

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述	
Press "P" Key 按 "P" 鍵	1	H	Maximum sewing speed. 最高速度。	50 - 4500 spm	4000	
	2	SLM	Slow start operation mode. 起縫慢針模式。	A/T	T	A : Slow start operation will begin when the pedal is toed down. A : 踩下踏板即開始起縫慢針。 T : Slow start operation will begin when the first toe down after thread trimming. T : 剪線後只第一次踩下踏板會開始起縫慢針。
	3	CNR	Counter ratio setting. 計件倍率設定。	1 - 100	1	
	4	N	Start back-tacking speed. 起始回縫速度。	50 - 4500 spm	1800	
	5	V	End back-tacking speed. 終止回縫速度。	50 - 4500 spm	1800	
	6	B	Bar-Tacking Speed. 連續回縫速度。	50 - 4500 spm	1800	
	7	S	Slow start speed. 起縫慢針速度。	50 - 2000 spm	400	
	8	SLS	Stitch numbers for slow start. 起縫慢針針數。	0 - 99 stitches	2	
	9	A	Automatic sewing speed. 自動運轉速度。	50 - 4500 spm	4000	
	10	ACD	Automatic sewing End back-tacking. 自動縫紉終止回縫。	ON/OFF	ON	ON : Valid. Valid only when the [38. PM] set ON. ON : 有效。只在 [38. PM]=ON 時有效。 OF : Invalid. OF : 無效。
	11	RVM	Back-tacking mode selection. 手動回縫開關模式選擇。	J/B	B	J : Active when motor stop or running. J : 馬達停止或運行時有效。 B : Active only when motor running. B : 馬達運行時有效。
	12	SMS	Mode selection for Start back-tacking. 起始回縫模式選擇。	A/M/SU/SD/A1/ SU1/SD1/AN/SUN/ SDN	A	A : One shot sewing. A : 自動完成。 M : Pedal control and motor can stop at middle way. M : 踏板控制。 SU : One shot sewing but motor stops at needle up by [27. CT] timer at end of each seam. SU : 自動完成, 段落停針上 [27. CT] 時間。 SD : One shot sewing but motor stops at needle down by [27. CT] timer at end of each seam. SD : 自動完成, 段落停針下 [27. CT] 時間。 A1 : One shot sewing , Add one seam by one stitch. A1 : 自動完成後自由縫1針。 SU1 : One shot sewing , Add one seam for one stitch, but motor stops at needle up by [27. CT] timer at end of each seam. SU1 : 自動完成後自由縫1針, 段落停針上 [27. CT] 時間。 SD1 : One shot sewing , Add one seam for one stitch, but motor stops at needle down by [27. CT] timer at end of each seam. SD1 : 自動完成後自由縫1針, 段落停針下 [27. CT] 時間。 AN : One shot sewing , Add one seam by N stitches. AN : 自動完成後自由縫 [15.SBA] 針。 SUN : One shot sewing , Add one seam by N stitches, but motor stops at needle up by [27. CT] timer at end of each seam. SUN : 自動完成後自由縫 [15.SBA] 針, 段落停針上 [27. CT] 時間。 SDN : One shot sewing , Add one seam by N stitches, but motor stops at needle down by [27. CT] timer at end of each seam. SDN : 自動完成後自由縫 [15.SBA] 針, 段落停針下 [27. CT] 時間。
13	TYS	Mode selection at the end of Start back-tacking. 起始回縫完成模式選擇。	CON/STP/TRM	CON	CON : At the end of Start back-tacking ,machine continues sewing if pedal pressed or START signal on (standing operation). CON : 起始回縫完成後繼續自由縫。 STP : At the end of Start Back-Tacking, machine stops and must re-start by pedal command. STP : 起始回縫完成即停止, 踏板重新踩踏才可以自由縫。 TRM : Making the trimming cycle once the Start Back-Tacking finished. (Mini Bar tacking) TRM : 起始回縫完成後繼續切線。	
14	SBT	Start back-tacking function selection. 起始回縫選擇。	ON/OFF	ON	ON : Perform. ON : 執行。 OF : Not perform. OF : 不執行。	
15	SBA	Setting stitches A of Start back-tacking. 起始回縫針數A。	0 - 15 stitches	3	Start back-tacking stitches setting, [14.SBT]=ON valid. 起始回縫針數設定, [14.SBT]=ON 有效。	
16	SBB	Setting stitches B of Start back-tacking. 起始回縫針數B。		3		
17	SBN	Setting turns of Start Back-tacking. 起始回縫轉數。	0 - 4 times	2	Setting the seam times of Start back-tacking, [14.SBT]=ON valid. 起始回縫轉數設定, [14.SBT]=ON 有效。	
18	BT1	Stitch balance BT1 for Start Back-tacking. 起始回縫針數平衡BT1	0 - 250	40	BT1= 0/125: Invalid ; 1-124: Increase stitches of reverse seam ; 126-250: Increase stitches of forward seam. BT1= 0/125: 無效 ; 1-124: 增加逆縫線跡 ; 126-250: 增加正縫線跡。	
19	BT2	Stitch balance BT2 for Start Back-tacking. 起始回縫針數平衡BT2		30	BT2= 0/125: Invalid ; 1-124: Increase stitches of forward seam ; 126-250: Increase stitches of reverse seam. BT2= 0/125: 無效 ; 1-124: 增加正縫線跡 ; 126-250: 增加逆縫線跡。	
Pre 按 "						A : One shot sewing. A : 自動縫紉。

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SS P Key P 鍵	20	SME Mode selection for End back-tacking. 終止回縫模式選擇。	A/SU/SD/A1/SU1/ SD1	A	SU : One shot sewing but motor stops at needle up by [27. CT] timer at end of each seam. SU : 自動完成, 段落停針上 [27.CT] 時間。 SD : One shot sewing but motor stops at needle down by [27. CT] timer at end of each seam. SD : 自動完成, 段落停針下 [27.CT] 時間。 A1 : One shot sewing , Add one seam by one stitch. A1 : 自動完成後自由縫1針。 SU1 : One shot sewing , Add one seam for one stitch, but motor stops at needle up by [27. CT] timer at end of each seam. SU1 : 自動完成後自由縫1針, 段落停針上 [27.CT] 時間。 SD1 : One shot sewing , Add one seam for one stitch, but motor stops at needle down by [27. CT] timer at end of each seam. SD1 : 自動完成後自由縫1針, 段落停針下 [27.CT] 時間。
	21	EBT End back-tacking selection. 終止回縫選擇。	ON/OF	ON	ON : Perform. ON : 執行。 OF : Not perform. OF : 不執行。
	22	EBC Setting stitches C of End back-tacking. 終止回縫針數C.	0 - 15 stitches	3	End back-tacking stitches setting, [21.EBT]=ON valid. 終止回縫針數設定, [21.EBT]=ON 有效。
	23	EBD Setting stitches D of End back-tacking. 終止回縫針數D.		3	
	24	EBN Setting turns of End back-tacking. 終止回縫轉數。	0 - 4 times	2	Setting the seam times of End back-tacking, [21.EBT]=ON valid. 終止回縫轉數設定, [21.EBT]=ON 有效。
	25	BT3 Stitch balance BT3 for End Back-tacking. 終止回縫針數平衡BT3	0 - 250	20	BT3= 0/125: Invalid ; 1-124: Increase stitches of forward seam ; 126-250: Increase stitches of reverse seam. BT3= 0/125: 無效 ; 1-124: 增加正縫線跡 ; 126-250: 增加逆縫線跡。
	26	BT4 Stitch balance BT4 for End Back-tacking. 終止回縫針數平衡BT4		10	BT4= 0/125: Invalid ; 1-124: Increase stitches of reverse seam ; 126-250: Increase stitches of forward seam. BT4= 0/125: 無效 ; 1-124: 增加逆縫線跡 ; 126-250: 增加正縫線跡。
	27	CT Setting time interruption at each section end of Back-Tacking. 回縫每段結束停止時間。	0 - 990 ms	50	[12.SMS]=SU,SD,SU1,SD1,SUN,SDN setting valid. [12.SMS]=SU,SD,SU1,SD1,SUN,SDN 設定有效。 [20.SME]=SU,SD,SU1,SD1 setting valid. [20.SME]=SU,SD,SU1,SD1 設定有效。 [31.SMB]=SU,SD setting valid. [31.SMB]=SU,SD 設定有效。
	37	SMP Mode selection for Constant-stitch sewing. 定針縫模式選擇。	A/M	M	A : One shot sewing. A : 自動完成。 M : Pedal control and motor can stop at middle way. M : 踏板控制。
	38	PM Constant-stitch sewing selection. 定針縫選擇。	ON/OF	OF	ON : Perform. ON : 執行。 OF : Not perform. OF : 不執行。
39	PS Setting stitches for section 1~4 of Constant-stitch sewing. 定針縫針數1~4 Setting stitches for section 5~D of Constant-stitch sewing. 定針縫針數5~D	0 - 250 stitches	15 0	Parameter 47.MAC determines the display name and range of P1-PD 車頭碼決定P1-PD顯示的名稱與範圍。	

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按 "P" 鍵 Press P Key	40	WON		ON/OFF	ON : Enable. ON : 啟用. OF : Disable. OF : 禁止.	
	41	TM		ON/OFF	ON : Enable. ON : 啟用. OF : Disable. OF : 禁止.	
	42	CUD	Count mode selection. (For Bobbin Thread or Sewing Piece) 計數模式選擇. (適用於梭蕊線或縫紉片)	NOP/U/D/US/DS/ UT/DT/UTS/DTS	NOP	NOP : The counter is invalid. NOP : 計數器無效. U : Count up by stitches. When count over , counter will be auto- reset. U : 針數累加遞增, 計數到達自動重置計數器. D : Count down by stitches. When count over , counter will be auto- reset. D : 針數累加遞減, 計數到達自動重置計數器. US : Count up by stitches. When count over, motor stops and the counter must be reset by the A key on the front panel. US : 針數累加遞增, 計數到達禁止車縫, A鍵重置計數器. DS : Count down by stitches. When count over, motor stops and the counter must be reset by the A key on the front panel. DS : 針數累加遞減, 計數到達禁止車縫, A鍵重置計數器. UT : Count up by trimming. When count over , counter will be auto- reset. UT : 切線次數累加遞增, 計數到達自動重置計數器. DT : Count down by trimming. When count over , counter will be auto- reset. DT : 切線次數累加遞減, 計數到達自動重置計數器. UTS : Count up by trimming. When count over, motor stops and the counter must be reset by the A key on the front panel. UTS : 切線次數累加遞增, 計數到達禁止車縫, A鍵重置計數器. DTS : Count down by trimming. When count over, motor stops and the counter must be reset by the A key on the front panel. DTS : 切線次數累加遞減, 計數到達禁止車縫, A鍵重置計數器.
	43	UD	Setting the count. 計數目標值設定.	1 - 9999	99	Count setting. (Note: The real number = the value of [3.CNR] x [43. UD], when [42.CUD]=U/D/US/DS valid only.) 設定計數目標值。(備註: 實際值 = [3.CNR] x [42.CUD], 當[42.CUD]=U/D/US/DS 時.)
	44	PN	Display the current count. 計數值顯示.	0 - 9999	0	Display the current count. (Press A key 3'S Clear Counter Value) 計數值顯示。(按住 A 鍵歸零計數值)
	45	SP	Sewing speed. 車縫速度顯示.	0 - 8000	0	
	46	DIR	Direction of motor rotation. 電機旋轉方向.	CW/CCW	CW	CCW : counterclockwise. CCW : 逆時針. CW : clockwise. CW : 順時針.

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Press P Key + Power on 按“P”鍵 + 電源開啟	47	MAC Machine Code. 機器碼	0/520/521/ 522/523/524/ 525/526/120/ 121/122	0	0 : BRI M1 520 : C007KP-D pneumatic UT M5 521 : C007KP-D magnetic UT M5 522 : C007KP-D pneumatic UT CS M5 523 : VC/HF008 pneumatic UT M5 524 : 700K/L pneumatic M5 525 : U007K pneumatic UT M5 526 : U007K magnetic UT M5 120 : C007KD pneumatic UT M1 121 : C007KD magnetic UT M1 122 : C007KD pneumatic UT CS M1
	49	SPD Machine's pulley dimension. 車頭皮帶輪尺寸.	1 - 250 mm	75	When [51. PL]=ON valid. 當 [51. PL]=ON 設定有效.
	50	MPD Motor's pulley dimension. 馬達皮帶輪尺寸.	1 - 250 mm	75	When [51. PL]=ON valid. 當 [51. PL]=ON 設定有效.
	51	PL Pulley's ratio setting mode selection. 皮帶輪比模式選擇.	ON/OF	OF	ON : Manually setting the pulley sizes by [49.SPD], [50.MPD] ON : 手動. OF : Automatically setting the pulley sizes by the CPU. OF : 自動.
	52	BT Braking time of motor. 馬達穩定時間.	50 - 500 ms	200	
	53	POL Slow start at the first cycle of power ON. 只電源開啟車縫第一針慢速.	ON/OF	OF	ON : Valid. ON : 有效. OF : Invalid. OF : 無效.
	54	BK Motor braked at normal stop. 馬達停止時鎖住.	ON/OF	OF	ON : Valid. ON : 有效. OF : Invalid. OF : 無效.
	59	M Middle speed. 中速度.	250 - 4500	800	
	60	L Low speed. 最低速度.	50 - 500 spm	250	
	61	T Thread trimming speed. 切線速度.	50 - 500 spm	215	
	62	HPM Mode for foot lifting stroke change at special compound feed machine. 針送壓腳模式.	ALT/MON	MON	ALT : Presser foot lifting stroke function output. (Alternative mode) ALT : ALT.(交互動作模式) MON : Presser foot lifting stroke function output. (Momentary mode) MON : MON.(單次動作模式)
	63	FTP Type selection for foot lifting solenoid. 壓腳電磁鐵型式.	M/A	M	M : Magnetic type. M : 電磁式 A : Air type. A : 空氣式 Note : When set at Air type, [64. FO] and [65. FC] setting will be invalid. It will be full on. 註解：當設定為A時, [64. FO] and [65. FC] 設定無效, 只有全出力.
	64	FO Full-On time setting for foot lifting solenoid. 壓腳全額出力時間調整.	0 - 990 ms	350	Valid only when the [63.FTP] set M. 只在 [63.FTP]=M 時有效.
	65	FC Duty cycle time setting for foot lifting solenoid. 壓腳佔空比時間調整.	10 - 90 %	25	Valid only when the [63.FTP] set M. 只在 [63.FTP]=M 時有效.
66	FD Running-Delay time setting. 馬達運轉延遲時間.	0 - 990 ms	0	If foot lifter is installed, set 100 ms min. to ensure the presser foot will come down first. 如安裝壓腳電磁閥, 請設定最小為100ms, 確保壓腳先落下.	

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按 "P" 鍵 + 電源開啟	67	FPM	Protection for foot lifter solenoid. 壓腳保護機能。	ON/OF	ON	ON : Valid. ON : 有效. OF : Invalid. OF : 無效.
	68	FP	Working time limit for foot lifter solenoid. 壓腳保護時間	(0 - 9990) x 0.01s	3000	Valid only when the [67.FPM]=ON 只在 [67.FPM]=ON 時有效.
	69	HD	Timing adjustment for half-heeling pedal. 半後踏確認時間。	0 - 990 ms	100	Use this setting as foot lifter delay time at half heeling the pedal. If foot lifter is installed, set 100 ms min. If timing set to short, it will cause foot lifter started once before trimming at full heeling the pedal. If timing set to long, it will cause foot lifter started too slow the pedal. 使用於半後踏延遲動作壓腳電磁閥。 如安裝壓腳電磁閥，請設定最小為100ms。 如設定值太小，將導致全後踏之前，動作壓腳電磁閥。 如設定值太大，將導致太慢動作壓腳電磁閥。
	70	HHC	Cancel foot lifting at half-heeling pedal. 取消半後踏抬壓腳。	ON/OF	OF	ON : No foot lifting at half-heeling. (but full-heeling can operate foot lifter) ON : 半後踏不動作壓腳。(但全後踏可動作壓腳) OF : Operate foot lifting at half-heeling. OF : 半後踏動作壓腳。 Note : When [134.KLK]=ON for interlock-stitch machine, this function can be controlled by A key on the control box panel. Note : 當 [134.KLK]=ON 時，該功能可以通過控制盒面板上的A鍵控制。
	71	FL	Cancel foot lifting at full- heeling pedal. 取消全後踏抬壓腳。	ON/OF	OF	ON : No foot lifting at full- heeling pedal. ON : 全後踏不動作壓腳。 OF : Operate foot lifting at full- heeling pedal. OF : 全後踏動作壓腳。
	72	FHC	Cancel trimming at full-heeling pedal. 取消全後踏切線。	ON/OF	OF	ON : No function at full-heeling pedal. (Need up function are also invalid) ON : 全後踏不動作切線。(提針也無效) OF : Trimmer is functioned at full-heeling pedal. OF : 全後踏動作切線。
	73	NTC	Trimming works at neutral pedal. 踏板中立進行剪線。	ON/OF	OF	ON : Enable. ON : 啟用。只在 [72.FHC]=OF 時有效。 OF : Disable. OF : 禁止。
	74	FRV	Converter for foot lifter signal output. 壓腳出力反向器	ON/OF	OF	ON : The foot lifter goes up during sewing. ON : 縫紉啟動壓腳。 OF : Invalid. OF : 無效。
	75	SFM	Safety switch protection mode. 安全開關模式選擇。	NC/NO	NO	NC : Normal close. When signal at open, motor immediately stops and rotation symbol will stop. NC : 常閉。當信號為打開，馬達停止與旋轉符號停止轉動。 NO : Normal open. When signal at close, motor immediately stops and rotation symbol will stop. NO : 常開。當信號為關閉，馬達停止與旋轉符號停止轉動。
	76	TCL	Thread trimmer cancel. 取消切線。	ON/OF	OF	ON : Valid. ON : 有效。提針開關進行提針後踏不切線，平車只管制定針縫。 OF : Invalid. OF : 無效。
77	ILC	Cancel of interlock timing after full heeling pedal. 取消前後踏互鎖功能。	ON/OF	OF	ON : Valid. ON : 有效。掃線期間馬達運行開放。 OF : Invalid. OF : 無效。掃線期間馬達運行禁止。	

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Press P Key + Power on 按 "P" 鍵 + 電源開啟	78	TRM Motor running mode at trimming sequence. 馬達運轉模式.(切線)	LK/RK/KA/KB/KC/KD	LK	LK : For general Lock-Stitch machines .Trimming from needle down to up. LK : LK模式. RK : For Chain-Stitch machine easy pull out cycle. Needle stops with a reverse angle set by [116.DRU]. RK : RK模式. KA : For general Cover-Stitch machines with under trimmer only. KA : KA模式. KB : For special Cover-Stitch machines with upper trimmer. KB : KB模式. KC : Valid only when [79.LTM]=TK and [81. TS] > 0, otherwise function same as LK mode. (No used) KC : KC模式. (未使用) KD : For general Cover-Stitch machines with under trimmer only , can change needle position. KD : KD模式. (開放提針開關)
	79	LTM Trimming sequence mode selection. (For TM output signal) 切線模式.	T1/T2/T3/T4/TK/TS / T7/T8/T9	TS	T1 : At down position delayed [81. TS] angles on, at up position delayed [83. T2] time OF. T1 : 針下延遲 [81. TS] 角度開啟, 針上延遲 [83. T2] 時間關閉. T2 : At down position delayed [81. TS] angles on, extended [84. TE] angles OF. T2 : 針下延遲 [81. TS] 角度開啟 [84. TE] 角度. T3 : At down position delayed [81. TS] angles on, extended [83. T2] time OF. T3 : 針下延遲 [81. TS] 角度開啟 [83. T2] 時間. T4 : At down position delayed [82. T1] time on, extended [83. T2] time OF. T4 : 針下延遲 [82. T1] 時間開啟 [83. T2] 時間. TK : At up position delayed [82. T1] time on, extended [83. T2] time OF. TK : 針上延遲 [82. T1] 時間開啟 [83. T2] 時間. TS : At down position always on, at up position delayed [82. T1] time on, extended [83. T2] time. TS : 針下至針上開啟, 針上延遲 [82. T1] 時間開啟 [83. T2] 時間. T7 : At down position delayed [81. TS] angles on, at up position OF, and delayed [82. T1] time on, extended [83. T2] time OF. T7 : 針下延遲 [81. TS] 角度至針上, 針上延遲 [82. T1] 時間開啟 [83. T2] 時間. T8 : At down position delayed [81. TS] angles on, extended [84. TE] angles reduce (start switching) at up position OF. (No used) T8 : 針下延遲 [81. TS] 角度開啟 [84. TE] 角度, 然後以 [245.SFC] 續開啟至針上. (未使用) T9 : if T1+T2>W1, then W1=T1+T2, W2=W1+W2 T9 : 切線後掃線模式設定.
	80	LLM Tension-release sequence mode selection. (For ML output signal) 鬆線模式.	L1/L2/L3/L4/LK/LS/ L7/L8/L9	LS	L1 : At down position delayed [85. LS] angles on, at up position delayed [87. L2] time OF. L1 : 針下延遲 [85. LS] 角度開啟, 針上延遲 [87. L2] 時間關閉. L2 : At down position delayed [85. LS] angles on, extended [88. LE] angles OF. L2 : 針下延遲 [85. LS] 角度開啟 [88. LE] 角度. L3 : At down position delayed [85. LS] angles on, extended [87. L2] time OF. L3 : 針下延遲 [85. LS] 角度開啟 [87. L2] 時間. L4 : At down position delayed [86. L1] time on, extended [87. L2] time OF. L4 : 針下延遲 [86. L1] 時間開啟 [87. L2] 時間. LK : At up position delayed [86. L1] time on, extended [87. L2] time OF. LK : 針上延遲 [86. L1] 時間開啟 [87. L2] 時間. LS : At down position always on, at up position delayed [86. L1] time on, extended [87. L2] time OF. LS : 針下至針上開啟, 針上延遲 [86. L1] 時間開啟 [87. L2] 時間. L7 : At down position delayed [85. LS] angles on, at up position OF, and delayed [86. L1] time on, extended [87. L2] time OF. L7 : 針下延遲 [85. LS] 角度至針上, 針上延遲 [86. L1] 時間開啟 [87. L2] 時間. L8 : At down position delayed [85. LS] angles on, at up position OF, extended [87. L2] time OF. L8 : 針下延遲 [85. LS] 角度至針上, 針上開啟 [87. L2] 時間. L9 : At up position delayed [86. L1] time on, extended [87. L2] time OF. L9 : 針上延遲 [86. L1] 時間開啟 [87. L2] 時間.
	81	TS Trimmer running delayed angles selection. 切線延遲角度.	0 - 360 degrees	0	Valid for [79.LTM]=T1/T2/T3/T7/T8 有效於 [79.LTM]=T1/T2/T3/T7/T8 時.
	82	T1 Trimmer running delayed time selection. 切線延遲時間.	0 - 990 ms	0	Valid for [79.LTM]=T4/TK/TS/T7/T9 有效於 [79.LTM]=T4/TK/TS/T7/T9 時.
	83	T2 Trimming running time selection. 切線動作時間.	0 - 990 ms	0	Valid for [79.LTM]=T1/T3/T4/TK/TS/T7/T9 有效於 [79.LTM]=T1/T3/T4/TK/TS/T7/T9 時.
	84	TE Trimming running angles selection. 切線動作角度.	0 - 360 degrees	0	Valid for [79.LTM]=T2/T8 有效於 [79.LTM]=T2/T8 時.

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述
Press P Key + Power on 按 "P" 鍵 + 電源開啟	85	LS Tension release running delayed angles selection. 鬆線延遲角度。	0 - 360 degrees	0	Valid for [80.LLM]=L1/L2/L3/L7/L8 有效於 [80.LLM]=L1/L2/L3/L7/L8 時。
	86	L1 Tension release running delayed time selection. 鬆線延遲時間。	0 - 990 ms	0	Valid for [80.LLM]=L4/LK/LS/L7/L9 有效於 [80.LLM]=L4/LK/LS/L7/L9 時。
	87	L2 Tension release running time selection. 鬆線動作時間。	0 - 1500 ms	0	Valid for [80.LLM]=L1/L3/L4/LK/LS/L7/L9 有效於 [80.LLM]=L1/L3/L4/LK/LS/L7/L9 時。
	88	LE Tension release running angles selection. 鬆線動作角度。	0 - 360 degrees	0	Valid for [80.LLM]=L2/L8 有效於 [80.LLM]=L2/L8 時。
	89	D1 Delayed timing prior to upper trimmer engaged at down-stop. 下停切線延遲時間。	0 - 990 ms	30	Only valid when [78.TRM] set at 「 KB 」 mode. Signal output from the wiper MW. See the KB timing chart.
	90	D2 Setting timing of upper trimming at down-stop. 下停切線動作時間。	0 - 2500 ms	90	僅有效於 [78.TRM]=KB 時。
	91	D3 Timing recall of upper trimming at down-stop. 下停切線馬達復原運轉時間。	0 - 990 ms	120	由掃線MW信號輸出。 參見KB時序圖。
	92	W1 Wiper running delayed time selection. 上節刀(上吹風)延遲時間。	0 - 980 ms	10	
	93	W2 Wiper running time selection. 上節刀(上吹風)動作時間。	0 - 9990 ms	70	
	94	WF Foot lifting running delayed time after wiper active.	0 - 990 ms	50	
	95	CSF Condense-Stitch function selection. 密縫或鎖針模式選擇。	ON/OF/SL1/ST	OF	ON : Enable CS. Note : [96.CON]=8 / [97.FOS]=3 / [27. CT]=50 / [5. V] must be adjusted. ON : 密縫功能。註解:[96.CON]=8 / [97.FOS]=3 / [27. CT]=50 / [5. V] 調整。 OF : Disable. OF : 禁止。 SL1 : SL1 Stitch lock. Note: [96.CON]=0 / [97.FOS]=2 / [89. D1]=30 / [90. D2]=90 / [91. D3]=120 / [5. V]=1500 must be adjusted. ST : ST Stitch lock. Note: [96.CON]=1 / [97.FOS]=0 / [89. D1]=40 / [90. D2]=70 / [91. D3]=0 / [5. V] must be adjusted. ST : ST 鎖針功能。註解:[96.CON]=1 / [97.FOS]=0 / [89. D1]=40 / [90. D2]=70 / [91. D3]=0 / [5. V] 調整。
	96	CON Setting stitches of Condense-Stitch sewing. 密縫或鎖針開啟針數。	0 - 99 stitches	8	Valid only when the [95.CSF]=ON/SL1/ST. 只在 [95.CSF]=ON/SL1/ST 時有效。
	97	FOS Setting stitches prior to stop beyond Condense-Stitch. 密縫或鎖針關閉針數。	0 - 99 stitches	3	Valid only when the [95.CSF]=ON/SL1/ST. 只在 [95.CSF]=ON/SL1/ST 時有效。
	99	SEN Sensor function. 電眼功能。	ON/OF	OF	ON : Valid for all edge sensors. ON : 有效。 OF : Invalid for all edge sensors. OF : 無效。
100	SRS Ignored stitch number for mesh counter 電眼檢出網格排除針數。	0 - 99 stitches	1		
101	CMS Mesh counter for edge sensors. 電眼檢出網格確認針數。	0 - 99 stitches	3		
102	SE Motor stopped stitches by sensor. 電眼檢出停車針數。	0 - 999 stitches	6		

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼		Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述
按 "P" 鍵 + 電源開啟	103	SET	Process reset mode at sensor stop. 程序完成結束模式選擇。	ON/OFF	OF	ON : After the [102. SE] stitches finished, the process reset automatically. ON : [102. SE] 針數完成後自動重置。 OF : After the [102. SE] stitches finished, motor stopping ; free sewing forward is possible by pedal toe down. The process reset only by pedal full heeling. OF : [102. SE] 針數完成後, 前踏可自由車縫, 後踏才可程序重置。
	104	PSU	Stitches for emergency up-stop. 緊急停止於針上針數。	1 - 99 stitches	6	When PSU signal detected, running the stitches then stop at UP position. The speed of setting stitches is set by [9. A] 當偵測到PSU信號時, 自動運轉此針數, 然後停車於針上。 自動運轉速度由 [9. A] 設定。
	105	PSD	Stitches for emergency down-stop. 緊急停止於針下針數。	1 - 99 stitches	6	When PSD signal detected, running the stitches then stop at DOWN position. The speed of setting stitches is set by [9. A]. 當偵測到PSD信號時, 自動運轉此針數, 然後停車於針下。 自動運轉速度由 [9. A] 設定。
	106	PSN	Restart after the edge sensor. 電眼管制車縫。	ON/OFF	ON	ON : Restarting is not allow with the pedal toe down even if the sensor detected the fabric. ON : 有面料才可以啟縫。 OF : Restarting is always possible with the pedal toe down. OF : 永遠可以啟縫。
	107	S7U	Manual Back-Tacking engaged at needle-up position. 回縫電磁閥針上開啟, 手動回縫開關ON時。	ON/OFF	OF	When motor running, manually push the Touch Back switch, reverse solenoid engaged on at needle up. 當馬達運行時, 按下回縫開關, 回縫電磁閥會在針上啟動。 ON : Valid. ON : 有效。 OF : Invalid. OF : 無效。
	108	S7D	Manual Back-Tacking engaged at needle-down position. 回縫電磁閥針下開啟, 手動回縫開關ON時。	ON/OFF	ON	When motor running, manually push the Touch Back switch, reverse solenoid engaged on at needle down. 當馬達運行時, 按下回縫開關, 回縫電磁閥會在針下啟動。 ON : Valid. ON : 有效。 OF : Invalid. OF : 無效。
	109	ROF	Mode for de-engaging Back-Tacking. 回縫電磁閥關閉時機, 手動回縫開關OF時。	ON/OFF	OF	During sewing, reverse output will be OF at needle UP or DOWN position. 縫製中, 回縫電磁閥於針上或針下關閉。 ON : At needle UP position. ON : 針上關閉。 OF : At needle DOWN position. OF : 針下關閉。
	111	COR	Correction Mode of Touch-Back Switch. 回縫開關納入提針機能。	1/2	2	Correction mode selection for Touch-Back Switch. Note: [10.ACD]=OF and [11.RVM]=B 回縫開關納入提針機能。備註: [10.ACD]=OF與[11.RVM]=B時。 1 : Doing correction with one touch the Touch-Back switch. 1 : 按1下回縫開關即提針。(車縫途中停止時) 2 : Doing correction with double touch the Touch-Back switch. 2 : 按2下回縫開關即提針。(車縫途中停止時)
	112	WMD	Wiper function related to full-heeling pedal. 全後踏關聯掃線機能。	W/O/A	W	W : Regular wiper function. (active 1 time when full heeling back after sewing) W : 標準掃線模式。(後踏動作1次) O : Wiper works at each full heeling back. (unlimited) O : 全後踏連動掃線。(無限) A : Wiper works only the pedal is kept full heeling back. Wiper turn OF when the pedal return to neutral. A : 全後踏啟動掃線時序, 中立關閉掃線。

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述	
Press P Key + Power on 按 "P" 鍵 + 電源開啟	113	DEG	Needle DOWN position stop angle. 針下位置停止角度.	5 - 180 degrees	12	
	114	UEG	Needle UP position stop angle. 針上位置停止角度.	5 - 180 degrees	12	
	115	PMD	Power on display condition. 開機顯示條件.	ON/OFF	OF	ON : When power switch turned on, the panel displays previous condition. (Keep previous condition). ON : 當電源開啟時, 面板將顯示以前的狀態. (保持先前的狀態) OF : When power switch turned on, the panel displays normal mode. OF : 當電源開啟時, 面板標準顯示.
	116	DRU	Reverse angles through Needle down and up. 針下與針上通過反轉角度	1 - 360 degrees	180	Valid only when [78.TRM]=RK mode. Motor reverses from needle down, and stops at the needle upper dead point. 只在 [78.TRM]=RK 時有效. 馬達反轉由針下開始, 停止於針上.
	117	ER	Error code display. 故障碼紀錄顯示.	5 set	-	
	118	NOS	Converting to a clutch motor selection. 離合器行為.	ON/OFF	OF	ON : Without the synchronizer, motor is running as a clutch motor and stops at random position. ON : 同離合器行為, 隨機停止. OF : With synchronizer. OF : 依照定位器.
	119	DD	Symbolic display of the motor rotation. 電機符號旋轉方向.	ON/OFF	ON	ON : CCW. ON : 逆時針. OF : CW. OF : 順時針.
	120	FHM	Mode selection for full-heeling after power on or trimming. 開電或切線後, 全後踏動作模式.	FU/NU/NO/NUF/EFF	FU	FU : Regular operation -- full heeling for trimming and foot lifting. FU : 標準模式 -- 全後踏切線與抬壓腳. NU : Full heeling for up needle. NU : 全後踏提針. NO : No foot lifting function. NO : 全後踏不抬壓腳. NUF : Full heeling for foot lifting and up needle. NUF : 全後踏提針與抬壓腳. EFF : Full heeling for foot lifting and running at low speed. EFF : 全後踏抬壓腳並低速車縫.
	121	ANU	Needle goes up as power turned ON. 開電自動找針上.	ON/OFF	OF	
	122	HL	Upper limit of maximum speed. 最高速度上限.	50 - 5000 spm	4500	

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述	
Press S Key + Power on 按 "S" 鍵 + 電源開啟	123	FAS	Factory default save. 儲存出廠設定。	FASET	FASET	
	124	PG	Program down load from /save to operation box (T220, C300) / computer 操作盒上傳下載。	NOP/LOAD/SAVE/ COPY/IU/IV/IP/E2P	NOP	NOP : No function. NOP : 無機能。 LOAD : Down load the program from T220 / C300 operation panel. LOAD : 由操作盒下載至控制箱。 SAVE : Save the program to T220 / C300 operation panel. SAVE : 由控制箱上傳至操作盒。 COPY : No function. COPY : 無機能。 IU : Current sensor initial value. IU : 電流檢知器初始值。 IV : Current sensor initial value. IV : 電流檢知器初始值。 IP : Program Stack register value Display. IP : 程序暫存器值。 E2P : Rester EEPROM E2P : 重寫EEPROM
	125	USM	Mode for the manual needle up switch. 手動提針開關模式。	A/B/C/D/E/F/G/H/I	A	A : Stitch changeover + inching(when the needle up switch is held down). A : 半針+低速(當提針開關按住時). B : Stitch changeover only. B : 半針。 C : Up needle only. C : 針上。 D : Up needle and presser foot. D : 針上抬壓腳。 E : Inching one stitch only. E : 一針。 F : Inching one stitch backward only. F : 回縫一針。 G : Backward running for [133.CHS] setting stitches. G : 回縫[133.CHS]針數。 H : Up needle + Tension on + Sewing suppression + O5 BTL Lamp blinks. H : 針上 + 鬆線ON + 禁止車縫 + BTL閃爍。 I : Up needle + Tension on + presser foot + Sewing suppression + O5 BTL Lamp blinks. I : 針上 + 鬆線ON + 壓腳ON + 禁止車縫 + BTL閃爍。
	126	USA	Mode selection for [125.USM] [125.USM]模式選擇。	ON/OFF	OF	ON : Always enable. ON : 隨時有效。 OF : Enable only at intermediate stop. OF : 車縫途中有效。
	127	MAV	Maximum voltage hold. 最大電壓值紀錄顯示。		—	
	128	MIV	Minimum voltage hold. 最小電壓值紀錄顯示。		—	
	129	PV	Current voltage display. 當前電壓顯示。		—	
	130	OVD	Over voltage setting. 過電壓檢出位準。	340 - 360	350	
	132	UPG	User program saving. 使用者程序保存。	0 - 3	0	Save the user's parameter setting into memory blocks for later use. Setting procedure: 1. Press S key display [UPG. 0] 2. Press D key to select a block number from [UPG. 0] ~ [UPG. 3] 3. Press A key to save the program. (Press C key to load the program.) 使用者參數設置保存與下載操作說明: 1. 按S鍵顯示[UPG. 0] 2. 按D鍵選擇[UPG. 0] ~ [UPG. 3] 3. 按A鍵參數設置保存。(按C鍵參數設置下載)

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述
Press S Key + Power on 按 "S" 鍵 + 電源開啟	134	KLK SBT/EBT Key Lock selection. 鎖住SBT/EBT按鍵.	ON/OF	OF	ON : Locked. The A/B/C/D keys will be defined to specific functions as follow: A key : Cancel foot lifting after at half- heeling pedal. B key : Cancel trimmer function at full heeling pedal. C key : Cancel wiper function at full heeling pedal. D key : Start constant stitch setting. ON : 鎖住. 按鍵A/B/C/D將定義為下列功能. A鍵: 取消半後踏抬壓腳. B鍵: 取消切線. C鍵: 取消掃線. D鍵: 前密縫. OF : Unlocked. OF : 不鎖住.
	135	TOT Auto-running full time setting. 自動運行時間設置.	0 - 168 Hrs	1	Auto-running full time setting. When [138.UTD]=ON valid. Note: [135.TOT]=0 for unlimited time. 自動運行模式總時間. 當[138.UTD]=ON有效. 註解: [135.TOT]=0 不限時間.
	136	TM1 Auto-running on cycle time setting. 自動運轉 on 時間設定.	(1-250)x0.1S 1-250 ms	20	When [138.UTD]=ON valid. When output is setting TF the value is delay time. (x10ms) 當[138.UTD]=ON 有效. 當出力=TF為延遲時間.
	137	TM2 Auto-running OF cycle time setting. 自動運轉 OF 時間設定.	(1-250)x0.1S 1-250 ms	20	When [138.UTD]=ON valid. When output is setting TF the value is on time. (x10ms) 當[138.UTD]=ON 有效. 當出力=TF為動作時間.
	138	UTD Auto-running test selection. 自動運轉功能.	ON/OF	OF	ON : Valid. ON : 啟動. OF : Invalid. OF : 關閉.
	139	PSL Speed curve adjustments. 速度曲線調整.	1 - 100%	85	
	140	OSE Outside setting the [102. SE] parameter. 外部設置參數[102. SE]	ON/OF	OF	C-300 operation box E&F stitches. C-300操作盒E&F段針數. ON : Enable. ON : 啟用. OF : Disable. OF : 禁止.

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述
按 "S" 鍵 + 電源開啟 Press S Key + Power on	144	IN1		OP	<p>IN1 input function select. IN1輸入功能選擇.</p> <p>NOP : No function. 無機能.</p> <p>OP : Folder function.(Relative when the output be setted for OP/OM) OP開關.</p> <p>TK : Tape cutting switch input. 手動斬刀開關.</p> <p>U : Needle up function of [125.USM]. 提針開關.</p> <p>USR : Up the needle by the angle of [58.TR8] when this switch pushed on. 提針[58.TR8]角度.</p> <p>BCR : An input signal for selecting ON / OF of motor start with a reverse angle, Valid only when [125.USM]=OF 啟動反轉, 有效於[125.USM]=OF</p> <p>F : Knee switch input. 壓腳開關.</p> <p>HP : High lift of walking foot input. 高壓腳開關.</p> <p>PT : Edge sensor. 電眼.</p> <p>PSU : An input signal for emergency stop at up position. 緊急停針上開關.</p> <p>PSD : An input signal for emergency stop at dn position. 緊急停針下開關.</p> <p>ES : An input signal for emergency stop. 緊急停止.</p> <p>CW : Reverse run signal. 反轉.</p> <p>BTL : Back-tacking suppression / recall switch for SBT/ EBT only. 前回縫與後回縫, 取消或回復單次有效.</p> <p>BTC : Back-tacking suppression + OS BTL Lamp On / cancel for SBT/ EBT only. 前回縫與後回縫, 取消全程有效.</p> <p>SH : A one-shot signal for speed change limited by [9. A]. 自動運轉.</p> <p>S6 : Safety switch input. 安全開關.</p> <p>S7 : An input signal for reverse sewing. 回縫開關.</p> <p>DB2 : Motor is running by [190. B2] speed. 馬達運轉依[190. B2]速度.</p> <p>DB3 : Motor is running by [191. B3] speed. 馬達運轉依[191. B3]速度.</p> <p>S0 : An input signal for speed change limited by low speed of [60. L] 運行[60. L]速度.</p> <p>S4 : Motor is running with [1. H] speed setting. 運行[1. H]速度.</p> <p>ST1 : Inching one stitch only. 提針1針.</p> <p>ST2 : Up needle + Tension on + Sewing suppression + BTL Lamp blinks. 針上 + 鬆線ON + 禁止車縫 + BTL閃爍.</p> <p>ST3 : Up needle + Tension on + presser foot + Sewing suppression + BTL Lamp blinks. 針上 + 鬆線ON + 壓腳ON + 禁止車縫 + BTL閃爍.</p> <p>ST4 : Up needle + presser foot + Sewing suppression + BTL Lamp blinks. 針上 + 壓腳ON + 禁止車縫 + BTL閃爍.</p> <p>ST5 : Up needle + Sewing suppression + BTL Lamp blinks. 針上 + 禁止車縫 + BTL閃爍.</p> <p>CRS : An input signal for counter reset, Valid only when [42.CUD]=U/D/US/DS/UT/DT/UTS/DTS 計數器重置. 有效於[42.CUD]=U/D/US/DS/UT/DT/UTS/DTS</p> <p>FAW : A signal for bobbin thread detector. 底線檢知.</p> <p>WL : Wiper output cancel switch. 滯線取消.</p> <p>TL : An input signal for trimmer output cancel. 切線取消.</p> <p>BWL : Thread break detector Lo. 斷線檢知器Lo觸發.</p> <p>BWH : Thread break detector Hi. 斷線檢知器Hi觸發.</p> <p>NUD : Motor stop position, Lo by needle up, Hi by needle down. 停針位, Lo停針上, Hi停針下.</p> <p>RST : Valid only when the [47.MAC] set 15/16/17/111/112. (No used) 只在 [47.MAC]=15/16/17/111/112 時有效. (未使用)</p> <p>PUL : Puller switch. 輔助輪開關.</p> <p>IO2 : Inching one stitch backward + reverse sewing. Valid only when [10.ACD]=OF and [11.RVM]=B mode. 回縫一針 + 回縫開關. 只在 [10.ACD]=OF 與 [11.RVM]=B 與 入力選項無S7 時有效.</p> <p>IO3 : Inching one stitch + reverse sewing. Valid only when [10.ACD]=OF and [11.RVM]=B mode. 一針 + 回縫開關. 只在 [10.ACD]=OF 與 [11.RVM]=B 與 入力選項無S7 時有效.</p> <p>OPC : Folder turn off switch.(Relative when the output be setted for OP) OPC開關.</p>

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述
按 "S" 鍵 + 電源開啟	145	IN2		U	
	150	INE		S7	
	151	INF		F	
	153	INK		HP	

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述
Press S Key + Power on 按 "S" 鍵 + 電源開啟	154 OA	<p>OA output function select. OA輸出功能選擇.</p> <p>NOP : No function. 無機能. TM : Trimmer output. 切線. WP : Wiper output. 上飾刀(上吹風) MR : Reverse output. 回縫. ML : Tension release output. 鬆線. TK : Tape cutting output. 斬刀. OP : Folder function output. (Alternative mode) OP. (交互動作模式) OM : Folder function output. (Momentary mode) OM. (單次動作模式) ASL : Chain cutter mode 2. (No used) 節氣吸模式二. (未使用) NCL : Needle Cooling output. (Motor running signal), (Lint suction) 針冷卻. HP : High lift for walking foot output. (Momentary mode) 高壓腳.(單次動作模式) HPL : HP_LED output. 高壓腳指示燈. BTL : BTL_LED output. 前回縫與後回縫, 取消或回復單次有效, 指示燈. FK : Thread nipper output. 夾線. PUL : Puller output. 輔助輪. TB : Trimming function output, motor running link. 修整機能, 馬達運行連動. TF : Trimming function output. Related parameter : [136.TM1], [137.TM2] 修整機能. 相關參數: [136.TM1], [137.TM2] UC : Output is turned ON if at needle up position when the sewing machine is stopped. 停止於針上指示燈. CK : Needle down pulse width output. 針下信號. PO1 : Needle down pulse width output. 針下信號. PO2 : Needle up pulse width output. 針上信號. P12 : Needle down, needle up pulse width output. 針上針下信號. BUZ : Buzzer output is turned on when the [42.CUD]=US/DS/UTS/DTS and the count becomes end. RESET: When the counter reset by pushing the "A" key at panel of controller or by CRS input signal. 計數器報警. ALM : Buzzer output is turned on when the CLK, and [328. RH] setting value < [327.PRH] setting value. RESET: When the counter reset by pushing the "A" key at panel of [RH. Xxxx] or by CRS input signal. (No used) 計時保養報警. (未使用) FD : Rear ON time to [87. L2], when [99.SEN]=ON valid only. 後段開啟 [87. L2] 時間, 當[99.SEN]=ON 時. FNC : Edge sensor with Needle Cooling. 電眼連動針冷卻. KS1 : Activated with [102.SE], when [205.BAF]=1/2 valid only. [102.SE]針數連動, 當[205.BAF]=1/2 時. KS2 : Activated with edge sensor, when [205.BAF]=1/2 valid only. 電眼連動, 當[205.BAF]=1/2 時. KS3 : Trimming function output. Related parameter : [248. T6], [249. T7] 修整機能. 相關參數: [248. T6], [249. T7] KS4 : Activated with pedal, when [205.BAF]=1/2 valid only. 踏板連動, 當[205.BAF]=1/2 時.</p>		TM	

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述	
Press S Key + Power on 按 "S" 鍵 + 電源開啟	155	OB	OB output function select. OB輸出功能選擇. NOP : No function. NOP : 無機能. All other functions of the keys as with parameter [154. OA] 其他所有功能同參數[154. OA]	WP		
	156	OD	OD output function select. OD輸出功能選擇. NOP : No function. NOP : 無機能. All other functions of the keys as with parameter [154. OA] 其他所有功能同參數[154. OA]	ML		
	157	O1	O1 output function select. O1輸出功能選擇. NOP : No function. NOP : 無機能. All other functions of the keys as with parameter [154. OA] 其他所有功能同參數[154. OA]	OP		
	158	O3	O3 output function select. O3輸出功能選擇. NOP : No function. NOP : 無機能. All other functions of the keys as with parameter [154. OA] 其他所有功能同參數[154. OA]	HP		
	163	BD	Setting the times of [57. TRU]=ON. 切線後反轉穩定時間.	70 - 990	70	
	164	MXI	Maximum current limiter. 馬達最大電流.	5 - 22A	10	
	165	WKT	Weak braking torque scale. 馬達停止時續住力.	0.1 - 5.0	2.0	
	166	ACT	Acceleration time adjustment. 加速時間調整.	60 - 990 ms	140	
	167	DCT	Deceleration time adjustment. 減速時間調整.	60 - 990 ms	160	
	168	HKP	Motor's holding torque gain adj. 定位增益.	5 - 400	25	
	169	LKP	Low speed gain. 低速增益.	5 - 400	40	
	170	KP	Gain kp Kp增益.	5 - 150	30	
	171	KI	Gain ki Ki增益.	100 - 3000	1800	
	172	KS	Gain ks Ks增益.	1 - 40	18	
173	QSK	Quick stop counter. 定位距離.	30 - 999	100		
174	QSP	Quick stop speed. 定位速度.	50 - 500	100		

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述
按"停針位"鍵 + 電源開啟 Press needle up/down key + Power on	176	VDN Positioning by index (reference) point. 虛擬定位模式。	OF/A/B/C	OF	OF : Needle up and down is adjusted by external synchronizer. OF : 針上與針下由定位器調整。 A : Needle up is adjusted by [179.PUA], and needle down is adjusted by [181.PDA] A : 針上由[179.PUA]調整, 針下由[181.PDA]調整。 B : Needle up is adjusted by [179.PUA], needle down is adjusted by [181.PDA] and needle bar upper dead point is adjusted by [183.PUB] B : 針上由[179.PUA]調整, 針下由[181.PDA]調整, 切線後由[183.PUB]。 C : When pedal control, needle up is adjusted by [179.PUA], needle down is adjusted by [184.PDB] , [185.PDC] ; if U switch operation in half stitch control ; then, can stop the motor at [179.PUA] , [181.PDA] , [184.PDB] , [185.PDC] this function for handle stitch machine only. C : 針上由[179.PUA]調整, 針下由[184.PDB] [185.PDC]調整, 擇針順序[179.PUA] [184.PDB] [181.PDA] [185.PDC]
	177	SIN Single positioning signal synchronizer. 單信號兩定位。	ON/OF	OF	ON : Valid. ON : 有效。 OF : Invalid. OF : 無效。
	178	NU Define the UP positioning signal mode H/L 單信號兩定位針上信號位準。	H/L	L	L : Input logic Lo active for needle up. L : 信號Lo為針上。 H : Input logic Hi active for needle up. H : 信號Hi為針上。
	179	PUA Virtual up A position edge angle. 虛擬針上位置A。	0 - 359 degrees	0	
	180	PUW Virtual up A position ON angle. 虛擬針上位置A角度。	10 - 70 degrees	40	
	181	PDA Virtual down A position edge angle. 虛擬針下位置A。	0 - 359 degrees	180	
	182	PDW Virtual down A position ON angle. 虛擬針下位置A角度。	10 - 70 degrees	40	
	183	PUB Virtual up B position edge angle. 虛擬針上位置B。	0 - 359 degrees	0	
	184	PDB Virtual down B position edge angle. 虛擬針下位置B。	0 - 359 degrees	90	
	185	PDC Virtual down C position edge angle. 虛擬針下位置C。	0 - 359 degrees	270	
	186	MS Walking foot lifting maximum speed. 高壓腳最高速度。	200 - 5000 spm	3500	
	187	WS Walking foot lifting minimum speed. 高壓腳最低速度。	200 - 4800 spm	2000	
	188	MIN Minimum stroke value of potentiometer for walking foot lifting. 高壓腳電位器最小行程值。	0 - 255	---	
	189	MAX Maximum stroke value of potentiometer for walking foot lifting. 高壓腳電位器最大行程值。	0 - 255	---	
	190	B2 DB2000 speed limiter. DB2000速度限制。	200 - 5000 spm	2000	
	191	B3 DB3000 speed limiter. DB3000速度限制。	200 - 5000 spm	3000	
	192	PTE Positioning teaching mode. 虛擬定位學習模式。	ON/OF	OF	ON : Must be selected when [176.VDN]= A/B/C ON : 當[176.VDN]= A/B/C有效。 OF : Invalid. OF : 無效。
202	IBV INB input logic changeover. INB輸入邏輯轉換。	ON/OF	OF	ON : Edge sensor type for D-ON ON : 電眼型式為D-on OF : Edge sensor type for L-ON OF : 電眼型式為L-on	
205	BAF Mode selection for hemming guide device. 包邊裝置模式。	OF/1/2/3	OF	OF : Invalid. OF : 無效。 1 : For auto mode hemming guide device. 1 : 自動包縫。 2 : For manual mode hemming guide device. 2 : 手動包縫。 3 : For constant-stitch mode hemming guide device. 3 : 定針包縫。	

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述	
按"慢速起縫"鍵 + 電源開啟 Press slow start Key + Power on	208	VER Software Version. 軟體版本.	-	TD6B04	When the software version is TD6C04, show as "TD6C04".	
	209	IDX Define the source of Index (reference) point. 定位指標信號來源.	UP/DN	UP	UP : The reference index point is from the needle up signal. UP : 針上信號當指標. DN : The reference index point is from the needle down signal. DN : 針下信號當指標.	
	212	THP The timing prior to HP speed. HP速度轉換時間.	80 - 500 ms	100		
	213	CHP Setting the number of stitches for HP function. HP針數.	0 - 255	0	Valid only when [62.HPM]=ALT 只在[62.HPM]=ALT有效.	
	214	FNK Mode for the "needle cooling" output. 針冷卻模式.	0/1/2	0	0 : Normal needle cooling function. by [215. T5] setting delay OF needle cooling output. 0 : 受限參數[215. T5] 1 : Normal needle cooling function. by [215. T5] & [216. NK] setting. 1 : 受限參數[215. T5] & [216. NK] 2 : Pedal with needle cooling. 2 : 踏板運動針冷卻.	
	215	T5 Setting the needle cooling delay OF time. 針冷卻延遲關閉時間.	0 - 2550 ms	0		
	216	NK Setting the needle cooling speed. 針冷卻速度限制.	40 - 6000 spm	40		
	217	FLK Lift roller function. 輔助輪模式.	0/1/2/3/4/5	0	0 : Roller works independently. 0 : 輔助輪獨立工作. 1 : Roller works with foot lifter and back tacking. 1 : 壓腳與回縫運動輔助輪. 2 : Roller works with foot lifter. 2 : 壓腳運動輔助輪. 3 : Roller works with back tacking. 3 : 回縫運動輔助輪. 4 : Roller works with foot lifter and back tacking. (Back tacking delay puller output by [96.CON] stitch.) 4 : 壓腳與回縫運動輔助輪. (後回縫之前, 先動作[96.CON]針數) 5 : Roller works with back tacking. (Back tacking delay puller output by [96.CON] stitch.) 5 : 回縫運動輔助輪. (後回縫之前, 先動作[96.CON]針數)	
	218	STR Tension release output function. 鬆線模式.	0/1/2	0	0 : Tension R. output depends on the timing of [80.LLM] only. 0 : 鬆線依[80.LLM] 1 : Tension R. operates with foot lifting after motor stop. 1 : 鬆線運動壓腳, 車縫中途半後踏有效, 運動10秒限定. 2 : Tension R. operates with foot lifting after trimming or power on. 2 : 鬆線運動壓腳, 車縫中途半後踏無效, 運動10秒限定.	
	220	INB INB input function select. INB輸入功能選擇. NOP : No function. NOP : 無機能. All other functions of the keys as with parameter [144. IN1] 其他所有功能同參數[144. IN1]			PSD	
	222	TOF Trimmer protection function. 切線保護機能.		ON/OF	OF	ON : Enable. ON : 啟用. OF : Disable. OF : 禁止.
	223	S2P Selecting the trimmer protection mode. When [222.TOF]=ON 切線保護模式. 當[222.TOF]=ON時.		NO/PS	NO	NO : Operate foot lifting only, without up needle and thread trimming. NO : 偏移成立, 後踏抬壓腳, 不提針, 不切線. PS : Operate foot lifting and up needle only, without thread trimming. PS : 偏移成立, 後踏提針壓腳, 不切線.
224	TOA Setting the range for thread trimmer protection. When [222.TOF]=ON 切線保護角度. 當[222.TOF]=ON時.		5 - 40 degrees	10		

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述	
按 "慢速起繃" 鍵 + 電源開啟 Press slow start key + Power on	226	CTW	Stitches prior to the roller is lowered. 手動輔助輪針數。	0 - 255 stitches	10	
	227	PLC	ON/OFF switch for [226.CTW] 手動輔助輪機能。	ON/OFF	OF	ON : Enable. ON : 啟用。 OF : Disable. OF : 禁止。
	228	FBM	Forward_backward_motion control function. 往復式運動。	ON/OFF	OF	ON : Enable. ON : 啟用。 OF : Disable. OF : 禁止。
	229	KHP	Setting the number of stitches for HP function. 半後踏運動高壓腳針數。(車縫途中有效)	0 - 255 stitches	0	
	230	KLC	To operate HP function by half heeling pedal. 半後踏運動高壓腳機能。(車縫途中有效)	ON/OFF	OF	ON : Enable. ON : 啟用。 OF : Disable. OF : 禁止。
	231	FLC	To operate HP function by the knee switch. 膝蓋開關運動高壓腳機能。	ON/OFF	OF	ON : Enable. ON : 啟用。 OF : Disable. OF : 禁止。
	232	DBA	Manual backtack with speed limitation [191. B3] 手動回縫開關限速[191.B3]	ON/OFF	OF	ON : Enable. ON : 啟用。 OF : Disable. OF : 禁止。
	233	KNA	Knee switch control function. 膝蓋開關模式。	ON/OFF	OF	ON : The knee switch can be activated during sewing. (Used for blind stitch machine) ON : 縫製中膝蓋開關有效。(適用於盲縫車) OF : The knee switch can be activated at sewing stop only. OF : 縫製中膝蓋開關無效。
	235	FHP	Setting the number of stitches for HP function. 壓腳開關運動高壓腳針數。	0 - 255 stitches	0	
	238	CK1	CK output ON delay angle. CK開啟延遲角度。	0 - 250 degrees	0	Valid only when CK output. 只在CK出力有效。
	239	CK2	CK output OFF delay angle. CK關閉延遲角度。	0 - 250 degrees	10	
	240	O2	O2 output function select. O2輸出功能選擇。 NOP : No function. NOP : 無機能。 All other functions of the keys as with parameter [154. OA] 其他所有功能同參數[154. OA]		NCL	
	242	IDC	Password Function. 密碼機能。	ON/OFF	OF	ON : Enable. Note: Passcode Level 1/7/8/9/10 (1689), Level 2/3/4/5/6 (1269) ON : 啟用。備註: 第1/7/8/9/10階(1689), 第2/3/4/5/6階(1269) OF : Disable. OF : 禁止。
	244	SFO	Full-On time setting for tension release solenoid. 鬆線全額出力時間調整。	0 - 990 ms	350	Valid only when the [63.FTP] set M. 只在 [63.FTP]=M 時有效。
	245	SFC	Duty cycle time setting for tension release solenoid.	10 - 100 %	40	Valid only when the [63.FTP] set M. 只在 [63.FTP]=M 時有效。
	247	MTC	The tape cutting switch mode selection when sensor detected. 當電眼觸發時, 手動斬刀動作模式選擇。	ON/OFF	OF	ON : Valid. (the tape cutting can active by manual control) ON : 開啟。(電眼檢測有加工物時手動切刀有效) OF : Invalid. (the tape cutting cannot active by manual control) OF : 關閉。(電眼檢測有加工物時手動切刀無效)
	248	T6	Delayed timing prior to trimmer engaged. KS4延遲動作時間。	0 - 990 ms	0	Valid for [79.LTM]=T4/TK/TS/T7 只在[79.LTM]=T4/TK/TS/T7有效。
249	T7	Trimming time. KS4動作時間。	0 - 990 ms	0	Valid for [79.LTM]=T1/T3/T4/TK/TS/T7 只在[79.LTM]=T1/T3/T4/TK/TS/T7有效。	
250	FTC	When the sensor is triggered, step forward again to sew. 電眼觸發後, 再前踏進行車縫。	ON/OFF	OF	ON : disable when the sensor detected on. (with fabrics) ON : 無前斬刀。 OF : Enable when the sensor detected OF. (without fabrics) OF : 有前斬刀。	
251	MTP	Motor Driver mode Selection. 馬達型式選擇。	0/1/2	2	0 : M5 motor. 0 : M5馬達。 1 : M5(8K) motor. 1 : M5(8K)馬達。 2 : M1 motor. 2 : M1馬達。	

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述
Press P key + foot lifting at motor stop + Power on 按 P 鍵 + "中立自動抬壓腳" 鍵 + 電源開啟	253	OL Motor overload protection function. 馬達過載保護。	500/750	500	500 : For 500W 500 : 適用於500W 750 : For 750W 750 : 適用於500W
	254	MSL Customer mode select. 顧客模式選擇。	H	H	H : By Hohsing Machine Code. H : 賀欣車頭碼。

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述
Press D key + Power on 按"D"鍵 + 電源開啟	255	CHO Check output motion. 檢查輸出動作。	OA/OB/OC/OD/ OF/O1/O2/O3	OA	Select the output, press and hold the A key to turn on, and release the A key to turn OFF. 選定輸出, 按住A鍵啟動輸出, 放開A鍵關閉輸出。
	256	CHI Check input motion. 檢查輸入動作。	---/IN1/IN2/INB/ INE/INF/INK/INL/ ING/INH	---	Normal display "---", when the input function INB is ON, it will display INB 正常顯示 "---", 當INB開關啟動將顯示"INB"
	258	RFC Duty cycle time setting for reverse solenoid. 回線佔空比時間調整。	10 - 90 %	25	
	260	FMP Foot lifting slow down. 壓腳軟下放功能選擇。	0/1/2/3/4	0	0 : Invalid. 0 : 無效。 1 : Duty [65. FC] x 10% takes 200ms to close the presser foot lifting. 1 : 空佔比[65. FC] x 10%維持200ms才關閉壓腳。 2 : Duty [65. FC] x 20% takes 200ms to close the presser foot lifting. 2 : 空佔比[65. FC] x 20%維持200ms才關閉壓腳。 3 : Duty [65. FC] x 30% takes 200ms to close the presser foot lifting. 3 : 空佔比[65. FC] x 30%維持200ms才關閉壓腳。 4 : Duty [65. FC] x 40% takes 200ms to close the presser foot lifting. 4 : 空佔比[65. FC] x 40%維持200ms才關閉壓腳。 When the software version is TD6B04, 260.FMP=2~4 fails, the function is same to 260.FMP=1
	261	AFM Foot lifting model selection. 自動抬壓腳模式。	OF/SF/TF/ST	OF	OF : Depends on the pedal. OF : 取決於踏板。 SF : At motor stop.. SF : 馬達停止。 TF : At trimming after. TF : 剪線完成。 ST : At trimming after & at motor stop. ST : 剪線完成與馬達停止。
	262	LUM Sensitivity adjustment for external LED brightness.	0/50/100/150/ 200/250	200	
	264	SCF Slow inch one stitch function. 操控1針加強。	ON/OF	OF	ON : Valid. ON : 有效。 OF : Invalid. OF : 無效。
	265	BUF Needle up selection when full heeling back the pedal. 踏板全後踏提針模式。	ON/OF	OF	ON : Valid. ON : 有效。 OF : Invalid. OF : 無效。
	266	FNU Full heel by Up needle only at sensor detect cloth. 全後踏提針.(工序不取消)	ON/OF	OF	ON : Valid. ON : 有效。 OF : Invalid. OF : 無效。
	267	TRS Setting the speed of [57.TRU]=ON. 切線後反轉速度。	200 - 900 spm	500	
268	CP Pulse. 脈衝。	1/60/72/90	1		

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述
按 "D" 鍵 + 電源開啟 Press D key + Power on	272	HLM Upper limit of maximum speed mode. 最高速度上限模式。	1/2/3/4/5/6/7/8 A/C	5	1 : limit of maximum 1000 1 : 最大限制為1000 2 : limit of maximum 2000 2 : 最大限制為2000 3 : limit of maximum 3000 3 : 最大限制為3000 4 : limit of maximum 4000 4 : 最大限制為4000 5 : limit of maximum 5000 5 : 最大限制為5000 6 : limit of maximum 6000 6 : 最大限制為6000 7 : limit of maximum 7000 7 : 最大限制為7000 8 : limit of maximum 8000 8 : 最大限制為8000 A : limit of maximum 6500 A : 最大限制為6500 C : limit of maximum 5500 C : 最大限制為5500
	273	SVC Pedal start stroke position adjustment. 前踏啟動行程調整。	1 - 12	6	1 : 1.40V ... 5 : 1.80V ... 9 : 2.20V ... 12 : 2.50V Automatic memory pedal voltage when power on. 電源開啟自動記憶踏板電壓
	274	TVC The stroke adjustment for full heeling pedal. 全後踏行程的調整。	0 - 9	0	0=0.40v ... 5=0.20v ... 9=0.12v
	281	INL INL input function select. INL輸入功能選擇。 NOP : No function. NOP : 無機能。 All other functions of the keys as with parameter [144. IN1] 其他所有功能同參數[144. IN1]		S6	
	283	STP Restart section function select. 程序結束縫紉模式。	ON/OFF	ON	ON : Normal stop after the [39. PS_P6] stitches finished even if the pedal toe down. ON : [39. PS_P6] 針數完成後, 一律停車。 OF : Motor non stop (at [39. PS_P6] stitches finished) when the pedal toe down. OF : [39. PS_P6] 針數完成後, 如果踏板保持前踏則不停車。
	284	SYN Synchronizer Select. 偵測定位器選擇。	ON/OFF	ON	ON : Extern Synchronizer. ON : 偵測。 OF : With motor index. OF : 不偵測。
	285	OC OC output function select. OC輸出功能選擇。 NOP : No function. NOP : 無機能。 All other functions of the keys as with parameter [154. OA] 其他所有功能同參數[154. OA]		MR	
	294	OPM OPC switch protection mode. OPC開關模式選擇。	NC/NO	NO	NC : Normal close. When signal at open, folder(OP.SOL) turn off. NC : 常閉. 當信號為打開, folder(OP.SOL)關閉。 NO : Normal open. When signal at close, folder(OP.SOL) turn off. NO : 常開. 當信號為關閉, folder(OP.SOL)關閉。

TD Parameters List(控制器參數設置列表)_E2

Software Version(軟體版本) : TD6B04(100P) / TD6C04(80P)

Panel 面板	Parameters Code 參數代碼	Parameters Function 參數功能	Range 範圍	Pre.setting for 預先設定	Description 描述
Press A key + Power on 按 "A" 鍵 + 電源開啟	301	IOT Iot function selection. IOT 功能選擇.	ON/OF	OF	ON : Valid. ON : 有效. OF : Invalid. OF : 無效.
	302	ID1 Control box ID (Hight Byte) 控制箱 ID Code 設定 (高位元)	0 - 7F	15	
	303	ID2 Control box ID (Low Byte) 控制箱 ID Code 設定 (低位元)	0 - FFFFFFFF	000001	
Press C key + Power on 按 "C" 鍵 + 電源開啟	352	KCT Tape cutting ON time. 斬刀開啟時間.	0 - 990 ms	100	
	354	KLM Tape cutting switch mode. 手動斬刀開關模式.	0/1/2	0	0 : Tape cutting. 0 : 斬刀. 1 : Air suction. 1 : 吸風. 2 : Tape cutting + Air suction. 2 : 斬刀 + 吸風
	355	KST Initial time for suction on when the manual TK switch enable. 手動斬刀之斬刀動作前斬刀吸風動作時間.	0 - 990 ms	0	
	356	KET Delay time for suction OF when the manual TK switch OF. 手動斬刀之斬刀動作後斬刀吸風動作時間.	0 - 990 ms	0	
	370	BWM Rester mode for thread break detector. 斷線檢知器重置模式.	0/1	1	0 : Rester for pedal. (E17) 0 : 踏板重置. (E17) 1 : Rester for S key. (E18) 1 : S鍵重置. (E18)
	371	BWN Stitch numbers for thread break detector. 斷線檢知器針數.	0 - 99 stitches	20	
Press B key + Power on 按 "B" 鍵 + 電源開啟	401	PYY Year of manufacture. 製造年份.	19 ~ 99	21	Support barcode. Note: Passcode 3426 支援條碼機. 備註: 密碼3426
	402	PMM Month of manufacture. 製造月份.	1 ~ 12	01	
	403	PNO Serial number of manufacture. 製造序號.	0 - 9999	0000	
	404	CMN Control box version number. 控制箱版本號.	0 - 255	0	Used in modbus system. 使用於modbus系統.