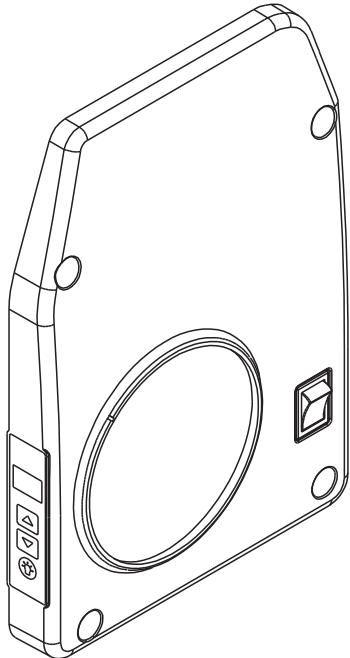


Overlock Machine Integrated Control System

Operation and Installation Manual



Motor Servo Control System Parameter Setting Instructions

I . Operation Introduction



Graph.	Name	Description
8.8	Display area	Parameters and operation status display
▲	Plus Button	Parameter and speed plus key
▼	Minus button	Parameter and speed minus key
✖	Brightness adjustment	1:Off 2:Brightness 2 3:Brightness 3 4:Brightness 4

II . Display of the panel

1. **P.0** 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.
2. **b.b** Without the stopping needle hall, needle sew freely.
3. **P.0** Without the stopping needle hall, the memory of the needle position is down needle position, back press the pedal for needle-lift function.
With the stopping needle hall, it can judge the needle position.
Note: The above needle position can be set through **P.3** key.
4. Standby state, Press **▼** for 3 seconds, enter parameter **P.1** , at this time **▲** key is to add parameters, **▼** is minus parameter, choose the parameter you need, then long time press **▼** key and enter the parameter modify menu, at this time press **▲** **▼** to adjust the parameter value, then long time press **▼** key to confirm, if no more operation, after 3 seconds it return to standby state.
5. How to enter advanced system parameter setting: when the machines is turned off status, press **▼** then turn on it, it will show **P.1** .

III . Quick adjust the parameter.

1. Speed adjust: standby status, press **▲** enter the adjustment menu, when it show **50** means speed is 5000rpm, then press **▲** or **▼** to reduce the speed.
2. The running direction of the motor. Press **▼** and same time turn on the machine, it appears **P.1** adjust it to **P. b** , Long time press **▼** to enter the parameter modify. 0 is forward running, 1 is reverse running.
3. Light adjustment : direct press **✖** , enter the function of light brightness adjustment.
4. Restore the factory settings: Press and hold the **▲** key in the power-off state, turn on the power it shows **P.1** .

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

IV . Parameter description

Serial Number	Name	Range	Initial value	Content numerical description
P. 1	Lowest speed	300~900	300	Lowest sewing speed
P. 2	Running speed	300~4500	4000	Maximum speed setting when sewing
P. 3	Stop position	0~2	2	0: free sewing 1: up stop position 2: low stop position
P. 4	Maximum speed limited	300~4500	4500	Maximum speed limited [P.-02] Parameter range.
P. 5	Alternate			
P. 6	Acceleration time	0~99	03	The large the number, the slower the acceleration

P.7	Deceleration time			The software is fixed and can not be modified
P.8	Alternate			
P.9	Up needle position	1~*	1	Angle adjustment of up needle position
P.8	Down needle position adjustment	1~*	12	Angle adjustment of down needle position
P.6	Forward or reverse running of motor	00~01	0	0: Forward 1:Reverse
P.5	Pedal and step switch	00~01	01	0: No back press pedal and needle lift function 1: Back press pedal and needle lift
P.4	Alternate			
P.3	Trailer/auto test function	00~01	00	0: Off 1: Turn on autorun function
P.2	Auto run speed	00~4500	3000	Auto run speed setting
P.6	Auto run time limited	00~99	10	Auto run 0~99 hours time
P.8	Auto run stop time	00~99	02	Auto-run interval of each run
P.1	Auto run time	0~99	05	Automatic operation free seam working time
P.2	Alternate			
P.5	Motor type	01~04	02	1: Quadrupole; 2: Six poles; 3and 4: Octupole
P.4	Pedal neutral voltage	00~40	23	Pedal voltage regulation, the value should be bigger if the voltage is higher
P.3	Alternate			
P.2	Version number	00~99	01	Software version number

V. Error Solution

ERROR	ERROR REASON	SOLUTION
E.3	Motor drive tube short circuit	Re-power or replace the electric control box
E.4	Pedal signal problem	Need to check whether the line is connected or overloaded
E.6	Overcurrent, motor current too large	Check whether the motor socket is well connected or overloaded
E.7	Heavy head or thread stuck	Check whether the motor socket is well connected or overloaded
E.9	Problem with the motor signal hall signal	Check whether the motor socket is well connected or change motor

Notice:

1. Do not press the pedal when turn on the machine, otherwise it show [E.4], just press the pedal in the middle position, then forward press the pedal is ok.
2. If it shows [E.9], 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 it shows [E.1], please check whether the machine head is jammed, or whether the motor copper wire is broken, if the machine head is light, please replace to motor.

VI. Section font comparison table

Arabic Numbers	٠	١	٢	٣	٤	٥	٦	٧	٨	٩
English alphabet	A	B	b	C	D	d	E	E	F	F
	K	t	L	L	M	n	n	O	P	P
	U	U	V	U	W	B	X	I	Q	R
										T

Integrated Machine Simple installation diagram

