C5C

C5C 包缝机面板操作说明书 V0.4

Instructions of C5C overlock sewing machine panel operation

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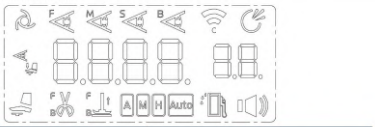
1. 显示及操作界面 Display and operation menu

1.1 显示界面介绍 Operation Panel Instructions

序号 No.	图标 Icon	说明 Description	备注 Remark
1	P	用户参数设置键 Customer parameter settings	
2		左移键 Left button	1、参数内容区内，向左选择参数项 Towards the left to chooseparameter
3		上移键 Up button	1、向上调速键 Increase speed button 2、参数内容区内，设定数值递增键 Increase the number within a parameter
4		下移键 Down button	1、向下调速键 Decrease speed button 2、参数内容区内，设定数值递减键 Decrease the number within a parameter
5		右移键 Right button	1、机头灯亮度调节 Control machine head LCD light brightness 2、参数内容区内，向右选择参数项 Towards the right to choose parameter within a parameter
6		缝纫模式键 Sewing mode button	更改缝纫模式 Change thesewing mode
7		抬压脚功能键 Presser foot lifter function button	更改抬压脚高度 Change presser foot lifter height
8		剪线参数设置键 Trimmer parameter setting button	剪线模式调节 Trimmer mode adjustment
9		复位键 Reset button	长按 2S 恢复出厂设置 Long press for 2 seconds restoring factory setting
10		前剪线加键 the forward cutting line plus button	前剪线长度参数值增加 The parameter value of the front cutting line length increases
11		前剪线减键 the forward cutting line minus button	前剪线长度参数值减少 The parameter value of the front cutting line length has decreased
12		后剪线加键 the post-cut wire plus button	后剪线长度参数值增加 The parameter value of the post-cutting line length increases
13		后剪线减键 the post-cut wire minus button	后剪线长度参数值减少 The parameter value of the post-cutting line length decreases
14		感应器键 Sensor button	短按切换面料，长按感应器自动校准 Press briefly to switch the fabric, and press long for the sensor to calibrate automatically

1.2 液晶图标介绍 LCD icon introduction



序号 No.	图标 Icon	说明 Description	备注 Remark
1		全智能模式图标 Full smart mode icon	指示当前缝纫模式 Indicates the current sewing mode
2		半智能模式图标 Semi-smart mode icon	
3		全电脑模式图标 Full computer mode icon	
4		前感应器图标 Front sensor icon	
5		后感应器图标 Rear sensor icon	指示当前感应器状态，图标点亮表示感应器被遮挡，未点亮表示传感器未遮挡 Indicates the current sensor status, the Icon lights up to indicate that the sensor is blocked, and the unlit state Indicates that the sensor is not blocked
6		短线头感应器图标（预留）Short thread sensor icon（Reserved）	
7		防切布感应器图标 Anti-cut cloth sensor icon	
8		抬压脚图标 Lifter icon	图标和字母 F 点亮表示前自动抬压脚功能开启 The icon lights up and F lights up to indicate that the front automatic presser foot function is turned on 图标和字母 B 点亮表示后自动抬压脚功能开启 The icon lights up and B lights up to indicate the back automatic presser foot function is turned on
9		剪线图标 Trimming line icon	图标，与字母 F 点亮表示前自动前剪线功能开启 The icon lights up and the F lights up to indicate that the front automatic thread trimming function is turned on 图标表示与字母 B 点亮表示后自动剪线功能开启 The icon lights up and the B lights up to indicate the back automatic thread trimming function is turned on
10		吸风图标（预留）Suction icon（Reserved）	图标点亮表示吸风功能开启 The icon lights up to indicate that the suction function is on
11		语音图标（预留）Speech icon（Reserved）	图标点亮表示语音开启 Lights up to indicate voice on
12		油量图标（预留）Oil quantity icon（Reserved）	图标点亮并闪烁表示当前无油，需添加白油 The icon lights up and flashes to ind cate that there is no oil at present. White oil needs to be added
13		WiFi 联网图标（选配）WiFi networking icon（Optional）	图标常亮表示联网正常，图标闪烁表示网络断开，不显示表示未联网 The icon is always on, indicating that the network is normal, the icon blinking indicates that the network is disconnected, and the non-display indicates that the network is not
14		牙齿档位图标（预留） Tooth grade icon（Reserved）	预留 Reserve
15		第五、第六数码管 The fifth and sixth nixie tube	显示抬压脚电机相关参数或者感应器电压值 Display the relevant parameter of the lifting motor or the voltage value of the sensor

1.3 按键设置介绍 Button setting Instructions

长按P键（P）约1.5秒，将进入用户参数调整模式，通过左移键（◀）和右移键（▶）修改参数项，按上移键（Speed ▲）和下移键（Speed ▼）修改相应参数的值，按P键（P）确认并保存，按左移键（◀）或右移键（▶）不保存并退到参数项设置界面，再次按P键（P）退到待机界面。

Long press （P） for 1.5 seconds and machine will enter the user parameter adjustment mode. Press left button （◀） and right button （▶） to modify the parameter. Press up button （Speed ▲） and down button （Speed ▼） to modify the value of the corresponding parameter. Press enter button （P） to confirm and save, press left button （◀） or right button （▶） if user doesn't want to save and will return to the parameter setting interface. Press （P） again will return to standby interface.

2. 常用参数设置 Common parameters setting

2.1 全智能/半智能/全电脑模式设置 Automatic/Semi-automatic/Full manual mode settings

按下缝纫模式选择键（M），时，即可修改缝纫模式，连续按下此键时，缝纫模式按以下三种模式循环：全智能、半智能、全电脑。设置完后按P键（P），进行确认保存，10S无按键则不保存退到待机界面。

Press sewing mode button （M） ,sewing mode can be modified. Continuous press down this button, sewing mode will be cycled as following three modes: Automatic/ Semi-automatic/ Full manual. Press enter node （P） to confirm and save after finishing setting, no pressing for 10 seconds return to standby interface if user doesn't want to save.

2.2 抬压脚高度设置 Presser foot lifter height setting

按下抬压脚模式调整键（F），时， 直接调节 U33 抬压脚高度参数值，可通过上键（Speed ▲）或者下键（Speed ▼）进行该参数值的调节，在抬压脚高度调节的界面第五、第六数码管显示抬压脚高度，单位为毫米。设置完后按 P 键（P）进行确认保存，10S 无按键则不保存退到待机界面。

Press presser foot function button （F） , Directly adjust foot height parameter value of the U33, the current parameter enter the adjustment of the parameter value through the upper （Speed ▲） or lower （Speed ▼） button. When adjusting the lifting height, the fifth and sixth digital tubes show the height of the foot and feet in millimeters. Press enter button （P） to save and confirm after finishing setting, no pressing for 10 seconds return to standby interface if user doesn't want to save.

2.3 剪线参数设置 Trimmer parameter setting

按下剪线参数设置键（✂），P94 = 8时，按此键进入修改P46连续送布吸气调节参数；当P94 = 6或7时，按此键时进入修改P07剪线模式调节参数；按上移键（Speed ▲）和下移键（Speed ▼）修改相应参数的值，设置完后按P键（P）进行确认保存，10S无按键则不保存退到待机界面。

Press trimmer parameter setting button （✂） , When P94 = 8, press this button to enter and modify the continuous feeding and suction adjustment parameters of P46; When P94 = 6 or 7, pressing this button will enter the parameter adjustment mode of modifying P07. Press up button （Speed ▲） and down button （Speed ▼） to modify the value of the corresponding parameter, After finishing settings, press enter button （P） to save the parameter. If customer doesn't want to save, no pressing for 5 seconds back to standby interface if user doesn't want to save.

2.4 转速的修改 Modify speed

在待机界面按上移键（Speed ▲）和下移键（Speed ▼）可以快速调整最高转速值，按上移键（Speed ▲）递增 100 RPM，按下移键（Speed ▼）递减 100 RPM。设置完按 P 键（P）进行确认保存，10S 无按键则不保存退到待机界面。

Press the up button （Speed ▲） and down button （Speed ▼） in standby interface can rapidly adjust the highest speed value. Press up button （Speed ▲） increases 100 RPM while press down button （Speed ▼） decreases 100 RPM. After finishing settings, press enter button （P） to save the parameter. If customer doesn't want to save, no pressing for 10 seconds back to standby interface if user doesn't want to save.

2.5 技术区参数的修改 Change technician parameter

按组合键P键（P）+ 抬压脚键（⤓）约1.5秒，将进入技术员参数调整模式，显示P26，通过左移键（◀）和右移键（▶）修改参数项，按上移键（Speed ▲）和下移键（Speed ▼）修改相应参数的值. 设置完按P键（P）进行确认保存，10S无按键则不保存退到待机界面。

Press button （P） and enter button （⤓） together for 1.5 seconds，the machine will enter the technician parameter adjustment mode and the panel will display P26.Press left button （◀） and right button （▶） to change the parameter. Press up button （Speed ▲） and down button （Speed ▼） to modify the value of corresponding parameter. Press enter button （P） to confirm and save, no pressing for 10 seconds back to standby interface if user doesn't want to save.

2.6 工艺区参数的修改 Change sewing process parameter

按组合键P键（P）+下移键（Speed ▼）约1.5秒，将进入工艺区参数调整模式，显示U1，通过左移键（◀）和右移键（▶）修改参数项，按上移键（Speed ▲）和下移键（Speed ▼）修改相应参数的值，设置完按P键（P）进行确认保存，10S无按键则不保存退到待机界面。

Press button （P） and enter button （Speed ▼） together for 1.5 seconds，the machine will enter the sewing process parameter adjustment mode and the panel will display U1.Press left button （◀） and right button （▶） to change the parameter. Press up button （Speed ▲） and down button （Speed ▼） to modify the value of corresponding parameter. Press enter button （P） to confirm and save, no pressing for 10 seconds back to standby interface if user doesn't want to save.

2.7 恢复出厂设置 Restore factory setting

按复位键（R）约2秒参数将恢复用户保存参数，参数范围为用户参数与技术员参数。按左移键（◀）和右移键（▶）约2秒，恢复出厂参数，恢复关联参数。（P21 = 1时按P键保存一组用户常用参数，复位键恢复用户保存参数，未保存前出厂参数与用户保存区参数相同。P66/P67/P68转换板感应器强度参数、P73出厂默认补速参数、P90监控查看使能参数、P94/P95机型选择参数、P103强制电动抬压脚使能等不恢复出厂设置）。

Press reset button （R） for 2 seconds ,parameters will restore users saving parameters. Parameters range from uses parameter to technician parameter. Press left button （◀） and right button （▶） together for 2 seconds, parameter will restore factory parameters and associated parameters. When P21=1, P button for saving users commor parameters, reset button for restoring users saving parameters, before saving, factory parameters are the same as users saving parameters. P66/P67/P68 adapter board duty cycle parameter, P73 factory default speed parameter, P90 monitor view enable parameter, P94/P95 model selection parameter, etc. are not restored to factory settings).

2.8 穿线灯开关的设置 LED light setting

穿线灯亮度分为六档，在待机显示界面，按右移键（▶），穿线灯光亮度在6个档位间循环调节。（其中一个档位为关闭）

LED light is divided into six gears, on the standby interface ,press right button （▶） , LCD light brightness will be cycled in six modes.(one is off)

2.9 按键锁定设置 Button lock setting

更改参数项P62为1时，锁定按键后，按键动作无响应。长按剪线参数设置键（✂）约1.5秒解除锁定，按键恢复使用。

When modifying parameter P62 to 1, button will be locked and no response. Long Press trimmer parameter （✂） for 1.5 seconds will cancel the lock setting, press restore used.

2.10 面料选择 Fabric selection

待机界面下，短按感应器键（◀）进入面料选择设置，并显示当前布料类型（常规布料显示为 b0，大网孔布料显示为 S，网纱布料显示为 A），短按感应器键（◀）进行 b0、S、A 切换，短按 P 键（P）进行保存，此时会重新自动校准感应器电压值，显示 OK 表示选择成功。

In the standby interface, press and hold the Sensor button（◀） to enter the fabri: selection setting, and display the current fabric type (the normal fabric is displayed as b0, the big net hole fabric is displayed as S ,the mesh fabric is displayed as A), short press the Sensor button （◀） to switch between b0 / S /A, short press the P button（P） save it, the sensor voltage value will be automatically calibrated again, and OK will be displayed.

退出方式：1，切换成功/失败后自动退出;2、10s 内无按键操作自动退回待机界面

Exit mode: 1. Automatically exit after successful/failed switch over;2, no button operation within 10s, automatically return to the standby interface

2.11 感应器自动校准 Sensor automatic calibration

长按感应器键（◀）约 1.5 秒保开始感应器自动校准，校准结束后显示 OK 表说明识别成功，否则识别失败。

Press and hold sensor button （◀） for about 1.5 seconds to start the sensor automatic calibration. When the calibration is finished, the OK is displayed, indicating that the recognition is successful, otherwise the recognition fails.

2.12 前剪线参数调节 Adjustment of the front cutting line parameters

按下前剪线参数设置键（✂），P94 = 8 时，按此键进入修改 P30 前剪线吸风关闭针数参数；当 P94 = 6 或 7 时，按此键时进入修改 P27 前剪线延迟针数参数； 按前剪线加键（Speed ▲）和前剪线减键（Speed ▼）修改相应参数的值， ，设置完后按 P 键（P）进行确认保存 ，10S 无按键则不保存退到待机界面。

Press the front thread cutting parameter setting button （✂）, When P94 = 8, press this button to enter the modification of the P30 front thread cutting suction close needle number parameter. When P94 = 6 or 7, pressing this button will enter the parameter for modifying the delay stitch count before P27. Press the forward cutting line plus button （Speed ▲） and the forward cutting line minus button （Speed ▼） to modify the values of the corresponding parameters. After setting, press the P button （P） to confirm and save. If there is no button for 10 seconds, it will not be saved and will return to the standby interface.

2.13 后剪线参数调节 Adjustment of post-cutting wire parameters

按后下剪线参数设置键（✂），P94 = 8 时，按此键进入修改 P31 后剪线吸风关闭针数参数；当 P94 = 6 或 7、P32=0 时，按此键时进入修改 P28 后剪线延迟针数参数；当 P94 = 6 或 7、P32=1 时，按此键时进入修改 P50 后切布感应器延迟针数参数； 按后剪线加键（Speed ▲）和后剪线减键（Speed ▼）修改相应参数的值 ，设置完后按 P 键（P）进行确认保存 ，10S 无按键则不保存退到待机界面。

Press the post-cut thread parameter setting button （✂）. When P94 = 8, press this button to enter the parameter for closing the number of needles after modifying P31 for thread cutting and suction. When P94 = 6 or 7,P32 = 0;pressing this button will enter the parameter of the number of stitches for the delay of thread cutting after modifying ?28. When P94 = 6 or 7,P32 = 1;pressing this button will enter the parameter of the number of stitches for the delay stitches number of trimmer after sewing P50;Press the post-cut wire plus button （Speed ▲） and the post-cut wire minus button （Speed ▼） to modify the values of the corresponding parameters. After setting, press the P button （P） to confirm and save. If there is no button for 10 seconds, it will not be saved and will return to the standby interface.

2.14 定期保养 Regular maintenance

当机器使用时间到达定期保养提醒时间后，面板会显示 A09/A10 ， 10min 后不再显示 A09/A10 直到下一个提醒时间到。可通过修改 P100/P101 的参数值设定提醒时间或关闭该提醒功能。

注：定期保养提醒过程中可正常缝纫。

When the machine use time arrives at the regular maintenance reminder time, the panel will display A09/A10,10 minutes later again no longer display A09/A10 until the next reminder time arrives. The alarm time can be set or the alarm function can be turned off by modifying the parameter values of P100/P101.

note: normal sewing can be done during regular maintenance reminder.

2.15 物联网序列号设置和查看 Internet of Things serial number setting and viewing

短按 P 键（P），+上移键（Speed ▲）进入研发参数密码输入界面，输入密码后按 P 键确认，进入研发参数界面，通过右键（▶）选择参数项 P116，通过上移键（Speed ▲）或下移键（Speed ▼）将参数值改为 1，短按 P 键保存，面板进入物联网序列号设置/查看界面，此时通过上移键（Speed ▲）或下移键（Speed ▼）可设置闪烁位的数值 通过左键（◀）或右键（▶）可选择需要设置的位，序列号长度为 11 位，设置完成后，可通过短按 P 键（P）+剪丝键（✂）保存，如需放弃修改，短按 P 键直接退出。

Short press P button （P）, + up button （Speed ▲） to enter the R&D parameter password input interface, press P button to confirm, enter the R&D parameter interface, select parameter item P116 by right button （▶）, move up （Speed ▲） or move down. The button （Speed ▼） changes the parameter value to 1, short press the P button to save, the panel enters the IOT serial number setting/view interface. At this time, the value of the flashing bit can be set by the up button （Speed ▲） or down button （Speed ▼）. The button （◀） or right button （▶） can select the bit to be set. The serial number length is 11 digits. After the setting is completed, you can save it by pressing the P button （P）, + trimming button （✂）. If you need to give up the modification, short press the P button. Exit directly.

2.16 断网报错查看 Broken network error report

当面板与物联网采集模块断开 1min 后，面板报错 A13。当采集模块与网关器断开，面板报错 A11，当网关器与服务器断开，面板报错 A12，此三个报错号不显示，可通过 M15 查看 。

When the panel is disconnected from the IOT collector for 1 min, the panel reports A13. When the collector is disconnected from the gateway, the panel reports A11. When the gateway is disconnected from the server, the panel reports an error A12. The three error numbers are not displayed. View through M15.

2.17 快速绑定设备 Fast binding device

当需要将设备快速绑定到服务器上时，确认好物联网序列号并添加后，面板上操作上移键（Speed ▲）+抬压脚键（⤓），面板显示 OK，表示设定成功。此时设备可快速绑定到服务器上。

When you need to quickly bind the device to the server, after confirming the IOT serial number and adding it, operate the up button （Speed ▲）+ presser foot button （⤓） on the panel, and the panel displays OK, indicating that the setting is successful. The device can now be quickly bound to the server.

3. 数码管显示说明 Digital tube display instructions

(1) 数字部分：Digital part

实际数值 Actual numerical value	0	1	2	3	4	5	6	7	8	9
数码管显示 Digital tube display	0	1	2	3	4	5	6	7	8	9

(2) 英文字母部分：English letter part:

英文字母 English alphabet	A	B	C	D	E	F	G	H	I	J
数码管显示 Digital tube display	A	b	C	d	E	F	G	H	I	J
英文字母 English alphabet	K	L	M	N	O	P	Q	R	S	T
数码管显示 Digital tube display	K	L	M	n	o	P	q	r	S	T
英文字母 English alphabet	U	V	W	X	Y	Z				
数码管显示 Digital tube display	U	V	W	H	Y	Z				

4. 参数列表 Parameters list

4.1. 操作参数说明表 Operating parameters Instructions

序号 No.	功能参数 Function parameter	范围 Range	默认值 Default	参数说明 Description
	用户区，按住"P"键 1.5 秒进入 User parameters：Press P button for 1.5seconds to enter			
P1	最高转速 Max rotate speed	P120 - 7000	6000	RPM
P2	停针定位选择Needle stop positioning selection	0 - 5	1	0：不定位 No needle position 1：上针位 Up needle position 2：下针位 Down needle position 3：下针位 Down needle position(rear tread will not to find up needle position) 4：下针位(缝台上有无布后踩都可找上针位)：Down needle position(You can find a needle on the sewing table even if you step on it with or without fabric) 5：下针位（停车时缝台上无布自动回到上针位）：Down needle position(When parsing, if there is no fabric on the sewing table, it will automatically return to the upper needle position)
P3	起缝速度 Start sewing speed	500 - 7000	S700(抓刀 Chopper) 4000(脚吸 Side suction)	RPM
P4	启动模式 Start up mode	0 - 1	0	0：启动模式 Automatic mode　1：脚控模式 Foot control
P5	模式选择 Sewing mode selection	0 - 2	1	0：全电脑 Manual 1：半智能 Semi-automatic 2：全智能 Full automatic
P7	剪线模式调节 Trimming mode	0 - 3	3	0：关闭 Off

	adjustment		1：前剪 Trimmer before sewing 2：后剪 Trimmer after sewing 3：前后剪 Trimmer both before and after sewing
P8	自动后吸气 Automatic inhalation	0 - 3	1（吸刀 Chopper） 3（侧吸 Side draught）	0：关闭 Off 1：前剪线吸气开Suction when trimmer before sewing 2：后剪线吸气开Suction when trimmer after sewing 3：前后剪线吸气开Suction when trimmer before and after sewing
P9	反踏剪线开关 Counter pedal trimmer	0 - 1	1	0：关闭 Off　1：开启 On
P10	抬压脚模式调节 Presser foot mode adjustment	0 - 3	0	0：关闭 Off 1：前抬 Lifter befre sewing 2：后抬 Lifter after sewing 3：前后抬 Lifter both before and after sewing
P11	车缝中途停止时抬压脚 Press foot lifter when sewing stops	0 - 1	0	0：关闭 Off 1：抬压脚 Presser foot lifter
P12	剪完线停止时抬压脚 Press foot lifter after trimming	0 - 1	0	0：关闭 Off 1：抬压脚 Presser foot lifter
P13	半反踏抬压脚 Semi - counter presser foot lifter	0 - 1	1	0：关闭 Off 1：半反踏或反踏抬压脚 Semi-counter presser foot lifter
P14	手动吸气 Manual suction switch	0 - 2	2	0：关闭 Off 1：后吸 Rear sucton 2：前后吸 Front sution and rear suction
P15	机头灯开关 Head lamp switch	0 - 5	1	0：关闭 Off　1~5：开启 On
P16	休眠功能开关 Dormancy fuction	0 - 1	1	0：关闭 Off　1：开启 On
P17	半智能连续缝制 Semi - automatic constant rate trimming	0 - 2	2	0：关闭 Off 1：前踏可连续缝制 Front step continuous sewing 2：连续缝制，踏板前感应器使能开关 Constant sewing and ignore the front sensor switch
P18	半智能恒速前缝机 Semi - automatic constant rate trimming	0 - 1	1	0：关闭 Off 1：踩底前预线锁定打速度 Fix the machine speed when front thread trimmer
P21	用户常用参数 User common parameters	0 - 1	0	0：无操作 No operation 1：保存参数为用户常用参数 Saving parameters into user common parameters
P22	前感应器开关 Front sensor switch	0 - 1	1	0：关闭 Off　1：开启 On
P23	前吸风打开时间 Opening time of manual suction	1 - 250	5	前吸风关闭时间 *100 ms》Opening time of manual suction
P24	吸风关闭时间 Turn off time of suction	0 - 250	5	前吸风关闭时间 *100 ms》0 表示无关闭 Time when front suction off。0 means no shutdown
P25	后感应器开关 Back sensor switch	0 - 1	1	0：关闭 Off　1：开启 On

技术员区，同时按住"P"键和"抬压脚"键进入 Technician parameter，Press P button and presser foot button at the same time to enter

P26	前后感应器间针数 The stitch number between front sensor and back sensor	0 - 250	0（P05=0,1） 100（P05=2）
P27	前剪线足距针数The delay stitches number of trimmer before sewing	30-50	48
P28	后剪线足距针数 Delay stitches number of anti - cutting the cloth	0 - 30	8
P29	前剪线吸风开启针数 Front trimming suction open thread number	1 - 50	1
P30	前剪线吸风关闭针数 Front trimming suction close thread number	0 - 250	0（吸刀 Chopper） 5（侧吸 Side draught）
P31	后剪线吸风关闭延时 Delay time after back suction off	1 - 50	15（吸刀 Chopper） 30（侧吸 Side draught）
P32	防导布感应器开关 Sensor for anti - cutting the cloth switch	0 - 1	1（吸刀 Chopper）	0：关闭 Off 1：开启 On

			0（侧吸 Side draught）
P33	防切布感应器灵敏度Sensitivity of sensor for anti - cutting the cloth	200 - 400	330	灵敏度参数越大，越能识别半透明材料 The bigger of the sensitivity parameter, the more capable to identify translucent materials
P34	后感应器与防切布感应器间针数 Stitch number between back sensor and sensor for anti-cutting the cloth	0 - 200	0 (P05=0,1） 99 (P05=2）	
P35	停车延迟针数 Delay stitch number when stop sewing	0 - 99	0（吸刀 Chopper） 30（侧吸 Side draught）	
P36	后剪线吸风开启针数 Back trimming suction open thread number	1 - 50	3	
P37	前感应器灵敏度 Sensitivity of front sensor	200 - 400	330	灵敏度参数越大，越能识别半透明材料 The bigger of the sensitivity parameter, the more capable to identify translucent materials
P38	后感应器灵敏度 Sensitivity of back sensor	200 - 400	330	灵敏度参数越大，越能识别半透明材料 The bigger of the sensitivity parameter, the more capable to identify translucent materials
P39	前抬压脚保持时间 Delay time before presser foot fitter	1 - 50	2	（*100ms）
P40	后抬压脚启动时间 Start time after presser foot lifter	0 - 20	0	（*100 ms）
P41	压脚全出力时间	1-50	10	（*10 ms）
P42	压脚出力阀输出号Pressure foot output cycle signal	0-50	15	
P43	压脚下放时间 Time of presser foot put down	1 - 99	10	（*10 ms）
P44	压脚保护时间 Time of presser foot protection	1 - 20	5	
P45	剪线时间 Time of trimmer	1 - 100	11	
P46	连续送布吸气 Continuous feeding and suction	0 - 3	2	0：关闭吸屑 Closed suction crumbs 1：连续吸屑 Continuous suction crumbs 2：吸剪与前线吸气同步 Suction crumbs and trimming suction in sync 3：间歇吸气 Intermittent crumbs
P47	手动剪线动作开关 Manual trimmer switch	0 - 2	1	0：关闭 Off 1：开启 On 2：遮前感应器不能手动剪线 On
P48	开机自动找上针位 Automatically find up positioning	0 - 2	0	0：关闭 Off 1：开启 On 2：无论是否在上针位都找上针位 On
P49	压脚周期关闭时间Pressure foot cycle closing time	0-50	35	
P50	防切布感应器延迟针数 The delay stitches number of trimmer after sewing	0-50	0	
P51	点针参数 Point needle parameter	0 - 511	87（P122=1） 42（P122=0）	大于 P111，小于 *121-P123-25
P52	测试速度 Speed testing	500 - 7000	5500	RPM
P53	测试工作时间 Work time testing	1 - 60	3	S
P54	测试停止时间 Stop time testing	1 - 60	3	S
P55	A 项测试 Testing parameter A	0 - 3	0	0：关闭 Off 1：开启 On 2：休眠 Dormancy 3：只老化主轴和剪线 Only aging spindle and trimming
P56	B 项测试 Testing parameter B	0 - 1	0	0：关闭 Off 1：开启 On （老化前压脚和剪线）Aging presser foot and trimming
P57	压脚保护开关 Presser foot safety switch	0 - 1	1	0：关闭 Off 1：开启 On
P58	缝合保护开关 Sewing plate safety switch	0 - 1	1	0：关闭 Off 1：开启 On
P61	休眠时间 Sleeping time	1 - 250	30	分钟

P62	面板按键锁定 Panel button lock	0 - 1	0	Unit: minutes 0：不锁定 Unlock 1：锁定 Lock (面板锁定后长按剪线键解除锁定)After the panel is locked, press and hold the trimming button to unlock it.
P63	降 速 开 关 Slow down speed button	0 - 1	0	
P64	降速针数 Stitch number of slow down speed	1- 200	1	
P65	降速速度 The speed of slowing down	500 - 7000	3500	RPM
P66	前感应器电压值调节 Front sensor voltage value adjustment	1 - 180	80—	参数值越大，感应器电压值越大 The greater the parameter values, The greater the voltage value of the sensor
P67	后感应器电压值调节 Back sensor voltage value adjustment	1 - 180	150—	参数值越大，感应器电压值越大 The greater the parameter values, The greater the voltage value of the sensor
P68	防切布感应器电压值调节 Anti fabric cutting sensor voltage value adjustment	1 - 180	40—	参数值越大，感应器电压值越大 The greater the parameter values, The greater the voltage value of the sensor
P69	计件数计数单位 Unit number counting	1 - 50	10	执行设置剪线次数，计件数加 1 Execute the number of trimmings, the number of pieces is increased by one.
P70	计件数总数设定 Total counting setting	1-9999	100	
P71	计件数计数模式 Counting mode	0 - 5	0	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：升序计满报警 Ascending full alarm 4：降序计满报警 Descending full alarm 5：清除计满报警 Remove full alarm
P72	强制后剪线延迟针数 The stitches number of constrain back trimmer	0 - 20	9	布料前剪线上面产生，后感应器且未建往防切布感应器经过设定针数后执行后剪线。Adjust the back trimmer function even the fabric does not cover the anti-cutting sensor, can adjust the stitches number before the trimmer function active
P73	出厂默认转速参数 Factory default speed parameters	0-5	0	0：跨线机型默认转速 P01=6000 P03 =5500 1：五线机型默认转速 P01=5000 P03 =5000 2：厚料机型默认转速 P01=5300 P03 =5000 3：2 机机型默认转速 P01=6000 P03 =5500 4：针织机型默认转速 P01=5500 P03 =5500 5：二线机型默认转速 P01=6000 P03 =5700
P74	后剪线前切布参数 Rear cutting thread anti cutting fabric parameters	0-1	0	

系统员参数 System member parameters

P75	转接板报错使能 Adapter board error enable	0 - 2	1	0：关闭：Off 1：打开转接板检测功能：Open the adapter board detection function 2：打开检测功能 (屏蔽抬压脚报警)：Open detection function(Alarm for the shield presser foot lift)
P76	背光亮度调节参数 Backlight brightness adjustment parameter	1 - 3	3	
P77	内部频速 Internal speed limit	500-7000	6000	RPM
P78	显示模式 Display mode	0 - 4	0	0：正常缝纫的模式和转向 Normal sewing mode and steering 1：实时显示当前速度 Real-time display of current speed 2：前感应器感应电压值 Front sensor induced voltage value 3：后感应器感应电压值 Post sensor induced voltage value 4：防切布感应器感应电压值 The third sensor induces a voltage value
P79	恢复出厂设置 Reset	0 - 1	0	0：无操作；No operation 1：恢复所有出厂参数。Restore all factory parameters;
P81	同步吸气，前吸屑关闭针数 Synchronous inspiratory，front suction crumbs close thread number	0 - 250	0	0：前吸屑与前罗线吸气同步关闭 Front suction crumbs and front trimming inspiratory synchronous closing 其他：前吸屑开启 P81 针数后关闭 When after front suction crumbs opening go by P18 thread number closing
P82	同步吸气，后吸屑与后剪线吸气同步关闭 Synchronous inspiratory，back suction crumbs close thread number	0 - 250	0	0：后吸屑与后剪线吸气同步关闭 Back suction crumbs and back trimming inspiratory synchronous closing 其他：后吸屑开启 P82 针数后关闭 When after back suction crumbs opening go by P82 thread number closing
P83	前剪线松线电磁阀开启针数 Front trimming loose line solenoid valve open thread number	0 - 50	1	0：前剪线松线电磁阀关闭 Front trimming loose line solenoid valve

	Front trimming loose line solenoid valve open thread number			opening 其他：前剪线松电磁阀吃线(P83)-1 针数开启 Front trimming loose line solenoid valve go by (P83)-1 open thread number
P84	前剪线松线电磁阀关闭针数 Front trimming loose line solenoid valve close thread number	1 - 50	1	
P85	后剪线松线电磁阀开启针数 Back trimming loose line solenoid valve open thread number	0 - 50	12	0：后剪线松线电磁阀关闭 Back trimming loose line solenoid valve closing 其他：后剪线松线电磁阀经 P85 针数开启 Back trimming loose line solenoid valve go by P85 open thread number
P86	后剪线松线电磁阀关闭针数 Back trimming loose line solenoid valve close thread number	1 - 50	15	
P87	手动吸气档缝时间 Duration time of manual suction	1 - 50	3	
P88	手动吸气电机转速 Speed of manual suction motor	500 - 7000	3500	
P89	点针功能使能 Enable One Pin	0 - 1	0	
P90	错误查看使能 Error viewing enable	0 - 1	0	
P91	薄料感应延时速波延时针数 Thin material induction delay filter delay stitch	0 - 100	30	
P92	面料识别布料类型 Fabric identification fabric type	0 - 2	0	0：常规布料模式 Normal fabric mode 1：大网孔布料模式 Big net hole fabric mode 2：网纱布料模式Gauze fabric mode
P93	厚料感应延时滤波延时针数 Thick material induction delay filter delay stitch	0 - 100	0	
P94	机型选择 Model selection	6 - 8	6	6：电动 Electric 7：气动 Pneumatic 8：侧吸 Side draught
P95	机型选择使能 Model selection enable	0 - 1	0	0：不使能 Not enabled 1：使能 Enabled
P96	三排的吸风模式 Three rows of suction mode	0 - 2	0	0：前吸风与后吸风同步 前吸风（二排电磁阀） 后吸风（三排电磁阀） 0: The front suction is synchronized with the rear suction 1: Intermittent suction (three rows of solenoid valves) 2: Long suction (the rows of solenoid valves)
P97	间歇吸风开启针数 Intermittent suction opening number	1 - 100	50	
P98	间歇吸风关闭延时时间 Intermittent suction closing delay time	1 - 25	5	单位：100ms　Unit: 100ms
P100	定期清洁提醒时间 Regularly change the white oil reminder time	0 - 9999	60	0：不使能 Not enabled 单位：小时 Unit: hour
P101	定期更换白油提醒时间 Regularly change the white oil reminder time	0 - 500	6	0：不使能 Not enabled 单位：月 Unit: Month
P102	获取厚料基值使能 Get thick material base value enable	0 - 1	0	
P103	强制电动抬压脚使能 Force electric presser foot lift enable	0 - 1	0	
P107	抬压脚电机初始角 Foot motor first position angle	1 - 360	38	
P109	踏踏板车后踏电压值 Pedal half-back step voltage value	12-511	127（P122=1） 和 99（P122=0）	该参数小于 P123-25（P122=0）或 P123-33（P122=1），大于 12
P110	踏踏板全后踏电压值 Pedal back step voltage value	13-511	38（P122=1） 和 55（P122=0）	该参数小于 P109

P111	踏板前踩运行开始位置（相对于回中位置）Step forward in running position	3-511	43（P122=1） 和 30（P122=0）	该参数小于 P51
P112	前剪线吸风中途半吸风度能 Front cut line suction midway stop enable	0 - 1	0	
P116	物联网序列号设置使能 IOT serial number setting enable	0 - 1	0	接入物联网模块时，此参数有效 This parameter is valid when accessing the Internet of Things module
P117	后剪线吸风加速速度 Acceleration speed of rear trimming suction	0-1000	0（吸刀 Chopper） 500（侧吸 Side draught）	RPM
P118	左右恢复内部限速使能 Restore internal speed limit enable left and right	0 - 1	0	-
P119	剪线延迟针数 Number of stitches for thread trimming delay	0 - 9999	0	-
P120	最低转速 Min rotate speed	200 - 500	300	单位：RPM　Unit: RPM
P121	踏板最大速度位置 Pedal maximum speed voltage value	0-511	380（P122=1） 和 320（P122=0）	大于(P123+ P51+25) more than(P123+ P51+25)
P122	脚踏类型选择 Pedal selection	0-1	1	0：包缝调速器 Overlock sewing pedal 1：平缝调速器 Lockstitch sewing pedal
P123	脚踏回中电压值 Setting of reference value in pedal return	0-511	182（P122=1） 和 175（P122=0）	大于 P109+25(P122=0)或大于 P109+33(P122=1)，小于 P121-P51-25

工艺参数（P+下键）

U1	踏板报警检测使能 Pedal alarm detection enable	0-1	0	0-开启报警 Open alarm 1-关闭报警 Close alarm
U3	后剪线电机状态初始化 Motor status of trimmer after sewing	0-100	3	
U15	厚度检测灵敏度 Thickness detection zero position threshold	100 - 500	450	单位：0.01V　Unit:0.01V
U17	过程后提速时间 Speed-up time after bone cross sewing	1 - 50	5	单位：100ms　Unit:100ms U20=2 时，厚料调起后开始计时。U17*100ms 后提速（如果是薄料，则立即提速）When U20 = 2, the timing begins after the heavy material decelerates, and increases after U17 * 100ms (if it is thin material, it increases immediately).
U18	过程降速速度 bone-cross decelerating speed	500 - 7000	5000	单位：RPM　Unit:RPM
U19	薄厚料切换递度增量 Increment of switching speed for thin and thick materials	1 – 100	10	1RPM/ms 从厚料变为薄料时，速度以 U19 的幅度从降速速度提速到正常速度 When changing from thick material to thin material, the speed increases from decreasing speed to normal speed in the range of U19.
U20	过程降速开关 Switching speed reduction after bone cross sewing	0 - 2	0	0：关闭，Close 1：过厚降速模式　Thick material deceleration mode 2：过梗降速模式　Bone cross slowdown speed mode
U24	剪线补偿功能使能参数 Compensation function of trimming enabling parameter	0 - 1	0	
U25	出厂针距设定 Out-of-factory Needle gauge setting	10 - 60	44	单位：0.1mm　Unit:0.1mm 使用手动设定针距 Use manual setting of needle gauge
U26	自动补偿面料类型选择 Selection of automatic compensation fabric types	0 - 2	0	0：针织短线头模式 knitting short thread trimmer mode 1：梭织短线头模式　woven short thread trimmer mode 2：大针距短线头模式 large gauge short thread trimmer mode
U33	抬压脚高度调节 Presser foot height adjustment	1 - 20	20	档 Gear
U34	微抬高度调节 Slight Foot height	4 - 11	5	档 Gear
U35	抬压脚判断平台角度	0-360	345	
U37	薄厚档位切换段偏开关 Thin and	0 - 1	0	0：关闭 Off

	thick gear switch reminder switch			1：开启 On
U40	特殊松线功能使能 Special release function enable	0 - 1	1	
U41	避前不停车使能 No stop enable before cover	0 - 1	1	
U42	缓放压脚档位 Slowly release the presser foot gear	0 - 9	3	
U47	空缝降噪模式 Switch for noise reduction in front of sewing	0-2	0	0：关闭 Off 2：空缝压脚踩脚踏 The pressure foot of the empty seam is slightly lifted
U47	空缝降噪运行针数 Noise reduction delay needle	0 - 100	0	
U49	压脚保护开关频率强制抬压脚 Presser foot safety switch damaged and force presser foot lift	0 - 2	1	0：抬压脚时检测压脚安全开关状态 When lifting the presser foot, check the status of the presser foot safety switch 1：抬压脚时不检测压脚安全开关状态 When lifting the presser foot, the status of the presser foot safety switch is not detected 2：电控不检测自压脚电机状态 The electronic control does not detect the status of the motor of the press-lifting foot
U69	抬压脚最大高度补偿角度（非下俯）Maximum height compensation angle for presser feet（Not downwards）	100 - 108	103	单位：1 度　Unit:1 degree
U70	抬压脚最大高度补偿角度 Maximum height compensation angle for presser feet（downwards）	60 - 130	128	单位：1 度　Unit:1 degree
U74	停机欠压报警使能 Enable the shutdown under voltage alarm	0 - 1	0	0：关闭 Close 1：开启 Open
U75	停机过压报警使能 Enable overvoltage alarm for shutdown	0 - 1	1	0：关闭 Close 1：开启 Open
U80	伺服转线角度 Servo line cutting Angle	0 - 179	81	单位：1 度　Unit:1 degree
U83	伺服控制参数调节使能 Servo control parameters are adjusted and enabled	0 - 1	0	0：关闭 Close 1：开启 Open
U84	伺服剪线速度 Servo line cutting Speed	700-1200	1150	RPM
U85	开机自动校准 Automatic startup calibration	0 - 1	0	0：关闭 Close 1：开启 Open
U87	抬压脚高度限制 Enable not downwards height restriction for presser feet	0-5	5	0：关闭 Close 1：1-6mm Open 2：2-7mm Open 3：3-8mm Open 4：4-9mm Open 5：5-10mm Open
U91	抬压脚电机速度 Foot motor Speed	600 - 1000	900	RPM
U92	下停针偏移 Lower needle stop position deflection	0 - 4	0	
U93	上停针每度微调 Up needle stop position angle adjustment	0 - 70	22	0：关闭该功能 Turn off this function
U94	转接板通讯开关 Enable the adapter board communication	0 - 1	1	0：串口通讯 Normal serial communication 1：高速串口通讯 High-speed serial communication
U101	中料阈值里值 Medium thick makings threshold	0 - 500	40	单位：0.01V　Unit:0.01V（最大值小于 U102 当前值）(The maximum value is less than the current value of U102)
U102	厚料阈值里值 Thick makings threshold	0- 500	80	单位：0.01V　Unit:0.01V（大于 U101 当前值，小于 U15）(Greater than the current value of U101, less than U15)
U103	抬压脚电机缺相检测开关 Pressure foot lifting motor phase loss detection switch	0-1	1	

4.2. 监控参数 Monitoring parameters

P+右键进入监控界面，左右键调整监控参数项，按 P 键进入当前监控参数值。在监控 M00 项时按 P 键退出监控模式。

P+ right button enters the monitoring interface, left and right buttons adjust the monitoring parameter item, press P button to enter the current monitoring parameter value. Press the P button to exit the monitor mode while monitoring the M00 item.

序号	内容	序号	内容
M0	退出监控模式 Exit monitor mode	M14	母线电压值 Bus voltage value
M1	当前计数 Current piece count	M15	物联网联网状态 IOT networking status
M2	机型类型 Model type	M16	程序识别号 Software number
M3	Q 轴电流 Q axis current	M17	转接板软件版本号 Adapter board software version number
M4	交流输入电压 AC input voltage	M18	主轴电机控制软件版本号 Main motor control software version number
M5	踏板电压值 Pedal voltage value	M19	Craft control software version number
M7	前感应器电压值 Front sensor voltage value	M20	面板软件版本号 Panel software version number
M8	中感应器电压值 Medium sensor voltage value	M21	前抬脚电机控制软件版本号 Presser foot motor control software version number
M9	后感应器电压值 Post sensor voltage value	M22	老化 15 分钟完成标志 Complete the aging mark in 15 minutes 百位——厚料机型才看，普通点，厚料-1 Hundreds digit --thick material models, normal models-0,thick material models-1
M10	实时速度值 Real-time speed value	M32	厚度检测电压值 Voltage value of thickness measurement
M11	物联网缝纫机工作状态 Working status of IoT sewing machines	M33	短线头感应器电压值 Voltage value of Short thread sensor
M12	防干扰中感应器电压值（保留）Anti-interference sensor voltage value (reserved)	M34	抬压脚电机角度值 Presser foot motor angle value
M13	防干扰后感应器电压值（保留）Anti-interference sensor voltage value (reserved)	M35	抬压脚电机电流 Presser foot lifter motor current
M36	面板版本日期 Panel Version Date	M37	电控版本日期 Electric control version date
M38	主轴运行时最大电流 Maximum current during spindle operation	M39	抬压脚电机电角度 Electric angle of the presser foot motor

备注 1：0-普通缝纫机状态；1-物联网分期状态；2-物联网锁机状态；3-物联网锁机完成；IOT sewing machine working status (0-normal sewing machine status; 1 - Internet of Things staging status; 2 - Internet of Things lock machine status; 3 - Internet of Things lock line speed)

5. 错误码说明表 Error code description table

机器出错报警时，面板显示报警号

When the machine error alarm occurs, The panel shows the alarm number

序号 NO	内容 Content(when there is a failure, broadcast	对策（按下前自带机键维护）Countermeasure(press the voice navigation button broadcast)
E1	主轴电机堵转 Main motor stall	请检查机头是否卡死或者机动困难；请检查电机插头，电机接应器接头是否松动或脱落，上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the machine head is stuck or difficult to turn; Please check if the motor plug and motor sensor connector are loose or loose; If you still can't solve the above, please contact your local service provider or call 40087685.
E2	主轴电机软件过流 Main motor software over current	请检查使用电压是否正常，请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the voltage used is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 40087685.
E3	操作面板与控制箱通讯异常 The operation panel and the control box communicate abnormally	请检查操作面板和控制箱连接线是否松动；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或售打 40087685。Please turnoff the system power, check if the motor Hall signal connector is loose or disconnected, return it to normal and restart the system. If you still can't solve the above, please contact your local service provider or call 40087685.
E4	主轴电机霍尔错误 Motor Hall error	请关闭系统电源，检查电机霍尔信号接头是否松动或脱落，将其恢复正常后重启系统，上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the operation panel and control box cable are loose; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 40087685.
E5	停针信号异常 Abnormal needle stop signal	请关闭系统电源，检查电机停针信号接头是否松动或脱落，将其恢复正常后重启系统，上述如仍无法解决请联系当地服务商或售打 40087685。Please turn off the system power, check if the motor stop signal connector is loose or fall off, return it to normal and restart the system. If you still can't solve the above, please contact your local service provider or call 40087685.
E6	压脚保护功能开启 Presser foot protection is on	请检查压脚是否排回到正确位置，仍无法解决需要临时使用请将 P58 项参数里的 1 改为 0。上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the presser foot is pushed back to the correct position; Still can not solve the need to temporarily use, please change the 1 in the P58 parameter to 0; If you still can't solve the above, please contact your local service provider or call 40087685.
E7	缝台缝针是否排回到正确位置，仍无法解决需要临时使用请将 P58 项参数里的 1 改为 0。上述如	

	protection function is on	仍无法解决请联系当地服务商或售打 40087685。Please check if the sewing table is pushed back to the correct position; Still can not solve the need for temporary use, please change the 1 in the P58 parameter to 0; if the above still can not be resolved, please contact the local service provider or call 40087685.
E9	脚踏板连接异常 Abnormal foot pedal connection	请检查踏踏板插头是否连接控制箱或者松动；上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the pedal plug is connected to the control box or loose; If you still can't solve the above, please contact your local service provider or call 40087685.
E10	主轴电机硬件过流 Main motor hardware overcurrent	请检查供电电压是否正常，请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the power supply voltage is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 40087685.
E11	主轴电机停机时过压 Main motor overpressure during shutdown	请检查供电电压是否正常，请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the power supply voltage is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 40087685.
E12	主轴电机系统欠电压 Main motor system under voltage	请检查供电电压是否正常，请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the power supply voltage is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 40087685.
E13	主轴电机刹动回踩异常 Main motor abnormal brake circuit	请联系当地服务商或售打 40087685。Please contact your local service provider or call 40087685.
E14	参数读写异常 Parameter read and write exception	请尝试关闭电源重启，如仍无法解决请联系当地服务商或售打 40087685。Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 40087685.
E19	主轴电机电流检测回路异常 Main motor current detection loop is abnormal	请检查主轴电机电源线是否松动；请检查如仍无法解决请联系当地服务商或售打 40087685。Please check if the motor power cord is loose; If you still can't solve it, please contact your local service provider or call 40087685.
E20	电源关闭 Power off	
E21	主轴电机保 IGBT 缺相 Lack of phase in Main motor or IGBT	请检主轴电机动力线是否缺相，电控硬件驱动回路是否异常；请尝试关闭电源重启如仍无法解决请联系当地服务商或售打 40087685。Please check if the power line of the spindle motor is out of phase and if the electronic control hardware drive circuit is abnormal; Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 40087685.
E26	转接板与控制器通讯异常 The adapter board communicates abnormally with the controller.	请检查转接板与控制箱连接线是否松动；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the connection between the adapter plate and the control box is loose; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 4008876585.
E27	恢复出厂设置错误 Factory reset error	关机重启后，重新恢复出厂设置。After the shutdown is restarted, the factory settings are restored.
E31	抬压脚电机软件过流 Foot motor soft overcurrent	请检查使用电压是否正常，请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the voltage used is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 40087685.
E32	抬压脚电机电流检测回路异常 Foot motor current detection loop is abnormal	请尝试关闭电源重启如仍无法解决请联系当地服务商或售打 40087685。Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 40087685.
E33	抬压脚电机堵转 Foot Motor stall	请检查机头是否卡死或者机动困难；请检查电机插头，电机编码器接头是否松动或脱落，上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the machine head is stuck or difficult to turn; Please check if the motor plug and motor encoder connector are loose or loose; If you still can't solve the above, please contact your local service provider or call 40087685.
E34	抬压脚电机动力线或编码器信号故障 Foot Motor Encoder signal abnormally	请检查电机插头，电机编码器接头是否松动或脱落；上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the motor plug and motor encoder connector are loose or loose; If you still can't solve the above, please contact your local service provider or call 40087685.
E35	抬压脚电机找初始位置出错 Foot motor find first position abnormally	请检查机头是否卡死或者机动困难；请检查电机插头，电机编码器接头是否松动或脱落；上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the machine head is stuck or difficult to turn; Please check if the motor plug and motor encoder connector are loose or loose; If you still can't solve the above, please contact your local service provider or call 40087685.
E36	抬压脚电机硬件过流 Foot motor hard overcurrent	请检查供电电压是否正常，请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the power supply voltage is normal; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 40087685.
E37	抬压脚电机超速 Foot motor is overspeeding	请检查编码器支撑是否有灰尘或损坏；请尝试关闭电源重启如仍无法解决请联系当地服务商或售打 40087685。Please check if the encoder grating is dusty or damaged; Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 40087685.
E38	抬压脚电机缺相检测开关 Lack of phase in foot motor or IGBT	请检查抬压脚电机动力线是否缺相，电控硬件驱动回路是否异常；请尝试关闭电源重启如仍无法解决请联系当地服务商或售打 40087685。Please check if the power line of the foot motor is out of phase and if the electronic control hardware drive circuit is abnormal; Please try to turn off the power and

E40	抬压脚电机过载 Foot motor is overloaded	restart. If you still can't solve it, please contact your local service provider or call 40087685.
E41	抬压脚电机位置偏差计数器溢出 foot motor position deviation counter is overflowing	请检测抬压脚电机编码器光栅是否有灰尘、编码器是否损碎或有破纹，请尝试关闭电源重启如仍无法解决请联系当地服务商或售打 40087685。Please check if there is dust on the encoder grating of the presser foot motor, if the encoder is faulty, or if the load is too high ; Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 40087685.
E43	抬压脚电机超速 Foot motor is overspeeding	请检查编码器光栅是否有灰尘或损坏，请尝试关闭电源重启如仍无法解决请联系当地服务商或售打 40087685。Please check if the encoder grating is dusty or damaged; Please try to turn off the power and restart. If you still can't solve it, please contact your local service provider or call 40087685.
E57	转接板连通串口通讯故障 High speed serial communication failure of the adapter board	请检查转接板与控制箱连接线是否松动，或设置 U94 项参数为 0；请尝试恢复出厂设置或将电源重启；上述如仍无法解决请联系当地服务商或售打 40087685。Please check if the connection between the adapter plate and the control box is loose,or set the U94 parameter to 0.; Please try to restore the factory settings or restart the power supply; If you still can't solve the above, please contact your local service provider or call 40087685.
EA1	计件数开计数递 Counting counts in ascending order	按