

SV-520/550 INSTRUCTION MANUAL

SV-520/550 系列 操作說明書

Rev – 6B

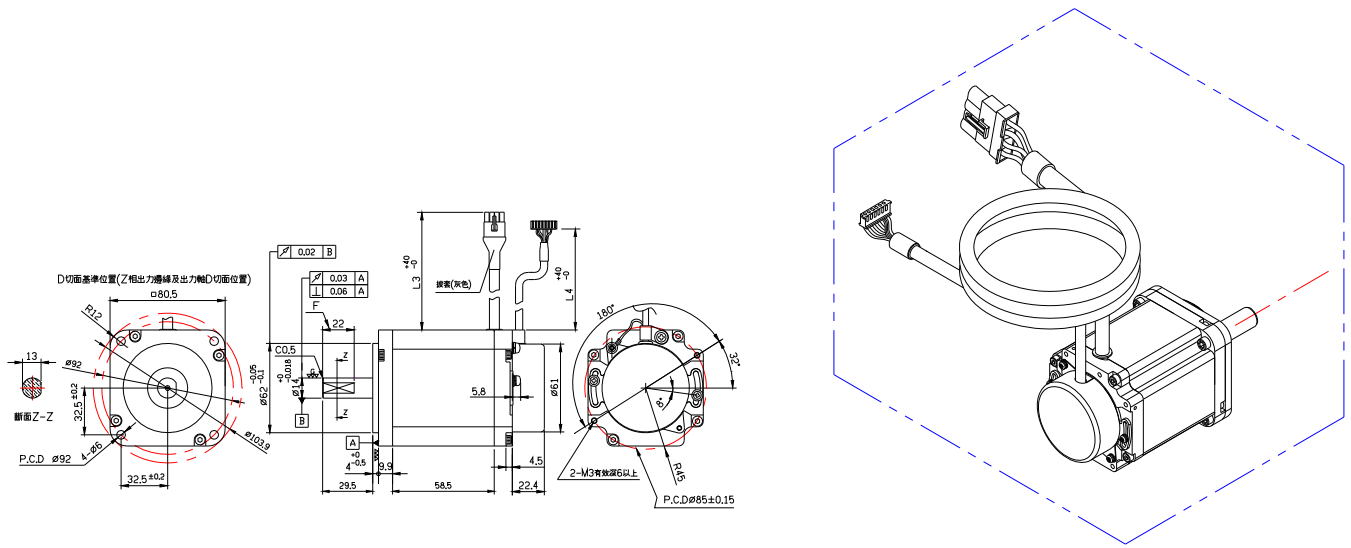
For safe operation

重要安全事項

1. Prior the use of this product, please read the instruction Manual. Keep this Instruction Manual and the user may read it at anytime when necessary.
使用本產品前,請先閱讀本說明書;同時應將此說明書妥善保管以便能隨時查閱 .
2. Before turn on the power, be sure to check the power voltage and phase agreeing with the nameplate that indicated in the control box.
電源開啟前,請先確認電源的電壓與相數,是否與控制箱銘牌相符.
3. Grounding the machine is always necessary for safe and normal operation.
為了正常安全運轉,須安裝地線.
4. Check lubricating oil prior to operation.
操作前,請先確認縫紉機潤滑油充足.
5. Check that rotational direction of the motor is correct prior to operation.
操作前,請先確認馬達轉動方向正確.
6. So as to prevent personal injuries during operation, be careful not to allow your head and hands to come close to the moving parts. Also never try to stop it with external forces.
使用中,切勿將頭,手靠近皮帶輪,皮帶,旋梭,天平等移動部份;同時也不可以用外力,強制停止移動部份.
7. For the following conditions, turn off the power or disconnect the power plug from receptacle.
發生下列情況時,應立即關閉電源開關或者拔下電源插頭:
 - 7.1 For threading needle or replacing bobbin.
穿線和更換旋梭時.
 - 7.2 To plug or unplug any connectors from control box.
插拔控制箱上任何連接線與接頭.
 - 7.3 For maintenance and repairing.
保養與修理時.
 - 7.4 When machine is not at use, inspected or adjusted.
翻抬針車頭,取下皮帶時. 檢查或調整車頭時 或機器不用時
 - 7.5 When lightning and thunder occurs.
打雷閃電時.
8. Repairing, remodeling and adjusting works must only be done by appropriately trained technicians or specially skilled personnel.
本產品的修理,改造,調整;應由受過專門訓練的技術人員來進行.

I. Set up 安裝

1. For motor & control box set up



馬達及控制箱的安裝:

Dimensions of motor & control box as shown in Fig.1

馬達與控制箱的外型尺寸如圖(一)所示:

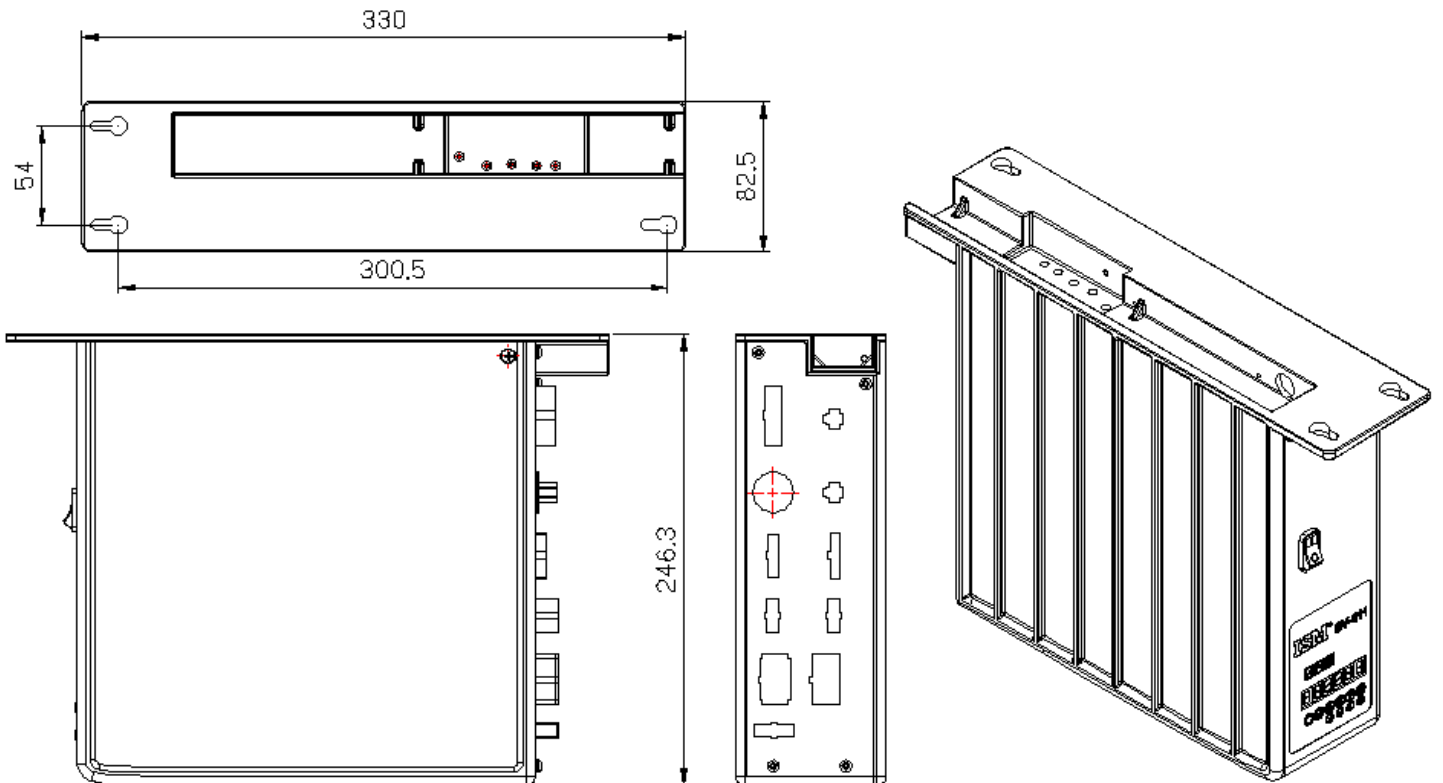


Fig.1 (圖一)

2. Connector position and function

接頭位置與功用:

電路板上備有下列接頭.如圖(二);表(一)為接頭說明;控制箱外部接頭如圖(三),再根據縫紉機的裝置,把連接線接到適當位置.

Circuit boards as Fig. 2 . Table1 is the explanation for the connectors. Connectors for control box external output please refer to Fig 3, then according to the machine, connect it to the respective connectors.

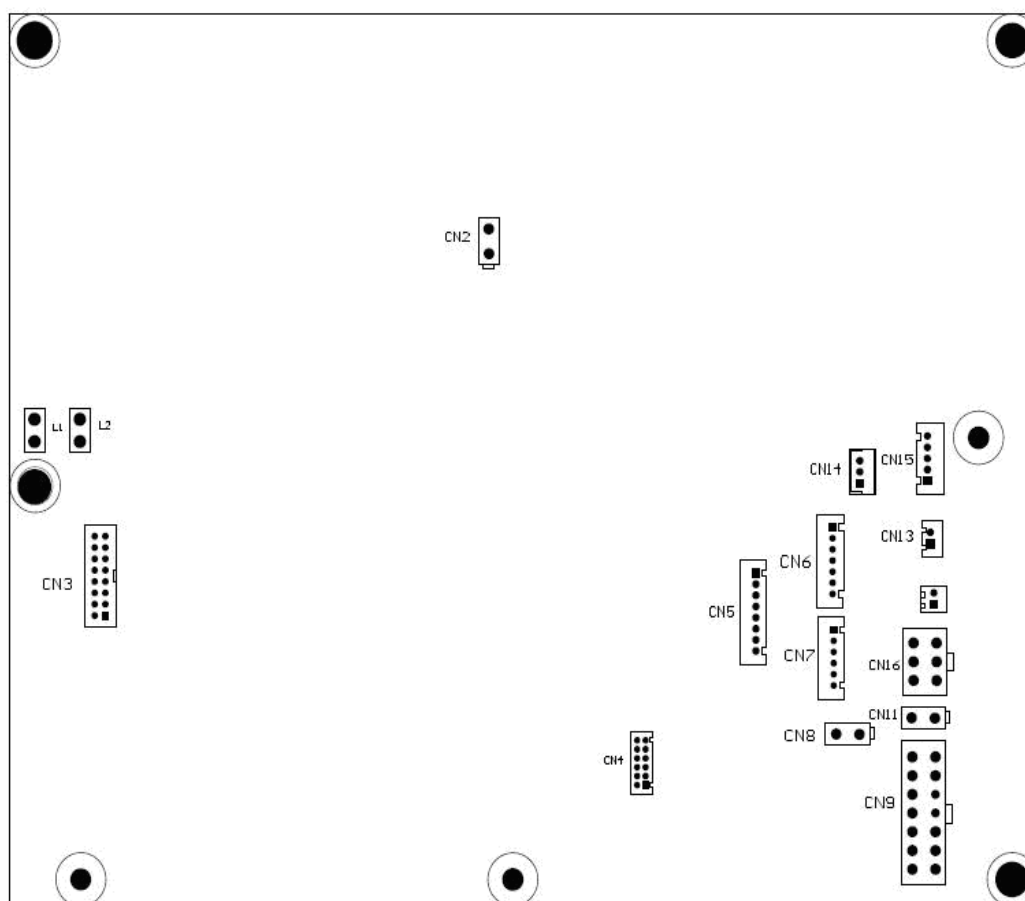


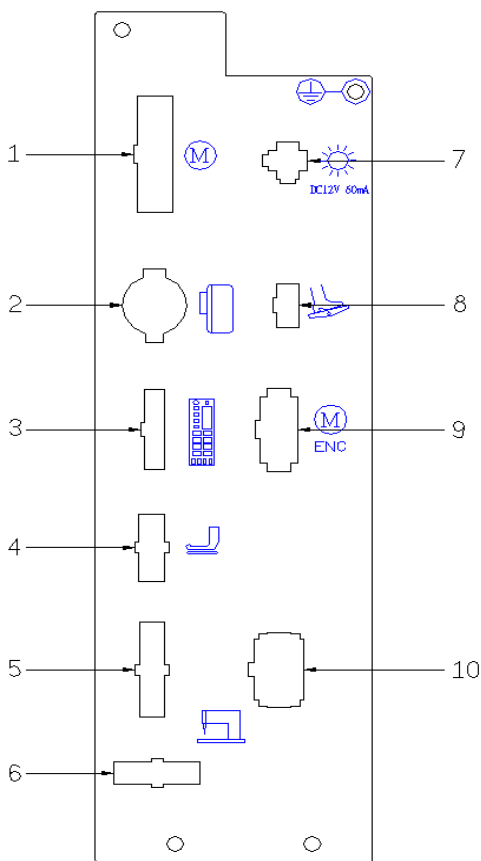
Fig.2 (圖 二)

接頭 Connector	接頭說明 Connectors' description
CN3	前蓋 C02 接頭. Front cover C02 connector
CN5	馬達編碼器接頭 Motor encoder connector
CN4	立式踏板接頭 Standing operation pedal connector Option IN_I: pin 5 & 6 Option IN_A : pin 7 & 8 Option IN_B : pin 9 & 10 Option IN_C : pin 11 & 12
CN13	速度基座接頭 Speed unit connector
CN14	安全開關接頭 Safety switch connector
CN7	同步器接頭 Synchronizer connector
CN6	選針盒接頭 External Panel connector

CN9	車頭功能線圈接頭 Machine functions' connector Option OUT_B : pin 6 & 13 Option OUT_E : pin 2 & 9 Option OUT_F : pin 1 & 8 Option OUT_G : pin 7 & 14 壓腳開關 : pin 4 & 11 Foot lifter switch 回針開關 : pin 5 & 12 Back tack switch
CN11	提壓腳線圈接頭 Foot lifter Solenoid connector
CN16	OPTION_D 接頭 connector Option IN_K : pin 2 & 6 Option IN_L : pin 3 & 6 Option IN_M : pin 4 & 6
CN15	布端檢出器接頭 Material edge sensor connector
CN8	銅殼放電電阻接頭 Foot lifter discharge resistor
CN12	+12V 電源輸出接頭 +12V Power output connector

表 一

Table 1



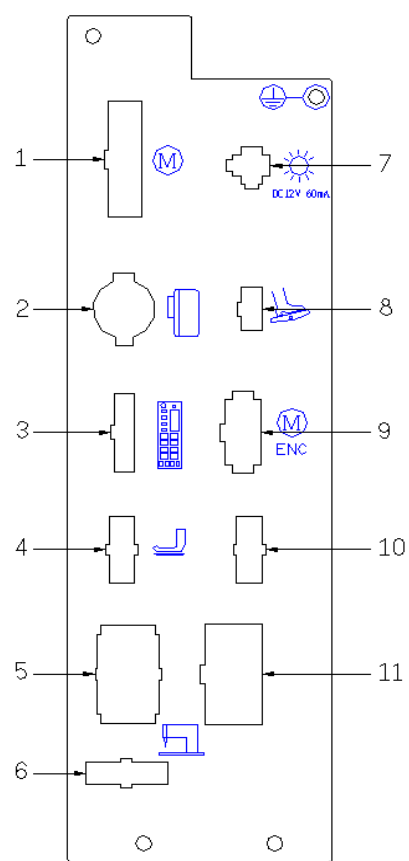
版本 1

Fig.3 (圖 三)

See Fig. 3

如圖(三)所示:

1.Motor power line connector.



版本 2

Fig.4 (圖 四)

See Fig. 4

如圖(四)所示:

1.Motor power line connector.

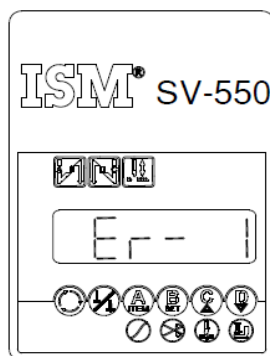
- 1.馬達動力線接頭.
2. Synchronizer connector
- 2.同步器接頭
- 3.Operation panel connector
- 3.選針盒接頭
4. Foot lifter solenoid connector
- 4.提壓腳線圈接頭
- 5.Sewing machine function connector
- 5.車頭功能線圈接頭 1
- 6.Safety switch connector
- 6.安全開關接頭
- 7.DC 12V 60mA output connector
- 7.直流 12V 60mA 輸出接頭
- 8.Pedal sensor connector
- 8.速度基座接頭
- 9.Encoder connector
- 9.馬達編碼器接頭
- 10.Sewing machine function connector2
- 10.車頭功能線圈接頭 2

- 1.馬達動力線接頭.
2. Synchronizer connector
- 2.同步器接頭
3. Operation panel connector
- 3.選針盒接頭
4. Foot lifter solenoid connector
- 4.提壓腳線圈接頭
- 5.Sewing machine function connector
- 5.車頭功能線圈接頭 1
- 6.Safety switch connector
- 6.安全開關接頭
- 7.DC 12V 60mA output connector
- 7.直流 12V 60mA 輸出接頭
- 8.Pedal sensor connector
- 8.速度基座接頭
9. Encoder connector
- 9.馬達編碼器接頭
10. Foot lifter switch connector
- 10.壓腳開關接頭
11. Sewing machine function connector2
- 11.車頭功能線圈接頭 2

II Error message indicator 錯誤訊息顯示:

When abnormal condition occurs, the error message will display as below figure.

當發生不正常狀況時，顯示畫面會將檢測出的錯誤訊息顯示出來。如圖所示:



Error message display:

錯誤訊息顯示:

Error Code	Description of error detected	Items to be checked
Er-1	Synchronizer failure	-Synchronizer connector is loose or line is broken.

Er-2	Motor is not rotating	-Machine head or motor is locked. -Motor power line or encoder line. is broken, or connector is loose. -IPM is failed
Er-3	Power failure	-Voltage is either too high or too low. -Fuse (F2) is burned out.
Er-4	Safety switch failure(chain stitch machine)	-Failure in safety switch connection. -Safety switch failure -Wrong setting for parameter No.35.
Er-5	Speed unit output failure	-Speed unit connector is loose -Speed unit is broken -Connecting rod installation is incorrect
Er-6	CPU error	-Noise interference (Ex. High frequency machine, welding machine) -Eeprom damaged
Er-7	Material edge sensor function is failed.	-Parameter No.42 wrong setting -Material edge sensor not properly adjusted -Connector for material edge sensor is loose - Material not properly settled through machine
Er-8	Setting speed over the motor maximum speed.	-Parameter No.1 setting value is too large -Motor pulley diameter is too small -Motor pulley ratio setting error
Er-9	IPM is failed.	-IPM overheated -Short circuit or low voltage of IPM
Er-10	Solenoid output is overload	-Solenoid resistance is too low - Transistor is failed
Er-11	Synchronizer down signal failure	-Synchronizer connector is loosen or line is broken. -Setting error for parameter No51 & 52
Er-12	Safety switch failure(overlock machine)	-Failure in safety switch connection. -Safety switch failure -Wrong setting for parameter No.35.

請依下表進行確認:

錯誤顯示	錯誤內容	確認項目
Er-1	同步器信號異常	同步器接頭鬆脫,斷線; 皮帶沒有傳動針車頭.
Er-2	馬達不動	針車頭鎖死 馬達鎖死 馬達接頭鬆脫(動力線與編碼器線) IPM 輸出異常
Er-3	電源異常	外部電壓太高,太低 保險絲(F 2)燒斷.
Er-4	安全開關異常(鏈縫車)	安全開關接點異常, 安全開關連接線鬆脫 參數 NO.35 設定錯誤
Er-5	開機時速度基座準位異常	速度基座接頭鬆脫 連接桿安裝不適當, 速度基座故障
Er-6	當機	雜訊源干擾.(高週波 ,電焊機) EEPROM 故障

Er-7	布端檢出功能異常	參數 NO.42 設定錯誤 布端檢出器調整不良 布端檢出器連接線鬆脫,斷線 待車物料擺放位置不適當
Er-8	最高轉速設定超過馬達的最快速度	參數 NO.1 設定值太大 馬達皮帶輪尺寸太小 馬達皮帶輪比設定錯誤
Er-9	功率晶體模組故障	功率晶體模組過熱 功率晶體模組輸出短路 供應功率晶體模組的電壓太低
Er-10	週邊輸出過載	線圈阻抗太低 控制週邊輸出的電晶體故障
Er-11	同步器下停信號異常	同步器接頭鬆脫,斷線; 皮帶沒有傳動針車頭. 參數 No51 & 52 設定錯誤
Er-12	安全開關異常(拷克車)	安全開關接點異常, 安全開關連接線鬆脫 參數 NO.35 設定錯誤


III Setting way 設定方式


1.Parameter setting:


參數設定方式:


①

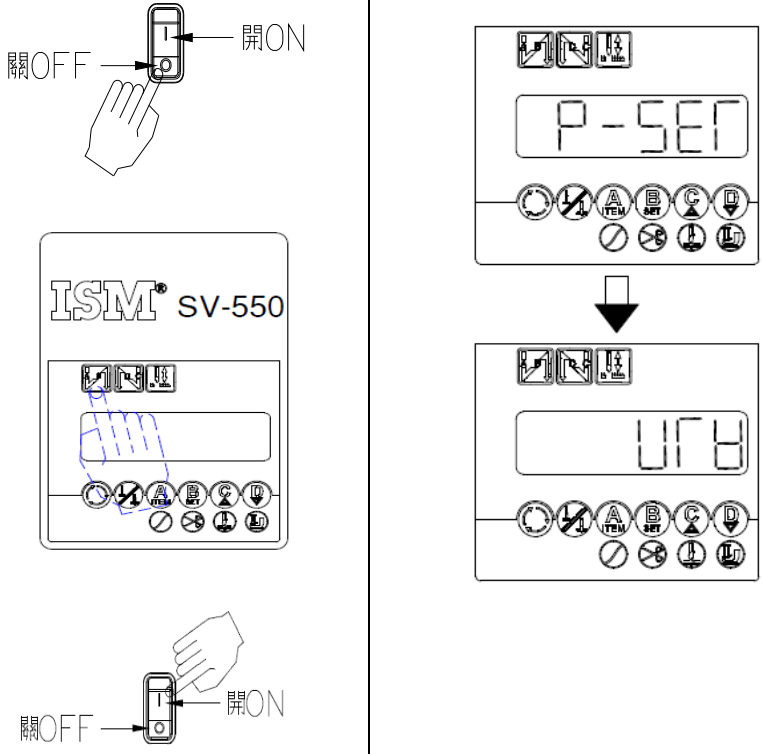
1. Turn OFF the power
關掉電源。

2. Press  key, then turn ON the power simultaneously.
To display “P-SET”, then


release  key, the selected machine type display twinkled.


按住  鍵,同時打開電源.出現 P-SET


放開  鍵.
所選定的針車頭選項閃爍顯示.

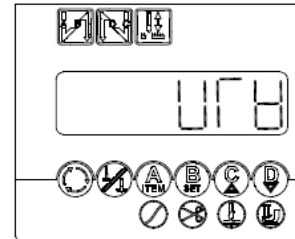
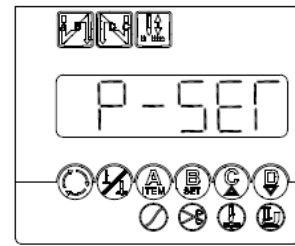
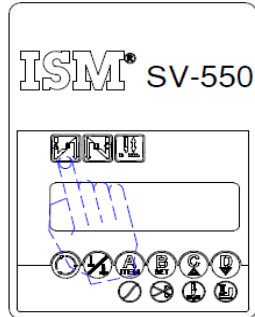
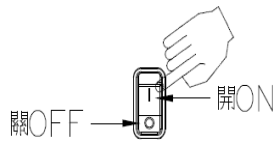


②

1. Turn ON the power.
開啟電源。
2. Press key  exceed 2 second until display “P-SET”, then release  key, the selected machine type display twinkled.

按住  停鍵超過 2 秒，出現 P-SET


放開  鍵;所選定的針車頭選項閃爍顯示。




2.If it is not displayed as shown above, please repeat steps ① or ②


2.如果顯示畫面與上述不同,請重覆步驟 ① or ②

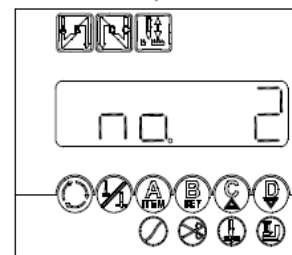
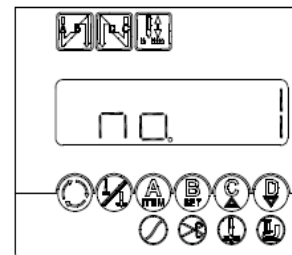
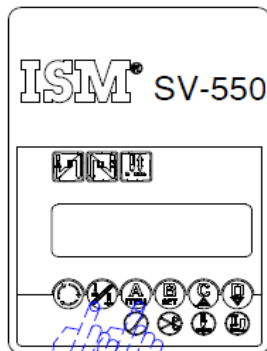
3.


3-1 Press  key, thus parameters no. will be cycle decreased.


3-1.按  鍵,則參數號碼循環遞減.

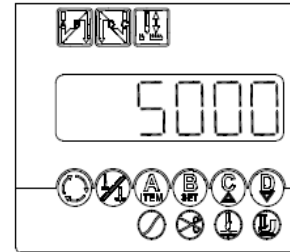
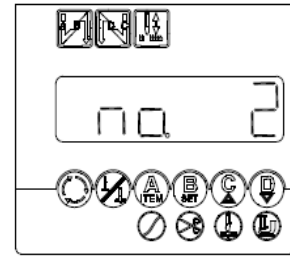
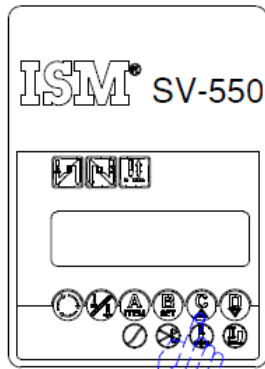
3-2 Press  key, thus parameters no. will be cycle increased.


3-2 按  鍵,則參數號碼循環遞增.




4. Once the modifying parameter has been found, press  key, and the relative parameter setting will display accordingly

4. 找到想要修改之參數號碼, 按  鍵, 則顯示該號碼相對應之參數值.




5. Press  key to increase parameter value.

Press  key to decrease parameter value.


If you keep the key pressed, it will be continuously changing for new parameter values. (Ex. If you want to change parameter No.3 from 135 to

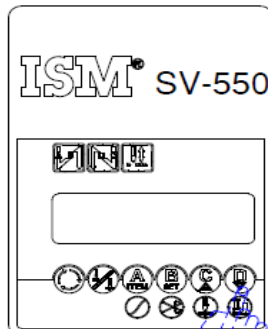
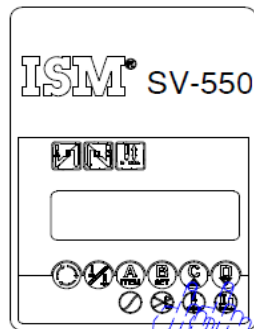
130. Press  key 5 times, and 130 will be displayed on the screen.

5. 按  鍵增加參數值

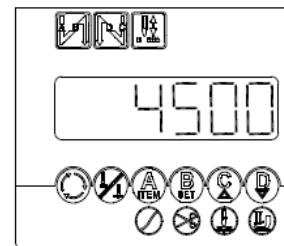
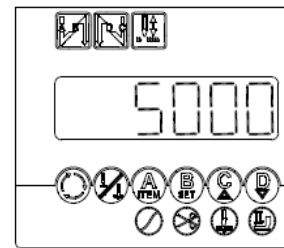
按  鍵減少參數值
持續按住按鍵, 可連續更新參數值.

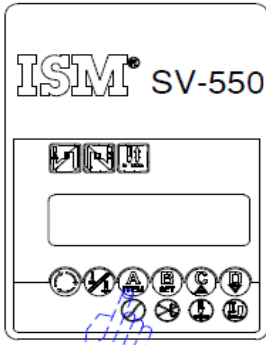
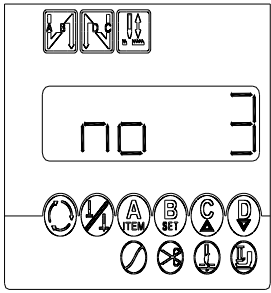
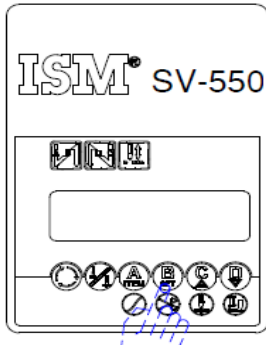
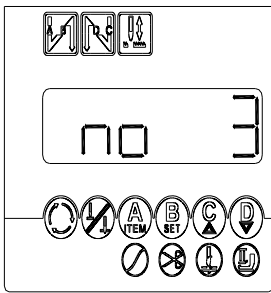
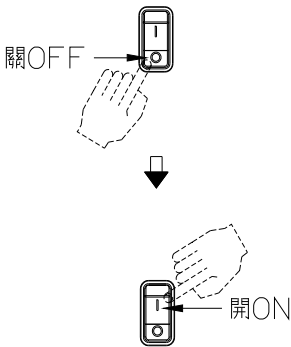
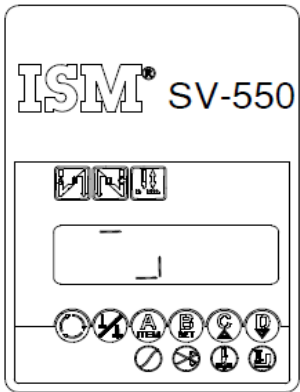
(例: 要將參數 No.2 的值由 5000 修改為 4500. 操作方法為按

 鍵 10 次, 使畫面顯示出 4500)



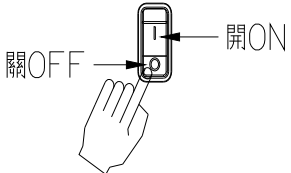
連接 10 次





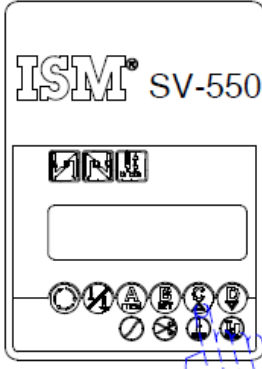
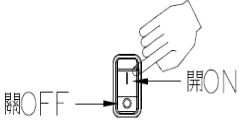
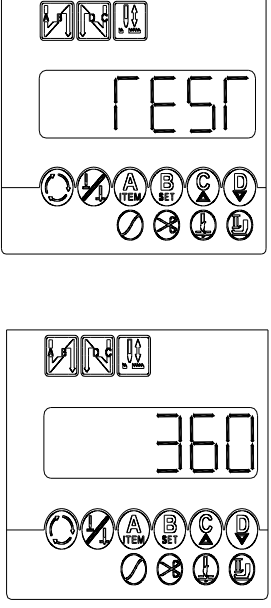
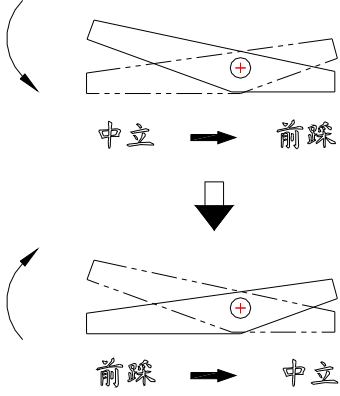
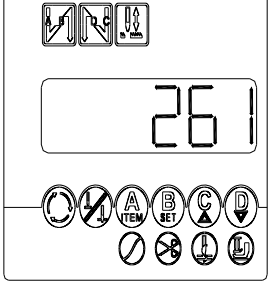


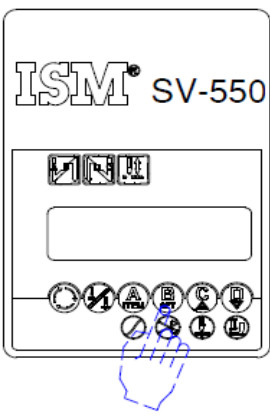
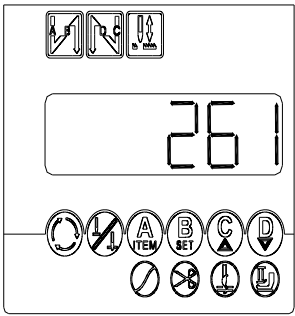
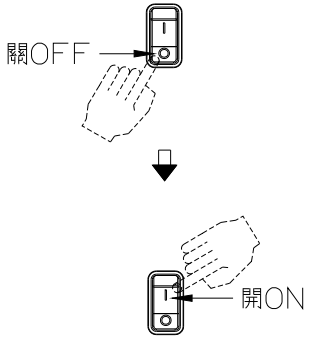
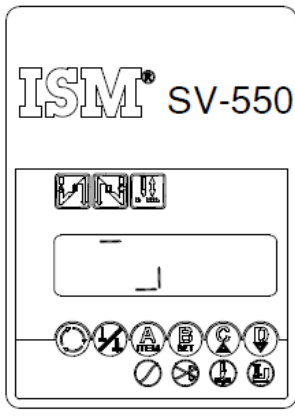
<p>6. Pressing A _{ITEM} key can select for the next parameter no. repeat steps 4-6 to modify parameter value.</p> <p>6. 按 A _{ITEM} 鍵可顯示下一組參數號碼, 重複步驟 4~6 選擇下一組要修改之參數.</p>		
<p>7. Once all specified value has been changed, press B _{SET} key to save. If this procedure is not performed, the specified value will not be updated.</p> <p>7. 當所有參數修改完畢後按 B _{SET} 鍵, 會將修改後之參數內容儲存; 如不進行此步驟, 則無法更新參數內容, 仍以舊參數操作.</p>		<p>畫面閃爍一次 顯示參數號碼</p> 
<p>8. Turn OFF the power then re-start the power, thus it will operate according to new parameter values</p> <p>8. 關掉電源, 再打開電源, 將以最新的參數設定運作.</p>		

2. Motor pulley ratio measurement :

馬達皮帶輪比量測:

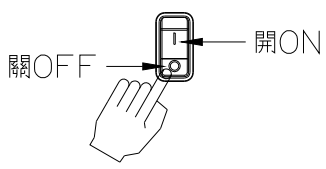
<p>1. Turn OFF the power.</p> <p>1. 關掉電源.</p>		
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<p>2. Press  key, then turn ON the power. Release  key.</p> <p>2. 按住  鍵,同時打開電源.畫面出現 TEST,放開  鍵,畫面出現存在 EEPROM 中的皮帶輪比</p>	 	
<p>3. If the display is not as shown above, please repeat steps 1-2.</p> <p>3. 如果顯示畫面與上述不同,請重覆步驟 1~2.</p>		
<p>4. If the pedal is forwardly pressed, the motor will rotate 7 turns at positioning speed. After the motor stops, the motor pulley ratio will be displayed. (Sewing machine 360°=motor ? degrees). The step 4 can be repeated to confirm.</p> <p>4. 踏板前踩一下,馬達以定位速度運轉7圈馬達停止後,畫面會顯示所量測的馬達皮帶輪尺寸比(針車頭一圈 360 度=馬達?度)可以重覆步驟 4 ,再進一步確認.</p>		

<p>5. Press B SET key to save. If this procedure is not performed, it will remain as the old values.</p> <p>5.按 B SET 鍵,會將此一皮帶輪比儲存;如不進行此步驟,則無法更新內容 .</p>		<p>畫面閃爍一次 顯示參數號碼</p> 
<p>6. Turn OFF the power then re-turn ON the power, It will operate according to new pulley ratio values .</p> <p>6.關掉電源,再打開電源,將以最新的馬達皮帶輪比設定運作.</p>		

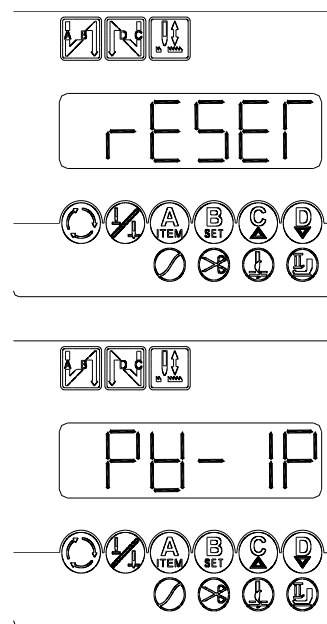
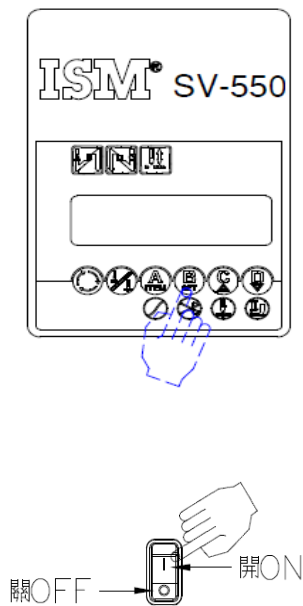
3. Select the machine type :

選擇針車頭選項:

<p>1. Turn OFF the power.</p> <p>1.關掉電源.</p>		
--	---	--

2. Press **B SET** key simultaneously, then turn ON the power, until rESET displayed then release the key.

2. 按住 **B SET** 鍵, 同時打開電源, 直到畫面出現 rESET 才將按鍵放開出現 PW-IP 畫面.




3. If it is not displayed as shown above, please repeat steps 1-2.

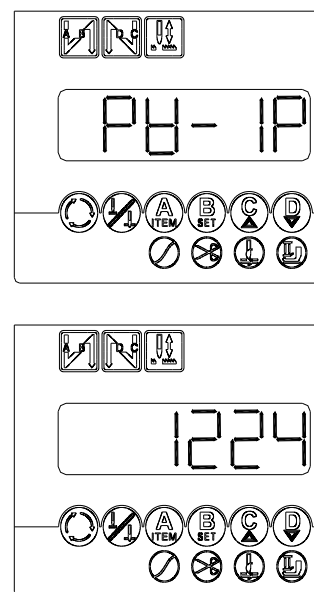
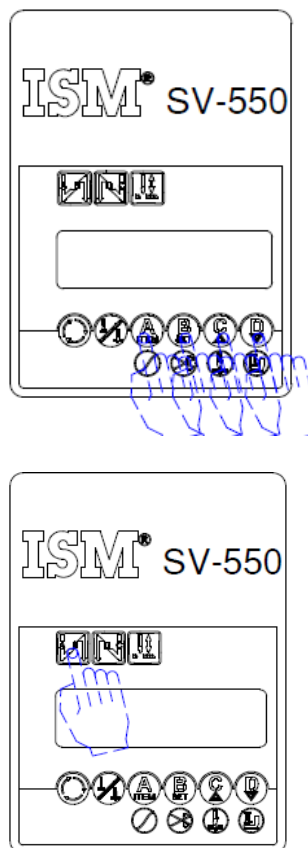
3. 如果顯示畫面與上述不同, 請重覆步驟 1~2.

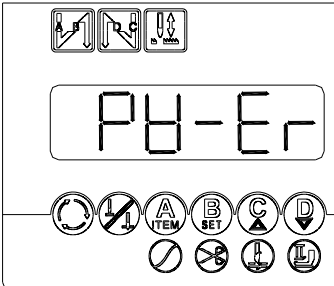
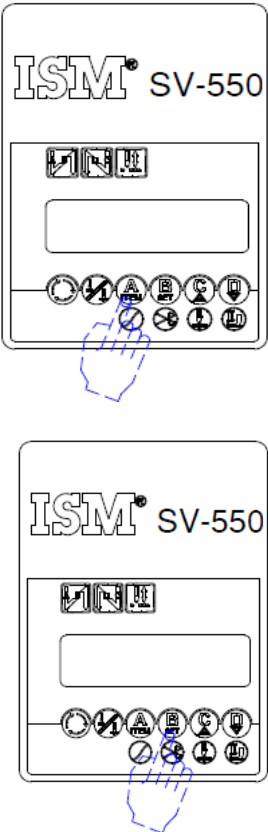
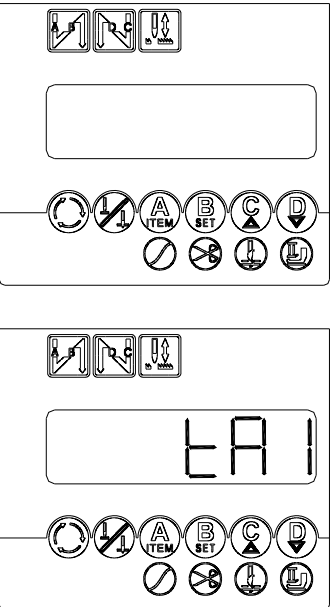
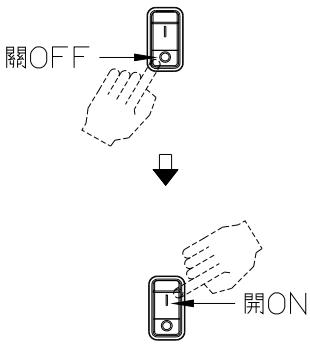
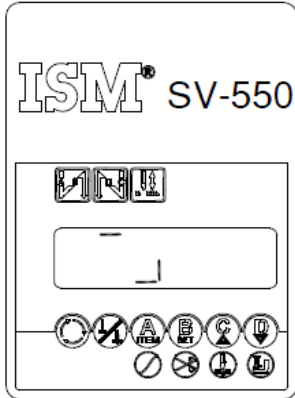
4. Use A, B, C, D key to key in the password. And enter to confirm.

4. 利用 A, B, C, D 鍵將密碼輸入

再按  鍵做確認. 不需要

密碼的群組直接按  即可

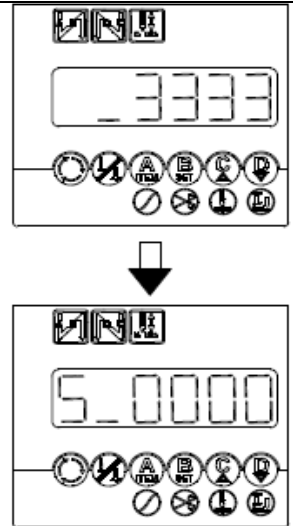
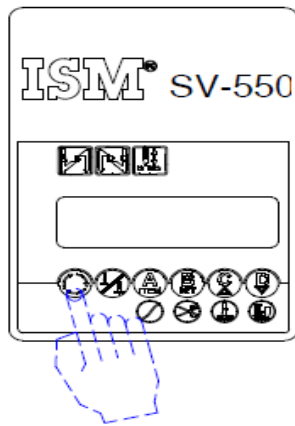


<p>5.If the password is correct, the 1st sewing machine head choice will be displayed. If the password is incorrect, the "PW-ER" will be displayed. Please repeat step 4.</p> <p>5.如果密碼正確會出現第一個針車頭選項, 如果密碼錯誤則出現 PW-ER 請重覆步驟 4.</p>		
<p>6.Press A ITEM key to select machine type, then press B SET key .</p> <p>6.按 A ITEM 鍵,選擇要設定的針車模式後,按下 B SET 鍵.</p>		
<p>7.Turn OFF the power, then turn ON the power again. It will operate according to the manual's instruction initial value.</p> <p>7.關掉電源,再打開電源,將以說明書上參數的初始值來運作.</p>		

4. Switch the function screen
功能畫面切換:

1.在平常工作模式，畫面顯示針數

按下  鍵，畫面出現 S_0000 顯示針車轉速畫面。



2.在平常工作模式，畫面顯示針車

轉速，按下  鍵，畫面出現 F_0000 功能選擇畫面。

Function display

- : 表示致能
- : 表示無功能



鍵對應慢速啟動功能



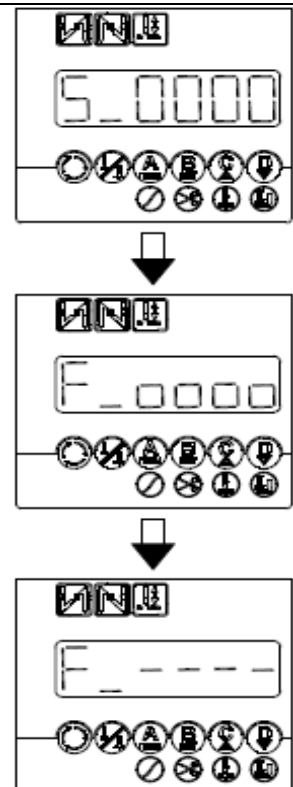
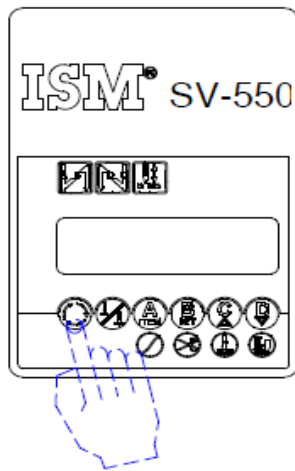
鍵對應切線功能




鍵對應撥線功能

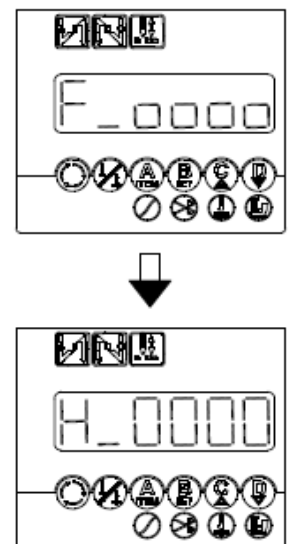
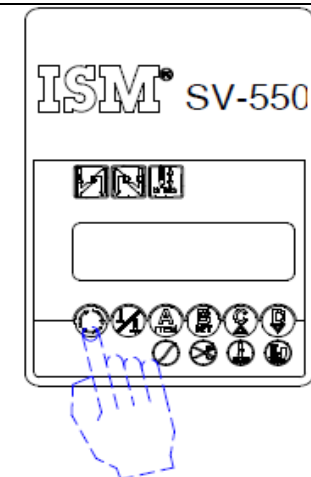






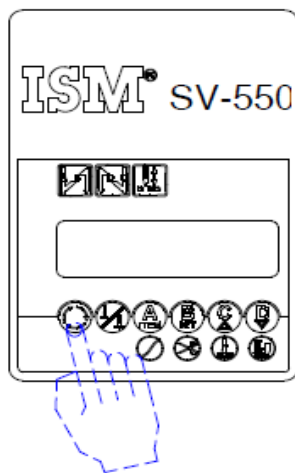
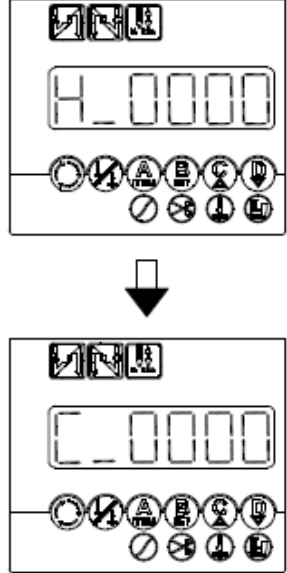


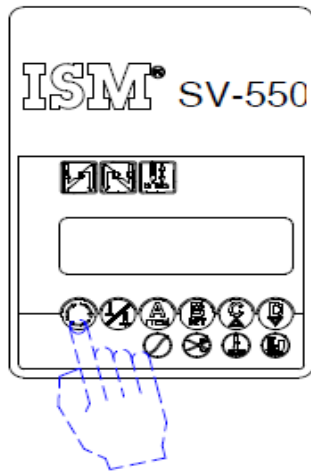
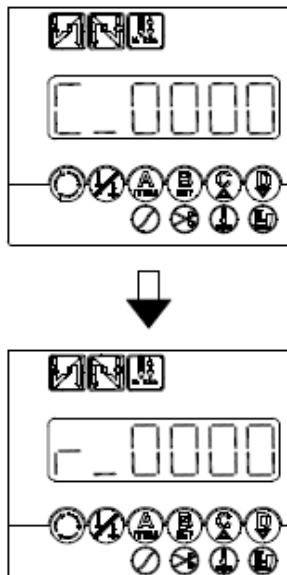

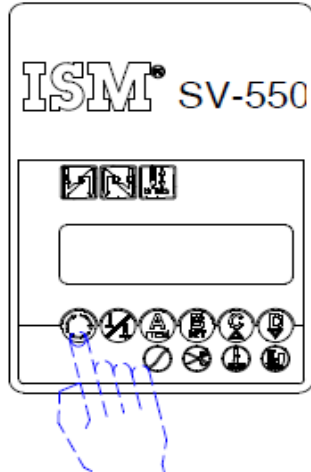
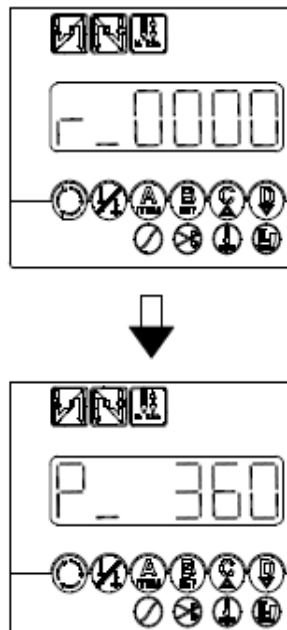
鍵對應壓腳功能



3.在平常工作模式，當畫面顯示功

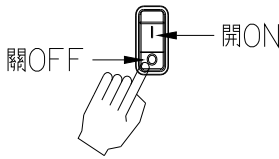




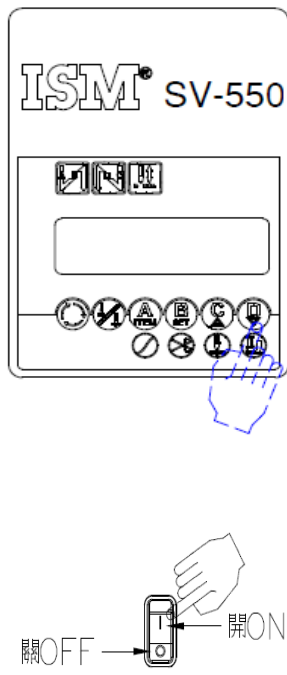
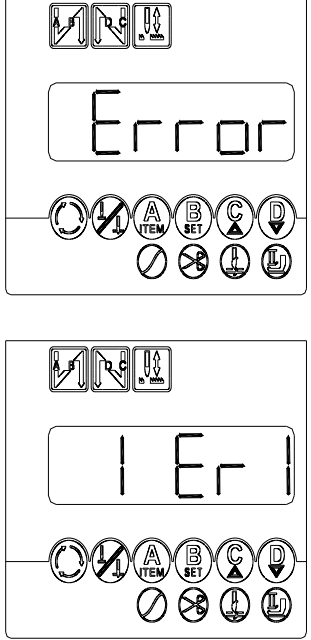


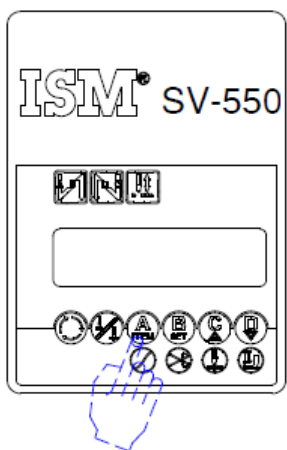
能選擇時，按下  鍵，畫面出現 H_**** 顯示單件計針畫面，計件值加一時會自動歸零。



<p>4. 在平常工作模式，當畫面顯示</p>  <p>畫面顯示單件時，按下</p> <p>鍵，畫面出現 C_**** 顯示計件值。</p> <p>按  鍵 → 計件值增加 1</p> <p>按  鍵 → 計件值減少 1</p> <p>按  鍵 2 秒 → 計件值歸零</p>		
<p>5. 在平常工作模式，當畫面顯示</p>  <p>計件值時，按下</p> <p>鍵，畫面出現 r_****顯示馬達運轉時間畫面。</p> <p>按  鍵 2 秒，馬達運轉時間歸零。</p>		
<p>6. 在平常工作模式，畫面顯示馬達</p>  <p>運轉時間，按下</p> <p>鍵，畫面出現 P_360 顯示皮帶輪比值畫面。</p>		

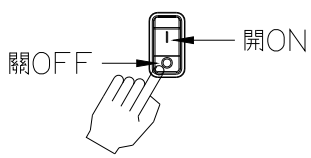
5. Historical error message display




錯誤歷史顯示:

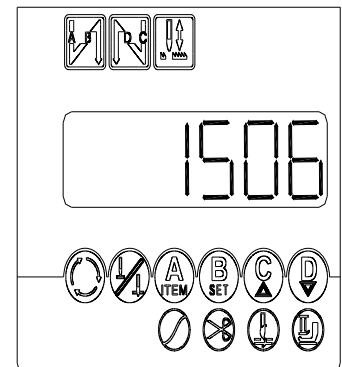
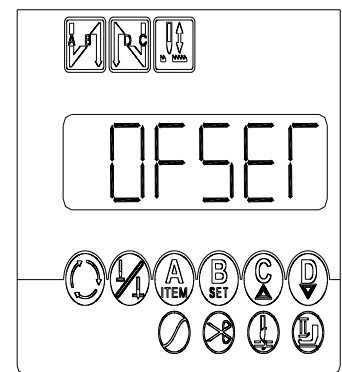
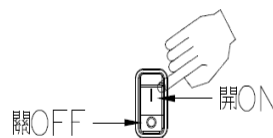
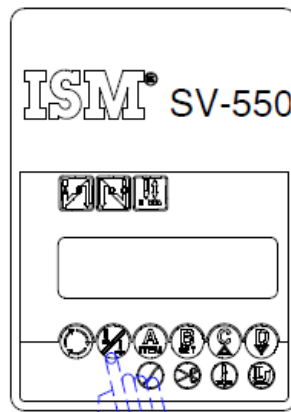
<p>1. Turn OFF the power.</p> <p>1. 關掉電源.</p>		
<p>2. Press  key, then turn ON the power simultaneously and display "ERROR"</p> <p>2. 按住  鍵,同時打開電源.出現 ERROR</p> <p>2.1 Release  key and will display recent error message.</p> <p>2.1 放開  鍵顯示畫面出現最後出現的錯誤訊息代碼</p>		
<p>3. Press  key to cycle display recent 6 error messages.</p> <p>3. 按  鍵最近所發生的 6 次錯誤訊息</p>		

6. Pedal sensor neutral point setting mode

速度基座中立點設定模式:

<p>1. Turn OFF the power</p> <p>1 關掉電源.</p>		
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2. Speed unit (Pedal sensor) pedal sensor in the neutral point.
- Press  key, then turn ON the power simultaneously and display “OFFSET”.
2. 速度基座置於中立點，
- 按住  鍵，同時打開電源。出現 OFFSET
3. Release  key, and will display the pedal sensor value that was stored in EEPROM.
- 3 放開  鍵，會出現儲存於 EEPROM 中速度基座的讀值；
4. Once pressed  key, read the pedal sensor again. If the value between 1340~1790, press  key to save the value.
4. 每按一次  鍵則會重新讀取一次速度基座，當出現的值介於 1340~1790，則按下  鍵儲存。
5. If always displays “ERROR” that means the pedal sensor neutral point offset is too much. The pedal sensor mechanical neutral point must be adjusted then repeat step 4.
5. 若一直出現 ERROR 表示速度基座中立點的機構位置偏離太多，必須先調整速度基座中立點的機構位置，再重復上述步驟 4 的動作。



IV SV-520/550 series Control box parameter list:

[SV-520/550 系列參數一覽表](#)

No 項目	Item 內容	Range 範圍	Remarks 備註
1	Sewing machine maximum speed 針車最高速度	200spm ~ 8000spm	50 rpm/step
2	Sewing machine medium speed 針車中速	200spm ~ 8000spm	50spm / step
3	Sewing machine positioning speed 針車定位速度	100spm ~ 250spm	1spm / step
4	Sewing machine trimming speed 針車切線速度	100spm ~ 250spm	1spm / step
5	The speed of start auto back tack 開始自動倒縫速度	500spm ~ 2500spm	10spm /step
6	Soft start speed 慢速啟動速度	250spm ~ 2000spm	10spm /step
7	Soft start stitches 慢速啟動針數	0 ~ 19 stitches	
8	Condensed sewing speed / End auto back tack speed 密縫速度 / 結束自動倒縫速度	500 ~ 2500spm	10spm /step
9	End condensed stitches' number 結束密縫針數	0 ~ 99 stitches	
10	Stitches' number that between condensed sewing and trimming 密縫結束後切線執行前車縫針數	0 ~ 19 stitches	
11	Foot lifter type 壓腳型式	SOL: Solenoid type 線圈式 AIR: Pneumatic type 汽閥式	
12	Foot lifter control mode 壓腳控制模式	PFL: Pedal controls foot lifter. 踏板控制壓腳 TAFI: auto foot lifts after trimming 切完線後自動抬壓腳 AFL: Auto foot lifting after positioning 馬達定位停自動壓腳 TFL: Pedal controls foot lifter after trimming 切完線後才可以踏板控制抬壓腳 SFL: Auto foot lifting (Material edge sensor as output control) 自動壓腳(布端檢出器控制輸出) AFL2: Auto foot lifting after trimming. (It's effective even pedal forward) 切完線後自動抬壓腳(踏板保持前踩狀態時仍有效)	
13	Delay time after foot lifter is down 壓腳放下後延遲時間	100 ~ 2500 ms	10 ms / step
14	Confirming time for foot lifter acting level 壓腳動作準位確認時間	10 ~ 1000 ms	10 ms / step
15	Foot lifter duty 壓腳控制責任週期	0 ~ 99%	1 % / step
16	Foot lifter full duty output time 壓腳全壓控制輸出時間	100 ~ 1000 ms	10 ms / step

17	Thread trimming mode 切線模式	OFF : No thread trimming 無切線 LOCK : lockstitch thread trimming 平車切線 LU2 : LU2220 thread trimming LU2220 切線 LU1 : LU1520 thread trimming LU1520 切線 LU:Other LU machine thread trimming 其他 LU 機型切線 US639 : US63900 thread trimming US63900 切線 UT : Needle up trimming 上停切線 (上切刀) AIR:Needle up trimming (AIR BLOW) 上停切線 (吹氣式) UT2:Needle down trimming (trimming & wiping together) 上停切線(切線與撥線一起動作)	
18	Thread trimming delaying time 切線延遲時間	0 ~ 200 ms	10 ms / step
19	Thread trimming acting time 切線動作時間	0 ~ 1000 ms	10 ms / step
20	Thread wiping delaying time 撥線延遲時間	0 ~ 300 ms	10 ms / step
21	Thread wiping acting time 撥線動作時間	0 ~ 2500 ms	10 ms / step
22	Foot lifter delaying time 壓腳延遲時間	0 ~ 2500 ms	10 ms / step
23	Thread wiping output control 撥線輸出控制	0 : No output thread wiping 不輸出撥線 1 : Output thread wiping 輸出撥線 2 : Output thread wiping when foot lifter active 輸出撥線,切完線後與壓腳同動	
24	Motor rotating direction 馬達轉向	CCW : Counterclockwise 逆時針 CW : Clockwise 順時針	
25	A_ code back tacking compensation A_CODE 回針線圈動作補正角度	0 ~ 720 °	5 ° /step
26	B_ code back tacking compensation B_CODE 回針線圈釋放補正角度	0 ~ 720 °	5 ° /step
27	C_ code back tacking compensation C_CODE 回針線圈釋放補正角度	0 ~ 720 °	5 ° /step
28	The curve slope of pedal stroke vs. motor rotating speed 踏板行程對應馬達速度曲線	0 ~ 4 Bigger value means smaller curve slope 數值越大曲線斜率越小	
29	Motor type select 馬達型式選擇	6535 : 650 W / 3500 rpm 5535 : 550 W / 3500 rpm 5560 : 550 W / 6000 rpm 5550 : 550 W / 5000 rpm 6560 : 650 W / 6000 rpm 4550 : 450 W / 5000 rpm 5070 : 500 W / 7000 rpm 3570 : 350 W / 7000 rpm 啟動電流大小順序 : 3570 < 5070 < 4550 < 6560 < 5550 < 5560 < 5535 < 6535	

30	The pedal stroke adjustment for motor rotating 馬達開始轉動的踏板行程調整	50 ~ 90 (Pedal neutral = 40, LD1 lighting) (中立點參考值 = 40, LD1 點亮)	
31	Pedal stroke adjusts for motor accelerating 馬達開始加速的踏板行程調整	70 ~ 110	
32	Pedal stroke adjusts for foot lifter acting 壓腳開始動作的踏板行程調整	10 ~ 35	
33	Pedal stroke adjusts for start thread trimming 切線開始動作的踏板行程調整	3 ~ 30	
34	Standing type pedal operating choice 立式作業選擇	OFF : Normal speed pedal unit 速度基座正常操作 PK70 : For JUKI standing operation PK70 type 配合 JUKI 立式作業 PK70 PKSW : Standing pedal operation, the speed is fixed (low speed & high speed) 立式作業,速度固定(低速&高速) PK71 : For YHH standing operation PK71 type 配合永輝興立式作業 PK71	
35	Safety switch type 安全開關型式	N.O : Normal open switch 常開接點 N.C : Normal close switch 常閉接點	
36	In auto test mode, motor running time adjustment 自動測試模式下,馬達運轉時間調整	100 ~ 20000 ms	100 ms / step
37	In auto test mode, motor stopping time adjustment 自動測試模式下,馬達停止時間調整	100 ~ 20000 ms	100 ms / step
38	Back tacking switch function 回針按鍵功能	BTSW : Control back tacking solenoid 控制回針線圈 NDUP : Control back tacking solenoid when motor runs, and as needle up switch when motor stops 運轉中控制回針,靜止時提針至上停 DSIN : Control back tacking solenoid when motor runs, non-continuously inching during motor stops 運轉中控制回針線圈,靜止時不連續補針 CNIN : Control back tacking solenoid when motor runs, continuously inching during motor stops 運轉中控制回針線圈,靜止時連續補針 RFSS : Reverse feed stitching function is effective both during sewing and stopping 途中倒縫(車縫中&停止時均有效) UPBT : Control back tacking solenoid only in up position 控制回針線圈只在上停點有效 SHOT : Control back tacking solenoid, No.74 decide the output pulse width. 控制回針輸出脈波寬由 NO.74 決定 FLIP : Control back tacking solenoid, by flip-flop type output 以 flip-flop 方式控制回針線圈	
39	Stitches' number in reverse feed stitching 途中倒縫針數	0 ~ 19 stitches	
40	Trimming function in the reverse feed stitching 途中倒縫切線功能	OFF: Ineffective 無功能 ON: Effective 有此功能	

41	Execute auto thread trimming after end fixed stitches' number sewing process 定寸縫工程結束後,自動切線功能	OFF: Ineffective ON: Effective	無功能 有此功能	
42	Material edge sensor function 布端檢出器功能	OFF: Ineffective ON: Effective	無功能 有此功能	
43	Material edge sensor stitches' number 布端檢出器針數	0 ~ 250 stitches 針		
44	Use material edge sensor to process trimming function 利用布端檢出器進行切線功能	0 : No such function. 無功能 1 : Auto trimming after execute the step-1 stitches. 執行完第一段布端檢出器針數 , 自動接著做切線 2 : Auto trimming after execute the step-2 stitches. 執行完第二段布端檢出器針數 , 自動接著做切線 3 : Auto trimming after execute the step-3 stitches. 執行完第三段布端檢出器針數 , 自動接著做切線 4 : Auto trimming after execute the step-4 stitches. 執行完第四段布端檢出器針數 , 自動接著做切線		
45	Auto needle up positioning when power on 開機自動上停	OFF: Ineffective ON: Effective	無功能 有此功能	
46	Backtack switch protect time 回針按鍵保護時間	0 ~ 30 seconds		
47	To lock the pedal forward function before finish trimming process 切線完成前踏板前踩互鎖功能	OFF: Ineffective ON: Effective	無功能 有此功能	
48	Sewing machine reversed revolution function after thread trimming processed 切線完成後車頭反轉功能	OFF: Ineffective ON: Effective	無功能 有此功能	
49	Sewing machine reversed revolution angles after thread trimming processed 切線完成後車頭反轉角度	0 ~ 250°		1° / step
50	The delaying time after finished thread trimming but before sewing machine reversed revolution. 切線完成後車頭反轉前延遲時間	0 ~ 2500 ms		10 ms / step
51	Virtual needle down positioning function 虛擬下停功能	OFF: Ineffective ON: Effective	無功能 有此功能	
52	The angles between virtual needle down positioning point and needle up signal 虛擬下停點,由上停信號開始點起算	0 ~ 250°		1° / step
53	The needle positioning function of starting sewing 起縫定針功能	OFF: Ineffective ON: Effective	無功能 有此功能	
54	The needle positioning angles of starting sewing 起縫定針角度	0 ~ 250°		1° / step
55	The starting angle of trimming action (count from the needle down position and only effective in LU trimming mode) 切線動作開始角度(下停開始起算,只在 LU 切線模式有效)	0 ~ 250°		1° / step
56	The continuous angles of trimming action (count from the needle down position and only effective in LU trimming mode) 切線動作持續角度(只在 LU 切線模式有效)	0 ~ 250°		1° / step

57	The tension release starts acting angles (count from the needle down position and only effective in LU trimming mode) 紗拉組開始動作角度(下停開始起算,只在 LU 切線模式有效)	0 ~ 250°	1° / step
58	The tension release continuous acting angles (only effective in LU trimming mode) 紗拉組動作持續角度(只在 LU 切線模式有效)	0 ~ 250°	1° / step
59	The tension release continuous acting time (count from the needle up position and only effective in LU trimming mode) 紗拉組動作持續時間(上停信號開始動作起算,只在 LU 切線模式有效)	0 ~ 1250 ms	5 ms / step
60	The function choice of Option IN_A Option IN_A 功能選擇	OFF : No function 無功能 DSCT: Cancel thread trimming for one time 單次取消切線 DSBT: Cancel auto back tacking for one time 單次取消自動回針 DSCN : Cancel condensed stitching for single time 單次取消密縫 NDUP : Needle up switch 提針到上停 HALF : Half stitch inching 半針補針 ONE : One stitch inching 一針補針	(it's only effective when No.34=OFF) No.34 = OFF 時才有效
61	The function selection for Option IN_B Option IN_B 功能選擇		
62	Option IN_P 功能選擇 (只有 SV-520 有效) The function selection for option IN_P (only SV-520 effective)	0 : Stop switch 停止按鍵 1 : Stop switch (flip-flop type) , output OUT_E when active 停止按鍵(FLIP-FLOP 型式), 動作時同時輸出 OUT_E 2 : Cancel automatic backtack switch , output OUT_E when active 取消自動回針按鍵, 動作時同時輸出 OUT_E	
63	Motor stop before executes EBT 執行 EBT 之前馬達是否停止	OFF : ineffective 馬達不會停止,直接作 EBT ON : effective 馬達會停止一段時間(參數 NO.64 設定)再接 EBT	
64	Motor stops time before executes EBT (only effective when No.63=ON) 執行 EBT 之前馬達停止時間 (只在 NO.63=ON 時有效)	20 ~ 1500 ms	10 ms / step
65	Breaking thresfold 煞車臨界值	130-250	
66	Slight breaking action time 微小煞車動作時間	10-50ms	
67	Slight breaking speed 微小煞車動作臨界速度	200-1700rpm	
68	Slight breaking function 微小煞車動作	OFF: Ineffective 無功能 ON: Effective 有此功能	
69	The Option OUT_A acts stitches' number after material edge sensor on 布端檢出器開始動作 Option OUT_A 動作針數	0 ~ 99 stitches	

70	The Option OUT_A delays stitches' number after material edge sensor off 布端檢出器結束動作 Option OUT_A 延遲針數	0 ~ 99 stitches	
71	The acts stitches' number after the Option OUT_A delays stitches' number & material edge sensor off 布端檢出器結束動作 Option OUT_A 延遲後動作針數	0 ~ 99 stitches	
72	The Option OUT_B acts stitches' number after material edge sensor on 布端檢出器開始動作 Option OUT_B 延遲針數	0 ~ 99 stitches	
73	The Option OUT_B delays stitches' number after material edge sensor off 布端檢出器結束動作 Option OUT_B 延遲針數	0 ~ 99 stitches	
74	The Option OUT_B acts time Option OUT_B 動作時間	0 ~ 250 ms	
75	The Option OUT_C acts stitches' number after material edge sensor on 布端檢出器開始動作 Option OUT_C 動作針數	0 ~ 99 stitches	
76	The Option OUT_C delays stitches' number after material edge sensor off 布端檢出器結束動作 Option OUT_C 動作針數	0 ~ 99 stitches	
77	The Option OUT_D acts stitches' number after material edge sensor on 布端檢出器開始動作 Option OUT_D 延遲動作針數	0 ~ 99 stitches	
78	The Option OUT_D delays stitches' number after material edge sensor off 布端檢出器結束動作 Option OUT_D 持續動作針數	0 ~ 99 stitches	
79	The function choice of Option OUT_A Option OUT_A 功能選擇	0 : No output 無輸出 1 : Depend on the setting stitches' number output 根據所設定針數輸出 2 : Depend on the setting stitches' number output when foot lifter acts 根據所設定針數輸出 & 舉壓腳動作時輸出 3: No output when motor stop 馬達停止時無輸出	
80	The function choice of Option OUT_B Option OUT_B 功能選擇	0 : No output 無輸出 1 : Depend on the setting stitches' number output (Pedal control speed) 根據所設定針數輸出(踏板控制速度) 2 : Depend on the setting stitches' number output (material edge sensor starts & during motor medium speed) 根據所設定針數輸出(布端檢出器開始&結束動作時馬達為中速)	
80	The function choice of Option OUT_B Option OUT_B 功能選擇	3 : Depend on the setting stitches' number output (material edge sensor ends & during motor medium speed) 根據所設定針數輸出 (布端檢出器結束動作時馬達為中速)	

81	The function choice of Option OUT_C Option OUT_C 功能選擇	0 : No output 無輸出 1 : Depend on the setting stitches' number output (Pedal control speed) 根據所設定針數輸出(踏板控制速度) 2 : Depend on the setting stitches' number output (material edge sensor ends & during motor medium speed) 根據所設定針數輸出(布端檢出器結束動作時馬達為中速) 3 : Auto sewing the setting stitches without pedal press 踏板不需要前踩也可以自動執行所設定的針數	
82	The function choice of Option OUT_D Option OUT_D 功能選擇	0 : No output 無輸出 1 : Depend on the setting stitches' number output 根據所設定針數輸出 2 : Depend on the setting stitches' number output when foot lifter acts 根據所設定針數輸出 & 舉壓腳動作時輸出 3 : Depend on the setting stitches' number output (keeps acting even motor stops) 根據所設定針數輸出(馬達停止時仍保持動作)	
83	The control solenoid output cycle choice of material edge sensor 布端檢出器控制線圈輸出週期結束選擇	0 : Option OUT_A 1 : Option OUT_B 2 : Option OUT_C 3 : None	
84	The priority between material edge sensor on & pressing pedal forward 布端檢出器開始動作與踏板前踩優先權選擇	0 : The material edge sensor must be acted before pressing pedal 布端檢出器須在踏板前踩之前動作 1 : Pedal condition is immediate effective when material edge sensor on 布端檢出器開始動作時踏板的狀態立刻有效 2 : Pressing pedal is prior. 踏板前踩優先	
85	Cancel the thread trimming function choice when pedal is heeled. 取消踏板後踩切線功能選擇	OFF : With the thread trimming function when pedal is heeled 有踏板後踩切線功能 ON : Cancel the thread trimming function when pedal is heeled. And just the foot lifting function is effective. 取消踏板後踩切線功能只做舉壓腳動作	

86	Special function choice 特殊功能選擇	0 : No special function 沒有特殊功能 1 : LB2 enable, MTJ=OFF LB2 致能 , MTJ = OFF 2 : LB2 enable, MTJ=ON LB2 致能 , MTJ = ON 3 : BAF function BAF 功能 4 : LU1521 function LU1521 功能 5 : CA1 function CA1 功能 6 : SAS1 function SAS1 功能 7 : BASF function BAFS 功能 8 : Manual one- shot function 踏板控制 one-shot 針數車縫功能 9 : Automatic one-shot function 自動 one-shot 針數車縫功能 10 : edge sensor with re-cycle function 布端檢出器有再次循環功能 11: auto sewing when use PKSW PKSW 控制自動車縫功能 12: jy function Jy 特殊功能 13: FW740 function FW740 特殊功能 14: FW730 function FW730 特殊功能 15: Accelerating command adjustment 加速指令調整	
87	No synchronizer operation mode 沒有同步器操作模式	OFF : ineffective . 無功能 ON : effective 有此功能 (不會顯示 ER-1)	
88	The speed margin of executing needle positioning 執行定位的速度臨界值	80 ~ 160	1 / step
89	Decelerating speed slope choice 減速曲線選擇	1 ~ 8 (The bigger value means the longer time of decelerating.) 設定值越大,減速時間越長	
90	Motor static brake function 馬達靜止煞車功能	0 : No such function 無功能 1 ~ 20 : (The bigger value means the more powerful braking force.) 1 ~ 20 : 有此功能, 設定值越大煞車力量越大	
91	Motor rotation signal control 馬達轉動信號控制	OFF : No output 不輸出 TL1 : TL solenoid outputs when motor rotates. 馬達轉動時由 TL 線圈輸出 TL2 : TL solenoid outputs when motor rotates & foot lifter acts. 馬達轉動時和舉壓腳動作時由 TL 線圈輸出 TL3 : TL solenoid control by edge sensor 由 SENSOR 控制 TL 線圈輸出 TL4 : TL solenoid control by edge sensor and Interval stitch 由 SENSOR 控制 TL 線圈輸出, 且間隔固定針數控制 TL 線圈輸出 TL5 : TL solenoid control by Interval stitch 間隔固定針數控制 TL 線圈輸出	

92	Forward output the motor rotation signal 馬達轉動信號提早輸出時間	0 ~ 1250 ms		5 ms / step
93	Current limit table boost up 提升起動電流限制值	0 ~ 20		
94	Reverse angles when machine starts stitching. 起縫反轉角度	0 ~ 250°		1° / step
95	Check the speed control unit condition function when power on. 開機時檢查速度基座狀態功能	OFF: Ineffective ON: Effective	無功能 有此功能	
96	Alarm signal output function. 發生 alarm 時有訊號輸出功能	OFF: Ineffective ON: Effective	無功能 有此功能	
97	Auto function setting. (Only effective in BAFS machine) 自動機能設定(只在 BAFS 車頭選項中有效)	OFF: Ineffective ON: Effective	無功能 有此功能	
98	Motor delays starting time. (Only effective in BAFS machine) 馬達延遲啟動時間(只在 BAFS 車頭選項中有效)	0 ~ 9900 ms		100 ms / step
99	BLOWER-B delays output time. (Only effective in BAFS machine) BLOWER- B 輸出延遲時間(只在 BAFS 車頭選項中有效)	0 ~ 9900 ms		100 ms / step
100	BLOWER-B output time. (Only effective in BAFS machine) BLOWER- B 輸出動作時間(只在 BAFS 車頭選項中有效)	0 ~ 9900 ms		100 ms / step
101	In motor running, FLSW key input to control FLL output acted stitches' number 馬達運轉中 option IN_G 按鍵輸入控制 option OUT_D 輸出動作針數	0 ~ 500 stitches		2 stitches/ step
102	Material edge sensor begins acting, Option OUT_E delay acting stitches number 布端檢出器開始動作 Option OUT_E 延遲動作針數	0 ~ 99 stitches		
103	Material edge sensor ends acting, Option OUT_E continuously act stitches number 布端檢出器結束動作 Option OUT_E 持續動作針數	0 ~ 99 stitches		
104	Option OUT_E function choice Option OUT_E 功能選擇	OFF : No output 無輸出 ON : Depend on setting stitches' number output 根據所設定針數輸出		
105	Foot lifter protecting time 押腳保護時間	0 ~ 60 seconds		1 seconds / step
106	Folder auto function setting (Only effective in TCF machine) Folder 自動機能設定 (只在 TCF 車頭選項中有效)	OFF: Ineffective ON: Effective	無功能 有此功能	
107	Folder auto function delays stitches' number (Only effective in TCF machine) Folder 自動機能延遲針數(只在 TCF 車頭選項中有效)	0 ~ 99 stitches		
108	Motor's braking force when positioning 馬達定位時煞車力(位置參數)	0 ~ 5		
109	Quick Needle positioning function 快速定位停	OFF: Ineffective ON: Effective	無功能 有此功能	
110	Motor positioning stopping force 馬達定位時煞車力(速度參數)	0 ~ 5		

111	ER-2 checking time ER-2 檢查時間	0 ~ 5 seconds 秒	1 seconds / step
112	ATC auto function setting (Only effective in ATC machine) ATC 自動機能設定(只在 ATC 車頭選項中有效)	OFF: Ineffective 無功能 ON: Effective 有此功能	
113	Material edge sensor begins acting, Option OUT_F delay acting stitches' number 布端檢出器開始動作 Option OUT_F 延遲動作針數	0 ~ 99 stitches	
114	Material edge sensor ends acting, Option OUT_F continuously act stitches' number 布端檢出器結束動作 Option OUT_F 持續動作針數	0 ~ 99 stitches	
115	Option OUT_F function choice Option OUT_F 功能選擇	OFF : No output 無輸出 ON: Depend on setting stitches' number output 根據所設定針數輸出	
116	Control Option OUT_C solenoid output function by Option IN_D 利用 Option IN_D 控制 Option OUT_C 線圈輸出功能	OFF: Ineffective 無功能 ON: Effective 有此功能	
117	Start condensed stitching stitches' number 開始密縫針數	0 ~ 99 stitches	
118	During motor rotates, auto FOLDER stitches' number (YU2F & YU3F machine is effective) 馬達運轉中,自動 FOLDER 針數(YU2F & YU3F 車頭有效)	0 ~ 99 stitches	
119	Auto FOLDER function (YU2F & YU3F machine is effective) 自動 FOLDER 功能(YU2F & YU3F 車頭有效)	OFF: Ineffective 無功能 ON: Effective 有此功能	
120	D_code back tacking compensation D_CODE 回針線圈動作補正角度	0 ~ 720 °	5 ° /step
121	C2_code back tacking compensation C2_CODE 回針線圈釋放補正角度	0 ~ 720 °	5 ° /step
122	A2_code back tacking compensation A2_CODE 回針線圈動作補正角度	0 ~ 720 °	5 ° /step
123	B1_code back tacking compensation B1_CODE 回針線圈釋放補正角度	0 ~ 720 °	5 ° /step
124	WA_code back tacking compensation WA_CODE 回針線圈動作補正角度	0 ~ 720 °	5 ° /step
125	WB_code back tacking compensation WB_CODE 回針線圈釋放補正角度	0 ~ 720 °	5 ° /step
126	Position subroutine executive timr 定位停執行時間	0 ~ 100 ms	
127	Forward stitches to decelerate speed in SBT 前自動倒縫結束提前減速針數	0 ~ 2	

128	Special function choice 特殊功能選擇	<p>OFF : ineffective 無功能</p> <p>1: When flsw active , change the foot lifter control mode to TFL 只要壓腳開關動作過一次,就強制將壓腳控制模式改為 TFL,直到關機</p> <p>2: Option OUT_A delay off function Option OUT_A 延遲 OFF 功能</p> <p>3: Four –step selection for edge sensor stitches 布端結束後的針數可分為 4 段</p> <p>4: Start backtack last trip modify mode 前倒縫最後一趟修正模式</p> <p>5: Special display for DINO DINO 特殊顯示功能</p> <p>6: Edge sensor re-effective after chain-off thread suction (only effective in MO3 machine) 吸線裝置動作完成後,布端檢出器自動有效 (只在 MO3 機型有效)</p> <p>7: Slow down the speed at auto backtack turning point 前/後倒縫轉折處提早降速功能</p> <p>8: Tension release enable (chain stitch) 鬆線輸出(三本車)</p>	
129	Differential control function 微分控制功能	<p>OFF: Ineffective 無功能</p> <p>ON: Effective 有此功能</p>	
130	Up position adjustment 上停點位置調整	- 50 ° ~ 50 °	1 ° / step
131	Stitch number for one-shot function ONE-SHOT 針數	0 ~ 250	
132	The delay time for DST function DST 延遲時間	0 ~ 300 ms	10 ms / step
133	The acting time for DST function DST 動作時間	0 ~ 2500 ms	10 ms / step
134	Stop position when material edge sensor active 布端檢出器動作時,馬達停止位置	<p>OFF : Depend on simple control panel setting 由簡易面板上下停決定</p> <p>UP : Up position 上停點</p> <p>DOWN : Down position 下停點</p>	
135	UTL delaying time UTL 延遲輸出時間	0 ~ 200 ms	10 ms / step
136	UTL acting time UTL 動作輸出時間	0 ~ 2000 ms	10 ms / step
137	Delay time between UTL and condensing stitch UTL 動作輸出後到執行密縫前延遲時間	0 ~ 200 ms	10 ms / step
138	Option OUT_C delay acting stitches (only effective in PT2 machine) 布端檢出器開始動作 Option OUT_C 延遲動作針數(只在 PT2 機型有效)	0 ~ 99 stitches	
139	Option OUT_C acting stitches (only effective in PT2 machine) 布端檢出器動作 Option OUT_C 持續動作針數(只在 PT2 機型有效)	0 ~ 99 stitches	
140	Motor protecting function 馬達運轉時間保護功能	<p>OFF: Ineffective 無功能</p> <p>ON: Effective 有此功能</p>	
141	Cumulate times for motor protecting function 馬達發生保護功能時間	100 ~ 5000 hours	50 hours / step
142	Forward stitches to decelerate speed in EBT 後自動倒縫結束提前減速針數	0 ~ 2	

143	Stitches counter for ATC machine ASC 機型針數計數	0 ~ 1000	4 stitches/ step
144	In auto test mode, motor running level adjustment 自動測試模式下,馬達運轉速度準位調整	60 ~ 250	10 / step
145	In auto test mode, motor stop mode selection 自動測試模式下,馬達停止模式選擇	TRIM : trimming active 切線動作 FLON : foot lifter active 舉押腳動作 STOP : motor stop 馬達停止	
146	Motor stop at the end of start back-tacking 前倒縫結束後強制停止功能	OFF : ineffective 無功能 ON : effective 有此功能	
147	Inching switch (on display panel)operation mode 操作面板上補針按鍵功能	NDUP : Needle up switch 提針到上停 HALF : Half stitch inching 半針補針 ONE : One stitch inching 一針補針	
148	Quick needle positioning check level 快速定位停檢查準位	500 ~ 1000 spm	50 / step
149	Soft start mode 慢速啟動模式	0 : First stitching after trimming 在切完線後第一次車縫 1 : After the start back-tacking 切完線後第一次平縫	
150	Motor automatic stop function 馬達自動停止功能	OFF: Ineffective 無功能 ON: Effective 有此功能	The cumulate time is clear after power turn off 電源關機後累積時間就被清除
151	Times for automatic stop the motor 馬達執行自動停止時間	0 ~ 100 hours	1 hour / step
152	Speed loop gain adjustment 速度迴路增益調整	0 ~ 5	
153	Virtual needle up positioning function(only for direct drive motor) 虛擬上停功能(直驅馬達適用)	OFF: Ineffective 無功能 ON: Effective 有此功能	
154	Decelerating speed slope choice for fixed stitches sewing 定寸縫減速曲線選擇	0 ~ 4	
155	The safety range of UP position 上停定位的安全範圍	0 ~ 100	
156	Dotted line function 鎖線功能	OFF: Ineffective 無功能 ON: Effective 有此功能	
157	Delay time before dotted line function 鎖線前延遲時間	0 ~ 1000 ms	
158	Active angle for dotted line function 鎖線動作角度	200 ~ 360 °	
159	Step-2 for material edge sensor stitches' number 第二段布端檢出器針數	0 ~ 250 stitches	
160	Step-3 for material edge sensor stitches' number 第三段布端檢出器針數	0 ~ 250 stitches	
161	Step-4 for material edge sensor stitches' number 第四段布端檢出器針數	0 ~ 250 stitches	

162	Execute auto foot lifter after end fixed stitches' number sewing process 固定針數縫製工程結束後,自動壓腳功能	OFF: Ineffective ON: Effective	無功能 有此功能	
163	Fast cutter function 快速切刀功能	OFF: Ineffective ON: Effective	無功能 有此功能	
164	Stitches between UTL and trimming UTL 動作輸出後到切線前縫製針數	0 ~ 99		
165	Option OUT_A delay Off time Option OUT_A 延遲 OFF 時間	0 ~ 9000 ms		
166	Control the speed for material edge sensor stitches' number (only effective in SAF、YU2F、YU3F machine) 控制布端檢出器針數執行時的速度 (只在 SAF、YU2F、YU3F 機型有效)	0 : pedal control speed 踏板控制速度 1 : medium speed 固定中速 2 : Auto sewing without pedal press 自動縫製不需踏板前踩		
167	Forward decelerating angle for quick needle positioning 快速定位停提前減速角度	0 ~ 200 °		
168	Interval stitch between both intermediate suction 中途吸風間格針數	0 ~ 250 stitches		
169	Suction active stitch for intermediate suction 中途吸風動作針數	0 ~ 250 stitches		
170	Stop up position before foot lifter active 舉壓腳動作前馬達先轉到上停位置	OFF: Ineffective ON: Effective	無功能 有此功能	
171	Chain-off thread suction active time when manual cutter switch active 手動斬刀開關動作時吸線裝置動作時間	0 ~ 9900 ms		100 ms / step
172	Manual blower function 手動吹風功能	OFF: Ineffective ON: Effective	無功能 有此功能	
173	Blower start active angle 吹風開始角度	0 ~ 250 °		
174	Blower stop active angle 吹風結束角度	100 ~ 250 °		
175	Blower start active angle 吹風動作針數	0 ~ 19 stitches		
176	Tension release delay time when blower active 吹風動作時紗拉組延遲時間	0 ~ 100 ms		
177	Tension release active time when blower active 吹風動作時紗拉組動作時間	0 ~ 150 ms		
178	Edge sensor type select 布端檢出器型式	OFF : light on. ON : dark on		
179	Foot lifter active when edge sensor detect material 布端檢出器控制舉壓腳動作	OFF: Ineffective ON: Effective	無功能 有此功能	
180	Prevent special parameter be modified 參數鎖定功能	OFF: Ineffective ON: Effective	無功能 有此功能	
181	Compensation stitch in end back tacking C_code 後倒縫 C_CODE 針數補償	0 ~ 3 stitches		
182	Material edge sensor detects stitches 布端檢出器檢出判斷針數	0 ~ 3 stitches		
183	ER-9 detect counter ER-9 檢出判斷次數	3 ~ 6		
184	Manual motor pulley ratio measure 手動皮帶輪比量測	OFF: not execute ON: executed	未執行 已執行	

185	Backtack solenoid active degree when backtack turning point slowdown speed selected 倒縫轉折處提前降速角度	0 ~ 250°	
186	Exciting power (in motor adjustment mode) 激磁力 (馬達調整模式下)	0 ~ 8	
187	Accelerating command adjustment 加速指令調整	0 ~ 16	
188	Auto start back tacking mode 自動開始倒縫模式	AUTO : auto mode 自動模式 STOP : stop in down position when finish every process 每趟段落針數完成後，在下停點暫停	
189	Auto end back tacking mode 自動結束倒縫模式	AUTO : auto mode 自動模式 STOP : stop in down position when finish every process 每趟段落針數完成後，在下停點暫停	
190	Continuously auto back tacking mode 連續自動倒縫模式	AUTO : auto mode 自動模式 STOP : stop in down position when finish every process 每趟段落針數完成後，在下停點暫停	
191	Auto back tacking stopping time 自動倒縫段落針數完成後停止時間	0 ~ 2500 ms	
192	Auto mode control by material edge sensor 布端檢出器控制自動運轉模式	OFF: Ineffective 無功能 ON: Effective 有此功能	
193	Edge sensor checking time for auto mode 自動運轉模式布端檢出器確認時間	1 ~ 20 second	
194	Speed error abnormal detecting 速度誤差異常檢出功能	OFF: Ineffective 無功能 ON: Effective 有此功能	
195	Input voltage select 輸入電壓選擇	110v: AC 110 V 220v: AC 220 V	
196	Stitch setting for fix stitch sewing function 針數設定值(固定車縫功能)	0 ~ 20000 stitches	100 stitches/ step
197	Save remnant stitch when power off(for fix stitch sewing function) 關機時儲存殘餘針數(固定車縫功能)	OFF: Ineffective 無功能 ON: Effective 有此功能	
198	Charging IPM module when motor stopping 馬達停止時對 IPM 啟動電路充電	OFF: Ineffective 無功能 ON: Effective 有此功能	

