



# 智能控制面板

## SMART CONTROL PANEL



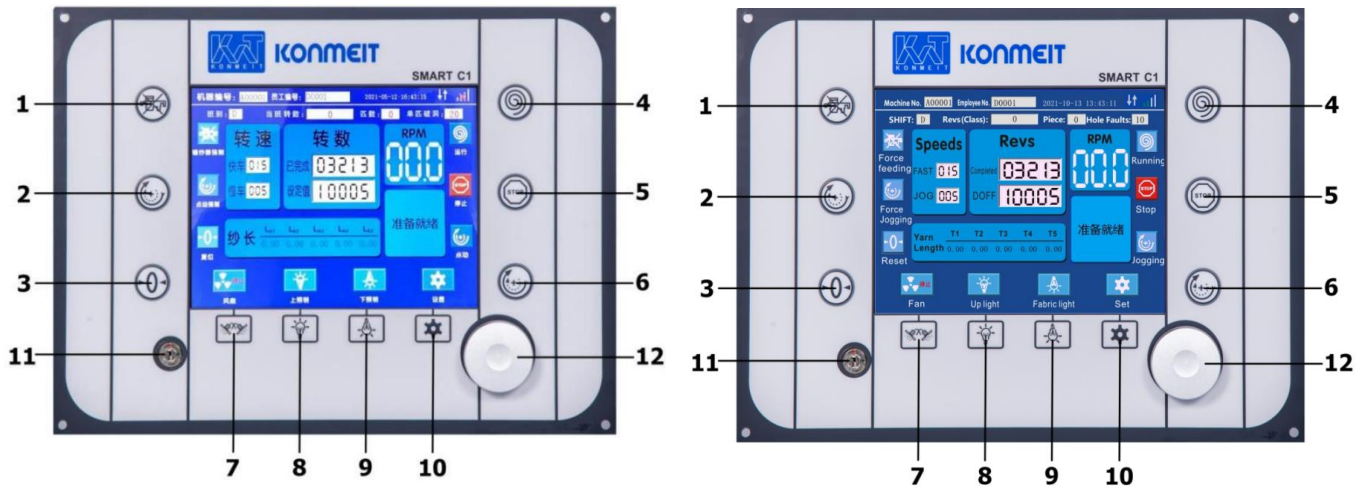
# 一 智能控制器面板/Smart Controller Panel


## 1.1 操作智能控制器面板/Operate Smart Controller Panel

智能控制器主要包括：


The smart controller mainly includes:

- 功能键：开启相关功能（例如，开启照明）
- Function Button: turn on the relevant function (for example, turn on the lighting)
- 菜单键：进入设置菜单
- Menu Button: enter the setting menu
- 旋转按钮：在界面上做选择和修改配置
- Rotary Button: select functions and modify configurations on the interface
- 钥匙开关：插入钥匙并开启钥匙开关方可进行参数设置
- Key Switch: Insert the key and turn on the key switch for parameter setting



1.  **输纱器强制键**：在1秒内连续按下两次，图标会变为红色，启用输纱器强制功能。此时存在断纱故障，按下点动键时，系统以点动频率运行，松开点动键时，系统停止。如果断纱故障解除，按下启动键时，系统以快车频率运行，再次按一次输纱器强制键，恢复为正常模式。

Force feeding : Press the button twice within 1s until the icon turn red to force enable the yarn feeder. If there is a yarn breakage fault at this moment, press<Jogging> button, the system will run at the jog frequency, and loose the button to start the system. If the yarn breakage fault is cleared, press <Start> button, the system will run at the fast frequency, and press <Force feeding> button again to return to normal mode.

2.  **点动（慢车）强制键**：在1秒内连续按下两次，图标变为红色，启用点动强制功能。再次按一次按键，恢复为正常模式。

Force Jogging : Press the button twice within 1second until the icon turns red to enable the jog force function. Press the button again to return to normal mode.

3.  **转数复位键**：当前<转数>栏<已完成>数值不为0时，且系统处于停止状态时，按下<转数复位>键后，<已完成>数值恢复为0。  

Reset : When the value of <Completed> in the current <rev.> column is not 0, and the system is stopped, press the <rev. reset> button, and the <Completed> value will return to 0.
4.  **快车启动运行键**：系统处于运转状态下时，屏上对应的图标变为绿色，按下此键系统按快车频率运行。  

Running : At runtime the corresponding icon on the screen will turn green. Press this button, the system will run at the fast mode frequency.
5.  **停止键/复位键**：在系统运行时，按下该键系统停止运行。当系统出现安全门、探针器、超速等自锁定故障时，在故障已经排除掉后，需要再次按下该键复位故障告警。  

Stop : When the system is running, press this button to stop the system. When the system has self-locking faults such as safety door, probe, overspeed, etc., you need to press this button again to reset the fault alarm after the fault has been eliminated.
6.  **点动（慢车）键**：按此键时，系统会以点动模式运转，松开此键时，系统则停止运行。机台正常运行时按点动键就以点动频率运行，放开后自动恢复到快车频率运行。  


Jogging : When this key is pressed, the system will run at the jog mode, and when this key is loosened, the system will stop running. When the machine is in normal operation, press the jog button to run at the jog frequency, and automatically return to the fast frequency after loosening the button.
7.  **风扇键**：按下按键后，图标切换显示三个模式，分别为停止、手动、自动。自动模式时，系统启动运转3圈后，风扇开始持续运转，系统停止时，风扇关闭。  


Fan : After pressing the key, the icon displays three modes, namely stop, manual and automatic. In automatic mode, the fan starts to run continuously after the system starts and runs for 3 circles, and when the system stops, the fan will be turned off.
8.  **上照明开关键**：用来控制上照明灯开启或关闭，屏上对应图标则点亮或灭掉。  

Up light : Control the upper lighting to be on or off, and the corresponding icon on the screen will be on or off.
9.  **下照明开关键**：用来控制下照明灯开启或关闭，屏上对应图标则点亮或灭掉。  


Fabric light: Control the lower lighting to be on or off, and the corresponding icon on the screen will be on or off.
10.  **设置键**：进入设置菜单。若当前不处于主界面，则直接返回主界面。若有未调整完毕的项目，则放弃调整，直接返回主显示页面。  


Set : Enter the setup menu. If it is not currently in the home interface, it will directly return to <Home>. If there are unadjusted items, no adjustment will be made and return to the home display page directly.

11.  **钥匙开关：** 锁住时，所有系统配置参数只能查看，无法修改。

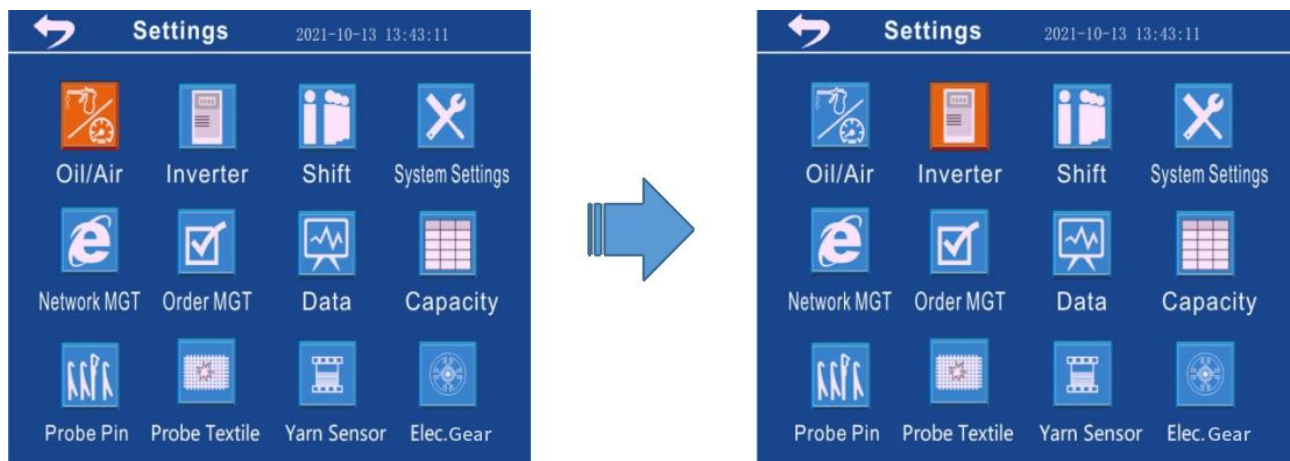
 对操控面板或更改参数时，一定要先用钥匙解锁才能操作。

Key switch: When locked, all system configuration parameters can only be viewed and cannot be modified.

 Please unlock with the key before operating the control panel or changing parameters

12.  **旋转按钮/确认按钮：** 可以在界面各个图像间或单元格间游走选择，转动旋钮到所需要图像或单元格，按压旋钮确认选择和设置。

Rotary button/confirm button: Select the icon of the interface, rotate the button to the corresponding icon, and press the button to confirm the selection and setting.







## 二 面板功能介绍/Panel Function Introduction

### 2.1 主界面（工作界面）/ Home Interface (Working Interface)

当 SMART C1 智能控制系统启动后，下面界面会显示在智能控制器的屏幕上。

When the SMART C1 smart control system starts up, the interface below will be displayed on the screen of the intelligent controller.



- ① **机器编号：**显示<系统设置>界面中的<机器编码>字段；  
**Machine number：** Display <machine code> in the <system setting> interface;
- ② **员工编号：**显示当前班别对应的工号。若使用刷卡功能后，则显示 10 位纯数字卡号；  
**Work number：** Display the work number corresponding to the current shift. If there is no shift currently, then display<00000>;
- ③ **系统时间：**根据当前系统设置值显示；  
**System time：** Display according to the current system setting value;
- ④ **通信：**与服务器通信时，显示图标，否则显示图标；  
**Communication：** When communicating with the server, display icon, otherwise display icon;
- ⑤ **信号强度：**根据 WIFI 网络的信号强度显示信号等级；  
**Signal strength：** Display signal level according to the signal strength of WIFI network;
- ⑥ **班别：**根据 <班别>界面中的班别时间段来显示，若当前时刻不属于 5 个班别时间区域，则显示空白；  
**Shift：** If the current time does not belong to the 5 shift time zones, it will display blank;
- ⑦ **当班累计转数：**显示当班累计运行的转数；  
**Accumulated revolutions during the shift：** display the accumulated revolutions during the shift;

- ⑧ **匹数**: 显示当班的生产量; <当班累计转数>和<匹数>记录当前班别已完成的转数及匹数, 切换至新班别后, 显示数值锁定5分钟。5分钟后开始实时显示新班别产量数据;
- Output: Display the output of the shift:** <The accumulated revolutions of the shift> and <Output> record the completed revolutions and output of the current shift. After switching to a new shift, the value displayed will be locked for 5 minutes. After 5minutes, the output of the new shift will be displayed in real time;
- ⑨ **单匹破洞**: 数值表示当前未完成布匹已经出现的破洞数。需要配合探布器设备来统计数量, 探布器报一次故障, 该计数值累加 1;
- Broken Hole:** the value indicates the number of holes that have appeared in the currently unfinished cloth. It is needed to work with the probe to count the number. When the probe reports a fault, the count accumulated will increase 1;
- ⑩ **快车**: 设置<快车频率>, 最大值限制为<转速>界面中的<最大频率>值, 最小值为0, 若当前系统正以快车频率运行, 则实时输出调整的频率;
- Fast Mode:** set<fast frequency>, the maximum value is limited to the <maximum frequency> value of <rev> in the interface. When the minimum value is 0, if the current system is running at the fast frequency, then the adjusted frequency will be output in real time;
- ⑪ **慢车**: 设置<慢车频率>, 最大频率限制为15Hz, 最小值为0, 若当前系统正以慢车频率运行, 则实时输出调整的频率;
- Slow Mode:** set<slow frequency>, the maximum frequency limit is15Hz, and minimum value is 0. If the current system is running at the slow frequency, then the adjusted frequency will be output in real time;
- ⑫ **RPM**: 显示当前圆机转速, 单位为转/分;
- RPM:** Display the current rotating speed of the circle machine. The unit is rev/min;
- ⑬ **已完成转数**: 设备运行后, 实时显示设备运转的转数, 当设备运转的转数达到设定的转数时, 设备停止运行, 屏幕显示 。仅在设备停机状态下, 可通过复位键  将“已完成转数”值清零;
- Rev. completed:** After the equipment is running, the revolutions of the equipment will be displayed in real time. When the number of revolutions of the equipment reaches the set number of revolutions, the equipment will stop running, and the screen will display . Only when the equipment is stopped, the “rev. completed” value can be reset by pressing the reset button .
- ⑭ **设定的转数**: 设备停止状态下进入设定模式, 5位数全部设定完毕后, 系统存储为默认复位值; 若在设定过程中, 按下启动键启动系统, 则退出设定模式, 未调整完的数据不保存;
- The number of set revolutions:** enter the setting mode when the equipment is stopped, after all the 5 digits are set, these 5 digits will be stored as the default reset value; during the setting process, if you press the start button to start the system, the setting mode will be exited, and the unadjusted data will not be saved;

- ⑮ **纱长:** 显示5个通道的测纱器纱长检测值。若开启测纱器报警功能,当相应通道测纱数值超出设定范围时,系统会报警停机,提示<测纱器>故障。停机后,异常的测纱数值仍会继续显示在屏幕上,正常通道的测纱值显示为0;


**Yarn length:** Display the yarn length detection value of the yarn gauge of the 5 channels. If the yarn detector alarm function is enabled, the system will alarm and stop when the measured yarn length of the corresponding channel exceeds the set range, prompting <yarn gauge>failure. After shutdown, abnormal yarn length value will constantly be displayed on the screen, and the yarn length values in other normal channels will be displayed as 0;

- ⑯ **故障告警显示:** 当有告警时,显示对应告警内容;


**Fault alarm display:** When there is an alarm, display the corresponding alarm content;

-  检测到多个故障时,则间隔0.5秒切换逐个显示故障内容;

When multiple faults are detected, display the fault content one by one every other 0.5s;


-  出现自锁定故障时,故障排除后,需要再次按下<停止>键复位故障;非自锁定故障一旦排除,则自动清除故障状态;


When self-locking fault occurs and after troubleshooting, it is needed to once again press<stop> button to reset fault; non-self-locking faults will be cleared automatically once the fault is removed;

-  自锁定故障列表: 伺服驱动、探针器、掉布、超速、伺服通信、存储器、频率组件、WiFi组件、编码器、驱动过载、订单完成、测纱器。


Self-locking fault list: servo drive, probe, cloth drop, overspeed, servo communication, memory, frequency component, WIFI component, encoder, drive overload, order completed, yarn gauge.

## 2.2 设置界面/ Setting Interface

按设置键  进入到功能界面如下图

Press the setting button  to enter the function interface as shown below



转动旋转按钮  到所需要图像或单元格，按压旋转按钮确认选择和设置。

Rotate the button  to the desired icon, press the button to confirm selection and setting.

## 2.3 喷油吹气(电磁阀)设置/ Oil/Air (Solenoid Valve) setting



本界面设置举例说明如下：

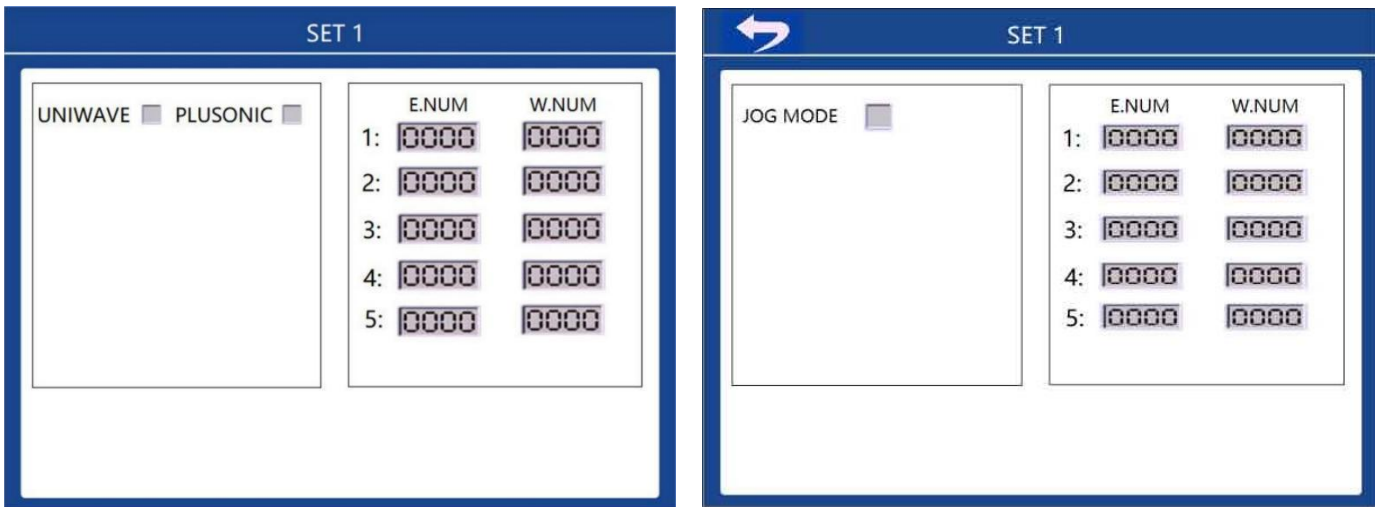
系统 ON/OFF	始动转数	工作转数	停止转数	控制状态
OFF	任意值	任意值	任意值	关闭
ON	任意值	0	任意值	关闭

ON	0	$M(M \geq 1)$	0	启动后立即开启输出
ON	0	$M(M \geq 1)$	$N(N \geq 1)$	启动后立即开启输出，运转 M圈，停止N圈，如此循环
ON	$K(K \geq 1)$	$M(M \geq 1)$	0	启动后，先运转K圈后，再开启输出
ON	$K(K \geq 1)$	$M(M \geq 1)$	$N(N \geq 1)$	启动后，先运转K圈后，再开启输出运转M圈，然后停止N圈，再开启M圈，如此循环
ON	3	5	8	启动后，先运转3圈然后开启输出，运转5圈后，关闭输出，停止8圈后，再次开启输出5圈，如此循环

This interface setting is as follows:

System ON/OFF	Starting revolutions	Working revolutions	Stop revolutions	Control State
OFF	Random value	Random value	Random value	OFF
ON	Random value	0	Random value	OFF
ON	0	$M(M \geq 1)$	0	Turn on output immediately after startup
ON	0	$M(M \geq 1)$	$N(N \geq 1)$	Turn on the output immediately after startup, run M circles, stop N circles, and so on
ON	$K(K \geq 1)$	$M(M \geq 1)$	0	After startup, run K circles first, and then turn on the output
ON	$K(K \geq 1)$	$M(M \geq 1)$	$N(N \geq 1)$	After startup, run K circles first, then turn on the output to run M circles, stop for N circles, and then run M circles, and so on
ON	3	5	8	After startup, first run 3 circles and then turn on the output, after 5 circles, turn off the output, after stop for 8 circles, turn on the output again for 5 circles, and so on

### 2.3.1 喷油吹起 SET1 画面/Oil/Air SET1 Interface



**UNIWAVE:** 手动模式。

**E.NUM:** Starting revolutions.

**PLUSONIC:** 常通模式。

**W.NUM:** Work revolutions.

**E.NUM:** 始动转数。

**W.NUM:** 工作转数。

 启动后，先运转始动转数的圈后，再开启运行工作转数的圈数。

After startup, first run starting revolutions, and then start running working revolutions.

## 2.3.2 清车模式/ Clearing Mode

请先打开特殊清车模式，见 2.6.2 系统设置隐藏画面中的 P1.07（特殊清车模式开关）。

Please turn on customized clearing mode, see 2.6.2 hide system setting interface in P1.07(Customized Clearing Mode Switch)

1) 清车转数>0时，开启该模式，否则关闭该模式。

When the clearing revolutions > 0, turn on this mode, otherwise turn off this mode.

2) 功能启用时，在系统到转后，提示到转故障并停车，按下 RESET键后，<设定转数> 切换为清车转数设定值，再次按下启动时，系统以清车频率运转，若按下点动，则以点动频率运转，执行电磁阀控制。

When this function is enabled, after the system reaches the revolutions, it will prompt the revolution fault and stop. After pressing the RESET button, the <set revolutions> will be switched to the set value of the clearing revolutions. When pressing startup again, the system will run at the frequency of clearing mode. If you press the <JOG> button, it will run at the jog frequency, and the solenoid valve control will be executed.

3) 电磁阀控制：首列为始动转数，次列为工作转数。

Solenoid valve control: the first column is the starting revolutions, and the second column is the working revolutions.

4) 清车转数执行完毕后，系统自动停车，同时切换<设定转数>数值为原设定值，复位 已完成转数值。

After the revolutions of the clearing mode are completed, the system will automatically stop, and at the same time, the <set revolutions> will be switched to the original set value, and the completed revolution value will be reset.

5) 清车模式完毕后，不新增记录匹数，系统事件记录停车事件为<按键停机>。

After the clearing mode is completed, the number of recorded output will not be added, and the system event records the stop event as <press button to stop>.

6) 处于清车模式下时，不允许修改<设定转数>数值，不允许修改<清车转数>数值。

In the clearing mode, it is not allowed to modify the value of <set revolutions>, and it is not allowed to modify the value of <clearing revolutions>.

7) 该模式工作时，系统仍然提示清车模式。

When this mode is working, the system still prompts the clearing mode.

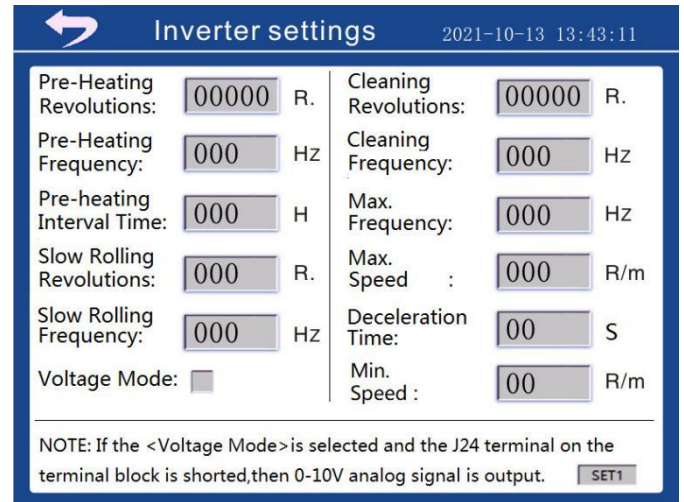
8) 该模式暂停后断电，重新上电后，需重新完整执行一遍。

After the mode is suspended, the power will be turned off. When the power is turned on again, the whole process will be executed again.

9) 处于清车模式下时，RESET键不生效。

Under the clearing mode, the RESET button does not take effect.

## 2.4 变频器设置/Inverter Settings



本界面的设置说明如下:

The settings of this interface are described as follows:

1) **暖机设置:** <暖机转数>设置值大于0时, 暖机功能开启时。系统启动时, 先以<暖机频率>运转<暖机转数>数值的圈数, 然后自动切换到<快车频率>运转。系统持续停止时间过<暖机间隔>数值所示时间后, 再次启动时会重新以暖机模式开启; <暖机间隔>值设定为0时, 每次启动都执行暖机模式; <暖机转数>值为0时, 关闭暖机功能。

**Pre-Heating setting:** <Pre-Heating Revolutions> When the setting value is greater than 0, the warmer function will be turned on. When the system starts, it will first run the <Pre-Heating Frequency> with <Pre-Heating Revolutions>, and then automatically switch to <Fast Frequency> for operation. If the system continues to stop for more than the time indicated by the value of <Pre-Heating Interval Time>, it will restart under the Warmer Mode; when the value of <Pre-Heating Interval Time> is set as 0, the Warmer Mode will be executed every time it is started; when the <Pre-Heating Revolutions> is 0, the warmer function will be turned off.

2) **清车设置:** 系统运转剩余圈数小于<清车转数>所示值时, 系统以<清车频率>所示频率进行运转。若<清车转数>数值设置为0, 则不启动清车功能。

**Clearing setting:** When the remaining revolutions of the system are less than the value shown in<Clearing Revolutions>, the system will run at the frequency indicated by<Clearing Frequency>. If the value of<Clearing Revolutions>is set as 0, the clearing function will not be activated.





3) **最大频率:** 设定最大频率。设定值需与变频器频率设定的最大频率一致, 否则会导致输出电流与变频器对应不上, 从而出现频率设置错误的情况。

**Max. Frequency:** Set the maximum frequency. The set value must be consistent with the maximum frequency set by the inverter frequency. Otherwise, the output current will not correspond to the variable frequency, and frequency setting failure will occur.

4) **最高限速:** RPM值超过该值时, 故障报警, 报警内容为<超速>。


**Max. Speed:** When the RPM value exceeds this value, there will be a fault alarm <Overspeed>.

 旋转旋钮  到  , 先按下  按钮然后再按下  旋钮, 即可进入SET1界面。

Rotate the button  to  , press the  button and then press the  button to enter the SET1 interface.

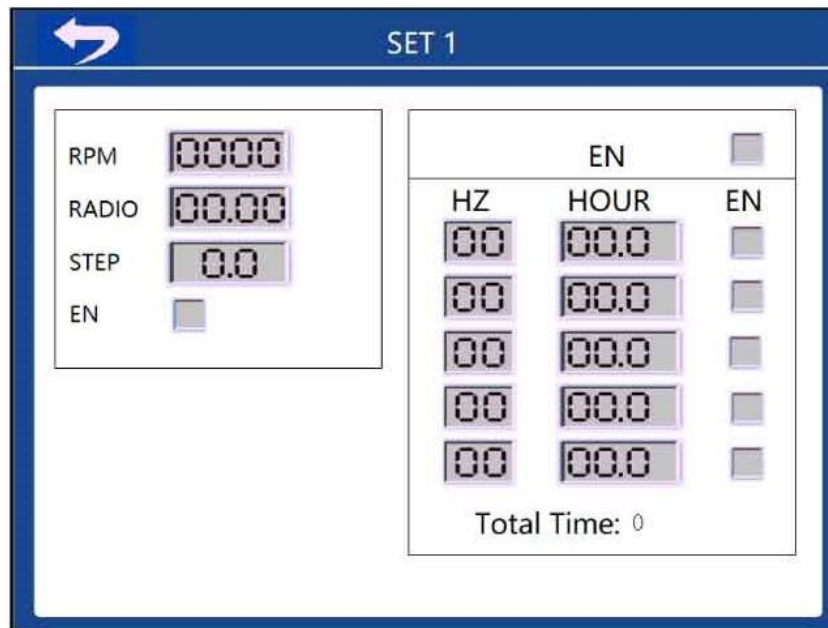
## 2. 4. 1 变频器参数设置/Inverter Parameter Setting

F0-01	第一电机控制方式	The first motor control method	2	/
F0-02	运行指令选择	Run command selection	1	/
F0-03	主频率指令输入选择	Main frequency command input selection	2	/
F0-17	加速时间	Acceleration time	6	S
F0-18	减速时间	Deceleration time	0.8	S
F1-01	电机额定功率	Motor rated power	--	KW
F1-02	电机额定电压	Motor rated voltage	--	V
F1-03	电机额定电流	Motor rated current	--	A
F1-04	电机额定频率	Motor rated frequency	--	HZ
F1-05	电机额定转速	Motor rated rotating speed	--	rpm
F6-11	停机直流制动频率	Downtime DC braking frequency	0.2	HZ
F6-13	停机直流制动电流	Downtime DC braking current	70	%
F6-14	停机直流制动时间	Downtime DC braking time	1.5	S
F8-01	点动加速时间	Jog accelerating time	6	S
F8-02	点动减速时间	Jog decelerating time	0.8	S
F0-10	最大频率	Maximum frequency	60	HZ

 变频器的电机额定功率、额定电压、额定电流、额定频率、额定转速的设置要根据实际使用的电机参数进行设置。

The motor rated power, rated voltage, rated current, rated frequency and rated speed of the inverter should be set according to the parameters of the actual motor being used.

## 2.4.2 变频器设置 SET1 画面/ Inverter Setting SET1 Interface



右侧方框内容是磨机功能,一共可以设置 5 组时间段分别运行。

The content inside the right box is running-in mode setting , and a total of 5 groups of time periods can be set to run separately.

1) <b>主 EN:</b> 打钩会启动系统磨机功能	1) <b>FIRST EN :</b> Tick to activate system running-in function
2) <b>HZ:</b> 系统磨机运行时的频率	2) <b>HZ :</b> Operation frequency during system running-in period
3) <b>HOUR:</b> 系统磨机运行的时间	3) <b>HOUR :</b> System running-in operation duration
4) <b>次 EN:</b> 控制单个时间段系统磨机的开启和关闭。	4) <b>SECOND EN :</b> Switch on and off of the system running-in function in a single time period

## 2.5 班别设置/ Shift Setting

班别	时间	工号
A	00 : 00 - 05 : 59	A0001
B	06 : 00 - 10 : 59	B0001
C	11 : 00 - 15 : 59	C0001
D	17 : 06 - 20 : 59	D0001
E	21 : 00 - 23 : 59	E0001

Shift	Time	Employee No.
A	00 : 00 - 05 : 59	A0001
B	06 : 00 - 10 : 59	B0001
C	11 : 00 - 15 : 59	C0001
D	17 : 06 - 20 : 59	D0001
E	21 : 00 - 23 : 59	E0001

本界面的设置说明如下：

The setting description of this interface is as follows:

1) **时间设置**： 例如： A班:08:00 – 15:59， 则班别对应时间段:08:00-16:00

**Time Setting** : E.g.: Shift A: 08:00–15:59, then the corresponding time period of the shift: 08:00-16:00



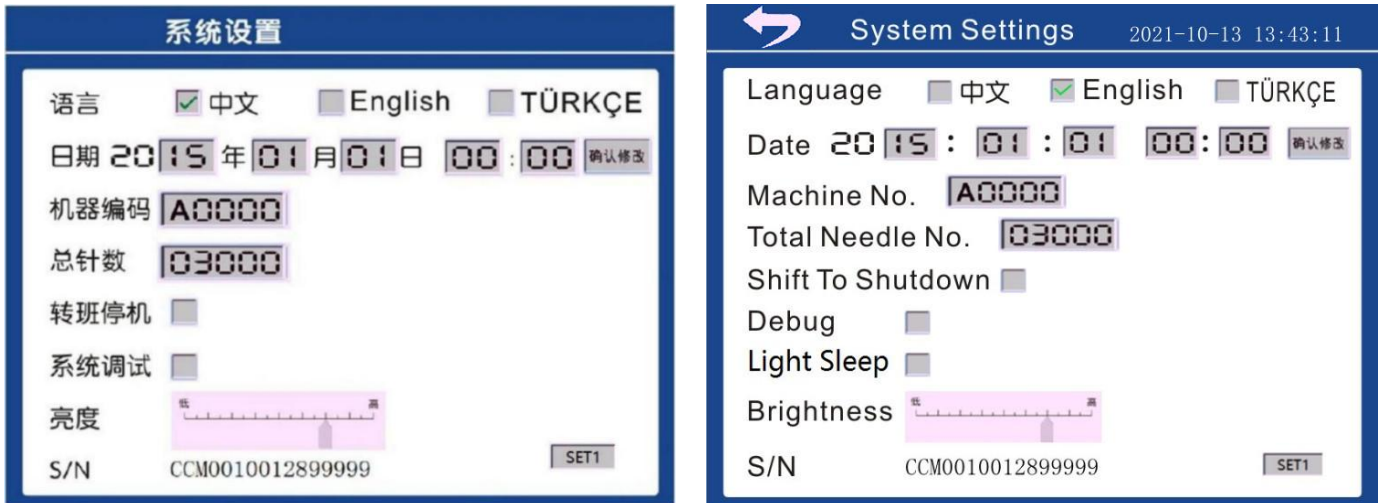
系统班别选择，依照 A-B-C-D-E 的时间段来检索，若 A 时间段覆盖了部分或全部 B 时间，则系统班别不会切换至 B 班。

Note: System shift selection, search according to the time period of A-B-C-D-E. If time period A covers part or all of time period B, then system shift will not switch to shift B.

2) **工号设置**： 设置工作人员工号。字符设定范围:0-9、A-Z。

**Employee No. Setting** : Set the employee ID. Character setting range: 0-9, A-Z.





## 2.6 系统设置/System Setting



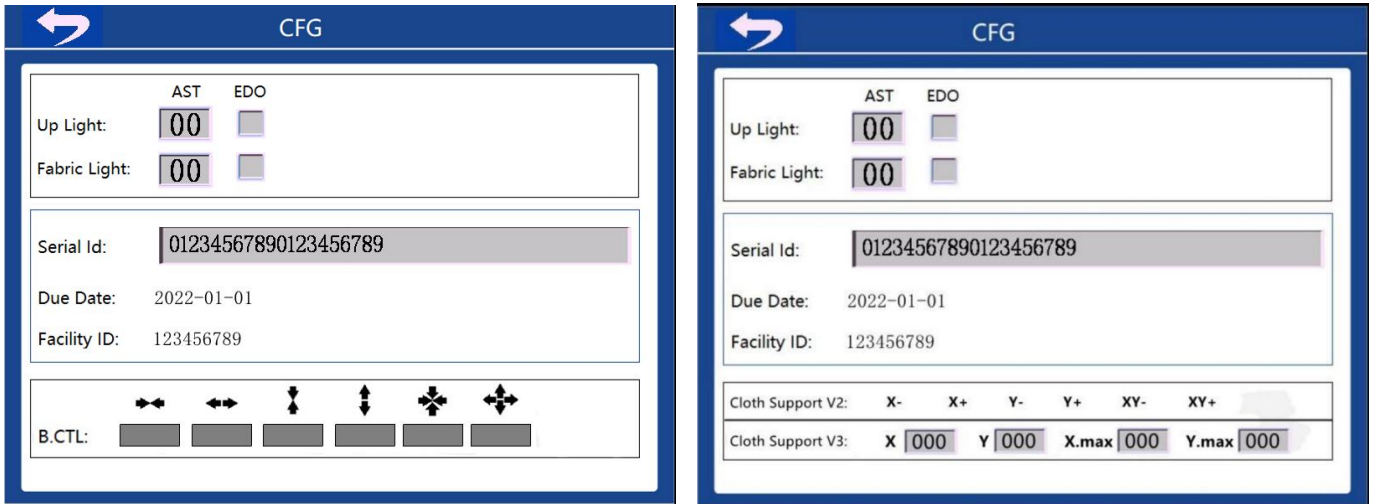
本界面的设置说明如下/The setting description of this interface is as follows:

- 1) **语言选择**: 三种语言选择。/**Language selection** : There are three language options.
- 2) **日期**: 根据实际时间进行编辑, 确认修改后, 系统校验设定数值, 若符合日期时间规范, 则更新系统时钟。若输入的设定数值不合法, 则放弃输入字段。  
**Date** : Edit according to the actual time. After confirming the modification, check the setting value. If it conforms to the date and time specification, update the system clock. If the input setting value is invalid, the input field will be discarded.
- 3) **机器编码**: 用于显示或设定当前机器编号, 字符设定范围: 0-9、A-Z;  
**Machine No.** : display or set the number of the current machine, character setting range: 0-9, A-Z;
- 4) **总针数**: 设定<系统总针数>, 纱长单位选择<百针/CM>时, 该参数会影响测纱器数值的计算。  
**Total Needle No.** : set<system total stitches>. When the <100 stitches/CM> is selected as the unit of yarn length, the parameter will affect the calculation of the yarn gauge value.
- 5) **转班停机**: 选中时, 班别切换时系统停机。  
**Shift To Shutdown** : When this option is selected, the system will be shut down when the shift is switched.
- 6) **系统调试**: 选中时, 不记录产量信息。正常工作时, 若需要记录产量数据, 则不选中 该复选框。  
**Debug** : When this option is selected, no output information will be recorded. When the system is working normally, if you need to record the output data, do not select this option.
- 7) **亮度**: 用于设定屏幕背光亮度;/**Brightness** : Set the brightness of the screen backlight;
- 8) **S/N**: 仅用于显示当前产品序列号;/**S/N** : Display the serial number of the current product;

 旋转旋钮  到  , 先按下  按钮然后再按下  旋钮, 即可进入SET1界面。

Rotate the button  to  , press the  button and then press the  button to enter the SET1 interface.







## 2.6.1 系统设置 SET1 画面/Enter <SET1> Interface









本界面的设置说明如下/The setting description of this interface is as follows:

- 1) **Up Light:** 上照明灯/**Up Light** : Upper Light.
- 2) **Fabric Light:** 下照明灯/**Fabric Light** : Lower light.
- 3) **Ast:** 上照明和下照明灯的睡眠时间。设置时间到了时照明灯自动休眠。  
**Ast** : Sleep time for upper and lower lights. When the set time is up, the light will automatically sleep.
- 4) **Edo:** 安全门故障。勾选后打开照明灯对应的安全门时，照明灯自动点亮。  
**Edo** : Safety door fault. When this box is ticked, if the safety door corresponding to the light is opened, the light will be automatically turned on.
- 5) **Serial ID:** 租赁ID。输入租赁ID后，自动生成可使用的租赁时间<Due date>。  
**Serial ID** : Lease ID. After entering the lease ID, the available lease time will be automatically generated<Due date>.
- 6) **Facility ID:** 设备ID/**Facility ID** : Facility ID.

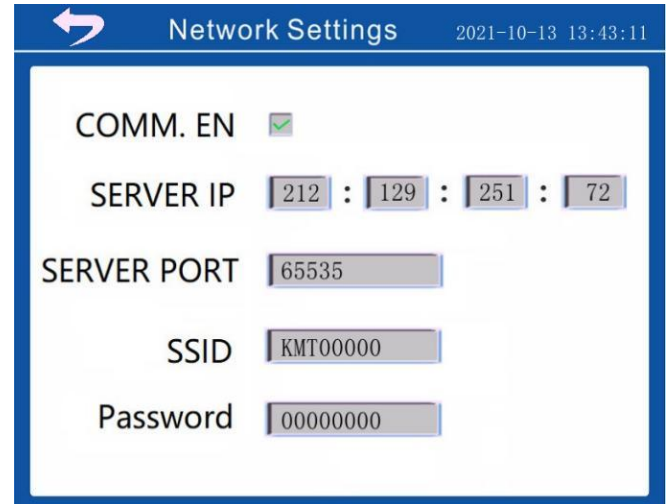
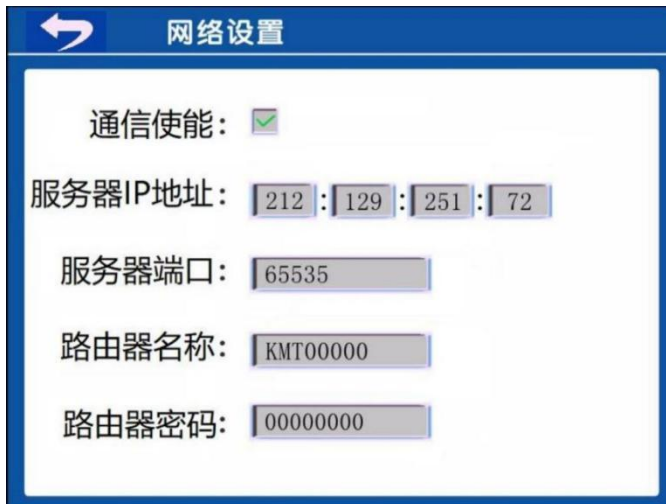
页面中<Cloth Support V2>能对 V2 版本的电子撑布架进行控制。X-和X+表示横向收缩伸展操作,Y-和Y+表示纵向收缩伸展操作。XY-和XY+表示横向和纵向同时收缩伸展操作。

**B.CTL:**  and  refer to the horizontal contraction and extension operation,  and  refer to the vertical contraction and extension operation.  and  refer to the horizontal and vertical simultaneous contraction and extension operations.

页面中的<Cloth Support V3>能对V3版本的电子撑布架进行控制。X表示输入横向伸缩位置坐标的数值，Y表示输入纵向伸缩位置坐标的数值，X.max表示输入限制X横向伸缩最大位置的数值，Y.max表示输入限制Y.纵向伸缩最大位置的数值。如X.max输入100，X的最大有效值为100。

If any button of , , , , ,  is pressed on the panel, it will automatically exit the remote control mode and enter the panel mode. If you want to re-enter the remote control mode, just exit and re-enter the CFG page, it will automatically enter the remote control mode again.

## 2.7 网络设置/Network Settings



本界面的设置说明如下：

The setting description of this interface is as follows:

1) **服务器 IP 地址：** IP 地址为 212.129.251.72，如有更改请联系供应商申请并开通；

**Server IP address :** The IP address is 212.129.251.72. If there is any change, please contact to the supplier for application and update;

2) **服务器端口：** 服务器通信TCP端口值请联系供应商申请并开通；

**Server port :** For server communication TCP port value, please contact the supplier for application and update;

3) **路由器名称：** 根据路由器名称输入名称，最多可输入12个字符（字符范围是可显示的ASCII 码字符）。

如名称为“KMT00000”时，该位置设置为<KMT00000>；

**SSID :** Enter the name according to the router name, with a maximum of 12 characters (the character range is the displayable ASCII characters). For example, when the name is "KMT00000", the location will be set as <KMT00000>;

4) **路由器密码：** 根据路由器密码输入密码，最多可输入 12个字符（字符范围是可显示的ASCII码字符）。


如密码为“00000000”时，该位置设置为<00000000>。

**Password :** Enter the password according to the router password, with a maximum of 12 characters (the character range is the displayable ASCII characters). For example, when the password is "00000000", the location will be set as <00000000>.

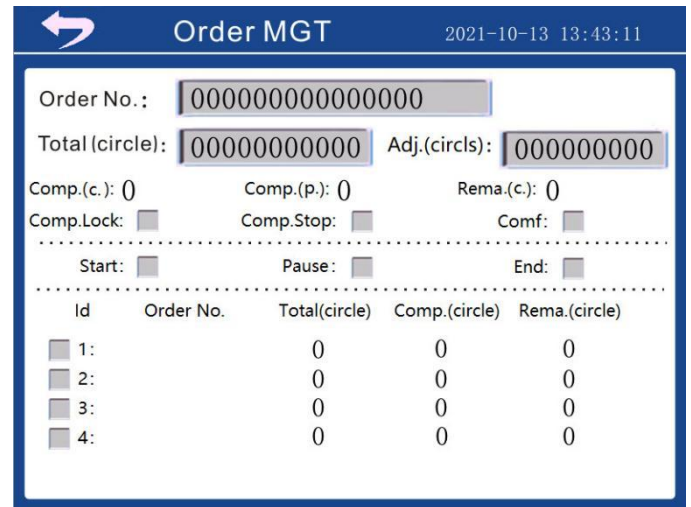
 此界面配置参数在 WIFI 通信模式时生效。

The configuration parameter of this interface takes effect in WIFI communication mode.

 逆时针旋转旋钮  到第一个空字符位置并按压确认选择，可以立即停止输入并退出输入状态。

Rotate the button  counterclockwise to the first null character position and press to confirm the selection, immediately stop input and exit the input state.

## 2.8 订单管理/Order Management

本界面的设置说明如下：

The setting description of this interface is as follows:

1) **订单编号**：用于显示当前选中订单号或者输入新增订单号。输入支持最长15个字符，字符范围：0-9，A-Z（大写）中间不能存在空格。若订单列表已满（4条）则不允许新增订单，输入无效。若输入订单号为现存订单，则输入无效。

**Order No.** : The currently selected order number or enter a new order number. The input supports maximum 15 characters. Character range: 0-9, no spaces between A-Z (uppercase). If the order list is full (4 items), new orders are not allowed, and the input is invalid. If the input order number is an existing order, the input is invalid.

2) **订单总量**：用于显示当前选中订单的生产数量（圈数），或输入新增订单的生产数量（圈数）。输入数值范围：0~99999999。当<订单总量>输入新增订单号时，现存订单若需要调整生产数量，必须通过<调整>框来输入数值调整。

**Total (circle)** : The production quantity (circles) of the currently selected order, or enter the production quantity (circles) of the new order. Input value range:0~99999999. When new order number is input in the <Number of Orders>, and if you want to adjust the the production quantity of the existing order, you must adjust the value by entering the <Adjust> box.

3) **调整**：用于增加或减少当前选中订单的生产数量（新输入订单号时，不允许输入该值）。最大支持输入：-99999999 ~ +99999999。

**Adj.(circls)** : Increase or reduce the production quantity of the currently selected order (the value will not be allowed when a new order number is input). Maximum supported input:-99999999~ +99999999.

4) **已完成(圈)**：用于显示当前选中订单号已经生产完成的圈数。

**Comp.(c.)** : The number of circles that have been completed for the currently selected order number.

5) **已完成(匹)**：用于显示当前选中订单号已经生产完成的匹数。

**Comp.(p.)** : The number of pieces that have been produced for the currently selected order number.

6) **剩余(圈)**：用于显示当前选中订单号剩余待生产圈数。

**Rema.(c.)** : The remaining circles to be produced for the currently selected order number.

7) **完成锁机**：用于表示当前选中的订单在生产完成时，是否锁定机器。或者在输入新增订单号时，如果选中<完成锁机>功能后<完成停车>功能会自动同时选中，并且在未选中<完成锁机>功能时，才能修改<完成停车>功能。

**Comp.Lock** : Display whether to lock the machine when the production of the currently selected order is completed; or when entering the new order number, if the function of <Lock when completed> is selected, the <Shutdown when completed> function will be automatically selected at the same time, and the <Shutdown when completed> function can only be modified when the <Lock when completed> function is not selected.

8) **完成停车**：用于表示当前选中订单生产完成时，是否停机；或输入新增订单号时，配置完成停机功能。

**Comp.Stop** : Whether to stop when the production of the currently selected order is completed; or when entering a new order number, enable the shutdown function.

9) **确认修改**：当前选中订单情况下，<调整>、<完成锁机>、<完成停机>改变时，按下此键生效保存。当输入新增订单号情况下，按下此键生效保存。

**Comf** : When the current order is selected, if you want to change the <Adjust>, <Lock when completed>, <Shutdown when completed>, press this button to take effect and save. When the new order number is input, press this button to take effect and save.

10) **订单开始**：若当前为打钩状态，则表示当前选中订单号正在生产；若为非打钩状态，表示当前选中订单处于暂停状态；按下该键后，暂停其余所有订单生产，启动当前选中订单生产。

**Start** : If it is currently selected, it means that the currently selected order number is being produced; if it is not ticked, it means that the currently selected order is in a suspended state; after pressing this button, the production of all other orders will be suspended and the production of the currently selected order will be started.

11) **订单暂停**：若当前为选中状态，则表示当前选中订单处于暂停状态，若为未选中状态，则表示当前选中订单处于生产状态。

**Pause** : If it is currently selected, it means that the currently selected order is in a pause state; if it is not selected, it means that the currently selected order is in a production state.

12) **订单结束**：按下时，提前结束当前选中订单。当<订单结束>选项选中后，立即将当前选中订单切换为<已完成>状态，并在订单列表中将之删除。

**End** : When the current state is ticked, the currently selected order will be ended in advance. When the <End the order> option is selected, the currently selected order will be switched to <Completed> status and it will be deleted from the order list.

13) **序号**：用于表示当前所选中的订单号。可查看不同订单数据，或修改订单生产数量，完成控制方式等。

**Id**: The currently selected order number. You can view different order data, or modify the order production quantity, completion control method, etc.

14) **订单列表**：用于显示所有有效订单号。/**Order No.** : All valid order numbers.

15) **订单数量**：用于表示订单对应的生产数量。

**Total (circle)** : The production quantity corresponding to the order.

16) **已完成数量**: 用于表示订单已生产完成数量 (圈数)。

**Comp.(circle)**: The completed quantity (circles) of the order that has been produced.

17) **剩余数量**: 用于表示待生产数量 (圈数)。

**Rema.(circle)**: The quantity to be produced (circles).



进入订单页面后, 将系统存在的未完成订单显示在<订单列表>中, 同时自动选择到当前正常生产订单, 若当前无正常生产订单, 则自动选择首行订单号<订单编号>、<订单总量>、<已完成(圈)>、<已完成(匹)>、<剩余(圈)>、<完成锁机>、<完成停车>、<订单开始>、< 订单暂停>、位置显示所选订单的数值或状态; <调整>数值显示为0; 若订单列表为空, 则显示空白。



After entering the order page, the unfinished orders existing in the system will be displayed in the <Order list>, and the current normal production order will be automatically selected. If there is no normal production order, the first line of order number <Order No.>, <Total order>, <Completed (circle)>, <Completed (pcs)>, <Remaining (circle)>, <Lock when completed>, <Shutdown when completed>, <Order start>, <Order pause> will be automatically selected, and the position shows the value or status of the selected order; <adjust> value is displayed as 0; if the order list is empty, it will be blank.



订单完成时, 若订单开启<完成停车>功能, 则在订单完成时报警停机, 主告警区域提示<订单完成>告警。若订单未选中<完成锁机>功能, 则可以按下<停止键>复位告警。若订单开启了<完成锁机>功能, 则必须在开始其他订单生产后 (订单页面选中订单, 并打钩<订单开始>操作), 才能按下<停止键>复位告警。



When the order is completed, if the function <Shutdown when completed> is enabled, it will alarm and stop when the order is completed, and the main alarm area will prompt the <Order completed>. If the function <Lock when completed> is not selected for the order, you can press the <Stop button> to reset the alarm. If the function <Lock when completed> is enabled for the order, you can only press the <Stop button> to reset the alarm after starting the production of other orders (select the order on the order page and tick the <Order start> operation).

## 2.9 历史数据/Historical Data

历史数据				
ID	日期	时间	事件描述	数值
1	2015-01-02	11:54:00.0	到转	2000
2	2015-01-02	11:54:00.0	启动	1890
3	2015-01-02	11:54:00.0	故障清除	01:54:00
4	2015-01-02	10:00:00.0	故障停机	1890
5	2015-01-02	10:00:00.0	上断纱	0
6	2015-01-02	09:10:40.0	启动	1568
7	2015-01-02	08:30:50.0	按键停机	1568
8	2015-01-02	08:30:16.0	启动	1025
9	2015-01-02	08:20:20.0	故障清除	00:09:54
10	2015-01-02	08:10:30.0	变频器	0
11	2015-01-02	08:10:28.0	安全门	0
12	2015-01-02	08:10:26.0	缺气	0
13	2015-01-02	08:10:26.0	班别切换	A
14	2015-01-02	08:10:23.0	系统开机	3

Data				
ID	Date	Time	Description	No.
1	2021-01-02	11:54:00.0	Complete	2000
2	2021-01-02	11:54:00.0	Startup	1890
3	2021-01-02	11:54:00.0	Clear Fault	01:54:00
4	2021-01-02	10:00:00.0	Fault to Stop	1890
5	2021-01-02	10:00:00.0	Up Break	0
6	2021-01-02	09:10:40.0	Startup	1568
7	2021-01-02	08:30:50.0	Push Stop	1568
8	2021-01-02	08:30:16.0	Startup	1025
9	2021-01-02	08:20:20.0	Clear Fault	00:09:54
10	2021-01-02	08:10:30.0	Inverter	0
11	2021-01-02	08:10:28.0	Door	0
12	2021-01-02	08:10:26.0	Low Air	0

本界面的设置说明如下/The setting description of this interface is as follows:

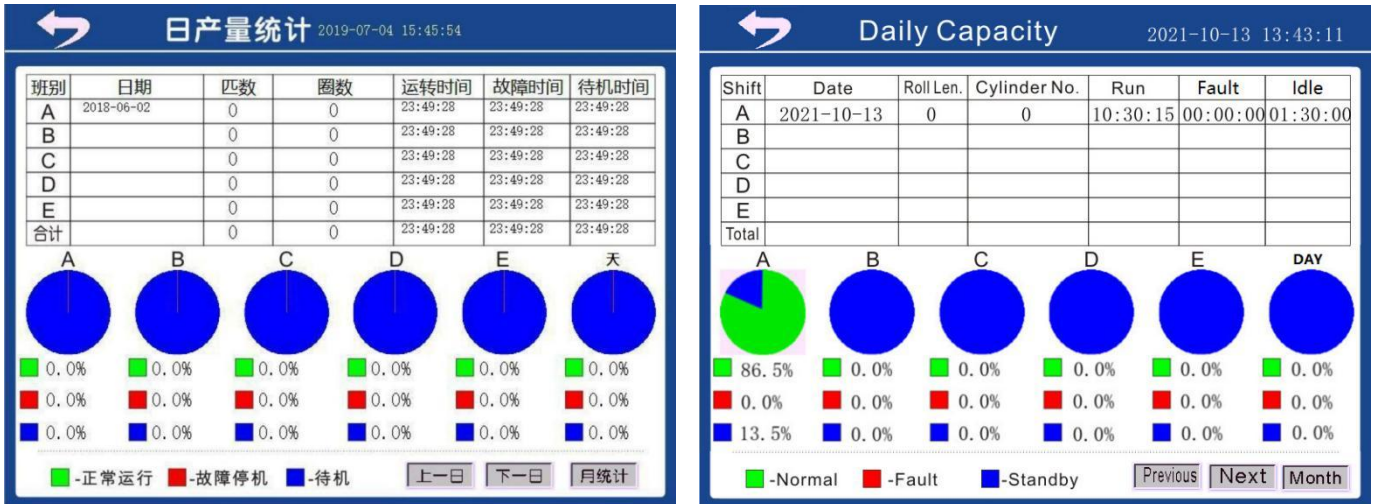
- 1) 每个界面显示 14 条记录, 包含<日期><时间>数据, 以及<事件描述>和<数值>字段;  
Each interface displays 14 records, including <date> <time> data, as well as <event description> and <value> fields;
- 2) 系统最多保留约8000条记录, 当记录满时, 系统会自动记录时间最早的事件, 以便保存新的事件;  
The system retains about 8000 records at most. When the records are full, the system will automatically record the oldest event in order to save the new event;
- 3) 日期: 例如, 2015-10-18, 显示当前描述事件发生的日期;  
**Date** : e.g, 2015-10-18, display the date when the current event occurred;
- 4) 时间: 例如, 15:12:08.2, 显示当前描述事件发生的时间, 精确到0.1秒。  
**Time** : e.g. 15:12:08.2, display the time when the current event occurred, accurate to 0.1s.  
历史数据画面中<事件描述>以及相应<数值>表示的意义:  
The meaning of <Description>and corresponding<NO.> in the historical data screen:

描述/Description	事件意义, 数值意义/The meaning of event and value
启动 Startup	按下启动按钮运转系统事件记录, 数值表示启动时的转数 Press the start button to run the system event record. The value indicates the number of revolutions at startup
按键停机 Stop	按下停止按钮停止运转事件记录, 数值表示停止时的转数 Press the stop button to stop the operation event record. The value indicates the number of revolutions at the time of stop
故障停机 Fault to Stop	出现故障导致系统停止运转的事件记录, 数值表示停止时的转数 A record of events that caused the system to stop when a fault occurs. The value indicates the number of revolutions at the time of stop

订单切换 Switch Order	调整订单编号时记录该事件，数值表示新订单编号 This event is recorded when the order number is adjusted. The value indicates the new order number
订单调整 Change Order	调整总量调整时记录该事件。数值表示新的订单总量 Event record when all faults are cleared. The value indicates the duration of the fault (including all faults)
故障清除 Clear Fault	所有故障清除时事件记录，数值表示故障持续时间(包含所有故障) Event record when all faults are cleared. The value indicates the duration of the fault (including all faults)
系统开机 System Boot	每次上电或者系统复位时，记录一次事件，数值无意义 Each time the power is turned on or the system is reset, an event is recorded, and the value is meaningless
上断纱 Up Break	上断纱故障，数值无意义 Upper yarn break fault, the value is meaningless
下断纱 Down Break	下断纱故障，数值无意义 Lower yarn break fault, the value is meaningless
伺服驱动 Servo Driver	伺服故障，数值无意义 Servo fault, the value is meaningless
变频器 Inverter	变频器故障，数值无意义 Inverter fault, the value is meaningless
安全门 Door	安全门故障，数值无意义 Safety door fault, the value is meaningless
急停 Stop	急停故障，数值无意义 Emergency stop fault, the value is meaningless
探布器 Break	探布器故障，数值无意义 Probe fault, value is meaningless
探针器 Needle	探针器故障，数值无意义 Probe fault, the value is meaningless
缺气 Low Air	缺气故障。数值无意义 Lack of air failure, the value is meaningless
喷油机 Oil Sprayer	喷油机故障，数值无意义 Injector failure, the value is meaningless
剖布机 Cutting	剖布机故障，数值无意义 Cutter fault, the value is meaningless
掉布 Drop	掉布故障，数值无意义 Fabric drop fault, the value is meaningless
超速 Speed	超速故障，数值=超速RPM 数值* 10 Overspeed fault, value = overspeed RPM value *10

到转 Complete	转数到达，数值表示当前已完成的转数 The number of revolutions has been completed, and the value indicates the number of revolutions currently completed.
伺服通信 Servo Comm	伺服从机通信故障，数值表示异常通道 ID号 Servo communication fault, the value indicates abnormal channel ID number
换班 Shift	切换班别事件，数值表示新生效的班别，若为无效班别，则显示空白 Shift switch event, the value indicates the new effective shift, if it is an invalid shift, it will be blank
保险丝-220V Fuse-220V	220VAC 保险丝故障 220VAC fuse fault
保险丝-24V Fuse-24V	24VAC 保险丝故障 24VAC fuse fault
保险丝-20V Fuse-20V	20VAC 保险丝故障 20VAC fuse fault
存储器 Storage	系统内部存储器故障，数值无意义 Internal memory of the system fault, the value is meaningless
频率组件 Frequency	变频器频率输出组件故障，数值无意义 Fault of the frequency output component of the inverter, the value is meaningless
WIFI 组件 WIFI	WIFI 组件故障，数值无意义 WIFI component fault, the value is meaningless
编码器 Encoder	伺服系统编码器故障，可能为编码器供电异常或编码器损坏或接线异常 Fault of the encoder of the servo system, the power supply to the encoder may be abnormal or the encoder is damaged or the wiring is abnormal
驱动过载 Drive Overload	12VDC/24VDC 输出过电流故障，或者主板内部电压异常，数值无意义 12VDC/24VDC Output overcurrent fault, or abnormal voltage inside the main board, the value is meaningless
订单完成 Complete Order	订单完成，数值表示订单号 The order is completed, the value indicates the order number
测纱器 Yarn Sensor	测纱器故障，数值无意义 Yarn gauge fault, the value is meaningless

## 2.10 产量统计/Output Statistics



日产量统计数据说明如下：

Daily output statistics are explained as follows:

1) 每天产量统计按照 A-E 顺序排列，默认显示当天的 5 个班别产量统计。

Enter this interface, default display the output statistics of the five shifts.

2) 按<上一日>或<下一日>来切换显示不同日期的 5 个班别产量信息。该页面仅能检索到有存储产量数据的记录。

Press<Previous> or <Next> to display 5 shift output information on different dates. The page only records stored output data.

例如：2015-01-02 为当前显示页面，按下<上一日>后，若 2015-01-01 日无产量记录，而 2014-12-31 日有产量记录，则直接显示 2014-12-31 的产量数据。若选择当前最新日期，则无论是否有产量记录，都会显示。

E.g.: 2015-01-02 is the current display page, when you press the <previous day>, if 2015-01-01 has no output record while 2014-12-31 has daily output record, the output data of 2014-12-31 will be displayed directly. If the latest date is selected, it will be displayed whether there is output record.



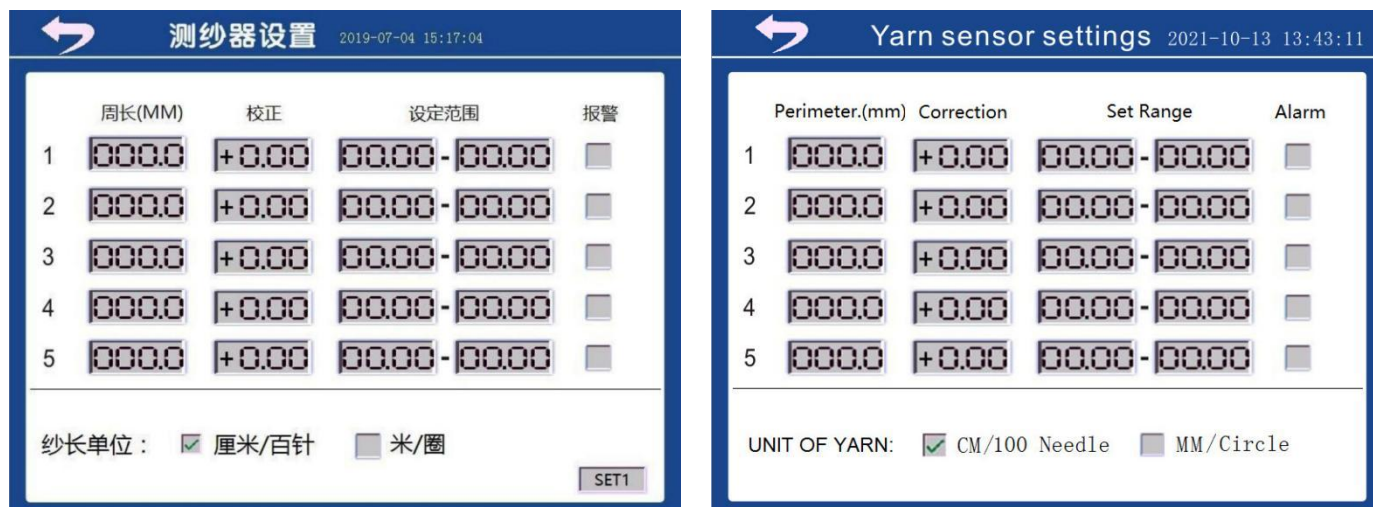
正确的产量统计数据，依赖准确无误日期设置。一旦日期设置错误，则可能成产量统计错误。



Correct output statistics relies on the accurate date settings. Once the date is set incorrectly, it may result in an error in production statistics.



## 2.11 测纱器设置/Yarn Gauge Setting



测纱器设置画面说明如下/The description of yarn gauge setting interface is as follows:

1) **纱轮周长**: 设定相应通道的测纱器对应的输纱纱轮周长值, 单位为 MM。

**Perimeter.(mm)** : Set the circumference of the yarn feed wheel corresponding to the yarn gauge of the corresponding channel, unit: mm.

2) **设定范围**: 设定相应通道纱长在允许误差范围内的最大值与最小值。该数值单位跟随<纱长单位>选项。

**Set Range** : Set the maximum and minimum value of the yarn length of the corresponding channel within the allowable error range. The numerical unit follows the <Yarn Length Unit> option.

3) **报警**: 设定相应通道测纱异常报警停车是否启用, 若不启用, <设定范围>项目的设定数值没有意义。

**Alarm**: Whether shutdown caused by the abnormal yarn measuring of the corresponding channel is enabled. If it is not enabled, the setting value of the<Set Range> is meaningless.


4) **纱长单位**: 根据用户习惯, 选择合适的纱长显示单位。该参数影响主显示页面的纱长显示值, 若系统开启<伺服控制>菜单, 还会影响伺服驱动参数, 请勿随意调整, 否则可能造成系统启动后大量断纱、掉纱的情况。


**Unit Of Yarn**: Select the appropriate yarn length display unit according to user habits. This parameter affects the yarn length display value of the main display page. If the system turns the <Servo Control>menu on, it will also affect the servo drive parameters. Please do not adjust randomly, otherwise a lot of yarn breakage and yarn drop will occur when the system is started.

5) **校正**: 相应通道面板上显示的纱长值与对应通道设定的纱长值之间误差的校正。对应通道面板显示值 - 对应通道纱长设定值=对应通道校正值




**Correction** : Correction of the error between the yarn length value displayed on the corresponding channel panel and the yarn length value set by the corresponding channel.

Corresponding channel panel display value-corresponding channel yarn length setting value=corresponding channel correction value

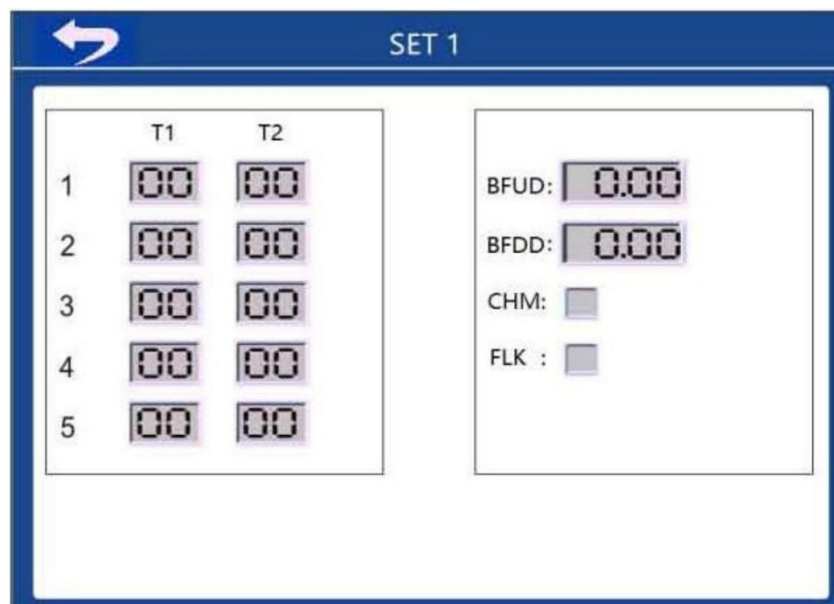
 此校正值必须在纱长设定值等于实际测量纱长值一致的情况下方可设置。

 This correction value must be set under the condition that the yarn length setting value is equal to the actual measured yarn length value.

 旋转旋钮  到 SET1，先按下  按钮然后再按下  旋钮，即可进入SET1界面。

Rotate the button  to SET1, press the  button and then press the  button to enter the SET1 interface.

### 2.11.1 测纱器 SET1 画面/Yarn Gauge SET1 Interface



测纱器 SET1 画面说明如下：

The description of the yarn gauge SET1 screen is as follows:

1) **T1:** 1~5 是输纱器齿轮数。

2) **T2:** 1~5 是电机齿轮数。

**T1:** 1~5 refers to the number of yarn feeder gears.

**T2:** 1~5 refers to the motor gear number.

3) **BFUD:** 上断纱检测延时。

4) **BFDD:** 下断纱检测延时。

**BFUD:** Upper yarn break detection delay.

**BFDD:** Lower yarn break detection delay.

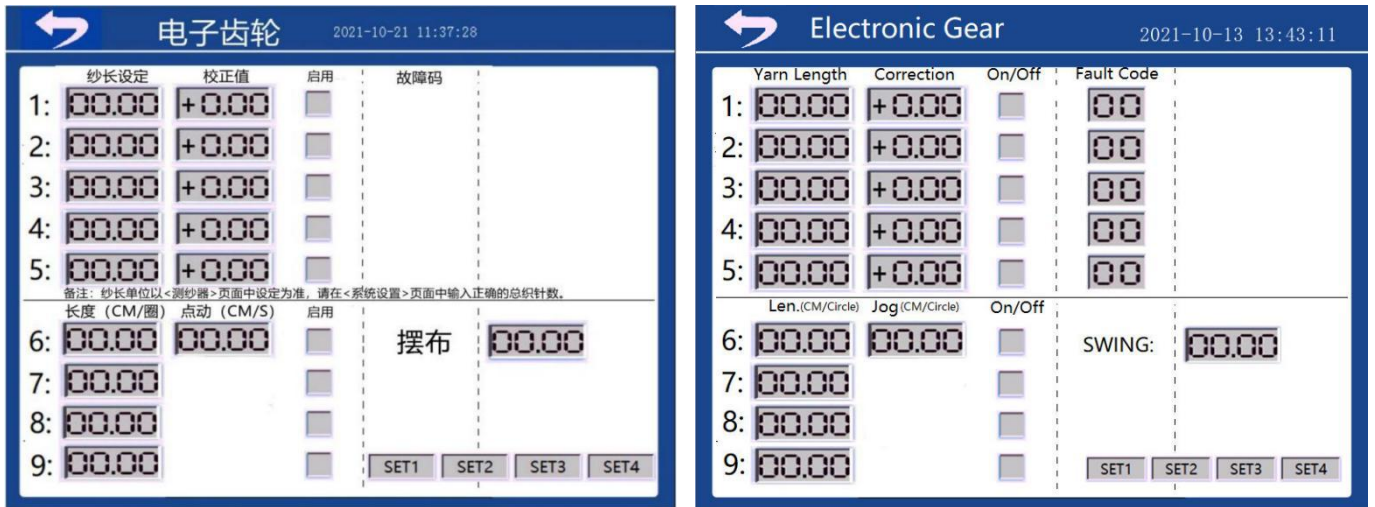
5) **CHM:** 测纱传感器强制使用外部传感器。使用外部测纱传感器时勾选此选项。

**CHM:** The yarn measuring sensor is forced to use an external sensor. Tick this option when using an external yarn measuring sensor.

6) **FLK:** 断纱闪烁。选择后断纱故障闪烁。

**FLK:** It will flash when the yarn breaks. After selection, it will flash when there is a yarn breakage fault.

## 2.12 电子齿轮页面/Electronic Gear Page



伺服送纱和伺服卷布相关参数设定 /Parameter setting related to servo yarn feeding and servo batching:

1) **纱长设定**: 设定相应通道的伺服送纱纱长值, 单位必须与<测纱器>页面中<纱长单位>保持一致。

**Yarn length**: set the servo yarn length value of the corresponding channel, the unit must be consistent with the <yarn length unit> in the <yarn gauge> page.

2) **启用**: 控制相应通道的伺服送纱使能与关闭。(1~5是伺服送纱通道, 6、7是伺服卷布通道) 伺服卷布根据客服需求有分一个伺服电机和两个伺服电机, 6号通道为主电机, 7号通道为辅电机。

**On/Off**: Control the enable and disable of servo yarn feeding of the corresponding channel. (1~5 are servo yarn feeding channels, 6、7 are servo batching channels) For servo batching, one servo motor or two servo motors can be selected according to customer service requirements. Channel 6 is the main motor, and channel 7 is the auxiliary motor.

3) **校正值**: 实测纱长与设定纱长存在误差时, 可调整相应通道校正值修正误差。校正值=实测纱长-设定纱长  
**Correction**: When there is an error between the measured yarn length and the set value, the correction value of the corresponding channel can be adjusted to correct the error. Correction value = measured yarn length - set yarn length

4) **故障码**: 显示相应通道的故障代码。/**Fault Code**: Display the fault code of the corresponding channel.





5) **长度(CM/圈)**: 设定伺服卷布的跟踪转速, 如圆机旋转一周, 需要卷布 16.5CM, 则 填入 016.5。

**Len.(CM/circle)**: Set the tracking speed of the servo batching, if the circular knitting machine rotates one circle, 16.5 cm of fabric will be batched, and 016.5 should be filled in.

6) **点动 (cm/s)**: 手动的卷布速度, 设定值不超过 0.5。

**Jog (cm/s)**: Manual batching speed, the set value does not exceed 0.5.

 旋转旋钮  到  , 先按下  按钮然后再按下  旋钮, 即可进入SET1界面。

Rotate the button  to  , press the  button and then press the  button to enter the SET1 interface.

## 2.12.1 电子齿轮 SET1 画面/ Electronic Gear SET1 Interface



电子齿轮 SET1 画面说明如下：

The description of the electronic gear SET1 interface is as follows:

**G. T.:** 1~5是输纱器齿轮数；6~9 是卷布棍齿轮数, 默认值。

**M. T.:** 1~9 是电机齿轮数, 默认值

**E. R.:** 编码器传动比, 用于指示机器旋转一圈, 编码器旋转了多少圈。

**S. D.:** 送纱脉冲分频比, 编码器传动比在30以下时, 设置为0, 大于30时, 根据实际情况设定。

**E. P.:** 所选编码器的编码数。

**B. D.:** 卷布脉冲分频比。注: 卷布系统使用。

**D. T.:** 测距传感器基准测距值。注: 卷布系统使用。

**E. R. (Calc.):** 测试编码器传动比, 修改数值方式见2. 12.3 E. R. (Calc.) 参数修改

**O. D. (CM):** 6~9 号棍的直径, 默认值。

**D. R.:** 6~9 号棍的减速比, 默认值。

**G.T.:** 1~5 refers to the gear number of the yarn feeder; 6~9 refers to the number of the roller gear, the default value.

**M.T.:** 1~9 refers the number of motor gears, the default value

**E.R.:** Encoder transmission ratio, used to indicate how many circles the encoder rotates for one revolution of the machine.

**S.D.:** Pulse frequency dividing ratio of the Yarn feeder, when the encoder transmission ratio is below 30, set it to 0; when it is greater than 30, set it according to the actual situation.

**E.P.:** Number of codes for the selected encoder.

**B.D.:** The frequency dividing ratio of the batching pulse.  
Note: For the batching system.

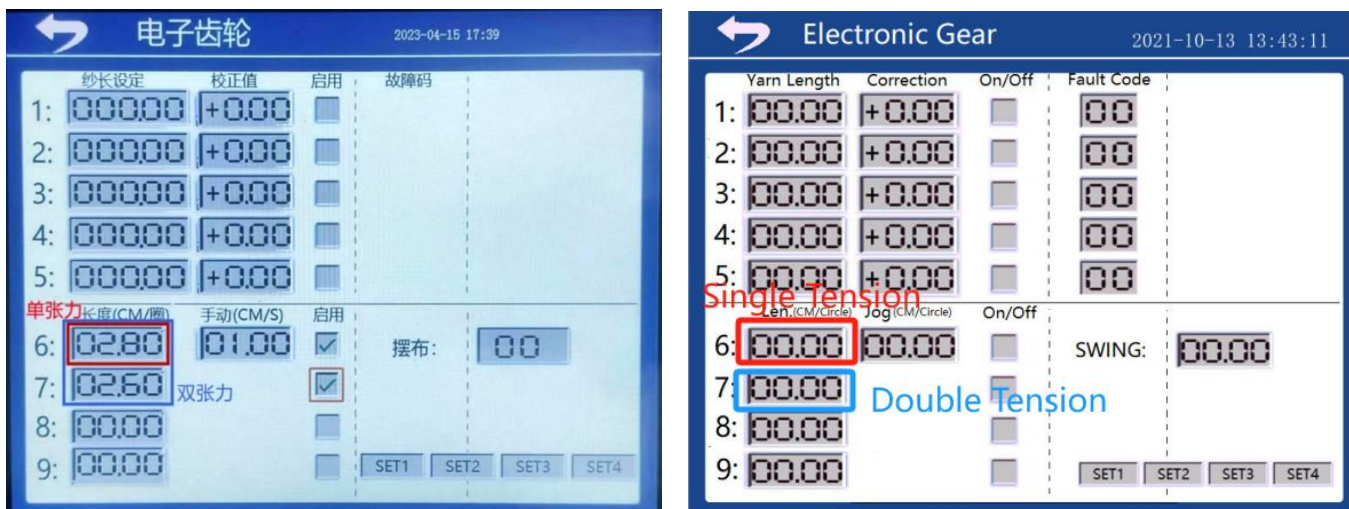
**D.T.:** The reference distance value of the distance sensor.  
Note: For the batching system.

**E.R.(Calc.):** Machine transmission ratio. For parameter modification, see 2.12.3 E.R. (Calc.) for details

**O.D.(CM):** The diameter of the stick 6~9, the default value.

**D.R.:** The reduction ratio of the stick 6~9, the default value.

## 2.12.2 张力卷布功能/ D.T. Parameter Modification



单通道（通道 6）张力卷布功能配置：

Single channel(Channel 6) tension batching function configuration:

1) 开启功能配置开关(恒张力卷布功能)。在<系统设置>界面里进入<功能配置>页面勾选P1.12(卷布张力控制模式)。

Turn on function configuration switch(constant tension batching function). Enter<Function Configuration>on <System Setting> interface to tick P1.12(batching tension control mode)

2) 开启卷布张力控制模式后，通道6的<长度>值表示所期望张力值，数值设定范围2.00-85.00。

Turn on batching tension control mode,Channel 6 displays expected tension value on <Length> value,set the value from 2.00 to 85.00.

双通道（通道6和7）张力卷布功能配置：

Double channel(Channel 6 and 7)tension batching function configuration:

1、开启功能配置开关（双张力卷布功能）。在<系统设置>界面里进入<功能配置>页面勾选P2.01（双张力控制模式）。

Turn on function configuration switch (Double tension batching function).Enter <Function Configuration> on <System Setting> interface to tick P2.01(double tension control mode)

2、开启卷布张力控制模式后，通道6和通道7的<长度>值表示所期望张力值，数值设定范围2.00-85.00。

Turn on batching tension control mode,Channel 6 and 7 display expected tension value on <Length> value,set the value from 2.00 to 85.00.

### 2.12.3 E.R. (Calc.)参数修改/E.R.(Calc.) Parameter Modification



先按压 将转速里的已完成清零，再将设定值设置成00001，然后点击 启动卷布机，然后再进入SET1界面里，点击 自动读取到数值，然后再返回主界面修改设定值。

First press to clear the completed value in the rotating speed, then set the set value to 00001, then click to start the batching machine. Enter the SET1 interface, click to automatically read the value, and then return to the home interface to modify the set value.

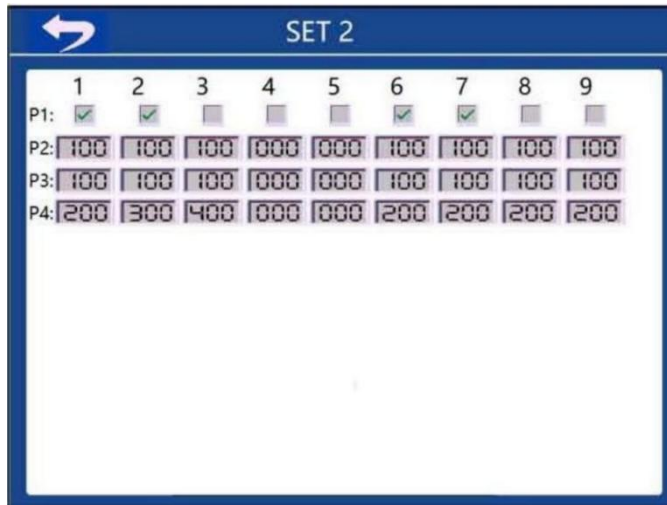


将设定值设置成00011，然后点击 启动卷布机，然后再进入SET1界面里，点击 自动读取到数值，然后点击 ，传动比的参数会自动写入到数值里。**注：**如果操作过程中发生停机，需要重新开始操作。

Set the setting value to 00011, then click to start the batching machine, then enter the SET1 interface, click to automatically read the value, then click , the parameter for the transmission ratio will be automatically written to the value.

**Note:** If a shutdown occurs during operation, please restart the operation.

## 2.12.4 电子齿轮SET2界面/Electronic Gear SET2 Interface



电子齿轮 SET2 画面说明如下：

The description of electronic gear SET2 interface is as follows:

1) **P1:** 1~5是输纱器电机正反转调节，6~9是卷布机电机正反转调节。在方框中打勾调节正反转，具体正反转方向调节根据布运行轨迹调节。

**P1:** 1~5 refers to the positive and negative rotating adjustment of the yarn feeder motor, 6~9 refers to the positive and negative rotating adjustment of the batching motor. Tick the box to adjust the positive and negative direction. For the specific direction adjustment, please adjust according to the fabric track.

2) **P2/ P3:** 默认值/ **P2/P3:** Default

3) **P4:** 减少抖动。具体调节参数根据实际运行调节。

**P4:** Reduce jitters. For specific adjusted parameters, please adjust according to the actual operation.

## 2.12.5 电子齿轮 SET3 界面/Electronic Gear SET3 Interface

Read ID:	42	Read
1:	0	719
2:	0	514
3:	0	32767
4:	0	32767
5:	0	32767
6:	3592	2844
7:	1138	3235
8:	0	1567
9:	0	0

该页面用于显示电子齿轮部分反馈值

This page indicates the feedback value of the electronic gear.

首列显示值:

Displayed value in the first column:

- 1) 40: 卷布通道实际齿轮值。
- 2) 42: 卷布实时张力监控值。
- 3) 39: 软件版本号。

- 1) 40: Actual number of the gears in the batching channel
- 2) 42: Monitored tension value of batching in real time
- 3) 39: Version number of the software

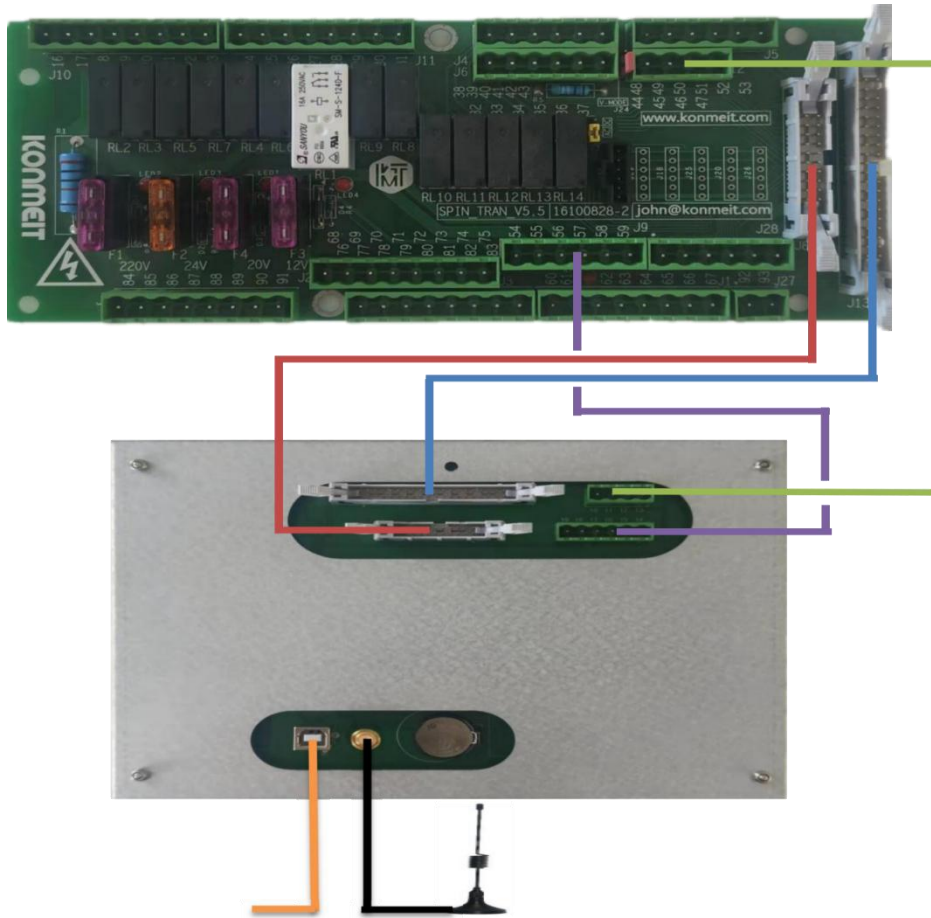
次列显示值:

Displayed value in the second column:







- 1) 表示当前通道电子齿轮值。

- 1) Indicates the number of electronic gears in current channel

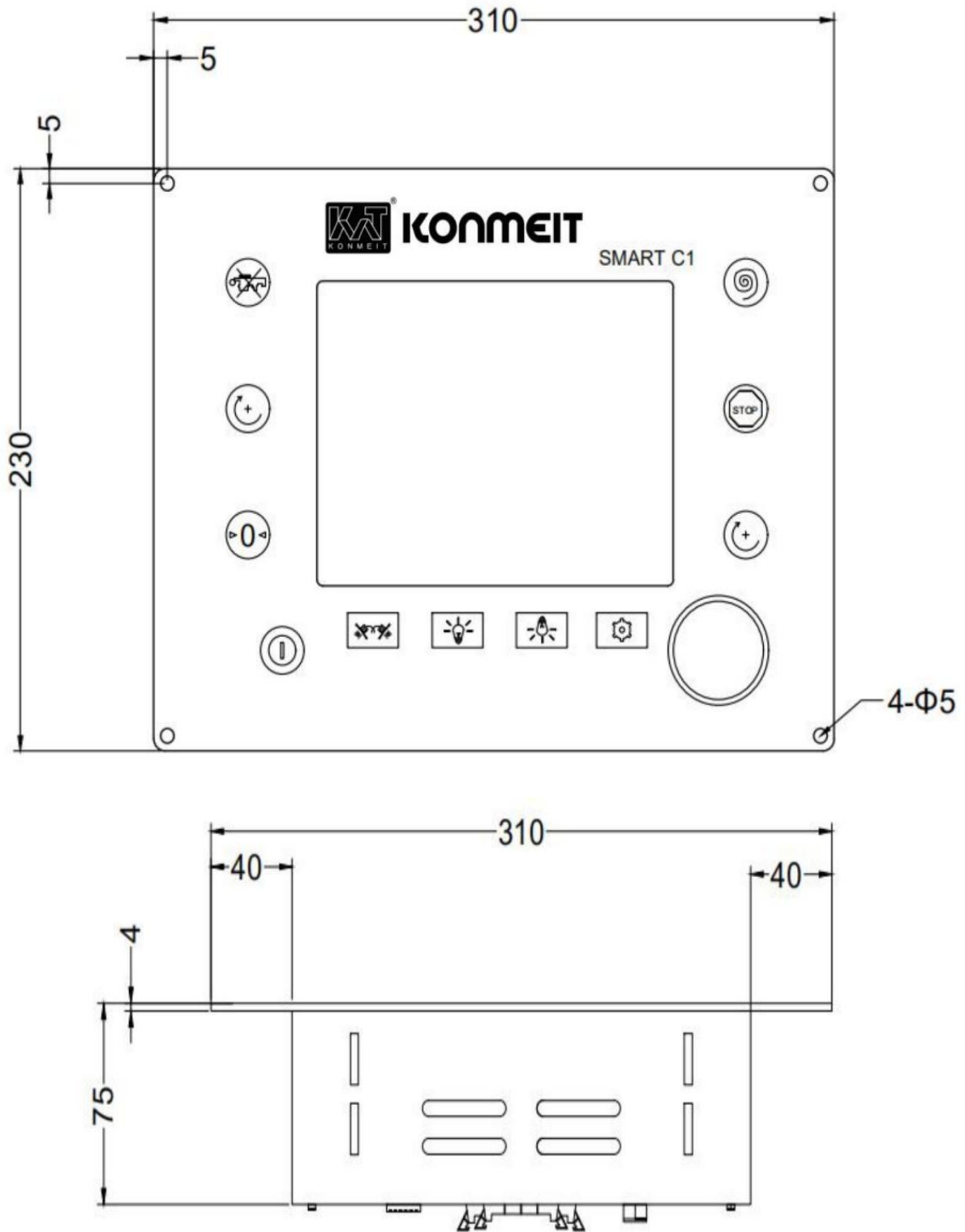
### 三 接线图/ Wiring Diagram



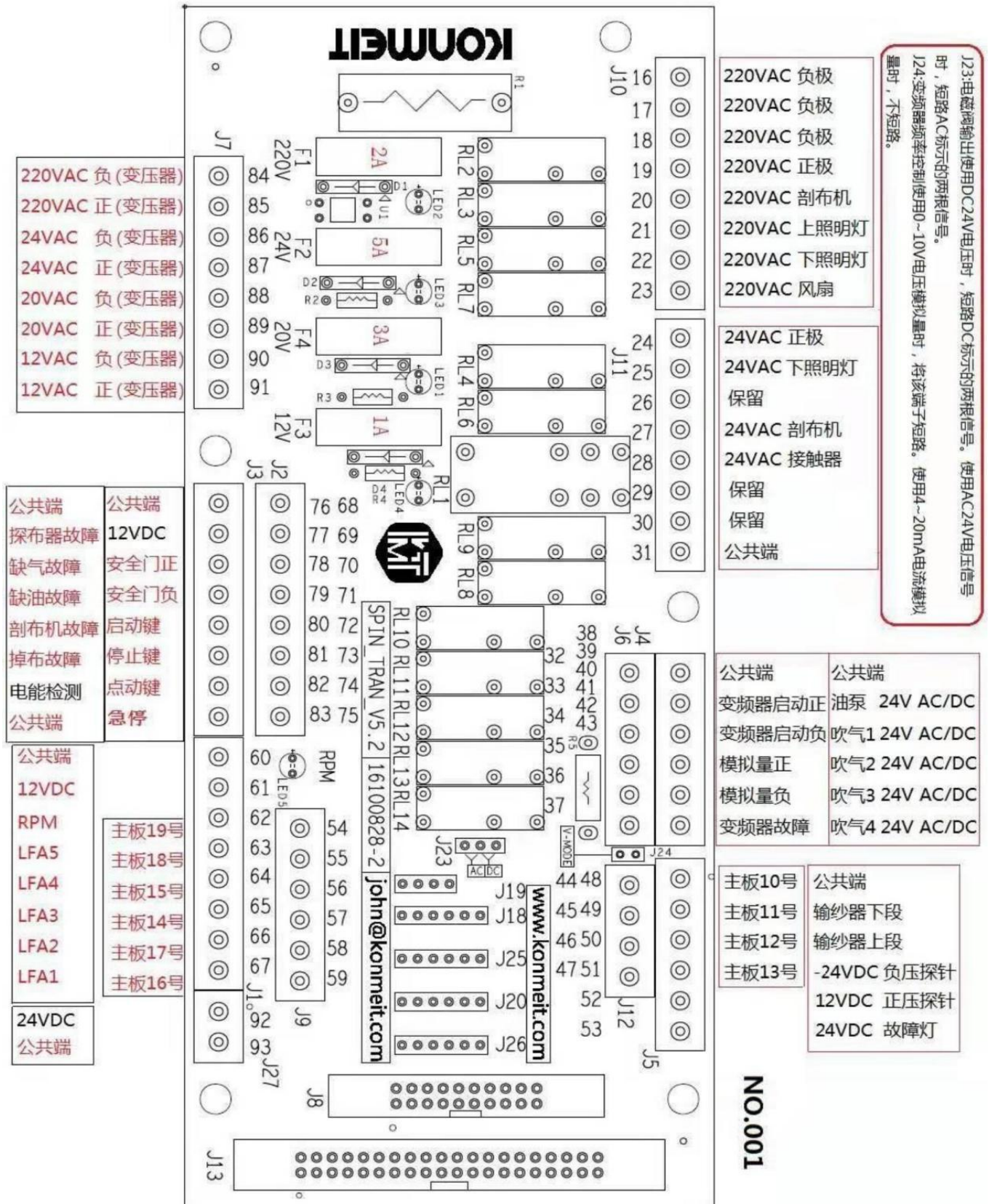
#### 3.1 接线线缆定义/ Definition of Wiring Cable

	蓝色 Blue	BU	屏信号传输线 Screen signal transmission line
	红色 Red	RD	屏信号传输线 Screen signal transmission line
	绿色 Green	GN	送纱器报警线 Yarn feeder alarm line
	紫色 Purple	VT	电源线 Power cable
	黄色 Yellow	YE	屏下载线 Screen download line
	黑色 Black	BK	屏信号天线 Screen signal antenna

### 四 安装尺寸/ Installation Size



## 五 接线板/Cable Connection Panel





# 故障代码

FAULT CODE

















机器编号: A0001 员工编号: B0001 2021-05-01 08:12:30

班别: D 当班转数: 12345 匹数: 5 单匹破洞: 1









控制/显示	内容
输纱器强制	图标
转速	快车 000 慢车 000
转数	已完成 00000 设定值 00000
RPM	000
运行	运行按钮
点动强制	图标
警告	警告图标: 到转
停止	STOP 按钮
纱长	L <sub>A1</sub> 10.05 L <sub>A2</sub> 10.05 L <sub>A3</sub> 10.05 L <sub>A4</sub> 10.05 L <sub>A5</sub> 10.05
点动	点动按钮
复位	0 按钮
风扇	风扇图标
上照明	上照明图标
下照明	下照明图标
设置	设置图标

故障显示 Fault Display	常见问题 Common Issues	处理方法 Treatment
 	1. 检查输纱器上的故障指示灯是否损坏不亮 1. Check whether the fault indicator on the yarn feeder is damaged and does not light up 2. 上下断纱的电线破皮接地 2. The wires of the upper and lower broken yarns are broken and grounded	1. 更换不亮损坏的输纱器 1. Replace the damaged yarn feeder that does not light up 2. 更换电线或修复破损电线处 2. Replace the wire or repair the damaged wire
 	1. 检查伺服驱动到转接板的连接线是否松动 1. Check whether the connecting wire from the servo drive to the adapter board is loosened 2. 检查伺服驱动控制箱是否有电源 2. Check whether the servo drive control box has access to power supply	1. 固定好连接线接头 1. Fasten the cable connector
 	1. 变频器故障 1. Inverter fault	1. 检查变频器 1. Check the inverter
 	1. 安全门的接近开关故障 1. The proximity switch of the safety door is faulty 2. 安全门的连接线松动或断开 2. The connecting wire of the safety door is loosened or disconnected	1. 更换近接开关 1. Replace the proximity switch 2. 固定好连接线，将断开的线连接好 2. Fasten the connecting wire and connect the disconnected wire
 	1. 急停按钮开关未松开 1. The emergency stop button switch is not loosened 2. 急停按钮连接线是否松脱 2. Whether the emergency stop button cable is loosen	1. 松开急停按钮 1. Loosen the emergency stop button 2. 锁紧松脱连接线 2. Tighten the loosened cable
 	1. 检查 77 号线是否接地或短路 1. Check whether line 77 is grounded or short-circuited	1. 排除接地或短路故障 1. Exclude grounding or short circuit faults
 	1. 运转速度超出最高限速 1. The operating speed exceeds the maximum speed limit	1. 修改限速速度值 1. Modify the speed limit value
 		1. 内部逻辑异常，请按下停止键尝试消除，若无法消除，请联系厂家处理 1. If the internal logic is abnormal, please try to eliminate by pressing the stop button. If it cannot be eliminated, please contact the manufacturer for processing.

	1. 检查探针是否复位 1. Check whether the probe is reset 2. 检查探针连接线是否接地 2. Check whether the probe connecting wire is grounded	1. 复位探针 1. Reset the probe 2. 修复探针连接线破皮接地位置或更换电线 2. Repair the broken and grounded position of the probe connecting wire or replace the wire
		
	1. 没有气压 1. No air pressure 2. 检查 78 号线是否接地 2. Check whether line 78 is grounded 3. 气压开关故障 3. Air pressure switch is faulty	1. 供气 1. Air supply 2. 修复 78 号线路破损及接地处或更换电线 2. Repair the damaged and grounded part of line 78 or replace the wire 3. 更换气压开关 3. Replace the air pressure switch
		
	1. 喷油机无油 1. There is no oil in the fuel injector 2. 检查 79 号线路破损接地 2. Check whether the line 79 line is damaged and grounded	1. 加油 1. Refuel 2. 修复 79 号线路破损接地处或更换电线 2. Repair the damaged and grounded part of line 79 or replace the wire
		
	1. 剖布机不正常工作 1. The cutter is not working normally 2. 检查剖布下面微动开关被布压住 2. Check whether the micro switch under the cutter is pressed by the fabric 3. 检查 80 号线路破损接地 3. Check whether the line 80 is damaged and grounded 4. 微动开关损坏 4. The micro switch is damaged	1. 更换剖布机 1. Replace the cutter 2. 挪开压住的布 2. Remove the pressed fabric 3. 修复 80 号线路破损接地处 3. Repair the damaged and grounded part of line 80 4. 更换微动开关 4. Replace the micro switch
	1. 三叉上的限位开关不在正常的位置 1. The limit switch on the three prongs is not in the normal position 2. 81 号线路破皮接地 2. Line 81 is damaged and grounded	1. 调整限位开关的正常位置 1. Adjust the limit switch to the normal position 2. 修复 81 号线路破损接地处 2. Repair the damaged and grounded part of line 81
		
	1. 未设定转数 1. Not reach preset revolutions; 2. 已经到达设定转数 2. Reaches setting revolutions;	1. 如果是未设定转数，设定好转数 1. If you haven't set revolution, then set revolutions 2. 如果已达到设定转数按面板 '0' 复位 2. If it has reached the preset revolution on the panel, then press reset button.

	1. 伺服驱动到转接板的连接线松动 1. The connecting line from the servo drive to the adapter board is loosened	1. 固定好连接线接头 1. Fix the connector of the cable
	2. 伺服驱动控制箱没有电源 2. The servo drive control box has no access to power supply  3. 伺服驱动器通讯线没连接 3. The communication line of the servo drive is not connected	2. 检查 220V 驱动器供电电源 2. Check the power supply of the 220V driver  3. 检查并确定通讯线接头牢固无松动 3. Check and make sure that the connector of the communication cable is fastened and not loosened
	1. 到达设定的换班时间 1. Reach the set time of shift switch	1. 按停止键解除 1. Press the stop button to cancel
		2. 若无需使用该功能, 可在<系统设置>页面中将<转班停机>功能关闭 2. If you do not need to use this function, you can turn off the function <stop for shift switch> in the <system setting> page
		1. 内部逻辑异常, 请联系厂家处理 1. If the internal logic is abnormal, please contact the manufacturer for processing
	 1. 转接板 F1 保险丝烧断 1. The F1 fuse of the adapter board is blown  2. 检查风扇及照明灯是否故障 2. Check whether the fan and lighting are faulty	1. 更换保险丝 1. Replace the fuse  2. 更换 220V 灯及风扇 2. Replace the 220V lamp and fan
		3. 若 F1 保险丝显示正常, 请检查面板与转接板排线连接是否异常 3. If the F1 fuse is displayed normally, please check whether the connection between the panel and the adapter board is abnormal
		1. 内部逻辑异常, 请联系厂家处理 1. If the internal logic is abnormal, please contact the manufacturer for processing
	1. 变频器所设定的频率给定方式与转接板的频率转换开关以及面板的给定方式不一致 1. The frequency setting method set by the inverter is inconsistent with the frequency switching switch of the adapter board and the given method of the panel.	1. 转接板转换开关置于 on 时, 面板的变频器页面里的电压选项打钩, 对应变频器模拟量输入为电压给定, 反之为电流给定 1. When the switch of the adapter board is turned on, the voltage option in the inverter page of the panel is ticked. The analog input of the corresponding inverter is the given voltage, otherwise it is the given current.
	2. 面板与转接板排线松动导致接触不良 2. The panel and the adapter board are loose, resulting in poor contact.	2. 确认排线接触良好 2. Make sure the cables are in good contact.
	3. 转接板 35/36 接线与变频器连接断开 3. The connection between the line 35/36 adapter board and the inverter is disconnected	3. 确认 35/36 端子到变频器之间的接线良好 3. Confirm that the connection between terminals 35/36 and the inverter is good
	1. 刷卡时读取卡号异常 1. Card number reading abnormal	1. 按下<停止键>可尝试复位 1. Press <Stop> button to reset

 	1. 转接板 F2 保险丝烧断 1. F2 fuse of the adapter board is blown 2. 电磁阀故障 2. Solenoid valve fault 3. 24V 照布灯故障短路 2. Fault and short circuit of 24V lighting 4. 转接板到面板的 6P 连接线松动接触不良 4. The 6P connecting wire from the adapter board to the panel is loose with poor contact 5. 24V 剖布机故障短路 5. Fault and short circuit of 24V cutter 6. 24V 接触器线圈短路 6. Short circuit of the coil of 24V contactor	1. 更换保险丝 1. Replace the fuse 2. 更换短路电磁阀 2. Replace the short-circuit solenoid valve 3. 更换照布灯排除短路 3. Replace the lighting lamp to eliminate short circuit 4. 固定好转接板到面板的连接线 4. Fasten the connecting wire of adapter to the panel 5. 更换剖布机 5. Replace the cutter 6. 更换接触器短路线圈 6. Replace the short-circuit coil of the contactor
 	1. 转接板 F4 保险丝烧断 1. The F4 fuse of the adapter board is blown 2. 检查输纱器的电源电压是否正确 2. Check whether the power supply voltage of the yarn feeder is correct 3. 转接板到面板的连接线松动接触不良 3. The connecting wire between the adapter board and the panel is loose with poor contact	1. 更换保险丝 1. Replace the fuse 2. 如果输纱器电压是 12V，对应必须接在变压器出线端口 10V 的位置。如果输纱器电压是 24V，则对应必须接在变压器出线端 20V 的端口 2. If the voltage of the yarn feeder is 12V, it must be connected to the 10V position of the outlet port of the transformer. If the yarn feeder voltage is 24V, it must be connected to the 20V port of the outlet port of the transformer. 3. 固定好转接板到面板的连接线 3. Fasten the connecting wire between the adapter board and the panel
 	1. 编码器故障 1. Encoder fault 2. 编码器连接线接头松动 2. The connector of the encoder cable is loose 3. J30 插座连接线松动 3. The J30 socket cable is loose	1. 更换编码器 1. Replace the encoder 2. 固定好接头 2. Fasten the connector 3. 确认接线良好 3. Make sure the wiring is good
  	1. 61/69/92 号端子所连接外设过载或对地短路，如三线金属感应器（转数感应开关、安全门感应开关等） 1. The peripherals connected to terminals 61/69/92 are overloaded or short-circuited to ground, such as three-wire metal sensors (revolution sensor switch, safety door sensor switch, etc.) 2. 三线纱长传感器供电端子对地短路 2. Three-wire yarn length sensor power supply terminal is short-circuited to ground 3. 三线纱长传感器接线错误 3. Three-wire yarn length sensor wiring error 4. 转接板上的电磁阀 AC/DC 选项错误 4. Solenoid valve AC/DC option on the adapter board is wrong	1. 按 STOP 键看能不能清除故障，如果不可以就从下面几方面判断故障来源。 1. Confirm that the wiring is correct, and replace the three-wire proximity switch. 2. 确认接线正确，更换三线近接开关 2. Eliminate the short-circuit power supply terminal 3. 排除短路供电端子 3. Exclude short-circuited power supply terminals 4. 更正连接线 4. Correct the wiring. 5. 若电磁阀是 AC 电源，对应转接板转换应在 AC 位置，反之应在 DC 位置 5. If the solenoid valve is AC power supply, the corresponding adapter board should be in the AC position,

		otherwise it should be in the DC position
 		<p>1. 内部逻辑异常，请联系厂家处理</p> <p>1. If the internal logic is abnormal, please contact the manufacturer for processing</p>
 		<p>1. 按复位键 ‘0’ 复位</p> <p>1. Press the reset button ‘O’ to reset</p>
 	<p>1. 超出设定的纱长范围值，检查确认，按下停止键解除</p> <p>1. Exceed the scope of the set yarn length, check to confirm, press the stop button to cancel</p>	<p>1. 若不需要该功能，请在&lt;测纱器&gt;页面将报警使能选项关闭</p> <p>1. If you don't need this function, please turn off the alarm enable option on the &lt;yarn gauge&gt; page</p>
 	<p>1. 停止按钮自锁或按钮触头没弹开</p> <p>1. The stop button is self-locking or the button contact does not pop up</p>	<p>1. 放开自锁按钮或更换不能复位的开关</p> <p>1. Release the self-locking button or replace the switch that cannot be reset</p>