

SV-250 (SV-260)

INSTRUCTION MANUAL

使用說明書

Ver – 32

For safe operation

重要安全事項

1. Prior the use of this product, please read the instruction Manual. Keep this Instruction Manual and the user may read it at anytime when necessary.
使用本產品前,請先閱讀本說明書;同時應將此說明書妥善保管以便能隨時查閱。
2. Before turn on the power, be sure to check the power voltage and phase agreeing with the nameplate that indicated in the control box.
電源開啓前,請先確認電源的電壓與相數,是否與控制箱銘牌相符。
3. Grounding the machine is always necessary for safe and normal operation.
爲了正常安全運轉,須安裝地線。
4. Check lubricating oil prior to operation.
操作前,請先確認縫紉機潤滑油充足。
5. Check that rotational direction of the motor is correct prior to operation.
操作前,請先確認馬達轉動方向正確。
6. So as to prevent personal injuries during operation, be careful not to allow your head and hands to come close to the moving parts. Also never try to stop it with external forces.
使用中,切勿將頭,手靠近皮帶輪,皮帶,旋梭,天平等移動部份;同時也不可以用外力,強制停止移動部份。
7. For the following conditions, turn off the power or disconnect the power plug from receptacle.
發生下列情況時,應立即關閉電源開關或者拔下電源插頭:
 - 7.1 For threading needle or replacing bobbin.
穿線和更換旋梭時。
 - 7.2 To plug or unplug any connectors from control box.
插拔控制箱上任何連接線與接頭。
 - 7.3 For maintenance and repairing.
保養與修理時。
 - 7.4 When machine is not at use, inspected or adjusted.
翻抬針車頭,取下皮帶時. 機器休息不用時。
 - 7.5 When lightning and thunder occurs.
打雷閃電時。
8. Repairing, remodeling and adjusting works must only be done by appropriately trained technicians or specially skilled personnel.
本產品的修理,改造,調整;應由受過專門訓練的技術人員來進行。

I. Set up

安裝

1. How to connect the cord

連接線的接法:

1). Open the front cover of the control box, the following connectors of the P.C.B are shown in Fig.3.

According to the sewing machine model, connect the connecting lines to the appropriate position.

控制箱前蓋打開,電路板上備有下列接頭.如圖(三);根據縫紉機的裝置,把連接線接到適當位置.

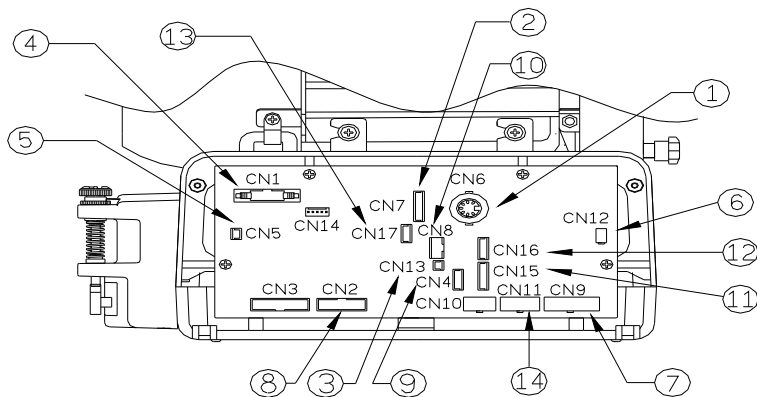


圖 Fig.3 (圖 三)

1) CN6: Synchronizer connector.

① CN6 :同步器接頭.

2) CN7: Encoder connector.

② CN7:馬達編碼器接頭.

3) CN13: Safety switch connector.

③ CN13:安全開關接頭.

4) CN1: Pattern setting switch box connector.

④ CN1: 選針盒接頭.

5) CN5: Speed control unit connector.

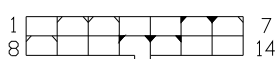
⑤ CN5: 速度基座接頭.

6) CN12: Presser foot lifter solenoid connector.

⑥ CN12:提壓腳線圈接頭.

7) CN9: Sewing machine head connector.

⑦ CN9 :車頭功能線圈接頭.



1,8	Trimming solenoid	切線線圈
2,9	Wiping solenoid	撥線線圈
5,12	Backack switch	回針開關
6,13	Backack solenoid	回針線圈
7,14	Reserved solenoid	備用線圈
10	Ground	接地

Option OUT_B : pin 6 & 13

Option OUT_E : pin 2 & 9

Option OUT_F : pin 1 & 8

8) CN2: Front cover counter (CO2) connector.

⑧ CN2:前蓋 C02 接頭.

9) CN4: Material edge sensor connector.

⑨ CN4:布端檢出器插頭.

10) CN8: Standing pedal operation connector.

⑩ CN8:立式作業踏板接頭.

Option IN_A : pin 7 & 8

Option IN_B : pin 9 & 10

Option IN_C : pin 11 & 12

11) CN15:option B.

⑪ CN15: option B 接頭.

Option IN_F : pin 2 & 7

Option IN_G : pin 3 & 7

Option IN_H : pin 5 & 7

12) CN16:option C.

⑫ CN16: option C 接頭.

Option IN_D : pin 2 & 6

Option IN_E : pin 3 & 6

13) CN17:option D.

⑬ CN17: option D 接頭.

14) CN11:option A.

⑭ CN11: option A 接頭.

Option OUT_A : pin 2 & 7

Option OUT_C : pin 1 & 6

Option OUT_D : pin 3 & 8

2). See Fig.4

如圖(四)所示:

1) Power source line connector.

①電源線接頭.

2) Motor power line connector.

②馬達動力線接頭.

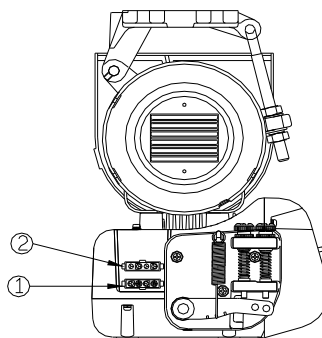


Fig.4 (圖 四)

II Operating way

操作方法:

1. **For regular operations:**(Turning the power switch on without pressing any button)

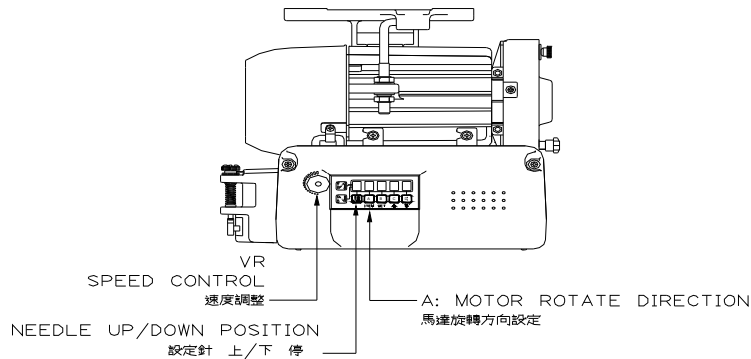
一般操作:(不按任何鍵下 開機)

The external VR let the user adjust freely the speed of the motor.

外部 VR 可供使用者自由調整控制馬達的操作速度.

Adjust speed intensity by turning clockwise direction through VR.

順時針方向旋轉 VR 可調快速度.



2 Speed unit adjustment

速度基座調整

After replacement of speed unit, Adjust speed unit standard voltage following the below procedures.

更換速度基座之後,速度基座的中立位準必須依下列步驟重新調整.

①Place the pedal sensor inner lever arm to the neutral position .

Loosen the hexagon screw (A) from the speed unit. Adjust the induction arm (B) so that LD1 from the main board turns on.

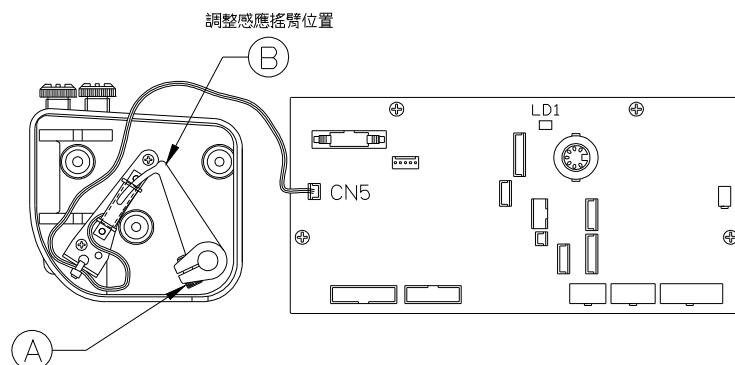
①速度基座拉臂置於中立點.將速度基座上螺絲(A)轉鬆 ;調整搖臂位置(B)使主機板上 LD1 點亮.

②Tighten the hexagon screw (A).

②將螺絲(A)轉緊.

③ If LD1 keeps on, thus adjustment is completed, otherwise repeat steps 1~2.

③LD1 保持點亮,則調整完成;否則請重覆步驟. 1~2.

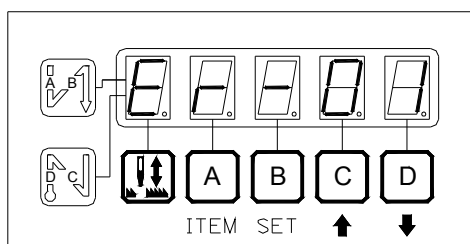


III Error message indicator

錯誤訊息顯示:

When abnormal condition occurs, the error message will displayed as below figure.

當發生不正常狀況時，顯示畫面會將檢測出的錯誤訊息顯示出來。如圖所示:



Error message display:

錯誤訊息顯示:

Error Code	Description of error detected	Items to be checked
Er-0	Over current	-Current is too high.
Er-1	Synchronizer failure	-Synchronizer connector is loosen or line is broken.
Er-2	Motor is not rotating	-Machine head is locked. -Motor is locked. -Motor power line or encoder line. is broken, or connector is loosen.
Er-3	Power failure	-Voltage is either too high or too low. -Power phase error. -Fuse (F2) is burned out.
Er-4	Safety switch failure	-Failure in safety switch connection. -Safety switch failure -Setting error for parameter No.35.
Er-5	Speed unit output failure	-Speed unit connector is loosen -Speed unit is broken -Connecting rod installation is incorrect
Er-6	CPU error	-Noise interference (Ex. High frequency machine, welding machine)
Er-7	Material edge sensor function is failed.	-Parameter No.42 setting error -Material edge sensor not properly adjusted -Connector for material edge sensor is loosen - Material not properly settled through machine
Er-8	Setting speed over the motor maximum speed.	-Parameter No.1 setting value is too large -Motor pulley diameter is too small -Motor pulley ratio setting error
Er-9	Power transistor module is failed.	-Power module overheated -Short circuit or low voltage

請依下表進行確認:

錯誤顯示	錯誤內容	確認項目
Er-0	過電流	電流太大 馬達線圈阻抗太小
Er-1	同步器信號異常	同步器接頭鬆脫,斷線; 皮帶沒有傳動針車頭.

Er-2	馬達不動	針車頭鎖死 馬達鎖死 馬達接頭鬆脫(動力線與編碼器線)
Er-3	電源異常	電壓太高,太低,欠相 保險絲(F 2)燒斷.
Er-4	安全開關異常	安全開關接點異常, 參數 NO.35 設定錯誤
Er-5	速度基座輸出異常	速度基座接頭鬆脫 連接桿安裝不適當, 速度基座故障
Er-6	當機	雜訊源干擾.(高週波 ,電焊機) EEPROM 故障
Er-7	布端檢出功能異常	參數 NO.42 設定錯誤 布端檢出器調整不良 布端檢出器連接線鬆脫,斷線 待車物料擺放位置不適當
Er-8	最高轉速設定 超過馬達的最快速度	參數 NO.1 設定值太大 馬達皮帶輪尺寸太小 馬達皮帶輪比設定錯誤
Er-9	功率晶體模組故障	功率晶體模組過熱 短路低電壓

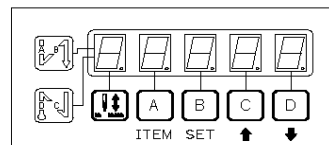
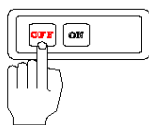
IV Setting way

設定方式


1. Parameter setting:


參數設定方式:

1. Turn OFF the power
1 關掉電源.



2. Parameters setting .


Press  key, then turn ON the power simultaneously.

Release  key

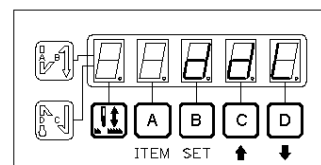
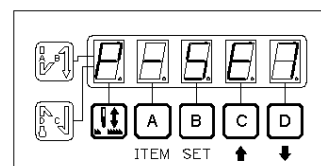
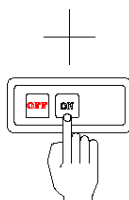
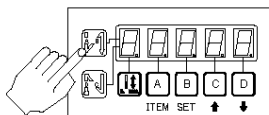
(一)操作參數:

按住  鍵,同時打開電源.

出現 P-SET


放開  鍵.

所選定的針車頭選項閃爍顯示.



3.If it is not displayed as shown above, please repeat steps 1-2.

3.如果顯示畫面與上述不同,請重覆步驟 1~2.

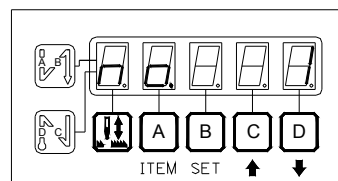
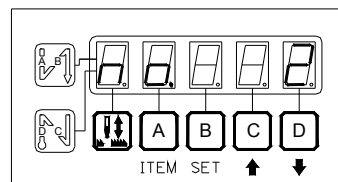
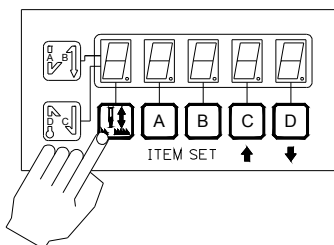
4. 4.1 Press  key, thus

parameters no. will be cycled decreased.

按  鍵,則參數號碼循環遞減.

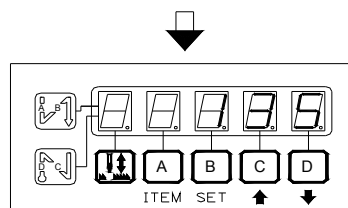
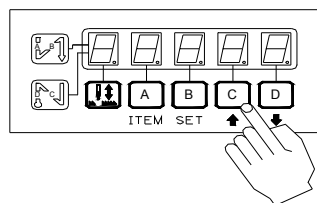
4.2 Press ITEM key, thus parameters no. will be cycled increased.

按 ITEM 鍵,則參數號碼循環遞增.



5.Once the modifying parameter has been found, press ↑ key, and the relative parameter setting will display accordingly

5 找到想要修改之參數號碼,按↑鍵,則顯示該號碼相對應之參數值.



6.Press ↑ key to increase parameter value.
Press ↓ key to decrease parameter value.

If you keep the key pressed, it will be continuously changing for new parameter values.

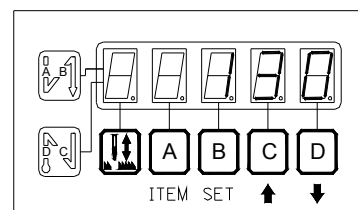
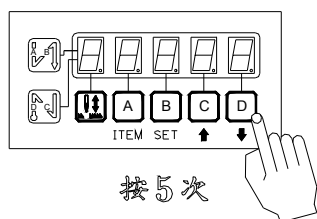
(Ex. If you want to change parameter No.3 from 135 to 130. Press ↓ key 5 times, and 130 will be displayed on the screen.)

6. 按↑鍵增加參數值

按↓鍵減少參數值

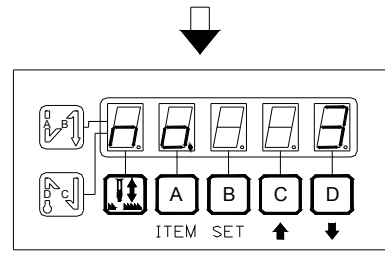
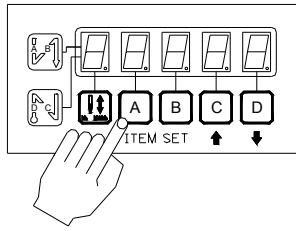
持續按住按鍵,連續更新參數值.

(例:要將參數 No.3 的值由 135 修改為 130.操作方法為按↓鍵 5 次,使畫面顯示出 130)



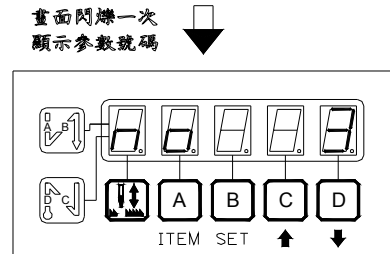
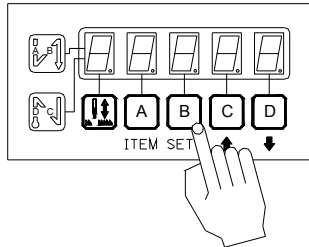
7. Pressing ITEM key can select for the next parameter no. repeat steps 4-6 to modify parameter value.

7. 按 ITEM 鍵可顯示下一組參數號碼,重覆步驟 4~6 選擇下一組要修改之參數.



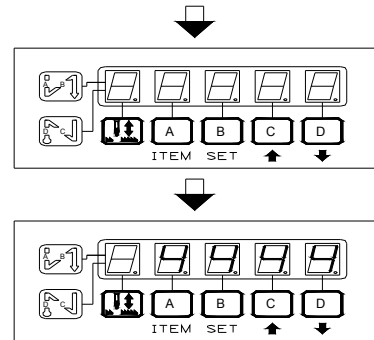
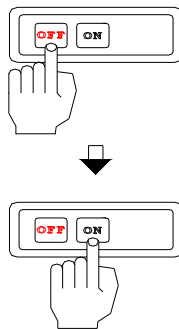
8. Once all specified value has been changed, press SET key to save. If this procedure is not performed, the specified value will not be updated.

8. 當所有參數修改完畢後按 SET 鍵,會將修改後之參數內容儲存;如不進行此步驟,則無法更新參數內容,仍以舊參數操作.



9. Turn OFF the power then re-start the power, thus it will operate according to new parameter values

9. 關掉電源,再打開電源,將以最新的參數設定運作.

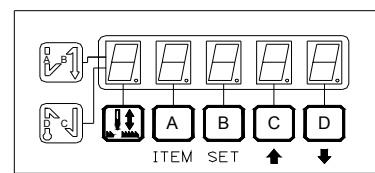
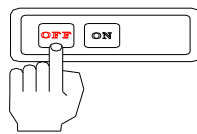


2. Motor pulley ratio measurement :

馬達皮帶輪比量測:

1. Turn OFF the power.

1. 關掉電源.



2. Press **C** key, then turn ON the power.

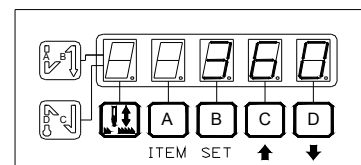
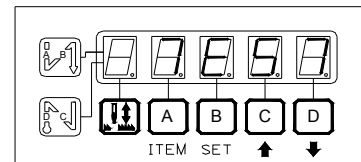
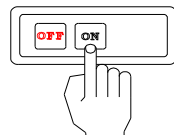
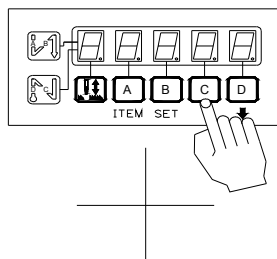
Release **C** key.

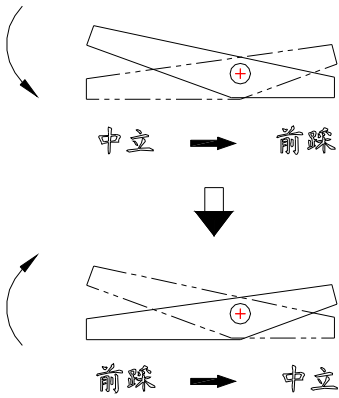
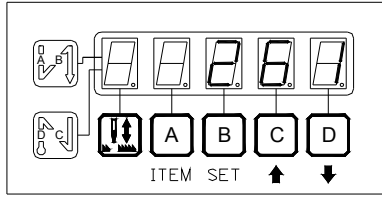
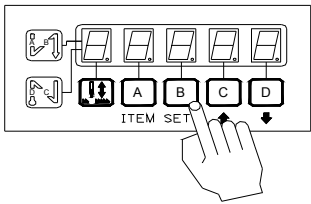
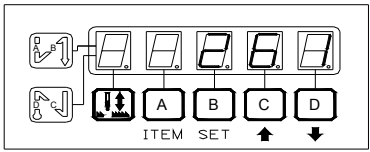
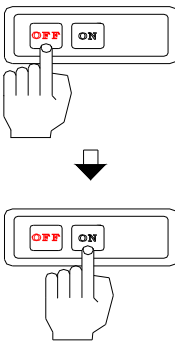
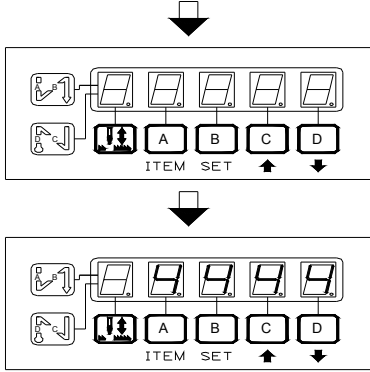
2. 按住 **C** 鍵,同時打開電源.

畫面出現 TEST

放開 **C** 鍵.

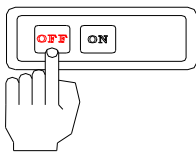
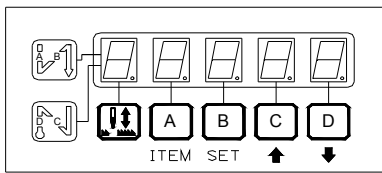
畫面出現存在 EEPROM 中的皮帶輪比

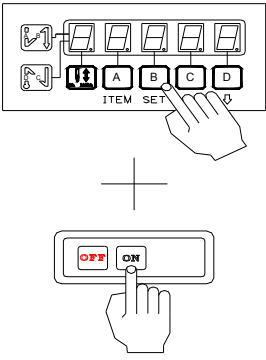
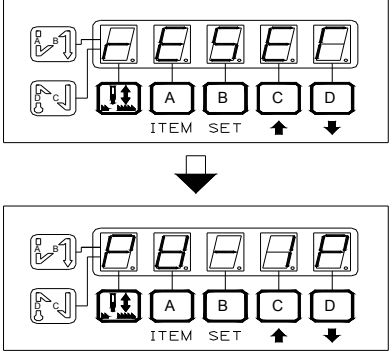


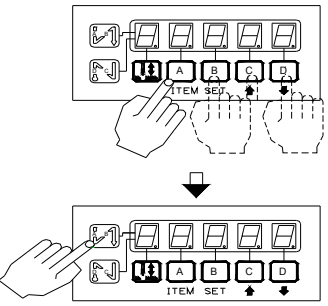
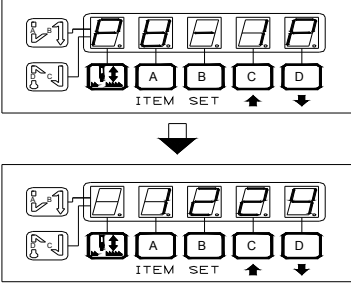
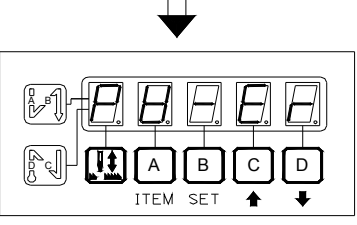
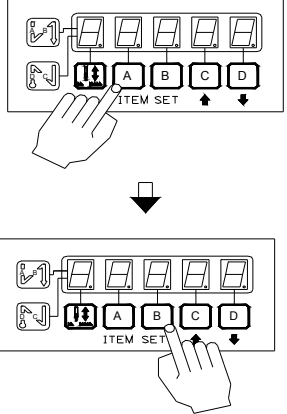
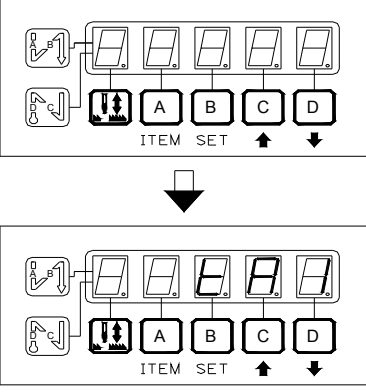


<p>3. If the display is not as shown above, please repeat steps 1-2. 3.如果顯示畫面與上述不同,請重覆步驟 1~2.</p>		
<p>4. If the pedal is forwardly pressed, the motor will rotate 7 turns in positioning speed. After the motor stop, the motor pulley ratio will be displayed. (Sewing machine 360°=motor ? degrees). The step 4 can be repeated to confirm. 4.踏板前踩一下,馬達以定位速度運轉7圈馬達停止後,畫面會顯示所量測的馬達皮帶輪尺寸比(針車頭一圈 360 度=馬達?度)可以重覆步驟 4,再進一步確認.</p>		
<p>5. Press SET key to save. If this procedure is not performed, it will remain as the old values. 5.按 SET 鍵,會將此一皮帶輪比儲存;如不進行此步驟,則無法更新內容 .</p>		<p>畫面閃爍一次 顯示參數號碼</p> 
<p>6. Turn OFF the power then re-turn ON the power, It will operate according to new pulley ratio values . 6.關掉電源,再打開電源,將以最新的馬達皮帶輪比設定運作.</p>		

3. Select the machine type :

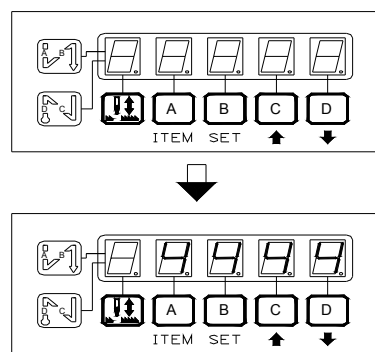
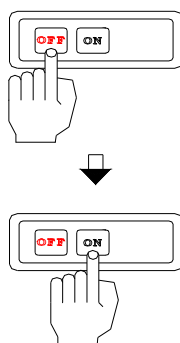
選擇針車頭選項:

<p>1. Turn OFF the power. 1.關掉電源.</p>		
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<p>2. Press SET key simultaneously, then turn ON the power, until rESET displayed then release the key.</p> <p>2. 按住 SET 鍵,同時打開電源,直到畫面出現 rESET 才將按鍵放開出現 PW-IP 畫面.</p>		
<p>3. If it is not displayed as shown above, please repeat steps 1-2.</p> <p>3. 如果顯示畫面與上述不同,請重覆步驟 1~2.</p>		
<p>4. Use A, B, C, D key to key in the password.</p> <p>And enter  to confirm.</p> <p>4. 利用 A, B, C, D 鍵將密碼輸入 再按  鍵做確認.</p>		
<p>5. If the password is correct, the 1st sewing machine head choice will be displayed. If the password is incorrect, the "PW-ER" will be displayed. Please repeat step 4.</p> <p>5. 如果密碼正確會出現第一個針車頭選項, 如果密碼錯誤則出現 PW-ER 請重覆步驟 4.</p>		
<p>6. Press "ITEM" key to select machine type, then press "SET" key .</p> <p>6. 按 ITEM 鍵,選擇要設定的針車模式後,按下 SET 鍵.</p>		

7. Turn OFF the power, then turn ON the power again. It will operate according to the manual's instruction initial value.


7. 關掉電源,再打開電源;將以說明書上參數的初始值來運作。




4. Switch the counter screen

計件畫面切換:

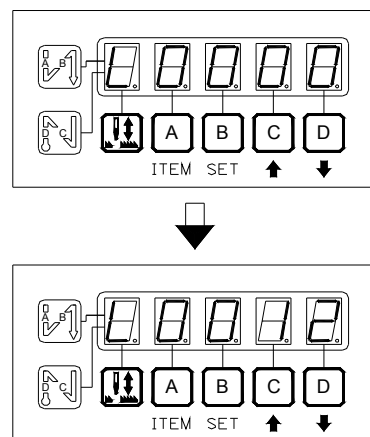
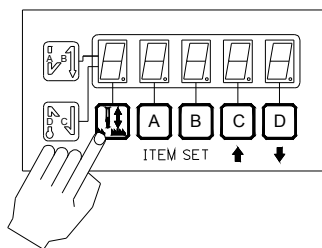
1. In normal operation mode, the stitches' number is displayed

Press  key for 2 seconds, the "COUNT" is displayed. Release "UP/DOWN" key, the counter is displayed.

1. 在平常工作模式,畫面顯示針數

按住  鍵 2 秒,畫面出現

COUNT,放開 UP/DOWN 鍵,畫面顯示計件值。




2. In counter displayed screen.

Press "C" key → counter +1

Press "D" key → counter -1

Press "ITEM" key for 2 seconds → counter →0

Press  key for 2 seconds, display "STIT", release "UP/DOWN" key, display the stitches' number.

2. 在顯示計件值畫面:

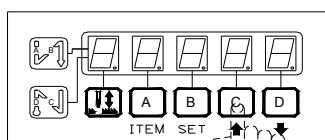
按 C 鍵 → 計件值增加 1

按 D 鍵 → 計件值減少 1

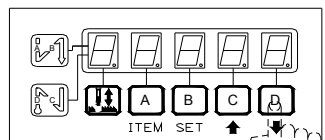
按 ITEM 鍵 2 秒 → 計件值歸零

再按住  鍵 2 秒,畫面出

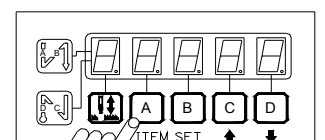
現 STIT,放開 UP/DOWN 鍵後,畫面則恢復顯示針數。



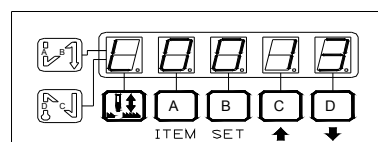
按 C 鍵



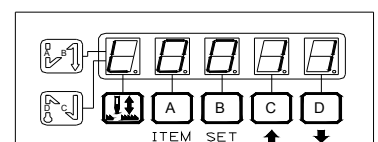
按 D 鍵



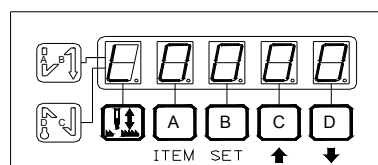
按 ITEM 鍵 2 秒



計件值 + 1



計件值減 - 1



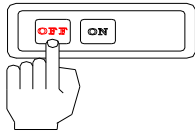
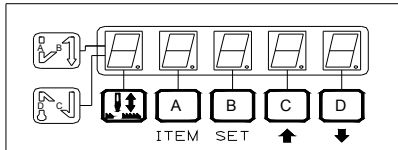
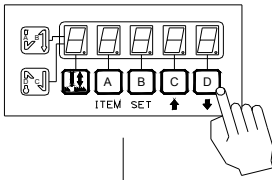
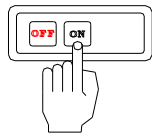
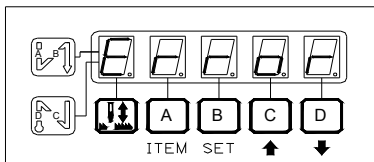
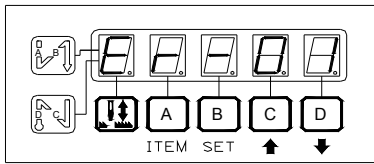
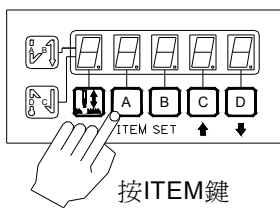
計件值歸零

3 Repeat above step, the screen will be switched between the stitches' number screen & the counter value screen.

3.重複上述步驟,可以在針數畫面與計件值畫面之間作切換.

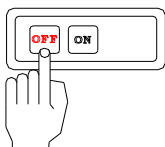
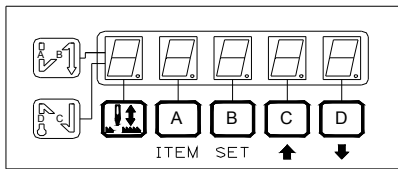
5. Historical error message display

錯誤歷史顯示:


<p>1. Turn OFF the power.</p> <p>1. 關掉電源.</p>		
<p>2. Press D key, then turn ON the power simultaneously and display "ERROR"</p> <p>2 按住 D 鍵,同時打開電源.出現 ERROR</p> <p>3. Release D key and display recently error message.</p> <p>3 放開 D 鍵.顯示畫面出現最近出現的錯誤訊息代碼</p>	 	 
<p>4 Press "ITEM" key to cyclic display recent 6 error messages.</p> <p>4 按 ITEM 鍵最近所發生的 6 個錯誤 error 循環顯示.</p>	 <p>按ITEM鍵</p>	

6. Pedal sensor neutral point setting mode


速度基座中立點設定模式:

<p>1. Turn OFF the power</p> <p>1 關掉電源.</p>		
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2. Set pedal sensor in the neutral point.


Press  key, then turn ON the power simultaneously and display “OFFSET”.

2. 將速度基座置於中立點，

按住  鍵，同時打開電源。

出現 OFFSET

3. Release  key, display the pedal sensor value that stored in EEPROM.

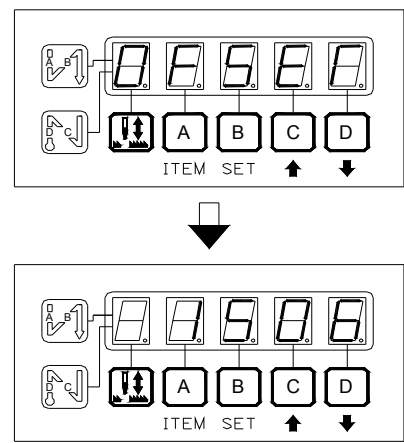
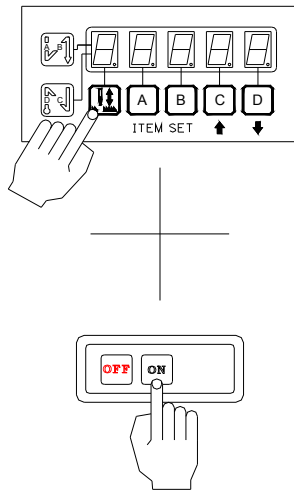
3 放開  鍵，會出現儲存於 EEPROM 中速度基座的讀值；

4. Once press “UP” key, read the pedal sensor again. If the value between 1340~1790, press is “B” key to store.

4. 每按一次 UP 鍵則會重新讀取一次速度基座，當出現的值介於 1340~1790，則按下 B 鍵儲存。


5. If always display “ERROR” that means the pedal sensor neutral point offset too much. The pedal sensor mechanical neutral point must be adjusted then repeat step 4.

5. 若一直出現 ERROR 表示速度基座中立點的機構位置偏離太多，必須先調整速度基座中立點的機構位置，再重復上述步驟 4 的動作。



SV-250 (SV-260) Control box parameter list:

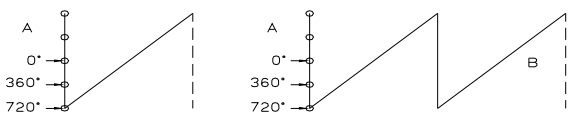
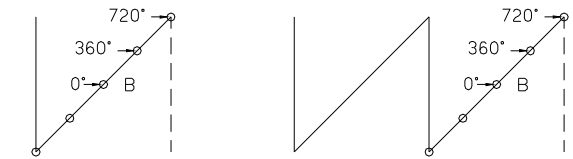
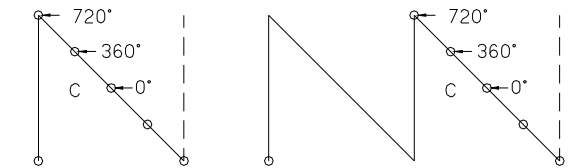
SV-250(SV-260) 參數一覽表

Press A  then turn ON the power

按住 A  後 開電源

No 項目	Item 內容	Range 範圍
1	Sewing machine maximum speed 針車最高速度	200spm ~ 8000spm
2	Sewing machine medium speed 針車中速	200spm ~ 8000spm
3	Sewing machine positioning speed 針車定位速度	100spm ~ 250spm
4	Sewing machine trimming speed 針車切線速度	100spm ~ 250spm
5	The speed of start auto back tack 開始自動倒縫速度	500spm ~ 2500spm
6	Soft start speed 慢速啓動速度	250spm ~ 2000spm
7	Soft start stitches 慢速啓動針數	0 ~ 19 stitches
8	Condensed sewing speed / End auto back tack speed 密縫速度 / 結束自動倒縫速度	500 ~ 2500spm
9	End condensed stitches' number 結束密縫針數	0 ~ 99 stitches
10	Stitches' number that between condensed sewing and trimming 密縫結束後切線執行前車縫針數	0 ~ 19 stitches
11	Foot lifter type 壓腳型式	SOL: Solenoid type 線圈式 AIR: Pneumatic type (Output voltage is 24V, without 60 seconds protection function) 汽閥式(輸出電壓固定爲 24V , 沒有 60 秒 保護功能) SOL2: Solenoid type(chopping duty control) 線圈式(使用斬波控制) AIR2 : Pneumatic type(chopping duty control) 汽閥式(24V 使用斬波控制)

12	Foot lifter control mode 壓腳控制模式	PFL: Pedal controls foot lifter. (PFL) 踏板控制壓腳 (PFL) TAFL: PFL & auto foot lifts after trimming PFL & 切完線後自動抬壓腳 AFL: Auto foot lifting after needle positioning 馬達定位停自動壓腳 TFL: Pedal controls foot lifter after trimming 切完線後才可以踏板控制抬壓腳 SFL: Auto foot lifting (Material edge sensor as output control) 自動壓腳(布端檢出器控制輸出) AFL2: Auto foot lifting after trimming. (It's effective even pedal forward) 切完線後自動抬壓腳(踏板保持前踩狀態時仍有效)
13	Delay time after foot lifter is down 壓腳放下後延遲時間	100 ~ 2500 ms
14	Confirming time for foot lifter acting level 壓腳動作準位確認時間	10 ~ 1000 ms
15	Foot lifter duty 壓腳 DUTY	0 ~ 99%
16	Foot lifter full duty output time 壓腳 FULL DUTY 輸出時間	100 ~ 1000 ms
17	Thread trimming mode 切線模式	OFF : No thread trimming 無切線
17	Thread trimming mode 切線模式	LOCK : lockstitch machine thread trimming 平車切線 LU2 : LU2220 thread trimming LU2220 切線 LU1: LU1520 thread trimming LU1520 切線 LU : Other LU machine thread trimming 其他 LU 機型切線 US639 : US63900 special thread trimming US63900 特殊切線 UT : Needle up trimming 上停切線(切刀式) AIR : Needle up trimming (AIR BLOW) 上停切線 (吹氣式) UT2 : Needle down trimming (trimming & wiping together) 上停切線(切線與撥線一起動作)
18	Thread trimming delaying time 切線延遲時間	0 ~ 200 ms

19	Thread trimming acting time 切線動作時間	0 ~ 1000 ms
20	Thread wiping delaying time 撥線延遲時間	0 ~ 300 ms
21	Thread wiping acting time 撥線動作時間	0 ~ 2500 ms
22	Foot lifter delaying time 壓腳延遲時間	0 ~ 2500 ms
23	Thread wiping output control 撥線輸出控制	OFF : No output wiping 不輸出撥線 ON : Output thread wiping 輸出撥線
24	Motor rotating direction 馬達轉向	CCW : Counterclockwise 逆時針 CW : Clockwise 順時針
25	A_code back tacking compensation A_CODE 回針動作補正 Single SBT Double SBT Single SBT Double SBT 	0 ~ 720 °
26	B_code back tacking compensation B_CODE 回針動作補正 Single SBT Double SBT 	0 ~ 720 °
27	C_code back tacking compensation C_CODE 回針動作補正 Single EBT Double EBT 	0 ~ 720 °

28	The curve slope of pedal stroke vs. motor rotating speed 踏板行程對應馬達速度曲線	0 ~ 4 Bigger value means smaller curve slope 數值越大斜率越小
29	Accelerating slope 加速曲線	1 ~ 8 Bigger value means slowly accelerating 數值越大加速越慢
30	The pedal stroke adjustment for motor start rotating 馬達開始轉動的踏板行程調整	50 ~ 90 (Pedal neutral reference point = 40, LD1 lighting) (中立點參考值 = 40 , LD1 點亮)
31	Pedal stroke adjusts for motor start accelerating 馬達開始加速的踏板行程調整	70 ~ 110
32	Pedal stroke adjusts for foot lifter start acting 壓腳開始動作的踏板行程調整	20 ~ 35
33	Pedal stroke adjusts for start thread trimming 切線開始動作的踏板行程調整	3 ~ 30
34	Standing type pedal operating choice 立式作業選擇	OFF : Normal operation of speed pedal unit 速度基座正常操作 PK70 : For JUKI standing operation PK70 type, the speed is variable 配合 JUKI 立式作業 PK70 ,速度可變 PKSW : Standing pedal operation, the speed is fixed (low speed & high speed) 立式作業 , 速度固定(低速&高速) PK71 : Speed pedal unit normal control and with foot lifting switch & thread trimming switch function 速度基座正常操作,另外有壓腳開關及切線開關的功能
35	Safety switch type 安全開關型式	N.O : Normal open switch 常開接點 N.C : Normal close switch 常閉接點
36	In auto test mode, motor running time adjustment 自動測試模式下,馬達運轉時間調整	2000 ~ 8000 ms
37	In auto test mode, motor stopping time adjustment 自動測試模式下,馬達停止時間調整	2000 ~ 8000 ms
38	Back tacking switch function 回針按鍵功能	BTSW : Control back tacking solenoid 控制回針線圈 NDUP : Control back tacking solenoid when motor runs, and as needle up switch when motor stops 運轉中控制回針線圈,靜止時提針至上停

38	Back tacking switch function 回針按鍵功能	DSIN : Control back tacking solenoid when motor runs, non-continuously inching during motor stops 運轉中控制回針線圈,靜止時不連續補針 CNIN : Control back tacking solenoid when motor runs, continuously inching during motor stops 運轉中控制回針線圈,靜止時連續補針 RFS : Reverse feed stitching function is effective during sewing 途中倒縫功能 (車縫中有效) RFSS : Reverse feed stitching function is effective both during sewing and stopping 途中倒縫功能(車縫中&停止時均有效) SHOT : Control back tacking solenoid, No.74 decide the output pulse width. 控制回針線圈 , 輸出脈波寬度由 NO.74 決定 UPBT : Control back tacking solenoid, it is effective only in needle up position 控制回針線圈 ,只在上停位置有效
39	Stitches' number in reverse feed stitching 途中倒縫針數	0 ~ 19 stitches
40	Trimming function in the reverse feed stitching 途中倒縫切線功能	OFF : No thread trimming function 不切線 ON : Execute auto thread trimming after reverse feed stitching. 途中倒縫針數結束後,進行自動切線
41	Execute auto thread trimming after end fixed stitches' number sewing process 固定針數縫製工程結束後,自動切線功能	OFF : No such function. 無功能 ON : With the function 有此功能
42	Material edge sensor function 布端檢出器功能	OFF : No such function. 無功能 ON : With the function 有此功能
43	Step-1 for material edge sensor stitches' number 第一段布端檢出器針數	0 ~ 250 stitches
44	Use material edge sensor to process trimming function 利用布端檢出器進行切線功能	0 : No such function. 無功能 1 : Auto trimming after execute the step-1 stitches. 執行完第一段布端檢出器針數,自動接著做切線 2 : Auto trimming after execute the step-2 stitches. 執行完第二段布端檢出器針數,自動接著做切線 3 : Auto trimming after execute the step-3 stitches. 執行完第三段布端檢出器針數,自動接著做切線 4 : Auto trimming after execute the step-4 stitches. 執行完第四段布端檢出器針數,自動接著做切線

45	Auto needle up positioning when power on 開機自動上停	OFF : No such function. 無功能 ON : With the function 有此功能
46	The counter number displays on the simple panel when power on 開機簡易面板顯示計件值	0 : Display the value of stitches' number 顯示針數 1 : Display the value of materials' number 顯示計件值 2 : Display the trimming , wiper , foot lifter function 顯示切線,撥線,壓腳功能 Counter value: 0~9999 計件值 : 0 ~ 9999
47	To lock the pedal forward function before finish trimming process 切線完成前踏板前踩互鎖功能	OFF : No such function. 無功能 ON : With the function 有此功能
48	Sewing machine reversed revolution function after thread trimming processed 切線完成後車頭反轉功能	OFF : No such function. 無功能 ON : With the function 有此功能
49	Sewing machine reversed revolution angles after thread trimming processed 切線完成後車頭反轉角度	0 ~ 250°
50	The delaying time after finished thread trimming but before sewing machine reversed revolution. 切線完成後車頭反轉前延遲時間	0 ~ 2500 ms
51	Virtual needle down positioning function 虛擬下停功能	OFF : No such function. 無功能 ON : With the function 有此功能
52	The angles between virtual needle down positioning point and needle up signal 虛擬下停點,由上停信號開始點起算	0 ~ 250°
53	The needle positioning function of starting sewing 起縫定針功能	OFF : No such function. 無功能 ON : With the function 有此功能
54	The needle positioning angles of starting sewing 起縫定針角度	0 ~ 250°
55	The starting angle of trimming action (count from the needle down position and only effective in LU trimming mode) 切線動作開始角度(下停開始起算,只在 LU 切線模式有效)	0 ~ 250°

56	The continuous angles of trimming action (count from the needle down position and only effective in LU trimming mode) 切線動作持續角度(只在 LU 切線模式有效)	0 ~ 250°
57	The tension release starts acting angles (count from the needle down position and only effective in LU trimming mode) 紗拉組開始動作角度(下停開始起算,只在 LU 切線模式有效)	0 ~ 250°
58	The tension release continuous acting angles (only effective in LU trimming mode) 紗拉組動作持續角度(只在 LU 切線模式有效)	0 ~ 250°
59	The tension release continuous acting time (count from the needle up position and only effective in LU trimming mode) 紗拉組動作持續時間(上停信號開始動作起算,只在 LU 切線模式有效)	0 ~ 1250 ms
60	The function selection for Option IN_A Option IN_A 功能選擇	OFF : No such function 無功能
61	The function selection for Option IN_B Option IN_B 功能選擇	DSCT: Cancel thread trimming for one time 單次取消切線
62	The function selection for Option IN_C Option IN_C 功能選擇	DSBT: Cancel auto back tacking for one time 單次取消自動回針 DSCN : Cancel condensed stitching for single time 單次取消密縫 NDUP : Needle up switch 提針到上停 HALF : Half stitch inching 半針補針 ONE : One stitch inching 一針補針 (it's only effective when No.34=OFF) No.34 = OFF 時才有效
63	Whether motor stops or not before executes EBT 執行 EBT 之前馬達是否停止	OFF : Motor will not stop, directly executes EBT 馬達不會停止,直接作 EBT ON : Motor will stop for A period time (set by No.64) then executes EBT 馬達會停止一段時間(參數 NO.64 設定)再接 EBT
64	Motor stops time before executes EBT (only effective when No.63=ON) 執行 EBT 之前馬達停止時間 (只在 NO.63=ON 時有效)	20 ~ 1500 ms

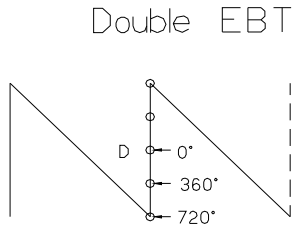
65	Start auto back tacking control mode 開始自動倒縫控制模式	AUTO : Auto mode 自動模式
66	End auto back tacking control mode 結束自動倒縫控制模式	ASU : After every back tacking cycle, firstly stop in the needle up position (the time period is as No.68 setting) then execute next process. 每趟針數執行完,在上停點停止(NO.68 所設定時間) 再接著做下一趟針數
67	Continuously auto back tacking control mode 連續自動倒縫控制模式	ASD : After every back tacking cycle, firstly stop in the needle down position (the time period is as No.68 setting) then execute next process. 每趟針數執行完,在下停點先停止(NO.68 所設定時間) 再接著做下一趟針數
68	Auto back tacking section stopping time 自動倒縫段落停止時間	20 ~ 1500 ms
69	The Option OUT_A acts stitches' number after material edge sensor on 布端檢出器開始動作 Option OUT_A 動作針數	0 ~ 99 stitches
70	The Option OUT_A delays stitches' number after material edge sensor off 布端檢出器結束動作 Option OUT_A 延遲針數	0 ~ 99 stitches
71	The acts stitches' number after the Option OUT_A delays stitches' number & material edge sensor off 布端檢出器結束動作 Option OUT_A 延遲後動作針數	0 ~ 99 stitches
72	The Option OUT_B acts stitches' number after material edge sensor on 布端檢出器開始動作 Option OUT_B 延遲針數	0 ~ 99 stitches
73	The Option OUT_B delays stitches' number after material edge sensor off 布端檢出器結束動作 Option OUT_B 延遲針數	0 ~ 99 stitches
74	The Option OUT_B acts time Option OUT_B 動作時間	0 ~ 250 ms
75	The Option OUT_C acts stitches' number after material edge sensor on 布端檢出器開始動作 Option OUT_C 動作針數	0 ~ 99 stitches
76	The Option OUT_C delays stitches' number after material edge sensor off 布端檢出器結束動作 Option OUT_C 動作針數	0 ~ 99 stitches
77	The Option OUT_D acts stitches' number after material edge sensor on 布端檢出器開始動作 Option OUT_D 延遲動作針數	0 ~ 99 stitches
78	The Option OUT_D delays stitches' number after material edge sensor off 布端檢出器結束動作 Option OUT_D 持續動作針數	0 ~ 99 stitches

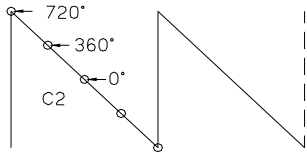
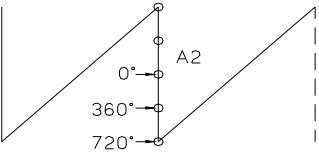
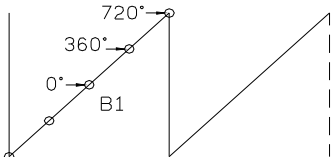
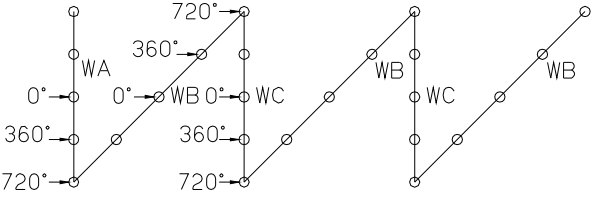
79	The function choice of Option OUT_A Option OUT_A 功能選擇	0 : No output 無輸出 1 : Depend on the setting stitches' number output 根據所設定針數輸出 2 : Depend on the setting stitches' number output when foot lifter acts 根據所設定針數輸出 & 舉壓腳動作時輸出 3: No output when motor stop 馬達停止時無輸出
80	The function choice of Option OUT_B Option OUT_B 功能選擇	0 : No output 無輸出 1 : Depend on the setting stitches' number output (Pedal control speed) 根據所設定針數輸出(踏板控制速度) 2 : Depend on the setting stitches' number output (material edge sensor starts & during motor medium speed) 根據所設定針數輸出(布端檢出器開始&結束動作時馬達為中速) 3 : Depend on the setting stitches' number output (material edge sensor ends & during motor medium speed) 根據所設定針數輸出 (布端檢出器結束動作時馬達為中速)
81	The function choice of Option OUT_C Option OUT_C 功能選擇	0 : No output 無輸出 1 : Depend on the setting stitches' number output (Pedal control speed) 根據所設定針數輸出 (踏板控制速度) 2 : Depend on the setting stitches' number output (material edge sensor ends & during motor medium speed) 根據所設定針數輸出 (布端檢出器結束動作時馬達為中速) 3 : Auto sewing setting stitches without pedal press 踏板不需要前踩也可以自動執行所設定的針數
82	The function choice of Option OUT_D Option OUT_D 功能選擇	0 : No output 無輸出 1 : Depend on the setting stitches' number output 根據所設定針數輸出 2 : Depend on the setting stitches' number output when foot lifter acts 根據所設定針數輸出 &舉壓腳動作時輸出 3 : Depend on the setting stitches' number output (keeps acting even motor stops) 根據所設定針數輸出(馬達停止時仍保持動作)

83	The control solenoid output cycle choice of material edge sensor 布端檢出器控制輸出線圈循環週期結束選擇	0 : Option OUT_A 1 : Option OUT_B 2 : Option OUT_C
84	The priority between material edge sensor on & pressing pedal forward 布端檢出器開始動作與踏板前踩優先權選擇	0 : The material edge sensor must be acted before pressing pedal 布端檢出器必須在踏板前踩之前動作
84	The priority between material edge sensor on & pressing pedal forward 布端檢出器開始動作與踏板前踩優先權選擇	1 : Pedal condition is immediate effective when material edge sensor on 布端檢出器開始動作時踏板的狀態立刻有效 2 : Pressing pedal is prior. 踏板前踩優先
85	Cancel the thread trimming function choice when pedal is heeled. 取消踏板後踩切線功能選擇	OFF : With the thread trimming function when pedal is heeled 有踏板後踩切線功能 ON : Cancel the thread trimming function when pedal is heeled. And just the foot lifting function is effective. 取消踏板後踩切線功能只做舉壓腳動作
86	Special function choice 1 特殊功能選擇 1	0 : No special function 沒有特殊功能 1 : LB2 enable, MTJ=OFF LB2 致能 , MTJ = OFF 2 : LB2 enable, MTJ=ON LB2 致能 , MTJ = ON 3 : BAF function BAF 功能 4 : LU1521 function LU1521 功能 5 : CA1 function CA1 功能 6 : SAS1 function SAS1 功能 7 : BASF function BAFS 功能 8 : Manual one- shot function 踏板控制 one-shot 針數車縫功能 9 : Automatic one-shot function 自動 one-shot 針數車縫功能 10 : edge sensor with re-cycle function 布端檢出器有再次循環功能 11 : multi-step material edge sensor stitches' number 多段式布端檢出器針數

87	No synchronizer operation mode 沒有同步器操作模式	0 : With synchronizer (detect ER-1). 有同步器操作模式 (會檢出 ER-1) 1 : Without synchronizer operation mode. (ER-1 is not displayed.) 沒有同步器操作模式 (不會顯示 ER-1) 2 : With synchronizer (don't detect ER -1) 有同步器操作模式 (不會檢出 ER-1)
88	The speed margin of executing needle positioning 執行定位的速度臨界值	80 ~ 160
89	Decelerating speed slope choice 減速曲線選擇	1 ~ 8 (The bigger value means the longer time of decelerating.) 設定值越大,減速時間越長
90	Motor static brake function 馬達靜止煞車功能	0 ~ 20 0 : No such function 無功能 1 ~ 20 : (The bigger value means the more powerful braking force.) 1 ~ 20 : 有此功能, 設定值越大煞車力量越大
91	Motor rotation signal control 馬達轉動信號控制	OFF : No output 不輸出 TL1 : TL solenoid outputs when motor rotates. 馬達轉動時由 TL 線圈輸出 TL2 : TL solenoid outputs when motor rotates & foot lifter acts. 馬達轉動時和舉壓腳動作時由 TL 線圈輸出
92	Forward output the motor rotation signal 馬達轉動信號提早輸出時間	0 ~ 1250 ms
93	Reverse revolution function when machine starts stitching. 起縫反轉功能	OFF : No such function 無功能 ON : With this function 有此功能
94	Reverse angles when machine starts stitching. 起縫反轉角度	0 ~ 250°
95	Check the speed control unit condition function when power on. 開機時檢查速度基座狀態功能	OFF : No such function 無功能 ON : With this function 有此功能
96	Special function choice 2 特殊功能選擇 2	0 : No special function 沒有特殊功能 1 : FLSW special function FLSW 特殊功能 3. Option OUT_A special function 輸出 OUT_A 特殊功能

97	Auto function setting. (Only effective in BAFS machine) 自動機能設定(只在 BAFS 車頭選項中有效)	OFF : No such function 無功能 ON : With this function 有此功能
98	Motor delays starting time. (Only effective in BAFS machine) 馬達延遲啟動時間(只在 BAFS 車頭選項中有效)	0 ~ 9900 ms
99	BLOWER-B delays output time. (Only effective in BAFS machine) BLOWER- B 輸出延遲時間 (只在 BAFS 車頭選項中有效)	0 ~ 9900 ms
100	BLOWER-B output time. (Only effective in BAFS machine) BLOWER- B 輸出動作時間 (只在 BAFS 車頭選項中有效)	0 ~ 9900 ms
101	In motor running, FLSW key input to control FLL output acted stitches' number 馬達運轉中 option IN_G 按鍵輸入控制 option OUT_D 輸出動作針數	0 ~ 500 stitches
102	Material edge sensor begins acting, Option OUT_E delay acting stitches number 布端檢出器開始 Option OUT_E 延遲動作針數	0 ~ 99 stitches
103	Material edge sensor ends acting, Option OUT_E continuously act stitches number 布端檢出器結束 Option OUT_E 持續動作針數	0 ~ 99 stitches
104	Option OUT_E function choice Option OUT_E 功能選擇	OFF : No output 無輸出 ON : Depend on setting stitches' number output 根據所設定針數輸出
105	Foot lifter protecting time 押腳保護時間	0 ~ 60 seconds
106	Folder auto function setting (Only effective in TCF machine) Folder 自動機能設定 (只在 TCF 車頭選項中有效)	OFF : No such function 無功能 ON : With this function 有此功能
107	Folder auto function delays stitches' number (Only effective in TCF machine) Folder 自動機能延遲針數 (只在 TCF 車頭選項中有效)	0 ~ 99 stitches
108	Motor's braking force when positioning 馬達定位時煞車力	0 ~ 3
109	Dial type choice Dial 型式選擇	0 : Dial is switch type 爲開關式 1 : Dial is VR type 爲 VR 型式 2 : Dial is not connected 未接

110	Needle thread winding device released time (LU-1521 is effective) 勾線裝置釋放時間 (LU-1521 車頭有效)	0 ~ 600 ms
111	ER-2 checking time ER-2 檢查時間	0 ~ 5 seconds
112	ATC auto function setting (Only effective in ATC machine) ATC 自動機能設定(只在 ATC 車頭選項中有效)	OFF : No such function 無功能 ON : With this function 有此功能
113	Material edge sensor begins acting, Option OUT_F delay acting stitches' number 布端檢出器開始動作 Option OUT_F 延遲針數	0 ~ 99 stitches
114	Material edge sensor ends acting, Option OUT_F continuously act stitches' number 布端檢出器結束動作 Option OUT_F 持續針數	0 ~ 99 stitches
115	Option OUT_F function choice Option OUT_F 功能選擇	OFF : No output 無輸出 ON : Depend on setting stitches' number output 根據所設定針數輸出
116	Control Option OUT_C solenoid output function by Option IN_D 利用 Option IN_D 控制 Option OUT_C 線圈 輸出功能	OFF : No such function 無功能 ON : With this function 有此功能
117	Start condensed stitching stitches' number 開始密縫針數	0 ~ 99 stitches
118	During motor rotates, auto FOLDER stitches' number (YU2F & YU3F machine is effective) 馬達運轉中,自動 FOLDER 針數 (YU2F & YU3F 車頭有效)	0 ~ 99 stitches
119	Auto FOLDER function (YU2F & YU3F machine is effective) 自動 FOLDER 功能 (YU2F & YU3F 車頭有效)	OFF : No such function 無功能 ON : With this function 有此功能
120	D_code back tacking compensation D_CODE 回針動作補正 Double EBT 	0 ~ 720 °

<p>121</p>	<p>C2_code back tacking compensation C2_CODE 回針動作補正</p> <p>Double EBT</p> 	<p>0 ~ 720°</p>
<p>122</p>	<p>A2_code back tacking compensation A2_CODE 回針動作補正</p> <p>Double SBT</p> 	<p>0 ~ 720°</p>
<p>123</p>	<p>B1_code back tacking compensation B1_CODE 回針動作補正</p> <p>Double SBT</p> 	<p>0 ~ 720°</p>
<p>124</p>	<p>WA_code back tacking compensation WA_CODE 回針動作補正</p> 	<p>0 ~ 720°</p>
<p>125</p>	<p>WB_code back tacking compensation WB_CODE 回針動作補正</p>	<p>0 ~ 720°</p>
<p>126</p>	<p>WC_code back tacking compensation WC_CODE 回針動作補正</p>	<p>0 ~ 720°</p>

127	Delay positioning function 延遲定位功能	OFF : No such function 無功能 ON : With this function 有此功能
128	Speed boosting 速度提升	0 ~ 50 %
129	Torque boosting when motor lock 馬達鎖死扭力提升	0 ~ 30
130	Up position adjustment 上停點位置調整	0 ~ 250 °
131	Stitch number for one-shot function ONE-SHOT 針數	0 ~ 250
132	The delay time for DST function DST 延遲時間	0 ~ 300 ms
133	The acting time for DST function DST 動作時間	0 ~ 2500 ms
134	Stop position when material edge sensor active 布端檢出器動作時,馬達停止位置	OFF : Depend on simple control panel setting 由簡易面板上下停決定 UP : Up position 上停點 DOWN : Down position 下停點
135	UTL delaying time UTL 延遲輸出時間	0 ~ 200 ms
136	UTL acting time UTL 動作輸出時間	0 ~ 2000 ms
137	Delay time after UTL active UTL 動作輸出後延遲時間	0 ~ 200 ms
138	Option OUT_C delay acting stitches (only effective in PT2 machine) 布端檢出器開始動作 Option OUT_C 延遲動作針數(只在 PT2 機型有效)	0 ~ 99 stitches
139	Option OUT_C acting stitches (only effective in PT2 machine) 布端檢出器動作 Option OUT_C 持續動作針數(只在 PT2 機型有效)	0 ~ 99 stitches
140	Protecting function for motor 馬達運轉時間保護功能	OFF : No such function 無功能 ON : With this function 有此功能
141	Times for Protecting function active 馬達發生保護功能時間	100 ~ 5000 hours

142	Forward stitches to decelerate speed in EBT 後自動倒縫結束提前減速針數	0 ~ 2
143	Stitches counter for ATC machine ASC 機型針數計數	0 ~ 1000
144	Dotted line function 鎖線功能	OFF : No such function 無功能 ON : With this function 有此功能
145	Delay time before dotted line function 鎖線前延遲時間	0 ~ 1000 ms
146	Active angle for dotted line function 鎖線動作角度	200 ~ 360 °
147	Step-2 for material edge sensor stitches' number 第二段布端檢出器針數	0 ~ 250 stitches
148	Step-3 for material edge sensor stitches' number 第三段布端檢出器針數	0 ~ 250 stitches
149	Step-4 for material edge sensor stitches' number 第四段布端檢出器針數	0 ~ 250 stitches
150	Execute auto foot lifter after end fixed stitches' number sewing process 固定針數縫製工程結束後,自動抬壓腳功能	OFF : No such function. 無功能 ON : With the function 有此功能
151	Fast cutter function 快速切刀功能	OFF : No such function. 無功能 ON : With the function 有此功能
152	Decelerating curve for fixed stitches' number sewing process 固定針數縫製減速曲線	0 ~ 4
153	Stitches between UTL and trimming UTL 動作輸出後到切線前縫製針數	0 ~ 99
154	Option OUT_A OFF delay time Option OUT_A 延遲關閉時間	0 ~ 9000 ms