

H6-27A 电控使用说明书

安全事项

- 在使用本产品之前，请先阅读《产品说明书》及所搭配的缝纫机机械说明书。
 - 本产品必须由接受过专业培训的人员来安装或操作。
 - 请尽量远离电弧焊接设备，以免产生的电磁波干扰本控制器而发生误动作。
 - 请不要在室温 45°以上或者 0°以下的场所使用。
 - 请不要在湿度 30% 以下或者 95% 以上或者有露水和酸雾的场所使用。
 - 安装控制箱及其他部件时，请先关闭电源并拔掉电源插头。
 - 为防止干扰或漏电事故，请做好接地工程，电源线的接地线必须牢固的与大地有效连接。
 - 所有维修用的零部件，须由本公司提供或认可，方可使用。
 - 在进行任何保养维修动作前，必须关闭电源并拔掉电源插头。控制箱里有高压危险，必须关闭电源五分钟后方可打开控制箱。
- Safety Precautions
- Before using this product, please read the User's Guide and the manual of the machine attached with it.
 - This product must be installed or operated by professionally trained personnel.
 - Please keep away from the arc welding equipment to avoid the electromagnetic wave from interfering with the controller.
 - Please do not use it at room temperature above 45° or below 0°.
 - Please do not use it in places with humidity below 30% or above 95% or where there is dew and acid mist.
 - When installing the control box and other parts, turn off the power and unplug the power plug.
 - To prevent interference or electric leakage accidents, make a good grounding work. The grounding wire of the power cord must be firmly connected to the earth.
 - All parts for maintenance must be supplied or approved by the Company before they can be used.
 - The power must be turned off and the plug unplugged before any maintenance action is performed. There is a high-voltage danger in the control box. You must shut down the power for 5 minutes before opening the control box.

1 产品安装 Product Installation

1.1 产品规格 Product specification

电源电压	AC 220±20% V
电源频率	50Hz/60Hz
最大输出功率	750W

1.2 接口插头的连接 The connection of interface plug

将脚踏板及机头的各连接插头安插到控制器后面对应的插座上，各插座名称如图 1-2-2 所示。连接好，请检查插头是否插牢。

Insert the connecting plugs of the foot pedal and the head of the machine into the corresponding socket at the back of the controller. Each socket names are shown in figure 1-2-2. Please check whether the plug is inserted.

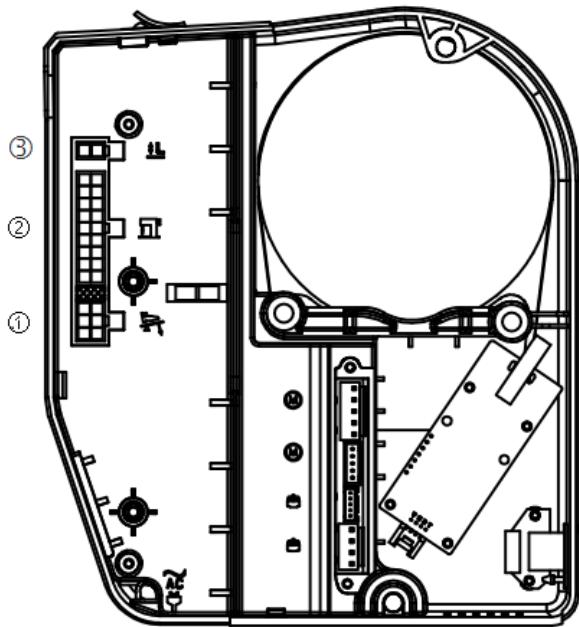


图 1-2-1 控制器图

- ① 脚踏板&升级插座 Socket of foot pedal and updating;
- ② 电磁铁、LED 灯、机头按键插座 Socket of Electromagnet, LED Lamp and machine head
- ③ 抬压脚电磁铁接口 Socket of foot Electromagnet

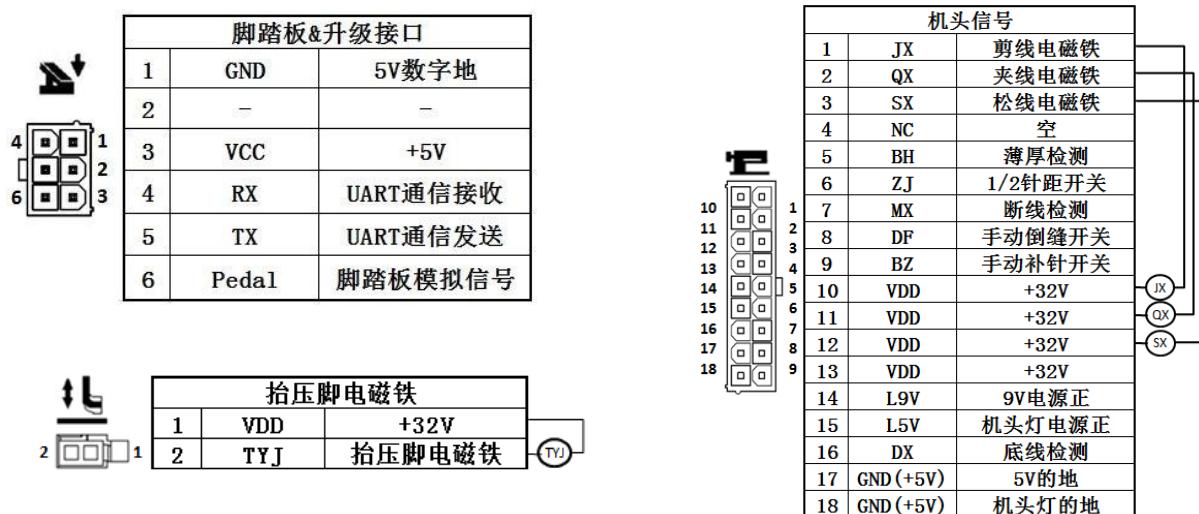


图 1-2-2 控制器接口定义 (controller connection plug definition)

注：使用正常力量插不进去时，请检查插头与插座是否匹配，插入方向或针的方向是否正确！

If it cannot be inserted normally, please check the plug and socket match or not, the direction of the insertion or the direction of the needle is correct or not.

1.3 接线与接地

必须要做好系统的接地工程,请合格的电气工程人员予以施工。产品通电及投入使用前,必须确保电源插座AC输入端已安全可靠的接地。系统的接地线为黄绿线,该地线请务必可靠连接至电网安全保护接地上,以保证安全使用,并可防止出现异常情况。

注:所有电源线、信号线、接地线等接线时不要被其它物体压到或过度扭曲,以确保使用安全。

2 操作面板使用说明

2.1 操作面板的显示说明

根据系统工作状态,操作面板的液晶屏将显示当前的缝纫状态(包含停针位指示)。操作面板外观如下所示。

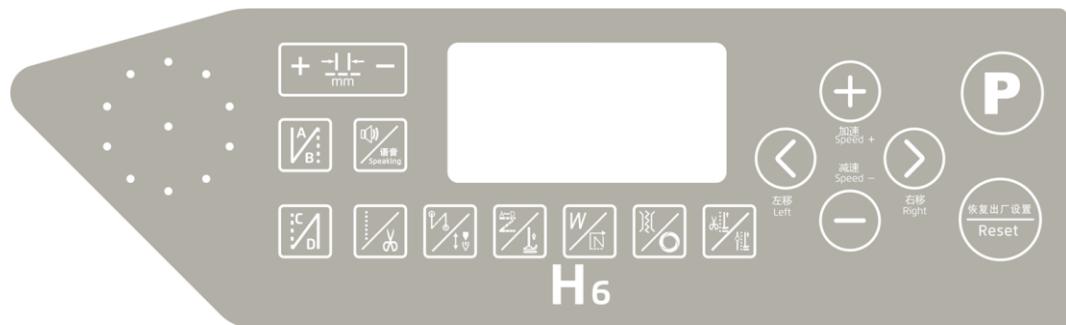


图 2-1 操作面板外观界面

2.2 操作面板各按键功能说明

序号	外观	名称	功能描述
1		针距调节键 Stitch length adjustment key	针距调整按键,空闲状态时短按加减针距 Stitch length adjustment key, press to increase or decrease stitch length in idle state
2		前加固键 Start tacking	前固缝选择键,每短按动一次,在设置前固缝、前双固缝、关闭之间循环选择,对应液晶屏图标点亮。选择对应的键可设置A、B段的针数。 The start tacking key is selected for each short press, the cyclical selection is between the front tacking, the front double tacking and the closing, and the corresponding LCD screen is lit. Select the corresponding key to set the number of needles of A and B.
3		后加固键 Back tacking	后固缝选择键,每短按动一次,在设置后固缝、后双固缝、关闭之间循环选择,对应液晶屏图标点亮。选择对应的键可设置C、D段的针数。 The back tacking key is selected for each short press, the

			cyclical selection is between the front tacking, the front double tacking and the closing, and the corresponding LCD screen is lit. Select the corresponding key to set the number of needles of C and D.
4		夹线键/自动触发键 Thread clamp/ Auto trigger key	短按此键，液晶屏夹线图标亮，夹线功能开启，再短按一次，夹线功能关闭；多段缝模式下长按此按钮，开启和关闭自动触发功能 Press this key for short time, icon become lit, so thread clamp is working now, press again, the turn this function Long press this key in multi-segment sewing mode to turn on and off the automatic trigger function
5		抬压脚键 Press foot lift key	1、短按此键，用于选择或取消剪线后抬压脚功能，选择时液晶屏幕下方会显示剪线后抬压脚状态标识； 2、长按此键，用于选择或取消中途抬压脚功能，选择时液晶屏幕下方会显示中途抬压脚状态标识； 3、P 键+抬压脚键两个按键同时按进入监控参数。 1、Press this key for short time, choose or cancel this function. If choose this function, then will show press foot lift after trimmer 2、Press this key for long time, choose or cancel this function, if choose, will show press foot lift on halfway 3、Press P+ Press foot lift key to enter monitor mode
6		自由缝键/ 剪线键	1、短按此键，液晶屏自由缝图标亮，选择自由缝模式； 2、长按此键，液晶屏剪线图标亮，自动剪线功能开启，再长按此键，自动剪线功能关闭。 1、Press for short time, icon become lit, choose free sewing function. 2、Press for long time, icon become lit, trimmer function turn on, press again, trimmer function turn off.
7		W 缝键/ 多段缝键	1、短按此键，液晶屏图标亮，表示当前是 W 缝模式。选择对应的键可设置 A、B、D 参数； 2、长按此键，液晶屏 图标亮，表示当前是多段缝模式。选择对应的键可设置多段缝总段数、每段针数。 1、Press this key for short time, icon is lit, so now is W sewing mode, choose the corresponding key to set A,B,C,D 2、Press the key for long time, icon is lit, means now is Several Segment Tacking mode, choose corresponding key to set all steps, and all stitches of each step.

8		锁针键/上下停针位键 Lock stitch key/Up and down needle position key	<p>1、短按此键，锁针功能依次切换为前锁针，后锁针，前后锁针，关闭锁针； 2、长按切换上/下停针位</p> <p>1、Press short time to this key, the lock stitch function will switch to front lock, rear lock, front and back lock, close; 2、Press long time to enter needle position function</p>
9		花样缝键/抬压脚开关键 Pattern sewing key/lifter function switch key	<p>1、短按此键进入花样缝模式，花样缝模式中短按此键，切换花样缝界面和花样缝设置界面 2、长按此按键切换抬压脚功能开关，对应图标亮灭，图标亮表示抬压脚功能开</p> <p>1、Short press this key to enter the pattern sewing mode, short press this key in this mode to switch between the pattern sewing interface and the pattern sewing setting interface 2、Long press this button to switch the presser foot lifting function switch, the corresponding icon is on and off, and the icon is on to indicate that the presser foot lifting function is on</p>
10		进入参数区功能键 Parameter mode Enter the parameter function	参数功能进入键 Enter the parameter function
11		参数加键（速度加） Up key(speed up)	在进入参数功能参数号/值加，初始待机下速度加 Enter this mode, adjust this key, increase speed
12		参数减键（速度减） Down key(speed down)	在进入参数功能参数号/值加，初始待机下速度减 Enter this mode, adjust this key, decrease speed
13		左移键 Key left	参数设定中，向左选择参数范围 Turn to left to choose parameter
14		右移键 Right selection	参数设定中，向右选择参数范围 Turn to right to choose parameter
15		恢复出厂设置 Reset key	长按 3S 后恢复出厂设置 Press 3 seconds, then back to factory setting

3 参数调节 Parameter adjustment

3.1 进入操作员参数模式及保存 Enter parameter mode and saving

空闲模式下，长按  键进入操作员参数模式。按  或  移动光标，相应位数值闪烁，再按  或  修改该位数值，按  键，保存参数。如果参数未修改，按  键退出参数模式；如果参数已经修改，第一次按键保存参数，第二次按  键退出参数模式。

Press , enter parameter mode, then press  or  to move the lit, corresponding number flashing, then press  or  to modify this value, press , save the parameter. If not modified, press  to log out parameter mode, if already modify, firstly save parameter, then press  to log out parameter mode.

3.2 进入技术员参数模式及保存 Enter technician parameter mode and save it

按住  键开机进入技术员参数模式。参数调节方式同操作员参数调节方式。

3.3 速度调节 Speed adjustment

在空闲模式下，按上键  下键  调速度。向上调快，向下调慢，每按一次调整数值 50，可以长按连续加减。

Press  and  to adjust the speed. For up, to adjust fast, for down, to adjust slow. each adjustment value is 50.

3.4 恢复出厂设置 Factory setting

长按  恢复出厂设置，作为恢复出厂设置的快捷方式。

Press the  for a long time, back to the factory setting.

3.5 进入监控模式 Enter monitoring system

在空闲模式下，按  +  键进入，按上下键调整监控参数项，按 P 键退出。（若为 24、25、26、28 项，长按 P 键保存当前监控值为对应参数，若保存成功，显示 OK，短按 P 键退出监控模式）

Press  +  to enter this mode, press up and down key to adjust this parameter, press P, then can log out.(if it is 24、25、26、28, then press P to save this monitoring value as the corresponding parameter, if save successfully, show OK, press P for short time to log out this mode.)

注：上停针位置设置：进入监控参数项 24，将手轮调整至上停针（参数会随着手轮位置而变化），长按  键保存参

数(保存后,下针位会自动进行相应调整),按  退出监控模式。

PS: Needle position setting, enter monitoring mode number 24, move the hand wheel to up needle position(the value will be changed with hand wheel position), press  for long time to save it(after save it, down needle position will be adjusted automatically), press  to log out this mode.

3.6 进入计针、计件快捷显示及修改 Enter the quick display and modify of needle counting and piece counting

在空闲模式下,按  +  键进入计针、计件快捷显示及修改界面,在该界面按  或  键切换计针、计件显示界面,可通过按  或  键直接修改针数或件数,按  +  键清除当前计针或计件数,短按  退出当前界面。

Press  +  to enter the quick display and modify of needle counting and piece counting, in this interface, you can press  or  key to switch the needle counting and pieces counting display interface, press  or  modify the counting directly. Press  +  to clear the current data, press  short to log out this interface.

3.7 进入针距补偿比例调节模式

在空闲模式下,长按  + 针距加键进入正缝参数修改界面,长按  + 针距减键进入倒缝参数修改界面。在参数修改界面短按  或  键切换修改的参数位,按  或  键修改针距补偿参数大小,修改后短按  保存针距补偿比例,面板显示 ok 表示参数设置成功,短按  键退出当前界面。

In idle mode, long press  + stitch length plus to enter the forward sewing parameter modification interface, and long press  + stitch length minus to enter the reverse stitch parameter modification interface. In the parameter modification interface, short press the  or  key to switch the modified parameter position, press the  or  key to modify the stitch length compensation parameter size, short press the  key to save the stitch length compensation ratio after modification, the panel displays ok to indicate that the parameter setting is successful, short press the  key to exit the current interface.

3.8 参数表

3.8.1 操作员参数(长按 P 键进入)

参数项 Parameter List	参数描述 Description	默认值 Default Value	参数范围 Parameter range	说明
P00	起缝速度(r/min) start sewing speed	200	100-800	
P01	自由缝最高转(r/min) Max speed of free sewing	2200	200-3000	
P02	多段缝速度 (r/min) Multi-segment sewing speed	2000	200-2200	
P03	上下停针选择 Needle position	1	0-1	0: 上停针 up 1: 下停针 down
P04	前固缝速(r/min) Start tacking speed	1200	200-1800	
P05	后固缝速(r/min)	1200	200-1800	

	Back tacking speed			
P06	W 缝速度(r/min) W sewing	1200	200-1800	
P07	慢速起缝速(r/min) Soft start sewing speed	400	100-2000	
P08	慢速起缝针数 Soft start sewing stitch	2	1-9	
P09	慢速起缝开关 Soft start sewing switch	1	0-1	0 关闭 1 开启 0:Off 1 On
P10	W 缝针迹补偿 1 (吸合) stitch compensation 1	2	1-10	
P11	W 缝针迹补偿 2 (释放) stitch compensation 1(release)	2	1-10	
P12	补半针延迟时间(ms) Delay time for half stitch	150	1-180	
P13	补一针延迟时间(ms) Delay time for one stitch	180	150-250	
P14	补针速度(r/min) Half stitch speed	200	100-500	
P15	按键补针模式 mode of half stitch	0	0-2	0: 按时间补针 Half stitch according to time to 1: 补半针 half stitch 2: 补一针 one stitch
p18	前固缝针迹补偿 1 Start back tack stitch compensation 1	2	1-10	
p19	前固缝针迹补偿 2 Start back tack stitch compensation 2	2	1-10	
P21	手动倒缝最高(r/min) max speed of manual reverse sewing 手动倒缝最高(r/min)	2200	200-2200	
P22	补针时倒缝关闭阀值 Value of backstitch during half stitch	8	0-9999	
P23	脚踏板控速曲线模式 curve mode of pedal 0: 直线 straight 1: 两段斜率 Slope 2: 曲线 curve (平方 square、开方 extraction of a root) 3: S 曲线 S curve	0	0-3	0: 直线 1: 两段斜率 2: 曲线 (平方、开方) 3: S 曲线
P24	踏板剪线位置 Pedal position of trimming	550	0-4095	
P25	后固缝针迹补偿 1 Stitch compensation of back tacking 1 (吸合 actuation)			
P26	后固缝针迹补偿 2 Stitch compensation of back tacking 1 (释放 release)			
P29	幂次控速曲线辅助参数 Power Control Curve Auxiliary Parameters	1	0-1	0: 平方 square 1: 开方 extract a root
P30	电机低速加力功能开关 switch for supplying power with low speed 0: 正常 normal 1: 电机加力 motor supplies more power 2: 电机加力+反拉控制 powerful motor + backwards to	0	0-2	0: 正常 1: 电机加力 2: 电机加力+反拉控制

	control			
P31	剪线加力系数 (电机加力) Trimming strength coefficient (motor force)	36	10-60	
P32	夹线电磁铁全出力时间 thread clamp magnet work time	40	1-200	
P33	夹线电磁铁每周期开通时间 thread clamp magnet dredging time	60	1-100	
P34	多段缝运动模式选择 Multi-segment sewing motion mode selection.	0	0-1	0:一键触发功能关 one key start function off 1:一键触发功能开 one key start function off
P35	夹线开关 Thread clamp switch	1	0-1	0 关闭 1 开启 0:Off 1 On
P37	夹线电磁铁每周期关闭时间 thread clamp magnet closing time	4	2-10	
P38	剪线开关 trimmer switch 0:关闭 off 1: 打开 on	1	0-1	0 关闭 1 开启 0:Off 1 On
P39	缝中抬压脚开关 press foot lifter in halfway	0	0-1	0 关闭 1 开启 0:Off 1 On
P40	剪线后抬压脚开关 switch of auto press foot lifter after trimming	0	0-1	0 关闭 1 开启 0:Off 1 On
P41	计针数计数单位 unit of counter	1	1-50	
P42	计针数总数设定 setting of total counter	9999	1-9999	
P43	计针数模式选择 counter mode	0	0-6	0: 关闭 off 1: 升序循环计数 Ascending cycle count. 2: 降序循环计数 Descending cycle count. 3: 升序计数, 计满报警并停止运行 Ascending accounting to full, alarm and stop running 4: 降序计数, 减为 0 报警并停止运行 Descending accounting to 0, alarm and stop running) 5:升序计数, 计满报警提示, 继续运行 (Ascending accounting to full, remind and keep running) 6: 降序计数, 减为 0 报警提示, 继续运行 (Descending accounting to 0, alarm and keep running) 注: 短按 P 取消报警 (note: press P shortly to cancel alarm)

3.9.2 技术员参数表 (按住 P 键再开机进入)

参数项	参数描述	默认值	参数范围	说明
P44	轻前踏抬压脚确认延迟时间 press the pedal forward lightly to confirm delayed time	0	0-300	0: 关闭 1-300: 根据延迟时间开启 0: off 1-300:start according to the delayed time
P47	剪线后反拉 after trimmer and pull back	360	200-360	

P49	剪线速度(r/min)trimmer speed	250	100-500	
P50	抬压脚电磁铁全出力时间 working time of electromagnet of press foot lifter(ms)	250	100-500	
P51	抬压脚电磁铁动作占空比 duty of presser	37	0-100	
P52	放压脚延迟时间(ms)delaying time of down presser foot lift	2	0-500	
P53	抬压脚功能选择 Switch of presser	0	0-1 0:Off 1:On	0 关闭 1 开启 0:Off 1 On
P54	背光亮度 Backlight brightness	100	0-100	
P56	上电自动找上针位 connect power and finding needle position automatically	1	0-1 0:Off 1:On	0 关闭 1 开启 0:Off 1 On
P57	抬压脚电磁铁保护时间(s) Protecting time of the electromagnet for press foot.			
P58	上停针调整角度 adjustment angle of up needle position	24	0-359	
P59	下停针调整角度 adjustment angle of down needle position	165	0-359	
P60	测试速度(r/min) testing speed	2200	200-2200	
P61	老化运行时间(s) Aging operation time	3	1-255	
P62	特殊运行模式 special running mode	0	0-3	0: 正常 1: 简易缝 2: 初始角测试 3: 自动测试模式 0: 正常 normal 1: 简易缝 easy sewing 2: 初始角测试 initial angle testing 3: 自动测试模式 automatic testing mode
P63	老化停止时间(s) aging stopping time	2	1-255	
P66	机头保护开关检测 protection switch of machine head testing	1	0-1 0:Off 1:On	0 关闭 1 开启 0:Off 1 On
P67	机头保护开关逻辑 protection switch of machine head	1	0-1	0: 正 forward 1: 反 backward
P70	踏板抬压脚位置设定 setting of press foot lift position of pedal	800	0-4095	
P71	起缝延迟时间 delay time of start sewing	260	0-900	
P72	踏板前踩运行开始位置(相对于回中位置) starting position of pressing the pedal forward	400	0-4095	
P73	踏板低速运行结束位置(相对于回中位置)end position at low speed	800	0-4095	
P74	踏板模拟量最大值 Max value of pedal analog	4000	0-4095	
P75	踏板回中位置设定 setting of pedal back to middle position	1650	0-4095	
P78	夹线开始角度 Thread clamp ending angle	182	10-359	

P79	夹线结束角度 Thread clamp end angle	280	0-359	
P80	剪线开始角度 trimming starting angle	7	0-359	
P81	剪线加力角度 trimming strength angle	100	0-359	
P82	剪线结束角度 Trimming ending angle	190	0-359	
P83	踏板抬压脚确认时间(ms) Pedal presser foot confirmation time.	150	1-500	
P84	安全开关报警确认时间(ms) The confirmation time of Safety switch alarm	300	1-500	
P85	安全开关报警恢复时间(ms) The recovery time of Safety switch alarm	50	1-200	
P86	两段斜率转折点速度(r/min) speed of two slopes at a turning point.	1500	0-4000	
P87	两段斜率中间模拟量 Two slope intermediate simulation	2700	0-4095	
P88	计件数计数单位 unit of counting	1	1-50	
P89	计件数总数设定 setting of total counting	9999	1-9999	
P90	计件数模式选择 counter mode	0	0-6	0: 关闭 off 1: 升序循环计数 Ascending cycle count. 2: 降序循环计数 Descending cycle count. 3: 升序计数, 计满报警并停止运行 (Ascending accounting to full, alarm and stop running) 4: 降序计数, 减为 0 报警并停止运行 (Descending accounting to 0, alarm and stop running) 5: 升序计数, 计满报警提示, 继续运行 (Ascending accounting to full, remind and keep running) 6: 降序计数, 减为 0 报警提示, 继续运行 (Descending accounting to 0, alarm and keep running) 注: 短按 P 取消报警 (note: press P shortly to cancel alarm)
P91	针数计数值 Stitch count value	0	0-9999	
P92	件数计数值 Piece count value	0	0-9999	
P93	语音开关 Voice switch	1	0-1	0 关闭 1 开启 0:Off 1 On
P94	开机语开关 Start language switch	1	0-1	0 关闭 1 开启 0:Off 1 On
P95	语音国家切换 Voice country switching	0	0-1	0: 第一国家语言 1: 第二国家语言 0:First century language 0:Second century language
P96	语音音量 Voice volume	20	0-31	

P97	主要部针距 Main part stitch length	60	0-50	
P98	密缝模式选择 Condense stitch mode selection	0	0-3	0-关闭 1-前加密 2-后加密 3-前后加密 0-Close 1-Front encryption 2-Back encryption 3-Front and back encryption
P99	针距锁 Stitch lock	0	0-1	0 关闭 1 开启 0:Off 1 On
P100	手动倒缝切换限速功能选择 Manual inverted seam switchin g speed limit function selection	0	0-1	0 关闭 1 开启 0:Off 1 On
P101	1/2 针距按键重定义选择 1/2 stitch length key mode change EN	0	0-1	0 关闭 1 开启 0:Off 1 On
P107	防断针功能选择开关 Safety needle break selection switch	1	0-1	0 关闭 1 开启 0:Off 1 On
P108	防断针开始机械角度 Safety needle break starting mechanical angle	20	0-359	
P109	防断针结束机械角度 Safety needle break finished mechanical angle	90	0-359	
P110	定针缝中途剪线后加固缝功能选择开关 fixed stitches trimmer in sewing and then bartack selection switch	0	0-1	0 关闭 1 开启 0:Off 1 On
P111	起缝压脚微抬功能选择开关 starting sewing presser foot lifter move-up selection switch	0	0-1	0 关闭 1 开启 0:Off 1 On
P112	起缝压脚微抬开始角度 starting sewing presser foot lifter move-up start angle	80	0-359	
P113	起缝压脚微抬结束角度 starting sewing presser foot lifter move-up finished angle	200	0-359	
P114	起缝抬压脚开持续时间限制 (ms) time limitation for starting sewing presser foot lifter open(ms)	60	0-1000	
P115	剪线上停针模式处理 Cut thread stop mode processing	0	0-1	0 关闭 1 开启 0:Off 1 On
P116	单固缝功能开关 Single seaming function switch	1	0-1	0 关闭 1 开启 0:Off 1 On
P117	物联网功能开关 IOT function switch	1	0-1	0 关闭 1 开启 0:Off 1 On
P122	无线通信信道设置 Wireless communication channel Settings	0	1-31	
P123	抬压脚全开通阶段占空比 Duty cycle of full opening phase of the presser foot	100	0-100	

P124	起始密缝针距 Starting condense stitch length	8	0 - 50	
P125	起始密缝方向 0-正缝 1-倒缝 Starting condense stitch direction	0	0-1	0- 正缝 1-倒缝 0- forward stitch 1- reverse stitch
P126	起始密缝速度 Starting condense stitch speed	1000	100 - 2500	0-正缝 1-倒缝 0- forward stitch 1- reverse stitch
P127	起始密缝针数 Starting condense stitch needle number	2	0 - 12	
P128	终止密缝针 Ending condense stitch needle	5	0 - 50	
P129	终止密缝速度 Ending condense stitch speed	1000	100 - 2500	
P130	终止密缝针数 Ending condense stitch needle number	2	0 - 12	
P131	终止密缝方向 Ending condense stitch needle number	0	0 - 1	0-正缝 1-倒缝 0- forward stitch 1- reverse stitch
P132	花样缝最高速 Pattern sewing max speed	1200	200~1200	0-正缝 1-倒缝 0- forward stitch 1- reverse stitch
P133	步进 Z 信号相对于 0mm 的偏移量 Step Z signal relative to 0mm offset	400	-999 ~999	
P136	正缝 1mm 针距基准值 Reference value of 1mm stitch length for stitching	88	0-1500	
P137	倒缝 1mm 针距基准值 Reference value of 1mm stitch length for reverse stitching	93	0-1500	
P138	正缝 2mm 针距基准值 Reference value of 2mm stitch length for stitching	183	0-1500	
P139	倒缝 2mm 针距基准值 Reference value of 2mm stitch length for reverse stitching	190	0-1500	
P140	正缝 3mm 针距基准值 Reference value of 3mm stitch length for stitching	260	0-1500	
P141	倒缝 3mm 针距基准值 Reference value of 3mm stitch length for reverse stitching	270	0-1500	
P142	正缝 4mm 针距基准值 Reference value of 4mm stitch length for stitching	340	0-1500	
P143	倒缝 4mm 针距基准值 Reference value of 4mm stitch length for reverse stitching	362	0-1500	
P144	正缝 5mm 针距基准值 Reference value of 5mm stitch length for stitching	422	0-1500	

P145	倒缝 5mm 针距基准值 Reference value of 5mm stitch length for reverse stitching	450	0-1500	
P146	正缝 6mm 针距基准值 Reference value of 6mm stitch length for stitching	500	0-1500	
P147	倒缝 6mm 针距基准值 Reference value of 6mm stitch length for reverse stitching	530	0-1500	
P148	正缝 7mm 针距基准值 Reference value of 7mm stitch length for stitching	574	0-1500	
P149	倒缝 7mm 针距基准值 Reference value of 7mm stitch length for reverse stitching	608	0-1500	
P150	正缝 8mm 针距基准值 Reference value of 8mm stitch length for stitching	650	0-1500	
P151	倒缝 8mm 针距基准值 Reference value of 8mm stitch length for reverse stitching	683	0-1500	
P152	正缝 9mm 针距基准值 Reference value of 9mm stitch length for stitching	725	0-1500	
P153	倒缝 9mm 针距基准值 Reference value of 9mm stitch length for reverse stitching	755	0-1500	
P154	正缝 10mm 针距基准值 Reference value of 10mm stitch length for stitching	805	0-1500	
P155	倒缝 10mm 针距基准值 Reference value of 10mm stitch length for reverse stitching	823	0-1500	
P160	速度补偿参考针距 Speed compensation reference stitch length	60	0-120	
p161	参考针距下正缝 800rpm 补偿值 800rpm compensation value for sewing under reference stitch length	5	0-300	
p162	参考针距下倒缝 800rpm 补偿值 800rpm compensation value for reverse sewing under reference stitch length	5	0-300	
p163	参考针距下正缝 1500rpm 补偿值 1500rpm compensation value for sewing under reference stitch length	25	0-300	
p164	参考针距下倒缝 1500rpm 补偿值 1500rpm compensation value for reverse sewing under reference stitch length	30	0-300	
p165	参考针距下正缝 2200rpm 补	45	0-300	

	偿值 2200rpm compensation value for sewing under reference stitch length			
p166	参考针距下倒缝 2200rpm 补 偿值 2200rpm compensation value for reverse sewing under reference stitch length	55	0-300	
P171	正缝针距补偿比例 Stitching needle length compensation ratio	1000	900-1100	
P172	倒缝针距补偿比例 Reverse stitching needle length compensation ratio	1000	900-1100	

3.9.3 监控参数表（开机后按 P 键+抬压脚键进入）

参数编号	参数描述	参数编号	参数描述
M10	针数计数值 stitches account number	M23	初始角度 Initial angle
M11	件数计数值 pieces account number	M24	机械角度 Mechanical angle
M13	操作面板软件版本号 panel version number	M25	踏板前踩模拟量最大值 Max value for pedal forward press
M18	控制器主板软件版本号 main board version number for control box	M26	踏板回中模拟量采样值 Sample value for pedal back
M20	母线电压 Generatrix Voltage	M28	踏板剪线模拟量采样值 Sample pedal value of trimming
M21	机头速度 Machine speed	M30-M37	历史故障代码 Historical Error number
M41	网络连接状态: 0: 正常连接, 信号图标显示; 1: 模块连不上网关, 信号图标闪烁(快闪); 2: 网关连不上服务器, 信号图标闪烁(慢闪); 3: 电控和模块断开, 信号图标不显示; Off: 物联网功能关闭, 信号图标不显示。		

4 错误代码

4.1 故障代码表

若系统出现报错或报警, 请首先检查如下项: 1 先确认机器的连接线是否连接完好; 2 确认电控和机头是否匹配; 3 确认恢复出厂是否准确。

故障代码	代码含义	解决措施
Err-01	主轴电机硬件过流 Arm shaft motor hardware overcurrent	1、关闭系统电源, 30 秒后重新接通电源。 1. Turn off the system power, and turn it on again after 30 seconds. 2、检查主轴电机编码器、电控是否有损坏等不良现象若有则及时更换。 2. Check whether the arm shaft motor encoder and electronic control are damaged or in other poor conditions. If so, replace them in time. 3、排除后重启系统若仍不能正常工作, 请联系当地服务商或拨打 4008876858 3. If the system still does not work properly after troubleshooting and restart. Please contact your local service provider or call 4008876858.
Err-03	系统欠压 System undervoltage	断开控制器电源, 检查输入电源电压是否低于 176V。若电源电压低于 176V, 请在电压恢复正常后重新启动控制器。若电压恢复正常后, 启动控制器仍不能正常工作。 Disconnect the power supply of the controller and check whether the input power supply voltage is lower than 176V. If so, please restart the controller after the voltage returns to normal. If the voltage returns to normal, it still does not work properly after the

		<p>controller starts up. 请联系当地服务商或拨打 4008876858。 Please contact your local service provider or call 4008876858.</p>
Err-04	停机时过压 Overvoltage during shutdown	<p>断开控制器电源，检查输入电源电压是否高于 264V。若电源电压高于 264V，请在电压恢复正常后重新启动控制器。若电压恢复正常后，启动控制器仍不能正常工作。请联系当地服务商或拨打 4008876858 Disconnect the controller power and check whether the input power voltage is higher than 264V. If so, please restart the controller after the voltage returns to normal. If the voltage returns to normal, it still does not work properly after the controller starts up. Please contact your local service provider or call 4008876858.</p>
Err-05	运行时过压 Overvoltage during operation	<p>断开控制器电源，检查输入电源电压是否高于 264V。若电源电压高于 264V，请在电压恢复正常后重新启动控制器。若电压恢复正常后，启动控制器仍不能正常工作。请联系当地服务商或拨打 4008876858 Disconnect the controller power and check whether the input power voltage is higher than 264V. If so, please restart the controller after the voltage returns to normal. If the voltage returns to normal, it still does not work properly after the controller starts up. Please contact your local service provider or call 4008876858.</p>
Err-06	电磁铁 回路故障 Electromagnet circuit failure	<ol style="list-style-type: none"> 关闭系统电源，检查电磁铁连线是否正确，是否有松动、破损等现象若有则及时更换 1. Turn off the system power, check whether the electromagnet connection is correct and whether there is any loose or damaged part. If so, replace it in time. 拔掉电控上电磁铁接口确认电控是否正常，如电控正常请排查各路电磁是否损坏。 2. Unplug the electromagnet plug on the electric control to confirm whether the electric control is normal. If the electric control is normal, please check whether the electromagnetic circuits are damaged. 排除后重启系统若仍不能工作，请联系当地服务商或拨打 4008876858 3. If the system still does not work after troubleshooting and restart. <p>Please contact your local service provider or call 4008876858.</p>
Err-07	主轴电机电流 检测 回路故障 Arm shaft motor current detection circuit failure	<p>关闭系统电源，30 秒后重新接通电源观察是否能正常工作。重试几次，若该故障频繁出现。请联系当地服务商或拨打 4008876858。 Turn off the system power, and turn on the power again after 30 seconds to see whether it can work properly. Try a few times again. If the fault occurs frequently, please contact your local service provider or call 4008876858.</p>
Err-08	主轴电机堵转 Arm shaft motor stalled	<ol style="list-style-type: none"> 请检查是否有异物缠绕在机头上，检查机器旋梭是否有线头卡死，机器偏心轮是否有卡死现象 1. Please check whether there is any foreign object wrapped around the machine head, whether there is any thread residue stuck in the rotating shuttle, and whether the eccentric wheel of the machine is stuck. 断开控制器电源，检查主轴电机电源输入插头是否脱落、松动、破损。 2. Disconnect the power supply of the controller and check whether the input plug of the arm shaft motor power supply is detached, loose, or damaged. 排除后重启系统仍不能正常工作。请联系当地服务商或拨打 4008876858。 3. If the system still does not work properly after troubleshooting and restart. Please contact your local service provider or call 4008876858.
Err-10	面板通讯故障 Panel communication failure	<ol style="list-style-type: none"> 请检查操作面板与电控的连线是否脱落、松动、断裂。 1. Please check whether the connection between the operation panel and the electric control is drops off, loose, or broken. 排除后重启系统若仍不能正常工作。请联系当地服务商或拨打 4008876858 2. If the system still does not work properly after troubleshooting and restart. Please contact your local service provider or call 4008876858.
Err-12	主轴电机初始	<ol style="list-style-type: none"> 请进入参数项里检查主轴电机初始角度。 1. Please enter parameter setting to check the initial angle of the arm shaft motor.

	角度检测故障 Arm shaft motor initial angle detection failure	2、请断电后再尝试 2-3 次，若仍报故障。请联系当地服务商或拨打 4008876858。 2. Please try 2-3 times again after power off. If it still fails. Please contact your local service provider or call 4008876858.
Err-13	主轴电机零位故障 Arm shaft motor zero position fault	1、关闭系统电源，检查主轴电机编码器接头是否松动或脱落，将其恢复正常后重启系统。 1. Turn off the power of the system, check whether the arm shaft motor encoder connector is loose, or drops off. Restore it to normal and restart the system. 2、更换主轴电机编码器。 2. Replace the arm shaft motor encoder. 3、排除后重启系统若仍不能正常工作请联系当地服务商或拨打 4008876858。 3. If the system still does not work properly after troubleshooting and restart, Please contact your local service provider or call 4008876858.
Err-14	主控 eeprom 元器件读写故障 Master control eeprom components read/write failure	关闭系统电源，30 秒后重新接通电源，控制器若仍不能正常工作，请联系当地服务商或拨打 4008876858 Turn off the system power, and then turn on the power again after 30 seconds. If the controller still does not work properly, please contact your local service provider or call 4008876858 关闭系统电源，30 秒后重新接通电源，控制器若仍不能正常工作，请联系当地服务商或拨打 4008876858 Turn off the system power, and then turn on the power again after 30 seconds. If the controller still does not work properly, please contact your local service provider or call 4008876858
Err-15	主轴电机超速保护 Arm shaft motor overspeed protection	Turn off the system power, and then turn on the power again after 30 seconds. If the controller still does not work properly, please contact your local service provider or call 4008876858
Err-16	主轴电机反转 Arm shaft motor reverse	
Err-17	面板参数读写故障 Pandel date read/write failure	
Err-18	主轴电机过载 Arm shaft motor overload	检查主轴电机是否堵转，若未堵转，请联系当地服务商或拨打 4008876858。 Check whether the arm shaft motor is stalled. If not, please contact your local service provider or call 4008876858.
Err-19	电机类型不匹配 Motor type mismatch	关闭系统电源，30 秒后重新接通电源，控制器若仍不能正常工作，请联系当地服务商或拨打 4008876858 Turn off the system power, and then turn on the power again after 30 seconds. If the controller still does not work properly, please contact your local service provider or call 4008876858
Err-20	调速器异常	1、请检查脚踏控速器连接线是否脱落、松动或脚踏控速器是否损坏。 1. Please check whether the connection cable of the pedal speed controller is drops off, loose, or damaged. 2、排除后重启系统仍不能正常工作。请联系当地服务商或拨打 4008876858。 2. If the system still does not work properly after troubleshooting and restart. Please contact your local service provider or call 4008876858.
Err-21	倒缝步进电机硬件过流 Backstitch step motor hardware overcurrent	1、关闭系统电源，30 秒后重新接通电源 1. Turn off the system power, and then turn on the power again after 30 seconds 2、检查机器倒缝步进电机、摆动座、牙齿是否卡死，恢复正常状态后，重启系统 2. Check whether the backstitch step motor, swing seat, and teeth are stuck. After returning to the normal state, restart the system.

		<p>3、排除后重启系统若仍不能正常工作。 3. If the system still does not work properly after troubleshooting and restart. 请联系当地服务商或拨打 4008876858 Please contact your local service provider or call 4008876858</p>
Err-22	倒缝步进电机 软件过流 Backstitch step motor software overcurrent	<p>、关闭系统电源，30 秒后重新接通电源 1. Turn off the system power, and then turn on the power again after 30 seconds 2、检查机器倒缝步进电机、摆动座、牙齿是否卡死，恢复正常状态后，重启系统 2. Check whether the backstitch step motor, swing seat, and teeth are stuck. After returning to the normal state, restart the system. 3、排除后重启系统若仍不能正常工作。请联系当地服务商或拨打 4008876858 3. If the system still does not work properly after troubleshooting and restart. Please contact your local service provider or call 4008876858</p>
Err-23	倒缝步进电机 电流检测回路 故障 Backstitch step motor current detection circuit failure	<p>关闭系统电源，30 秒后重新接通电源，控制器若仍不能正常工作，请联系当地服务商或拨打 4008876858。 Turn off the system power, and then turn on the power again after 30 seconds. If the controller still does not work properly, please contact your local service provider or call 4008876858.</p>
Err-24	倒缝步进电机 堵转 Backstitch step motor stalled	<p>1、关闭系统电源，30 秒后重新接通电源 1. Turn off the system power, and then turn on the power again after 30 seconds 2、检查机器倒缝步进电机、摆动座、牙齿是否卡死，恢复正常状态后，重启系统 2. Check whether the backstitch step motor, swing seat, and teeth are stuck. After returning to the normal state, restart the system. 3、检查倒缝步进编码器、电控是否有损坏等不良现象若有则及时更换 3. Check whether the backstitch step encoder and electronic control are damaged or in other poor conditions. If so, replace them in time. 4、排除后重启系统若仍不能正常工作。请联系当地服务商或拨打 4008876858 4. If the system still cannot work properly after troubleshooting and restart. Please contact your local service provider or call 4008876858</p>
Err-27	倒缝步进电机 通讯异常 Backstitch step motor controller communication failure	<p>关闭系统电源，30 秒后重新接通电源，控制器若仍不能正常工作，请联系当地服务商或拨打 4008876858。 Turn off the system power, and then turn on the power again after 30 seconds. If the controller still does not work properly, please contact your local service provider or call 4008876858.</p>
Err-28	倒缝步进电机 零位故障 Backstitch step motor zero position fault	<p>1、检查机器倒缝步进电机、摆动座、牙齿是否卡死，恢复正常状态后，重启系统 1. Check whether the backstitch step motor, swing seat, and teeth are stuck. After the normal state is restored, restart the system. 2、检查倒缝步进编码器是否有损坏等不良现象若有则及时更换 2. Check whether the backstitch step encoder is damaged or in other poor conditions. If so, replace it in time. 3、排除后重启系统若仍不能正常工作。请联系当地服务商或拨打 4008876858 3. If the system still does not work properly after troubleshooting and restart. Please contact your local service provider or call 4008876858</p>

4.2 安全报警表

报警代码	代码含义	解决措施
A-UP	翻抬开关报警 alarm of safety switch	摆正机头,确保翻抬开关复原 return machine head to normal position, to make sure safety switch rebound

ALR-1	机头按钮短路报警 Alarm of machine head button with short circuit	关闭系统电源, 更换机头灯按钮 turn off system power and change the light button of machine head
ALR-2	计针数计满报警 Alarm when needle counting is fulled	短按 P 键取消报警 press P key with short time, alarm will stop
ALR-3	计件数计满报警 Alarm when needle counting is fulled	短按 P 键取消报警 press P key with short time, alarm will stop

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