OPERATION INSTRUCTION OF OPERATION PANEL
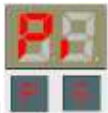

Picture1

This products with the double digit tube display and two press key.

Picture 1：the interface when turn on the machine

1. Parameter list

Para-meter	function	description
V	Parameter for adjust the speed	Speed=Value show in the digital X100(RPM/Min)
M	Set needle position function	0：turn off needle position function 1：turn on needle position function
Y	Parameter for needle position	Digital tube show "-" in upper location means upper needle position and in down location means down needle position Note：Y do not work when M value is 0
b	Set the rotation	The LED light running direction in the right side digital tube means the rotation of the motor

2. Parameter adjustment

2.1 Parameter Adjustment For Speed
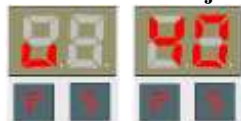
Picture 2   Picture 3

Picture 4   Picture 5

On the interface, press P, and then the digital show V(Picture 2), press S show the speed value(Picture 3), continue press S can adjust the speed value. When adjust ,if the small point of the digital is twinkling ,means adjustment is not saved,

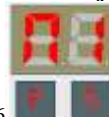The way to save the adjustment: press P. Show OK(Picture 4) means success, show Er(Picture 5) means failed

The way to give up adjustment: turn off the power, and waiting till the digital tube light turn off.

2.2 Parameter Adjustment For Auto-Needle Position Function

Picture 6

In the P interface, press key P several times quickly, will enter parameter M(Picture 6). Through press the right key S can adjust the value of M

Save the adjustment: press P.

Show OK means success, show Er means failed

Give up adjustment: turn off the power, and waiting(about 20s) till the digital tube light turn off.

2.3 Auto-Needle Position Model Adjustment

In P interface, to press the key P with several times quickly, the left side digital tube will show Y, and then press the right side key to adjust the needle position model.

Picture7   Picture 8

Note: If parameter M value is 0 then this parameter not work

2.4 Motor Rotation Adjustment

Picture 9

In P interface, press left side key with several times quickly till the left side digital tube show b, then through press the right side key to adjust the ration of the motor.

1) Before use the motor ,confirm the rotation of the sewing machine head first(clockwise rotation or counter clockwise rotation)

2) When the motor used in different type of sewing machines, please to adjust the motor rotation accordingly in parameter b. details refer to"b the list of motor parameter and motor direction".

2.5 Restoring To Factory Setup

When the control box can not work regularly, through restoring to factory setup make the machine can work regular again.

Press S (about 3 seconds)on the P interface till the digital tube shows "OK" will recover the system parameter to the factory setting. If shows Er means failed.

Please find the list of motor parameter and motor direction. as below

Parameter b	Belt Driver	Direct Driver Overlock/Inter-lock	Direct Driver Lockstitch
Right digit tube run in clockwise			
Right digit tube run in counter clockwise			

MANTAINANCE AND GENERAL RECOVERY PROCESSING

If the machine went wrong, maintenance and operation should be operated under professional trained person.

1. No reaction when turn on the power control box.

Picture 10

Please check whether the plug is inserted, the power cord and the fuse are in good condition(The fuse is inside the control box as picture 10 , please replace the fuse which as the same type as before if the original one is burnt.)

2. Control box is connected, but the motor doesn't work when pressing the pedal. Motor speed is not controlled by the governor.

Please check if the plug of speed controller, motor and motor signal wire is connected to the socket in control box correctly. Check if the speed controller is broken or not.

3. The rotate speed of motor sometimes fast and sometimes slow

Please check if the belt is too loose, or the belt puller slipped, or the pedal and tension rod is loose.

4. The motor suddenly stopped during running

Please check if the machine load too heavy first or there is mechanical problems. Then check if the power socket and plug connect well to the motor hall socket and plugs well. It's same to the socket and plug of speed controller.

5. The motor will run without stop when the control box is turning on.

Please check it if the position of alnico within speed adjustor changed. The method is as below mentioned: Open the plastic cover of speed controller, loose the fixed screw. Then adjust the position of swinging arm (picture 11 is the position of swinging arm when working), make the alnico within swinging arm on the right up of the part hall, (picture 12 is the position of swinging arm when stopping), generally, the machine could stop. If not, adjust the position again by clockwise.

Picture 11   Picture 12

6. If turn on the machine the fuse immediately burnt, after change the same specification fuse the problem still can't solve, please contact with the local agent to repaire.

7. Other problems not list above, please contact with the local agent

Error code	Reasons	Solution
E1	Motor with locked-rotor problem	Please reduce the load capacity and then restart the motor please check if the sewing material is too heavy Please check if the machine needs lubrication. Please check if the 10core line connect well or not
E2	over-current or under-voltage	Please check the voltage Because of supercharge or controller failure, if turn on the motor again can't solve the problem, please contact the local agent Please check if the 10core line connect well or not
E3	The board can not read the parameter	Please turn off the power and then turn it on again. If can't solve the problem, please contact the local agent
E4	Hall signal error	Please check if the 10core line connect well or not, please check if the connect line of hall is well or not
E5	Needle position with problem	Please check if the positioner connect well (if the positioner damage or don't need needle position function and with Er5 code, please keeping press S around 3seconds, enter parameter model, set M value into 0 can turn off the function

Note: If the control box give the error code made the machine can't run, please don't turn on the power till the problem solved