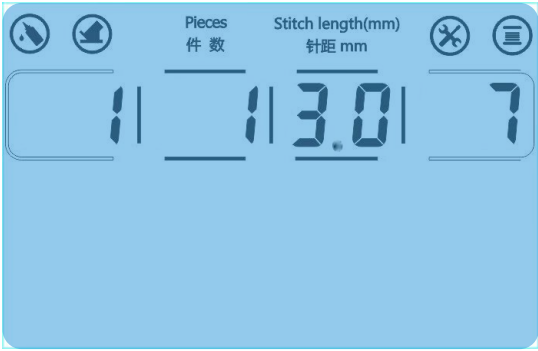
在普通操作界面，
长按 花样编辑 键，
+-键选择你需要修改的花样
S键确认



2. 花样参数设置

从左到右，依次设置
段数，针数，针距，重复次数

- 1** 代表第1段缝制内容
- 1** 代表要缝1针
- 3.0** 代表要用3mm针距来缝
- 7** 代表倒缝正缝来回重复7次



- 1** 代表段数
- 1** 代表针数
- 3.0** 代表缝制针距
- 7** 重复7次

花样编辑模式

花样介绍

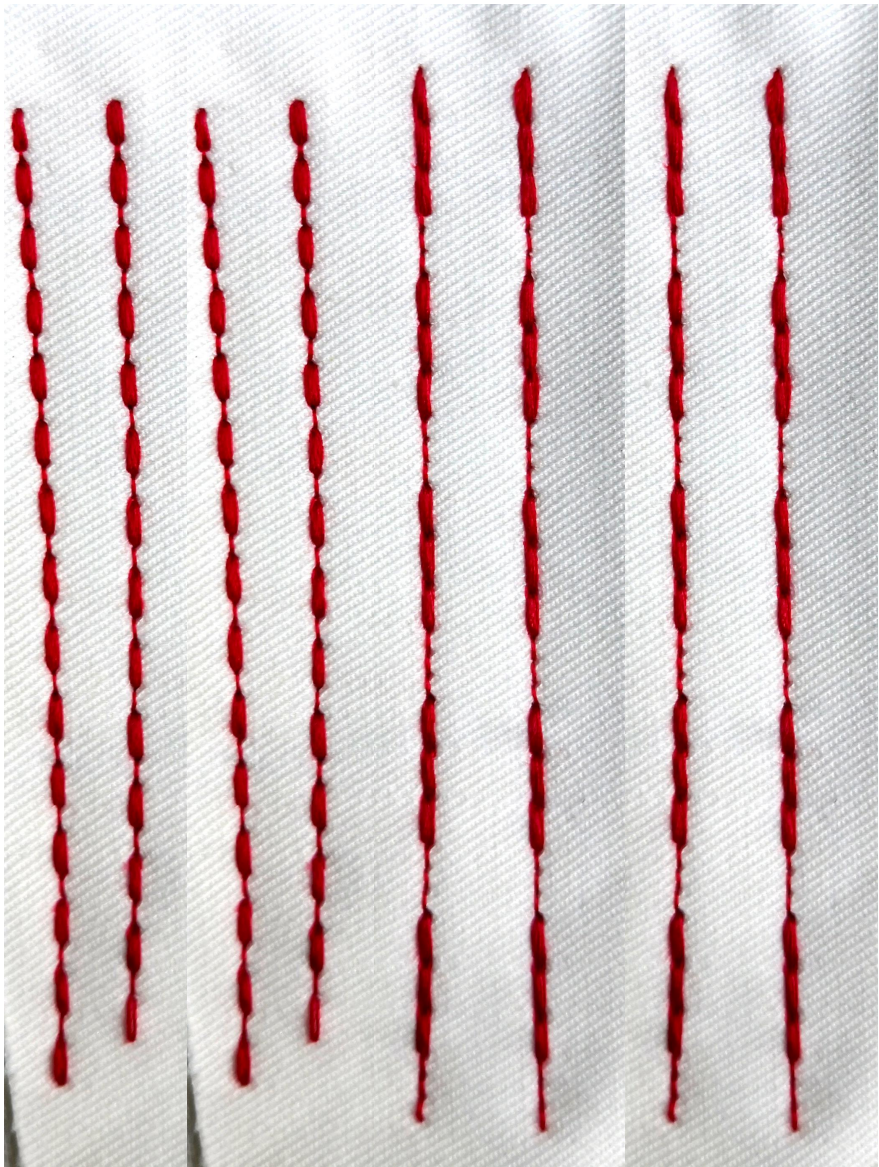
修改前D2花样(左)

段数	针距	针数	重复次数
1	4mm	1	7
2	2mm	1	1

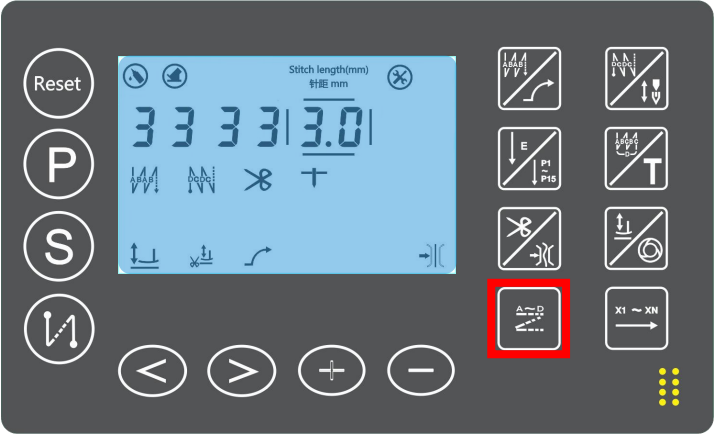


修改后D2花样(右)

段数	针距	针数	重复次数
1	4.2mm	3	7
2	2mm	3	1



二、基本参数功能介绍



前后固缝花样设置

1. 此功能开启后，前后固缝按照自行编辑花样来缝制

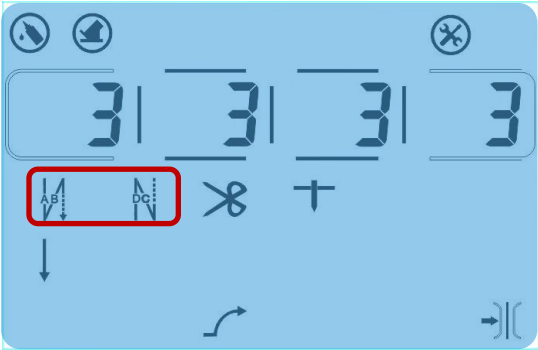
1. 前后固缝花样

在普通操作界面，短按下固缝花样键，选定花样可以作为前固缝和后固缝

按S键，进入
< > 键选择前固缝/后固缝
+ - 键修改前后固缝花样
选完按S键保存，按S键退出



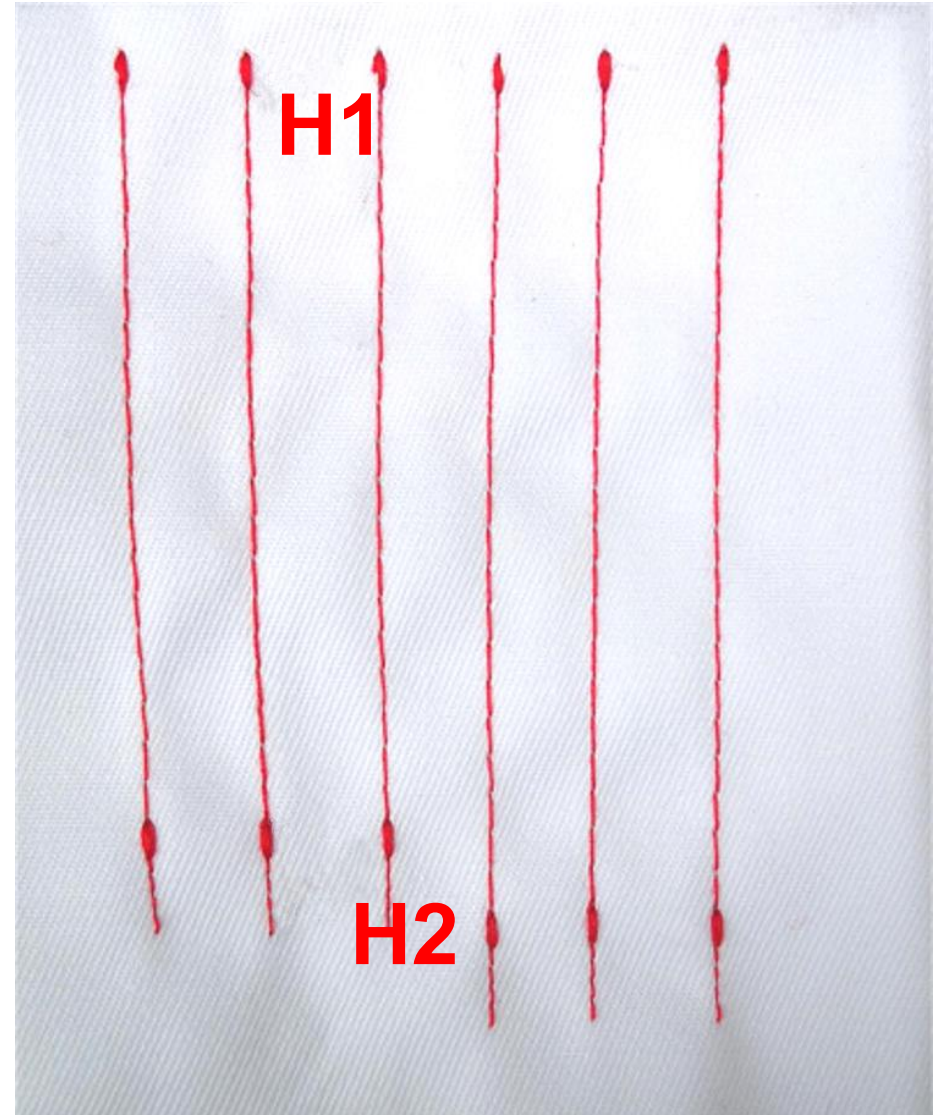
前固缝使用H1花样
后固缝使用H2花样



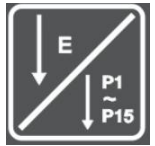
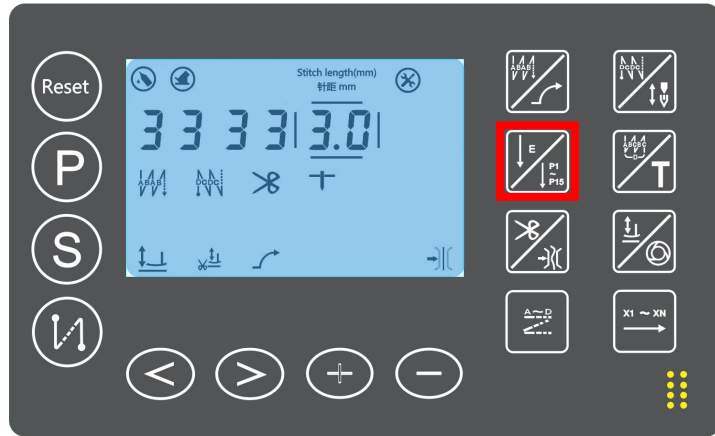
花样固缝功能

花样演示

- 备注：1、前固缝使用H1花样（花样缝）
2、后固缝使用H2花样（花样缝）



二、基本参数功能介绍



一段缝

循环：一段缝/多段缝/自由缝

设定一段缝针数，可设范围0 ~ 99针

注：按  键单段可以自动缝制

1. 针距设定

按下段缝键一次，进入一段缝

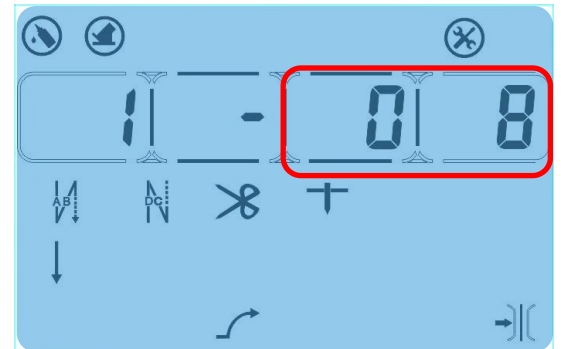
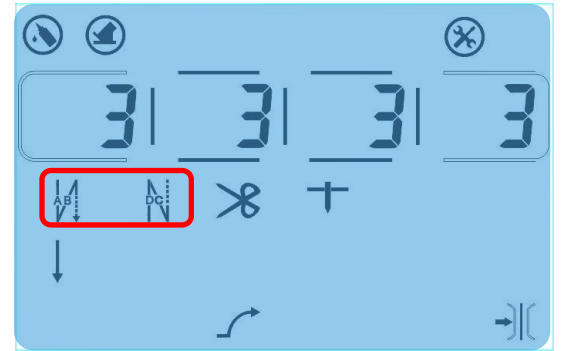
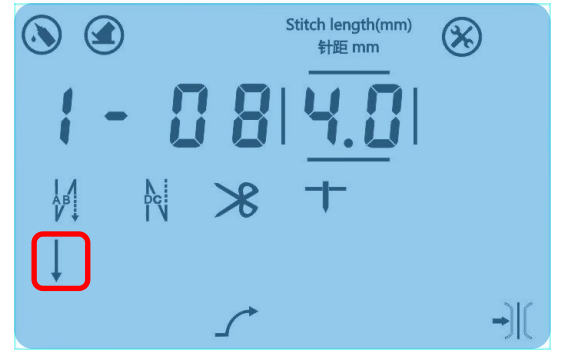
+ **-** 键设置定针针距

2. 倒缝针数设定

按**S**键，设置此模式下
首尾倒回缝针数设置

3. 定针针数设定

按**S**键，设置此模式下
缝制针数

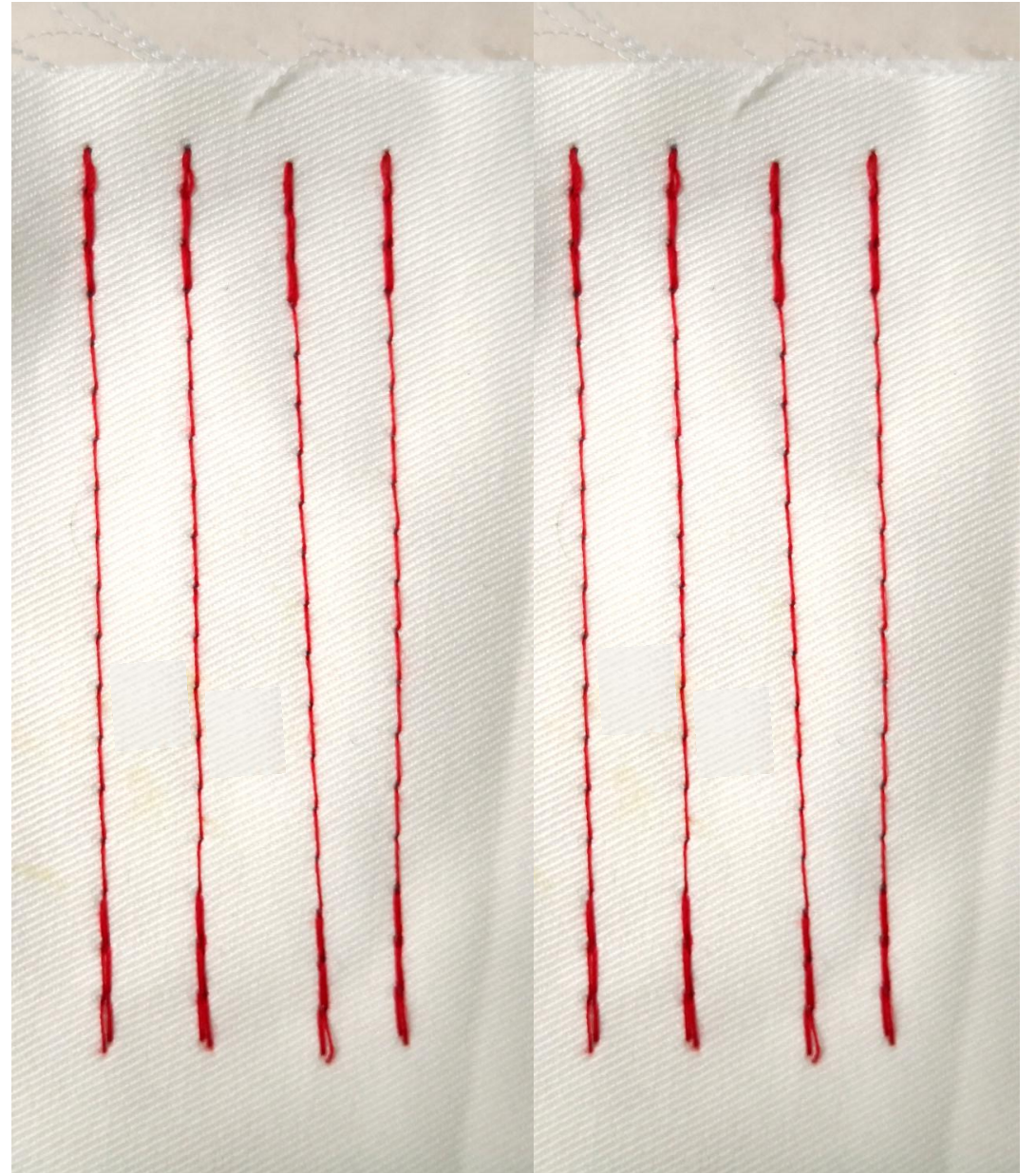


一段缝

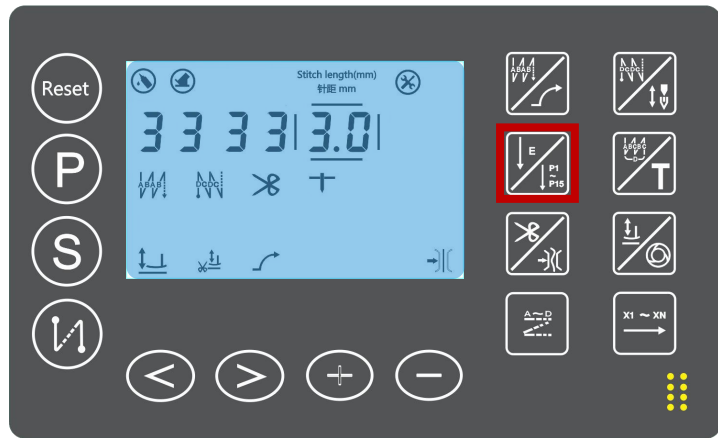
花样介绍

备注：1、前后固缝3针

2、定针缝18针



二、基本参数功能介绍



多段缝

循环：一段缝/多段缝/自由缝

设定多段缝针数，每段可设范围

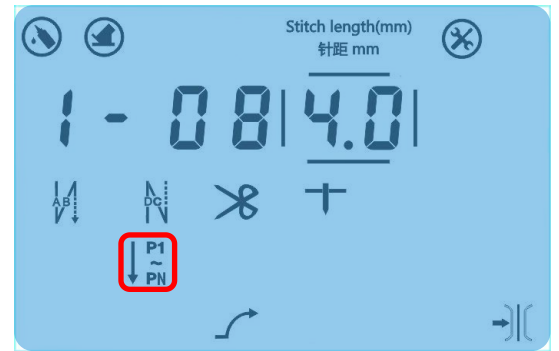
0 ~ 99针

注：按  键单段可以自动缝制

1. 针距设定

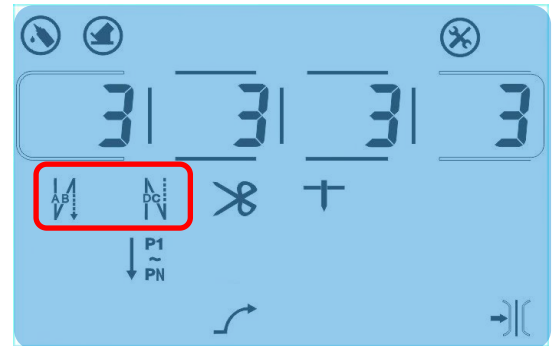
按下段缝键两次
进入多段缝模式

+- 键设置定针针距



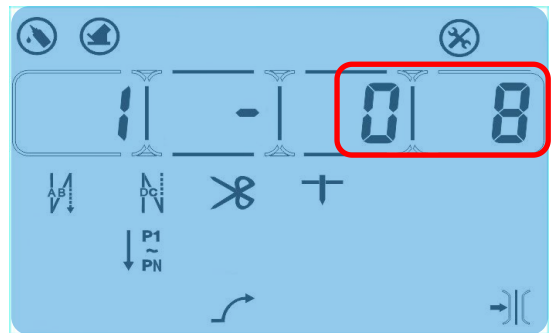
2. 倒缝针数设定

按S键，设置此模式下
首尾倒回缝模式、针数



3. 定针针数设定

按S键，设置此模式下
缝制每段针数



多段缝

花样介绍

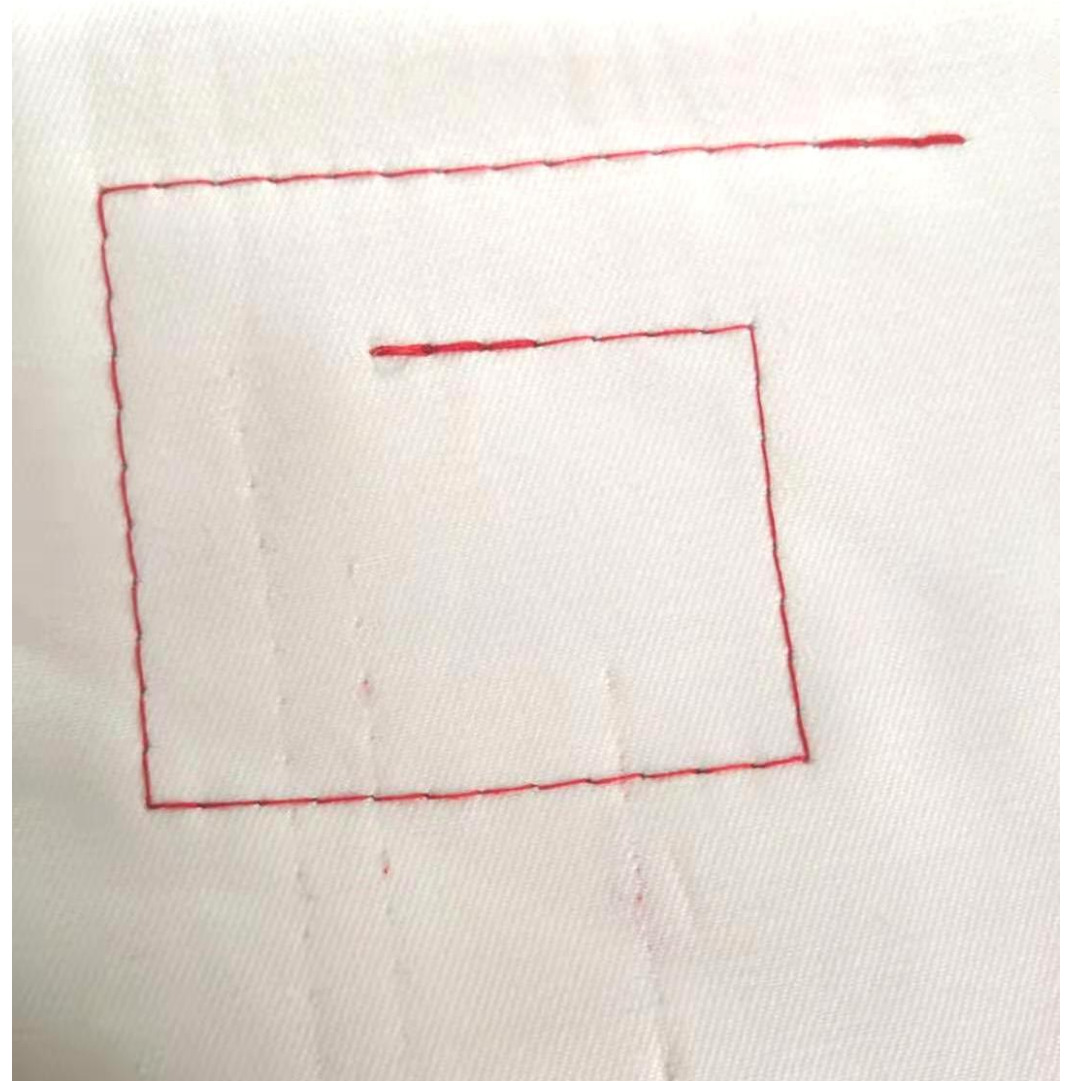
备注：1段：前固缝3针，针数16针，
针距7mm

2段：针距7mm，针数11针

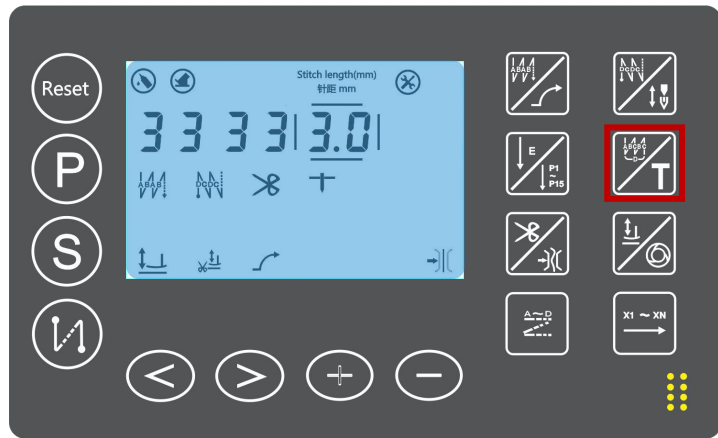
3段：针距7mm，针数12针

4段：针距7mm，针数8针

5段：后固缝3针，针数7针，
针距7mm



二、基本参数功能介绍



多段缝试校模式

在多段模式下，（长按T键）

1-15段自由设置，方便快捷

简单描述：使用此方法，先试缝一次，电控自动记录各段针数，不用按以往方式，试缝后一针一针数针数，然后输进去，提升效率

1. 试校模式

在多段缝操作界面，长按**T**键进入试校模式。

2. 试校针数设置

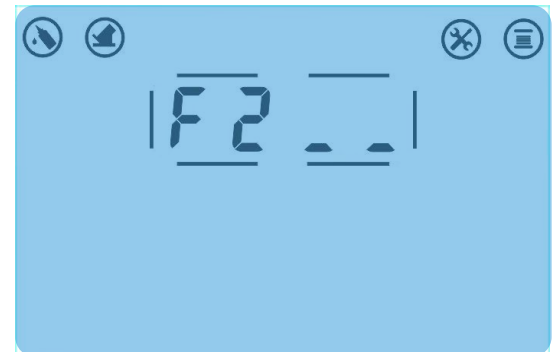
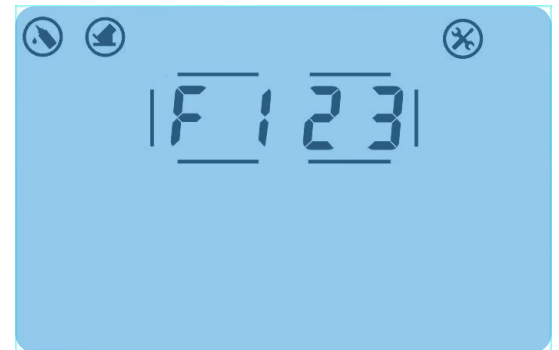
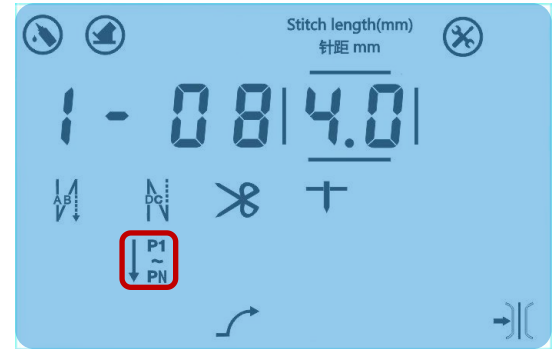
踩踏板运行到需要的线迹长度
电控会自动记录针数

如图，**F1**段记录针数为**23**针
可根据需要用**+** **-**键
适量修正针数

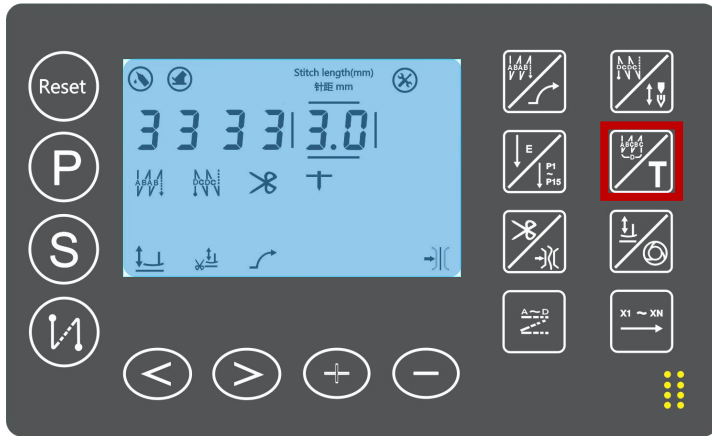
3. 多段试校

按 **>** 键，进行**T2**段针数设置
以此，依次设置各段针数

根据需要，设置所需段数
后踩脚踏板剪线，结束试校模式



二、基本参数功能介绍



1. 固缝针距

普通操作界面，短按连续固缝键+ -键选择**针距**
再次按此键返回自由缝界面



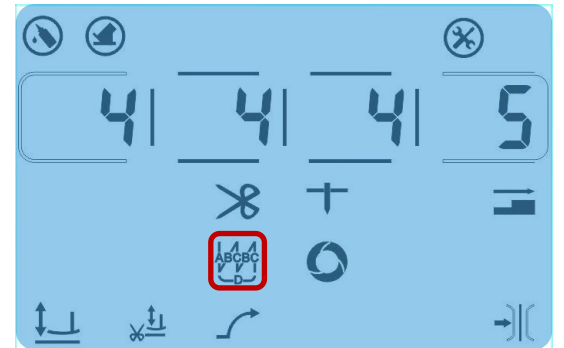
(W缝)连续固缝

短按循环：W缝/自由缝

多用于缝制标签

2. 针数次数设置

按**S**键，切换为固缝针数调节
及固缝次数调节
如图，固缝针数4针，来回5次

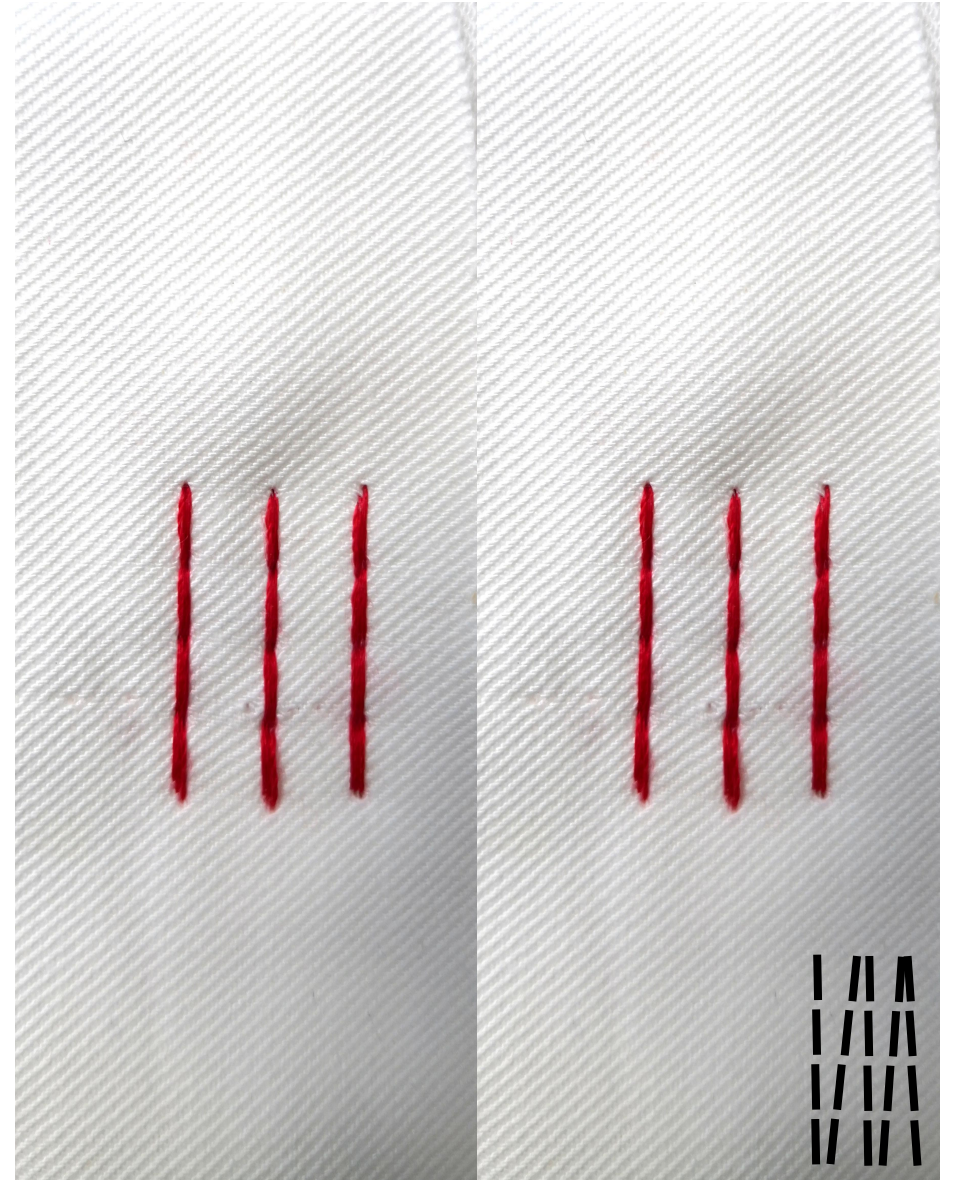


W缝 (连续固缝)

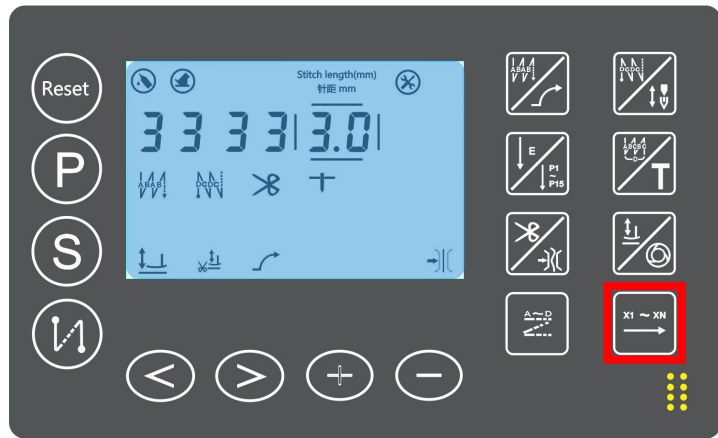
花样介绍

备注：1、固缝4针

2、来回5次



二、基本参数功能介绍



花样多段缝

1. 循环：多段自编花样缝/自由缝
2. 可设定多段缝，每段可设不同花样缝或正常针距缝。

1. 花样设定

在普通操作界面，按下段缝花样模式键，设置段缝花样

如图，设置第一段设置花样D1缝制，缝8段花样

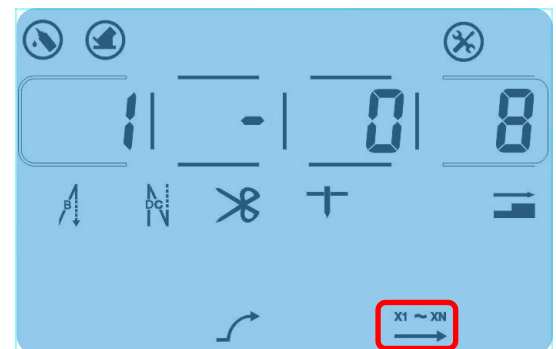
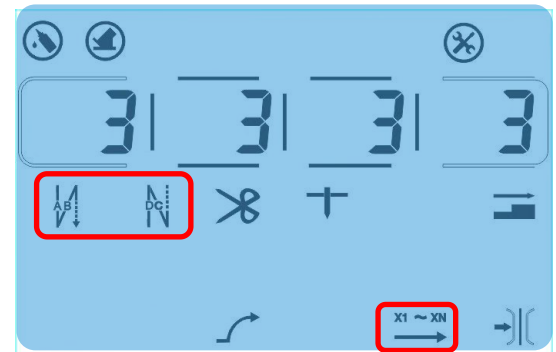
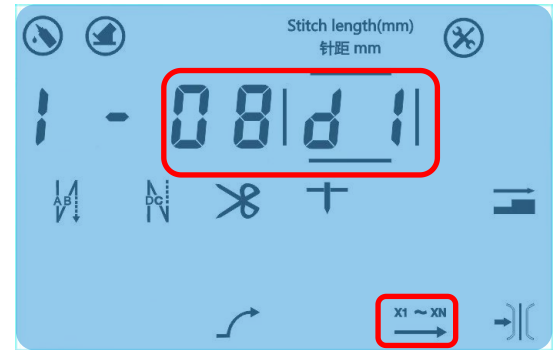
2. 倒缝针数设定

按S键，设置此模式下首尾倒回缝针数设置

如不需要此功能，请关闭倒回缝功能

3. 各段针数设定

按S键，设置此模式下各段花样缝制针数



段式自编模式

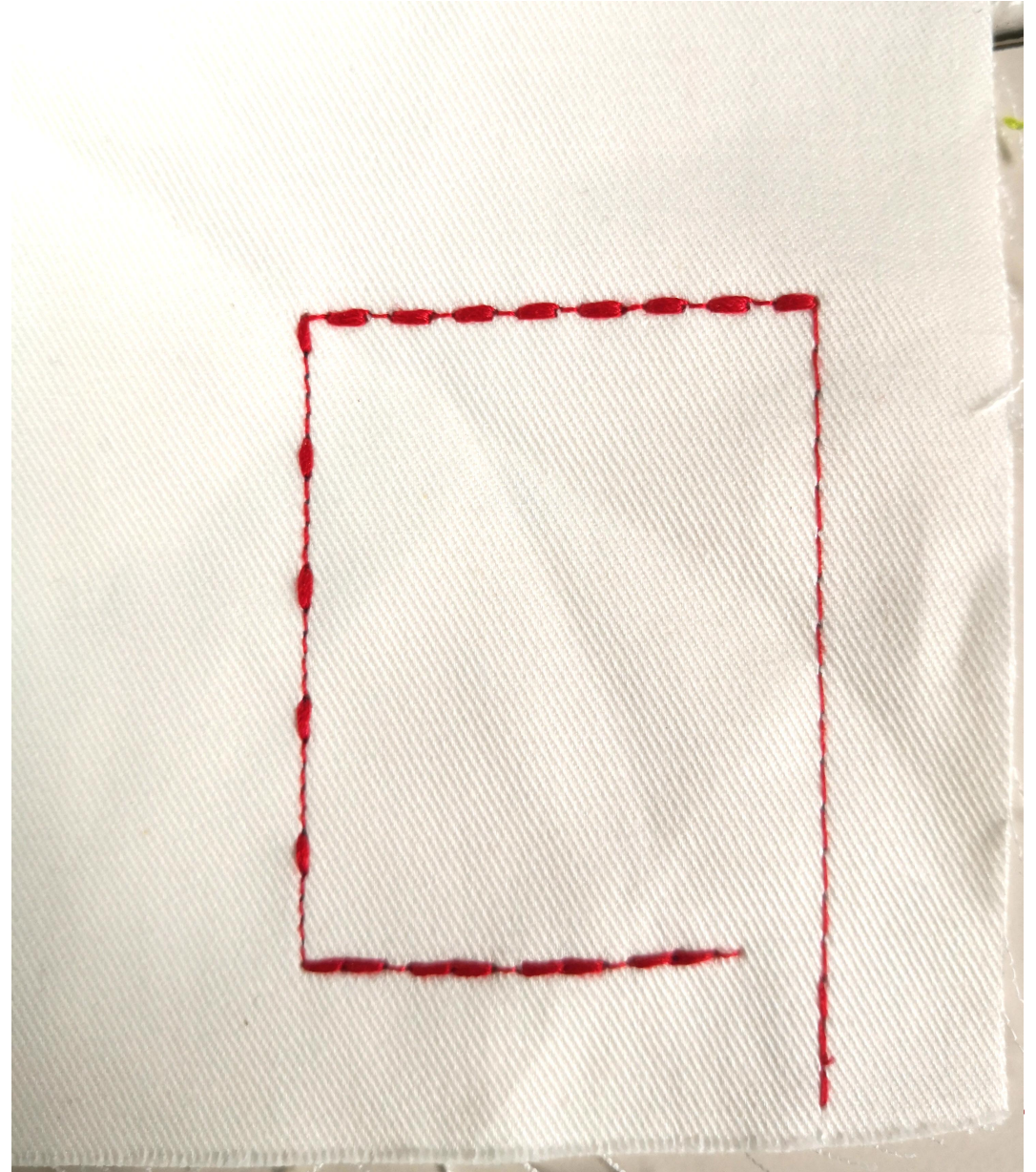
花样介绍

备注：1段：前固缝三针，针数18针，
针距6mm

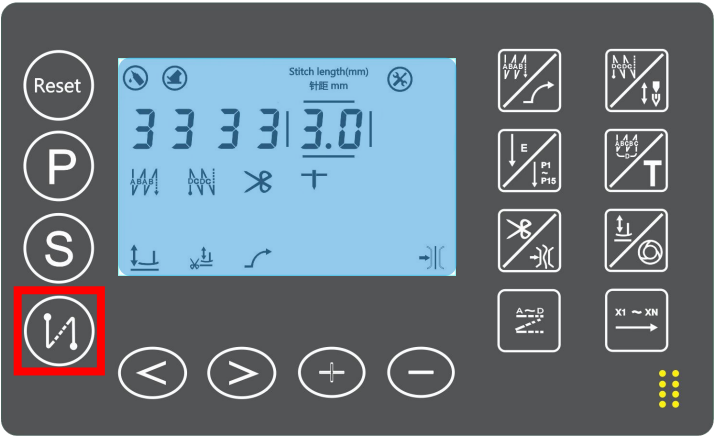
2段：花样缝D1，针数8针

3段：花样缝D2，针数5针

4段：花样缝D3，针数4针



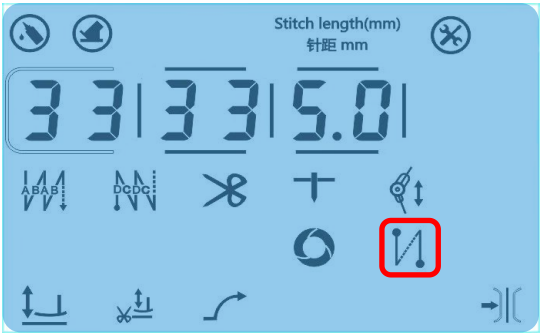
二、基本参数功能介绍



1. 密针缝功能

在普通操作界面，按下密针缝键
开启或关闭密针功能

- 参数P-78 密针模式设定
- 参数P-118 密缝针数设定
- 参数P-119 密缝针距设定



密针缝/ 机头按键功能

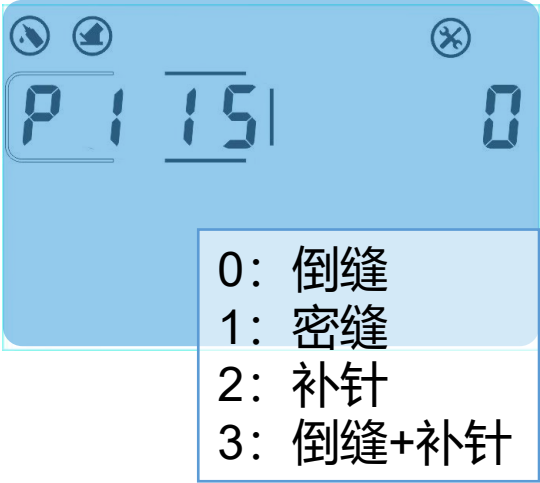
前加固及中途密针，线迹美观；
后加固密针，剪线线头短，不脱线

2. 机头按键功能

机头按键可根据需要设置功能

- 参数P-115 倒缝按钮功能
- 参数P-116 补针按钮功能设定
- 参数P-117 中途密针针距设定

可把原有按键设置任意功能



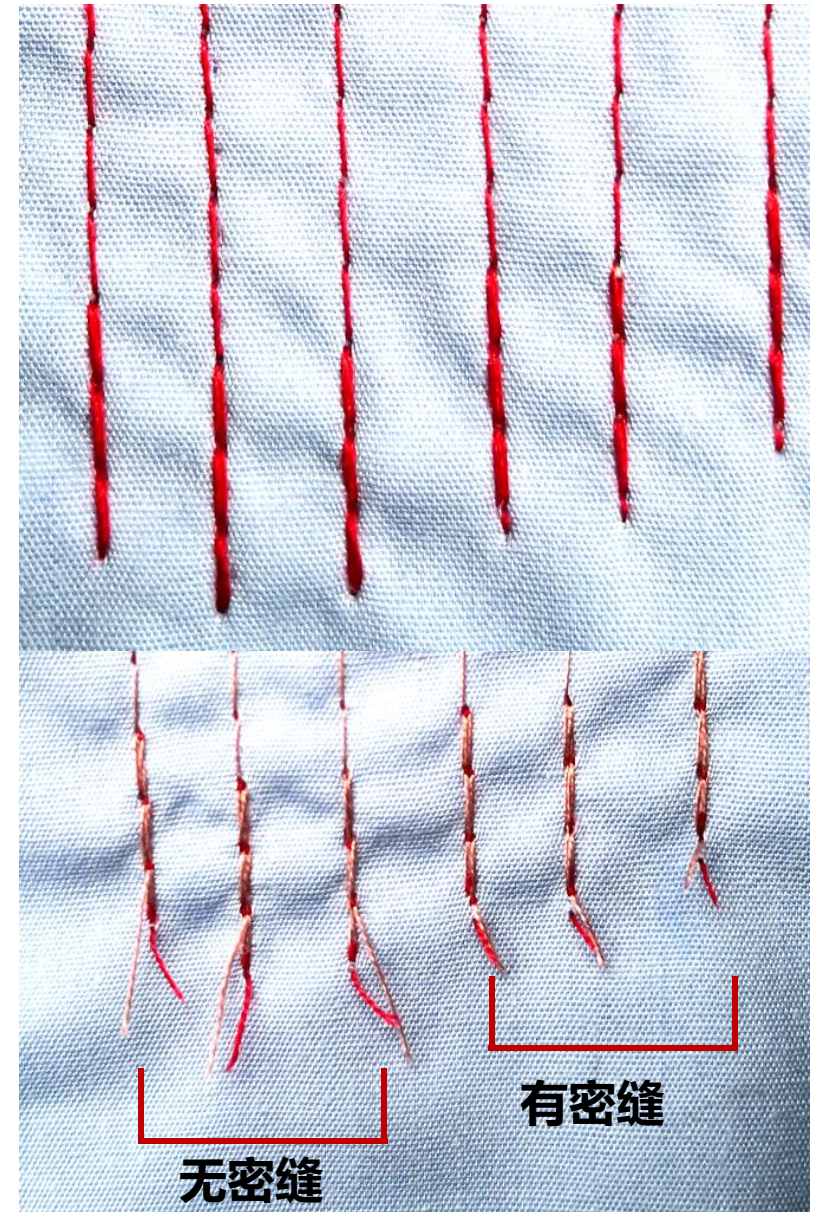
密针缝功能

花样介绍

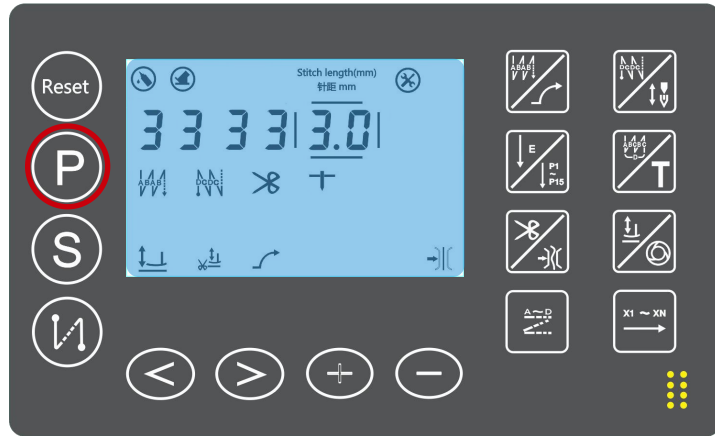
与普通缝制模式相比，
漂亮缝在后固缝结束后会
进行密针

(1-1.5mm长度可调)

剪线线头小于3mm



二、基本参数功能介绍



1. 剪线停针位调试

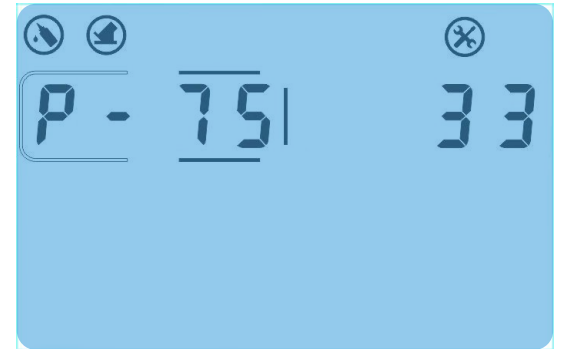
剪线动作完成后

长按**P**键，进入参数模式

选择**P-75**，S键确认

此时往前踩踏板运行一下

**用手转动手轮两周后，
停到正确剪线停针位置**



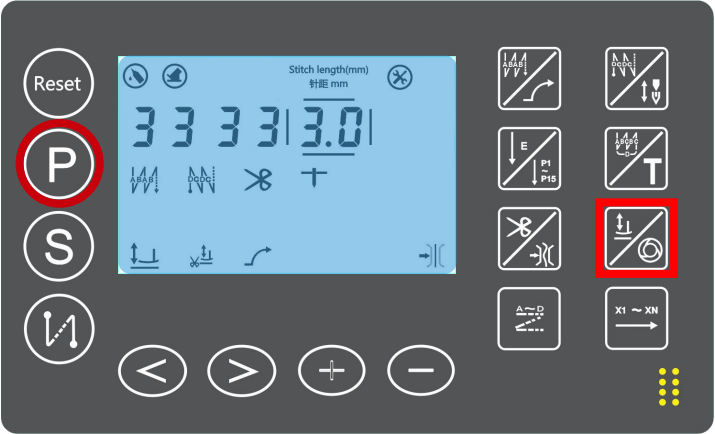
剪线停针位置调整

**通过参数进行进入调试，调节剪线后
停针位置**

(挑线杆最高位，反方向转手轮，使得
挑线杆下降到离最高点下1毫米处
或者薄料DBx1，机针针尖距离针板10mm
厚料DPx5，机针针尖距离针板12mm)

按S键保存，P键退出

二、基本参数功能介绍

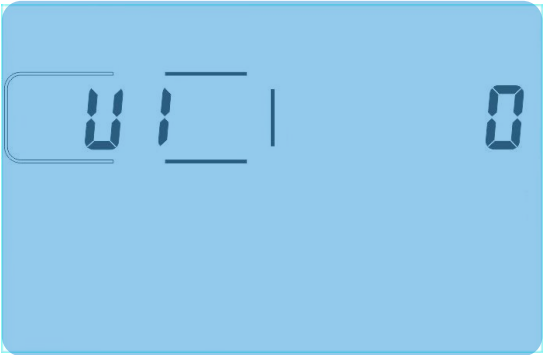


+ 监控/计件模式

通过组合键，使用监控、计件
及底线检测模式

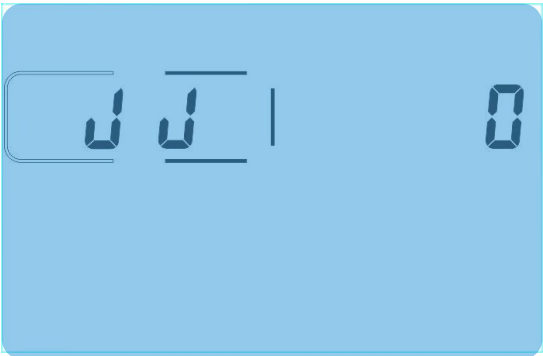
1. 监控功能

同时按 P键+触发键，
使用组合功能
监控目前机器使用状态



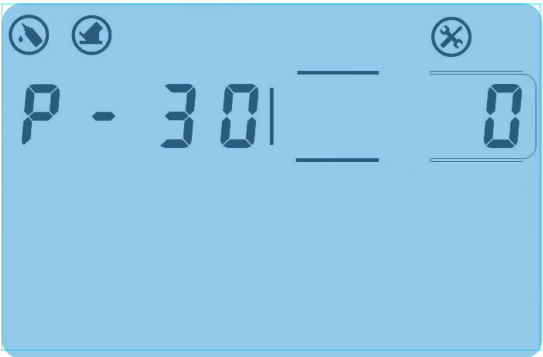
2. 计件功能

根据剪线次数，统计工作数量
JJ 计件递增
JP 计件递减



3. 底线监测功能

设置底线长度，线用完就报警
参数P-30 底线计数开/关
参数P-31 底线初值设定



1. 常规监测项

系统会随时监控目前机器使用状态
供厂家提供技术支持使用

2. 计件模式：计加JJ/计减JP

选择列表中JJ或JP功能

- 备注： 1、计件数清零长按  键3秒（在监控模式下有效）
2、 P-35参数 计件数倍率（以剪线次数做依据）
3、 P-38参数 选择 计件加JJ / 计件减JP 功能
4、计件报错：PBOB

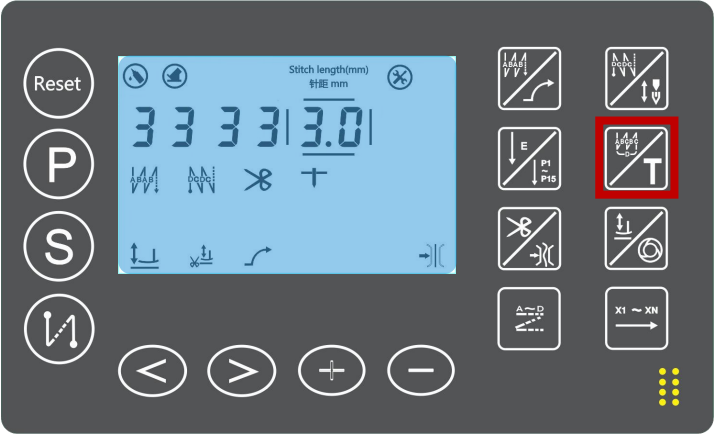
3. 底线检测模式

选择列表中DX功能

- 备注： 1、底线数清零长按  键3秒（在监控模式下有效）
2、 参数P-30 开启底线检测功能
3、 参数P-31 底线初值设定
4、底线报错：LBOB

索引号	内容	单位
U1	电机速度	rpm
U2	芯片型号（厂家使用）	GD/AT
U3	母线电压	V
U4	踏板电压	0.01V
U5	机头机械角	度
U6	电机初始角	度
U7	机头型号	JIA
U8	DSP版本号	V100
U9	DSP型号	F73
U10	步进版本号	V1xx
U11	步进压脚电流	0.01A
VER	HMI主芯片版本	v1xx
TYPE	HMI型号	C104
AD1	膝靠传感器电压	1mV
AD2	压脚高度传感器电压	1mV
H1	HMI从芯片版本号	V1xx
H2	机型	1969
JJ	计件数(加)	件
Jp	计件数(减)	件
DX	底线检测	cm

二、基本参数功能介绍



主轴电机角度调试

- 1. 更换主轴电机及编码器需要跑合角度
- 2. 电机角度不对 会影响使用性能，偶尔会出现飞车，报错，电机发热，影响使用

1. 跑合电机角度

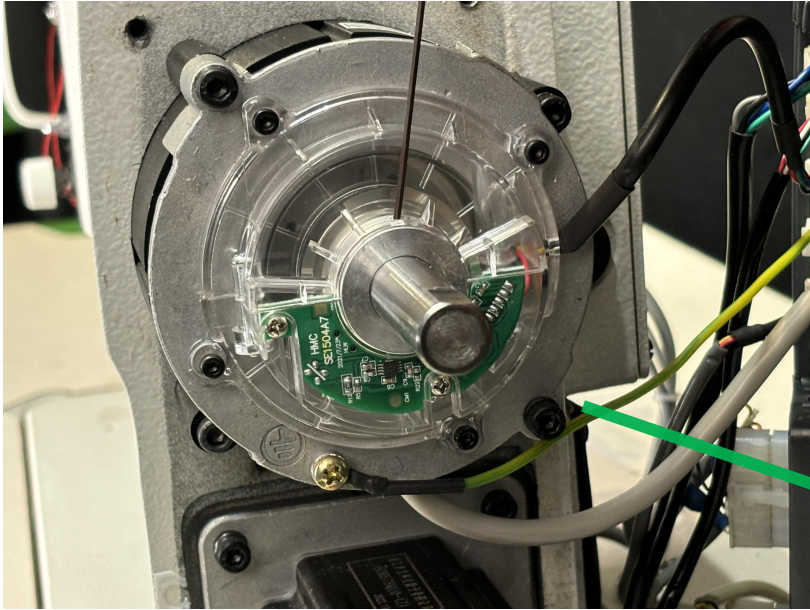
在普通操作界面，**长按T**键
选择**1-DJ**跑合电机角度模式
踩踏板，跑合电机角度
电机角度应为**268±5°**
跑合完毕，按**P**退出



2. 调节光栅

电机角度异常，拆开后盖
调节电机光栅片位置，
调一次，跑一次，直到达到
268±5°范围内。





**调节光栅
跑合电机角度**

电机角度异常，拆开后盖
调节电机光栅片位置

调一次，跑一次，直到达到
 $268 \pm 5^\circ$ 范围内

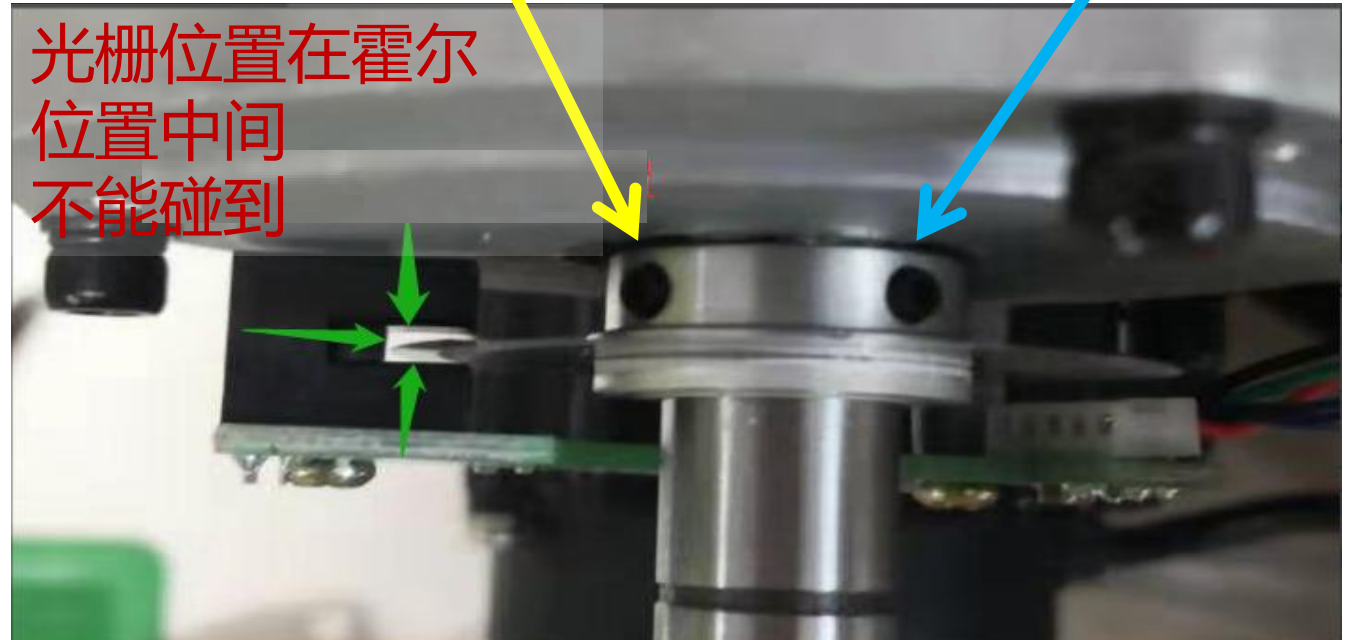
光栅向左转动

角度变小

光栅向右转动

角度变大

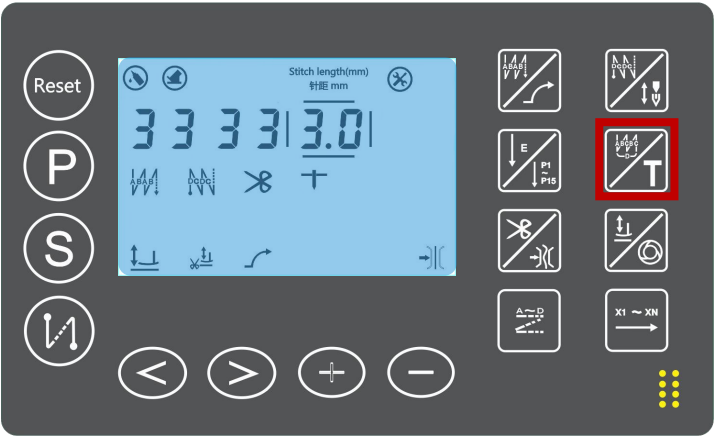
光栅位置在霍尔
位置中间
不能碰到



跑合电机角度

1. 更换主轴电机编码器需要跑合角度
2. 电机角度不对会影响使用性能，偶尔会出现飞车，报错，影响使用

二、基本参数功能介绍

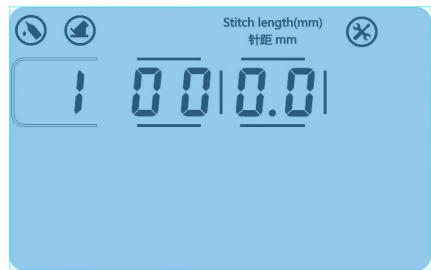
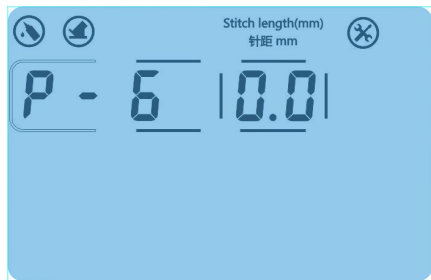


步进送料零位调整

- 1. 步进机械零位不正确，会导致整体针距大小不一，针迹不重合，严重影响缝制效果
- 2. 在实际缝制过程中，因布料、操作习惯、机械调节等情况导致线迹不美观，可用参数微调

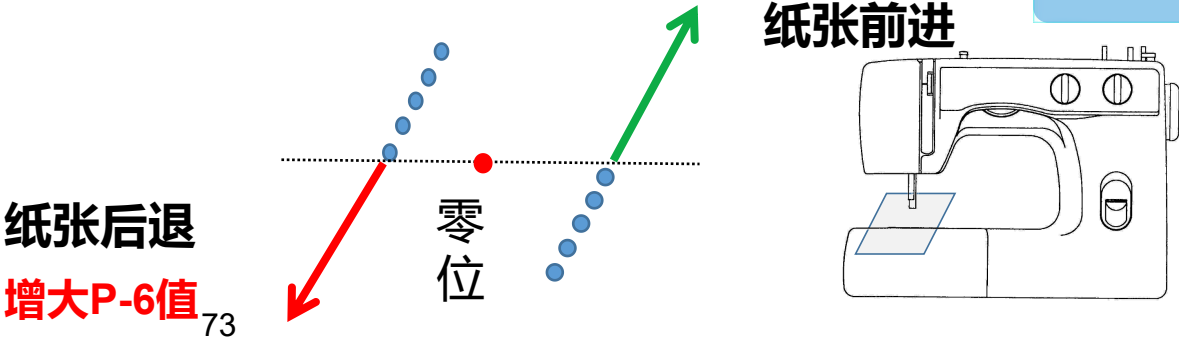
1. 步进送料零位参数调试方法：

- ① 在普通操作界面，长按 **T** 键
选择**2-BJ**，按**S**键
- ② 选择 **P-6**，**0.0**表示此时步进电机零位
那机械是不是零位呢？需要测一下
- ③ 取张白纸，放在压脚上，轻踩20针
针孔必须重叠，
- ④ **针孔不重叠**→调百分比参数，按S键保存
- ⑤ 最佳百分比为90-110之间



如图所示：

纸张后退，↑增加P-6百分比
纸张前进，↓减小P-6百分比



2. 步进送料零位机械调整方法

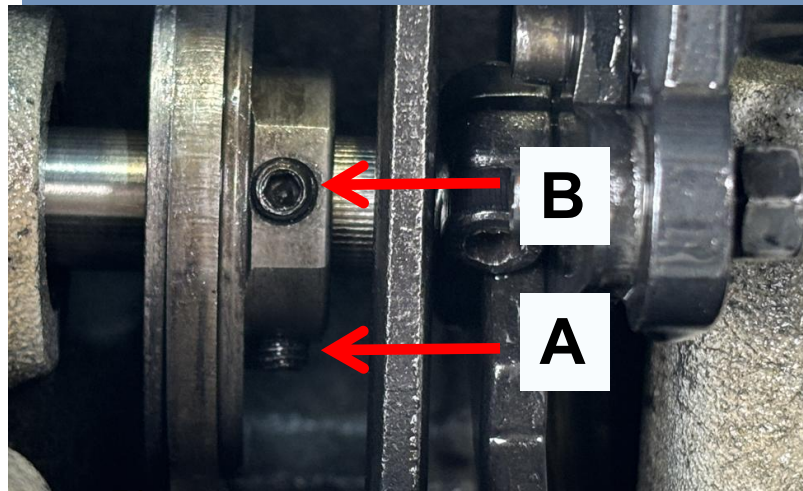
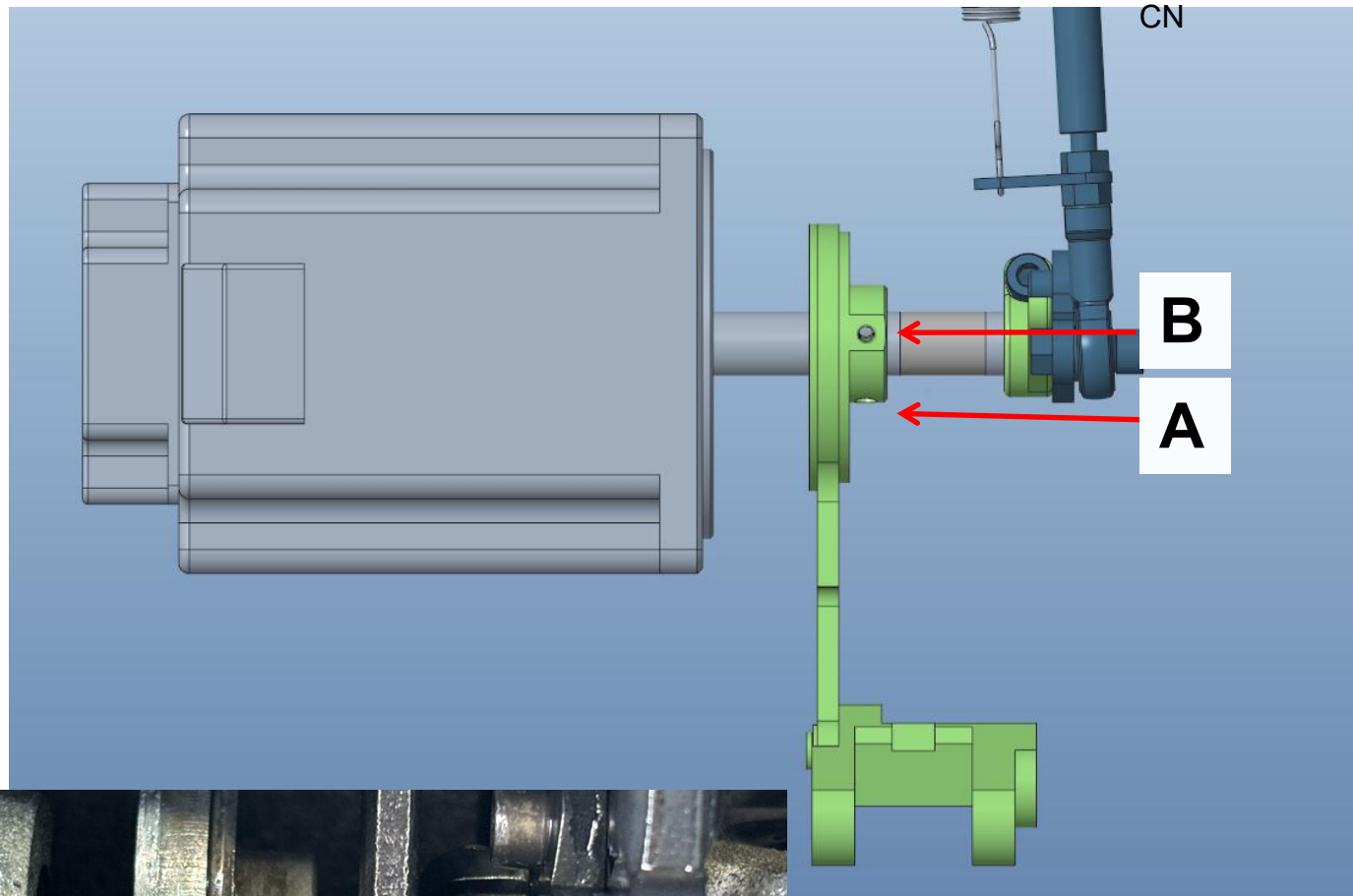
- ①选择 **P-6**,按S键, 将百分比调**100**, 按**S**
- ②打开后窗板, 先拧松 **螺钉A** 往前踩一下**踏板**拧松 **螺钉B** , 并以 B 螺钉作为调节

零位螺钉。

注意: 螺钉B 有一个平面作为调节螺钉
上下移动偏心轮, 同时观察送料情况

- ③当送料轴不送料时(机针扎在同一个孔)微微拧紧**螺钉B**,测试

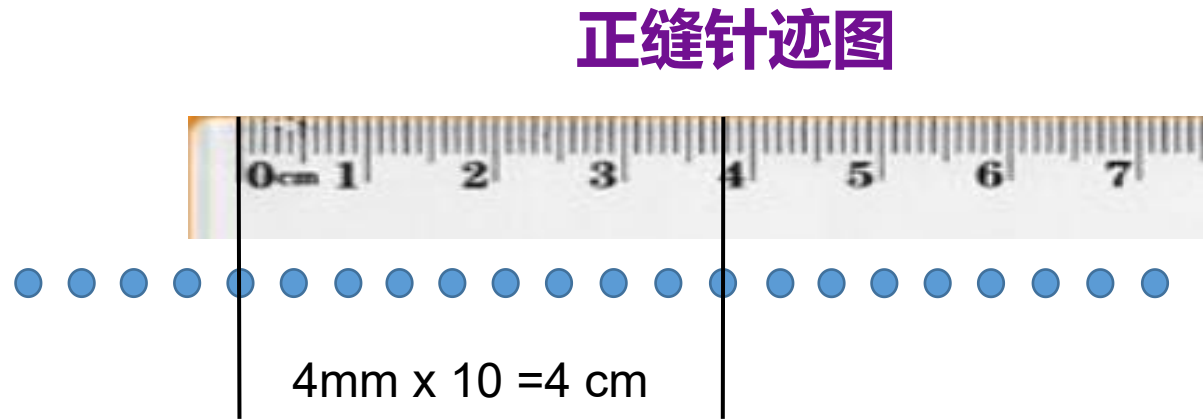
- ④多次试验, 直到零位准确, 拧紧螺钉B同样办法, 拧紧螺丝A



**注意: 完成机械粗调试,
然后用P-6参数细调**

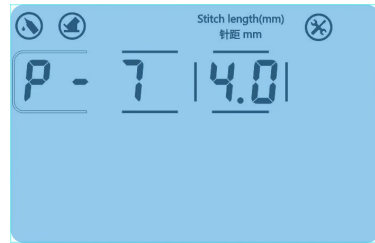
3. P-7 正缝针距修正值

- ① 在普通操作界面，按 **T** 键
选择**2-BJ**，按**S**键
- ② 选择 **P-7**，**4.0**表示针距**4mm**，
- ③ 取一张白纸，放在压脚下，踩20针
- ④ 取中间10段，用直尺量，此时
 $4\text{mm} \times 10 = 4\text{公分}$
- ⑤ 按S键，修改百分比后，按S保存



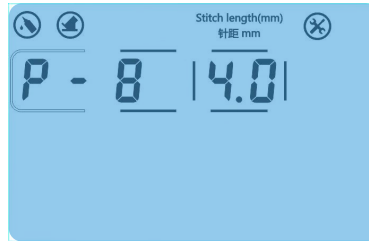
实际测试比4公分**大**↑，适当**减小**P-7百分比

实际测试比4公分**小**↓，适当**增大**P-7百分比
合理范围：4CM~4.3CM



4. P-8 逆缝针距修正值

① 在普通操作界面，按 **T** 键
选择**2-BJ**，按**S**键



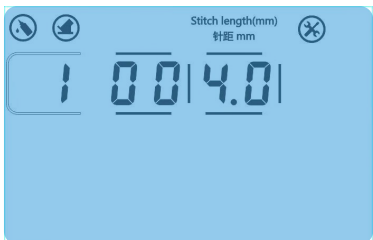
② 选择 **P-8**, **4.0**表示针距**4mm**，选择你需要修正的针距，左右键可修改针距

③ 取一张白纸，放在压脚上，踩10针，停
按住倒缝开关，轻踩

如右图所示，**观察倒缝与正缝重合程度**

走快了，就减小百分比，走慢了，就增大百分比

⑤ 按S键，修改百分比后，按S保存



正缝

1 ●

P-8 倒缝针距补偿

2 ●

← 走**多了**，P-8 **减小**

← 走**少了**，P-8 **增大**

3 ●



4 ●



倒缝

1. 抬压脚机械位置调整

① 调试方法：

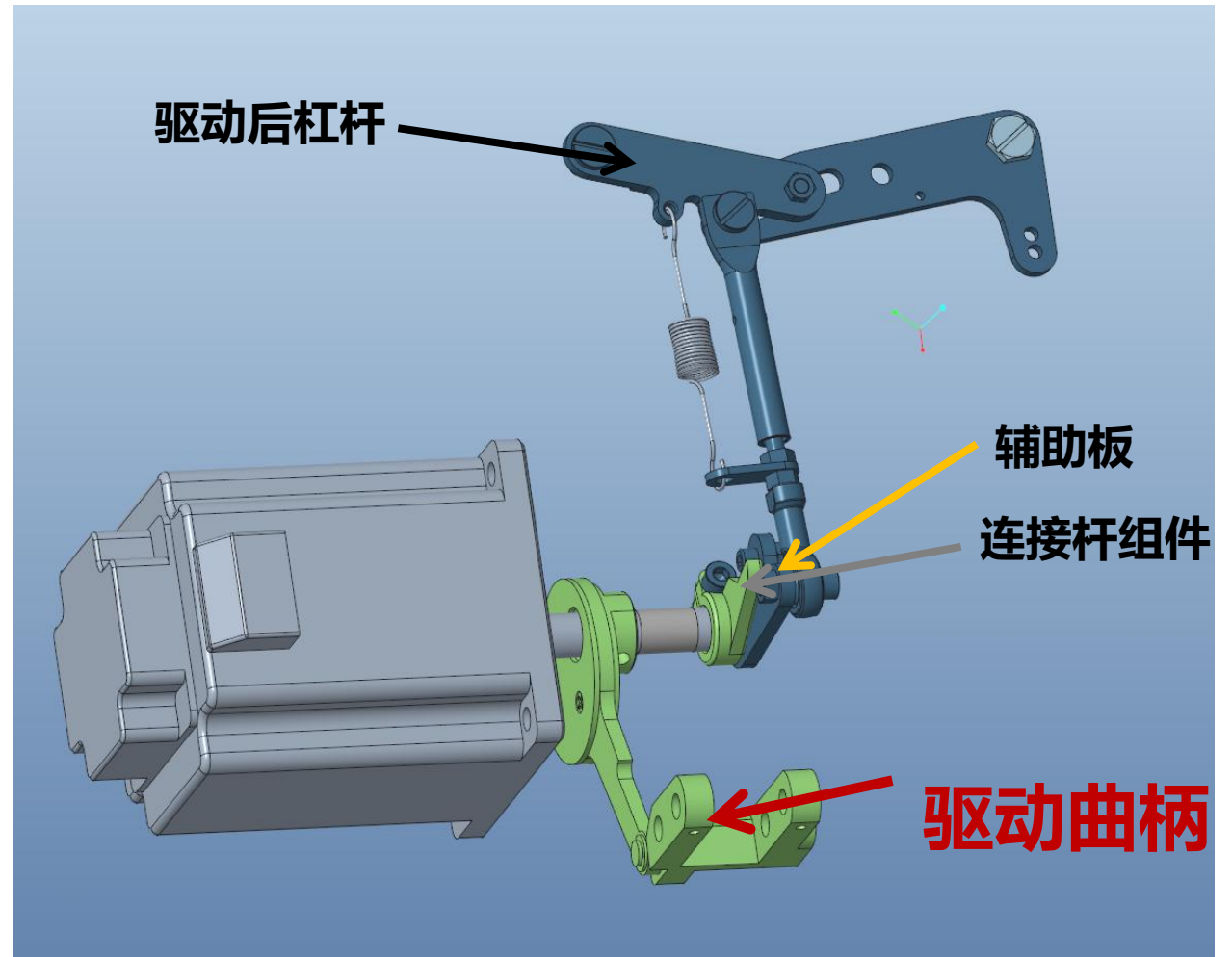
1：左右位置：

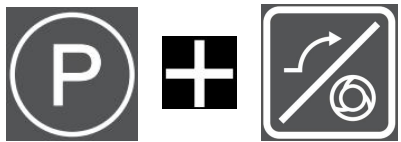
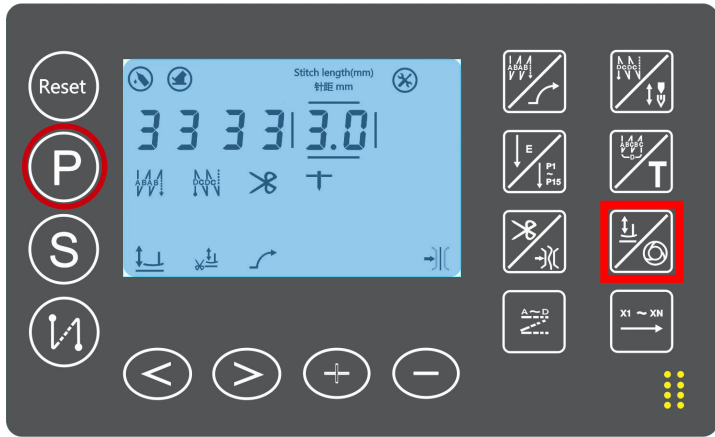
抬压曲柄必须向右靠抬压辅助板

2：上下位置：

抬压曲柄 距离 抬压辅助板杆 2MM

(必须保持距离，距离越小越好)





踏板零位调整

1. 踏板零位调整

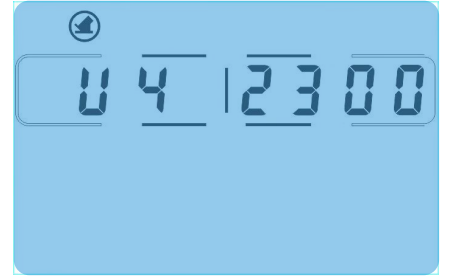
1. 踏板零位调整

同时按 P键+触发键，
使用组合功能

选择U4，并确认，此时显示为
踏板电压。踏板电压正常值为：

$2300 \pm 30^\circ$ 为正常

异常请调节踏板磁钢



2. 踏板零位校正

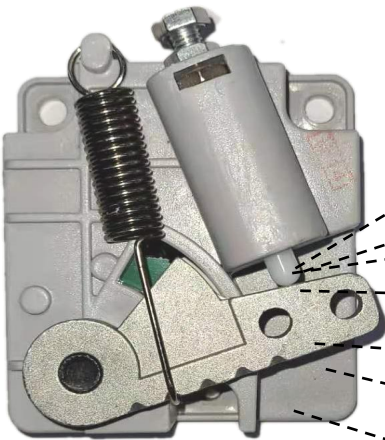
长按T键，选择参数3-pd

按S键确认，显示PDL

踩踏板开始校正

校正完毕显示PASS





- 压脚升起 -30°
- 剪线行程2 -60°
- 剪线行程1 -30°
- 零位 0°
- 开始运行 25°
- 开始加速 50°
- 运行高速 110°

1. 踏板行程调整

在普通操作界面，长按P键
进入参数模式，+ - 键选择
参数，S键确认参数

注：可调节踏板在不同位置
的角度，获得不同的脚感

P 踏板行程调整

- 1. 踏板零位 - 停车位置
 - 2. 开始运行 - 机器开始慢慢走的位置
 - 3. 开始加速 - 机器开始加速的位置
 - 4. 压脚升起 - 抬压脚开始工作的位置
 - 5. 剪线行程1 - 没有抬压脚，剪线的位置
 - 6. 剪线行程2 - 有抬压脚，剪线的位置
- 抬压脚命令时间：踏板后踩，抬压脚功能需要等
x毫秒开始工作

编号	项目	设定范围	默认值
P-41	踏板最低速度	100 ~ 500	200
P-63	踏板加速曲线	0: 正常 1: 加速慢 2: 加速快	2
P-62	开始运行的踏板行程	10 ~ 50	25
P-63	开始加速的踏板行程	10 ~ 100	50
P-64	运行高速的踏板行程	10 ~ 150	110
P-65	压脚升起的踏板行程	-100 ~ -10	-30
P-67	剪线动作的踏板行程1	-100 ~ -10	-30
P-68	剪线动作的踏板行程2	-100 ~ -10	-60
P-92	踏板抬压脚命令时间	100 ~ 300	80

最受欢迎的脚感参数：
P-42 (改2), P-62(15)
P-63(改30), P-64(改85)
P-68 (改-70), P-92(改300)

熟练工脚感参数：
P-42 (改2), P-62(15)
P-63(改30), P-64(改85)
P-68 (改-55), P-92(改200)
这套参数适用于长件工序（门襟）

新手脚感(感觉踏板太灵敏)：
P42(改1), P62(改15),
P63(改60), P64(改150)
P-68 (改-70), P-92(改300)

大神脚感参数：
P42(改2), P62(改15),
P63(改25), P64(改70)
P-68 (改-55), P-92(改150)

编号	项目	内容	设定范围	步距	默认值	级别
P-01	踏板最高速	设定踏板的最高转速	200~3000(rpm)	100	2400	I
P-02	软起动功能	开始缝纫时低速缝纫几针的功能: 1~9: 软起动针数	0~9	1	2	I
P-04	定长缝最高速	设定定长缝最高速度	200~3000(rpm)	100	2200	I
P-06	零位针距修正值	针距设为 0mm 时微调该值使实际缝纫针距为 0	50~ 150	1	100	I
P-07	正缝针距修正值	正缝针距放大比例 (固缝针迹)	50~ 150(%)	1	100	I
P-08	倒缝针距修正值	倒缝针距放大比例 (固缝针迹)	50~ 150(%)	1	100	I
P-09	倒缝开关限速速度	倒缝开关限速速度	500~ 1500(rpm)	50	1500	I
P-10	定长缝自编针距针数设定模式	0:设定各段针数即设定数值 1:定长缝设成自编时, 设定数值为花样的个数, 即总针数为花样针数×设定数值	0/1	1	1	I
P-12	抬压脚第一段角度	抬压脚第一段角度	0~ 100	1	30	I
P-13	压脚最大抬升高度 (步进有效)	剪线后压脚最大高度设置	0~ 100	1	55	II
P-14	压脚抬升速度 (步进有效)	压脚抬升的步进速度	20~500(rpm)	10	60	II

编号	项目	内容	设定范围	步距	默认值	级别
P-15	压脚释放速度（步进有效）	压脚释放的步进速度	20~500(rpm)	10	100	II
P-16	放压脚第一段角度	放压脚第一段角度	0~ 100	1	30	I
P-17	剪线松线占空比	剪线为电磁铁时：剪线松线占空比 (太小会影响剪线电磁铁吸合力度) 剪线为步进时：松线力度调节	0~ 100	1	50	II
P-18	前固缝衔接后固缝动作设定	前固缝结束立即后踩剪线不带后固缝功能设定：0：无效 1：有效	0/1	1	0	I
P-19	前固缝结束后停止	前固缝结束后停止设定 0：无效 1：有效	0/1	1	0	I
P-20	机头按键附件功能选择	0：无效 1：待机时手动剪线 2：剪线后手动压脚	0/1/2	1	0	I
P-21	软启动速度 1	软启动第 1 针速度	100~3000(rpm)	50	400	I
P-22	软启动速度 2	软启动第 2 针速度	100~3000(rpm)	50	1000	I
P-23	软启动速度 3	软启动第 3~9 针速度	100~3000(rpm)	50	1500	I

编号	项目	内容	设定范围	步距	默认值	级别
P-24	压脚软下降功能	防止损伤布料减慢压脚下降速度的设定	0/1	1	0	I
P-25	抬压脚使能	抬压脚使能设定 0：无效 1：有效 2：剪线后有效	0/1/2	1	1	I
P-26	过厚功能	过厚功能设定 0：无效 1：有效	0/1	1	0	I
P-27	上电定位设定	上电时机头自动找上针位的功能设定 0：无效 1：有效	0/1	1	0	I
P-28	安全开关信号模式	机头安全开关信号模式设定 0：常开 1：常闭 2：禁止保护	0/1/2	1	0	I
P-29	压脚软下降时间	压脚软下降时间设定 时间越长压脚下降越慢	100~500 (ms)	5	300	II
P-30	底线计数使能	0:无效 1：有效	0/1	1	0	I
P-31	底线初值设定	底线初值设定	200~4000 (0.1m)	20	1600	I
P-33	前固缝 ABA 模式选择	0：无效 1：有效	0/1	1	0	I
P-34	标准固缝速度模式选择	标准固缝速度模式选择 0 自动； 1 踏板控制	0/1	1	0	II

编号	项目	内容	设定范围	步距	默认值	级别
P-35	计件数倍率	计件数倍率设定	0~50	1	0	I
P-36	计件数初值设定	计件数初值设定	0~ 1000	5	100	I
P-37	拨线动作时间	拨线动作时间	0~800 (ms)	10	40	II
P-38	计件选择设定	0: 计件加 1: 计件减	0/1	1	0	I
P-39	压脚下降关断时间	压脚下降关断时间	0~50	1	0	II
P-41	低速速度	踏板最低速度	100~500(rpm)	10	200	I
P-42	踏板曲线选择	踏板调速功能调整 0: 正常 1: 加速慢 2: 加速快	0/1/2	1	0	I
P-44	剪线速度	剪线速度	100~500(rpm)	10	250	I
P-45	倒缝开关限速使能	倒缝开关限速处理 可以防止倒缝断针 0: 无限速 1: 有限速 2: 一直限速	0/1/2	1	2	I
P-46	放压脚延迟缝纫时间	为确认压脚已放下的延时	0~800(ms)	10	100	II
P-47	运行时膝靠压脚判断速度	运行时膝靠压脚判断速度	200~ 1000(rpm)	50	500	II

编号	项目	内容	设定范围	步距	默认值	级别
P-48	运行时膝靠压脚抬升高度	运行时膝靠压脚抬升高度	1~ 100	1	0	II
P-49	抬压脚保持时间	抬压脚保持时间后强制关断	1~60(s)	1	12	II
P-50	抬压脚全压输出时间	抬压脚全压输出时间	0~800(ms)	10	150	II
P-51	抬压脚输出占空比	抬压脚输出占空比	0~ 100	1	40	II
P-53	前固缝速度	前加固缝速度	100~3000(rpm)	50	1200	I
P-54	前固缝正缝补偿	前固缝正缝补偿系数	80~ 120	1	100	I
P-55	前固缝倒缝补偿	前固缝倒缝补偿系数	80~ 120	1	100	I
P-56	后固缝速度	后加固缝速度	100~3000(rpm)	50	1200	I
P-57	后固缝正缝补偿	后固缝正缝补偿系数	80~ 120	50	100	I
P-58	后固缝倒缝补偿	后固缝倒缝补偿系数	80~ 120	50	100	I
P-59	连续固缝速度	连续加固缝速度	100~3000(rpm)	50	1200	I
P-60	固缝取消限速开关	0: 软件有限速 1: 软件不限速 (大针距速度高时针迹可能不稳定)	0/1	1	0	I

编号	项目	内容	设定范围	步距	默认值	级别
P-61	机头按钮变针距取消角度限制开关	0: 在限制角度内变针距 1: 任意角度变针距 (针距可能不重合, 也可能断针)	0/1	1	0	I
P-62	开始运行的踏板行程	开始运行的踏板位置 (相对于踏板中立时的行程)	10~50(0.1 度)	1	15	II
P-63	开始加速的踏板行程	开始加速运行的踏板位置 (相对于踏板中立时的行程)	10~ 100(0.1 度)	1	45	II
P-64	运行高速的踏板行程	运行到最高速的踏板位置 (相对于踏板中立时的行程)	10~ 150(0.1 度)	1	100	II
P-65	压脚升起的踏板行程	压脚抬起动作的踏板位置 (相对于踏板中立时的行程)	-100~-10(0.1 度)	1	-25	II
P-67	剪线动作的踏板行程 1	无抬压脚功能时, 开始剪线的踏板位置 (相对于踏板中立时的行程)	-100~-10(0.1 度)	1	-50	II
P-68	剪线动作的踏板行程 2	有抬压脚功能时, 开始剪线的踏板位置 (相对于踏板中立时的行程)	-100~-10(0.1 度)	1	-60	II
P-69	下停针位	下停针位位置调整	0~240	1	175	I

编号	项目	内容	设定范围	步距	默认值	级别
P-70	提针功能	0: 关闭 1: 剪线后提针 2: 放压脚提针 3: 剪线后和放压脚时均提针	0~3	1	0	I
P-71	反转提针角度	反转提针角度	260~360(度)	1	330	I
P-72	夹线力度调整	调整夹线力度大小 0: 夹线功能无效 1~9: 力度调节	0~99	1	7	I
P-73	夹线吸合角度	夹线吸合角度	10~360(度)	5	100	I
P-74	夹线释放角度	夹线释放角度	160~360(度)	5	270	I
P-75	机头基准位置调整	机头基准位置调整	0~240	1	33	I
P-77	密针缝功能设置	0: 无效 1: 有效	0/1	1	0	I

编号	项目	内容	设定范围	步距	默认值	级别
P-78	密针缝模式设定	1: 起缝密针 2: 结尾密针 3: 首尾密针	1/2/3	1	3	Ⅱ
P-79	恢复出厂参数	特殊功能参数 5/8: 恢复出厂参数	0~ 15	1	0	I
P-80	缝纫最高速度	缝纫最高转速	300~3000(rpm)	100	2500	Ⅱ
P-81	踏板速度百分比	踏板速度百分比	50~ 100	1	100	Ⅱ
P-82	试用时间	试用功能 0 : 试用功能无效; 10~ 1000: 上电试用时间	0~ 1000(小时)	10	0	Ⅲ
P-83	加重功能	机针穿不透布时试用; 0 : 无效; 1~ 15: 力度调整	0~ 15	1	0	Ⅱ
P-84	剪线加力功能	剪线为电磁铁时有效; 0 : 无效; 1~ 15: 力度调整	0~ 15	1	0	Ⅱ

编号	项目	内容	设定范围	步距	默认值	级别
P-88	松线吸合角度	松线吸合角度	0~360	2	180	II
P-89	松线释放角度	松线释放角度	0~360	2	350	II
P-90	语言选择设定	语言选择设定：0：关闭 1：中文 2：英文	0~2	1	1	II
P-91	针距更改选择设定	针距是否可更改选择设定 0：允许更改 1：不允许更改	0~ 1	1	0	II
P-92	踏板抬压脚命令时间	踏板后踩，抬压脚命令有效时确认时间	10~300(ms)	10	80	II
P-93	踏板中立位置	踏板中立位置微调	-15~ 15(0.1 度)	1	0	II
P-95	防鸟巢功能选择	防鸟巢功能选择：0：夹线机型 1：防鸟巢机型 2：拨线机型	0/1/2	1	0	II

编号	项目	内容	设定范围	步距	默认值	级别
P-99	机型选择	机型模式选择	/	/	/	Ⅲ
P-100	膝靠功能设置	膝靠功能设置：0：无效 1：有效	0/1	1	0	Ⅱ
P-101	膝靠传感器零位电压	膝靠压脚零位电压值（单位 0.01V）	0~500	5	270	Ⅱ
P-102	膝靠传感器最大行程电压	膝靠压脚最大行程电压值（单位 0.01V）	0~500	5	60	Ⅱ
P-103	线张力/松线功能切换	0：线张力控制 1：普通松线电磁铁控制	0/1	1	1	Ⅱ
P-104	花样停针功能使能	0：无效 1：停针需走完当前花样针数	0/1	1	0	Ⅱ
P-105	压脚高度传感器功能设定	压脚高度传感器功能设定 0：无效 1：有效	0/1	1	1	Ⅱ

编号	项目	内容	设定范围	步距	默认值	级别
P-106	压脚高度传感器零位电压调整	压脚高度传感器零位电压调整 (单位 0.01v) (压脚落下、送料牙在台板下)	0~250	1	215	II
P-107	过厚检测灵敏度设定	过厚检测的压脚高度传感器电压设定 (单位 mv) (相对于零位电压)	0~500	5	100	II
P-108	剪线全压占空比	剪线全压占空比 (剪线吸合时缓冲)	50~ 100	1	98	II
P-109	压脚全压占空比	压脚全压占空比 (压脚吸合时缓冲)	50~ 100	1	80	II
P-110	布料厚度与张力控制	缝厚料时适当加大张力	0~ 10	1	0	II
P-111	过厚缝纫速度	过厚时限速处理	500~3000(rpm)	50	1500	II
P-112	过厚针距补偿系数	过厚针距补偿处理	50~ 150(%)	1	120	II

编号	项目	内容	设定范围	步距	默认值	级别
P-113	补针针距模式	补针针距模式 0：无效 1:有效（按 P114 设定针距）	0/1	1	0	I
P-114	补针针距设定	针距 5mm 机型参数范围(1.0mm~5.0mm) 针距 7mm 机型参数范围(1.0mm~7.0mm)	10 ~ 50 (70)	1	40	I
P-115	倒缝按钮功能设定	倒缝按钮功能设定：0：倒缝 1：密缝 2：补针 3：倒缝+补针	0~3	1	0	II
P-116	补针按钮功能设定	补针按钮功能设定：0：倒缝 1：密缝 2：补针 3：倒缝+补针	0~3	1	2	II
P-117	密缝针距设定	机头按钮密缝针距设定	50~ 150	1	110	II
P-118	前密针针数设定	前密针缝纫针数设定	1~ 10	1	1	II
P-119	前密针针距设定	前密针缝纫针距设定	50~ 150	1	110	II

编号	项目	内容	设定范围	步距	默认值	级别
P-121	剪线第 1 段开始角度	剪线第 1 段开始角度设定	200~300	2	230	Ⅱ
P-122	剪线第 1 段行程	剪线第 1 段行程设定	0~ 100	1	40	Ⅱ
P-123	剪线第 2 段开始角度	剪线第 2 段开始角度设定	250~360	2	330	Ⅱ
P-124	剪线第 2 段行程	剪线第 2 段行程设定	0~ 100	1	60	Ⅱ
P-125	定长缝中途停车剪线模式	0: 无效 1: 有效	0/1	1	0	Ⅱ
P-126	起缝松线使能	0: 无效 1: 有效	0/1	1	1	Ⅱ
P-127	起缝松线前延时	起缝松线前延时	0~ 1000	10	100	Ⅱ
P-128	起缝松线动作时间	起缝松线动作时间	0~ 1000	10	200	Ⅱ

编号	项目	内容	设定范围	步距	默认值	级别
P-129	显示屏背光亮度设定	显示屏背光亮度设定	0~ 10	1	5	I
P-135	中途倒缝功能选择	0.无效 1.有效	0~ 1	1	0	I
P-136	中途倒缝针数设定	针数设定 1~50 针	1~50	1	4	I
P-137	中途倒缝来回次数设定	次数设定 1~ 10 次	1~ 10	1	1	I
P-140	防鸟巢勾线前延时	剪线结束到勾线动作的延迟时间	0~500ms	5	50	II
P-141	防鸟巢勾线动作时间	勾线电磁铁的动作时间	0~500ms	5	50	II
P-142	防鸟巢勾线后延时	勾线电磁铁关断的延迟时间	0~500ms	5	50	II
P-143	防鸟巢勾线占空比	调整勾线电磁铁的动作力度	0~ 100	1	100	II

编号	项目	内容	设定范围	步距	默认值	级别
P-144	防鸟巢吸气动作时间	吸气气阀的动作时间	0~2000ms	10	250	II
P-145	防鸟巢挺线动作时间	挺线电磁铁的动作时间	0~500ms	5	50	II
P-150	最大针距设定	最大针距设定	10~ 100mm	1	80	II
P-151	起缝第一针防脱线功能开关	0.无效 1.有效	0~ 1	1	0	II
P-152	起缝第一针防脱线针距设定	针距设定, 参数范围 (1.0mm~5.0mm)	10~50	1	40	II
P-153	机头按钮点动模式设定	0: 无效 1: 点动有效 (按一次有效再按一次取消, 如密缝、过厚、压脚)	0~ 1	1	0	II
P-158	后密针针数设定	后密针缝纫针数设定	1~ 10	1	1	II

编号	项目	内容	设定范围	步距	默认值	级别
P-159	后密针针距设定	后密针缝纫针距设定	50~ 150	1	110	Ⅱ
P-161	1/2 补针按键功能设定	0: 倒缝 1: 密缝 2: 1/2 补针 3: 脚抬抬压脚	0~3	1	2	Ⅱ
P-162	1/4 补针按键功能设定	0: 倒缝 1: 密缝 2: 1/4 补针 3: 脚抬抬压脚	0~3	1	2	Ⅱ
P-166	前密针速度	前密针速度设定	200~3000	100	1500	Ⅱ
P-167	后密针速度	后密针速度设定	200~3000	100	600	Ⅱ
P-169	待抬压脚位置调节	通过此参数可调节 压脚放下后抬压脚曲柄的位置。	0~ 100	1	30	Ⅱ
P-170	按速度补偿系数使能	=0, P171~P176 参数无效; =1, P171~P176 参数生效	0 ~ 1	1	1	Ⅱ

编号	项目	内容	设定范围	步距	默认值	级别
P-171	速度正缝补偿	速度正缝补偿系数	50 ~ 150	1	100	II
P-172	速度倒缝补偿	速度倒缝补偿系数	50 ~ 150	1	100	II
P-173	前固缝速度正缝补偿	速度正缝补偿系数	50 ~ 150	1	100	II
P-174	前固缝速度倒缝补偿	速度倒缝补偿系数	50 ~ 150	1	100	II
P-175	后固缝速度正缝补偿	速度正缝补偿系数	50 ~ 150	1	100	II
P-176	后固缝速度倒缝补偿	速度倒缝补偿系数	50 ~ 150	1	100	II
P-177	按键补针模式	0: 连续补半针 1: 连续补一针 2: 半针 3: 一针	0 ~ 3	1	3	I
P-178	按键 1/2 补针模式	0: 连续补半针 1: 连续补一针 2: 半针 3: 一针	0 ~ 3	1	3	I

编号	项目	内容	设定范围	步距	默认值	级别
P-179	按键 1/4 补针模式	0: 连续补半针 1: 连续补一针 2: 半针 3: 一针	0 ~ 3	1	3	I
P-180	按针距补偿系数使能	=0, P181~P200 参数无效; =1, P181~P200 参数生效	0 ~ 1	1	1	II
P-181	1mm 正缝补偿	1mm 正缝补偿系数	50 ~ 150	1	100	II
P-182	1mm 倒缝补偿	1mm 倒缝补偿系数	50 ~ 150	1	100	II
P-183	2mm 正缝补偿	2mm 正缝补偿系数	50 ~ 150	1	100	II
P-184	2mm 倒缝补偿	2mm 倒缝补偿系数	50 ~ 150	1	100	II
P-185	3mm 正缝补偿	3mm 正缝补偿系数	50 ~ 150	1	100	II

编号	项目	内容	设定范围	步距	默认值	级别
P-186	3mm 倒缝补偿	3mm 倒缝补偿系数	50 ~ 150	1	100	II
P-187	4mm 正缝补偿	4mm 正缝补偿系数	50 ~ 150	1	100	II
P-188	4mm 倒缝补偿	4mm 倒缝补偿系数	50 ~ 150	1	100	II
P-189	5mm 正缝补偿	5mm 正缝补偿系数	50 ~ 150	1	100	II
P-190	5mm 倒缝补偿	5mm 倒缝补偿系数	50 ~ 150	1	100	II
P-191	6mm 正缝补偿	6mm 正缝补偿系数	50 ~ 150	1	100	II
P-192	6mm 倒缝补偿	6mm 倒缝补偿系数	50 ~ 150	1	100	II
P-193	7mm 正缝补偿	7mm 正缝补偿系数	50 ~ 150	1	100	II

编号	项目	内容	设定范围	步距	默认值	级别
P-194	7mm 倒缝补偿	7mm 倒缝补偿系数	50 ~ 150	1	100	II
P-195	8mm 正缝补偿	8mm 正缝补偿系数	50 ~ 150	1	100	II
P-196	8mm 倒缝补偿	8mm 倒缝补偿系数	50 ~ 150	1	100	II
P-197	9mm 正缝补偿	9mm 正缝补偿系数	50 ~ 150	1	100	II
P-198	9mm 倒缝补偿	9mm 倒缝补偿系数	50 ~ 150	1	100	II
P-199	10mm 正缝补偿	10mm 正缝补偿系数	50 ~ 150	1	100	II
P-200	10mm 倒缝补偿	10mm 倒缝补偿系数	50 ~ 150	1	100	II
P-246	花样固缝功能	花样固缝功能设定; 0: 关闭、1: 开启	0 ~ 1	1	0	I

故障代码	故障表述	故障排除
E011/E012	电机信号故障	电机插头是否接触良好；电机信号检测器件是否损坏；缝纫机手轮是否安装到位
E021/E023	电机超负荷	电机插头是否接触良好；机头或剪线机构是否卡死 是否缝制规格厚度以上布料；电流检测信号是否正常
E022	剪线卡刀	检查机头或剪线机构是否卡死；检查剪线时序和位置是否正确
E101	硬件驱动故障	系统电流检测回路是否工作正常；驱动器件是否损坏
E111/E112	系统电压过高	系统进线电压是否过高；制动电阻是否工作正常 系统电压检测回路是否工作正常
E121/E122	系统电压过低	系统进线电压是否过低；系统电压检测回路是否工作正常
E131	电流检测回路故障	系统电流检测回路是否工作正常
E133	OZ 回路故障	系统 OZ 回路是否工作正常
E134	DBFLT 故障	自动电阻插头是否接触良好；自动电阻是否损坏
E201	电机电流过大	系统电流检测回路是否工作正常；电机信号是否正常
E211/E212	电机运转非正常	电机插头是否接触良好；电机信号是否不匹配

故障代码	故障表述	故障排除
E301	操作盒通讯不良	操作盒插头是否接触良好；操作盒器件是否损坏
E302	操作盒 E2PROM 故障	检查操作盒器件是否损坏
E303	SPI通讯故障	检查主控板器件是否损坏
E304	HMI主从芯片通信故障	检查操作盒器件是否损坏
E402	踏板 ID 故障	踏板接头松动
E403	踏板零位校正故障	踏板损坏或者校正时踏板不是停止状态
E501	翻抬开关故障	放下机头或者检查翻抬开关
E502	油量报警故障	加油提示
E601	硬件过流故障	系统电流检测回路是否工作正常；驱动器件是否损坏
E602	软件过流故障	系统电流检测回路是否工作正常；驱动器件是否损坏
E603	电流检测回路故障	系统电流检测回路是否工作正常；驱动器件是否损坏

故障代码	故障表述	故障排除
E604	机械找零位故障	针距压脚电机插头是否接触良好；
E605	电机堵转	针距压脚电机插头是否接触良好；机械是否有卡点
E606	电机开路故障	系统电流检测回路是否工作正常；驱动器件是否损坏
E607	硬件过流故障	系统电流检测回路是否工作正常；驱动器件是否损坏
E608	软件过流故障	系统电流检测回路是否工作正常；驱动器件是否损坏
E609	电流检测回路故障	系统电流检测回路是否工作正常；驱动器件是否损坏
E610	机械找零位信号故障	剪线电机插头是否接触良好
E611	电机堵转	剪线电机插头是否接触良好；机械是否有卡点
E612	电机开路故障	系统电流检测回路是否工作正常；驱动器件是否损坏
E701	底线检测报警	更换底线或检查底线传感器
P.oFF	掉电显示	等待电源重新开通
EvAL	试用保护故障	联系代理商
L.bob	底线提示	更换底线后长按 S 键取消提示状态
P.bob	计件提示	按 S 键进入界面，长按“前固缝”键 2 秒以上取消提示状态 如需关闭计件功能，将 P35 参数数值更改为 0

NOTES

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

Dealer:

The Texi logo is located in the top right corner of the slide. It consists of a purple icon of a person with arms raised, followed by the word "texi" in a purple, lowercase, sans-serif font.