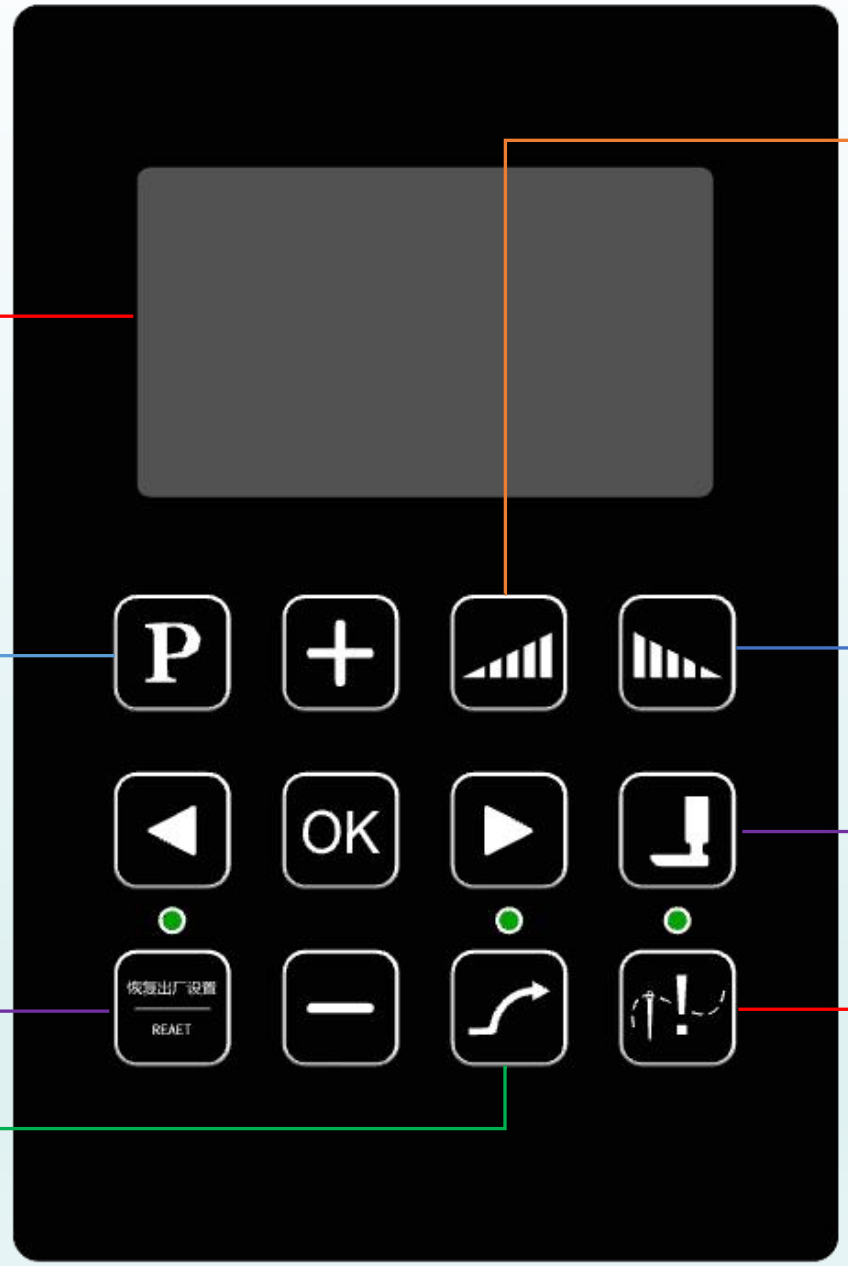
781双步进款操作说明
781 stepper style operation instruction



显示界面Display Area

参数键Parameter

恢复出厂设置
Restore the factory settings

慢启动键
Slow starting

低速键Low speed
调节低速时速度adjust the value of low speed

高速键High speed
调节高速时速度
adjust the value of high speed

抬压脚高度Presser foot height
进入参数可以调节抬压脚高度
adjust the height of presser foot

断线检测Thread broken detection
开启时压脚功能关闭presser foot function off when open this

参数项 parameter	范围 range	默认值 default value	说明 instruction	参数项 parameter	范围 range	默认值 default value	说明 instruction
P001	100-3500	2800	当前转速 Current speed	P099	0-300	80	夹线行程 Clamping trip
P002	100-3000	600	前启缝速度 The front starting speed	P100	0-1500	580	抬压脚行程 Presser foot lifting trip
P006	100-2000	700	慢速启缝速度 Slow start speed	P122	100-1240	850	切刀步进电机最大工作电流 Maximum working current of trimming stepping motor
P007	0-99	7	慢速启缝针数 Slow start stitch numbers	P123	100-1240	750	抬压脚步进电机工作最大电流 Maximum working current of presser foot stepping motor
P013	0-100	20	传感器触发间隔针数 sensor trigger spaced stitches number	P124	0-500	0	脚踏板实时数值 The value of the pedal
P021	0-2	0	安全开关 safety switch	P125	30-200	90	第一次切刀在总针数的3/4针数根据锁眼长度和针距加减针数调试 Number of stitches at the beginning of continuous cutting
P029	0-359	80	上停针位置点（手轮旋转到合适位置后，按压脚键更新上停针位置） Up needle stop position(press the presser foot key to update when turning the handwhhel to the up needle position)	P126	5-50	20	第二次循环切刀根据针数的针距和刀片的尺寸加减针数调试 Number of stitches at the between of continuous cutting
				P127	0-1	1	机器启动安全开关设置 Turn on the safety switch setting
P032	100-3500	3000	最大速度锁定 Maximum speed	P128	0-1	0	连续切刀开关 Knife protection switch
P035	1022	1022	版本号 Version	P129	0-1	0	断线刹车开关 Thread broken stop switch
P042	0-1	0	电机角度自动校准（0：关闭；1：开启） Automatic motor angle calibration	P130	0-1	1	后踏急停功能启用开关 Switch of the back step emergency stop function
P098	300-700	500	压脚步进机械零点 Presserfoot stepper machaical zero point	P133	50-800	750	剪线步进落刀速度 Cutting speed

参数项 parameter	范围 range	默认值 default value	说明 instruction	参数项 parameter	范围 range	默认值 default value	说明 instruction
P134	10-3000	300	最大运行针数 Maximum number of running stitches				
P136	40-600	450	步进抬压脚速度 Stepper motor lifting presser foot speed				
P137	40-400	80	步进下放速度 Stepper motor releasing presser foot speed				
P138	10-600	100	步进夹线速度 Stepper motor claming thread speed				
P139	10-600	200	步进下放的中间位置 The mid-position of stepper motor releasing				
P140	10-400	80	步进下放的中间速度 The mid-speed of stepper motor releasing				
P141	0-200	50	主轴完成动作时的抬起延时 Delay time of the presser foot lifting when spindle motor finishing work				
P142	0-5000	80	主轴启缝时的启动延时 Delay time of the spindle motor starting				
P143	1-5000	140	步进压脚下放延时 The delay of the stepper presser foot releasing				
P143	1-5000	140	步进压脚下放延时 The delay of the stepper presser foot releasing				
P144	0-9999	0	当前剪线计数 Current thread trimming count				

错误代码 Error code	错误明细 Error instruction	解决方案（操作前请先关闭电源） Solution(please turn off the power before operating)
ER01	定位器信号异常 positioner signal abnormal	1、检查电机编码器接口是否松动或脱落，重新连接后重启检查 check the connection of motor encoder plug, reconnect it and restart the controller to test 2、更换电机 change the motor 3、更换电控 change the controller
ER02	控速器连接异常 abnormal connection of speed controller	1、检查控速器是否有松动或接触不良 check the connection of th speed controller 2、更换控速器 change the speed controller 3、更换电控 change the controller
ER04	1)马达插头接触不良导致不转 poor connection of the motor plug 2)车头机构锁死或马达皮带异物卷入卡死 machine stuck 3)加工物过厚，马达扭力不足无法贯穿 the clothe is too thick to be penetrated 4)电控异常 abnormal of the controller	1、检查电机电源线接口是否松动或脱落，重新连接后重启检查 check the connection of motor power wire, reconnect it and restart the controller to test 2、检查车头是否过重或卡死 check the machine if it is stuck 3、检查缝制布料是否太厚 check if the cloth is too thick 4、更换主轴电机 change the spindle motor 5、更换电控 change the controller
ER05	1)主轴电机电力模块错误代码 spindle motor power module error code 2)主轴电机不正常过电流或过电压 abnormal overcurrent or overvoltage of spindle motor	1、重启电控 restart the controller 2、更换电控 change the controller
ER07	前面操作盒与CPU传输通信异常 abnormal transmission communication between display and CPU	1、检查显示屏面板和电控连接线是否松动或脱落，重新连接 reconnect the connection between display and controller 2、更换显示屏 change the display 3、更换电控 chenge the controller
ER15	主轴电机编码器错误 spindle motor encoder error	1、检查主轴电机编码器接口是否松动或脱落，恢复后重启检查 check the connection of motor encoder plug, reconnect it and have a test 2、更换主轴电机 change the spindle motor
ER16	系统不运行时过压 overvoltage when the system is not running	1、检查输入电压是否过高 check the input voltage if it is too high 2、更换电控 change the controller
ER20	系统欠压 system undervoltage	1、检查输入电压是否过低 check the input voltage if it it too low 2、更换电控 change the controller

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ER31	主轴电机原点检测错误 spindle motor origin detection error	1、检查主轴电机与电控连接线是否松动或脱落 check the connection between the spindle motor and controller
ER32	机头翻倒保护 machine overturn protection	1、检查机器机头是否复位 check the machine if it is overturn
ER33	倒缝超时保护 reverse sewing timeout protection	1、倒缝电磁铁吸合时间过长，重启即可 the closing time of reverse sewing electromagnet is too long, restart the controller 2、检查手动倒缝开关是否损坏 check if the manual reverse sewing switch is broken
ER34	剪线堵转 trimming stuck	转动手轮一圈使动刀回位,清理异物检查剪刀组件无异常时是否可继续工作 turn around the handwheel to return the moving knife, clean the table and check the knife set
ER36	系统运行时过压 overvoltage during system operation	1、检查输入电压是否过高 check the input voltage if it is too high 2、更换电控 change the controller
ER81	压脚步进电机原点检测错误 presser foot stepper motor origin detection error	检查步进安装是否错误，松掉固定螺丝后，重启电源是否继续报警 check if the installing of the stepper motor mistake or not, release the fixing screws, restart the controller to check if it is still error
ER84	压脚步进电机堵转 presser foot stepper motor stuck	1、检查步进电机编码器接口是否松动或脱落check the connection of stepper motor encoder plug 2、检查送料机械结构有无卡死或过载情况，恢复后重启检查 check whether the feeding mechanical structure is stuck or overloaded, restart the controller when recover it 3、更换步进电机 change the stepper motor 4、更换电控 change the controller
ER85	1.压脚步进电机电力模块错误代码 presser foot stepper motor power module error code 2.压脚步进电机不正常过电流或过电压 abnormal overcurrent or overvoltage of presser foot stepper motor	1、检查步进电机插座有无松动 check if the stepper motor plug not good connected 2、检查送料机械结构有无咬死，排除故障后重启/复位 check if the feeding mechanical structure is stuck,restart controller after troubleshooting 3、更换电控 change the controller
ER87	压脚步进电机与主轴电机端子插错 the terminals of presser foot stepper motor and spindle motor are wrongly inserted	1、互调两个编码器插头，重新拔插 change the terminals of the stepper motor and spindle motor 2、重启电控，若仍不能正常工作，请更换电控 restart controller, if still not work, change it
ER88	压脚步进电机到不了目标位置 presser foot stepper motor cannot reach the position	1、检查送料机械结构有无卡死或过载情况 check if the feeding mechanical structure is stuck or overloaded 2、检查连杆摆幅值有无超过限位，排除故障后重启/复位 check if the swing amplitude of the connecting rod exceeds the limit,restart after troubleshooting 3、更换电控 change the controller

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ER61	切刀步进电机原点检测错误 slicer stepper motor origin detection error	检查步进安装是否错误，松掉固定螺丝后，重启电源是否继续报警 check if the installing of the stepper motor mistake or not, release the fixing screws, restart the controller to check if it is still error
ER64	切刀步进电机堵转 slicer stepper motor stuck	1、检查步进电机编码器接口是否松动或脱落check the connection of stepper motor encoder plug 2、检查送料机械结构有无卡死或过载情况，恢复后重启检查 check whether the feeding mechanical structure is stuck or overloaded, restart the controller when recover it 3、更换步进电机 change the stepper motor 4、更换电控 change the controller
ER65	1.切刀步进电机电力模块错误代码 slicer stepper motor power module error code 2.切刀步进电机不正常过电流或过电压 abnormal overcurrent or overvoltage of slicer stepper motor	1、检查步进电机插座有无松动 check if the stepper motor plug not good connected 2、检查送料机械结构有无咬死，排除故障后重启/复位 check if the feeding mechanical structure is stuck,restart controller after troubleshooting 3、更换电控 change the controller
ER67	切刀步进电机与主轴电机端子插错 the terminals of slicer stepper motor and spindle motor are wrongly inserted	1、互调两个编码器插头，重新拔插 change the terminals of the stepper motor and spindle motor 2、重启电控，若仍不能正常工作，请更换电控 restart controller, if still not work, change it
ER68	切刀步进电机到不了目标位置 slicer stepper motor cannot reach the position	1、检查送料机械结构有无卡死或过载情况 check if the feeding mechanical structure is stuck or overloaded 2、检查连杆摆幅值有无超过限位，排除故障后重启/复位 check if the swing amplitude of the connecting rod exceeds the limit,restart after troubleshooting 3、更换电控 change the controller