

**嵌入式曲折缝电控系统**  
**Zigzag Stitching Machine**  
**Electronic Control System**

**用户手册**

**User Manual**

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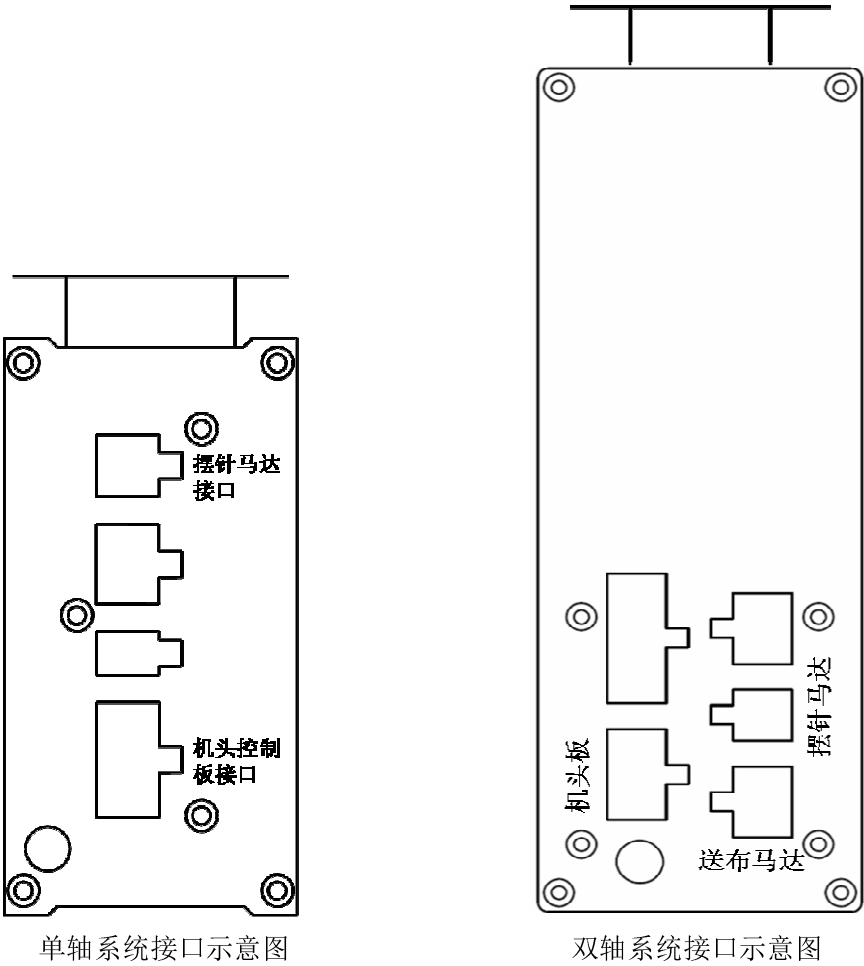
本手册若有更新恕不通知，任何技术咨询，请致电 0755-27513737 获得支持。

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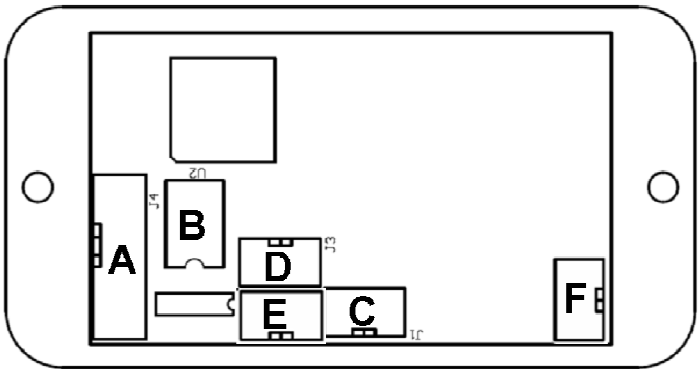
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# 1 控制箱硬件说明

## 1.1 控制箱的外部接口



## 1.2 机头控制板接口说明



机头控制电路板

| 插座/芯片          | 说明          |
|----------------|-------------|
| A（J4 白色 7 针插座） | 到控制箱的信号线插座  |
| B（U2 花样芯片）     | 客户定制花样芯片    |
| C（红色 3 针插座）    | 摆针电机零点传感器插座 |
| D（白色 3 针插座）    | 摆针同步传感器插座   |
| E（黄色 3 针插座）    | 送布同步传感器插座   |
| F（红色 3 针插座）    | 送布电机零点传感器插座 |

**注意：** 当花样芯片取下时，系统仍然可以正常工作！但系统只保留自带的花样，客户定制的花样将不再存在。同时花样的宽度默认为 8.0mm，只有在缝纫时设置改变，断电后不能保存。

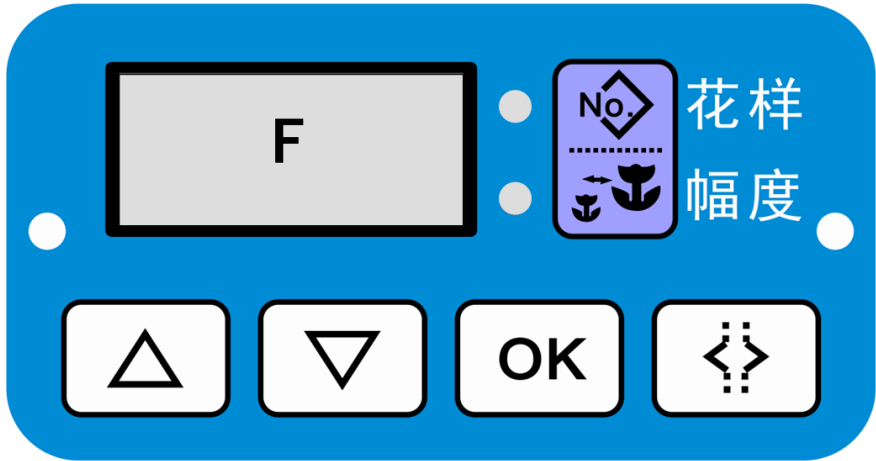
### 1.3 电源规格

电源电压：单相 AC100~240V

工作电流：平均电流小于 1.5A，峰值电流小于 2.5A

## 2 界面及操作说明

### 2.1 界面说明



面板界面

| 按键/窗口                                                                               | 说明                |
|-------------------------------------------------------------------------------------|-------------------|
| F（显示窗口）                                                                             | 由 3 位红色数码管显示      |
|  | 花样号、宽度、针距选择按键     |
|  | 增加按键              |
|  | 减小按键              |
| OK                                                                                  | 确认按键              |
|  | 花样镜像按键            |
|  | 指示灯，指示选择到花样、宽度或针距 |

### 2.2 操作说明

- 1、系统允许客户对四个设置对象改变操作：花样号、花样宽度、花样针距、花样镜像，其中花样号、花样宽度、花样针距由选择按键先选定，并由对应指示灯显示。

- 2、对于 OK 按键，用户在改变花样号、花样宽度、花样针距以及花样镜像后，都需要按该键确认。
- 3、每次按 OK 按键，系统都会回零一次。系统开电后会自动回零一次。
- 4、镜像按键按下后，花样的宽度前会显示一个“r”，再按一次“r”消失。镜像操作是实时的，断电后也不会保存。
- 5、花样的宽度改变从 0.0 到 9.0mm，每 0.1mm 可改变。
- 6、花样的针距改变从 0.0 到 3.0mm，每 0.1mm 可改变。
- 7、系统自带花样号从 1 到 240 可变（不同规格系统自带花样数量不同），客户定制花样号从单轴从 201 开始，双轴从 241 开始（不同规格系统允许客户定制的花样数量不同）。

## 2.3 传感器测试

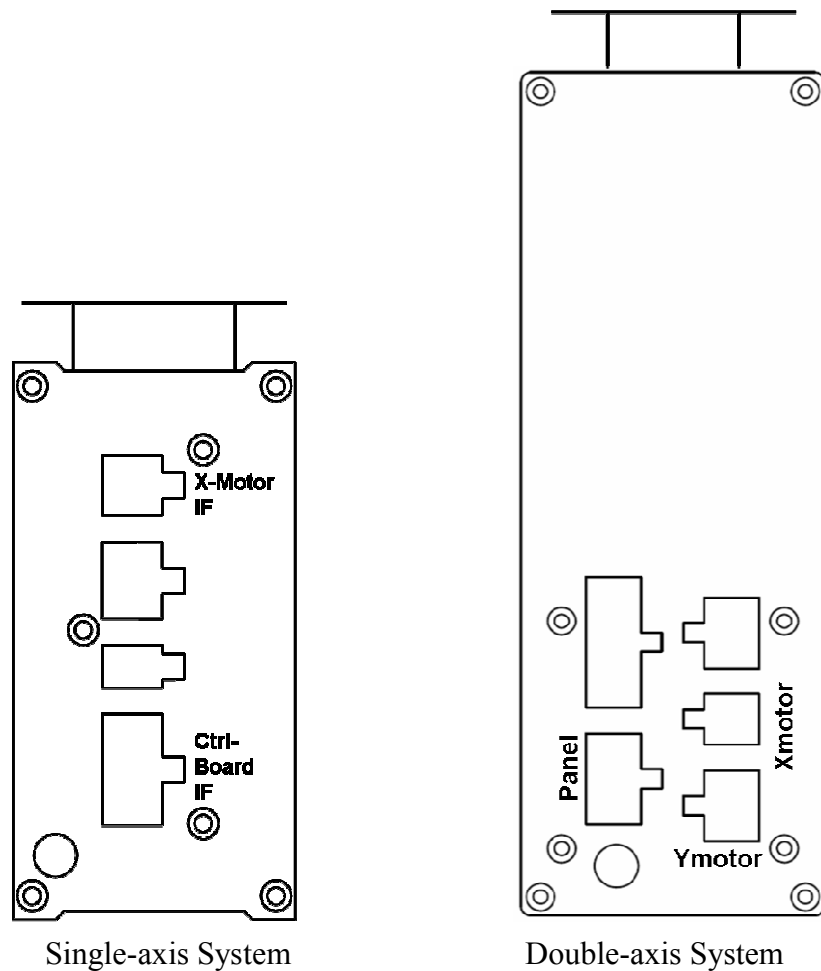
- 1、按住 OK 键同时开电，系统进入“PA1”界面（通过△、▽键选择 PA1、PA2 或 PA3），再按 OK 显示“L”或“H”，反复遮、放传感器观察值如有“L”和“H”翻转变则传感器是好的，反之故障。在“PA1”“PA2”、或“PA3”状态下长时间按 OK 键退出。PA1 对应摆针回零传感器，PA2 对应同步传感器，PA3 对应送布回零传感器。

## 2.4 报警

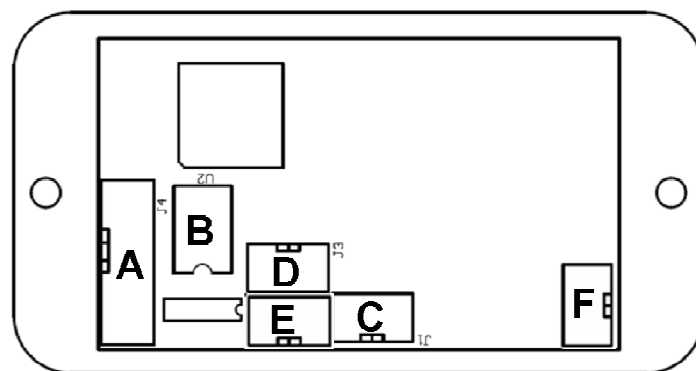
- 1、当摆针回零传感器故障、马达故障、接线故障、机械卡死时，系统开电回零或按确认 OK 键回零会报警“E-2”；送布轴则报“E-3”。
- 2、当客户花样芯片不存在，系统开电不会报警，系统照样可以正常工作，只是没有客户定制花样，花样号 201 之后[双轴为 241]不再可选，只能选择系统自带花样。
- 3、同步传感器信号不正常时，运行时马达不会动，但系统不报警。系统可以正常回零。

## 3 Hardware Instruction

### 3.1 External Interface of Ctrl-Box



### 3.2 Panel-Baord Interface



Panel-Baord

| Socket /IC                 | Description                  |
|----------------------------|------------------------------|
| A (J4 White 7-Pins socket) | To control box Signal socket |
| B (U2 pattern chip)        | Custom pattern chip          |
| C (Red 3-Pins socket)      | X-motor zero sensor socket   |
| D (White 3-Pins socket)    | X-Sync sensor socket         |
| E (Yellow 3-Pins socket)   | Y-Sync sensor socket         |
| F (Red 3-Pins socket)      | Y-motor zero sensor socket   |

**Notice:** When Custom pattern chip removed, the system can still work correctly! But only keep own patterns, customized patterns will no longer exist, pattern width is default 8.0 mm at the same time, can be changed only when setting, cannot be saved after the power off.

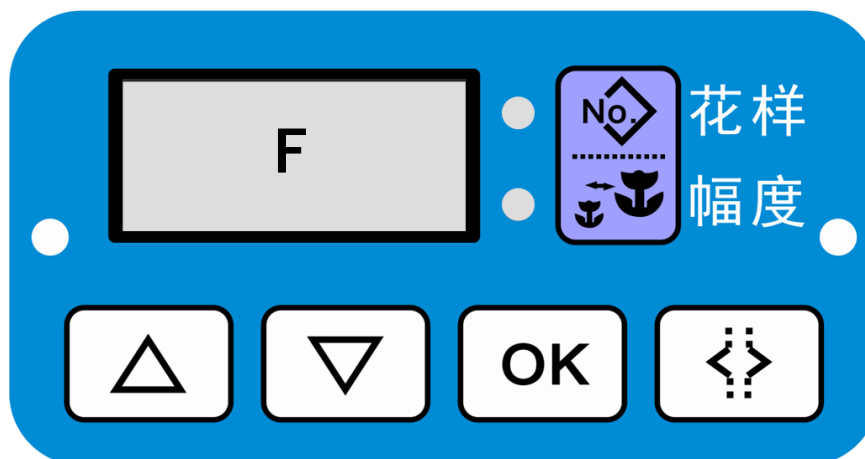
### 3.3 Power specification

Supply voltage: Single-phase, AC 100~240 V

Operating Current: Average Current is less than 1.5 A, Peak Current is less than 2 A.

## 4 Interface and instructions

### 4.1 Interface specification



Panel interface

| key/window                                                                        | Description                                                             |
|-----------------------------------------------------------------------------------|-------------------------------------------------------------------------|
| F (Display window)                                                                | By three red LED display                                                |
|  | Pattern Width、 Pattern No. and Stitch Length selection Key              |
|  | Add Key                                                                 |
|  | Dec Key                                                                 |
| OK                                                                                | Confirm Key                                                             |
|  | Pattern image mirror Key                                                |
|  | Indicator light, indicates Pattern Width 、 Pattern No. or Stitch Length |

## 4.2 Operating instructions

- 1、 System allows clients to 4 items change operation: Pattern No. 、 Pattern width、 Stitch Length and Pattern Mirror, The Pattern No.、 Pattern width、 Stitch Length by selection Key selected first, and the corresponding indicator light display.
- 2、 For OK key, the user to change pattern No, pattern width, Stitch Length and pattern mirror, all need to press the it to confirm.
- 3、 Each press OK Key, the system will go to Zero point. The system will automatically go to zero one time after power on.
- 4、 When Pattern Mirror Key pressed, the width of the pattern will show a "r", again according to the "r" disappear. Pattern Mirror operation is real-time, is not saved after the power off.
- 5、 Pattern width range is from 0.0 to 9.0 mm, the width of each 0.1 mm can be changed.
- 6、 Stitch length range is from 0.0 to 3.0 mm, the length of each 0.1 mm can be changed.
- 7、 System Pattern No. from 1 to 240 variable (System specifications different, pattern number. is different). Custom Pattern No. from 201 or 241 variable (System specifications different , number of custom Pattern allows to customize different)

## 4.3 Sensor checking

Press OK key when power on, the system of "PA1" into the interface (Through the  $\triangle$  or  $\nabla$  key to choose PA1, PA2 and PA3) And then press OK to show the "L" or "H", covering or opening sensor repeatedly, to observe such as "L" and "H" reverse changed, sensor is good, instead of failure. In the condition of "PA1" , "PA2"or "PA3"long press OK key to exit. PA1 corresponding X motor sensor , PA2 corresponding synchronous sensor, and PA3 corresponding Y motor sensor.

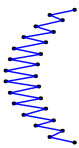
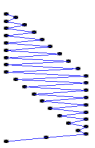
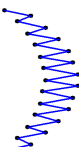
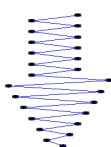
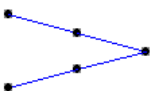
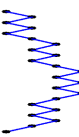
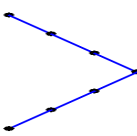
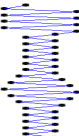
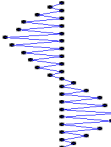
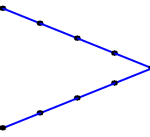
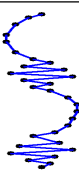
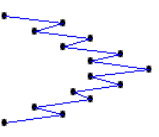
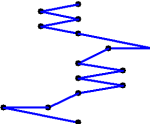
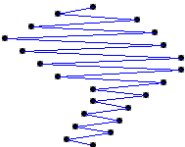
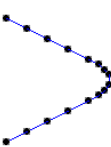
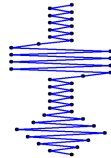
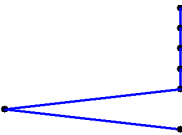
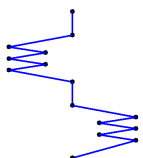
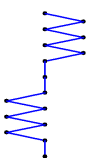
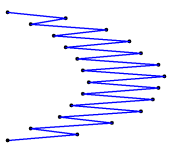
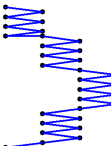
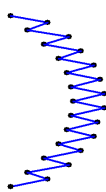
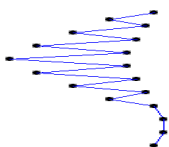
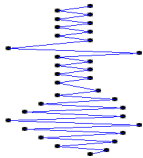
## 4.4 Alarm

- 1、When the X-axis zero sensor failure, motor fault, connection failure, or mechanical jammed, system will alarm "E-2" during power on or pressing OK key. For Y-axis, system will alarm "E-3".
- 2、When a customer pattern chip does not exist, system does not alarm during power on, system can work correctly without custom patterns.
- 3、When synchronous sensor signal is abnormal, the stepping motors will not move, but the system doesn't alarm. Under above condition, system can go to zero correctly.

## 附录 1：单轴系统花样(基本版)

## Appendix 1: Single-axis Sytem Pattern (Basic Ver.)

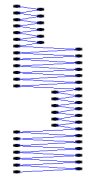
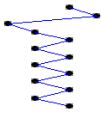
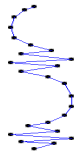
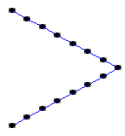
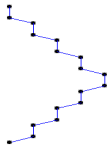
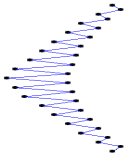
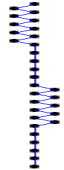
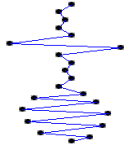
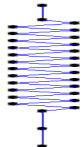
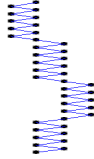
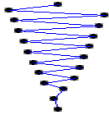
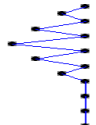
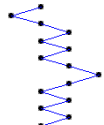
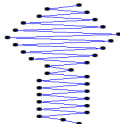
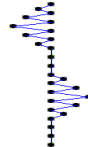
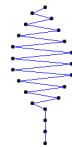
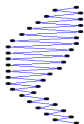
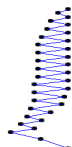
单轴系统花样 (1)  
Single-axis System Pattern (1)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                                |
|-------------------|-------------------------------------------------------------------------------------|-------------------|-------------------------------------------------------------------------------------|-------------------|---------------------------------------------------------------------------------------|
| 1                 |    | 11                |    | 21                |    |
| 2                 |    | 12                |    | 22                |    |
| 3                 |    | 13                |    | 23                |    |
| 4                 |    | 14                |    | 24                |    |
| 5                 |   | 15                |   | 25                |   |
| 6                 |  | 16                |  | 26                |  |
| 7                 |  | 17                |  | 27                |  |
| 8                 |  | 18                |  | 28                |  |
| 9                 |  | 19                |  | 29                |  |
| 10                |  | 20                |  | 30                |  |

单轴系统花样 (2)  
Single-axis System Pattern (2)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure | 花样号<br>Pattern No | 花样图案<br>Pattern Figure | 花样号<br>Pattern No | 花样图案<br>Pattern Figure |
|-------------------|------------------------|-------------------|------------------------|-------------------|------------------------|
| 31                |                        | 41                |                        | 51                |                        |
| 32                |                        | 42                |                        | 52                |                        |
| 33                |                        | 43                |                        | 53                |                        |
| 34                |                        | 44                |                        | 54                |                        |
| 35                |                        | 45                |                        | 55                |                        |
| 36                |                        | 46                |                        | 56                |                        |
| 37                |                        | 47                |                        | 57                |                        |
| 38                |                        | 48                |                        | 58                |                        |
| 39                |                        | 49                |                        | 59                |                        |
| 40                |                        | 50                |                        | 60                |                        |

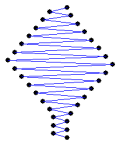
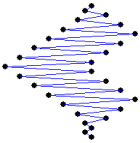
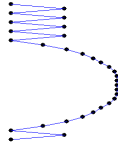
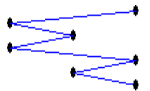
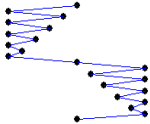
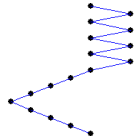
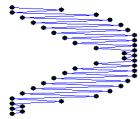
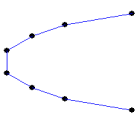
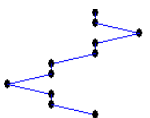
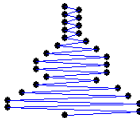
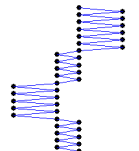
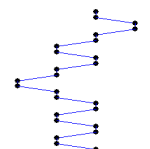
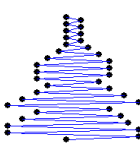
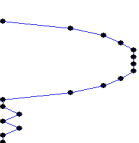
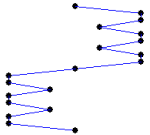
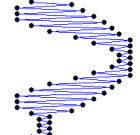
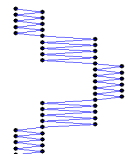
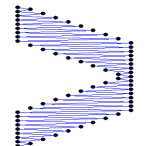
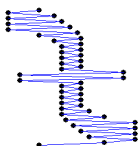
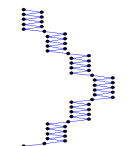
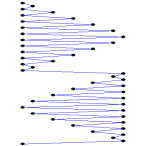
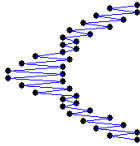
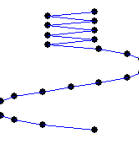
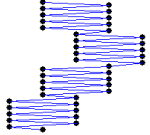
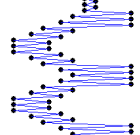
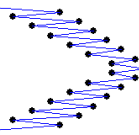
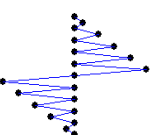
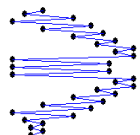
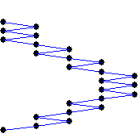
单轴系统花样 (3)  
Single-axis System Pattern (3)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                                |
|-------------------|-------------------------------------------------------------------------------------|-------------------|-------------------------------------------------------------------------------------|-------------------|---------------------------------------------------------------------------------------|
| 61                |    | 71                |    | 81                |    |
| 62                |    | 72                |    | 82                |    |
| 63                |    | 73                |    | 83                |    |
| 64                |   | 74                |   | 84                |   |
| 65                |  | 75                |  | 85                |  |
| 66                |  | 76                |  | 86                |  |
| 67                |  | 77                |  | 87                |  |
| 68                |  | 78                |  | 88                |  |
| 69                |  | 79                |  | 89                |  |
| 70                |  | 80                |  | 90                |  |

单轴系统花样 (4)  
Single-axis System Pattern (4)

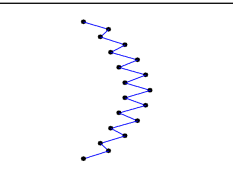
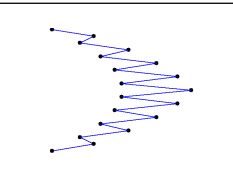
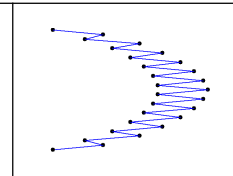
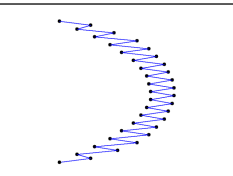
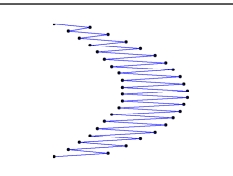
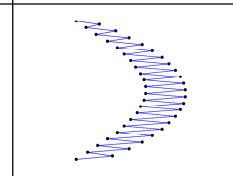
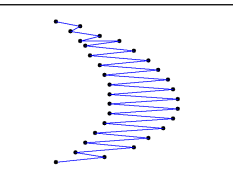
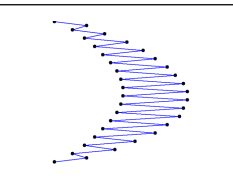
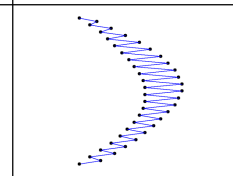
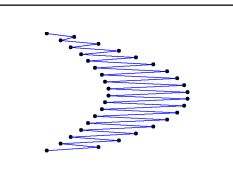
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|-------------------|------------------------|-------------------|------------------------|-------------------|------------------------|
| 91                |                        | 101               |                        | 111               |                        |
| 92                |                        | 102               |                        | 112               |                        |
| 93                |                        | 103               |                        | 113               |                        |
| 94                |                        | 104               |                        | 114               |                        |
| 95                |                        | 105               |                        | 115               |                        |
| 96                |                        | 106               |                        | 116               |                        |
| 97                |                        | 107               |                        | 117               |                        |
| 98                |                        | 108               |                        | 118               |                        |
| 99                |                        | 109               |                        | 119               |                        |
| 100               |                        | 110               |                        | 120               |                        |

单轴系统花样 (5)  
Single-axis System Pattern (5)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                                |
|-------------------|-------------------------------------------------------------------------------------|-------------------|-------------------------------------------------------------------------------------|-------------------|---------------------------------------------------------------------------------------|
| 121               |    | 131               |    | 141               |    |
| 122               |    | 132               |    | 142               |    |
| 123               |    | 133               |    | 143               |    |
| 124               |    | 134               |    | 144               |    |
| 125               |   | 135               |   | 145               |   |
| 126               |  | 136               |  | 146               |  |
| 127               |  | 137               |  | 147               |  |
| 128               |  | 138               |  | 148               |  |
| 129               |  | 139               |  | 149               |  |
| 130               |  | 140               |  | 150               |  |

单轴系统花样 (6)  
Single-axis System Pattern (6)

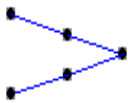
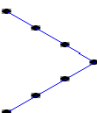
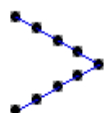
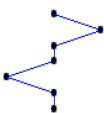
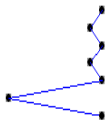
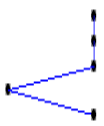
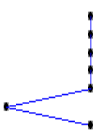
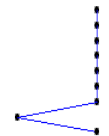
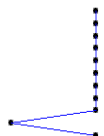
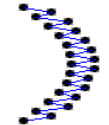
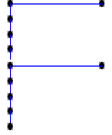
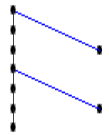
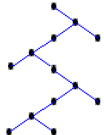
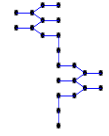
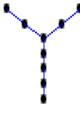
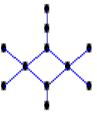
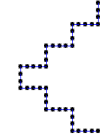
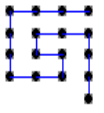
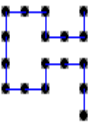
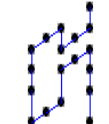
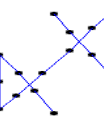
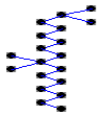
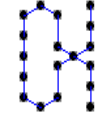
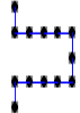
| 花样号<br>Pattern No | 花样图案<br>Pattern Figure | 花样号<br>Pattern No | 花样图案<br>Pattern Figure | 花样号<br>Pattern No | 花样图案<br>Pattern Figure |
|-------------------|------------------------|-------------------|------------------------|-------------------|------------------------|
| 151               |                        | 161               |                        | 171               |                        |
| 152               |                        | 162               |                        | 172               |                        |
| 153               |                        | 163               |                        | 173               |                        |
| 154               |                        | 164               |                        | 174               |                        |
| 155               |                        | 165               |                        | 175               |                        |
| 156               |                        | 166               |                        | 176               |                        |
| 157               |                        | 167               |                        | 177               |                        |
| 158               |                        | 168               |                        | 178               |                        |
| 159               |                        | 169               |                        | 179               |                        |
| 160               |                        | 170               |                        | 180               |                        |

|     |                                                                                   |     |                                                                                   |     |                                                                                     |
|-----|-----------------------------------------------------------------------------------|-----|-----------------------------------------------------------------------------------|-----|-------------------------------------------------------------------------------------|
| 181 |  | 182 |  | 183 |  |
| 184 |  | 185 |  | 186 |  |
| 187 |  | 188 |  | 189 |  |
| 190 |  |     |                                                                                   |     |                                                                                     |

附录 2：双轴系统花样(基本版)

Appendix 2: Double-axis Sytem Pattern (Basic Ver.)

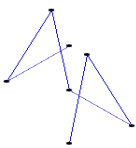
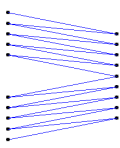
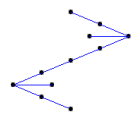
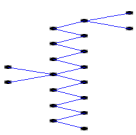
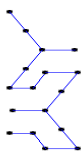
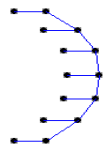
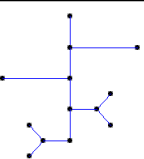
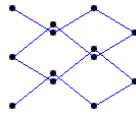
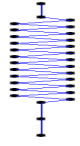
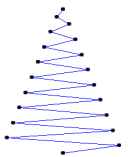
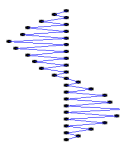
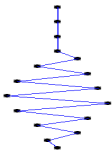
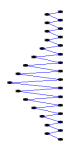
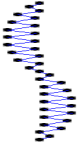
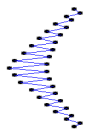
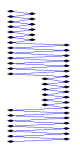
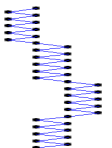
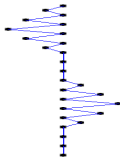
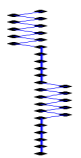
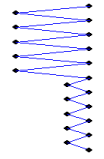
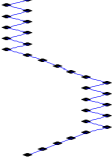
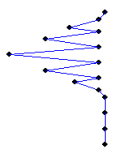
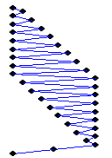
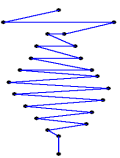
双轴系统花样 (1)  
Double-axis System Pattern (1)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                                |
|-------------------|-------------------------------------------------------------------------------------|-------------------|-------------------------------------------------------------------------------------|-------------------|---------------------------------------------------------------------------------------|
| 1                 |    | 2                 |    | 3                 |    |
| 4                 |    | 5                 |    | 6                 |    |
| 7                 |    | 8                 |    | 9                 |    |
| 10                |    | 11                |    | 12                |    |
| 13                |  | 14                |  | 15                |  |
| 16                |  | 17                |  | 18                |  |
| 19                |  | 20                |  | 21                |  |
| 22                |  | 23                |  | 24                |  |
| 25                |  | 26                |  | 27                |  |
| 28                |  | 29                |  | 30                |  |

双轴系统花样 (2)  
Double-axis System Pattern (2)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure | 花样号<br>Pattern No | 花样图案<br>Pattern Figure | 花样号<br>Pattern No | 花样图案<br>Pattern Figure |
|-------------------|------------------------|-------------------|------------------------|-------------------|------------------------|
| 31                |                        | 32                |                        | 33                |                        |
| 34                |                        | 35                |                        | 36                |                        |
| 37                |                        | 38                |                        | 39                |                        |
| 40                |                        | 41                |                        | 42                |                        |
| 43                |                        | 44                |                        | 45                |                        |
| 46                |                        | 47                |                        | 48                |                        |
| 49                |                        | 50                |                        | 51                |                        |
| 52                |                        | 53                |                        | 54                |                        |
| 55                |                        | 56                |                        | 57                |                        |
| 58                |                        | 59                |                        | 60                |                        |

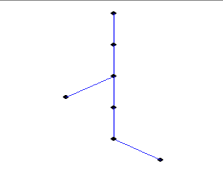
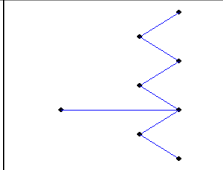
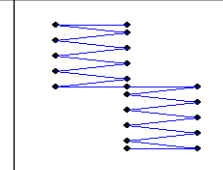
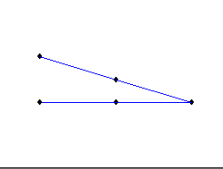
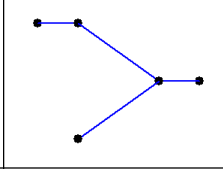
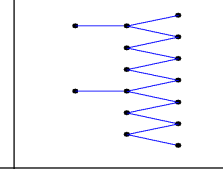
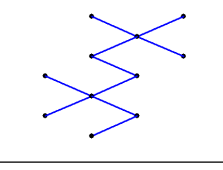
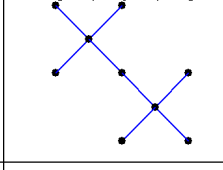
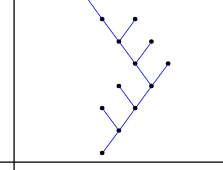
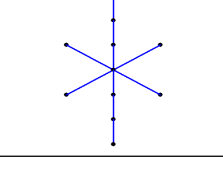
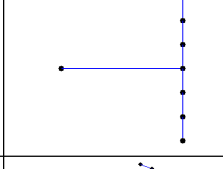
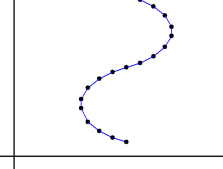
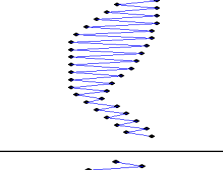
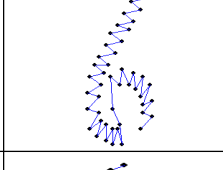
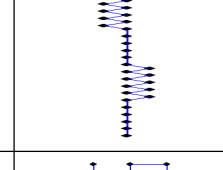
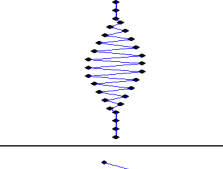
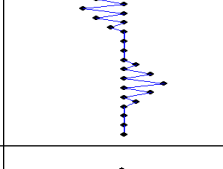
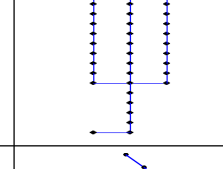
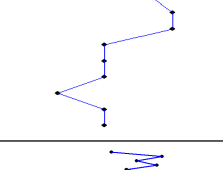
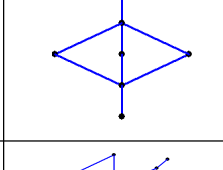
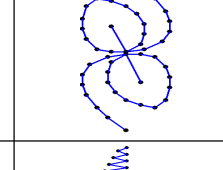
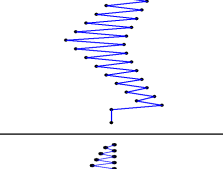
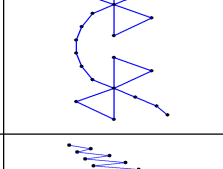
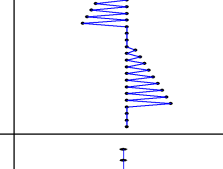
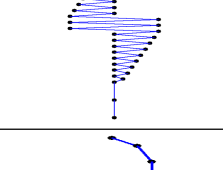
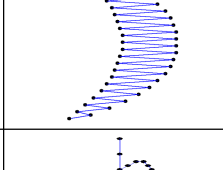
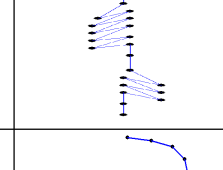
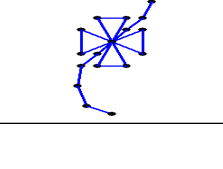
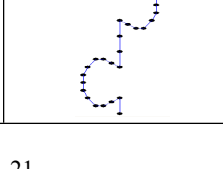
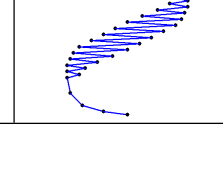
双轴系统花样 (3)  
Double-axis System Pattern (3)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                                |
|-------------------|-------------------------------------------------------------------------------------|-------------------|-------------------------------------------------------------------------------------|-------------------|---------------------------------------------------------------------------------------|
| 61                |    | 62                |    | 63                |    |
| 64                |    | 65                |    | 66                |    |
| 67                |    | 68                |    | 69                |    |
| 70                |    | 71                |    | 72                |    |
| 73                |  | 74                |  | 75                |  |
| 76                |  | 77                |  | 78                |  |
| 79                |  | 80                |  | 81                |  |
| 82                |  | 83                |  | 84                |  |
| 85                |  | 86                |  | 87                |  |
| 88                |  | 89                |  | 90                |  |

双轴系统花样 (4)  
Double-axis System Pattern (4)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure | 花样号<br>Pattern No | 花样图案<br>Pattern Figure | 花样号<br>Pattern No | 花样图案<br>Pattern Figure |
|-------------------|------------------------|-------------------|------------------------|-------------------|------------------------|
| 91                |                        | 92                |                        | 93                |                        |
| 94                |                        | 95                |                        | 96                |                        |
| 97                |                        | 98                |                        | 99                |                        |
| 100               |                        | 101               |                        | 102               |                        |
| 103               |                        | 104               |                        | 105               |                        |
| 106               |                        | 107               |                        | 108               |                        |
| 109               |                        | 110               |                        | 111               |                        |
| 112               |                        | 113               |                        | 114               |                        |
| 115               |                        | 116               |                        | 117               |                        |
| 118               |                        | 119               |                        | 120               |                        |

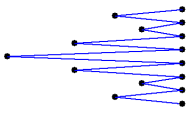
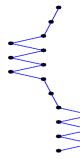
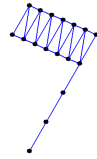
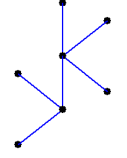
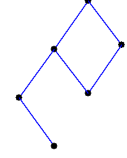
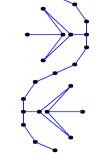
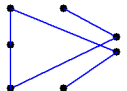
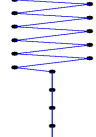
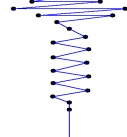
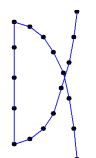
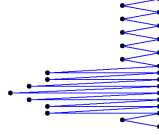
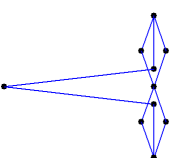
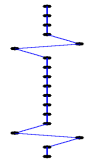
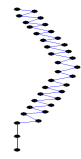
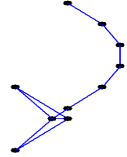
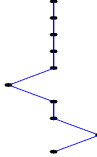
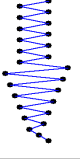
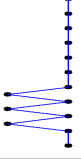
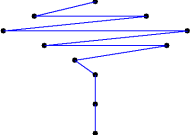
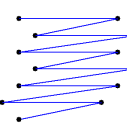
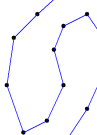
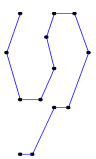
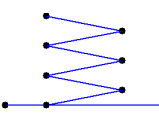
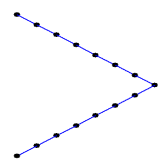
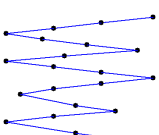
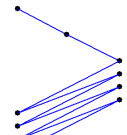
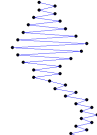
双轴系统花样 (5)  
Double-axis System Pattern (5)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                                |
|-------------------|-------------------------------------------------------------------------------------|-------------------|-------------------------------------------------------------------------------------|-------------------|---------------------------------------------------------------------------------------|
| 121               |    | 122               |    | 123               |    |
| 124               |    | 125               |    | 126               |    |
| 127               |    | 128               |    | 129               |    |
| 130               |   | 131               |   | 132               |   |
| 133               |  | 134               |  | 135               |  |
| 136               |  | 137               |  | 138               |  |
| 139               |  | 140               |  | 141               |  |
| 142               |  | 143               |  | 144               |  |
| 145               |  | 146               |  | 147               |  |
| 148               |  | 149               |  | 150               |  |

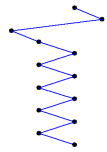
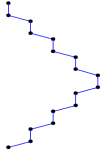
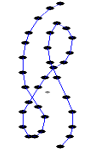
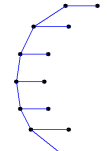
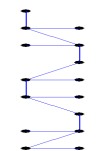
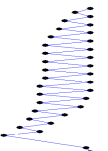
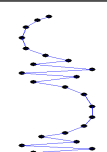
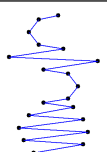
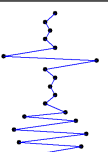
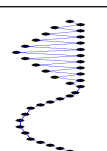
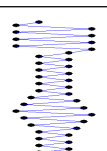
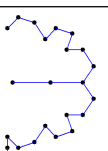
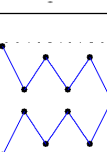
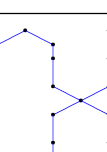
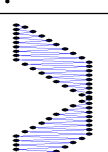
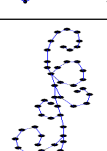
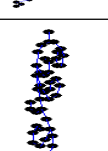
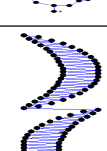
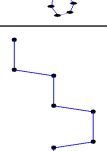
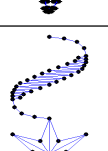
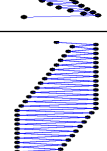
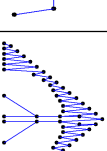
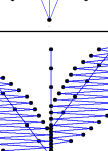
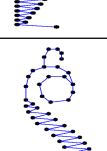
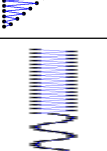
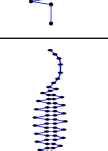
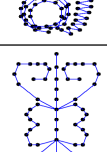
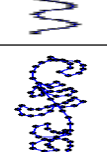
双轴系统花样 (6)  
Double-axis System Pattern (6)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure | 花样号<br>Pattern No | 花样图案<br>Pattern Figure | 花样号<br>Pattern No | 花样图案<br>Pattern Figure |
|-------------------|------------------------|-------------------|------------------------|-------------------|------------------------|
| 151               |                        | 152               |                        | 153               |                        |
| 154               |                        | 155               |                        | 156               |                        |
| 157               |                        | 158               |                        | 159               |                        |
| 160               |                        | 161               |                        | 162               |                        |
| 163               |                        | 164               |                        | 165               |                        |
| 166               |                        | 167               |                        | 168               |                        |
| 169               |                        | 170               |                        | 171               |                        |
| 172               |                        | 173               |                        | 174               |                        |
| 175               |                        | 176               |                        | 177               |                        |
| 178               |                        | 179               |                        | 180               |                        |

双轴系统花样 (7)  
Double-axis System Pattern (7)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                                |
|-------------------|-------------------------------------------------------------------------------------|-------------------|-------------------------------------------------------------------------------------|-------------------|---------------------------------------------------------------------------------------|
| 181               |    | 182               |    | 183               |    |
| 184               |    | 185               |    | 186               |    |
| 187               |    | 188               |    | 189               |    |
| 190               |    | 191               |    | 192               |    |
| 193               |  | 194               |  | 195               |  |
| 196               |  | 197               |  | 198               |  |
| 199               |  | 200               |  | 201               |  |
| 202               |  | 203               |  | 204               |  |
| 205               |  | 206               |  | 207               |  |
| 208               |  | 209               |  | 210               |  |

双轴系统花样 (8)  
Double-axis System Pattern (8)

| 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                              | 花样号<br>Pattern No | 花样图案<br>Pattern Figure                                                                |
|-------------------|-------------------------------------------------------------------------------------|-------------------|-------------------------------------------------------------------------------------|-------------------|---------------------------------------------------------------------------------------|
| 211               |    | 212               |    | 213               |    |
| 214               |    | 215               |    | 216               |    |
| 217               |    | 218               |    | 219               |    |
| 220               |    | 221               |    | 222               |    |
| 223               |   | 224               |   | 225               |   |
| 226               |  | 227               |  | 228               |  |
| 229               |  | 230               |  | 231               |  |
| 232               |  | 233               |  | 234               |  |
| 235               |  | 236               |  | 237               |  |
| 238               |  | 239               |  | 240               |  |

## 附录 3：常见问题及故障的检测

### 1、按键没有复位的现象和解决方法：

- (1) . 开启电源开关，在没有按任何按键的情况下，仍然显示 PA-1，此时 OK 键触片没有正常弹起复位，应在此处面贴撕开个小口，取出里面的金属触片擦拭干净后放回 OK 键的正下方，粘回面贴。
- (2) . 开启电源开关，开机花样号或摆幅自动向上加或向下减，对应的加键或减键触片处于没有复位状态，处理方法和上条 OK 键一样排除故障。
- (3) . 蓝色面板显示正常，按任何按键没有反应，蓝色面板故障。

### 2、摆针回零失败报 E-2 的现象和解决方法：

- (1) . 开启电源开关，针杆能左右来回到边摆几次然后面板显示 E-2。

A、关掉花样电控电源开关，拔掉红色电机插头，按住 OK 键不松，然后开启电源，待显示 PA1 后，按 OK 键进入 H~L 界面，用手左右掰动摆杆，观察显示界面是否有 H~L 字母转换，如果有变换，请将 PA3 的参数如果是 1 就改成 0，如果是 0 就改成 1，如果没有变换，打开机头盖，检查黑色感应器前面的金属片是否螺丝松动，金属片在感应器前面时黑色感应器需要亮起。

B、如果用手左右掰针杆金属片离开黑色感应器圆弧面时，感应器仍然亮红色灯，感应器故障，需更换。

C、如果用手左右掰针杆金属片离开或接近黑色感应器圆弧面时，感应器都不亮红色灯，检查蓝色面板后面的红色插头端子是否接触良好，如果接触良好，请将白色 3 针插头拔出，将黑色感应器红色插头插入白色 3 针座子中，关掉花样电控电源开关，拔掉红色电机插头，按住 OK 键不松，然后开启电源，待显示 PA1 后，加到 PA2，按 OK 键进入 H~L 界面，用手左右推动针杆，观察显示界面是否有 H~L 字母转换，如果有变换，蓝色面板坏，如果没有变换，黑色传感器坏，需更换。

- (2) . 开启花样电控电源开关，针杆不能左右来回到边摆，处于静止不动的

**情况，然后面板显示 E-2:**

A、如果用手掰动针杆能锁住，检查电控箱背面红色电机插头是否插上，端子是否接触良好，8 孔白色插头数据线两头是否接触良好，电控箱内部白色 3 芯数据线是否插牢，以及机械摆针在关电的时候是否异常卡住。

B、如果用手掰动针杆不能锁住，检查摆针马达轴与连杆之间的螺丝是否松动，检查电控箱背面红色电机插头是否插上，端子是否接触良好，电控箱内部驱动排线是否插好，电源板上的两个红色显示灯是否常亮，有闪烁或不亮的情况电控箱出现故障，需要更换电控。

**3、开启花样电控电源开关，蓝色面板能正常显示花样号，但是运行时不摆花样走直线:**

A、检查蓝色面板后面的 3 芯白色和黄色插头是否接触良好，打开机头盖，观察绿色电路板上的 2 个绿灯在主轴旋转时是否交替亮灭，如果没有交替亮灭，请检查绿色电路板正下方的白色磁环中心位置，是否对准绿色电路板的 3 脚黑色感应器，没有对准请调整磁环或电路板位置对准。

B、检查绿色电路板的黑色同步传感器好坏，磁环与电路板位置处于对准状态，关掉花样电控电源开关，拔掉红色电机插头，按住 OK 键不松，然后开启电源，待显示 PA1 后，加到 PA2, 按 OK 键进入 H~L 界面，用手旋转主轴，观察中间绿灯亮灭时，显示界面是否有 H~L 字母转换，如果有变换正常，再加到 PA4，用手旋转主轴，观察内侧绿灯亮灭时，显示界面是否有 H~L 字母转换，如果有变换正常，没有则绿色同步电路板有故障或蓝色面板有故障。

**4、送步回零失败报 E-3 的现象和解决方法（双轴）:**

**(1) . 开启花样电控电源开关，摆针回完零，然后面板显示 E-3，送步电机开电时能锁住。**

A、关掉花样电控电源开关，拔掉红色电机插头，按住 OK 键不松，然后开启电源，待显示 PA4 后，按 OK 键进入 H~L 界面，用手来回掰动送步电机臂，观察显示界面是否有 H~L 字母转换，如果有变换，检查黑色感

应器前面的金属片是否螺丝松动，金属片在感应器前面时黑色感应器需要亮起。

B、如果用手掰动送步电机臂金属片离开黑色感应器圆弧面时，感应器仍然亮红色灯，感应器故障，需更换。

C、如果用手掰动送步电机臂金属片离开或接近黑色感应器圆弧面时，感应器都不亮红色灯，检查蓝色面板后面的黑色插头端子是否接触良好，如果接触良好，请将红色 3 针插头拔出，将黑色感应器红色黑头插入红色 3 针座子中，关掉花样电源开关，拔掉黑色电机插头，按住 OK 键不松，然后开启电源，待显示 PA1 后，按 OK 键进入 H~L 界面，用手用手掰动送步电机臂，观察显示界面是否有 H~L 字母转换，如果有变换，蓝色面板坏，如果没有变换，黑色送步回零传感器坏，需更换。

**(2) . 开启电源开关，摆针回完零，后面板显示 E-3，送步电机开电时不能锁住。**

A、检查方法和摆针电机锁不住的判断过程类似。

## 附录 4: XinJunYe 电控系统产品分类与选型

表1 曲折缝/266/马克车/帮面 电控系统产品

| 序号 | 系统产品型号       | 适合机型                |
|----|--------------|---------------------|
| 1  | XJY-8508A    | 2290A-SR/SS 型曲折缝    |
| 2  | XJY-8508D    | 2284/457 改进型曲折缝     |
| 3  | XJY-20ULCD   | 外置手编花 20U曲折缝        |
| 4  | SSC-8508B    | 856D/2070 型曲折缝      |
| 5  | XJY-20UE     | 内置嵌入式 20U曲折缝        |
| 6  | XJY-1530F    | 2530/1530 型曲折缝      |
| 7  | XJY-1530S/SL | 1530 曲折缝经济型(替代常见花盘) |
| 8  | XJY-8200G    | 鞋帮/帮面 曲折缝           |
| 9  | XJY-2685D    | 皮革/鞋机(266、马克车、DY车等) |
| 10 | XJY-8488B    | 牛仔/服装类(双针旋转同步)      |

表2 套结机/钉扣机/渔网绳/渔网浮/冲帽眼 电控系统产品

| 序号 | 系统产品型号        | 适合机型                       |
|----|---------------|----------------------------|
| 1  | SSC-9500A     | 1900A/1903A/1906A 型套结机/钉扣机 |
| 2  | XJY-9508B     | 430D/438D 型套结机/钉扣机         |
| 3  | XJY-9500B1/B3 | 430D型渔网机/渔网结机              |
| 4  | SSC-9500B2    | 430D型气动压脚                  |
| 5  | SSC-9500C     | 430FS/438FS 型套结机/钉扣机       |
| 6  | XJY-9500B4    | 437D/G直驱电脑平缝椅垫机            |
| 7  | XJY-9500B5    | 自动帽眼冲孔打结机                  |
| 8  | XJY-9500B6    | 439D自动子母扣钉扣机               |
| 9  | XJY-9550A     | 渔网浮标机机                     |
| 10 | SSC-9600A     | 1900A/1903A 兼容重机型套结机/钉扣机   |
| 11 | SSC-9800      | 2516/3020/5030电子花样机        |
| 12 | XJY-8300A/B/C | 特厚料电子花样机、帆绳机               |

**表3 珠边机/暗缝/小烫/上袖/卷带机/口罩 电控系统产品**

| 序号 | 系统产品型号        | 适合机型                |
|----|---------------|---------------------|
| 1  | XJY-7500A/B   | 781/785 珠边机         |
| 2  | XJY-7800A/B   | 电子暗缝/双面呢系统          |
| 3  | XJY-7600A/B/C | 小烫机控制系统             |
| 4  | XJY-7700A     | 揉边、拉毛控制系统           |
| 5  | XJY-7900A     | 热风机、防护服封胶系统         |
| 6  | XJY-6680A/B   | 自动卷带机系统             |
| 7  | XJY-7650A     | 上袖机控制系统             |
| 8  | XJY-6880A/B   | 自动超声波切带机系统          |
| 9  | XJY-5000A/B/C | 缝制伴侣单元（断线、底线、布料等检测） |
| 10 | XJY-8780A/B   | 口罩自动封口系统            |

**表4 拖布轮/运模/打折机/省缝/袋贴/驳头机/袋口 电控系统产品**

| 序号 | 系统产品型号        | 适合机型            |
|----|---------------|-----------------|
| 1  | XJY-8850A/B/C | 通用电子拖布轮         |
| 2  | XJY-8870A/B   | 辘脚、埋夹大动力高速电子拖布轮 |
| 3  | XJY-9010A/B   | 自动省缝系统          |
| 4  | XJY-9020A     | 自动驳头机系统         |
| 5  | XJY-9000A/B   | 自动贴袋机系统         |
| 6  | XJY-8890A/B   | 运模机、小模板机        |
| 7  | XJY-8680A/B   | 气动/可编花打折机(窗帘)系统 |
| 8  | XJY-9040A     | （裤腰）自动合缝系统      |
| 9  | XJY-9030A/B   | 单双向包缝/包边自动控制系统  |
| 10 | XJY-9050A     | 袋口自动缝制控制系统      |
| 11 | XJY-9060A/B   | 全自动拷边机          |
| 12 | XJY-9070A     | 全自动下摆机系统        |
| 13 | XJY-9075A     | 全自动辘角机系统        |

**表5 自动化改造平台/定制平台 电控系统产品**

| 序号 | 系统产品型号      | 适合机型                   |
|----|-------------|------------------------|
| 1  | SAI-2025A/B | 自动化改造控制平台，量身订制系统！      |
| 2  | SAI-2540A   | 与重机/兄弟/贺欣/琦星/鲍麦对接的辅助系统 |

技术支持 86-755-27513737

