









# **2001D CONTROL MANUAL**

[1]



Function	Key	Description
Motor rest		Feeding motor rest
Setting		Enter setting interface
Presser foot		Presser foot control
Service mode		After clicking, prompt whether to enter maintenance status. If confirmed, start maintenance status
Roller		Roller control

Thread		After clicking, it will prompt whether to lift the pressure roller. If confirmed, the pressure roller will be lifted, and regardless of whether it is lifted, it will enter the threading state. At this time, the interface will prompt that it is currently threading, stop the operation, and exit after threading is completed.。
Speed up		Increase sewing speed
Speed down		Slow sewing speed
Auto sewing		Auto sewing mode
Slow speed sewing		Slow speed mode
Auto pre-feed		Auto pre-feed mode
Manual pre-feed		Manual pre-feed
Stacker		Active stacker one time
Cutter		Active cutter one time
Sensor status		At the top of the interface, the current status of relevant sensors, such as iron bars, knives, etc., will be displayed. You can use this to understand the current working status
Pitch		Stitch length setting
Thread breakage		Active the thread breakage sensor
Patterns saving		Save different patterns

Increase count		Count add one
Decrease count		Count minus one
Clear		Count clear

## [2] Motor setting




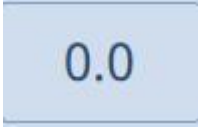




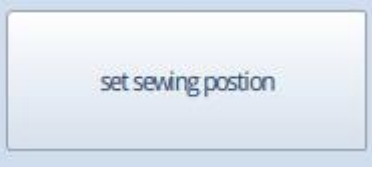

1. The list on the left is for shortcut key settings. If a key is selected, the values in which set of shortcut settings will be set

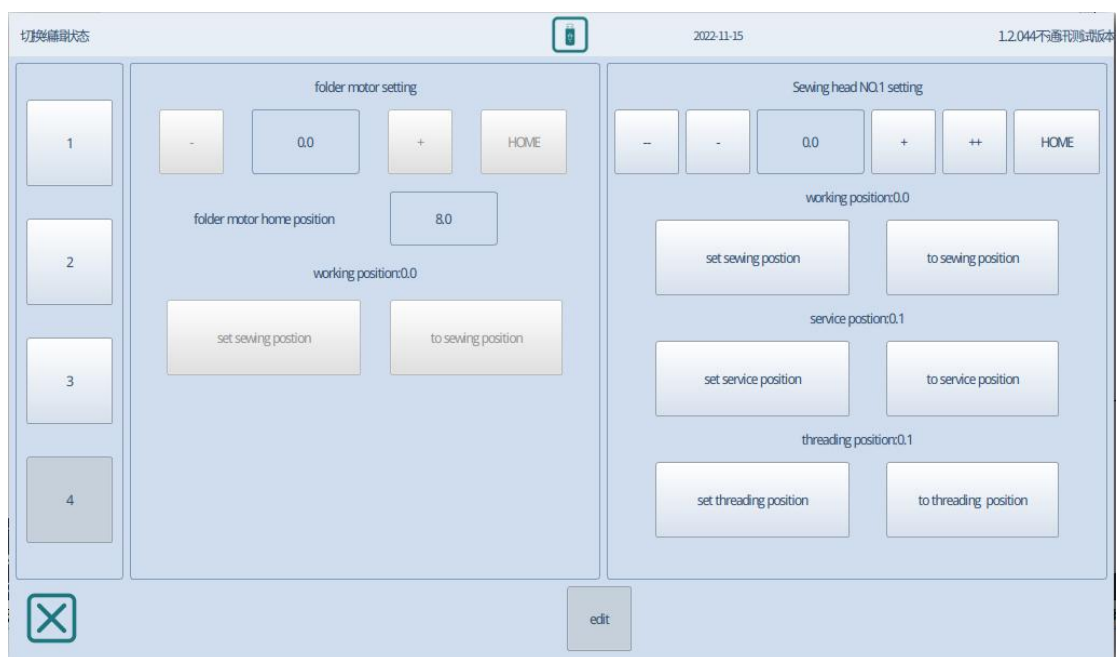
1. The editing button below displays whether the current setting can be modified. Pressing it will activate each modification button, otherwise it will be unavailable to avoid accidental modification

The area on the right is the parameter setting interface

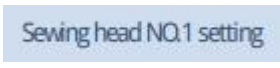


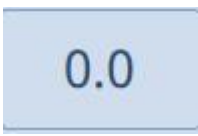








### A、Folder motor setting

Function	Key	Description
-0.1mm		Folder motor rotates in reverse 0.1mm

Current motor position		Display the current position of the folder motor rotation
+0.1mm		Folder motor rotates forward by 0.1mm
Home position		Folder motor rotates to hoe position
Home position setting		Click on the value to enter the input interface and modify the home position
Working position		Display the working position in the current setting
Set sewing position		Set the current rotation position of the folder motor to the working position
Move to sewing position		Folder motor rotates to sewing position

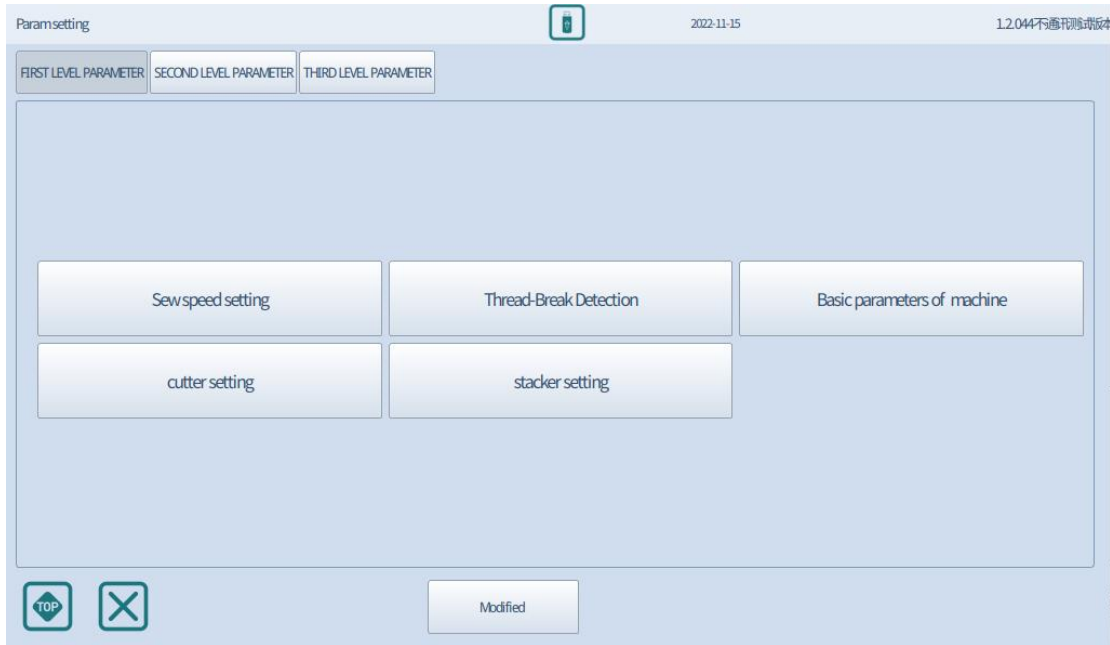


B、Head motor setting

Function	Key	Description
Current head		Display current sewing head
-1mm		Reverse rotation of the head motor 1mm
-0.1mm		Reverse rotation of the head motor 0.1mm
Current motor position		Display the current position of the head motor rotation
+0.1mm		The head motor rotates forward 0.1mm
+1mm		The head motor rotates forward 1mm
Home		The head motor rotates to the home position
Set sewing position		Set the current head motor rotation position to the working position
To sewing position		Rotate the head motor to the working position
Set service position		Set the current head motor rotation position to the maintenance position
To service position		Rotate the head motor to the maintenance position
Set threading position		Set the current head motor rotation position to the threading position

To threading position	to threading position	The head motor rotates to the threading position
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[3] Parameter



FIRST LEVEL PARAMETER				
Sew speed setting	Thread-Break Detection	Basic parameters of machine	cutter setting	stacker setting
First stitch speed	Invalid stitches before start bobbin thread detection	pre-feeding speed	Cutter switch	Stacker down timing
Second stitch speed		pocket distance	Cutter action time	Stacker delay timing
Third stitch speed		Upper pressure roller gain	Cutter mode	
Forth stitch speed		slow sewing speed	Cutter optical eye polarity reversal	
Fifth stitch speed	Continuous stitches when bobbin thread detection	idle sewing speed	Cutter spacing	
Spindle acceleration		Sync gain	front cutter deviation	
		Feed Start Delay	rear cutter deviation	

SECOND LEVEL PARAMETER		
Reset settings	PANEL AND DISPLAY	OTHER PARAMETERS
Whether to choose the upper deadpoint when the principal axis returns to the origin	Buzzer Sound Setting	Change language
	PANEL LUMINANCE SETTING	Power On Password
	PANEL LUMINANCE AUTO CLOSE SWITCH	EMBED COMMUNICATION
	WAITING TIME BEFORE PANEL LUMINANCE CLOSE	
	Button Display Type	
	Display Logo	

THIRD LEVEL PARAMETER	
Main shaft parameters	Sewing head speed
Max sew speed	sewing head uniform speed
Stop Position	sewing head startup speed
Feed Starting angle setting	sewing head accelerate speed
Feed stop angle setting	

#### A、Sew speed setting

Set Param
2022-11-15
1.2.044不透明玻璃版本


01/01

First stitch speed	300
Second stitch speed	500
Third stitch speed	1000
Forth stitch speed	1500
Fifth stitch speed	2000
Spindle acceleration	800

✕




## B、Thread-Break Detection


Set Param  2022-11-15 1.2.044不通过测试版本

Thread-Break Detection 01/01

Invalid stitches before start bobbin thread detection	0
Continuous stitches when bobbin thread detection	0






## C、Basic parameters of machine


Set Param  2022-11-15 1.2.044不通过测试版本

Basic parameters of machine 01/02

pre-feeding speed	600
pocket distance	10
Upper pressure roller gain	100
slowsewing speed	300
idle sewing speed	1
Sync gain	0.1




  

## D、cutter setting


Set Param  2022-11-15 1.2.044不逃我鸭成成4

01/02

Cutter switch	Off
Cutter action time	100
cutter mode	Front + Behind thread trimming
Cutter optical eye polarity reversal	Do not flip
Cutter spacing	0
front cutter deviation	0


  

## E、stacker setting

Set Param  2022-11-15 1.2.044不逃我鸭成成4

01/01

stacker down timing	7
Stacker delay timing	0




## F、Reset settings

Set Param 2022-11-15 1.2.044不通用测试版本

Reset settings 01/01

Whether to choose the upper deadpoint when the principal axis returns to the origin	Off
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## G、PANEL AND DISPLAY

Set Param 2022-11-08 1.2.044不通用测试版本

PANEL AND DISPLAY 01/01

Buzzer Sound Setting	Buzzer Off
PANEL LUMINANCE SETTING	100
PANEL LUMINANCE AUTO CLOSE SWITCH	NON-AUTO_OFF
WAITING TIME BEFORE PANEL LUMINANCE CLOSE	3
Button Display Type	Icon
display logo	hide




## H、 OTHER PARAMETERS

Set Param 2022-11-08 1.2.044不通过测试版本

OTHER PARAMETERS 01/01

Change language	EN
Power On Password	YES
EMBED COMMUNICATION	Off




## I、 Main shaft parameters

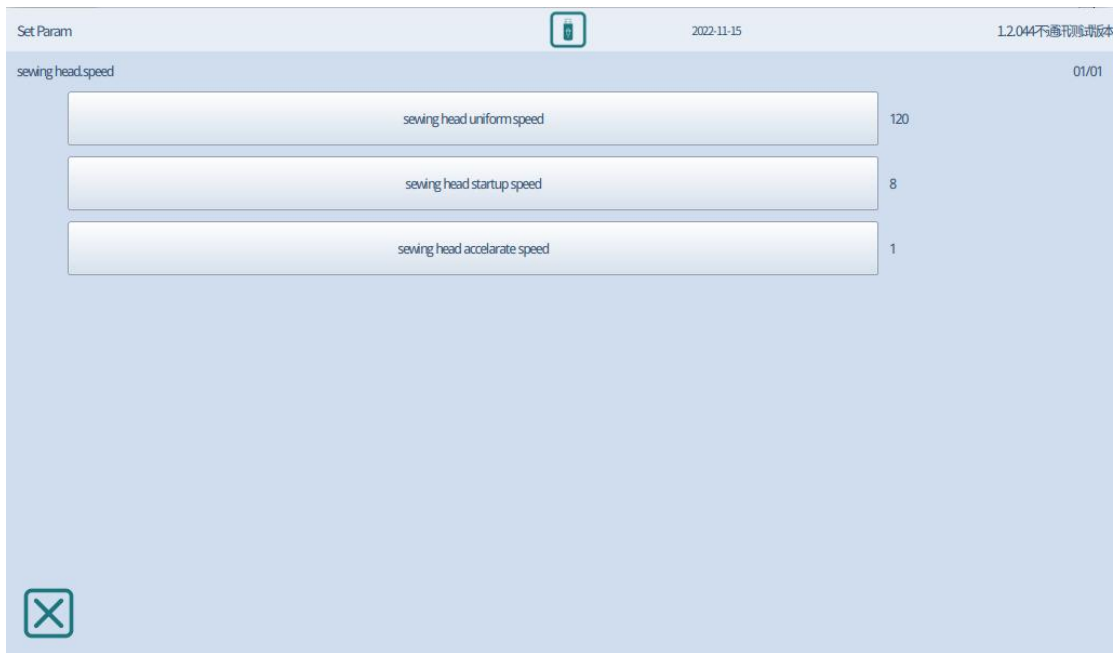
Set Param 2022-11-15 1.2.044不通过测试版本

Main shaft parameters 01/01

Max sew speed	3500
Stop Position	0
Feed starting Angle setting	0
Feed stop Angle setting	0

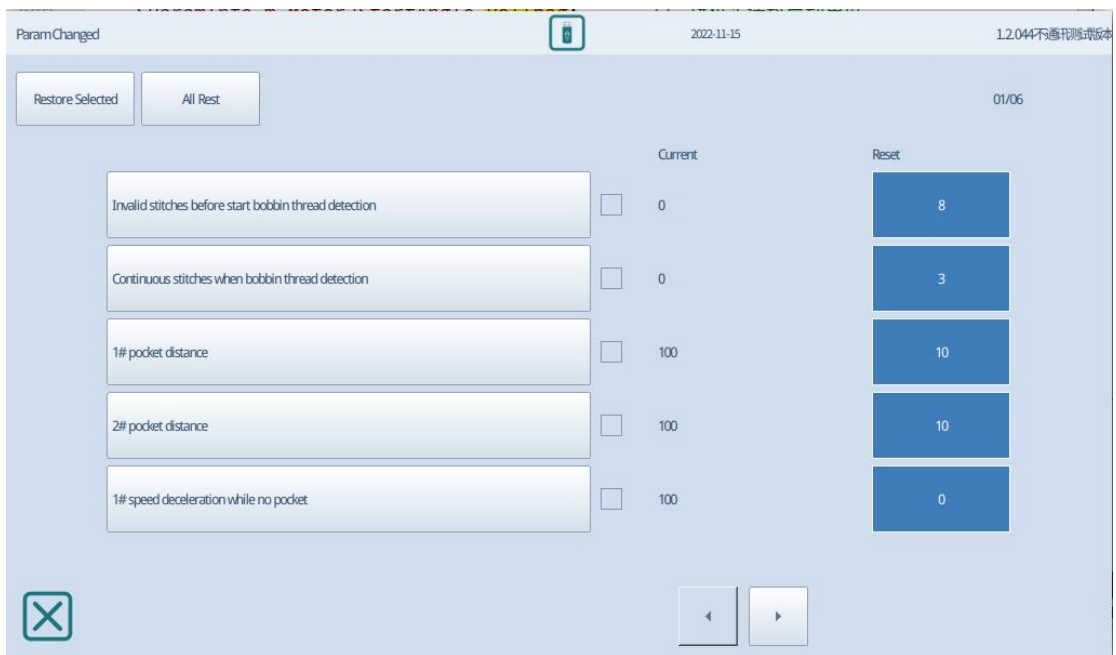


## J、 Sewing head speed



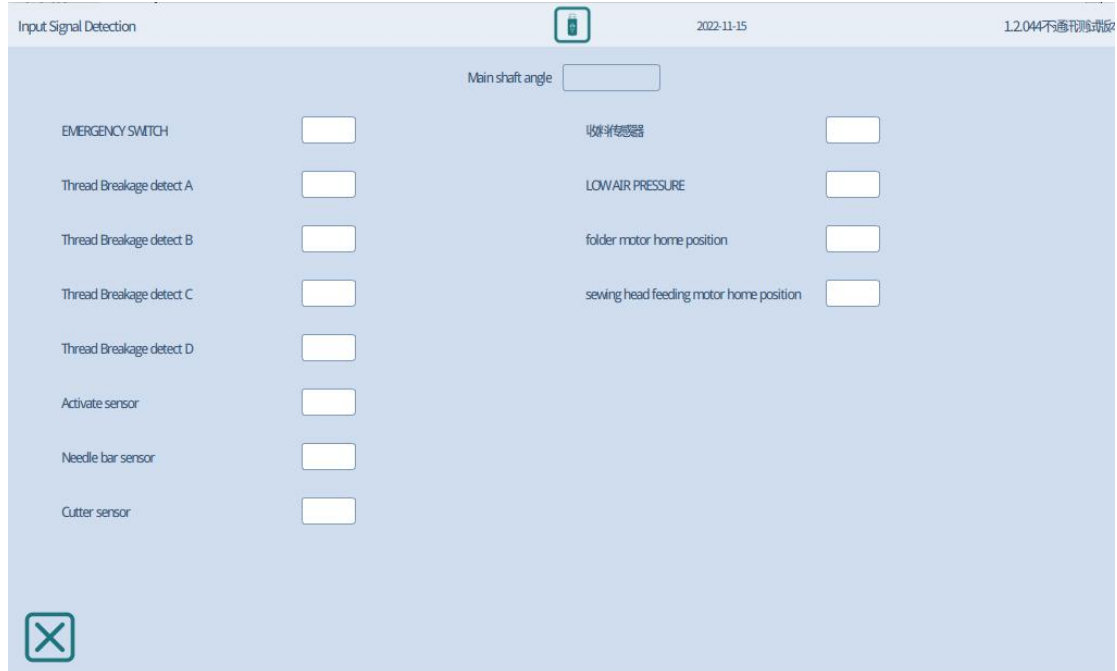
### K、Modified

Select the modified settings at the bottom to view the modified user parameters in the current system. You can directly click the corresponding parameter button to modify the parameter again. At the same time, you can also select the box on the right side of the button to reset the parameter and restore it to the factory parameters.



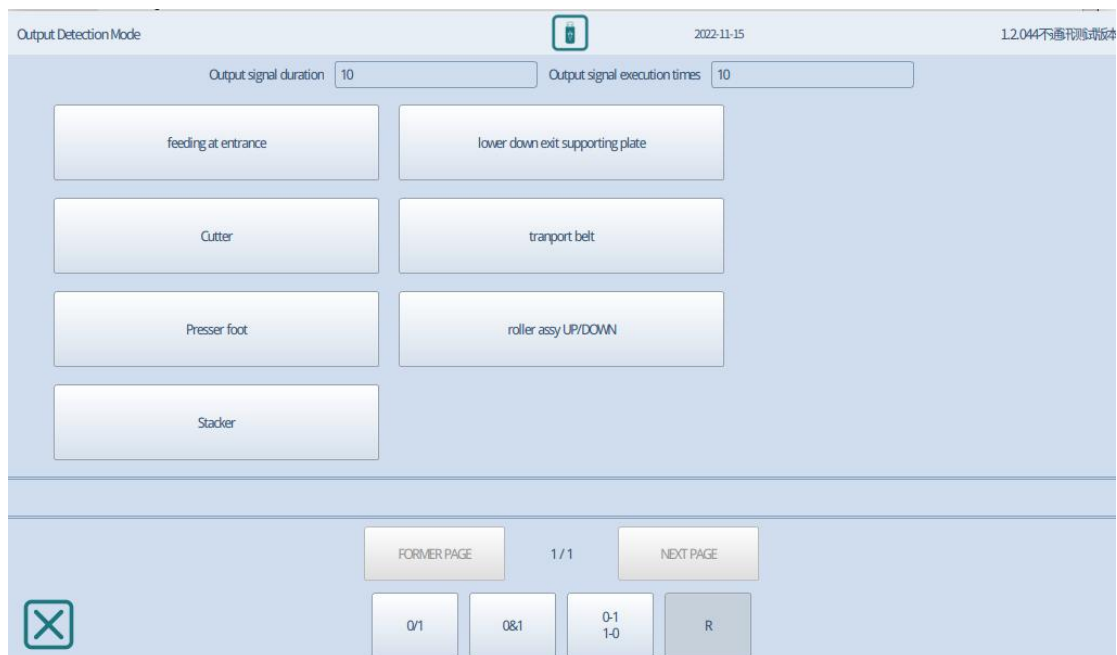
### A. Input signal

Select and click the input signal button to view the current input signal. This interface displays all input signals that will exist for this machine. The presence of signals can be determined by the color of the square behind the text. White indicates no signal input, while green indicates signal input.



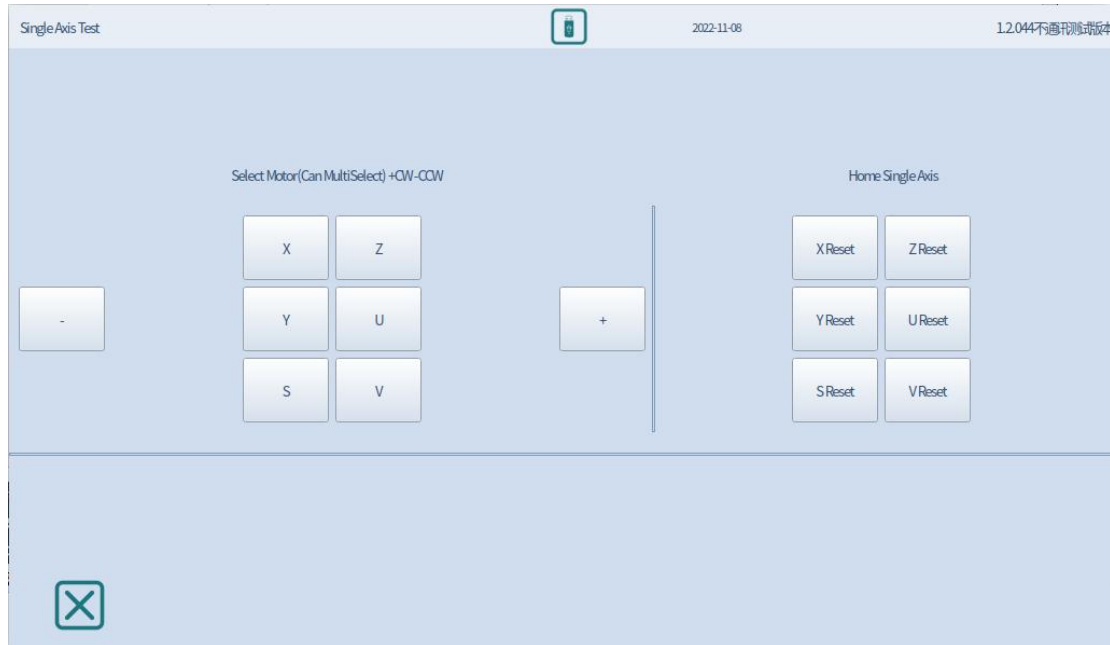
### A. Output signal

Select and click the input signal button to enter the output signal testing interface. By clicking on the button in this interface, output signals corresponding to the button function can be transmitted, and the machine can be detected to perform corresponding operations based on the transmitted operation signals.



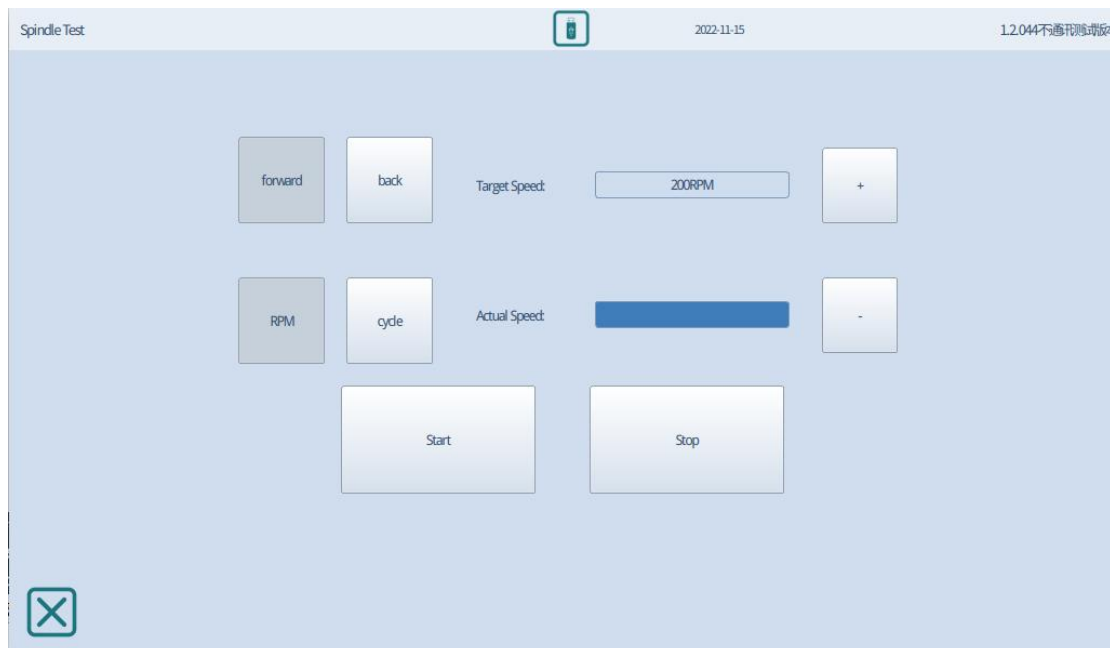
### A. Uniaxial testing

Select and click the single axis test button to enter the single axis test interface. At this time, all axes are not selected. Select and press the axis that needs to be modified, and the button will change. After selection, use the forward or reverse button to test whether the selected axis can be used normally. At the same time, you can also choose to reset the corresponding axis.



### Spindle aging

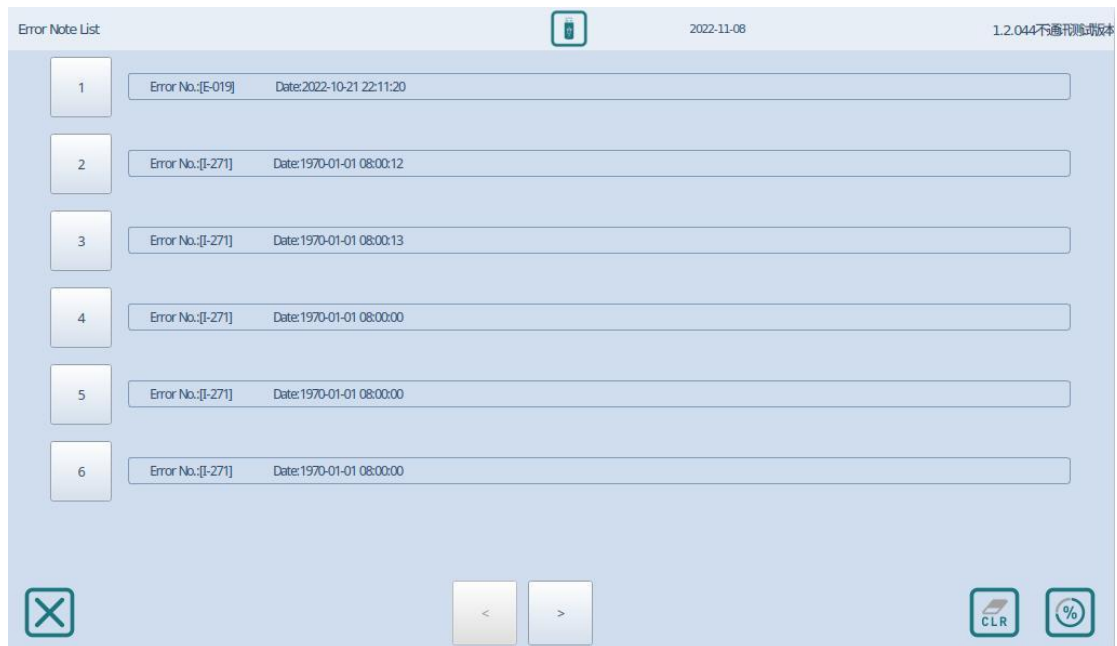
Select Factory Mode to enter the spindle aging interface, where you can perform spindle aging operations



You can choose the speed mode to keep the spindle running continuously at a certain speed, or you can choose the number of turns mode to make the spindle run a fixed number of turns.

## A. Alarm records

Select Factory Mode to enter the alarm record interface. In this interface, you can see the alarm information history of the equipment. Each alarm record has its error code and the current number of production pieces



You can select the serial number button of the error message to view the problem represented by the current error code.

