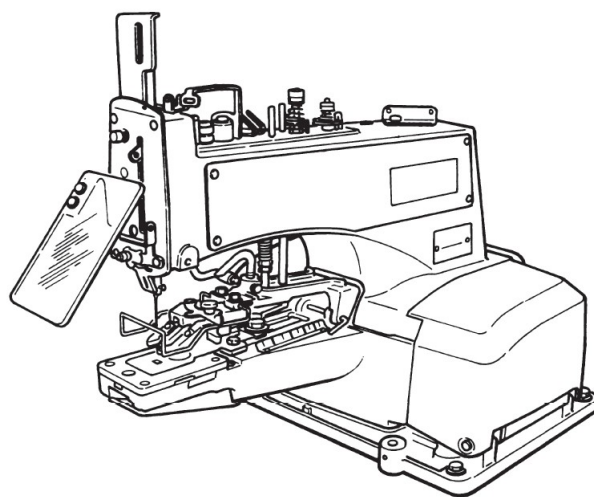


CONTROL PANEL MANUAL

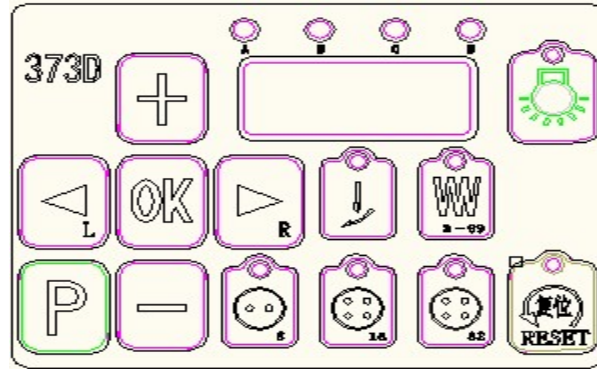
XF

Automatic industrial button sewing machine

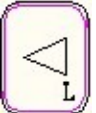
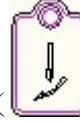


 *texi*

1: Introduction of display screen common Operation



No.	Button Icons	Function Description
1	LED (A)	When Press foot put into correct place LED lamp A on, When Press foot up or put into wrong place LED lamp A off.(It can be analyzed the presser foot Actual situation, Also to judge the quality of the presser foot motion sensor)
2	LED (B)	When small aluminum wheel in left of machine is rotated to a fixed position (The Al. wheel will auto to find needle stop position when machine open), It will be detected by sensor, LED lamp B will light. (It also can be used to judge the quality of aluminum wheel sensor)
3	LED (C)	Up Needle position of motor LED
4	LED (D)	This LED system status indicator, when system is running, LED lamp D light. When the system is on waiting, LED lamp D off.
P1		Button sewing machine 8-pin shortcut keys, When the function open , LED lights on above the key, machine will run 8-pin mode. (Can with 16-pin or 32-pin switchable)
P2		Button sewing machine 16-pin shortcut keys, When the function open, LED lights on above the key, machine will run 16-pin mode. (Can with 8-pin or 32-pin switchable)
P3		Button sewing machine 32-pin shortcut keys, When the function open, LED lights on above the key, machine will run 32-pin mode. (Can with 8-pin or 16-pin switchable)
P4		Wiper shortcut keys, When the function open, LED lights on above the key, When the function close the LED off.
P5		Button sewing Pin Defined Button, Touch (), Screen display n-08, after the number twinkling, touch () () can adjust the pin number, after

		 finish touch () to save the number and running the defined Button mode.
P6		Head LED light switch button. The LED on means head LED lamp is on, otherwise it Off.
P7		Machine Power reset button, when open the machine power, should be touch the reset one time, then can run the machine.
1		Enter parameter adjustment Secondary key, together with () or () using, different Combination into different Parameter List
2		Parameter determines the Save button
3		“+”button (modify the parameters plus)
4		“-”button (modify the parameters minus)
5		In the parameter list to return to the previous page
6		In the parameter list to enter the parameter for adjustment
Shortcut Key Function		
	Long press ()	Direct into enter the Wiper parameter adjustment
	Long press ()	Direct into enter the press foot parameter adjustment

	Long press 	Touch  button, Screen display 000, long press  button 5 seconds, Restore factory settings
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2: How to enter parameters and how to modify the parameters

System parameters entering analysis:

Together touch  and  enter into "System parameters" list, screen

display 0000, after input password, then touch  enter into. After entering the

system, the parameters number can be seen, then you can use   key to switch the parameter number, when you find the need modify number, then touch

 key enter the current parameters, last touch  button to save and
Esc

Note: the up entry method, specific parameters No. on behalf of the parameters meaning as follows:

3: Operating Parameter Description Table

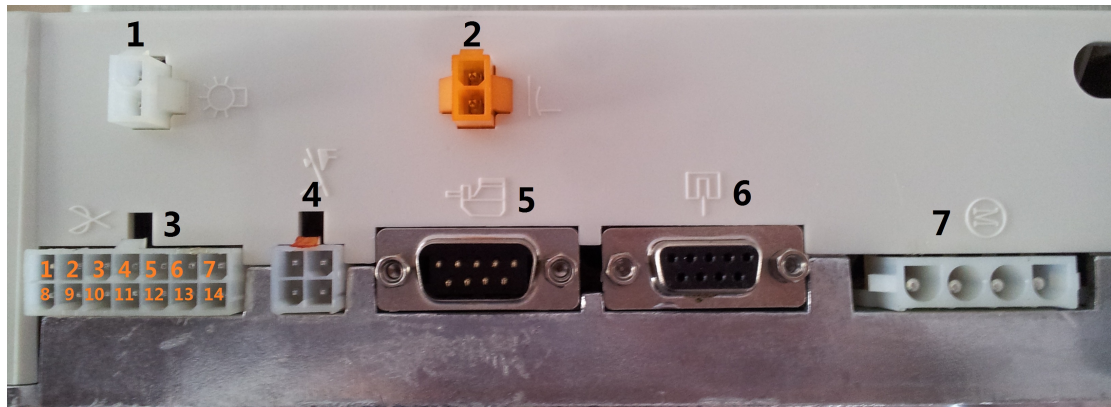
TEXI XF System parameter list

System param. list	Function Description	Function parameter default values	Function parameter ranges	Parameter Description	Precautions
002	Reset speed	200	150 ~800		
021	Restore the system password	000	000 ~ 003	This parameter is adjusted to 003 long press OK button	Restoring the factory password
023	Display speed		200~ 1800	Click the (P) key	Display motor speed
024	Governor detected	About 200 (Midpoint)		Detection governor normal	Detection Should before reset, otherwise affect safety
025	Automatic Running	0	0: close , 1:open	Machine Running run	Turn the power on again to close the parameter

031	Presser foot advance angle	80	10 ~ 90	Advance angle more bigger the sensitivity more stronger	Opinions parameter values 40 ~ 80
046	Wiper action delayed start time	40	10 ~ 2000		
047	Wiper action time	70	10 ~ 2000		
048	Wiper action time at full power time	70	10 ~ 990		
050	Wiper action time at maintain power	50	1 ~ 100		
051	Wiper action to release the protect time power	50	20 ~ 800		
055	Wiper function on off switch	(OFF)	(ON) (OFF)		
058	Foot-lifter action time at full power time	160	0 ~ 900		Not good too big effect of electromagnets time
059	Foot-lifter full-power power	100%	0 ~ 100%		Opinions parameter values 80 ~ 100
060	Foot-lifter Maintain power	6%	0 ~ 100%	Power for foot-lifter quite stay	Parameter is not good too large, easy to heat, affecting time
061	After the release of the presser foot, the time of delay needle down	1	1 ~ 900	When the presser foot down, operation of the motor required delay time	When parameter No. 63 open, the protection switch function open, no need delay
062	Time to maintain foot-lifter the power of time	180	0 ~ 900	After motor running, foot-lifter Residence time	
063	Foot-lifter protection needle sensor switch	1	0: OFF 1: ON		When parameter 63 is closed, you need to set parameters No. 61 to 350 or more, otherwise

					easy to break the needle
065	Delay time presser foot	0	0 ~ 900		
071	Running speed	1500	200 ~ 1800		

4: The control box Port Description



Port Number	Port device name for the connection
1	LED button sewing machine head LED socket
2	Presser foot control port, connect the presser foot solenoid or solenoid valve (30V)
3	14P multifunction port (Needle-protect switch and start the machine position sensor socket)
4	Foot pedals port , connection governor
5	connecting the control panel display
6	Connect the motor phase signal line
7	connection motor No.4 drive line

No.3 14pin multifunction port

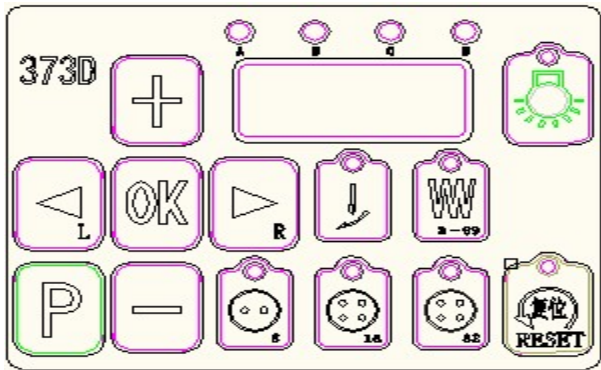
The 3rd multifunction port label	Function		
1, 8, 11	1: GND	8: Signal 1	11:5V
2, 9, 12	2: GND	9: Signal 2	12: 5V
3, 10	3: Presser foot output	10: 30V	
4, 2	4: Protection signal input	2: GND	
5	5: Ground		
6, 13	6: wiper output	13: 30V	
7, 14	7: Scissors output	14: 30V	

5. Error code analysis

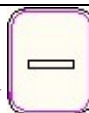
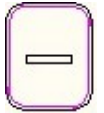
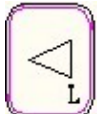
Display error code	Error code meaning	Various possible for the error
ER-01	No find needle position	1: Hand wheel and motor

		2: Hand wheel magnet off 3: Hand wheel magnet polarity reversal 4: Nine-pin terminal head Poor contact 5: Motor hall damaged, with the change motor
ER-02	Pedals velometer signal wrong	1: Not plugged velometer into box 2: velometer Inserted upside 3: velometer line broken 4: velometer damage
ER-03	Motor phase error signal	1: Nine-pin terminal head Poor contact 2: Hall and rotor has large deviations when the motor is mounted 3: Motor hall damage
ER-04	Motor stall protection	1: Sewing overweight or blocked 2: Motor overload 3: 4-wire motor drive cable is not connected or inserted upside
ER-05	Hardware over current	1: Sewing overweight or blocked 2: Motor overload 3: Motor phase signal line is not connected
ER-07	Serial communication timeout	1: Display bad cable connection Motherboard 2: Motherboard chip damage
ER-09	Poor memory	1: Motherboard memory corruption or bad
ER-13	Presser foot sensor no signal	1: Presser foot sensor is mounted too far away 2: Presser foot sensor damage 3: Magnet on press foot connecting bar falling or installed backwards
ER - 14	Reset sensor can not find the needle position	1: The sensor on left induction aluminum wheel is damaged 2: Magnet on aluminum wheel Fall or installed backwards
ER - 15	9700 error signal	1: 9700 encoder is damaged

1：显示屏常用操作介绍



序号	按键图标	功能说明
1	(A)	当压脚放下到位时指示灯亮起，压脚抬起或压脚放置不到位时指示灯熄灭。（可用作判断压脚实时情况，易可用来判断压脚动作传感器好坏）
2	(B)	当机器左侧开机找针位的小铝轮旋转到某个固定位置被传感器感应到后指示灯亮起。（可用来判断感应铝轮传感器的好坏）
3	(C)	电机上针位指示
4	(D)	此指示灯为系统状态指示灯，当系统处于运行状态时指示灯亮起，当系统处于待机时指示灯熄灭。
1		钉扣机 8 针快捷按键，当此功能开启时按键上方亮起，钉扣机将运行在 8 针模式。（可与 16 针 32 针配合切换使用）
2		钉扣机 16 针快捷按键，当此功能开启时按键上方亮起，钉扣机将运行在 16 针模式。（可与 8 针 32 针配合切换使用）
3		钉扣机 32 针快捷按键，当此功能开启时按键上方亮起，钉扣机将运行在 32 针模式。（可与 8 针 16 针配合切换使用）
4		拨线快捷按键，功能开启时按键上方亮起，功能关闭时按键上方熄灭。
5		钉扣针数自定义键，点动（  ）键，屏幕显示-08，后面 08 在闪

		烁此时点动   按键可直接调整针数，调整完毕后 点动  键将保存当前针数并运行自定义针数模式。
6		机头灯开关按键，当按键上方灯亮起时表示机头灯开启，当按键上方灯熄灭时表示机头灯关闭。
7		钉扣机开机复位按键，每次开始必须进行一次复位动作后方能运行。
1		进入参数调整辅助键，可与   键配合使用，不同配合将进入不同参数列表
2		参数确定保存键
3		“+” 键（修改参数时加）
4		“-” 键（修改参数时减）
5		向左键（在参数列表中用来返回上一页面用）
6		向右键（在参数列表中进入参数调整用）
快捷按键功能		
	长按  键功能	直接进入拨线参数调整

	长按  键功能	直接进入压脚参数调整
	长按  键功能	按一下  键。显示 000。长按  键 5 秒，还原出厂参数。

2：如何进入参数与如何修改参数

系统参数进入解析：

按住  键不放，在按  键将进入“系统参数”列表，显示屏会显示出 4 个零，输入密码后按  键即可进入。进入后可看见系统参数编号，此时可以用  键，切换系统参数编号，找到需要调整的参数时按下  键，最后按  键，保存退出。

注： 以上是进入方法，具体参数号代表的参数意思详情如下：

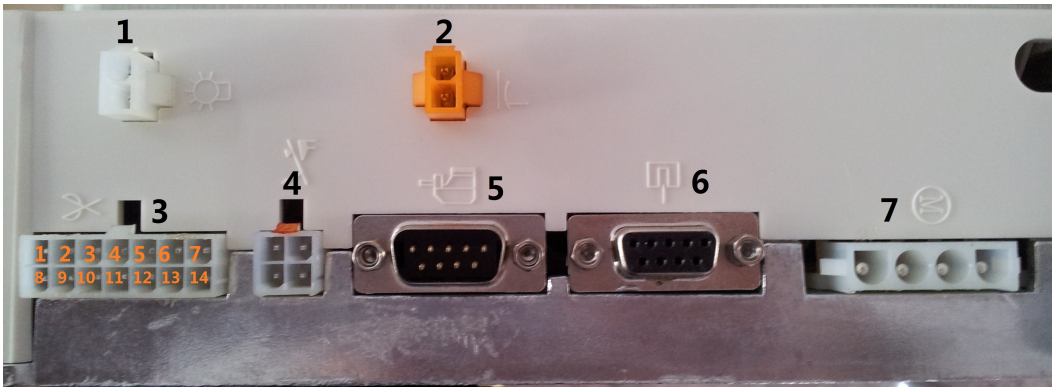
3：操作参数说明表

系统参数列表：

菜单号	功能说明	功能参数默认值	功能参数范围	参数说明	注意事项
002	复位速度	200	150~800	开机后寻找位置的运转速度	不易太快影响安全
021	还原系统密码	000	000~003	此参数调到 003 长按键即可	还原出厂密码
023	显示速度		200~1800	按一下Q键	显示电机转速
024	调速器检测	200 左右 (中点值)		检测脚踏板是否正常	在未复位前检测不然影响安全
025	自动磨合	0	0: 关闭 1: 开启	机器磨合运行	关闭电源重新开启即可关闭该参数
031	抬压脚提前角度	80	10~90	提前角度越大灵敏度越强	意见参数值 40~80

046	拨线动作延时启动时间	40	10 ~ 2000		
047	拨线动作时间	70	10 ~ 2000		
048	拨线动作功率时间	70	10 ~ 990		
050	拨线动作维持功率时间调整	50	1 ~ 100		
051	拨线动作释放保护时间	50	20 ~ 800		
055	拨线功能开启开关	000（关闭）	0001（开启）		
058	抬压脚全功率时间	160	0 ~ 900		不易过大影响电磁铁使用时间
059	抬压脚全功率功率	100%	0 ~ 100%		意见参数 80 ~ 100 80 ~ 100
060	抬压脚维持功率	6%	0 ~ 100%	抬起压脚后挺留时的功率	参数不易过大，容易发热，影响使用时间
061	放压脚后，下机针延时	1	1 ~ 900	当压脚放下时，运行电机需要的延时时间	当 63 号参数打开时保护开关起作用不需要延时
062	抬压脚维持功率时间	180	0 ~ 900	电机运行后抬起压脚停留的时间	
063	抬压脚保护机针传感器开关	1	0: 关闭 1: 开启		当 63 号参数关闭时，需要将 61 号参数设置为 350 以上，不然容易断机针
065	抬压脚延时时间	0	0 ~ 900		
071	运行速度	1500	200 ~ 1800		

4：控制箱端口说明



端口号码	端口连接的器件名称
1	373 钉扣机机头灯插孔
2	抬压脚控制端口，连接压脚电磁铁或电磁阀（30）
3	14 多功能端口（机针保护开关与机器启动位置传感器插口）
4	脚踏板端口，连接调速器
5	连接 显示控制面板

6	连接电机相位信号线
7	连接电机 4 线驱动线

3 号 14 多功能端口

3 号多功能端口标号	功能		
1, 8, 11	1: GND	8: 信号 1	11: 5V
2, 9, 12	2: GND	9: 信号 2	12: 5V
3, 10	3: 压脚输出	10: 30V	
4, 2	4: 保护信号输入	2: GND	
5	5: 大地		
6, 13	6: 拨线输出	13: 30V	
7, 14	7: 剪刀输出	14: 30V	

5: 错误代码解析

显示的错误码	错误码意思	错误的产生
ER-01	找不到停针位	1:手轮和电机靠的不够进 2: 手轮上磁钢脱落 3: 手轮磁铁极性装反 4: 九针端子头接触不良 5: 电机霍尔损坏, 跟换电机
ER-02	脚踏板信号错误	1: 开机时没插调速器 2: 调速器插反 3: 调速器线断开 4: 调速器损坏
ER-03	电机相位信号错误	1: 九针插头接触不良 2: 电机安装时霍尔和转子存在大偏差 3: 电机霍尔坏
ER-04	电机堵转保护	1: 缝纫机过重或堵死 2: 电机过载 3: 电机 4 线驱动线没连接好或插反
ER-05	硬件过流保护	1: 缝纫机过重或堵死 2: 电机过载 3: 电机相位信号线没连接好
ER-07	串口通讯超时	1: 显示屏连接主板线连接不良 2: 主板芯片损坏
ER-09	存储器不良	1:主板存储器损坏或不良
ER-13	压脚传感器无信号	1: 压脚传感器安装距离过远 2: 压脚传感器损坏 3: 压脚连杆上的磁铁脱落或 装反
ER - 14	复位传感器找不到针位	1: 左侧感应铝轮的传感器损坏 2: 铝轮上磁铁脱落或装反
ER - 15	9700 错误信号	1: 9700 编码器损坏

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:

