

CONTROL PANEL MANUAL

Walker 6LF

Automatic heavy-duty industrial lockstitch
sewing machine with walking foot

HD *texi*

 Safety Instruction

1. Users are required to read the operation manual completely and carefully before installation or operation.
2. The product should be installed and pre-operated by well-trained persons. All power supplies must be turned off during the installation work, remember not to operate with power on.
3. All the instruction marked with sign  must be observed or executed; otherwise, bodily injuries might occur.
4. For perfect operation and safety, it is prohibited that using extension cable with multi-outlet for power connection.
5. When connecting the power cord, it must be determined that the operating voltage conforms to the rated voltage value specified in the product identification.
6. Don't operate in direct sun light, outdoors area and where the room temperature is over 45°C or below 0°C.
7. Please avoid operating near the heater at dew area or at the humidity below 10% or above 90%.
8. Don't operate in area with heavy dust, corrosive substance or volatile gas.
9. Avoid power cord being applied by heavy objects or excessive force, or over bend.
10. The earth wire of power cord must be connected to the system ground of the production plant by proper size of conductions and terminals. This connection should be fixed permanently.
11. All the moving portions must be prevented to be exposed by the parts provided.
12. Turing on the machine in the first time, operate the sewing machine at low speed and check the correct rotation direction.
13. Turn off the power before the following operation:
 1. Connecting or disconnecting any connectors on the control box or motor.
 2. Threading needle.
 3. Raising the machine head.
 4. Repairing or doing any mechanical adjustment.
 5. Machines idling.
14. Repairs and high level maintenance work should only be carried out by electronic technicians with appropriate training.
15. All the spare parts for repair must be provided or approved by the manufacturer.
16. Don't use any objects or force to hit or ram the product.

1 Button displays and operating instructions

1.1 Key description

Name	key	Indicate
Stitch length setting		If click, increase or decrease stitch length. If long-press, continuously increase or decrease stitch length.
Pattern backing-tacking setting		If click, set used or cancelled pattern backing-tacking function. If long-press, switch to pattern backing-tacking mode editing interface.
Tight seam setting		If click, switch starting tight seam, ending tight seam, full function and function off successively. If long-press, switch to tight seam mode editing interface.
Pattern freedom sewing setting		If click, switch to pattern freedom sewing mode selection interface. If long-press, switch to pattern freedom sewing mode editing interface.
Pattern constant-stitch sewing setting		If click, switch multi-segment sewing mode or four segments sewing mode. If long-press, switch to pattern constant-stitch sewing mode editing interface.
Start back-tacking sewing		If click, switch AB start back-tacking → ABAB start back-tacking → function off → B start back-tacking successively
End back-tacking sewing		If click, switch CD end back-tacking → CDCD end back-tacking → function off → C end back-tacking successively.
Consecutive reverse sewing		If click, set to consecutive reverse sewing mode.
Free sewing		If click, set to free sewing mode.
M key		If click, set to multi-segment sewing mode (switch to four-segment sewing, seven-segment sewing, eight-segment sewing, and fifteen-segment sewing in sequence).
Auto function		1. If click, set used or cancelled auto function. 2. If long-press, it can restore factory setting.
Thread trimming		1. If click, set used or cancelled trimming function. 2. If long-press, enter counter interface.
Automatic presser foot lifting setting		If click, switch function off → automatic presser foot lifting after trimming → automatic presser foot lifting after pause → full function successively.
Half anti-side trample foot lifting		If click, set used or cancelled half anti-side trample foot lifting function.
Needle stop position selection		If click, the needle stop position after shift the sewing mode (up position / down position).
Slow launch setting		1. If click, set used or cancelled slow launch function. 2. In the parameter setting interface, if long-press, save the current parameter value as factory parameter value.
Mending stitch		If click, lift needle or mend half a stitch.
Function parameter edit		If click, enter or exit the user parameter setting interface. If long-press, it will switch to the password input interface. Enter the correct password, press S key to confirm, you can enter the advanced parameter setting interface.
Setting parameter check and save		For the content of the selected parameters check and save: after select parameter press this key to check and modify operation, after modified parameter value press this key to exit and save the parameter.

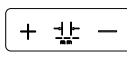
		On the main interface, long press to enter the debugging parameter interface.
Parameter increase		If click, increase the parameter. If long-press, continuously increase the parameter.
Parameter decrease		If click, decrease the parameter. If long-press, continuously decrease the parameter.
Speed increase		If click, increase the sewing speed. If long-press, continuously increase the sewing speed.
Speed decrease		If click, decrease the sewing speed. If long-press, continuously decrease the sewing speed.

1.2 Auxiliary function

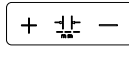
1.2.1 Debugging mode

On the main interface, long-press S key to enter to the debugging parameter interface. P92 correct the electrical angle of motor, P72 up needle position adjustment, P129 back-tacking stepping motor zero-point correction, P74 tacking stitch length compensation and P75 back-tacking stitch length compensation parameter setting.

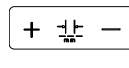
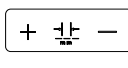
1.2.2 Tight seam mode editing

On the main interface, long-press tight seam key to display "F-1" (start back-tacking), and press the 4th column  ,  to switch between "F-1" (start back-tacking) and "d-2" (end back-tacking), press S to confirm, switch to the editing interface "01 0 0.5", press the 1st or 2nd column  ,  to adjust the number of stitches of 00-12, press the 4th column  ,  to adjust 0 (Normal sewing) -1 (reverse sewing). Press  to adjust the stitch length. After the setting is completed, press S key to confirm. Click P key to exit to the main interface.

1.2.3 Pattern freedom sewing mode

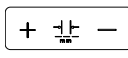
On the main interface short-press  to shift pattern freedom sewing mode selection interface "n1", press  to adjust n1-n9.

1.2.4 Pattern freedom sewing editing

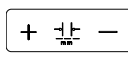
On the main interface long-press  to shift pattern freedom sewing mode editing interface "n-01 01", short-press the 4th column  ,  to adjust n01-n09, short-press  adjust 01-10 segment number, adjust to setting pattern number, segment number, short-press S key to confirm, shift to corresponding pattern number editing interface "01 1 3.0", short press 1st column or 2nd column  ,  to adjust 00-99 stitches, short-press 4th column  ,  1-9 repeat times, short-press 

to adjust stitch length, after finished setting short-press S key to confirm. Press P key can exit to interface.

1.2.5 Pattern back-tacking sewing editing

On the main interface, long press  to switch the pattern style editing interface "H-01 01", press the 4th column  ,  to adjust the H01-H09 pattern number, and short press  to adjust the 01-10 segment number, segment number, short press S key to confirm, switch to the corresponding pattern number editing interface "01 1 3.0", press the 1st or 2nd column  ,  to adjust the number of 00-99 stitches, press the 4th column  ,  to adjust Repeat 1-9 times, press  to adjust the stitch length. After the setting is completed, press the S key to confirm. Short press P key to exit to the main interface.

1.2.6 Pattern constant-stitch sewing editing

In the multi-segment sewing mode, long-press pattern constant-stitch sewing key on the main interface to switch to pattern constant-stitch sewing editing interface "d-01 3.0", press the fourth column  ,  to adjust the d01-d15 segment number, and press  to adjust the current segment stitch length. Short press P key to exit to the main interface.

2 User parameter

No.	Items	Range	Default	Description
P01	Maximum sewing speed (rpm)	100-2200	2000	Maximum speed of machine sewing.
P02	Set accelerated curve (%)	10-100	80	Set the acceleration slope. The greater the slope value, the steeper the speed; the smaller the slope value, the slower the speed.
P03	Needle UP/ DOWN	UP/DN	DN	UP: Needle stops at up position DN: Needle stops at down position
P04	Start back-tacking speed (rpm)	200-1800	1200	
P05	End back-tacking speed (rpm)	200-1800	1200	
P06	Bar-tacking speed (rpm)	200-1800	1200	
P07	Soft start speed (rpm)	200-1500	1500	
P08	Stitch numbers for soft start	1-15	2	
P09	Automatic constant-stitch sewing speed (rpm)	200-2200	2000	Speed adjustment for automatic constant-stitch sewing.
P10	Automatic end back-tacking sewing after constant-stitch sewing	ON/OFF	ON	ON: After executing the constant-stitch sewing, the back-tacking sewing will be executed automatically. In any sewing mode, mending stitch function cannot be used. OFF: After executing the last constant-stitch sewing, the back-tacking sewing function will not be automatically executed, and the front step or full back step must be performed again.
P11	Back-tacking stitch overall compensation	-20~20	0	Increase or decrease the parameter values of P18, P19, P25, P26, P32, and P33 at the same time.
P12	Start back-tacking running mode selection	0-1	1	0: Controlled by foot pedal, can be stopped and started at will. 1: Touch the foot pedal to automatically execute back-

No.	Items	Range	Default	Description
				tacking action.
P13	Ending mode of start back-tacking	CON/STP	CON	CON: Start back-tacking is completed automatically continued for next action. STP: After the number of stitches is completed, stop automatically.
P14	Slow start function selection	ON/OFF	OFF	
P15	Manual Switch A	0-6	5	0: OFF 1: Half stitch 2: One stitch 3: Continuous half stitch 4: Continuous one stitch 5: Back-tacking when machine stop or pause 6: Tight seam function
P16	Speed limit of manual back-tacking	0-2000	1800	The function is disabled when the value is less than 100.
P17-N04	Language setting	0-9	1	0: OFF 1: Chinese 2: English 3: Vietnamese 4: Portuguese 5: Turkish 6: Spanish
P17-N05	Voice broadcast selection	0-3	1	0: OFF 1: With key tone and error voice 2: Key tone only 3: Error voice only
P17-N06	Automatic piece counting function	0-50	1	0: OFF 1-50: Trimming counting times setting
P17-N12	Boot counter interface selection	0-1	0	0: OFF 1: ON
P17-N13	Automatic piece counting mode selection	0-1	0	0: Incremental piecework mode 1: Diminishing piecework mode
P18	Start back-tacking compensation 1	0-200	120	Stitch compensation for start back-tacking A section, 0~200 action gradually delay; The large value, the longer of the A section last stitch, and the shorter of the B section first stitch.
P19	Start back-tacking compensation 2	0-200	120	Stitch compensation for start back-tacking A section, 0~200 action gradually delay; The large value, the longer of the B section last stitch.
P21	The position of the pedal for accelerating	30-1000	520	
P22	The position of the pedal for the stop	30-1000	420	
P23	The position of the pedal for presser foot lifting	30-1000	270	
P24	The position of the pedal for thread trimming	30-500	130	
P25	End back-tacking compensation 3	0-200	120	Stitch compensation for end back-tacking C section, 0~200 action gradually delay; The large value, the shorter of the C section first stitch.
P26	End back-tacking compensation 4	0-200	120	Stitch compensation for end back-tacking D section, 0~200 action gradually delay; the large value, the longer of the C section last stitch, and the shorter

No.	Items	Range	Default	Description
				of the D section first stitch.
P29	The strength of thread trimming stop	1-45	20	
P32	Bar-tacking compensation 5	0-200	120	Stitch compensation for bar-tacking A (C) section, 0~200 action gradually delay; the large value, the longer of the A (C) section last stitch; the shorter of the B (D) section first stitch.
P33	Bar-tacking compensation 6	0-200	120	Stitch compensation for bar-tacking B (D) section, 0~200 action gradually delay; the large value, the longer of the B (D) section last stitch; the shorter of the C section first stitch.
P34	Constant-stitch sewing running mode selection	A/M	A	A: Touch the foot pedal to automatically execute constant-stitch sewing action M: Controlled by foot pedal, can be stopped and started at will
P35	Thread tension releasing function setting when presser foot lifting action	0-2	0	0: OFF 1: Thread tension releasing output function ON when presser foot lifting, thread tension releasing output function OFF when stopover 2: Full function
P36	Thread tension releasing function selection	0-1	0	0: OFF 1: ON
P37	Thread wiping function / Thread clamping function selection	0-11	8	0 : OFF 1: Thread wiping function 2-11: Thread clamping Function and the strength of automatic thread clamping.
P38	Automatic thread trimming function selection	ON/OFF	ON	
P39	Automatic presser foot lifting when pause function selection	UP/DN	DN	
P40	Automatic presser foot lifting after trimming function selection	UP/DN	DN	
P41	Thread trimming counter display	0-9999	0	Display the quantity of finished sewing piece. Long-press "-" key to clear the count
P42-N01	The control system version number			
P42-N02	The panel version number			
P42-N03	Speed			
P42-N04	The pedal AD			
P42-N05	The mechanical angle(upper position)			
P42-N07	Bus bar voltage AD			
P42-N14	Step drive version number			
P42-N15	Stitch counter display (every 10 stitches, the value changes by 1)			
P42-N16	Number of needles for maintenance operation (10,000 needles) *10			
P42-N17	The control system version number			

No.	Items	Range	Default	Description
P44	Brake strength during stopover	1-45	16	
P45	Pattern freedom sewing mode selection	0-1	0	0: Controlled by foot pedal, can be stopped and started at will 1: Touch the foot pedal to automatically execute a pattern sewing action
P46	Motor stop with a reverse angle after trimming function	ON/OFF	OFF	
P47	Adjust the reverse angle when motor stop after trimming	10-300	160	Start from the upper needle position and adjust the angle of the needle lift in reverse operation after trimming.
P48	The minimum speed (positioning speed) (rpm)	100-500	210	Adjust the minimum speed.
P49	Thread trimming speed (rpm)	100-500	250	Adjust thread trimming speed.
P52	Delay the start of the motor to protect the lowering time of presser foot (ms)	10-990	120	Delay the start time, with automatic presser foot down.
P53	Half back pedaling lifting presser foot function to cancel	0-2	1	0: OFF 1: Back pedaling and half back pedaling with lifting presser foot 2: Half back pedaling without lifting presser foot, back pedaling with lifting presser foot
P54	Thread trimming action time (ms)	10-990	250	
P55	Thread wiping action time (ms)	10-990	40	
P56	Power on and positioning	0-2	0	0: Always not to find the up needle position 1: Always to find the up needle position
P57	Presser foot solenoid protection time (s)	1-60	30	Forced shutdown after hold time to prevent the electromagnet from being hot for a long time
P58	Up needle position adjustment	0-359	260	Up position adjustment, the needle will advance stop when the value decreased, the needle will delay stop when the value increased.
P59	Down needle position adjustment	0-359	70	Down position adjustment, the needle will advance stop when the value decreased, the needle will delay stop when the value increased.
P60	Testing speed (rpm)	100-2500	2200	Setting testing speed.
P61	Testing A	ON/OFF	OFF	Continuous running testing.
P62	Testing B	ON/OFF	OFF	Start and stop testing with all functions.
P63	Testing C	ON/OFF	OFF	Start and stop testing without all function.
P64	Test run time	1-250	30	
P65	Test stop time	1-250	10	
P66	Machine protection switch selection	0-1	1	0: Disable 1: Testing zero signal
P69	Pattern freedom sewing speed	100-1800	1200	
P70	Type		162	
P71	Mending stitch length of manual button A	0-9.0	0	When the parameter value is 0, the stitch length of the mending stitch is the same as the stitch length in the normal sewing mode of 【P131】 .
P72	Up needle position adjustment	0-359		Adjust up needle position, the displayed value will change with the position of the handwheel, press "S" key to save the current position (value) as up needle position.
P73	Down needle position adjustment	0-359		Adjust down needle position, the displayed value will

No.	Items	Range	Default	Description
				change with the position of the handwheel, press "S" key to save the current position (value) as down needle position.
P74	Tacking stitch length compensation	-100~100	0	Compensate for the stitch length during tacking at 0mm~9.0mm stitch length.
P75	Back-tacking stitch length compensation	-100~100	0	Compensate for the stitch length during back-tacking at 0mm~9.0mm stitch length.
P77	Opportunity point of back-tacking for end back-tacking in high speed in free sewing mode	20-350	125	
P78	The start angle of thread clamping	5-359	100	
P79	The stop angle of thread clamping	5-359	270	
P80	Trimming engage angle	0-359	2	
P82	Trimming retract angle	0-359	160	
P83	Stopping strength after trimming	10-100	30	
P86	Up and down needle position distance	15-345	170	Up and down positioning distance angle (1 degree for every 4 values)
P87	Wiping thread return delay time	10-990	50	Make sure the wiper returns to its original position
P88	Stopover distance	10-100	30	
P89	AC overvoltage setting	500-1023	880	
P90	Soft start first stitch speed	200-1500	400	
P91	Soft start second stitch speed	200-1500	1000	
P92	Correct the electrical angle of motor		160	Reading the initial Angle of encoder, the factory default was set, please do not change the values (parameter value cannot be changed manually, random change it will result the control box and motor abnormal or damaged).
P93	The starting time of the half back pedaling function (ms)	10-900	100	
P99	Starting tight seam stitch length	0-9.0	0.5	
P100	Direction of starting tight seam	0-1	0	
P101	The start angle of thread tension releasing	1-359	30	Thread tension releasing start angle (defined as 0°under calculation)
P102	The stop angle of thread tension releasing	1-359	180	Thread tension releasing end angle (defined as 0°under calculation, must be greater than P101 parameter value)
P103	Thread tension releasing strength	1-80	30	
P105	Pattern freedom sewing mode selection	0-9	0	0: OFF 1-9: Pattern freedom sewing mode
P107	Starting tight seam speed	100-2000	1200	
P108	Starting tight seam stitch number	0-12	2	
P109	The delay time before thread wiping	5-990	5	Interval time before entering thread wiping action after finding the upper positioning.

No.	Items	Range	Default	Description
P110	Trimming back time (ms)	60-990	100	Make sure the thread trimming device returns to its original position
P118	Function selection of manual back-tacking button in pattern mode	0-1	1	
P119	Electromagnet overcurrent protection detection switch	0-1	0	
P125	The height of the presser foot lifting in the middle	0-4799	1200	
P126	The highest presser foot lift height of electric knee-control	0-4799	2010	
P129	Back-tacking stepping motor zero-point correction	-999~ 4799	0	
P130	Stepping motor presser foot zero position correction	-999~ 4799	1500	
P131	Normal stitch length	0-9.0	7.0	
P132	Manual close stitches distance	0-9.0	2.0	
P135	The lowest presser foot lift height of electric knee-control	0-4799	600	
P136	The maximum height of the presser foot when back pedaling	0-4799	2010	
P139	Presser foot lower buffer position	0-4799	700	
P143	Tight seam mode selection	0-3	0	0: OFF 1: Starting tight seam 2: Ending tight seam 3: Full function
P144	Tacking stitch length compensation in high speed	-100~ 100	-10	
P145	Back-tacking stitch length compensation in high speed	-100~ 100	-7	
P146	Presser foot lifting / lowering speed	50-400	200	
P153	Ending tight seam stitch length	0-9.0	0.8	
P154	Ending tight seam speed	100-2000	1200	
P159	Direction of ending tight seam	0-1	1	0: Forward 1: Backward
P160	Ending tight seam stitch number	0-12	2	
P165	Stitch counter mode selection	0-4	0	0: Do not count 1. Increase cycle count 2. Decrease cycle count 3. Increase count, alarm after the count is full, need to press the clear key to start recounting. 4. Decrease count, alarm after the count is full, need to press the clear key to start recounting.
P166	Upper limit of stitch counter (stitch) *10	0-9999	500	
P167	Upper limit of maintenance stitch number (10000 stitch) *10	0-9999	0	0: OFF

No.	Items	Range	Default	Description
P170	Mending stitch length of manual button B	0-9.0	0	
P171	Mending stitch length of manual button C	0-9.0	0	
P173	Mending stitch length of manual button D	0-9.0	0	
P174	Manual Switch B	0-6	3	0: OFF 1: half stitch 2: one stitch 3: continuous half stitch 4: continuous one stitch 5: Back-tacking when machine stop or pause 6: Tight seam function
P175	Manual Switch C	0-6	1	0: OFF 1: half stitch 2: one stitch 3: continuous half stitch 4: continuous one stitch 5: Back-tacking when machine stop or pause 6: Tight seam function
P176	Manual Switch D	0-6	3	0: OFF 1: half stitch 2: one stitch 3: continuous half stitch 4: continuous one stitch 5: Back-tacking when machine stop or pause 6: Tight seam function
P177	1mm forward stitch length reference value setting	0-2000	135	
P178	1mm backward stitch length reference value setting	0-2000	120	
P179	2mm forward stitch length reference value setting	0-2000	230	
P180	2mm backward stitch length reference value setting	0-2000	210	
P181	3mm forward stitch length reference value setting	0-2000	320	
P182	3mm backward stitch length reference value setting	0-2000	287	
P183	4mm forward stitch length reference value setting	0-2000	415	
P184	4mm backward stitch length reference value setting	0-2000	375	
P185	5mm forward stitch length reference value setting	0-2000	500	
P186	5mm backward stitch length reference value setting	0-2000	442	
P187	6mm forward stitch length reference value setting	0-2000	580	

No.	Items	Range	Default	Description
P188	6mm backward stitch length reference value setting	0-2000	501	
P189	7mm forward stitch length reference value setting	0-2000	655	
P190	7mm backward stitch length reference value setting	0-2000	571	
P191	8mm forward stitch length reference value setting	0-2000	730	
P192	8mm backward stitch length reference value setting	0-2000	633	
P193	9mm forward stitch length reference value setting	0-2000	795	
P194	9mm backward stitch length reference value setting	0-2000	690	
P227	Angle from which the stepping motor starts to adjust the stitch length when sewing (the upper position is 0 degrees)	0-300	95	
P228	Stepping motor speed when the presser foot zero point return stitch length area	50-8000	380	
P234	Mode selection of stopover in pattern sewing	0-1	0	0: Stop immediately. 1: Stop after sewing the current pattern.
P235	Pattern sewing compensation	0-200	120	

Note: the initial value of parameters is for reference only, and the actual value of parameters is subject to the real object.

3. Error code list

Error code	Problem description	Solutions
E01	High voltage	1. Whether the grid voltage is higher than AC260V. 2. If it is self-generated power supply, please reduce the generator power. 3. If it still does not work normally, please replace the control box and notify the after-sales service.
E02	Low voltage	1. Whether to connect to low voltage. 2. Reset. 3. If it still does not work normally, please replace the control box and notify the after-sales service.
E03	CPU communication abnormal	1. Turn off the system power and check whether the connection of the display screen is loose or disconnected, restart the system after returning it to normal. 2. Turn off the system power, remove the control box and only plug in the power cord to power on, whether alarm E05, if it still alarms E03, replace the control box and notify the after-sales service.
E05	Pedal signal abnormal	1. Check whether the pedal connector is loose or fall off, and restart the system after returning it to normal. 2. If it still does not work normally, please replace the control box or speed controller and notify the after-sales service.

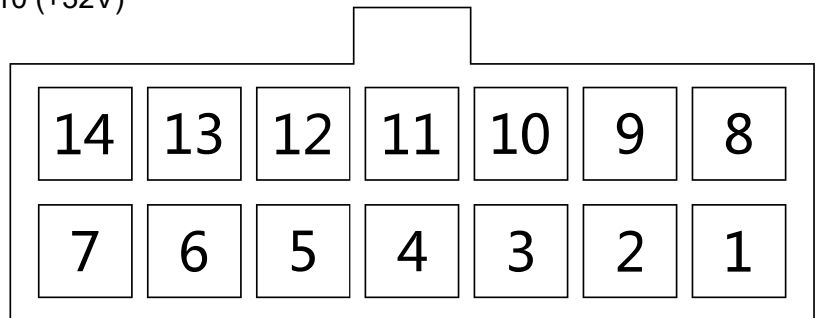
E07	Main shaft motor locked-rotor	1. Turn off the power and check whether the handwheel can be turned smoothly (turn the handwheel by hand), if it cannot be turned, please check the machine. 2. Turn off the power, check whether the motor power connector is loose, plug it in and restart it. 3. Check whether the upper needle stop position is correct, if not, please adjust the upper positioning position. 4. If it still does not work normally, please replace the control box or spindle motor and notify the after-sales service.
E10	Electromagnet overcurrent	1. Unplug the solenoid connector, if alarm E10, replace the control box and notify the after-sales service. 2. If there is no alarm after removing the solenoid connector, please plug it back in. 1) Step on the front pedal to let the sewing machine perform thread clamping and back-tacking. If alarms, please turn off start back-tacking and end back-tacking, restart the control box, and then step forward. If alarms, please turn off the thread clamping function and restart the electronic control, and step forward again. If there is no alarm, replace the clasper. 2) Step on the front pedal to let the sewing machine perform thread clamping and back-tacking. If it alarms, please turn off start back-tacking and end back-tacking, restart the control box, and then step forward. If there is no alarm, please turn off the thread clamping function and restart the control box, and open start back-tacking function, step forward again, if it alarms, please replace the back-tacking solenoid. 3) Step on the front pedal to let the sewing machine perform thread clamping and back-tacking. If there is no alarm, please step back halfway to raise the presser foot. If it alarms, please replace the presser foot solenoid. 4) Step on the front pedal to let the sewing machine perform thread clamping, back-tacking and half anti-side trample. If there is no alarm, please back step pedal to trim. If it alarms, please replace the thread trimming solenoid.
E09 E11	The positioning signal of main shaft motor encoder is abnormal	1. Turn off the system power, check whether main shaft motor encoder connector is loose or fall off, restore it to normal and restart the system. 2. Check whether the motor zero point correction setting is correct; Reset the motor zero point correction; Whether there is oil on the encoder code plate, please clean it if there is any. 3. If it still does not work normally, please replace the control box or main shaft motor and notify the after-sales service.
E14	Main shaft motor encoder signal is abnormal	1. Turn off the system power, check whether the main shaft motor encoder connector is loose or fall off, restore it to normal and restart the system. 2. Check whether the grating is installed correctly (whether the grating screws are tightened and whether the grating is in the center of the encoder). 3. Check whether there is oil on the encoder code plate, if there is, please clean it up, and restart the system after recovery. 4. If it still does not work normally, please replace the control box or main shaft motor and notify the after-sales service.
E15	Main shaft motor drive overcurrent	1. Please check whether the motor power cord has bad contact. 2. Please check whether the motor power cord is crushed. 3. Please replace the control box or main shaft motor and notify the after-sales service.
E17	Machine overturned	1. Turn off the system power and check if the machine is overturned. 2. Check whether the machine protection switch detection setting is correct. 3. If it still does not work normally, please replace the control box or panel and notify the after-sales service.

E20	Main shaft motor failed to start	1. Turn off the system power, check whether main shaft motor power cord connector and encoder connector are loose or fall off, restore them to normal and restart the system. 2. Check whether the motor zero point correction setting is correct, reset the motor zero point correction. 3. If it still does not work normally, please replace the control box or main shaft motor and notify the after-sales service.
E80	Abnormal communication between main chip and drive chip	Please replace the control box and notify the after-sales service.
E82	Back-tacking stepping motor overcurrent	1. Turn off the system power and observe whether back-tacking stepping motor is stuck. If it is stuck, remove the mechanical failure of the machine first. If it is normal, check whether connector of back-tacking stepping motor is loose or fall off, restore it to normal and restart the system. 2. If it still does not work normally, please replace the control box or back-tacking stepping motor and notify the after-sales service.
E84	The positioning signal of back-tacking stepping motor encoder is abnormal	1. Turn off the system power and observe whether back-tacking stepping motor is stuck. If it is stuck, remove the mechanical failure of the machine first. If it is normal, check whether the encoder connector of back-tacking stepping motor is loose or fall off, and restart the system after returning it to normal. 2. Check whether the grating is installed correctly (whether the grating screws are fastened and whether the grating is in the center of the encoder). 3. Check if there is oil on the grating code plate, if so, please clean it up, and restart the system after restoration. 4. If it still does not work normally, please replace the control box or back-tacking stepping motor and notify the after-sales service.
E85	Back-tacking motor encoder signal is abnormal	1. Turn off the power of the system, check whether the encoder connector of back-tacking stepping motor is loose or fall off, restore it to normal and restart the system. 2. Check whether the grating is installed correctly (whether the grating screws are fastened and whether the grating is in the center of the encoder). 3. Check if there is oil on the grating code plate, if so, please clean it up, and restart the system after restoration. 4. If it still does not work normally, please replace the control box or back-tacking stepping motor and notify the after-sales service.
E86	Back-tacking stepping motor failed to start	1. Turn off the power of the system, check whether the power cord connector of back-tacking stepping motor and the encoder connector are loose or fall off, restore them to normal and restart the system. 2. Check whether the grating is installed correctly (whether the grating screws are fastened and whether the grating is in the center of the encoder). 3. Check if there is oil on the grating code plate, if so, please clean it up, and restart the system after restoration. 4. If it still does not work normally, please replace the control box or back-tacking stepping motor and notify the after-sales service.
E87	Back-tacking stepping motor locked-rotor	1. Turn off the system power and observe whether back-tacking stepping motor is stuck. If it is stuck, remove the mechanical failure of the machine first. If it is normal, check whether the power cord connector of back-tacking motor and the encoder connector are loose or fall off, restore them to normal and restart the system. 2. If it still does not work normally, please replace the control box or back-tacking stepping motor and notify the after-sales service.

4. Port diagram

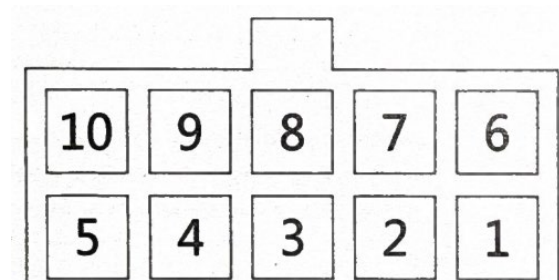
14P function port description (standard)

1. Thread trimming electromagnet: 1 (DGND), 8 (+32V)
2. Thread wiping/ thread clamping electromagnet: 2, 9 (+32V)
3. Thread tension releasing electromagnet: 3, 10 (+32V)
4. LED Light: 4 (DGND), 11 (+5V)
5. Back-tacking key: 5 (signal)
6. Mending stitch key: 7 (signal)
7. 1/2 mending stitch key: 14 (signal)
8. 1/4 mending stitch key: 12 (signal)



10P function port description (option)

1. 1/2 mending stitch signal: 8
2. 1/4 mending stitch signal: 3
3. Thread clamping: 4
4. Mending stitch signal: 5
5. LED: 9 (+5V), 10 (DGND)



8P function port description (option)

1. Suction with clamp function without any thrum: 1, 5
2. Hook thread with clamp function without any thrum: 2, 6
3. Thread clamping (thread wiping) / Pull thread with clamp function without any thrum: 3, 7 (+32V)
4. Thread tension release: 4, 8 (32V)

