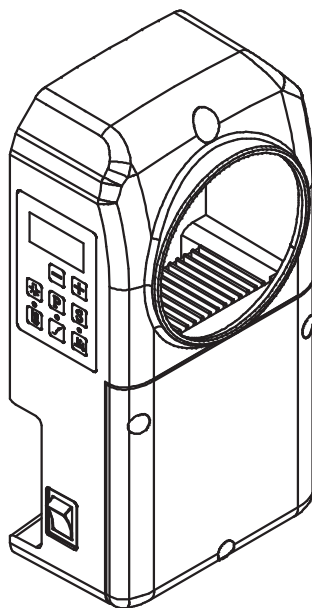
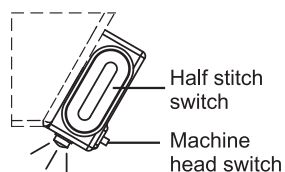
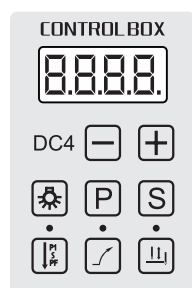


DC4 INTEGRATED MACHINE CONTROL SYSTEM

OPERATION AND INSTALLATION MANUAL



I. Operation Introduction



Graph	Name	Description
	Display area	Parameters and operating status display
	Left button	Parameter setting and needle position selection
	Right button	Parameter exit and multi-seam function
	Plus Button	Parameters plus key
	Minus key	Parameter minus key
	Brightness adjustment	1: Off 2: Brightness 1 3: brightness 2 4: brightness 3
	Multi-seam	1-15 section
	Soft start	Soft start 2 stitches
	Up and down needle position	Upper and lower needle position and no needle position

II. Display of the panel

- Without the stopping needle hall, it remember the up needle position when turn on the machine.
With the stopping needle hall, it can judge the needle position.
- Without the stopping needle hall, the needle free stop.
- Without the stopping needle hall, the memory of the needle position is down needle position, back press the pedal for needle-lift function.
The above needle position is adjusted by key, the light is on means it's up needle position.
Note: With the stopping needle hall, it can judge the needle position.
- Standby state, Press key for about 3 seconds, enter the parameters , at this time key is to add parameters, key is minus parameter, choose the parameter you need, then enter key and enter the parameter modify menu, press key or key to adjust the parameter value, then press key to confirm, then press key to exit parameter.

III. QUICK ADJUST THE PARAMETER.

- Speed adjust: standby status, press or enter the adjustment menu, after showing the speed value, press to speed up or press to reduce the speed.
- The running direction of the motor. press and same time turn on the machine, it appears adjust until it shows: , then press key to enter the parameter modify. 0 is forward running, 1 is reverse running.
- Light adjustment: directly press key, enter the function of light on and brightness adjustment and off.
- Free sewing function: key light is off means free sewing function.
- Multi-seam function: press key, it shows , the first "R" is pedal control speed and sections. The second "1" means section (totally 15 sections P1-PF), the section changed by key and key. The third and the fourth "15" is stitches (totally 199 stitches 01-J9), stitch changed by key and key. If change the section and stitches, the first "R" must change to "T" first. Then press key to appear . The first "A" means trigger auto function, press the pedal one time, it automatic make the stitches in this section.
- Soft start function: light on, means soft start function is on, the default number of stitch is 2 stitches.
- Restore the factory settings: Press and hold the key in the power-off state, at the same time turn on the power , then let go and wait it back to "Return" to factory setting or press key to exit quickly.

Note: After all the adjustment is completed, let go for about 3 seconds, the system will return automatically, at this time all adjustment is totally completed.

IV. Section font comparison table

Arabic Numbers	0	0	1	1	2	2	3	3	4	4	5	5	6	6	7	7	8	8	9	9
English alphabet	A	A	B	b	C	C	D	d	E	E	F	F	G	G	H	H	I	I	J	J
	K	k	L	L	M	m	N	n	O	o	P	P	Q	Q	R	r	S	s	T	T
	U	U	V	v	W	w	X	x	Y	Y	Z	Z								

V.Parameter Description

Serial number	Name	Range	Initial value	Content Numerical Description
[P.-01]	Lowest speed	300~900	300	Lowest sewing speed
[P.-02]	Running speed	300~4500	3500	Maximum speed setting when sewing
[P.-03]	Soft start speed	100~1500	300	Soft start speed setting
[P.-04]	Maximum speed limit	300~4500	4000	Maximum speed limit [p.-02] parameter range
[P.-05]	Alternate			
[P.-06]	Acceleration time	0~99	0	The larger the number,the slower the acceleration
[P.-07]	Deceleration time			The software is fixed and cannot be modified
[P.-08]	Number of stitch when soft start	1~9	2	Soft start stitch number setting
[P.-09]	Up needle position adjustment	1~*	9	Angle adjustment of up needle position
[P.-10]	Down needle position adjustment	1~*	1	Angle adjustment of down needle position
[P.-11]	Forward or Reverse running of motor	0~1	0	0: Forward 1: Reverse
[P.-12]	Pedal and step switch	0~1	1	0: No back press pedal and needle lift function 1: Back press pedal and needle lift
[P.-13]	Alternate			
[P.-14]	Trailer/Auto Run test function	0~1	0	0: Off; 1:Turn on autorun function When opened, press the S key directly to close.
[P.-15]	Auto Run speed	0~4500	3000	Auto Run speed setting
[P.-16]	Total Limited Time For Auto Run	0~720	200	The total running time of 0-720 hours auto run
[P.-17]	Auto-run Stop time	0~99	5	Auto-run interval of each run
[P.-18]	Auto Run time	0~99	5	Automatic operation free Seam working time
[P.-19]	Alternate			
[P.-20]	Motor type	1~4	2	1: Quadropole; 2: Six poles; 3 and 4: Octupole
[P.-21]	Pedal neutral voltage	0~400	230	Pedal voltage regulation, the higher the voltage value to adjust the greater
[P.-22]	Alternate			
[P.-23]	Version number	0~99	1	Software version number (not adjustable)

Vi. Error Solution

Error	Error Reason	Solution
Er03	Motor Drive tube Short Circuit	Re-power or replace the electric control box
Er04	Pedal signal problem	Need to check whether the line is connected or replace the pedal board
Er06	Overcurrent, motor current too large	Check whether the motor socket is well connected or overloaded
Er07	Heavy head or thread stuck	Check whether the motor socket is well connected or overloaded
Er09	Problem with the motor signal Hall signal.	

Notice:

1. Do not press the pedal when turn on the machine, otherwise will show Er04, just press the pedal in the middle position, then forward press the pedal will make running normally.
2. If the display Er09, please check whether the motor wire is plugged in, whether one of the motor wire has an exit phenomenon, if all is normal, then check the motor rotor (magnetic ring) installed position is correct, can be adjusted in a small range.
3. If the display of Er07, please check whether the machine head is jammed, or whether the motor copper wire is broken, if the machine head is light, you need to replace the motor.

DC4 Integrated Machine Simple installation diagram

