SiRUBA

使用説明書

INSTRUCTIONS BOOK

ACS200

危險水準的說明
Explanation of Dangerous Level

 危險 Dangerous	如果忽視此標記而運行了錯誤的機械操作，保養時肯定會引起當事者或第三者人員重傷或死亡。 Don't ignore the warning sign and don’t proceed incorrect operation. Or it will cause the person or the third party seriously injured or dead during maintenance.
 注意 Caution	如果忽視此標記而運行了錯誤的機械操作，保養時有可能會引起當事者或第三者人員受傷及造成設備損壞。 Ignoring this warning sign and proceed incorrect operation will cause the person involved or the third party wounded and equipment damaged during maintenance.

警告圖案表示及表示標誌的說明
Explanation of Warning Signs and Labels

警告圖案表示 Warning Sign		運動部位，謹防工傷事故 Moving part, beware of industrial accident
		高壓部位，謹防觸電事故 High voltage, beware of electric shock
		高溫部位，謹防燙傷事故 High temperature, beware of burns
指示標幟 Instruction Label		禁止 Prohibited
		地線的接線表示 Indication of ground wiring

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一般安全事項說明

GENERAL SAFETY INSTRUCTIONS

警告！

當使用這台機器，基本安全預防應恆被遵守，以減輕火災、電擊、或是個人傷害的風險。包含以下注意事項。

在操作這台機器之前，請閱讀所有說明並且緊記於心。

1. 保持工作場所清潔
   雜亂的環境與椅子會招引危害。

2. 考量工作場所環境
   勿暴露電源於雨水之中、勿在溼氣重的地方或潮濕的場所使用機械器具。保持工作場所良好整齊。當有引發火災或爆炸危險時，勿使用電源工具。

3. 免於電擊危害
   避免身體接觸地線或是接地表面。(即：管線，發熱物體，以及冷凍庫)

4. 勿使孩童接近
   不要讓訪客接觸工具或是延伸管線。

5. 適當的穿著
   不要穿著寬鬆衣物或是穿戴珠寶，這可能被活動零件拉扯而導致危險。穿戴護髮套可包住長髮。

6. 不要任意拉扯電線
   絕不要用電源端拉扯機器，或是從插座猛拉電線來拔掉電線。使電線遠離熱源、油類或是尖銳邊緣。

7. 謹慎保養機器
   遵從指示來添加潤滑油或是更換附件。定期檢測工具用線，如果有所損害，請使用合格的維修器具來修復。

Warning!

When using this machine, basic safety Precautions should always be followed to reduce the risk of fire, electric shock and personal injury, including the followings. Read all these instructions before operating this product and save these instructions.

1. **Keep work area clean**
   Cluttered areas and benches invite injuries.
2. **Consider work area environment**
   Do not expose power to rain. Do not use machine tools in damp or wet locations. Keep work area well lit.
   Do not use power tools where there is risk to cause any fire or explosion.
3. **Guard against electric shock**
   Avoid body contact with earthed or grounded surfaces (e.g. Pipes, radiators, ranges refrigerators.)
4. **Keep children away**
   Do not let visitors touch the tool or extension code.
5. **Dress properly**
   Do not wear loose clothing or jewelry, they can be caugh in moving parts. Wear protecting hair covering to contain long hair.
6. **Do not abuse the cord**
   Never carry the machine by cord or yank it to disconnect it from the socket. Keep the cord away from heat, oil, and sharp edges..
7. **Maintain machine with care**
   Follow instructions for lubrication and changing accessories. Inspect tool cord periodically. If damaged, have it repaired by an authorized service facility.

8. 中斷機器電源
當不使用機器時、維修前、以及更換配件時。

9. 避免誤啟動
不要以手指置於啟動開關上之後，搬運一個已插入電源的工具。確定在插電之前，電源開關是關閉的。

10. 檢查損害零件
在進一步使用器具之前，應該小心檢查並確認損傷的零件或是穿戴保護器具來確認零件會正確運轉並且呈現應有功能。

11. 警告
除了在這本使用說明手冊中建議的功能之外，任何附件或是配件的使用，都可能會導致個人傷害的危險。

12. 由合格人員來修理器具
所以修理工作應由合格的人員使用原始個別零件來作修理。

連接電源的特別警示！

1. 只可與有 "CE" 認證的按壓啟動裝置連接這台機器。
2. 遵守此使用說明手冊來安裝控制裝置。
3. 在操作過程中，永遠保持機器適當的接地。
4. 在調整、更換零件、或是維修保養之前，必須確定將插頭由插座拔出，以預防任何機器意料之外的啟動而造成危害。

8. Disconnect machine
When not in use, before servicing and when changing accessories.

9. Avoid unintentional starting
Do not carry a plug-in tool with a finger on the switch. Ensure the power switch is off when plugging in.

10. Check damaged parts
Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function.

11. Warning
The use of any accessory or attachment, other than those recommended in this instruction manual, may present a risk of personal injury.

12. Have your tool repaired by a qualified person
Repairs should only be carried out by qualified persons using original spare parts.

SPECIAL WARNING FOR ELECTRIC CONNECTION!

1. Incorporate this machine only with "CE" certificate hold-to-run control device.
2. Follow the instruction manual device to install control device.
3. Always earth machine appropriately during operation.
4. Before adjustment, parts change or servicing must be sure to pull out the plug from socket to prevent the hazard of unintentionally start of machine.

重要安全事項說明

恭喜您購買本機器，為了使這台機器能獲得最佳功能以及安全的操作，務必請正確的使用這台機器，使用前請仔細閱讀使用說明書，希望您能長期使用它。請記得將此說明書放在容易取得的地方。

1. 當您使用機器時，除了以下事項外，請注意其他基本安全措施。
2. 使用機器前，除了本使用說明書外，請詳細閱讀其他相關說明書。此外，請妥善保存此說明書，以便需要時可以隨時取閱。
3. 先確認機器是符合貴國安全規定及標準後，再使用機器。
4. 當機器完成操作時，所有安全配備必須安裝就緒，在缺少所述安全配備下操作是不被允許的，以免導致人員受傷。
5. 此機器應由受過適當訓練之操作員操作。
6. 為了安全，我們建議您配戴安全眼鏡。
7. 以下情形，請先關閉電源或拔掉插頭 :
   (1) 穿針線、導線片、天平等以及更換梭子時。
   (2) 更換針、壓具、針板、送具、頂針片、車布導板，以及其他附屬配件時。
   (3) 維修工作時。
   (4) 離開工作場所或工作場所無人看顧時。

IMPORTANT SAFETY INSTRUCTIONS

For operating safely and getting the best functions of this machine, you must operate it correctly. Please read and follow the instructions of this manual, and keep it at hand for future references. We are confident that you will enjoy this machine as much as we enjoy manufacturing it.

1. Instead of the following instructions, when you use this machine, please pay attention to the basic safety measures.
2. Before using this machine, please read this manual and all related instructions. In addition, please keep this manual for future needs.
3. Before using this machine, please ascertain that it conforms with safety standards and regulations of your country.
4. When the machine is ready for operation, all the safety equipments must be ready. Operate this machine without the specified safety devices is not allowed.
5. This machine must be operated by a properly trained operator.
6. For your own safety, we suggest you wearing goggles.
7. Please turn off the power switch or disconnect it for any one of the circumstances of the followings:
   (1) When threading needle(s), adjusting thread Take-up(s), thread guide(s), and/or replacing bobbin(s).
   (2) When replacing needles, presser feet, needle plates, feed dogs, needle guards, cloth guides and other parts or accessories.
   (3) When repairing.
   (4) When the operator leaves the working place or leaves the machine

(5) 若使用離合器馬達而無煞車片裝置時，必須待馬達完全停止。

8. 假如不慎讓機器及配件使用之油或油脂，接觸到眼睛、皮膚或誤食時，請立刻以水清洗接觸部位及就診。

9. 請勿擅自碰觸運轉中之零件或配件及注意機器電源是否已開啟，以免導致人員受傷。

10. 維修、修改及調整等工作，須由受過適當訓練的技師或熟手為之。維修時只許使用指定之零件。

11. 一般維修及檢查工作必須由受過適當訓練的人員為之。

12. 電子零件維修及保養工作必須由資深的電子技師為之，或由非常熟練的人員檢查及指導，當發現零件損壞時，請立刻停止機器運轉。

13. 在做裝有氣動式零件 (例如氣缸) 機器的維修及保養工作前，機器連接空壓機及高壓空氣必須予以關閉及卸除，機器中殘存高壓氣體必須予以消除，此外調整及性能檢查只能由受過適當訓練的技師或熟手為之。

14. 機器使用一段時間，必須定期清理。

unattended.

(5)If clutch motors without brake pads are used,must wait until the motor stops completely.

8. If grease, oil, or any fluid contacts your skin or eyes by any chance, please wash the contacted area completely with clean water and consult a doctor. Or, swallow a ny fluid mistakenly,consult a doctor immediately.

9. Do not touch any functioning parts and devices. Always attend to whether power switch is on or off before operating in order to prevent anyone from getting hurts.

10. Qualified technicians are required for adjustment, modification, and repair. Only use assigned parts for replacement.

11. Routine maintenance and service must be performed by well trained persons, or qualified technicians.

12. Maintain and check the electronic parts must be done by qualified electrician or well-trained persons. If any electronic part damaged or malfunctioned, stop the machine immediately.

13. The air house has to be detached from the machine and the compressor or air supply has to be cut off before repairing and servicing the machine equipped with pneumatic parts such as an air cylinder. Qualified technicians or well-trained persons are required for adjustment and repairs.

14. To ensure the best performance, periodically clean the machine is necessary.

15. 為使機器能正常操作以及減少噪音，機台務必平放地上，機器避免在強烈噪音的環境下操作。

16. 選用適當的電源插頭，並由電子技師將其安裝在機器上，且插頭必須插在接地線之插座上。

17. 機器只允許被使用於指定用途上，其他用途是不允許的。

18. 修改或變更機器必須依照安全規定及標準，同時採取有效的安全措施或變更機器所引起損壞之責。

19. 警告提示以兩種符號標示：

(1) 對操作員或服務人員之傷害危險，也為了避免觸電之危險，請勿打開馬達電器箱之外蓋，也不要觸摸電器箱裡面之零件。

(2) 必須特別注意事項

a. 絕對不可在移動外蓋，手指保護蓋或安全配件後，進行機器操作，以免導致人員受傷。

b. 為了避免被機器纏住，當機器運轉中，您的手、頭髮及衣服，需遠離手輪；此外這些部位周圍不可放置任何物品，以免導致人員受傷。

15. In order to operate properly and to reduce the noise, please place the machine flat and level on the ground. Avoid operating the sewing machine at a noisy surrounding.

16. Select a proper power plug and install it by an electrician. Please connect the power plug to a grounded receptacle.

17. This machine can only be used for the designed purpose. Other uses of this machine are not allowed.

18. Any modification or conversion made on this machine must be conformed with the safety standards and regulations. Precaution is necessary. No responsibility will our company take for damages caused by any modification or conversion of this machine without permission.

19. Two safety warning signs are applied as warning signs:

(1) For the safety of operators and service persons, please don't open the cover of any electronic control boxes of motor or other devices and don't touch any components inside to avoid electrical shock hazards.

(2) Always keep in mind:

a. Please never operate this machine without outer cover, finger guard or any safety device to avoid physical injury.

b. Please keep your hair, fingers and clothes away from the hand wheel while the machine is in operation, as well as never put anything near these parts, to prevent the risk of injuries by tangled into them.


c. 當您打開電源開關後或機器已 在運轉中，絕不可將您的手放在針的下方或針線控線桿外蓋中，以免導致人員受傷。


d. 當機器運轉中，梭頭高速轉動，為了避免對手可能引起之 傷害，必須確定您的手保持遠離梭頭附近。此外，當更換梭子時，確定電源開關已關閉，以免導致人員受傷。


e. 當放置或抬起機器時，小心勿將手置於機器中，以免導致人員受傷。


f. 為了避免機器突然啟動而引起可能意外，當機頭傾斜時，請關掉機器電源，以免導致人員受傷。


g. 如果您的機器是配置伺服馬達，機器於靜止狀態時，馬達是不會產生噪音的，為了避免機器突然啟動而引起可能意外，故請關掉機器電源。


h. 為了避免觸電之危險，請絕不要在移開電源接地線後操作機器。


i. 為了避免觸電或電子零件損壞而引起之可能意外，請先切斷電源，再插上或拔掉插頭。


c. Please never put your fingers under the needle(s) or in the thread take-up cover to prevent physical injuries when you turn on the power switch or operate the machine.


d. While the machine is in operation, the hook rotates at a high speed. Please keep your hands away from the area of hook to prevent any potential injury to your hands. In addition, please make sure to turn off the power of the machine while changing bobbins.


e. Be careful and do not place your fingers inside the machine when placing or lifting the machine head to avoid possible physical injuries.


f. Please turn off the power before tilting the machine head to avoid possible accidents due to abrupt start of this machine.


g. For machine equipped servo motors, the motors do not produce noise while the machines are at rest. Therefore, please turn off the power of this accidents due to abrupt start of the machine.


h. Never operate the sewing machine after the ground wire is removed to avoid electrical shock hazards.


i. Please turn the power switch off before connecting or disconnecting the power plug to prevent possible accidents due to electric shock or damaged electronic components.

特別事項

為了避免機器故障及損壞，請先確定以下事項：

1. 當您安裝好機器後，做第一次機器操作前，請徹底清潔機器。
2. 清除運送途中累積之灰塵及溢出之油脂。
3. 確定電壓及馬達相數（單相或三相）安裝正確。
4. 確定電源插頭正確地接上電源。
5. 當使用電壓與標示電壓不同時，請勿使用機器。
6. 確定機器轉動方向是否正確。

警告：
在操作或調整本書中所提到之各步驟前，請先將電源關掉，以免因為機器突然啟動造成之意外。

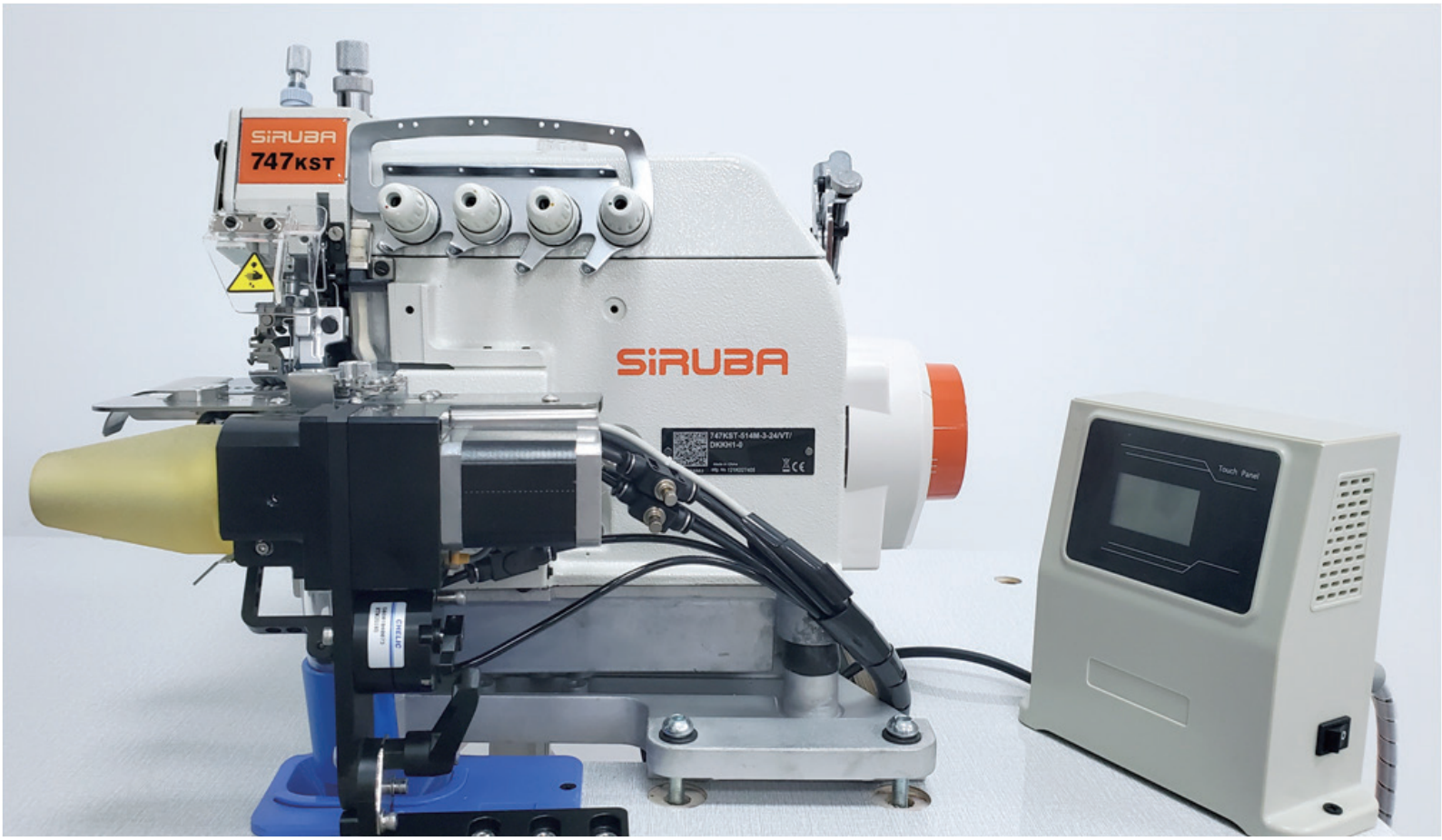
WARNING

Please confirm the followings to avoid malfunction or damage to this machine.

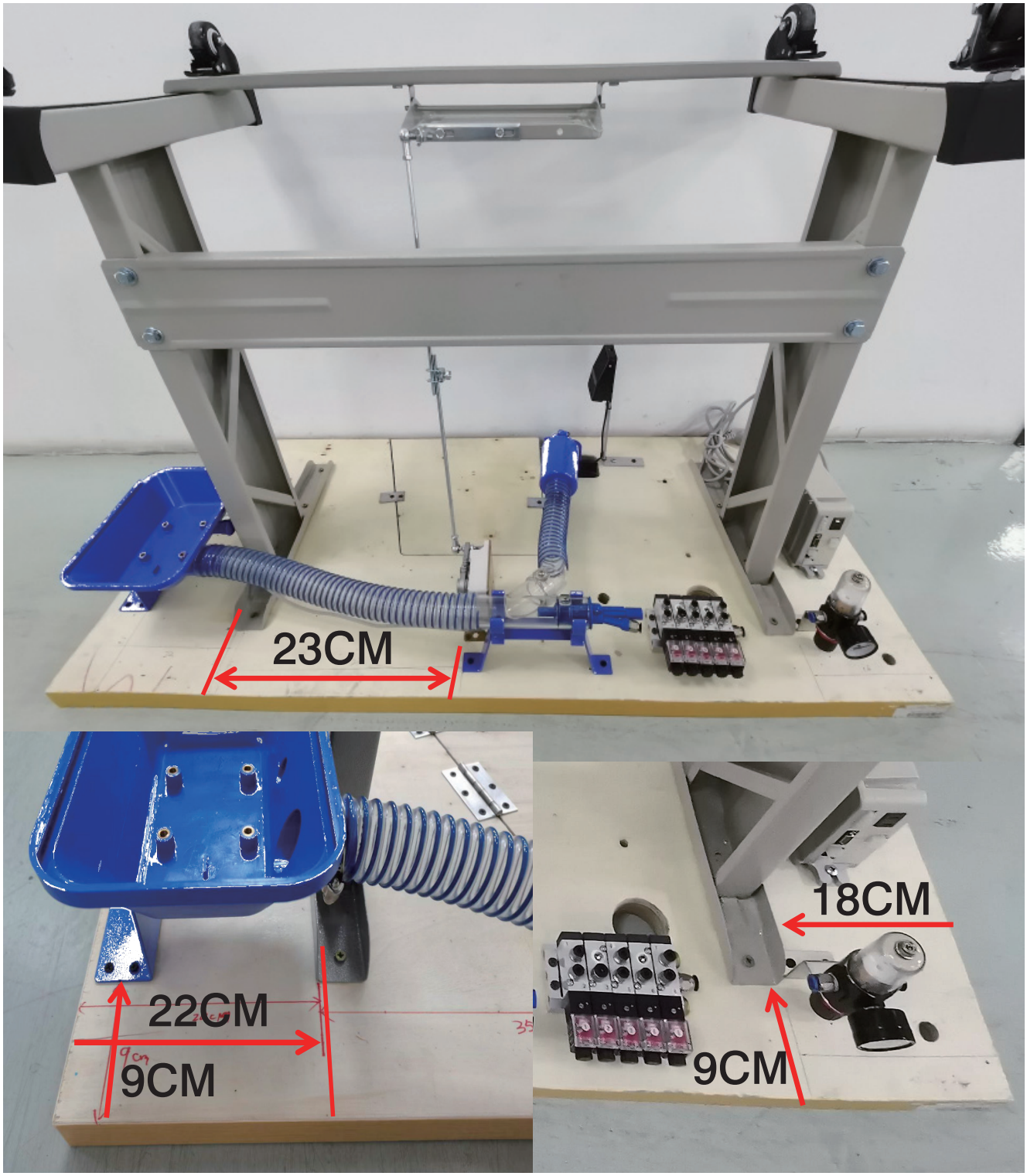
1. After installing the machine, and before the first operation, please clean it completely.
2. Clean all dust and overflowed oil during transportation.
3. Confirm that the voltage and the phase (single or 3 phase) of motor are set correctly.
4. Confirm that the power plug is correctly connected to the power supply.
5. Never use the machine when the local voltage type is different from the marked voltage on the nametag attached on the machine.
6. Confirm that the rotating direction of the machine pulley is correct.

Warning:
Before doing any operation or any adjustment described later in this manual, please turn the power off to prevent accidents caused by abrupt start of the sewing machine.

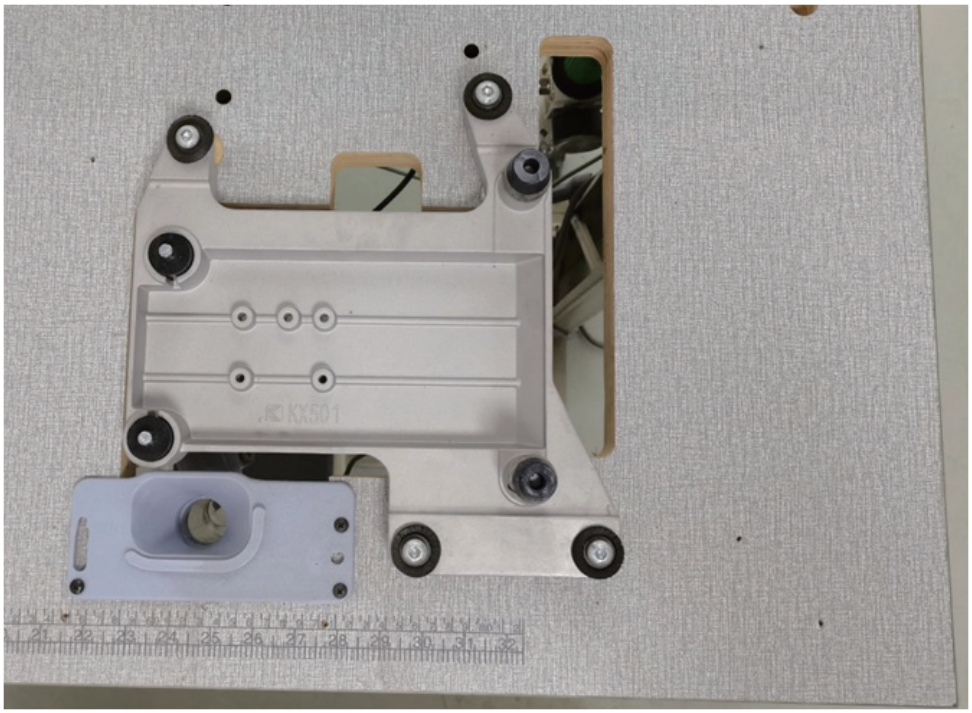
GS-ACS-200 series
自 動 圓 領 裝 置 安 裝 說 明



1、安裝腳架，集塵組，調壓閥，電磁閥，電機電控，速控器

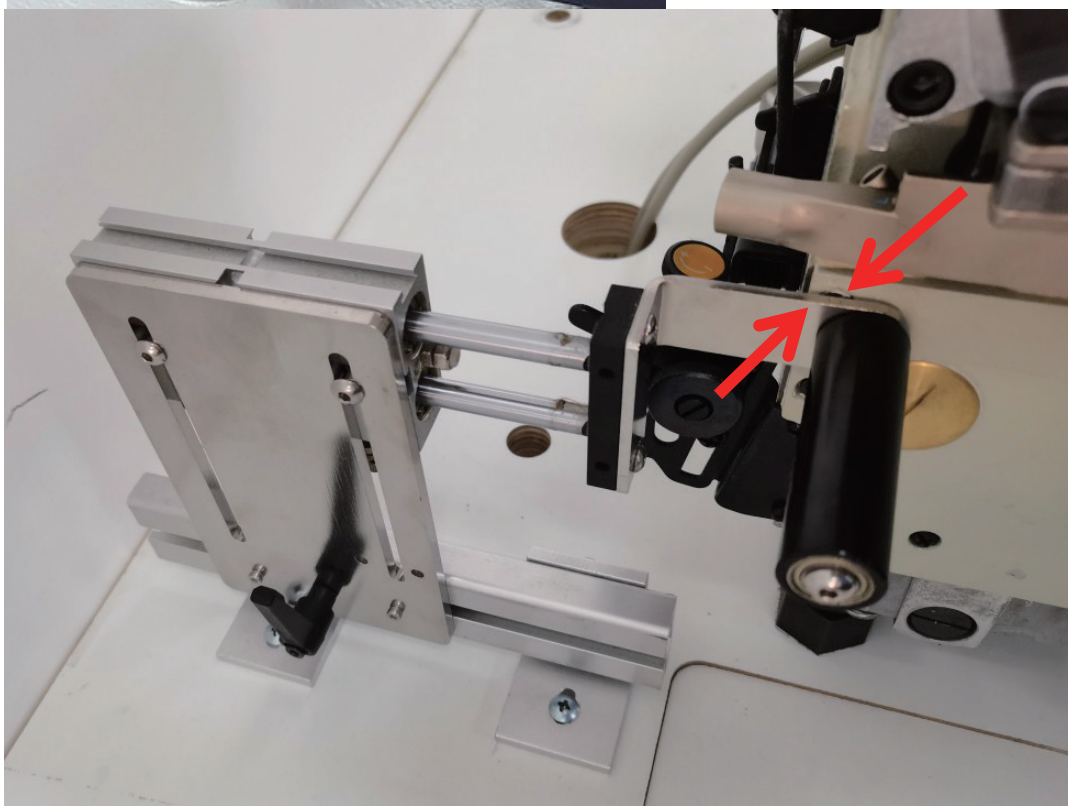


2、安裝漏斗，墊塊，防震膠，車頭

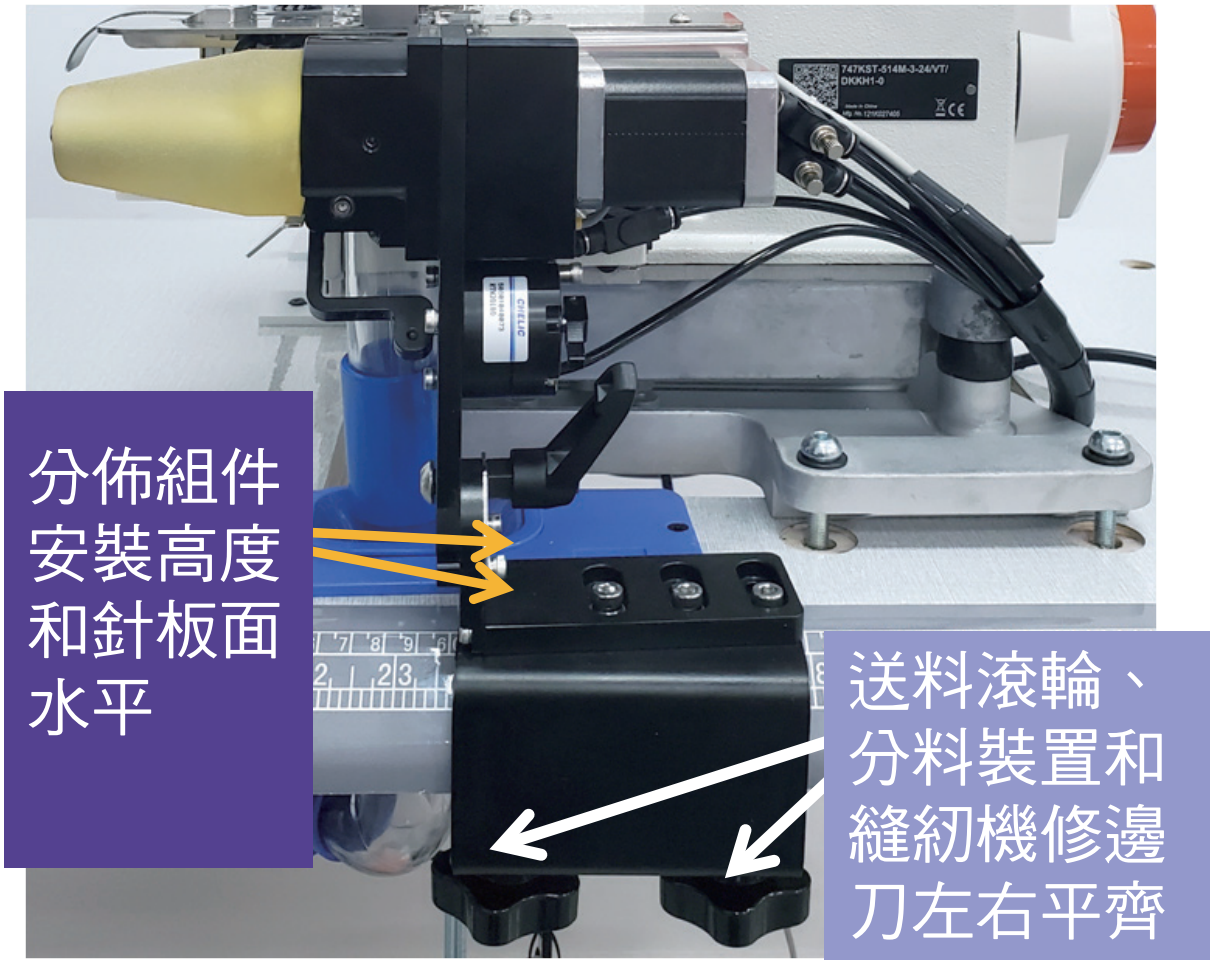


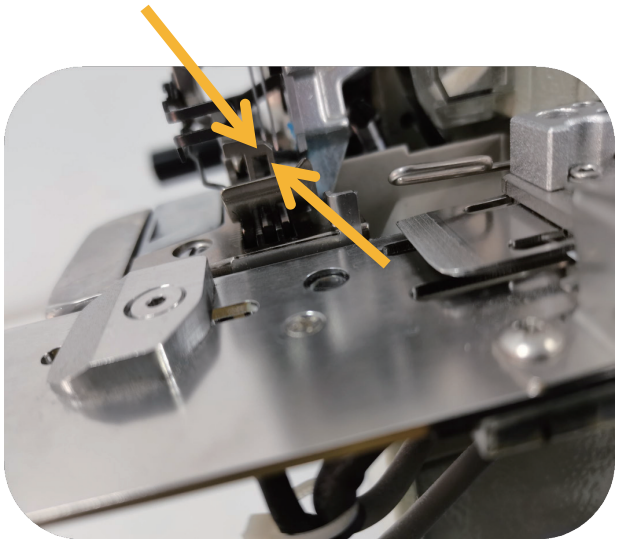
油盤安裝

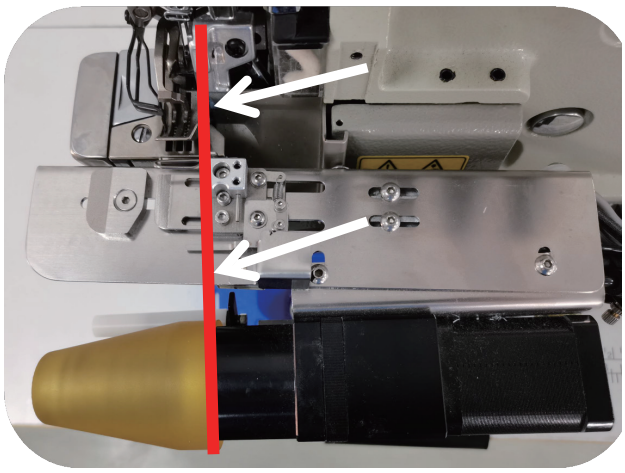
3、安裝抬壓腳氣缸，後滾輪組



4、安裝送料滾輪組


747KST-514M-3-24/VT/
DIKKH1-0
分佈組件
安裝高度
和針板面
水平
送料滾輪、
分料裝置和
縫紉機修邊
刀左右平齊

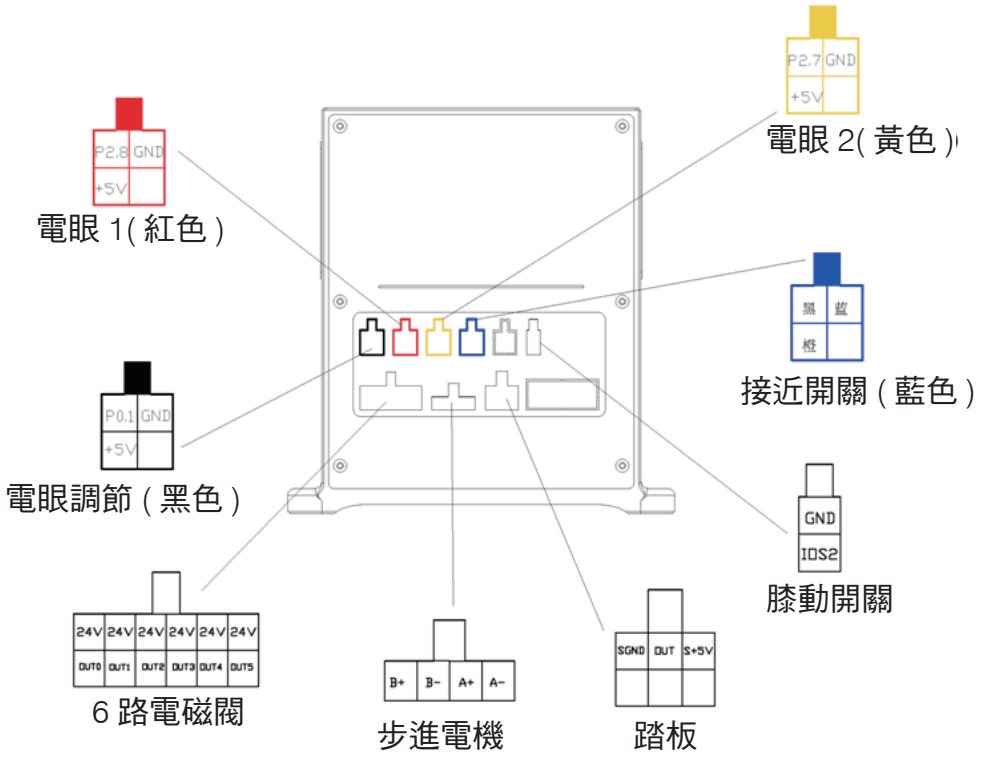




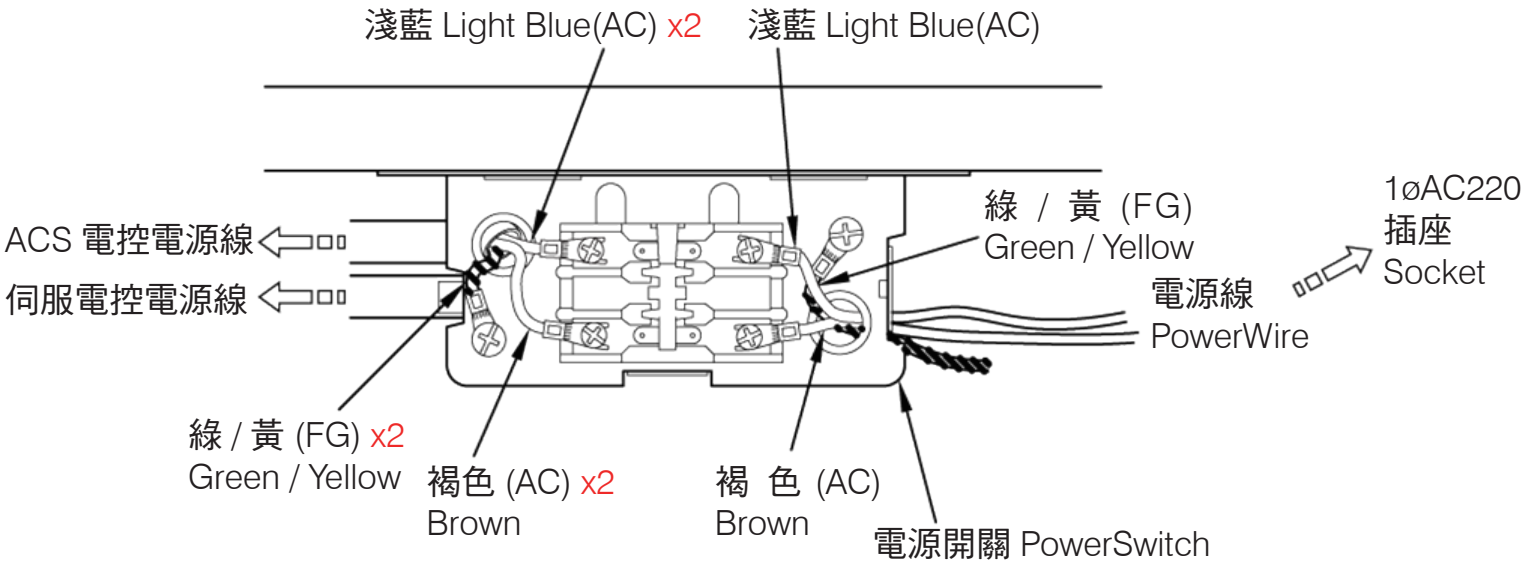
5、安裝圓領裝置顯示幕一體電控

速控器專用連接線插線方法

6、顯示幕插座信號指示
主機殼端子圖



7、AC 220V 接線方式



8、觸控面板圓領裝置操作說明

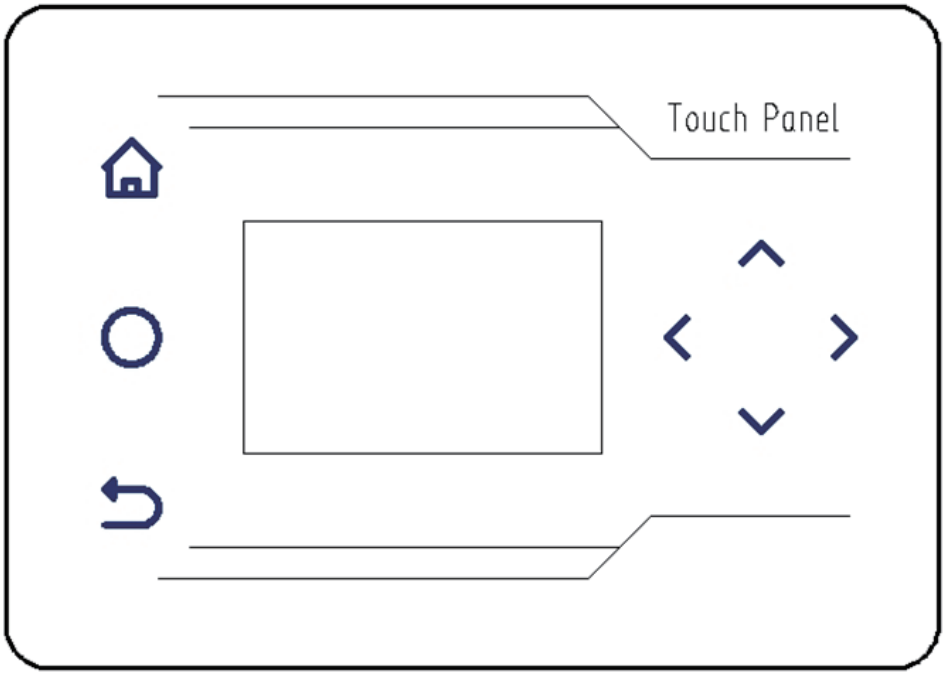


圖 1

一、按鍵使用說明

1. 功能表鍵，長按 3 秒進入系統參數修改選項。
2. 補償鍵，僅在自動狀態使用。
3. 返回鍵，退出參數修改頁面，返回工作頁面，並保存資料。
4. 左右移動鍵，在更改工程參數的介面下，移動參數修改浮標。
5. 加減鍵，更改各項功能的參數大小。

二、工作模式下，左移右移鍵的作用

按下 鍵後，自動保存並退出更改參數介面，鎖定所有工作狀態。

1. 按下 左鍵，顯示上一個工程值的資料。
2. 按下 右鍵，顯示下一個工程值的資料。

三、顯示窗內容說明：

圖 2

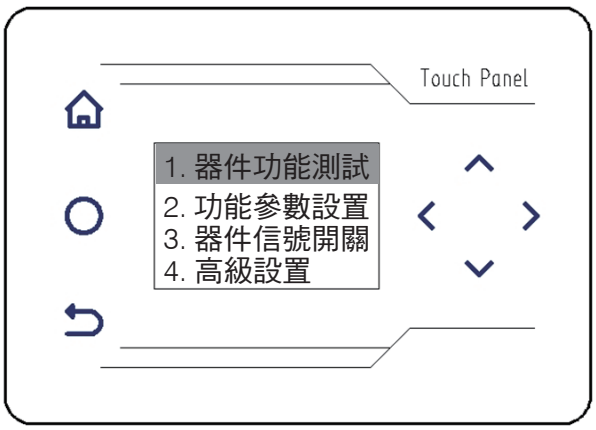


圖 3

工作狀態顯示：

圓領系統裝置開機後預設顯示（圖 2），按隱藏 加減鍵，更改自動模式或手動模式。

參數功能設置顯示介面：

長按 鍵 3 秒可進入參數設置介面（圖 3）：

1. 器件功能測試。
2. 功能參數測試。
3. 器件信號開關。
4. 高級設置。

四、介面操作說明

(一)、器件功能測試：

長按 鍵 3 秒進入系統參數設置介面，按 、 加減鍵，選中“器件功能測試”，按下 右鍵，進入子功能表介面（圖 4）：

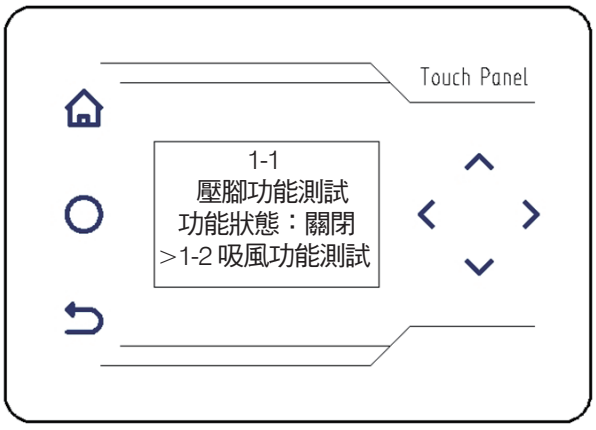


圖 4

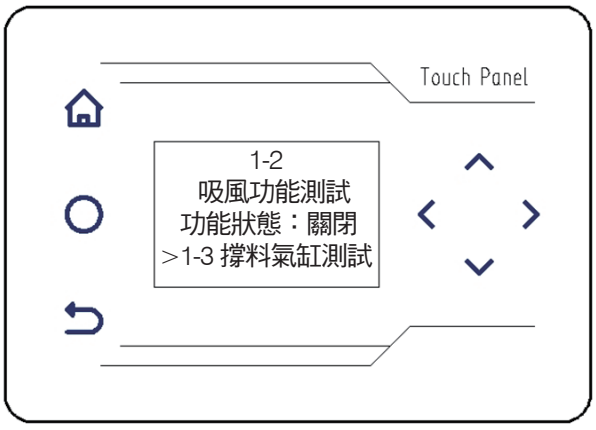


圖 5

各個器件的功能測試，功能狀態預設為“關閉”，如“圖 4”所示（“壓腳功能測試”），測試時，長按鍵 3 秒，功能狀態由“關閉”變為“開啟”；此時對應的電磁閥工作，電磁閥指示燈點亮，說明該器件功能正常。鬆開 鍵，功能狀態恢復預設“關閉”（器件功能測試選項前 6 項）。

按下 右鍵，可進入下一器件功能測試選項，器件功能測試選項 1 到 6 項（圖 4 至圖 9）：

1-1 壓腳功能測試
1-2 吸風功能測試
1-3 撐料氣缸測試
1-4 剎車氣缸測試
1-5 分料氣缸測試
1-6 步進電機測試
1-7 編碼器計數值
1-8 踏板輸入電壓
1-9 步進接近開關測試
1-10 布料檢測電眼測試
1-11 分料檢測開關測試
1-12 步進停車開關時間
1-13 迴圈功能測試

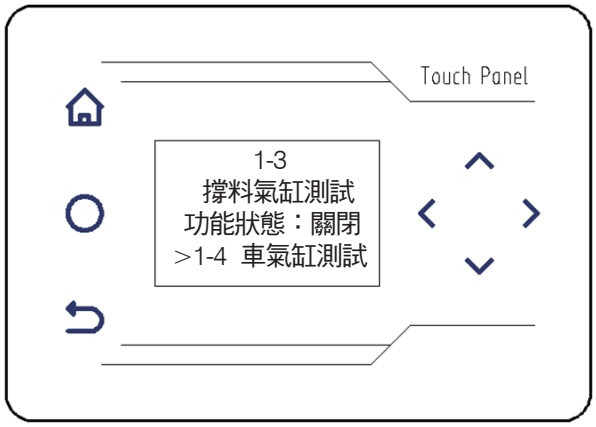


圖 6

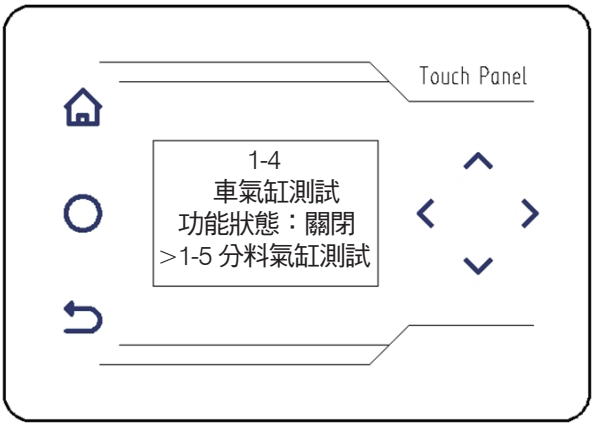


圖 7

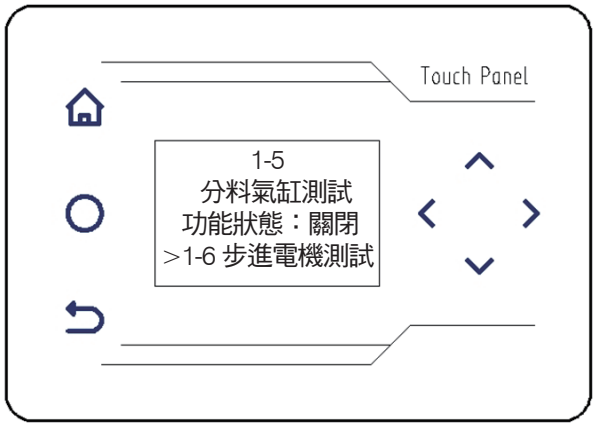


圖 8

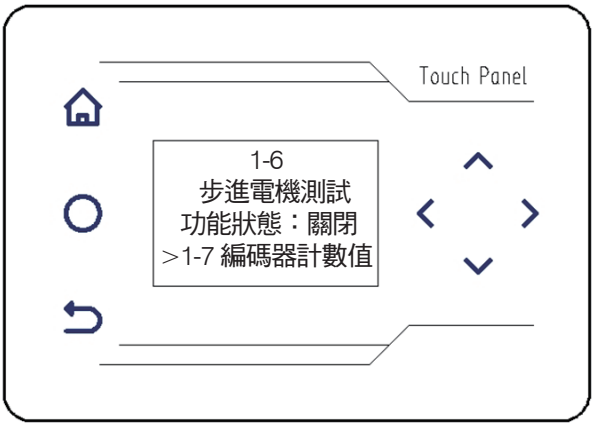


圖 9

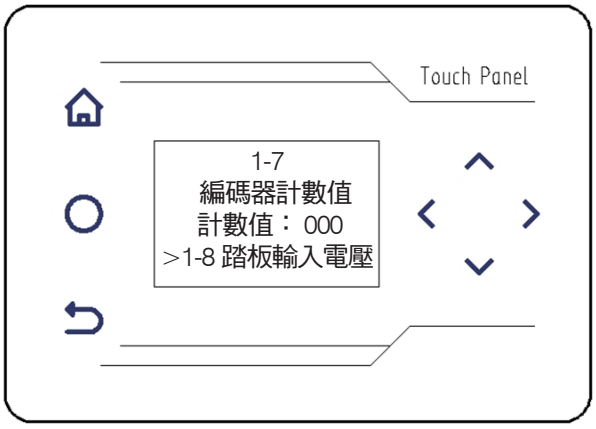


圖 10

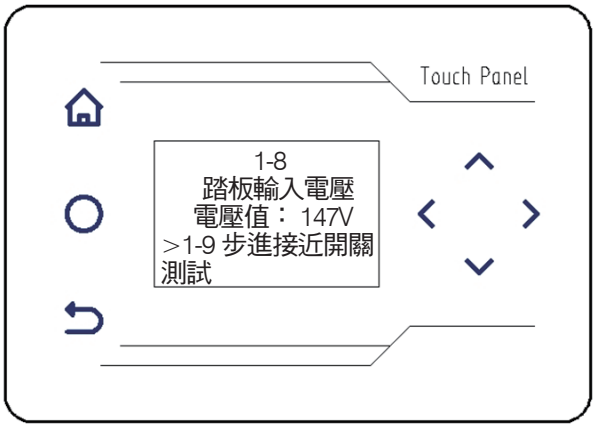


圖 11

1-7 編碼器計數值（圖 10）

編碼器計數值（預設狀態下顯示 000）的調試，暫不可調節。(轉動機器上手輪，每轉 (正反轉皆可) 一圈編碼器技術值會增加 1，說明編碼器工作正常。)

1-8 踏板輸入電壓（圖 11）

踏板輸入電壓的調試，（通過 左鍵、 右鍵）選擇“1-8 踏板輸入電壓”選項 (默認狀態下顯示 140V ～ 150V 之間)，踩踏腳踏板，螢幕上會顯示踏板中立、前踏、後踏狀態時的電壓值。

* 踩踏腳踏板，往腳後跟方向倒踩時，踏板輸入電壓值會在 000 ～ 015V；往腳尖方向踩踏時，電壓上升至 460 ～ 470V

圖 12

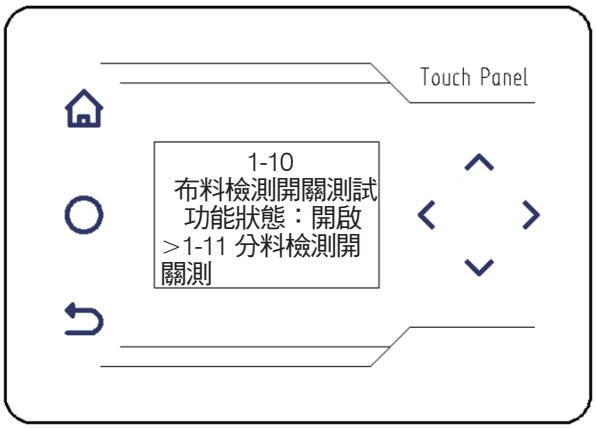


圖 13

1-9 步進接近開關測試（圖 12）

步進接近開關測試（預設功能狀態：開啟）的調試，（通過 左鍵、 右鍵）選擇“1-9 步進接近開關測試”選項，用手輕按“步進接近開關觸發器”，顯示器中，“功能狀態”由“開啟”變為“關閉”，表明“步進接近開關”正常。

1-10 布料檢測開關測試（圖 13）

布料檢測開關測試（預設功能狀態：開啟）的調試，（通過 左鍵、 右鍵）選擇“1-10 布料檢測開關測試”選項，當遮蓋機構上布料檢測的光電感測器，顯示器中，“功能狀態”由“開啟”變為“關閉”，表明“布料檢測開關”正常。

圖 14

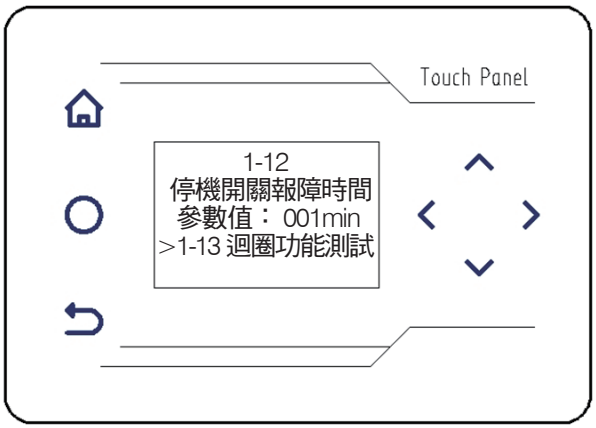


圖 15

1-11 分料檢測開關測試（圖 14）

分料檢測開關測試（預設功能狀態：開啟）的調試，（通過 左鍵、 右鍵）選擇“1-11 分料檢測開關測試”選項，當遮蓋機構上分料檢測的光電感測器，顯示器中，“功能狀態”由“開啟”變為“關閉”，表明“分料檢測開關”正常。

1-12 停機開關報障時間（圖 15）

停機開關報障時間預設參數值 1 分鐘，此數值為出廠設置，請勿調整。

圖 16

1-13 迴圈功能測試（圖 16）

迴圈功能測試（預設功能狀態：開啟）的調試，（通過 左鍵、 右鍵）選擇“1-13 迴圈功能測試”選項，選擇後，機器自動迴圈測試以上 12 項功能，作出對應動作。按 返回鍵，機器停止測試並返回到上一級介面（圖 3）。

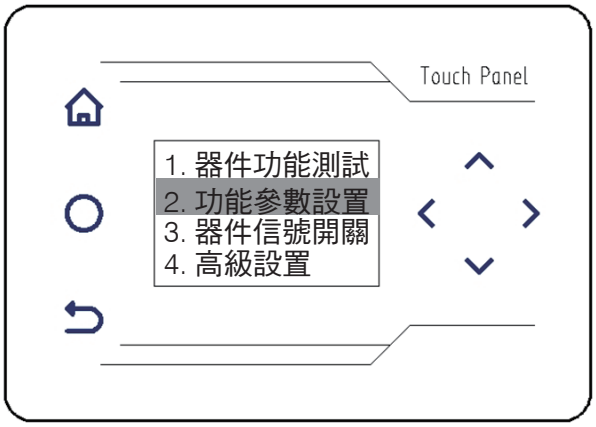


圖 17

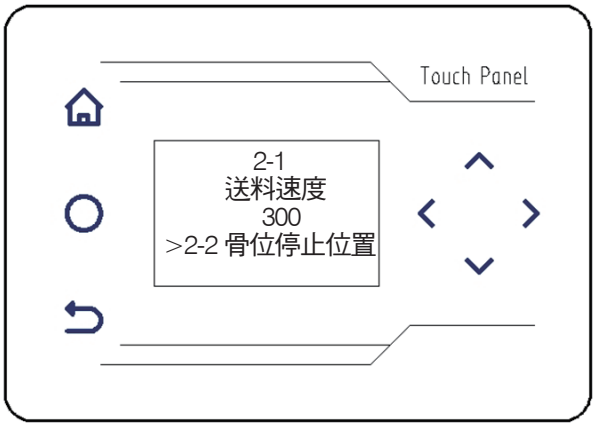


圖 18

（二）、功能參數設置

按 ^、v 加減鍵，選中“功能參數設置”（圖 17），按下 > 右鍵，進入子功能表介面（圖 18）：

2-1 送料速度（圖 18）

送料速度（預設 300 轉每分鐘）設置，通過 ^、v 加減鍵，可調節送料速度或關閉。

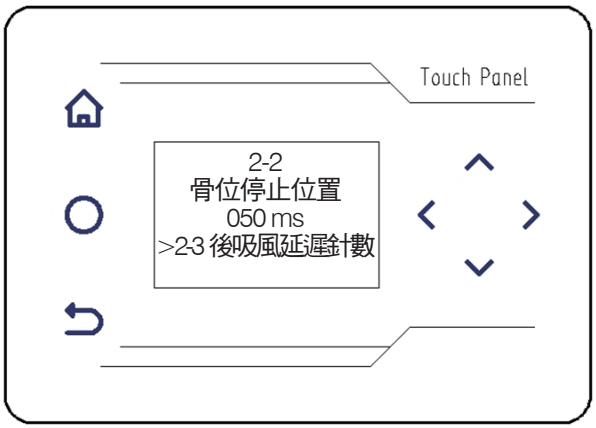


圖 19

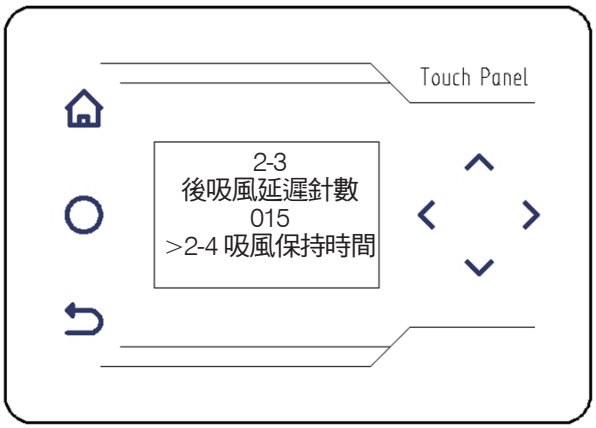


圖 20

2-2 骨料停止位置（圖 19）

骨料停止位置（默認 50ms）設置，通過 ^、v 加減鍵，可調節骨料停止位置。

2-3 後吸風延遲針數（圖 20）

後吸風延遲針數（默認 15 針）設置，通過 ^、v 加減鍵，可調節針數以控制吸風開始時間。

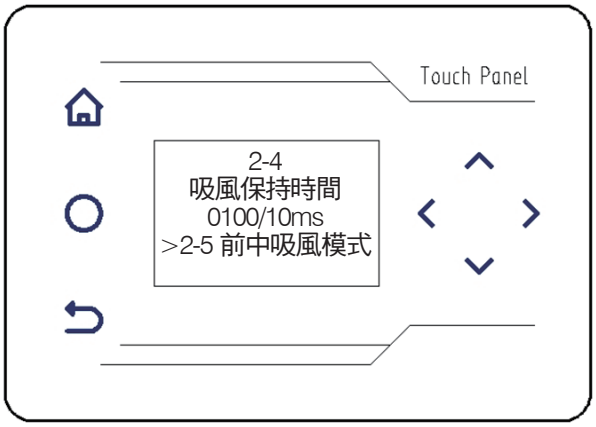


圖 21

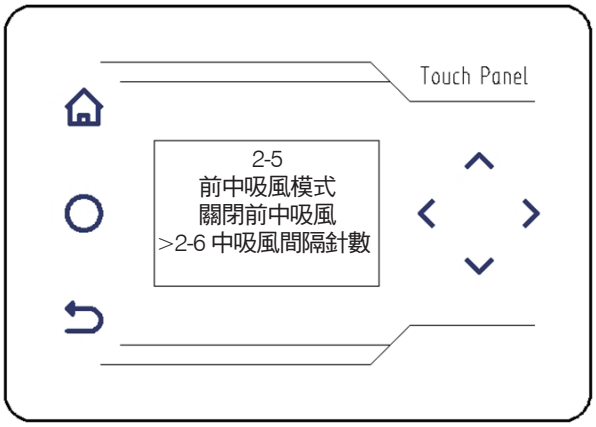


圖 22

2-4 吸風保持時間（圖 21）

吸風保持時間（默認 1000ms）設置，通過 ^、v 加減鍵，可調節吸風保持時間。

2-5 前中吸風模式（圖 22）

前中吸風模式（預設關閉前中吸風）設置，通過 ^、v 加減鍵，可打開或者關閉前中吸風。

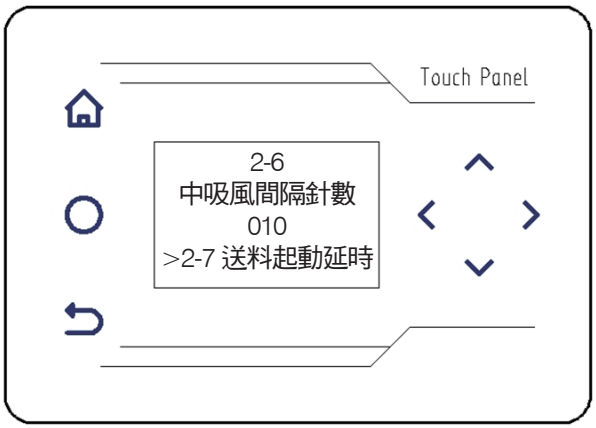


圖 23

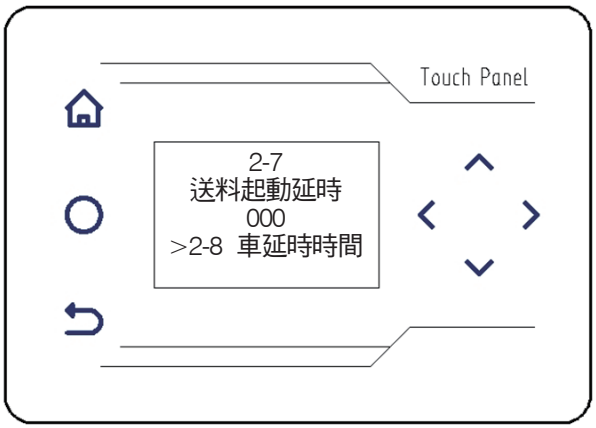


圖 24

2-6 中吸風間隔針數（圖 23）

中吸風間隔針數（默認 10 針）設置，通過 ^、v 加減鍵，可調節中吸風間隔針數。

2-7 送料起動延時（圖 24）

送料起動延時（默認 0ms）設置，通過 ^、v 加減鍵，可調節送料起動延時時間。

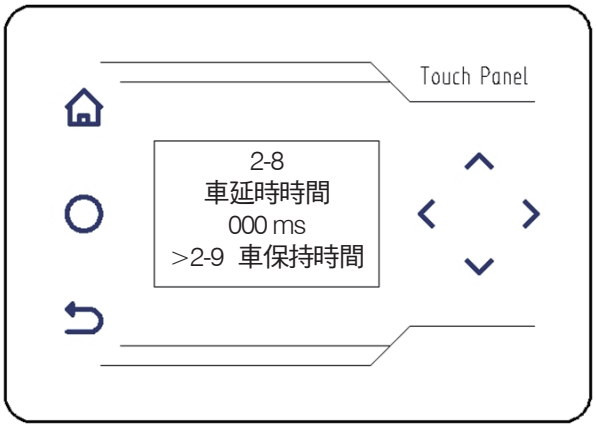


圖 25

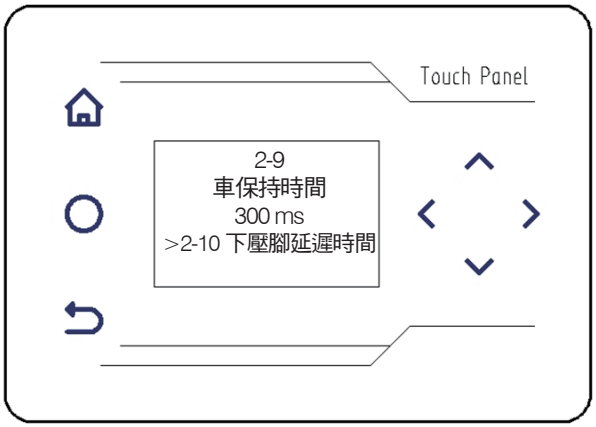


圖 26

2-8 剎車延時時間（圖 25）

剎車延時時間（默認 0ms）設置，通過 ^、v 加減鍵，可調節剎車啟動的延時時間。

2-9 剎車保持時間（圖 26）

剎車保持時間（默認 300ms）設置，通過 ^、v 加減鍵，可調節剎車保持時間。

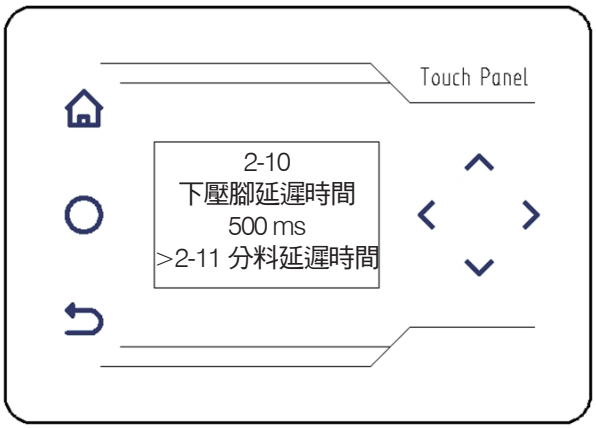


圖 27

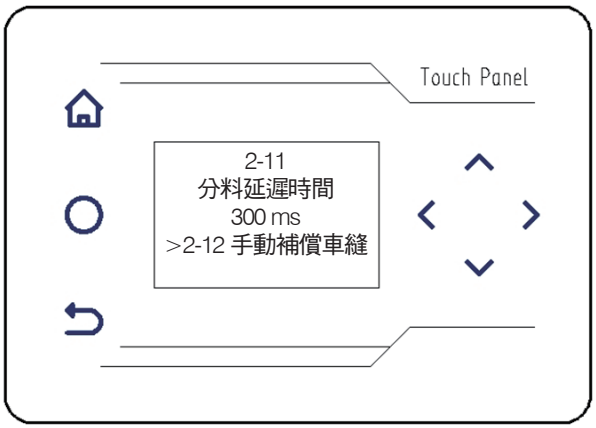


圖 28

2-10 下壓腳延時時間（圖 27）

下壓腳延時時間（默認 500ms）設置，通過 ^、v 加減鍵，可調節下壓腳延時時間。

2-11 分料延遲時間（圖 28）

分料延遲時間（默認 300ms）設置，通過 ^、v 加減鍵，可調節分料延遲時間。

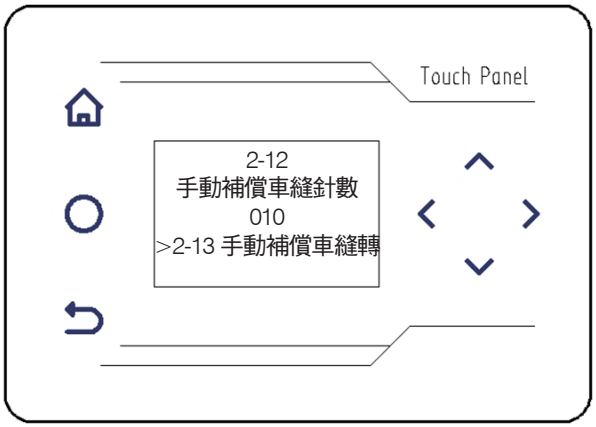


圖 29

圖 30

2-12 手動補償車縫針數（圖 29）

手動補償車縫針數（默認 10）設置，通過 ^、v 加減鍵，可調節補償車縫針數。

2-13 手動補償車縫轉速（圖 30）

手動補償車縫轉速（默認 50）設置，通過 ^、v 加減鍵，可調節補償車縫轉速。

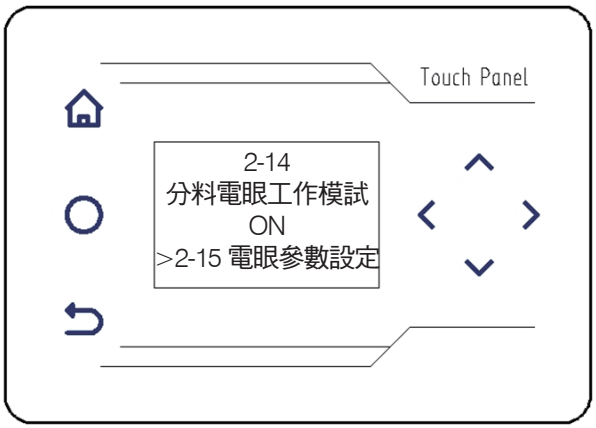


圖 31

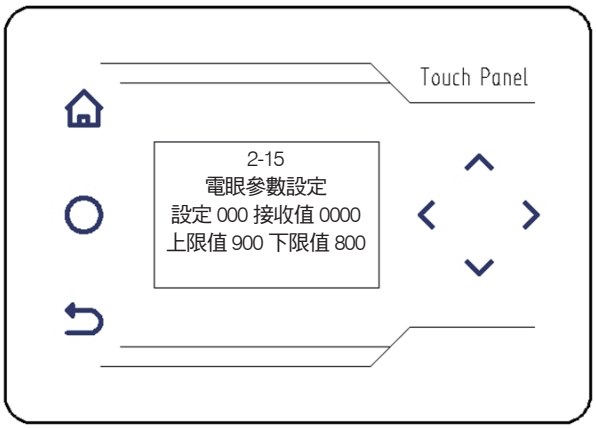


圖 32

2-14 分料電眼工作模式（圖 31）

分料電眼工作模式（預設 ON）設置，通過 ∧、∨ 加減鍵，可關閉或打開分料電眼開關。

2-15 電眼參數設置（圖 32）

電眼參數設置（預設值不確定）設置，通過 ∧、∨ 加減鍵，可調節“設定”數值，“接收值”會自動作出相應變化。

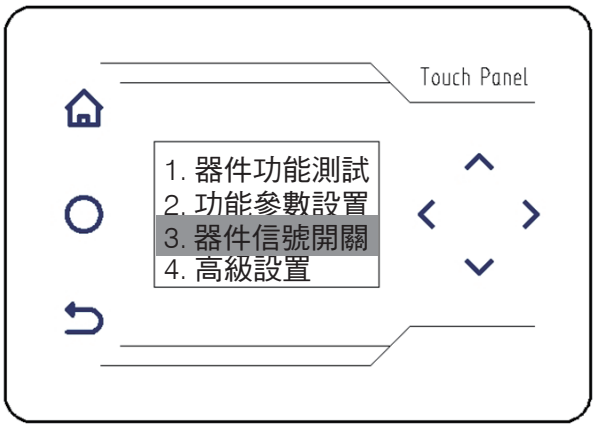


圖 33

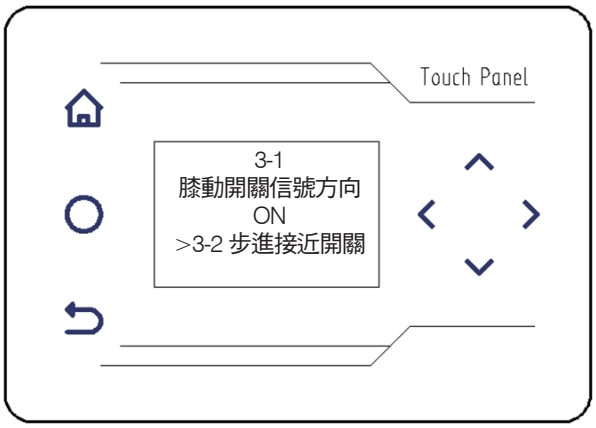


圖 34

（三）、器件信號開關

按 ∧、∨ 加減鍵，選中“器件信號開關”（圖 33），按下 > 右鍵，進入子功能表介面（圖 34）：

3-1 膝動開關信號方向（圖 34）

膝動開關信號方向（預設 ON）設置，通過 ∧、∨ 加減鍵，可關閉或打開膝動開關信號。

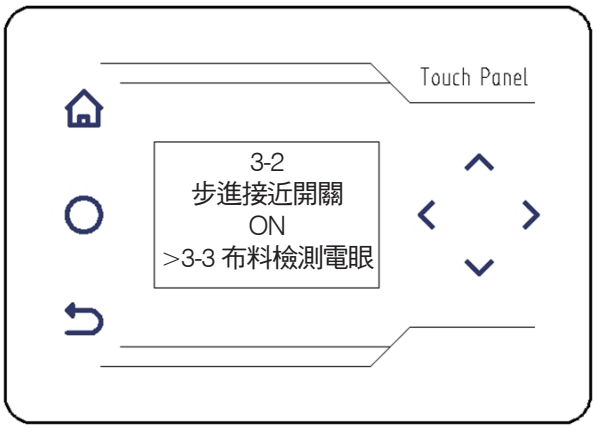


圖 35

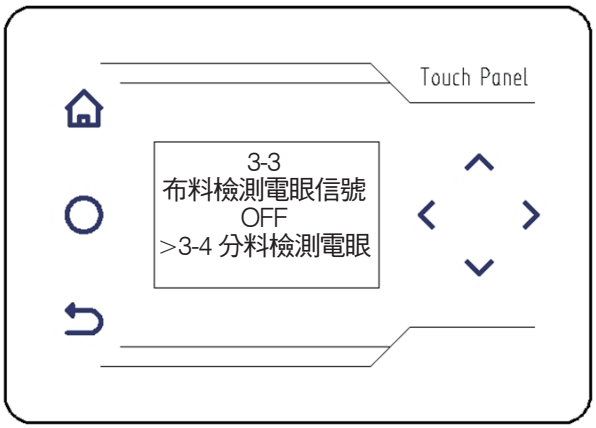


圖 36

3-2 步進接近開關（圖 35）

步進接近開關（預設 ON）設置，通過 ∧、∨ 加減鍵，可關閉或打開步進接近開關。

3-3 布料檢測電眼信號（圖 36）

布料檢測電眼信號（預設 OFF）設置，通過 ∧、∨ 加減鍵，可打開或關閉布料檢測電眼信號。

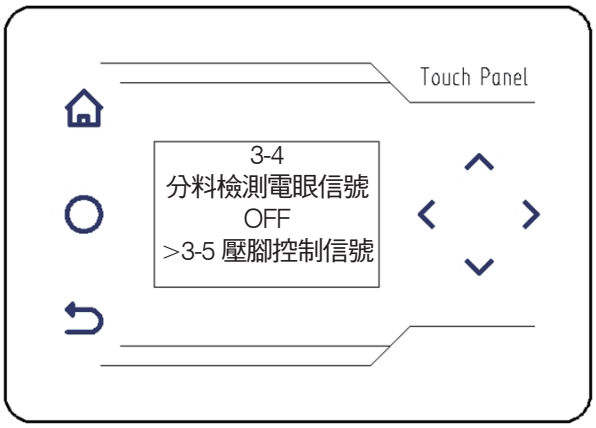


圖 37

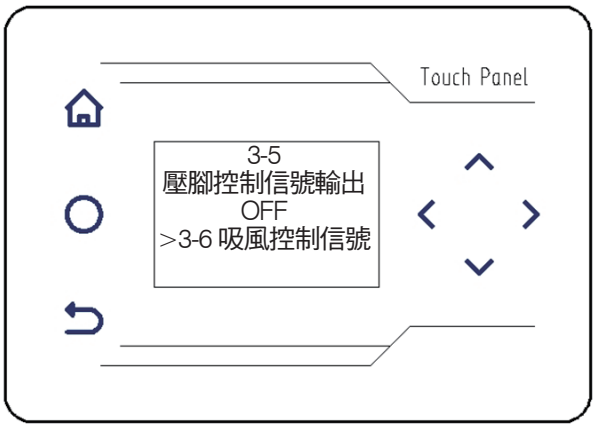


圖 38

3-4 分料檢測電眼信號（圖 37）

分料檢測電眼信號（預設 OFF）設置，通過 ∧、∨ 加減鍵，可打開或關閉分料檢測電眼信號。

3-5 壓腳控制信號輸出（圖 38）

壓腳控制信號輸出（預設 OFF）設置，通過 ∧、∨ 加減鍵，可打開或關閉壓腳控制信號輸出。

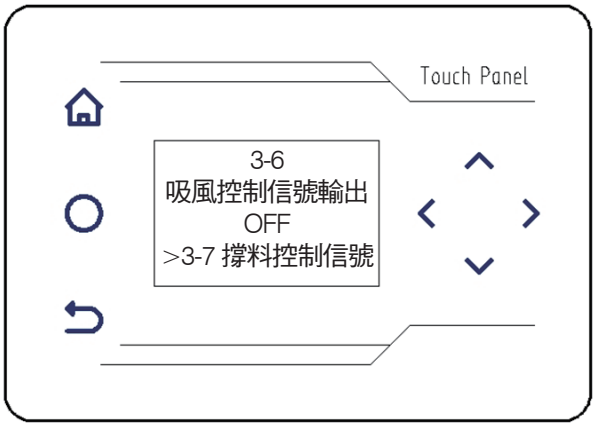


圖 39

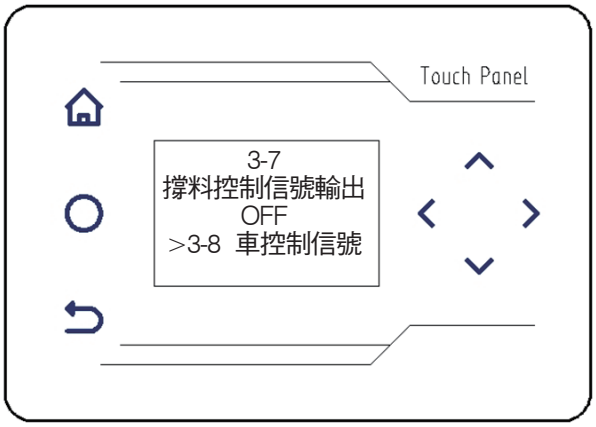


圖 40

3-6 吸風控制信號輸出（圖 39）

吸風控制信號輸出（預設 OFF）設置，∧、∨ 加減鍵，可打開或關閉吸風控制信號輸出。

3-7 撐料控制信號輸出（圖 40）

撐料控制信號輸出（預設 OFF）設置，通過 ∧、∨ 加減鍵，可打開或關閉壓腳控制信號輸出。

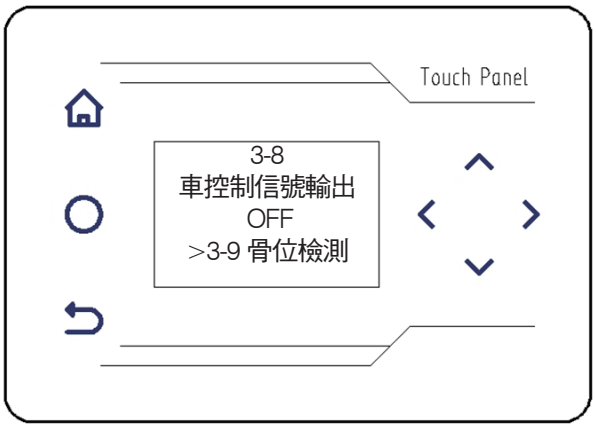


圖 41

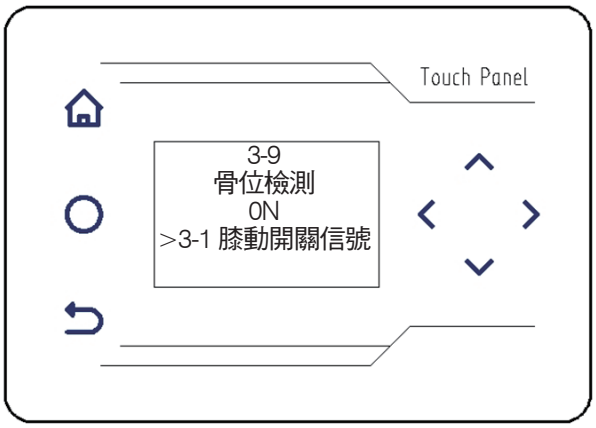


圖 42

3-8 車控制信號輸出（圖 41）

車控制信號輸出（預設 OFF）設置，通過 ∧、∨ 加減鍵，可打開或關閉 車控制信號輸出。

3-9 骨位檢測（圖 42）

骨位檢測（默認 ON）設置，通過 ∧、∨ 加減鍵，可打開或關閉骨位檢測功能。

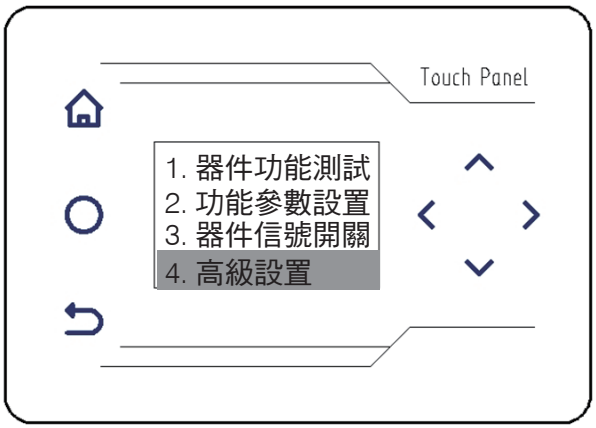


圖 43

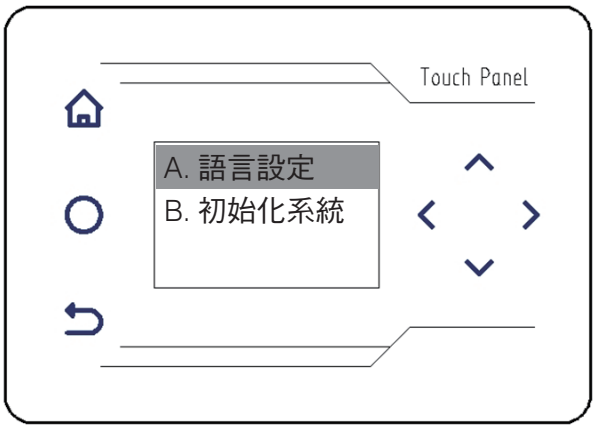


圖 44

（四）、高級設置

按 ^、v 加減鍵，選中“高級設置”（圖 43），按下 > 右鍵，進入子功能表介面（圖 44）：

A 語言設定（圖 44）

按下 > 右鍵，進入子功能表介面（圖 45），按 ^、v 加減鍵，可選擇系統語言“簡體中文”或者“English”（英語）。

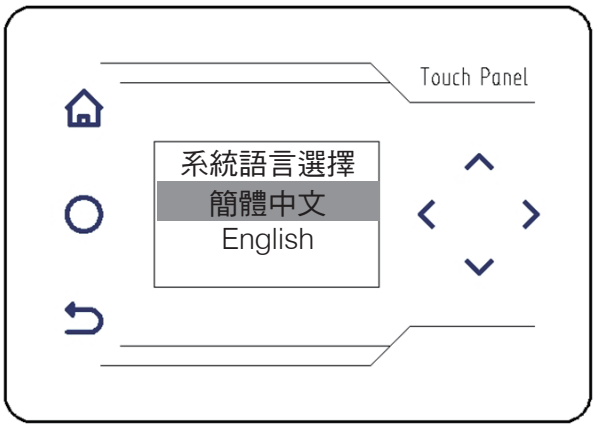


圖 45

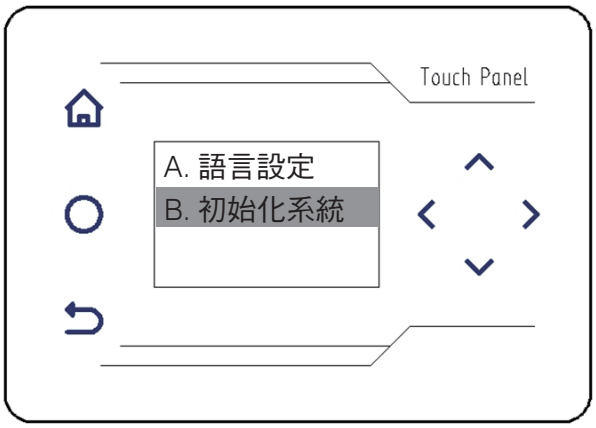


圖 46

B 初始化系統（圖 46）

在“高級設置”的子功能表介面下，按 ^、v 加減鍵，選中“初始化系統”（圖 46），按下 > 右鍵，系統將恢復出廠設置，即“初始化系統”。

控速器參數設置（隱藏菜單）

在“高級設置”的子功能表介面下，按 ^ 、v 加減鍵，選中“初始化系統”（圖 46），再按一次 v 加減鍵，遊標消失，出現（圖 47）介面，再按下 > 右鍵，進入控速器參數設置（圖 48）。“控速器參數設置”為隱藏項，出廠調整用，一般不對外開放。

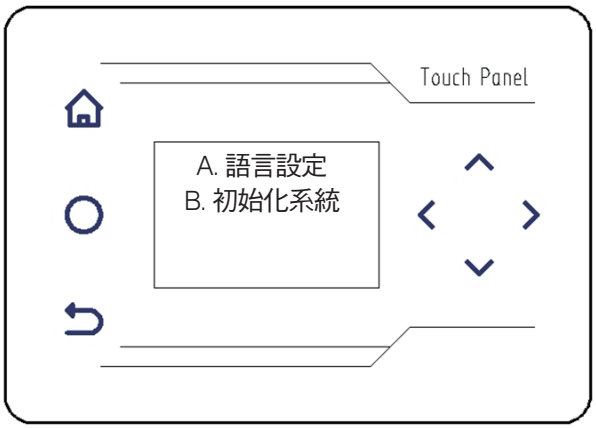


圖 47

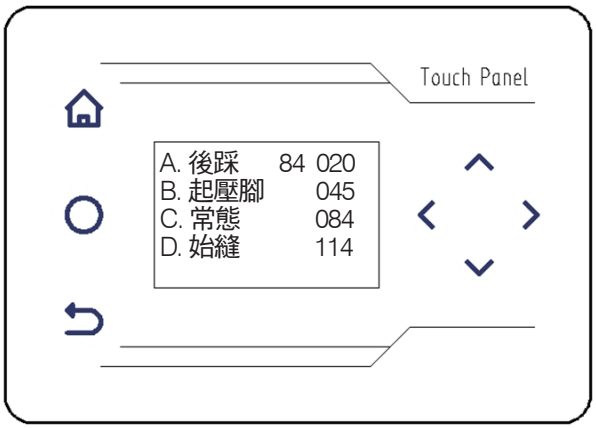


圖 48

以下電壓值需根據踏板四種狀態時的即時電壓值來進行設定

如圖 48 所示：

84 為中立狀態電壓值，

全後踏時 84 會變化為 05（不同品牌電機會有差異）

A. 後踩送料時電壓值（=05+015）：020

B. 抬壓腳時電壓值 =（084+05）/2：045

C. 中立時電壓值：084

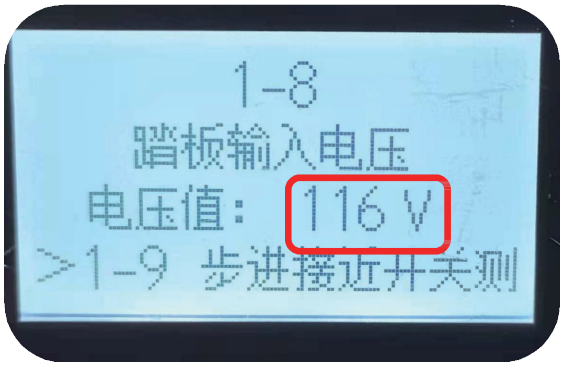
D. 前踏車縫時啟動電壓值（比中立時》30）：114

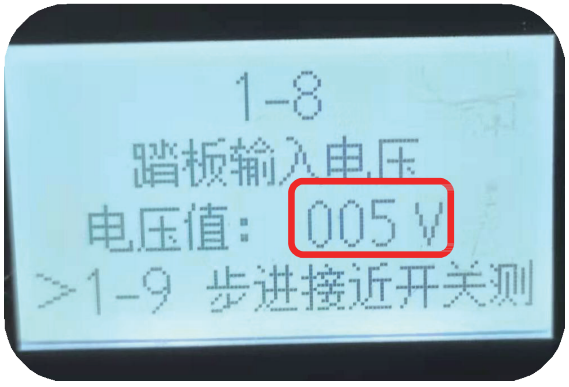
9、參 數 表

1. 器件功能測試	2. 功能參數設置	預設值	3. 器件信號開關	默認值	4. 高級設置
1-1 壓腳功能測試	2-1 送料速度	300	3-1 膝動開關信號方向	ON	A. 語言設定
1-2 吸風功能測試	2-2 骨料停止位置	50	3-2 步進接近開關	ON	B. 初始化系統
1-3 撐料氣缸測試	2-3 後吸風延遲針數	10	3-3 布料檢測電眼信號	OFF	
1-4 剎車氣缸測試	2-4 吸風保持時間	100	3-4 分料檢測電眼信號	OFF	兩項均沒有底色
1-5 分料氣缸測試	2-5 前中吸風模式	關閉前中吸風	3-5 壓腳控制信號輸出	OFF	後踏：
1-6 步進電機測試	2-6 中吸風間隔針數	100	3-6 吸風控制信號輸出	OFF	壓腳
1-7 編碼器計數值	2-7 送料起動延時	0	3-7 撐料控制信號輸出	OFF	常態：
1-8 踏板輸入電壓	2-8 車延時時間	0	3-8 車控制信號輸出	OFF	起縫：
1-9 步進接近開關測試	2-9 車保持時間	300	3-9 骨位檢測	ON	
1-10 布料檢測電眼測試	2-10 下壓腳延時時間	500			
1-11 分料檢測開關測試	2-11 分料延遲時間	300			
1-12 步進停車開關時間	2-12 手動補償車縫針數	10			
1-13 迴圈功能測試	2-13 手動補償車縫轉速	50			
	2-14 分料電眼工作模式	ON			
	2-15 電眼參數設置				

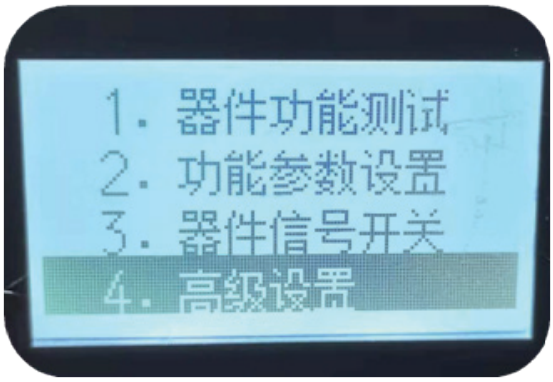
10、圓領裝置顯示幕一體電控匹配速控器參數調整

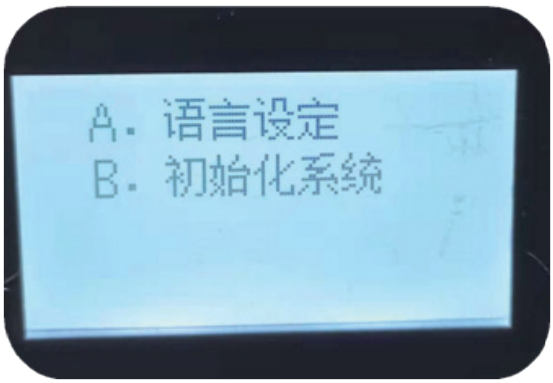
①、打開檢測項 1-8，記錄常態下電壓值和反踩踏板電壓值

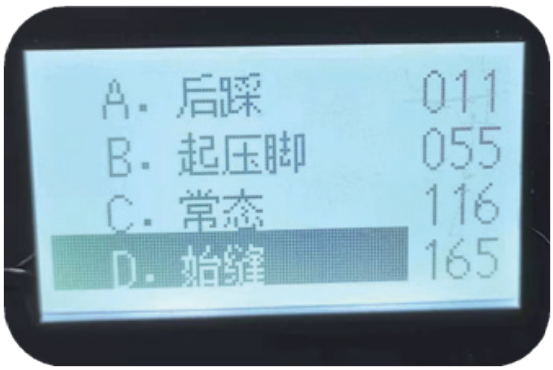




②、打開高級設置 ，調到 A-B 兩項都沒有底色進入參數設置







A. 後踩：參數調到大於反踩踏板電壓值，
*** 小於即送帶輪沒法啟動

B. 起壓腳：參數調到後踩和常態中位數

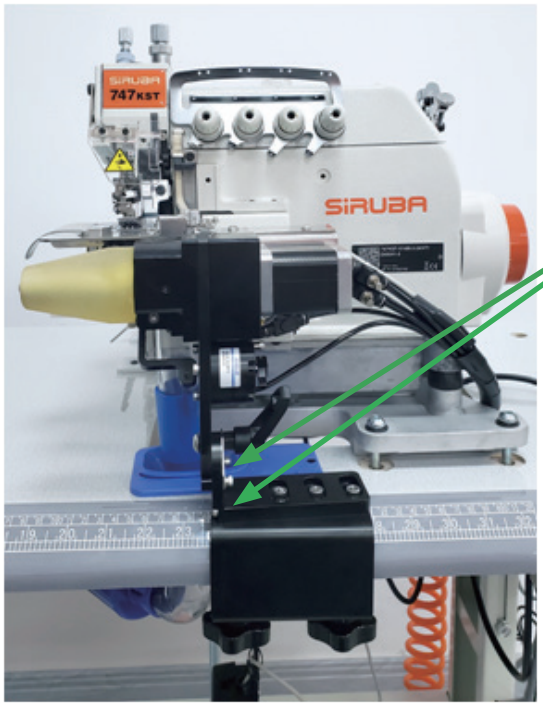
C. 常態：參數調到踏板常態下電壓值

D. 始縫 參數調到比常態大於常態值+30，
*** 始縫如小於常態即會開機電機就自行轉動

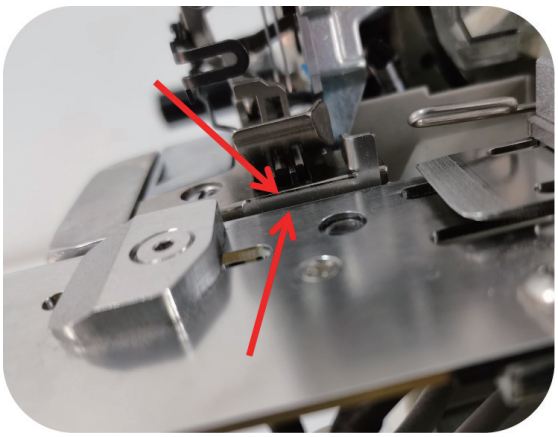
③ 、按 ⮌ 返回鍵保存並退出

11、安裝重點 & 使用維護調整

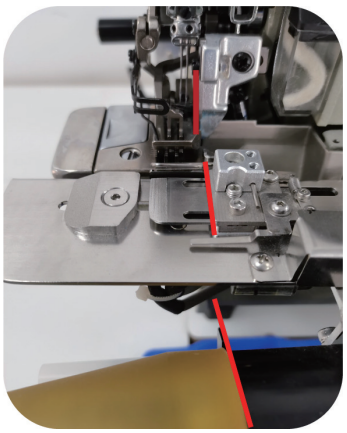
分料裝置高度調整



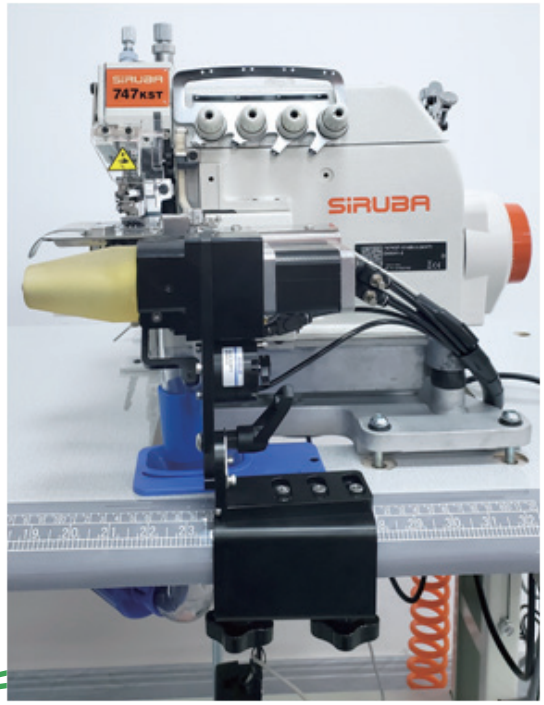
分料裝置高度調整與包縫機針板高度一致。



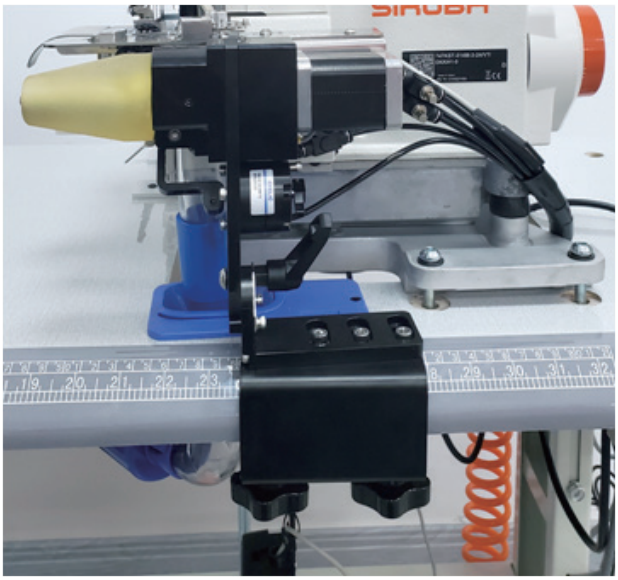
分料裝置左右調整

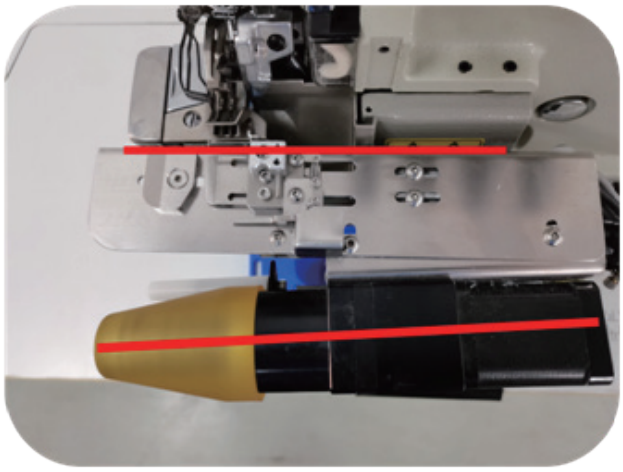


調整分料裝置左右位置，右邊擋板推到最左邊，移動組件左右位置與包縫機切刀平齊。



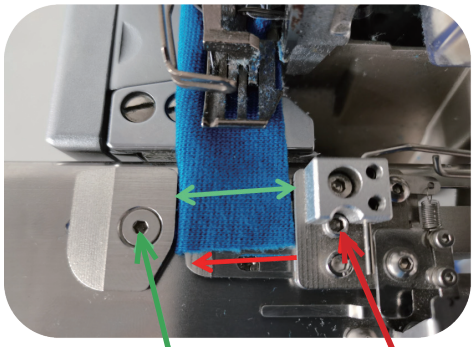
步進電機角度調整

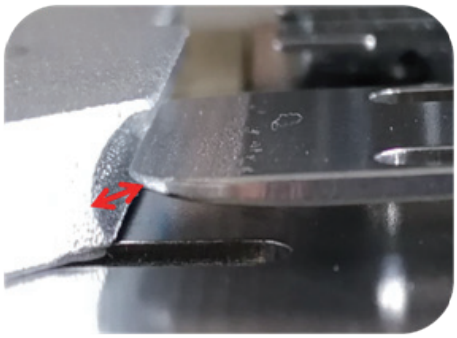




調整步進電機送帶輪與包縫機角度大約在 5 度 (視乎羅紋面料再做調整)，分料裝置與包縫機平行。留有一點間距，防止包縫機在轉動時震動與分料裝置碰撞。

羅紋寬度調整

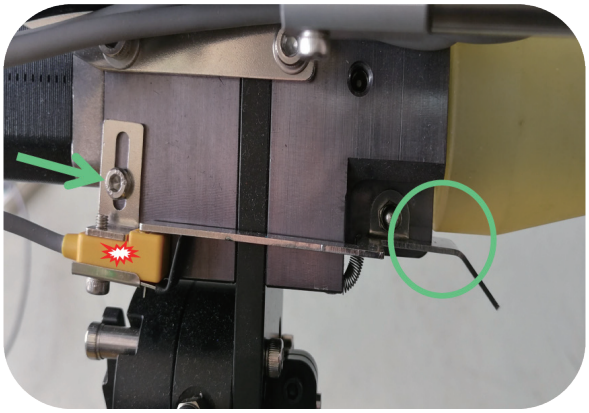


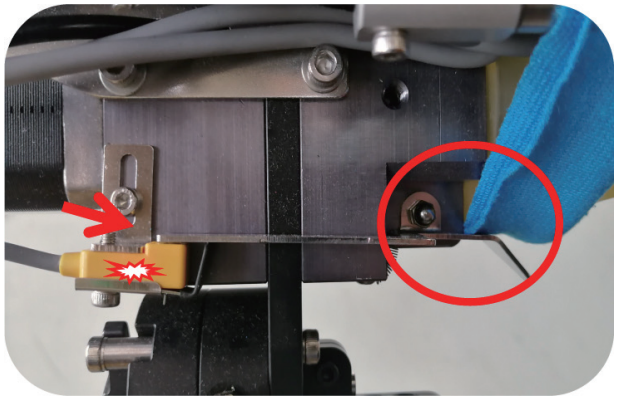


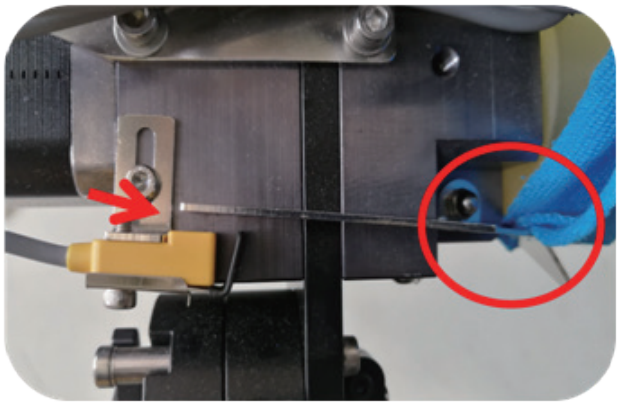
1. 右邊擋板移到最右邊，調整左擋板到右擋板距離和羅紋寬窄一致。

2. 分佈片向左推出與左擋板留有 1mm(視乎羅紋厚度)，中間間距越小最好。

感應骨位調整

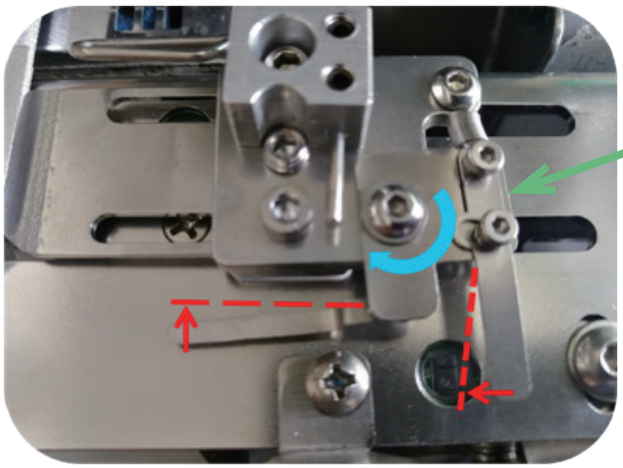






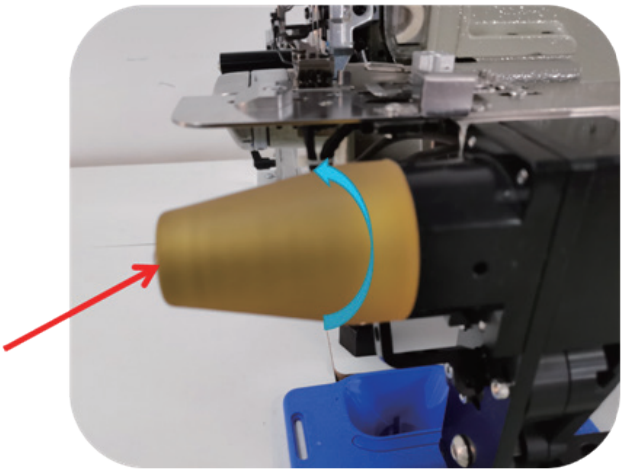
根據羅紋的厚度調整感應器的高度。感應器正常狀態下亮燈，當羅紋骨位通過感應片時，感應片離開感應器，感應燈不亮。

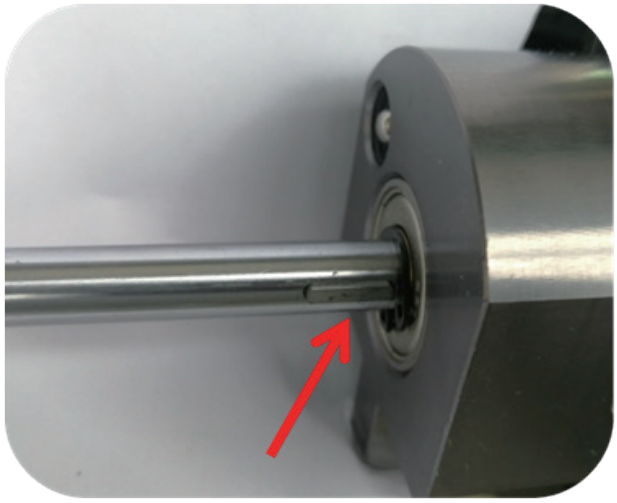
自動分料裝置感應調整



感應片向前移動 2mm, 調整感應反光片的位置，使電眼可以通過反光片反射光線，分料裝自動退回復位。

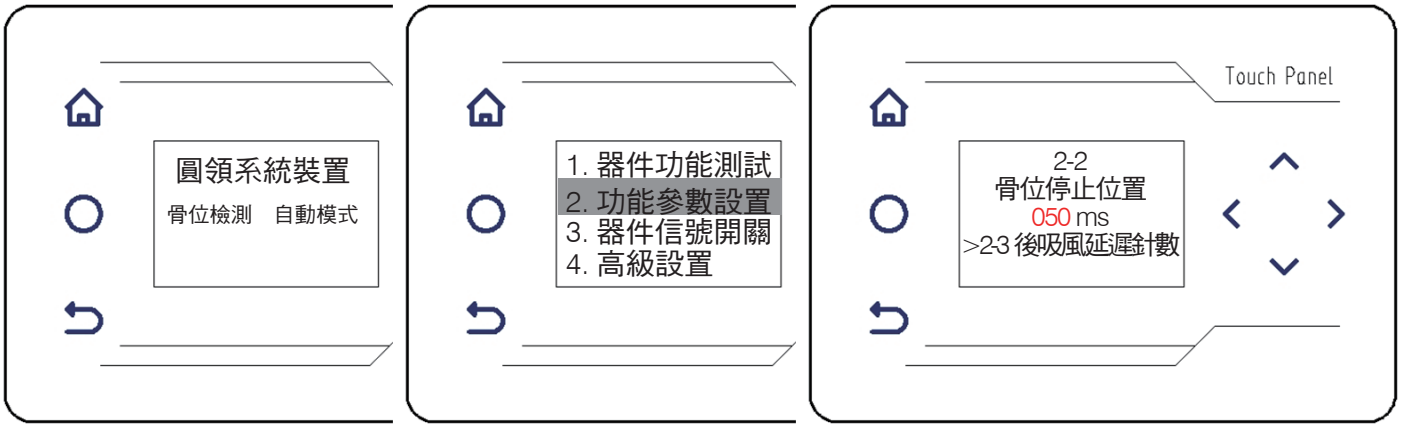
卡線處理





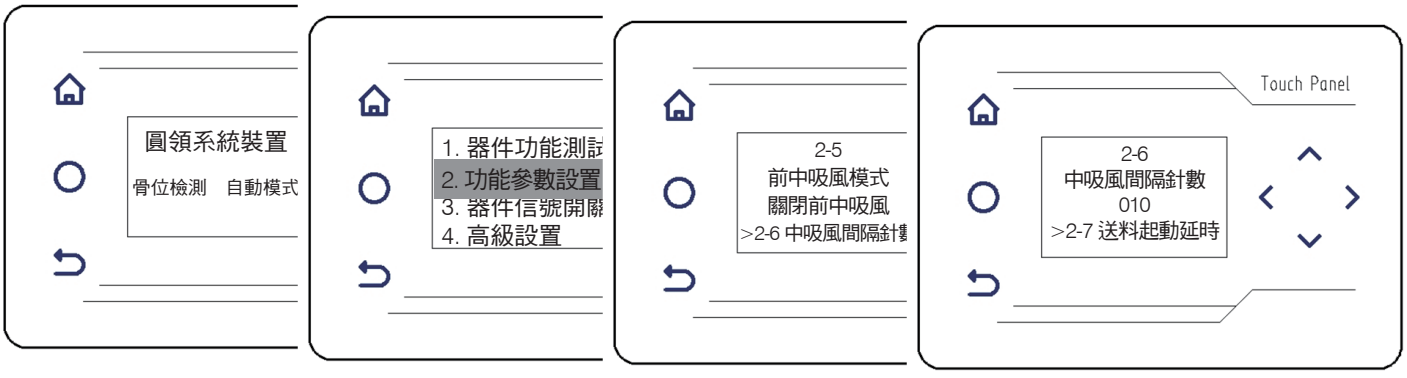
步進電機送帶輪，只能單方向向前轉動，反方向轉動會有阻力，如果向前轉動有阻力，即會導致羅紋跑偏。可能卡有線頭，拆下送帶輪清理，注意不要掉了鍵條。

自動對縫骨停止位置設置



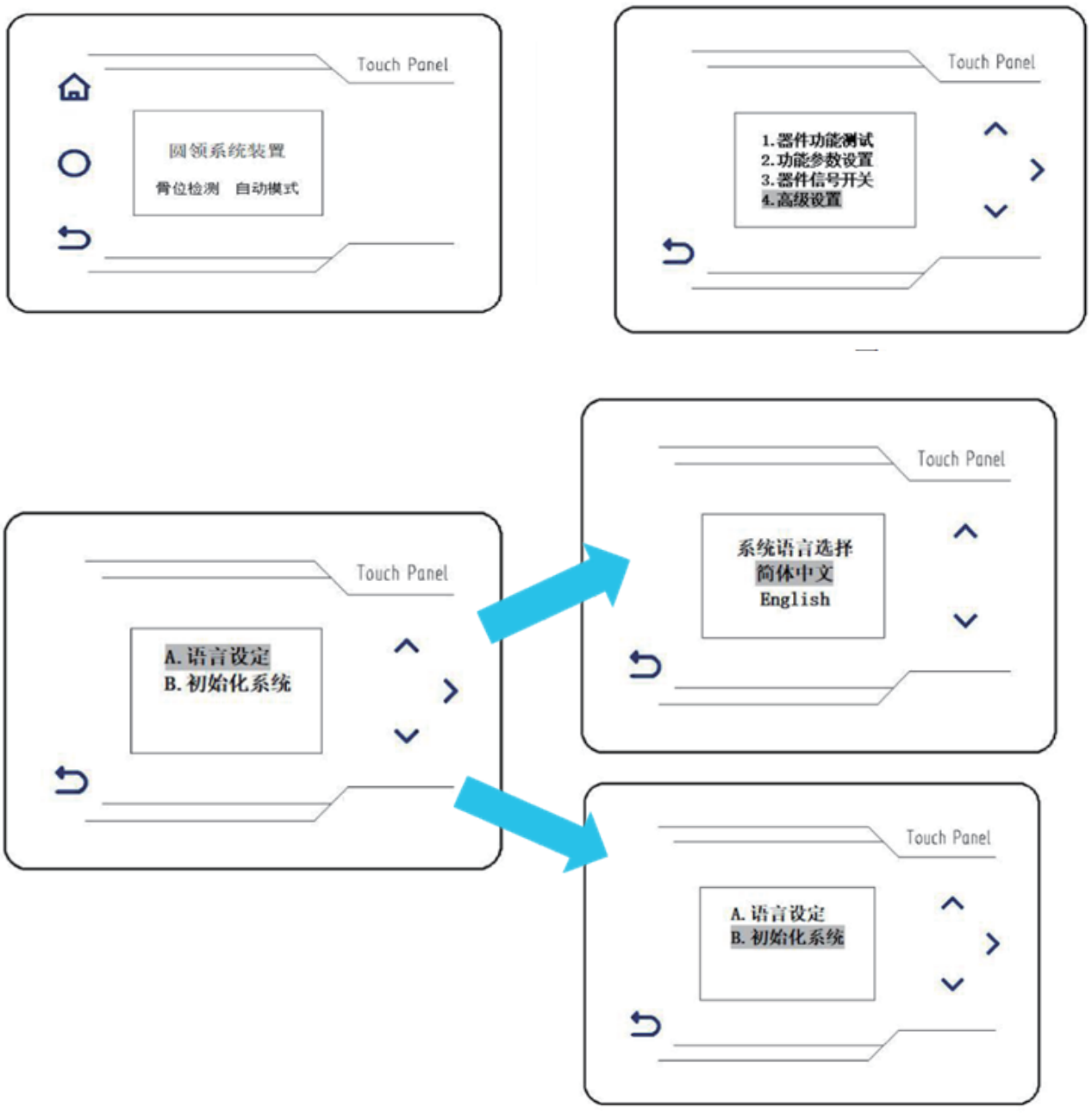
1. 長按 鍵 3 秒，進入參數設置介面。
2. 按下鍵選中”功能參數設置”按右鍵，進入子菜單介面。
3. 按右鍵選中 2-2 骨位停止位置，按上下鍵調整參數大小 (數值越大骨位停止位置向後，參數越小骨位停止位置向操作者)，然後按返回鍵退出，參數自動保存。

設置調為長吸風



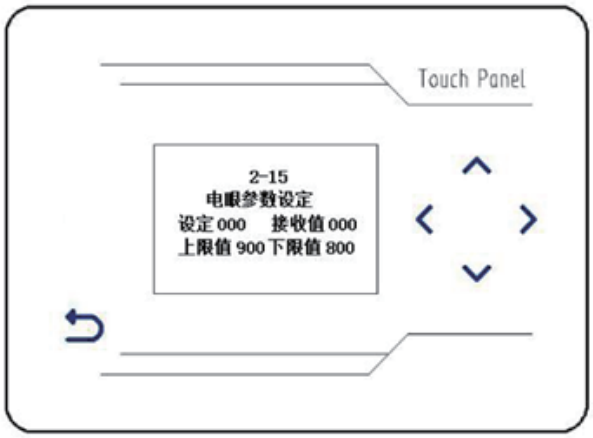
1. 長按 鍵 3 秒，進入參數設置介面。
2. 按下鍵選中”功能參數設置”按右鍵，進入子菜單介面。
3. 按右鍵選中 2-5 前中吸風吸風模式，按下鍵調整為開啟前中吸風。
4. 按右鍵選中 2-6 中吸風間隔針數，按下鍵調整為 0，按返回鍵退出。

語言選擇 & 初始化參數

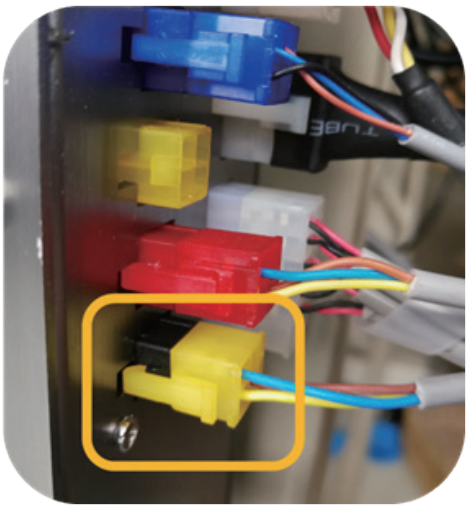


1. 長按 鍵 3 秒，進入參數設置介面。
2. 按下鍵選中 4. 高級設置，按右鍵進入菜單。
3. 按上下鍵選中 A. 語言設定或 B. 初始化系統，按右鍵進入子菜單。
4. 按上下鍵選中簡體中文或 English，按返回鍵，返回上一個介面。
5. 按下鍵選中 B. 初始化系統，按右鍵等待 2 秒，系統初始化完成自動返回主介面。

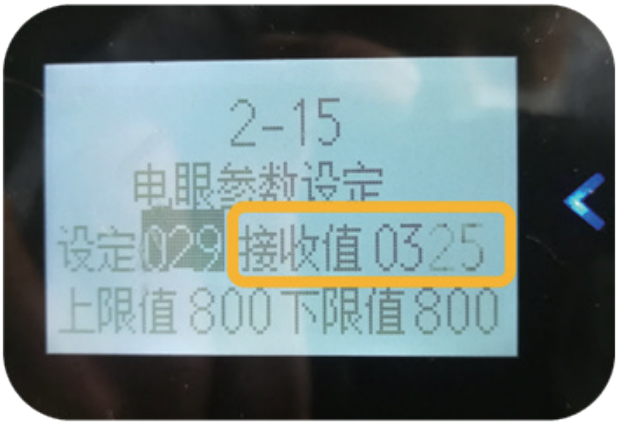
感應布料電眼的調整



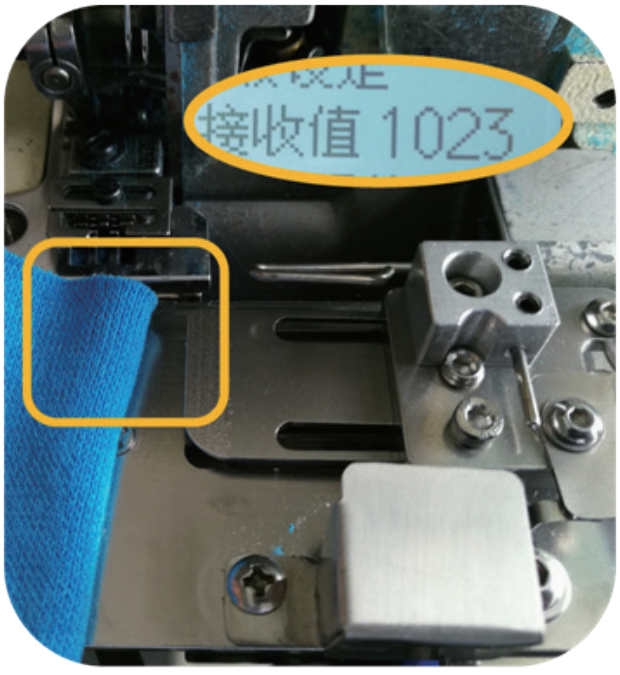
1. 長按菜單鍵 3 秒》
功能參數設置》
2-15 電眼參數設定



2. 將感應羅紋電眼插頭 (黃)，
插到黑色插座，

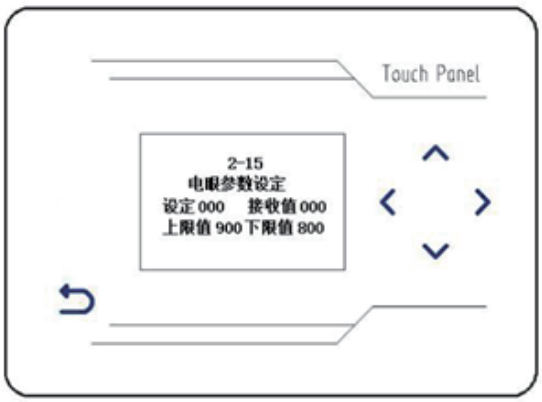


3. 按上下鍵調整設定值使接收值
在 300-400 之間

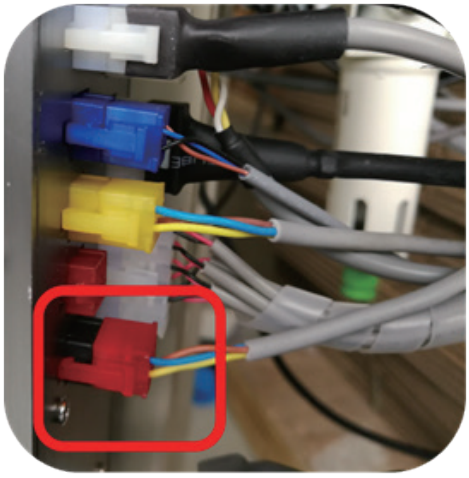


4. 用布料遮擋電眼，接收值為
1023，如果沒有達到 1023，按
上下鍵調整設定值，使接收值達
到 1023，如果接收值沒有變化，
即需要檢查或更換電眼。

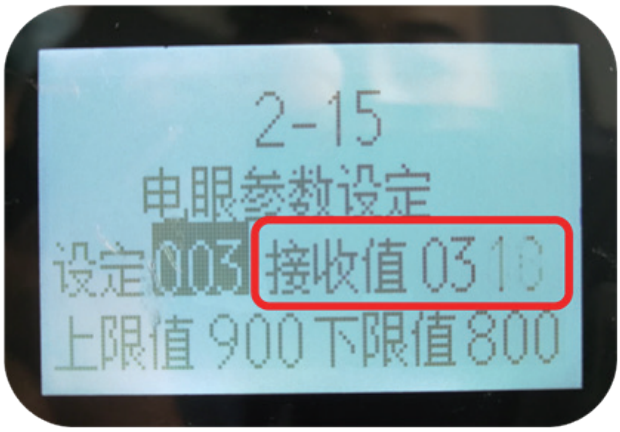
分料裝置自動復位電眼調整



1. 長按菜單鍵 3 秒》
   功能參數設置》
   2-15 電眼參數設定



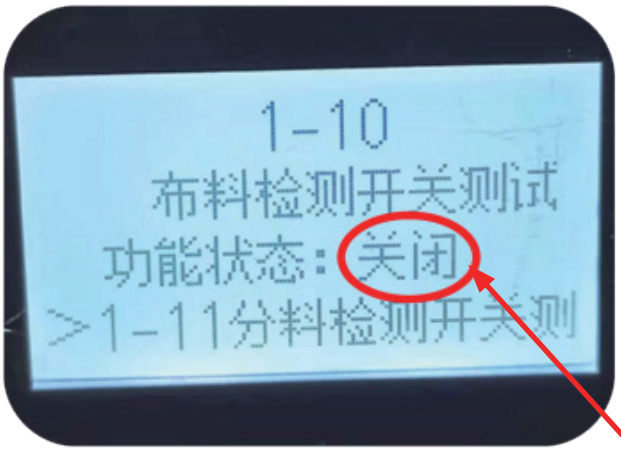
2. 將感應羅紋電眼插頭 (紅) 插到黑色插座



3. 按上下鍵調整設定值使接收值在 300-400 之間，

4. 用手指推動感應片使反光片遮擋電眼，接收值為 1023，如果沒有達到 1023，按上下鍵調整設定值，使接收值達到 1023，如果接收值沒有變化，即需要檢查或更換電眼。

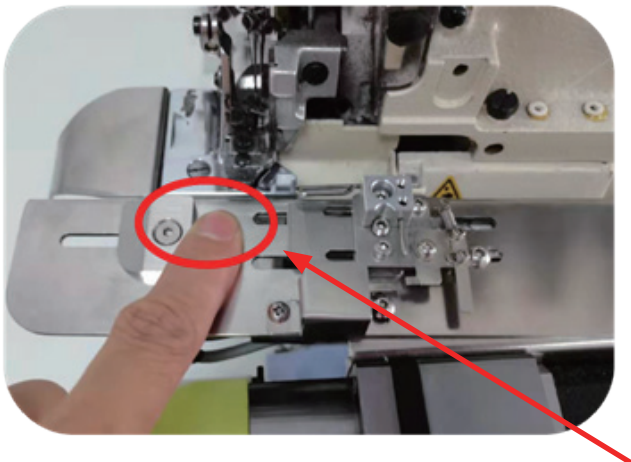
ACS-200 系列反踩踏板送帶輪不轉



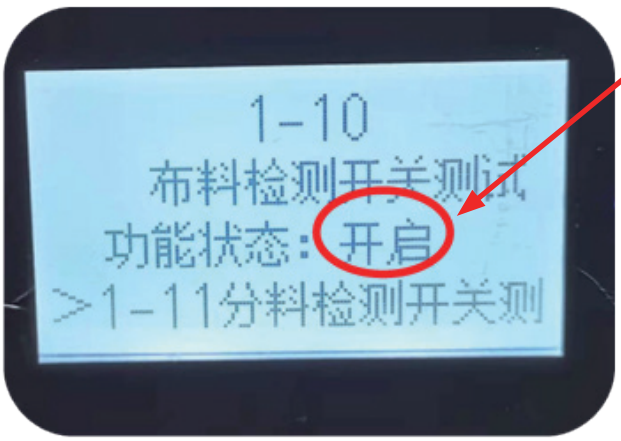
檢查布料檢測開關

1：檢測步進電機線是否存在斷線與插頭是否插好
2：檢測檢骨感應器與布料電眼正常否，進介面檢測排除
3：進介面檢測排除腳控後踩電壓配對合適否

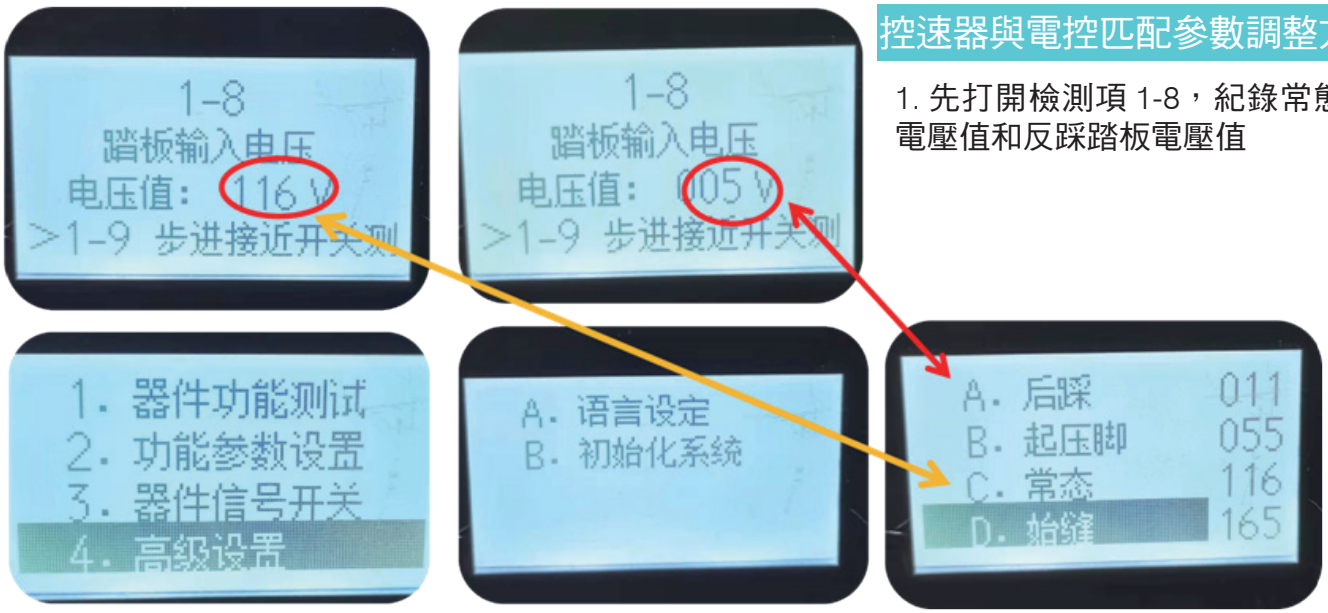
調到檢測項，1-10，在沒有布料擋住電眼的情況下，功能狀態顯示：關閉



用手擋住電眼，功能狀態顯示：開啟
如果沒有變化，即需要檢查電眼 (黃) 插頭是否接觸良好及 或調整電眼參數設置



ACS-200 系列反踩踏板送帶輪不轉



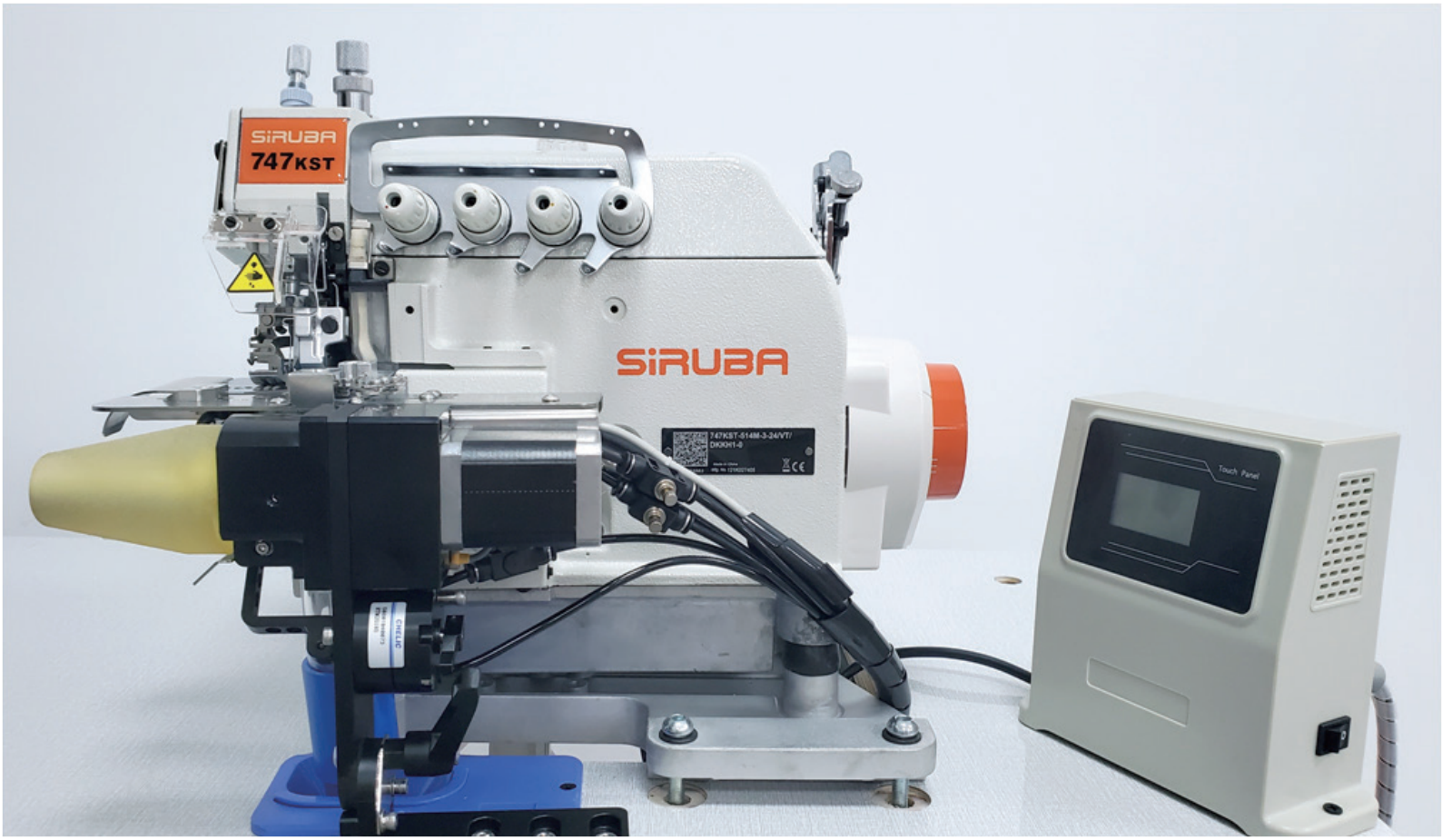
控速器與電控匹配參數調整方法

1. 先打開檢測項 1-8，紀錄常態下電壓值和反踩踏板電壓值

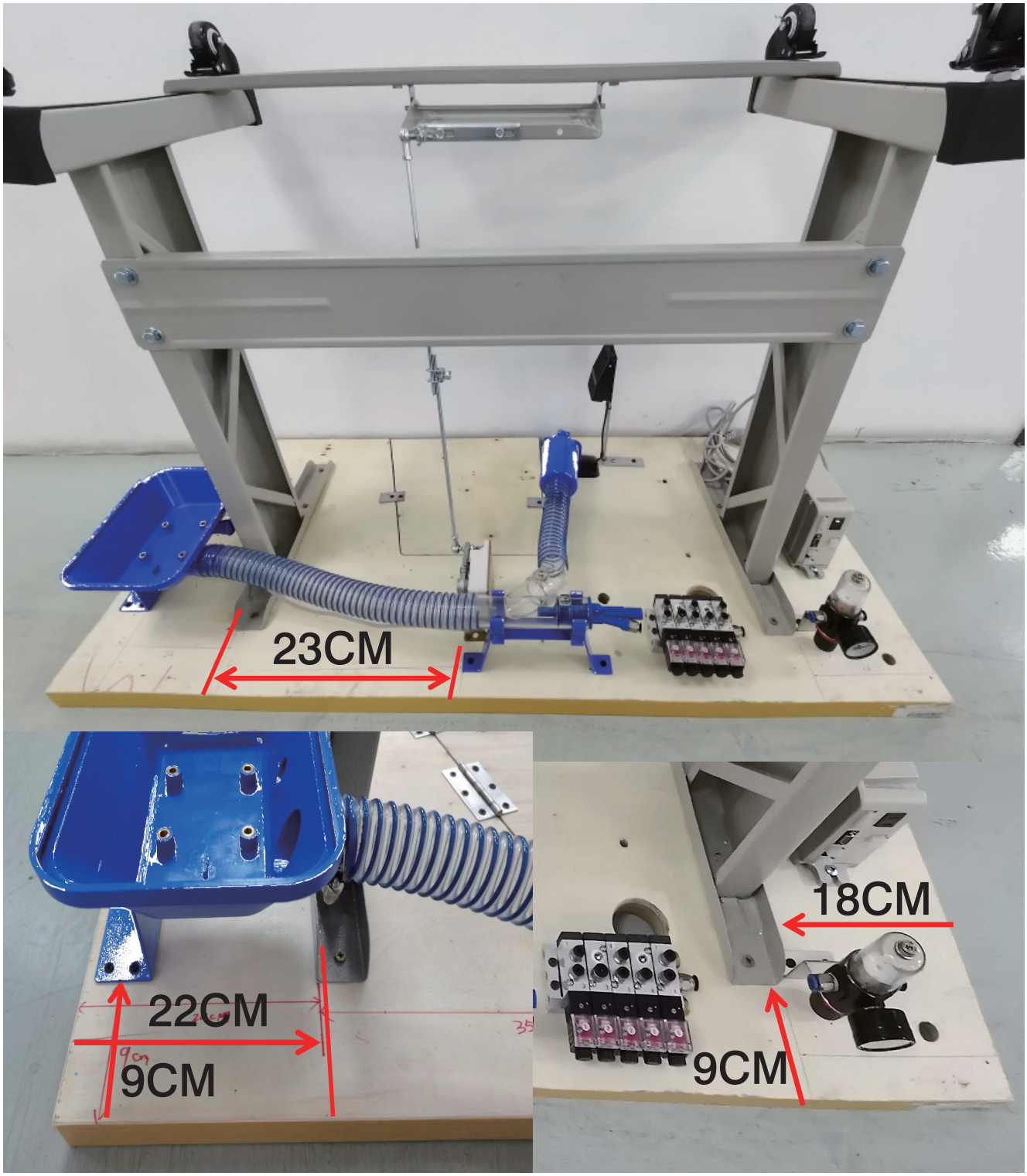
2. 打開高級設置
調到 A-B 兩項都沒有底色進入參數設置

A. 後踩：用於啟動送帶電機，參數調到大於反踩踏板
電壓值 005V，*** 小於 005V 即送帶輪沒法啟動
B. 起壓腳：參數調到後踩和常態中位數
C. 常態：參數調到踏板輸入電壓值 116V
D. 始縫 參數調到比常態大於常態值，116V
*** 始縫如小于常態即會開機電機就自行轉動

GS-ACS-200 series
Automatic Collar Attaching Device Installation Guide

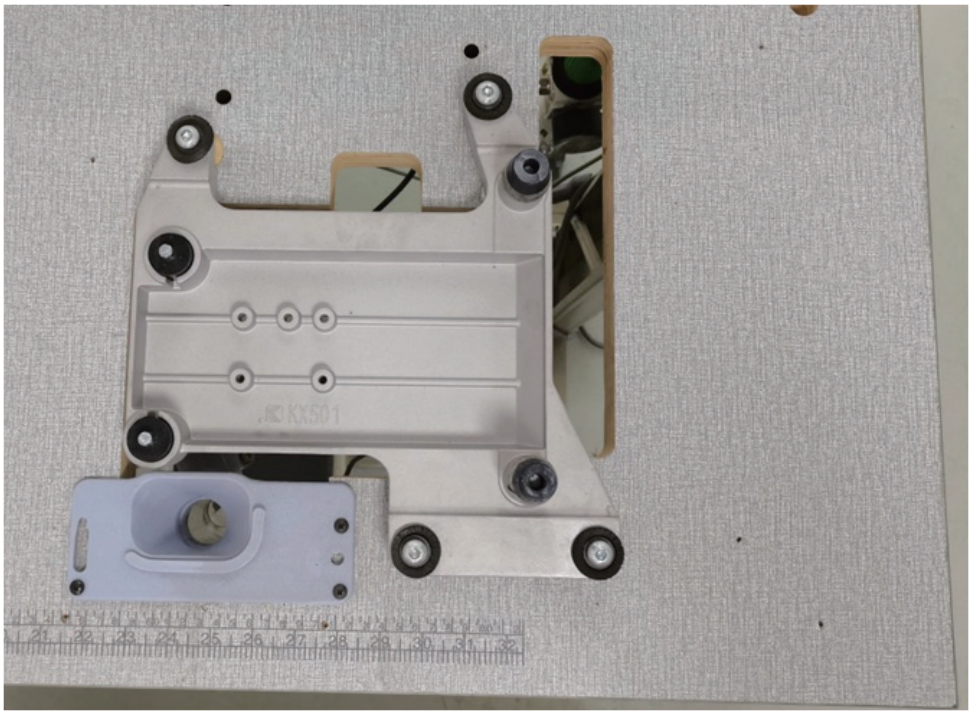


1、Install the stand, dust collector, solenoid, motor, control box and speed controller.

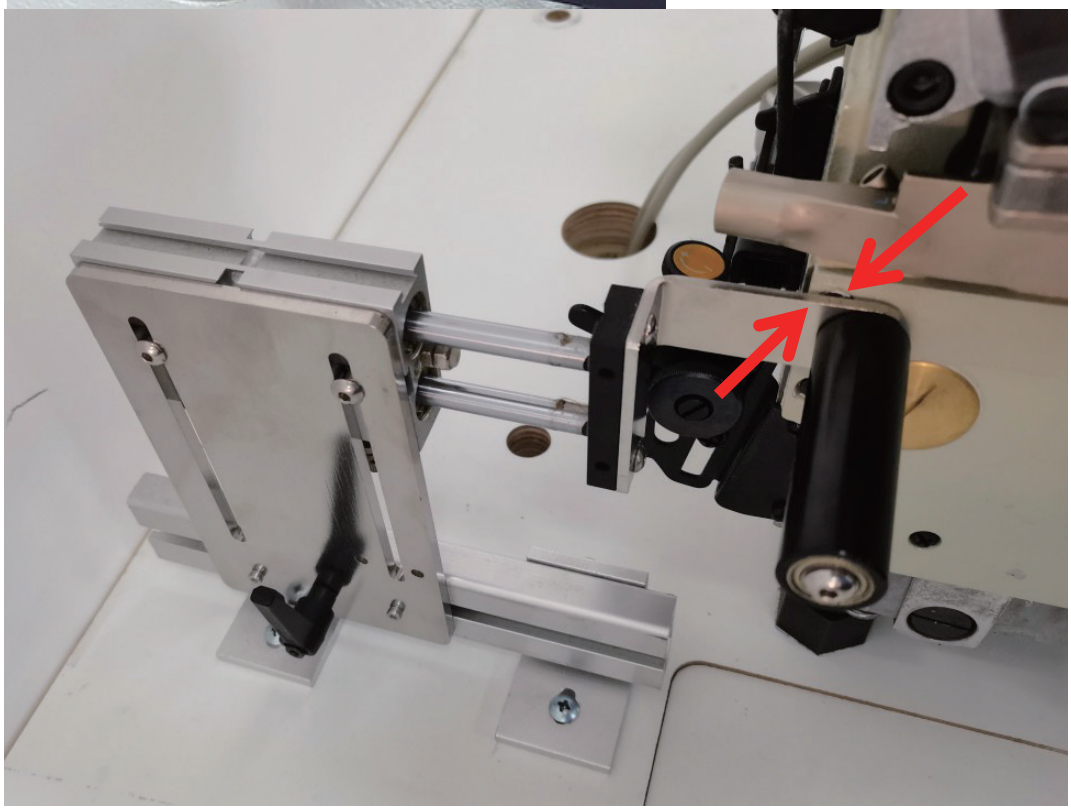


2、Install the funnel, mat, rubber cushion and machine head

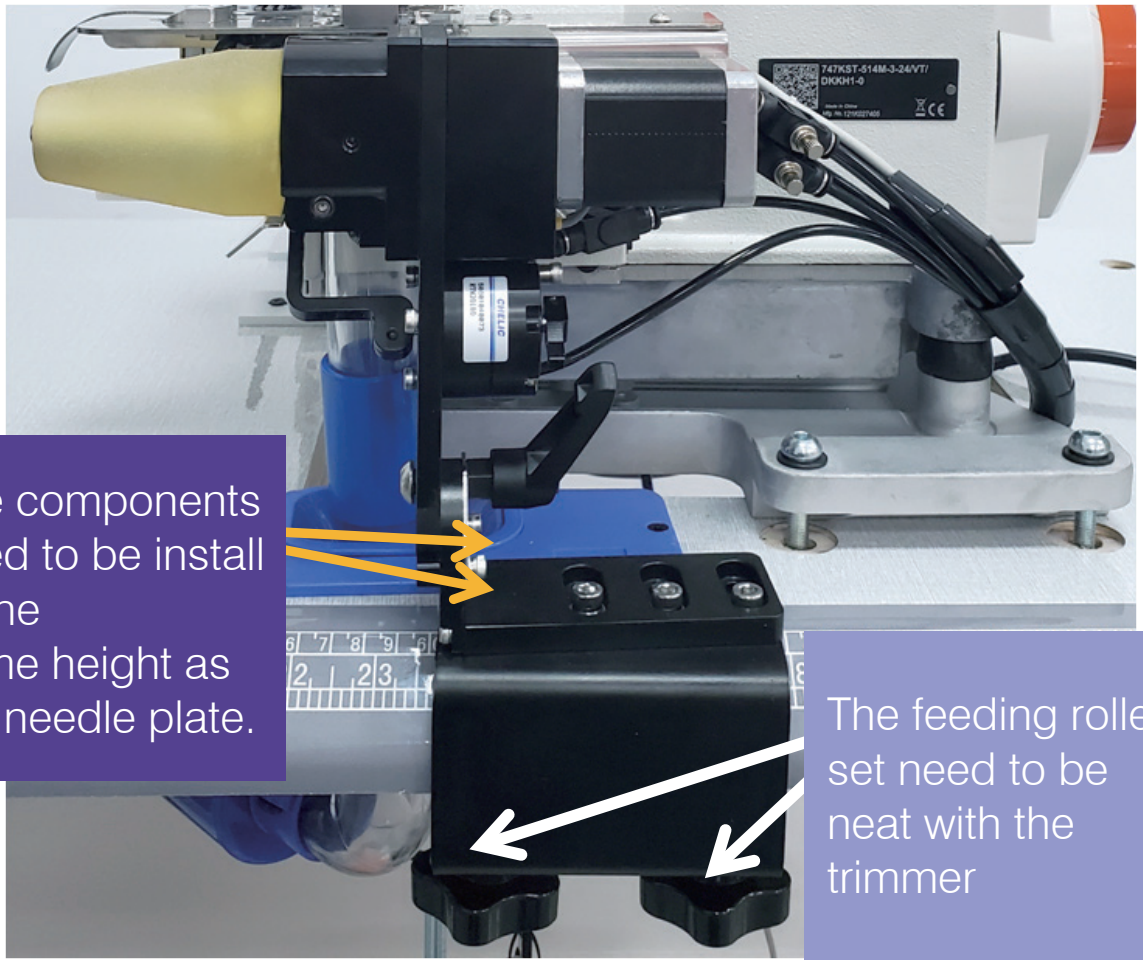
Oil tank install method

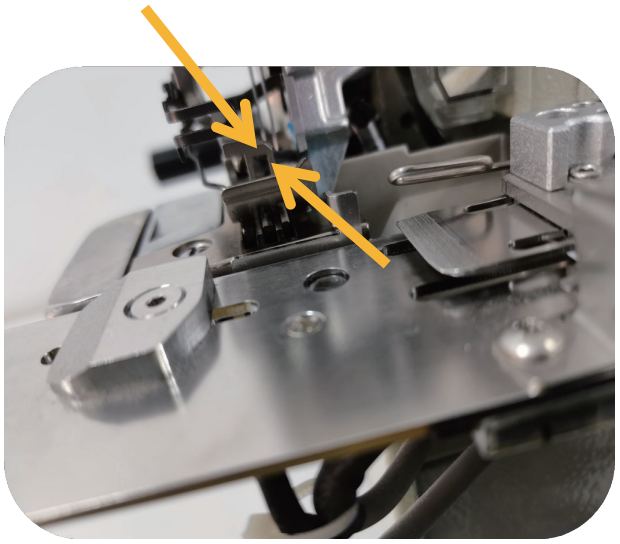


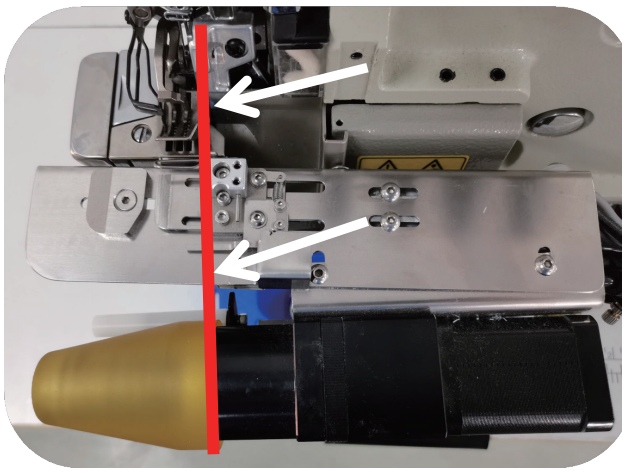
3、Install presser foot cylinder and back roller



4、Installing the feeding roller set

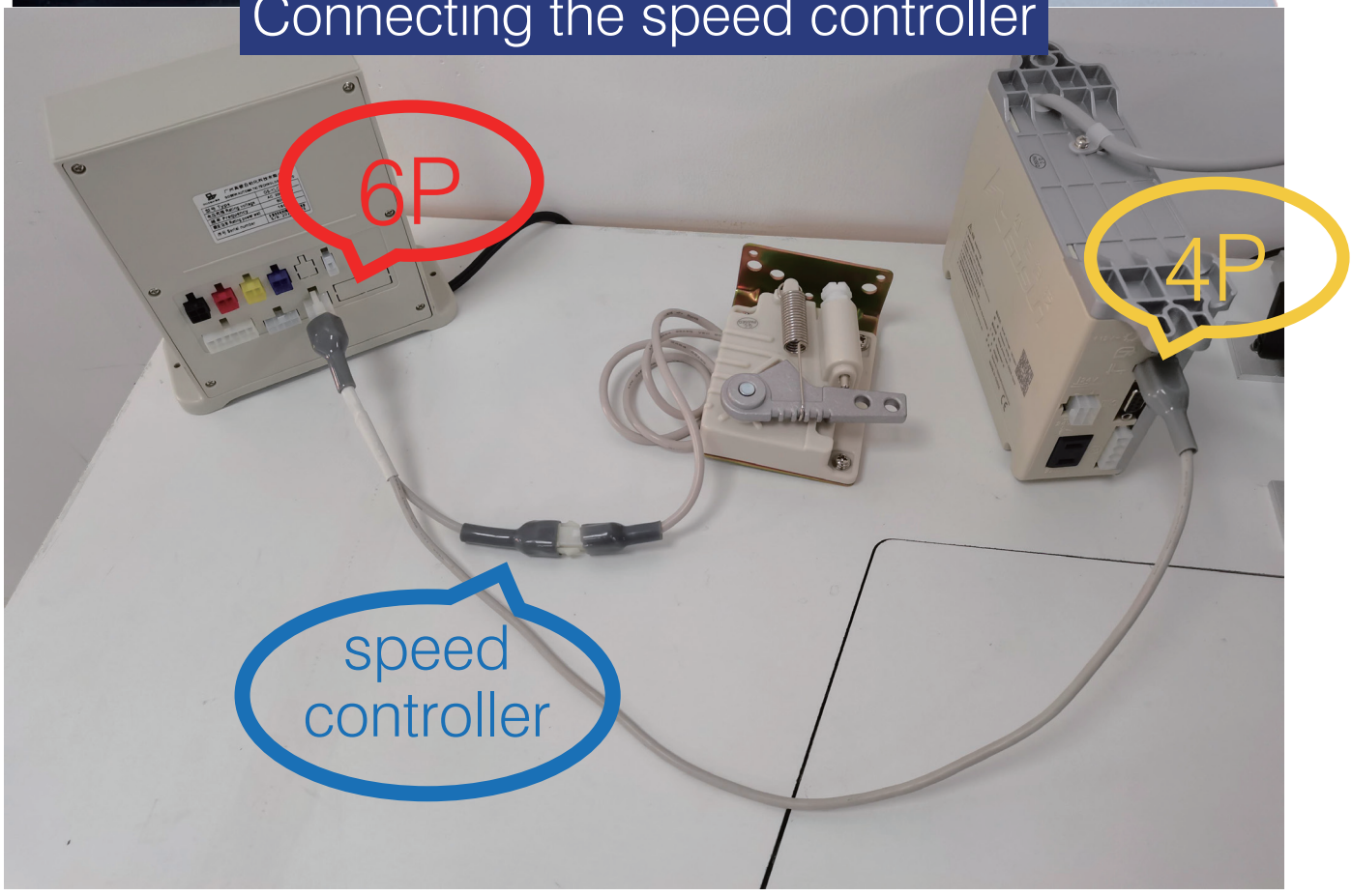




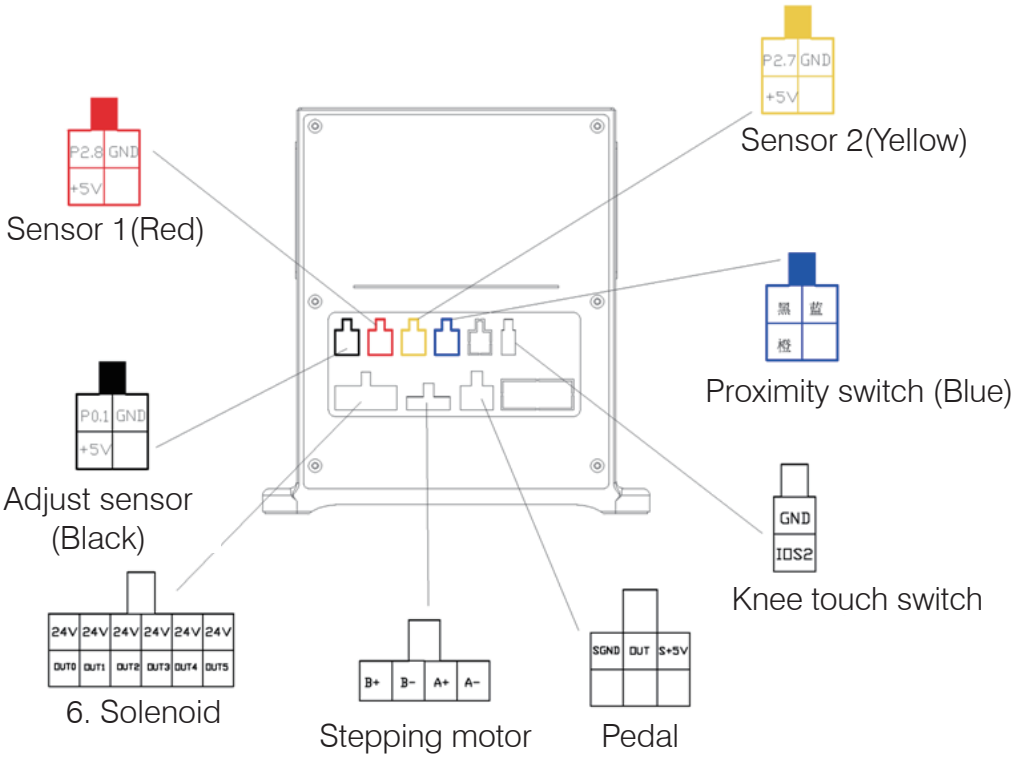


5、Install the ribbed collar device main board

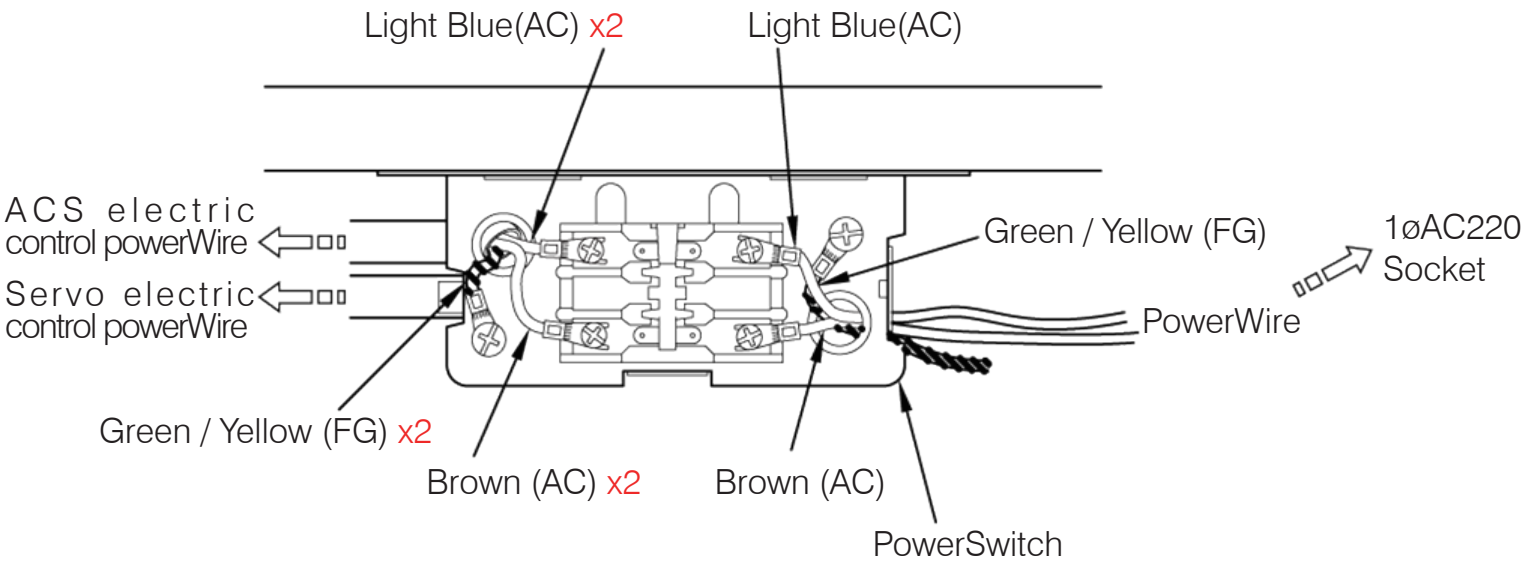
Connecting the speed controller



6、Panel outlet signal indication
(Main terminal diagram)



7、AC 220V wiring method



8、Touch panel collar device operation instructions

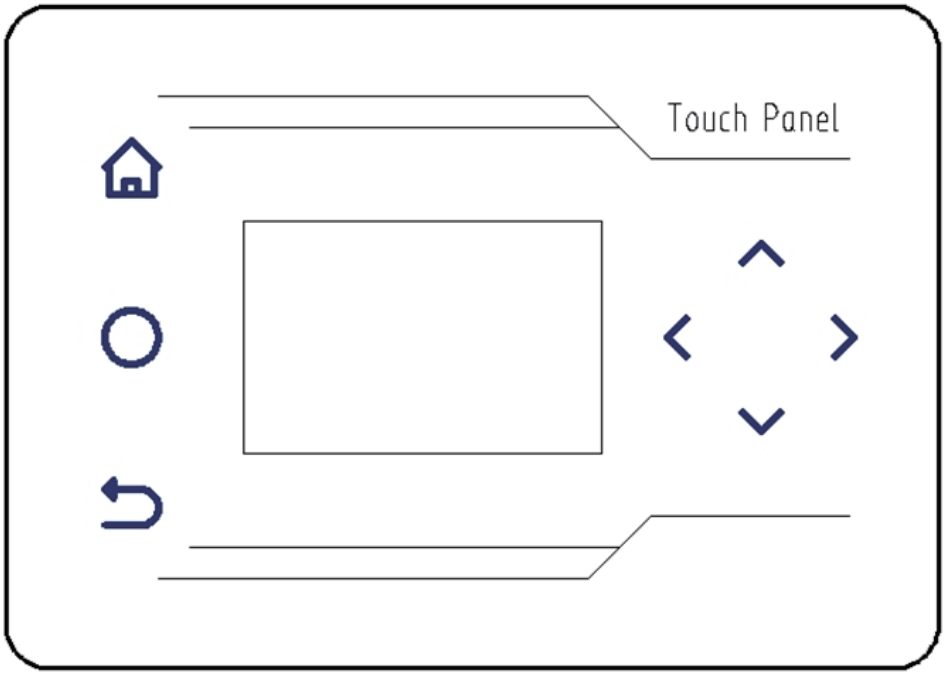


figure 1

1. Instructions for the use of keys

1. Menu key, long press 3 seconds to enter the system parameter modification options.
2. Compensation key, used only in automatic state.
3. Return key, exit parameter modification page, return to work page, and save data.
4. 、Left and right. keys Move the parameters to modify the buoy under the interface of changing engineering parameters. ◦
5. 、Add and subtract keys to change the parameters of various functions.

2. Working mode, the left shift right shift key role

Press , After the key, automatically save and exit the change parameters interface, locking all working states.

1.Press the Left-click to display the data of the last project value.

2.Press the Right-click to display the data for the next project value.

3. Description of display window

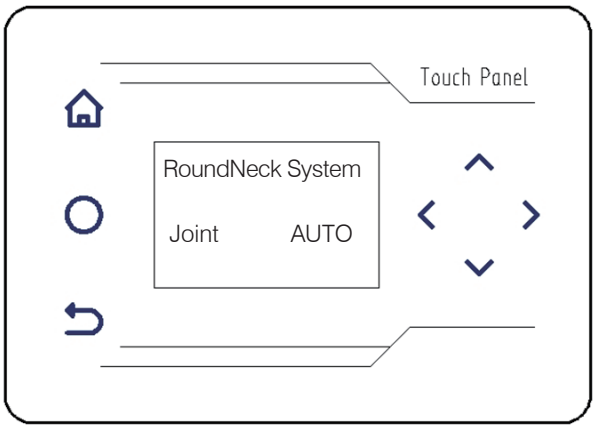


figure 2

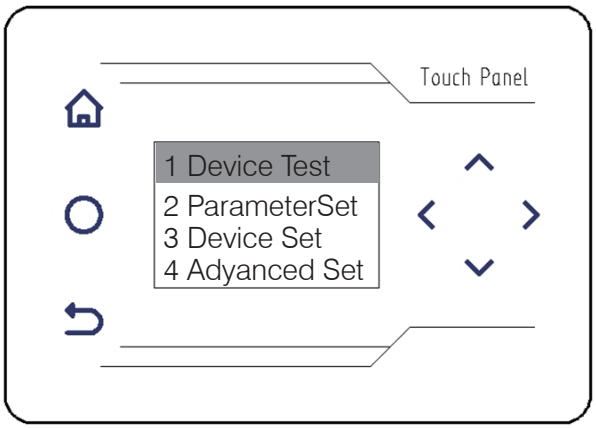


figure 3

Working status display

The round collar system device is displayed by default after starting up (figure 2). ，Pass the ^ v Add and subtract keys to change automatic mode or manual mode.

Parameter function setting display interface:

Short press 3 seconds to Enter the parameter setting interface（figure 3）：

1. Device Test
2. Parameter Set
3. Device Set
4. Advanced Set

4. Interface operation instructions

A. Device function test :

Short press 3 seconds to Enter the parameter setting interface, pass ^、v Add button,Select "device test",Pass > Right click，Enter the sub-menu interface (figure 4) :

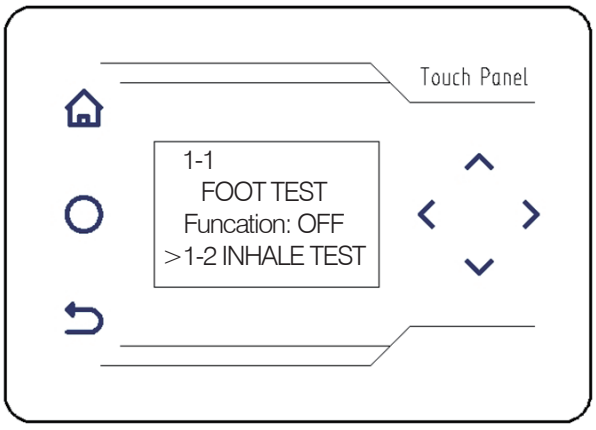


figure 4

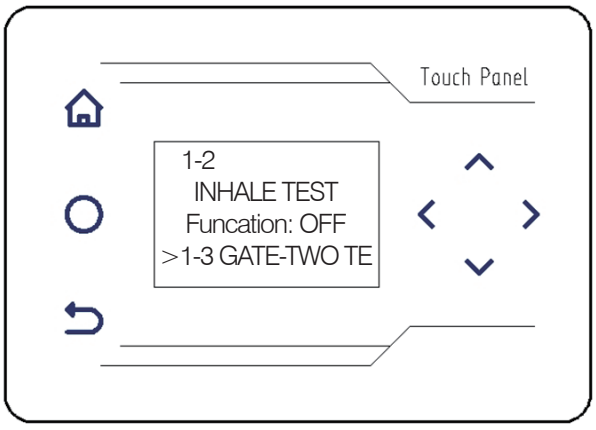


figure 5

The functional state of each device is "off" by default.As shown in figure 4 (" pressure foot function test "), during the test,

Long press The key for 3 seconds,The function state changes from "off" to "on";At this point the corresponding solenoid valve

work, the solenoid valve indicator light is on, indicating that the device function is normal.

loosen key , The function state is restored to the default "off" (first 6 device function test options).

Pass the Right click to enter the next device function test options, device function test options 1 to 6 (figure 4 to figure 9) :

1-1 FOOT TEST

1-2 INHALE TEST

1-3 GATE TWO TEST

1-4 GATE-THR TEST

1-5 GATE-FUR TEST

1-6 MOTIR TEST

1-7 MCOUNT

1-8 T INPUT

1-9 SW-A STATE

1-10 SW-B STATE

1-11 SW-C STATE

1-12 CHK-TIME

1-13 LOOP TEST

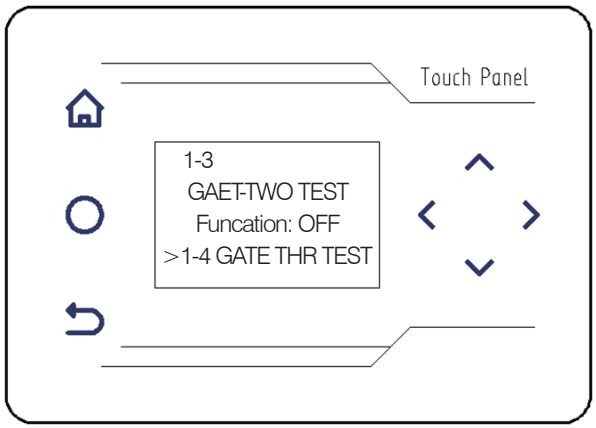


figure 6

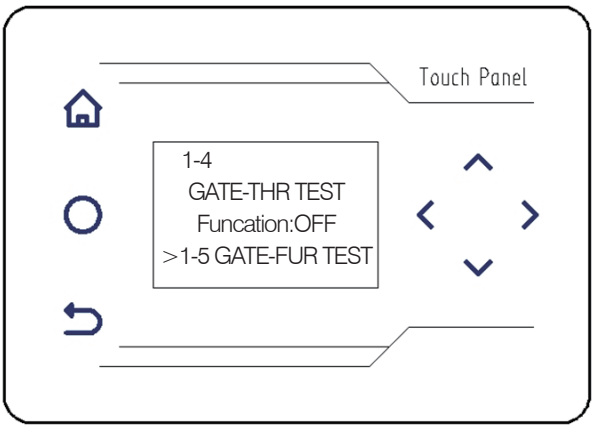


figure 7

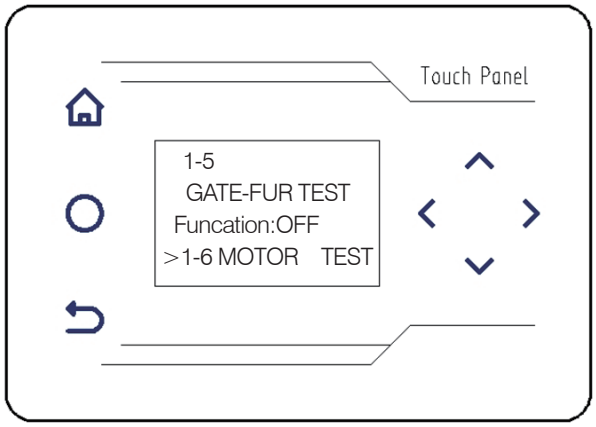


figure 8

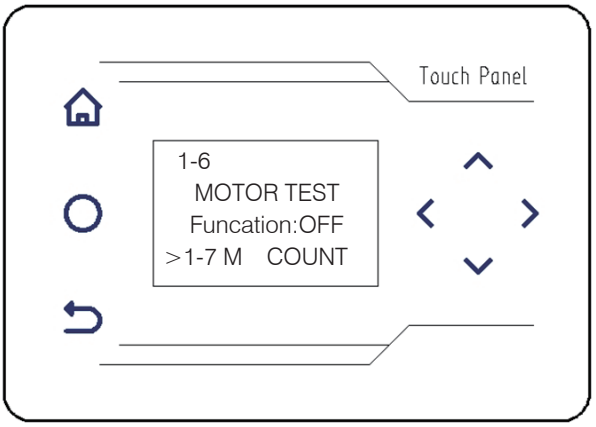


figure 9

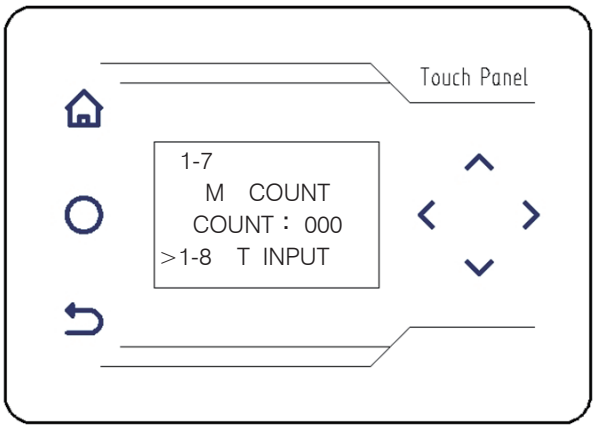


figure 10

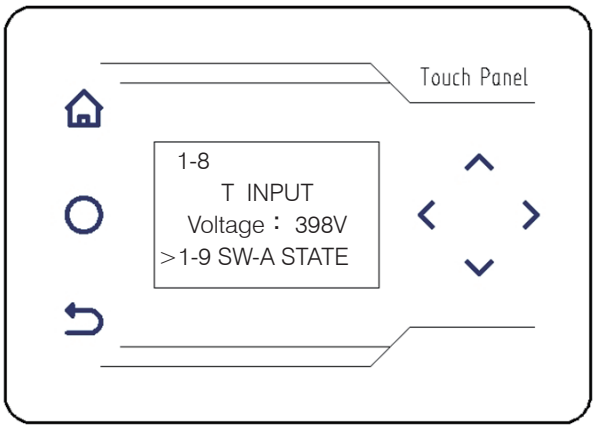


figure 11

1-7 encoder count value (figure 10)

Debugging of encoder count value (display 000 by default), select "1-7 encoder count value" option (through the left button ＜ and right button ＞), turn the handwheel on the machine, the encoder count value will increase by 1 for each turn (positive and negative rotation can be used), indicating that the encoder works normally.

1-8 pedal input voltage (figure 11)

Debug the pedal input voltage (between 140V and 150V by default). Select the "1-8 pedal input voltage" option (through the left button and right button), step on the pedal and step backward towards the heel, the pedal input voltage value will be 000-015v;When stepping towards the tiptoe, the voltage rises to 460-470v.

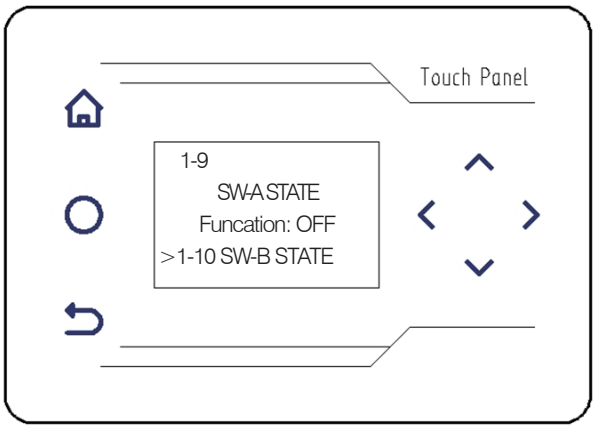


figure 12

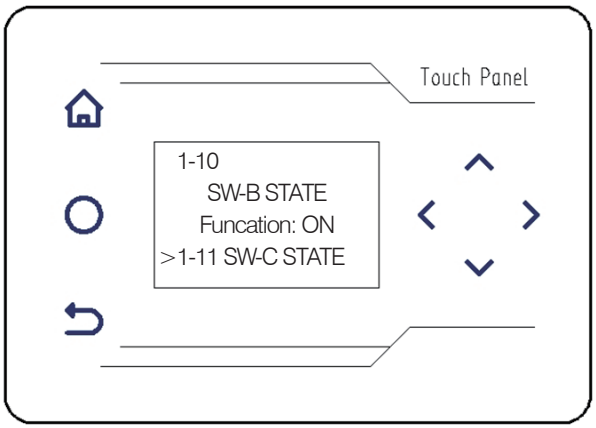


figure 13

1-9 proximity switch test (figure 12)
Step proximity switch test (default function state: open) debugging, (through the left button < , right button >) select the "1-9 step proximity switch test" option, gently press the "step proximity switch trigger", display, "function state" from "open" to "off", indicating that "step proximity switch" is normal.

1-10 fabric detection switch test (figure 13)
Debugging of fabric detection switch test (default function state: open). Select the option of "1-10 fabric detection switch test" (through the left < and right buttons >). When covering the photoelectric sensor of fabric detection on the mechanism and the display, the "function state" changes from "open" to "off", indicating that the "fabric detection switch" is normal. (figure 14)

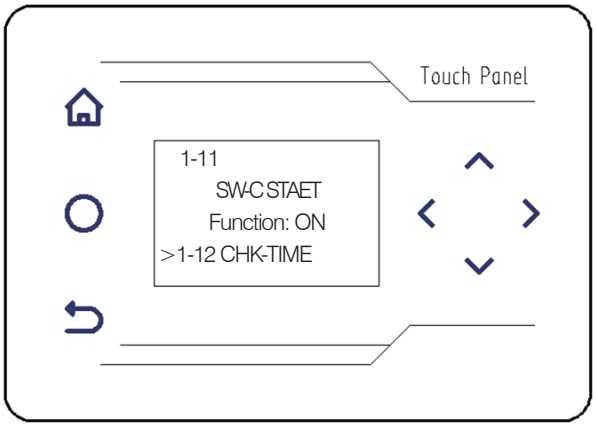


figure 14

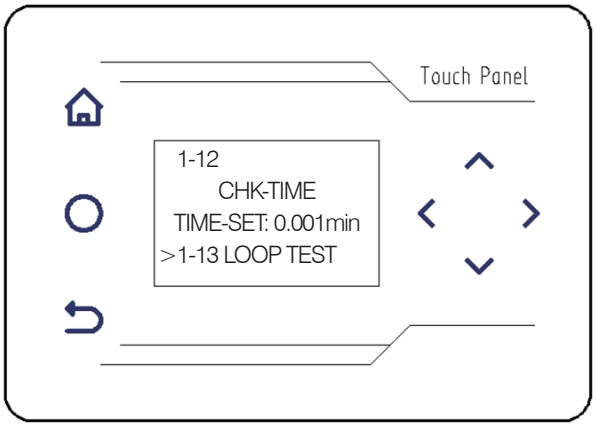


figure 15

1-11 splitter detection switch test (figure 14)
Debugging of material distribution detection switch test (default function state: open). Select the option of "1-11 material distribution detection switch test" (through the left and right buttons). When covering the photoelectric sensor of material distribution detection on the mechanism and the display, the "function state" changes from "open" to "off", indicating that "material distribution detection switch" is normal.

1-12 stop time (figure 15)
The default parameter value of stop switch is 1 minute. This value is the factory setting. Please do not adjust it.

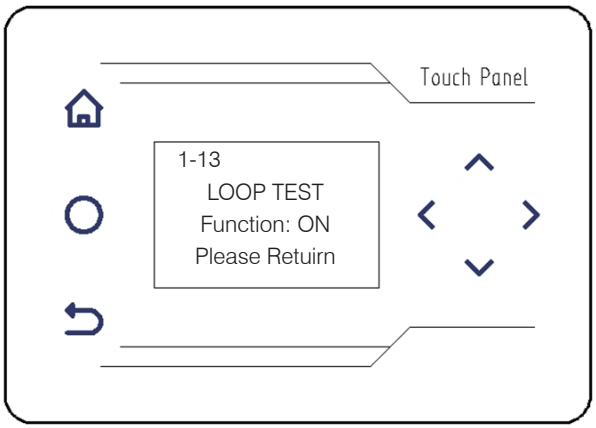


figure 16

1-13 cyclic function test (figure 16)

Debug the loop function test (default function state: open). Select the option of "1-13 loop function test" (through the left ＜ and right buttons ＞). After the selection, the machine will automatically loop test the above 12 functions and make corresponding actions. Press the return key and the machine stops testing and returns to the upper interface (figure 3).

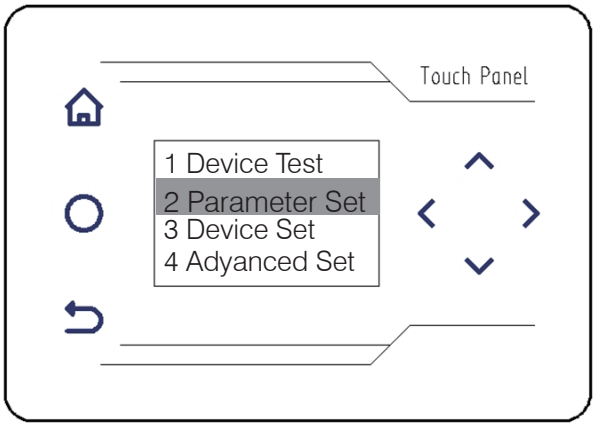


figure 17

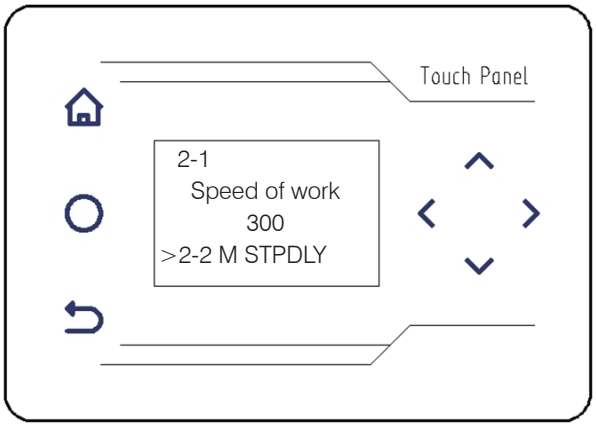


figure 18

B. Function parameter setting

Press 、 add or subtract, select "function parameter setting" (figure 17), press the right button , and enter the sub-menu interface (figure 18) :

2-1 feeding speed (figure 18)

Feeding speed (default 300 RPM) is set. Feeding 、 speed can be adjusted or closed by adding or subtracting keys.

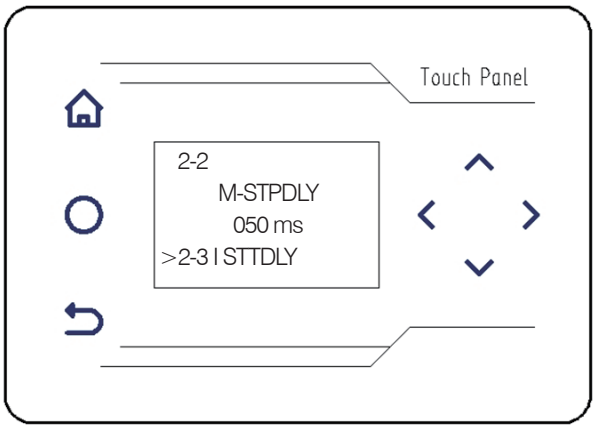


figure 19

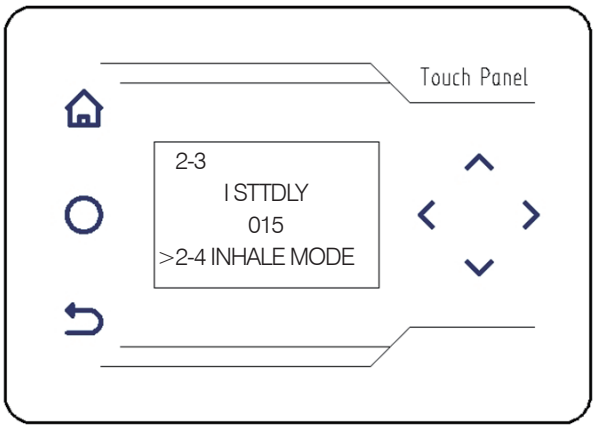


figure 20

2-2 stop position of aggregate (figure 19)

The aggregate stop position (default 50ms) is set. The aggregate stop position can be adjusted by ^ 、 v adding and subtracting keys.

2-3 backward suction delayed stitches (figure 20)

Set the number of delayed stitches (15 stitches by default) of the rear suction air. The number of stitches can be adjusted ^ 、 v to control the start time of the suction air through the add/subtract keys.

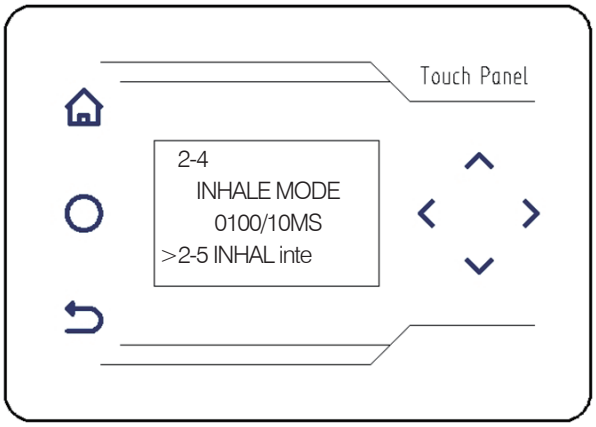


figure 21

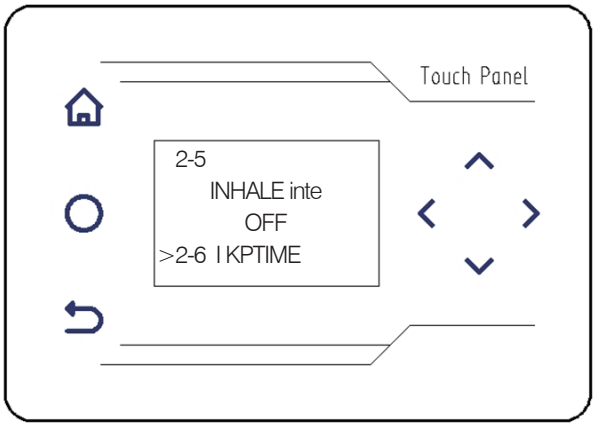


figure 22

2-4 air suction holding time (figure 21)

The air suction holding time (default 1000ms) is set. The air suction holding time can be adjusted by ^ 、 v adding and subtracting keys.

2-5 pre-medium suction mode (figure 22)

Pre-middle air suction mode (pre-middle air suction is closed by default) setting.Pre-middle air suction can be turned on or off by ^ 、 v adding or subtracting keys.

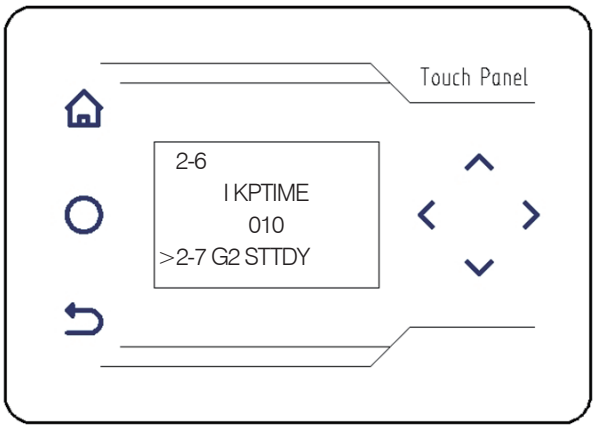


figure 23

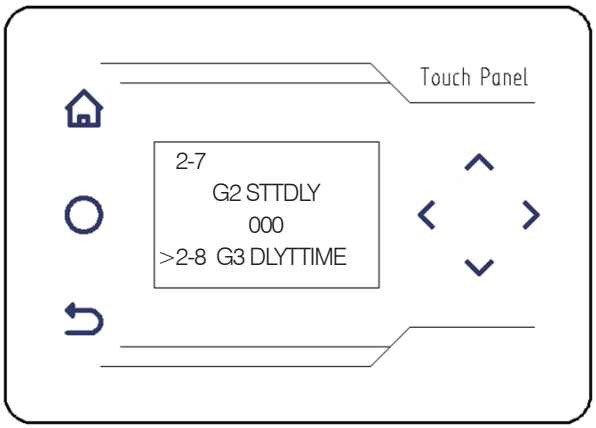


figure 24

2-6 number of air suction spacers (figure 23)
Set the number of air suction interval stitches (10 stitches by default). The number of air suction interval stitches can be adjusted by ^ 、 v adding or subtracting keys.

2-7 feeding start delay (figure 24)
Start delay of feeding (default: 0ms) is set. Start delay of feeding can be adjusted by ^ 、 v adding or subtracting keys.

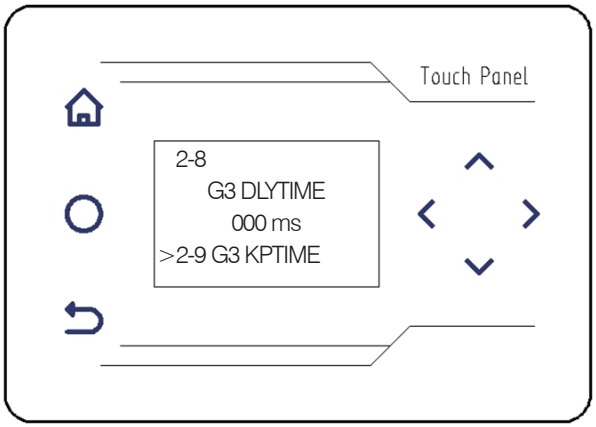


figure 25

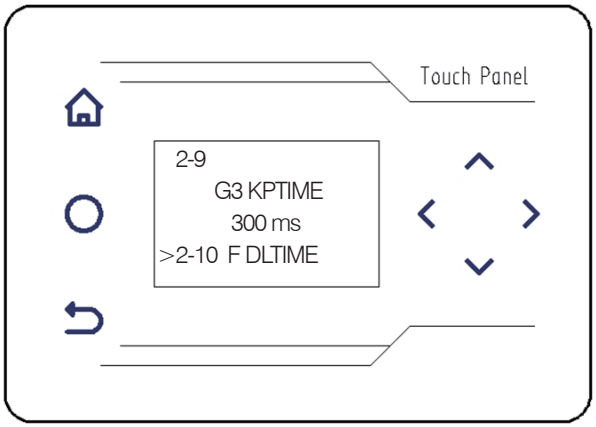


figure 26

2-8 Brake delay time (figure 25)
The delay time of brake (default 0ms) is set, and the delay time of brake start can be adjusted by ^ 、 v adding and subtracting keys.

2-9 brake holding time (figure 26)
Brake holding time (default: 300ms) is set. Brake holding time can be adjusted by ^ 、 v adding and subtracting keys.

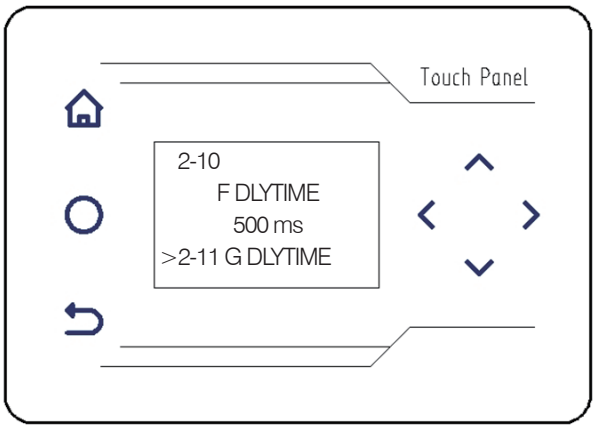


figure 27

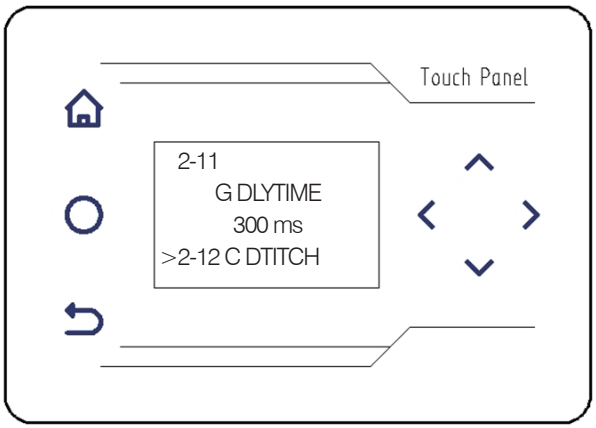


figure 28

2-10 delay time of pressing foot (figure 27)

The delay time of pressing foot is set (default is 500ms). The delay time of pressing foot can be adjusted by ^ 、v adding or subtracting keys.

2-11 delay time of material separation (figure 28)

Material delay time (default: 300ms) is set. Material delay time can be adjusted by ^ 、v adding or subtracting keys

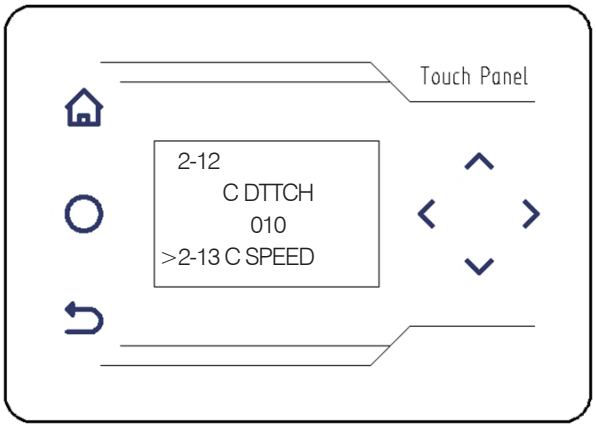


figure 29

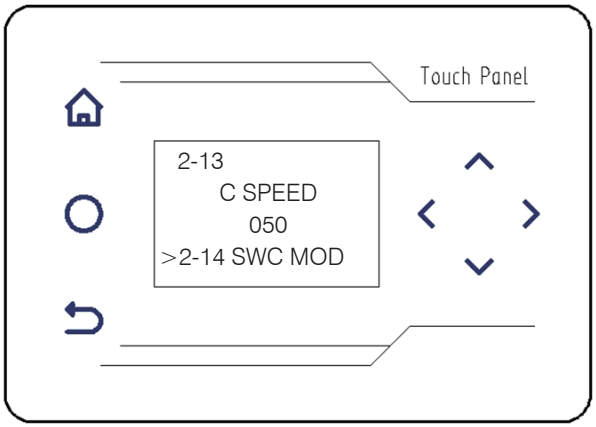


figure 30

2-12 manual compensation car suture needle count (figure 29)

Manual compensation car suture needle count (default) Settings, through, ^ 、v switch, adjustable compensation car number of stitches.

2-13 manual sewing speed compensation (figure 30)

Hand sewing speed compensation (50) by default Settings, through, ^ 、v the switch, the sewing speed can be adjusted to compensate.

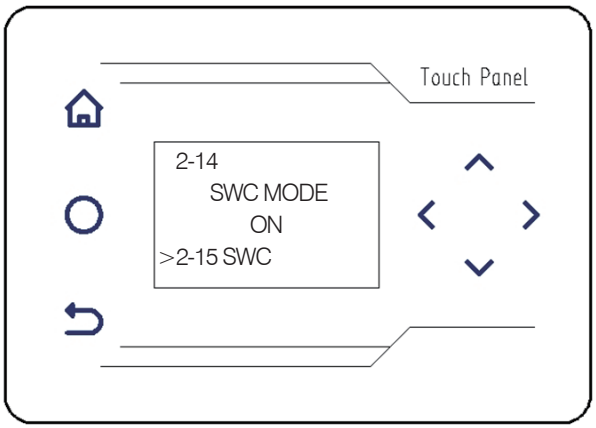


figure 31

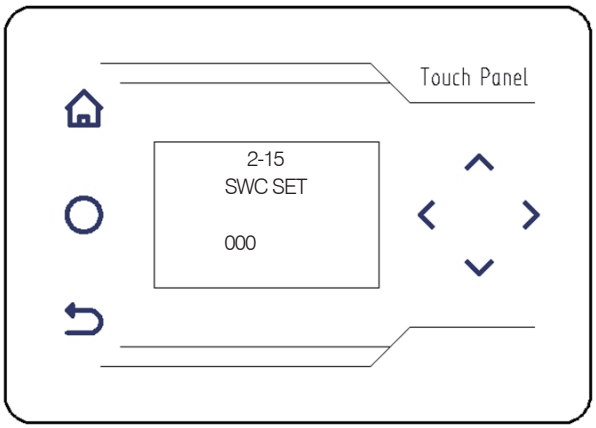


figure 32

2-14 working mode of electric eye for separating material (figure 31)

The working mode (default ON) of the electronic eye of material distribution is set. ^ 、 v The electronic eye switch of material distribution can be closed or opened through the add or subtract keys.

2-15 setting of electric eye parameters (figure 32)

Electronic eye parameter setting (the default value is uncertain) is set. The "set" value can be adjusted by ^ 、 v adding or subtracting keys. The "receive value" will automatically change accordingly.

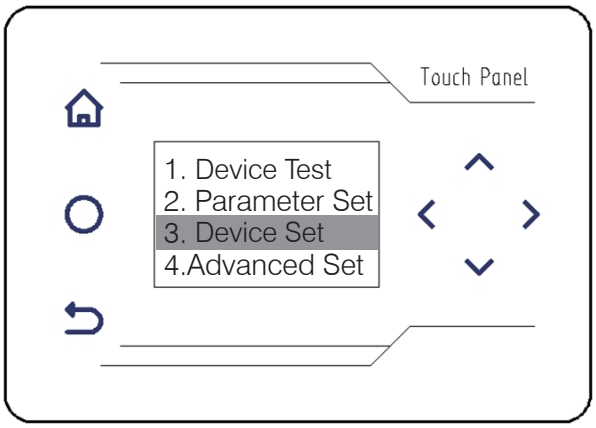


figure 33

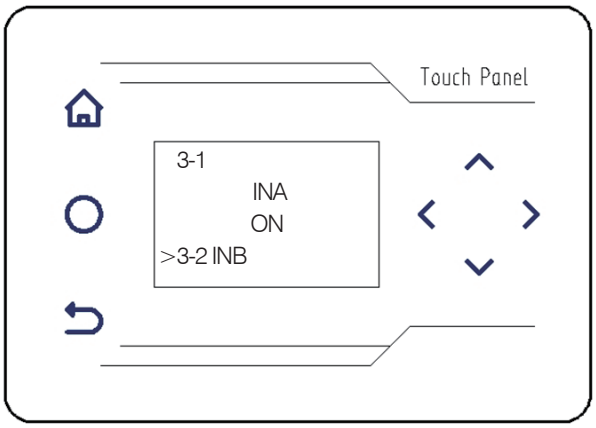


figure 34

C. Device signal switch

Press, ^ 、 v add or subtract, select "device signal switch" (figure. 33), press the right button >, and enter the sub-menu interface (figure. 34) :

3-1 signal direction of knee action switch (figure 34)

The signal direction of the knee action switch (default ON) is set, ^ 、 v and the knee action switch signal can be turned off or turned ON through the add or subtract keys.

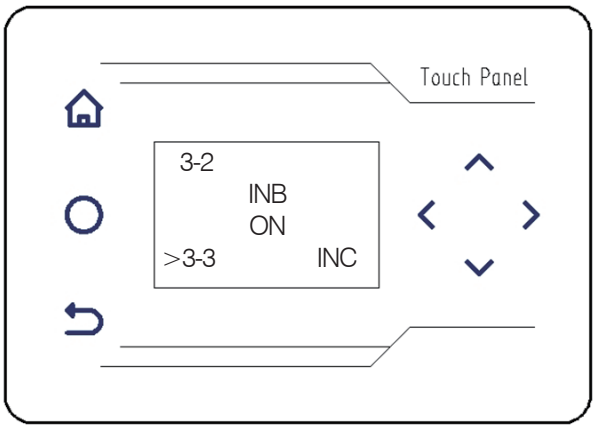


figure 35

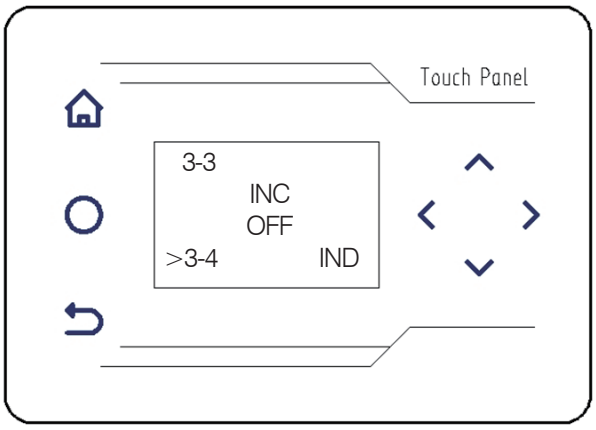


figure 36

3-2 Step approach switch (figure 35)

Step proximity switch (default ON) setting, ^ 、 v through the key, add/subtract, you can turn off or open step proximity switch.

3-3 Cloth detection of electric eye signal (figure 36)

Cloth detection electrical eye signal (default OFF) setting, ^ 、 v through the key, add/subtract, can open or close cloth detection electrical eye signal.

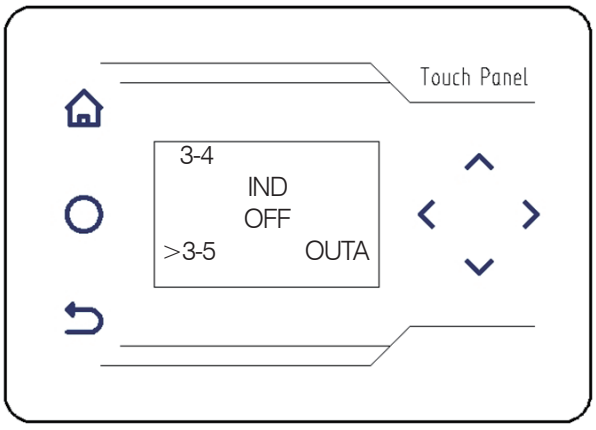


figure 37

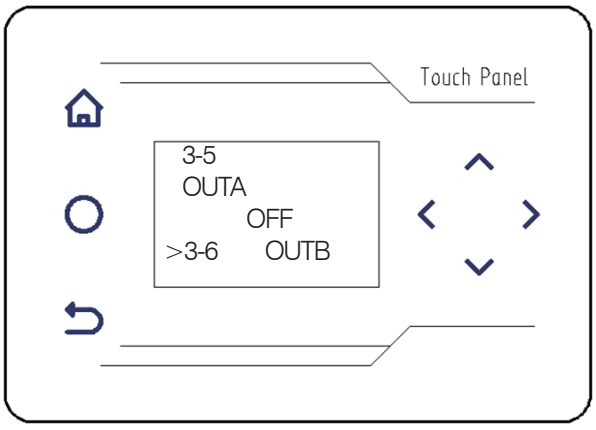


figure 38

3-4 electronic eye signal of material separation detection (figure 37)

Electronic eye signal for material splitting detection (default OFF) setting, ^ 、 v can be turned on or OFF by add/subtract keys.

3-5 pressure foot control signal output (figure 38)

Press foot control signal output (default OFF) setting. ^ 、 v Press foot control signal output can be turned on or OFF by adding/subtract keys

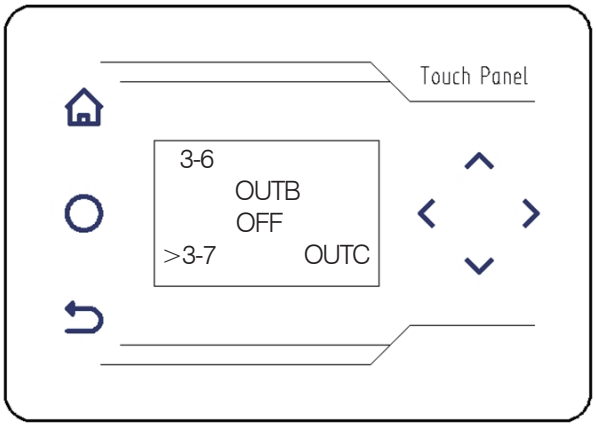


figure 39

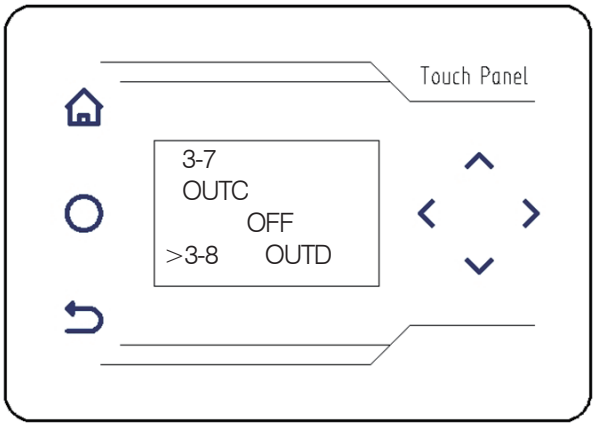


figure 40

3-6 Signal output of r Absorption control system (figure 39)

Absorption control signal output (default OFF) setting, ^ 、v can be turned on or OFF by add/subtract keys.

3-7 Support control signal output (figure 40)

Support control signal output (default OFF) setting, through the key, add/subtract, ^ 、v can open or close the pressfoot control signal output

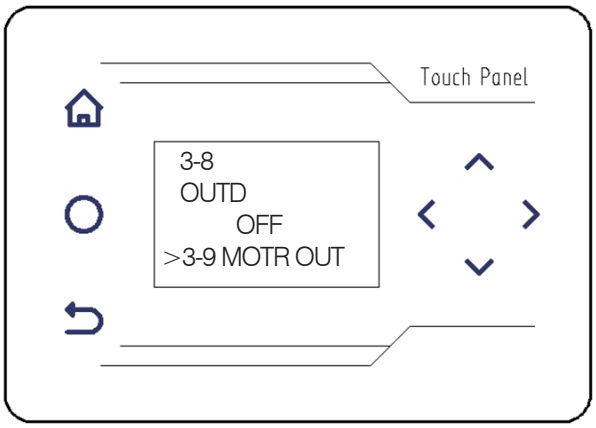


figure 41

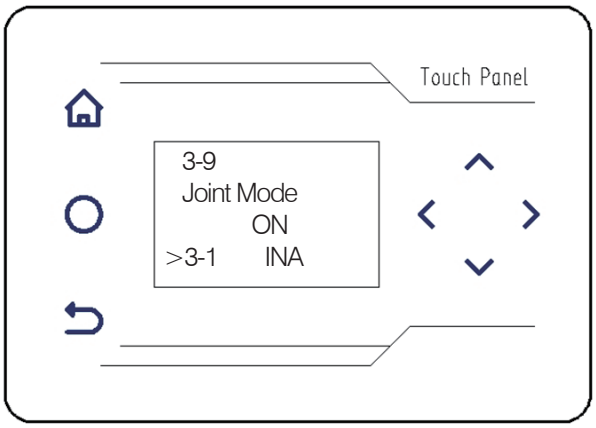


figure 42

3-8 brake control signal output (figure 41)

The output of the brake control signal (default OFF) is set. ^ 、v The output of brake control signal can be turned on or OFF by add/subtrac keys.

Step 3-9 Joint detection (figure 42)

Seam detection (default ON) setting, ^ 、v through the key, add/subtract, Can turn on or off the seam position detection function

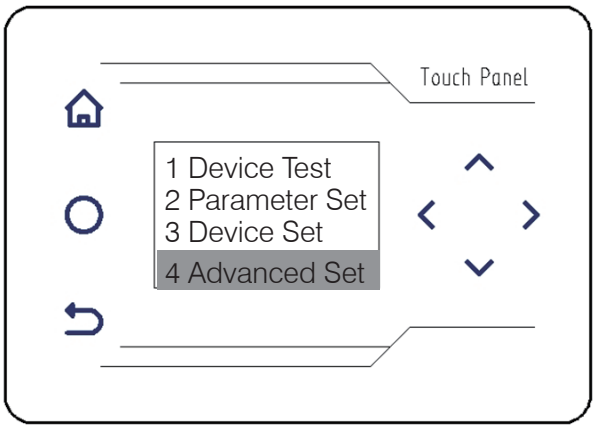


figure 43

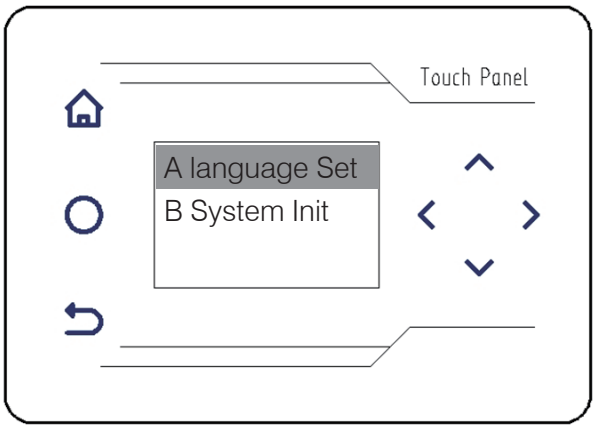


figure 44

D. Advanced Settings

Press, ^、v add/subtract, to select "advanced Settings" (figure 43), press the > right button, to enter the sub-menu interface. (figure 44)

A. Language setting (figure 44)

Press the > right button to enter the sub-menu interface (figure 45).

Press ^、v the add/subtract button to select the system language " 简体中文 " or "English".

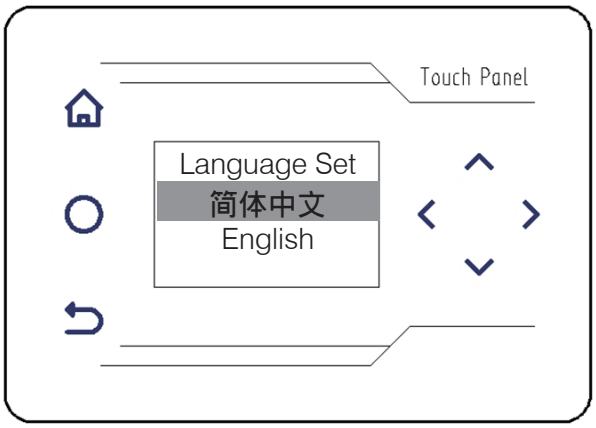


figure 45

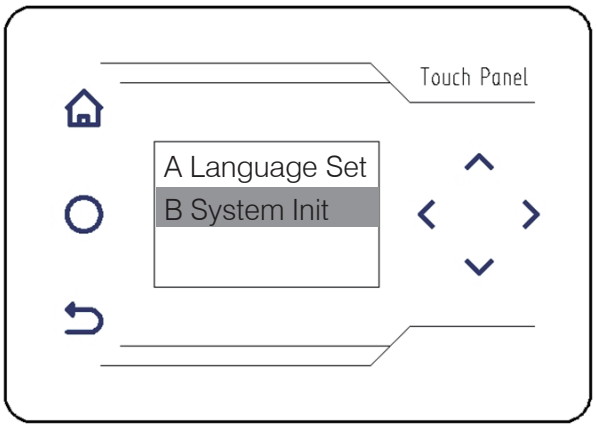


figure 46

B. Initialize the system (figure 46)

Under the sub-menu interface of "advanced Settings", press, ^、v add/subtract, select "initialization system" (figure 43), press the > right button, and the system will restore the factory Settings, namely "initialization system".

Speed controller parameter settings (Hidden Setting)

Under the sub-menu interface of "advanced Settings", press, ^ 、v add/subtract, select and press" initialization system" (figure 46),

Press again v Add/subtract button, until interface appears (figure 47), press > right button, enter the speed controller parameter settings (figure 48), "Speed controller parameter settings" is a hidden setting. Used for factory adjustment only not open to the public.

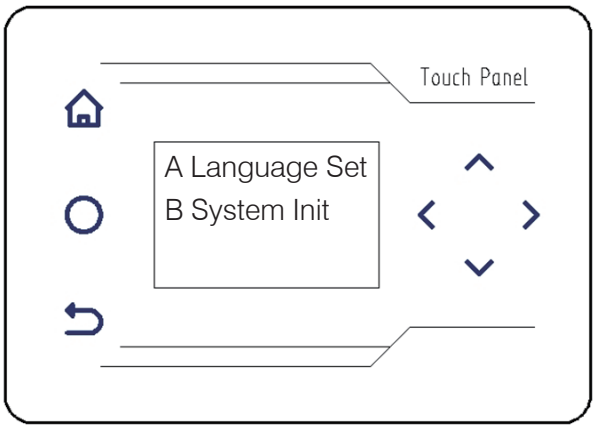


figure 47

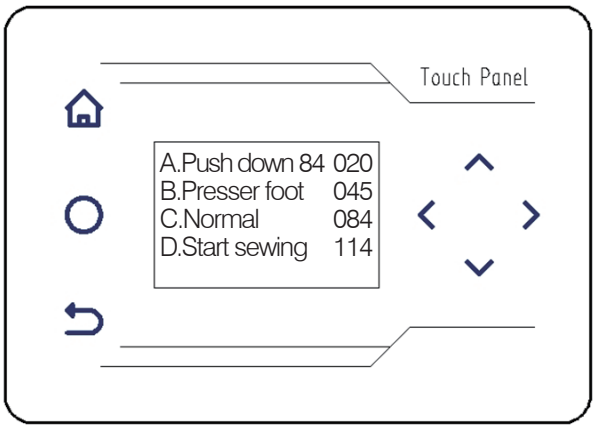


figure 48

The following voltage values are set accordingly to a real-time of the four states of the pedal.

As shown in figure 48:

84 is the neutral state voltage value

84 will change to 05 when fully press down (note that different brand of motors will have different values)

A.Voltage value when pressing down（=05+015）：020

B.Voltage value when lifting presser foot=（084+05）/2：045

C.Voltage value when neutral：084

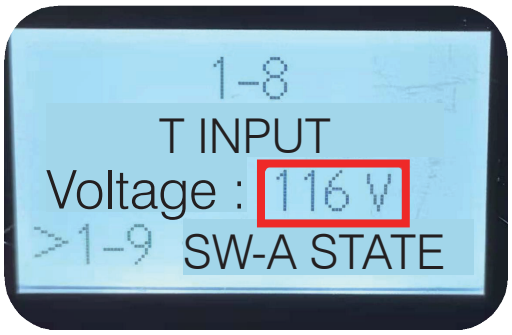
D.Voltage value when pressing up and sewing starts.（greater than neutral 》30）：114

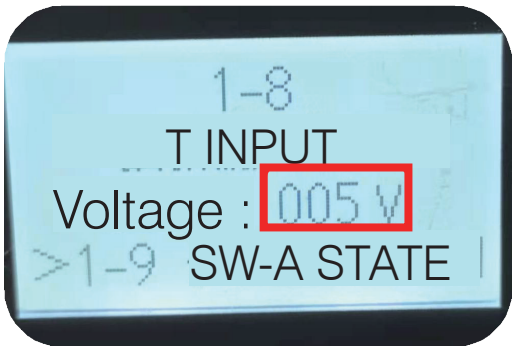
9、Parameters

1.Device function test	2.Function Parameters setting	Default	3.Device signal ON/ OFF	Default	4.Advance setting
1-1 Press foot function test	2-1 Feeding speed	300	3-1 Knee touch ON/OFF signal	ON	A.Language settings
1-2 Suction function test	2-2 Seam stop position	50	3-2 Step proximity ON/OFF	ON	B.initialization system
1-3 Support cylinder test	2-3 Back suction delay stiches	10	3-3 Material sensor signal	OFF	
1-4 Break cylinder test	2-4 Suction time	100	3-4 Material separation sensor signal	OFF	Both lines without background
1-5 Material separation cylinder test	2-5 Front suction mode	turn off front, mid-suction	3-5 Presser foot control signal input	OFF	Push down：
1-6 Stepping motor test	2-6 Mid-suction interval stiches	100	3-6 Suction control signal output	OFF	Presser foot
1-7 Encoder value	2-7 Start feeding delay	0	3-7 Material support control signal output	OFF	Normal：
1-8 Pedal voltage import	2-8 Break delay time	0	3-8 Break control signal output	OFF	Start sewing：
1-9 step approach ON/OFF test	2-9 Break hold time	300	3-9 Seam detaction	ON	
1-10 Material sensor test	2-10 Presser foot delay time	500			
1-11 Material separation ON/ OFF test	2-11 Material separation delay time	300			
1-12 Step stop switch time	2-12 Manual conpensation stiches	10			
1-13 Loop function tesst	2-13 Manual compensation RPM	50			
	2-14 Material separation sensor mode	ON			
	2-15 Sensor parameters settings				

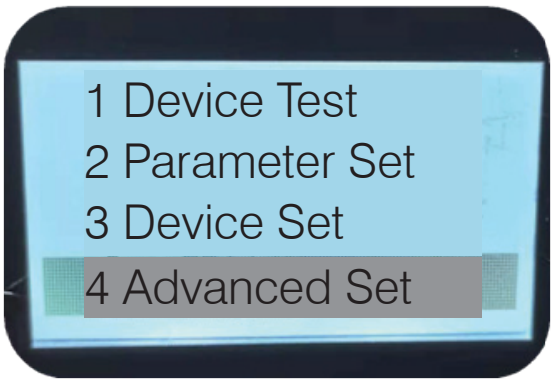
10、Setting the parameters for the speed controller

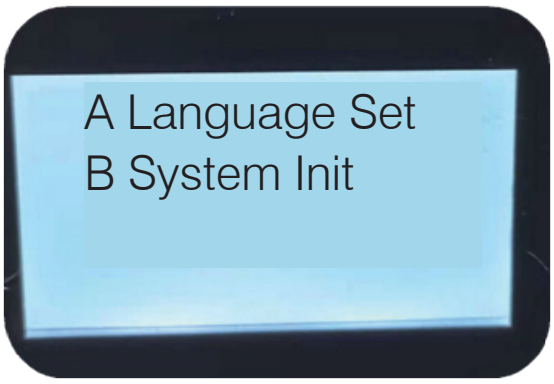
①、Select examination 1- 8, record the voltage value on normal state and the voltage value when the pedal is push down.





②、Select advance settings, and When A-B do not have any background, entrer the parameters setting.





A. Adjust the parameters to when the value is greater than the pedal voltage value when push down.
***If its lower, it will not work.

B. When lifting the press foot: set the parameter value to the median value between when the pedal is normal and push down.

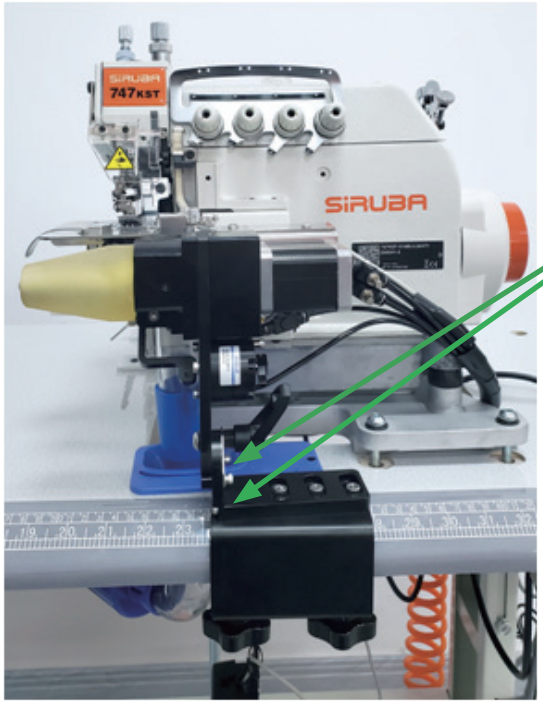
C.Normal: Set the parameter same as voltage value when the pedal is not use.

D.Sewing: Adjust the parameters to plus 30 greater than when normal.
***If when sewing the parameter is lower the normal value, the motor will turn on automatically.

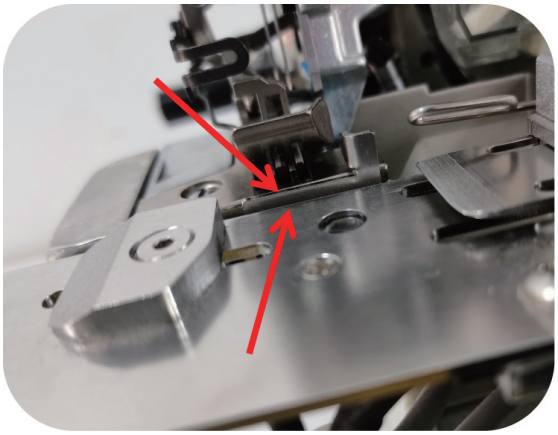
③、Press ⮌ the return button, save settings and exit.

11、Installation and maintenance adjustment

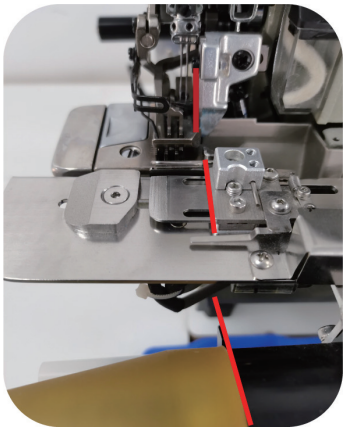
Distribution device height adjustment



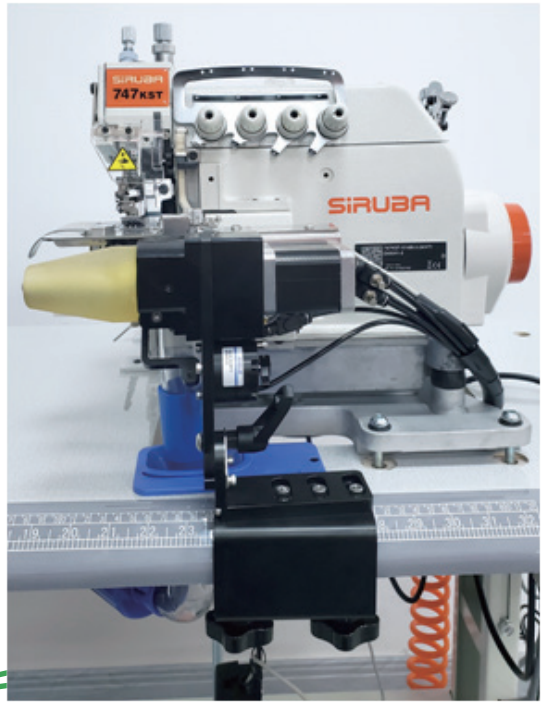
The hight of the distribution device need to be the same as the needle plate.



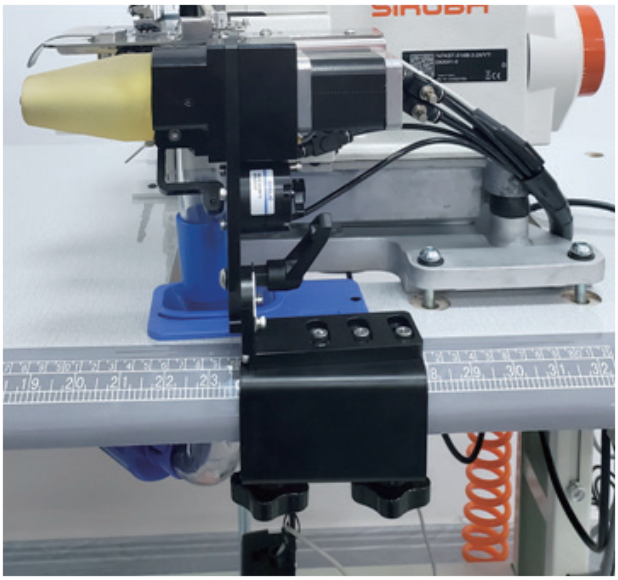
Distribution device left and right adjustment

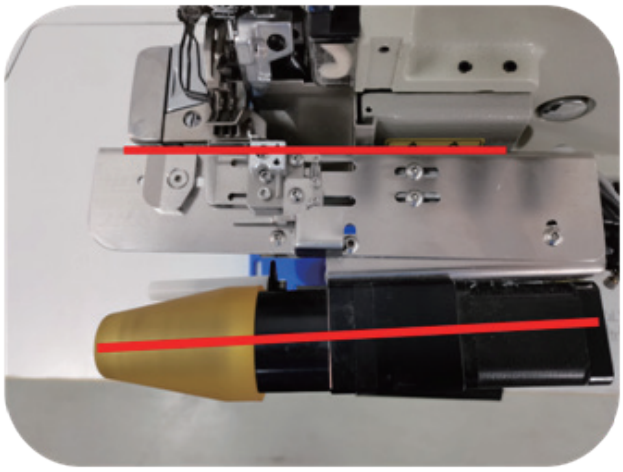


Adjust the left and right position of the distribution device, push the right plate all the way to the left and move the set until same set is align with the trimmer.



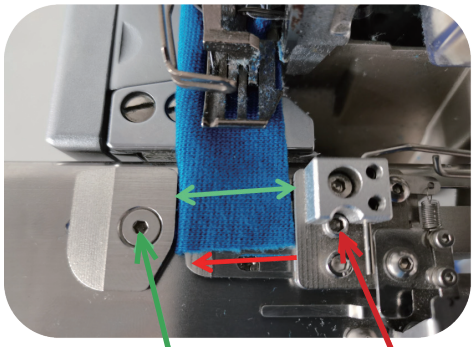
Stepping motor angle setting

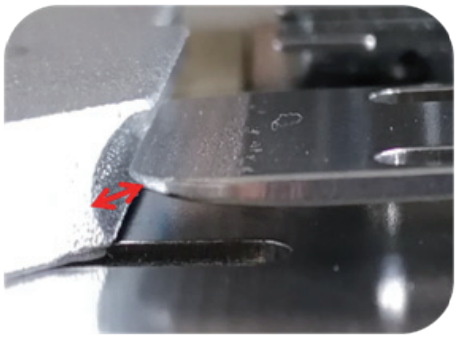




Adjust the angle between the stepping motor and the machine for about 5 degrees. (Adjust according to the rib fabric) the material distribution set needs to be parallel to the machine. Leave a gap between the machine and the distribution device to prevent collision.

Adjusting rib width

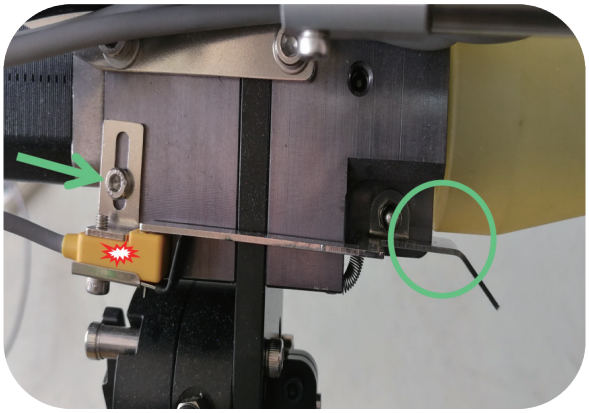


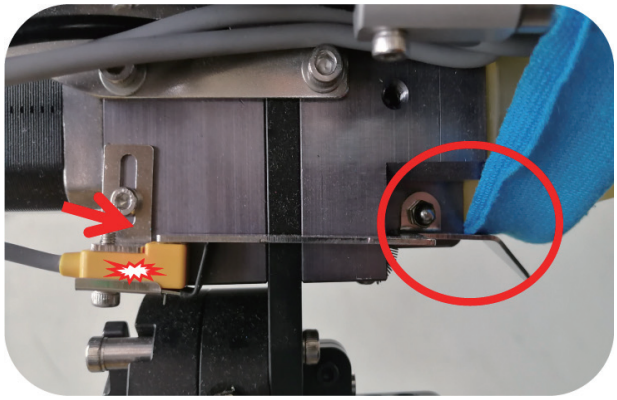


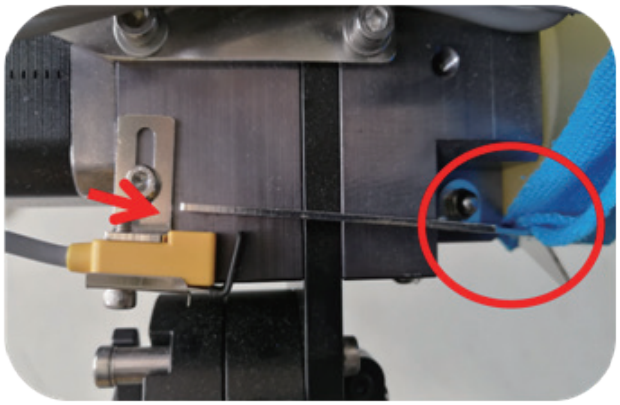
1. Shift the right side plate to all the way to the right and adjust the left side plate to where the distance between the left and right plate is the same as the width of the rib.

2. Push the distribution piece to the left and leave 1mm between the left side plate (depending on the rib thickness) The smaller the gap the better.

Seaming sensor adjustment

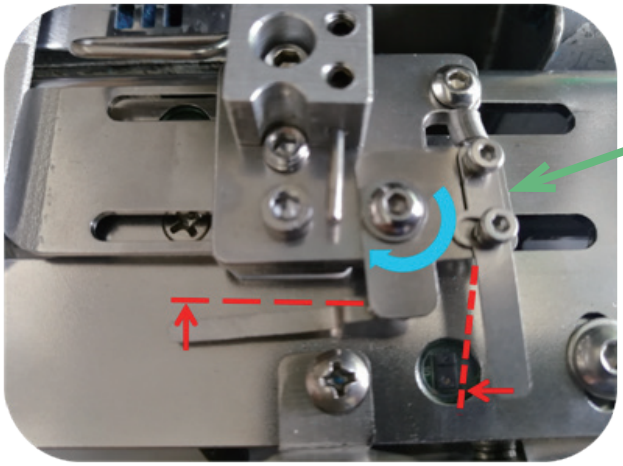






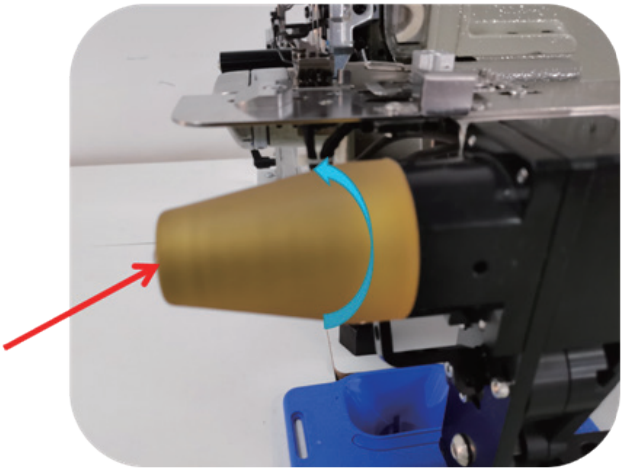
according to the thickness to adjust the high of sensor. Normally the sensor is light on. seaming sewing though sensor sheet would be left sensor and light off.

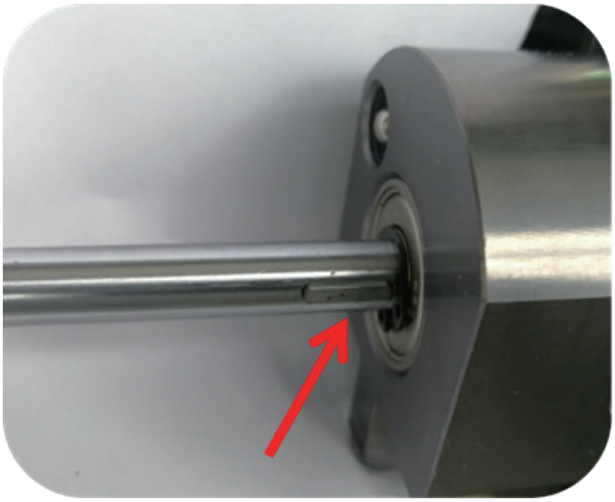
Auto distribution sensor device adjustment



sensor sheet move 2mm ahead. adjust sensor reflection sheet position in order to reflect light from reflection sheet by though sensor. distribution device auto reset.

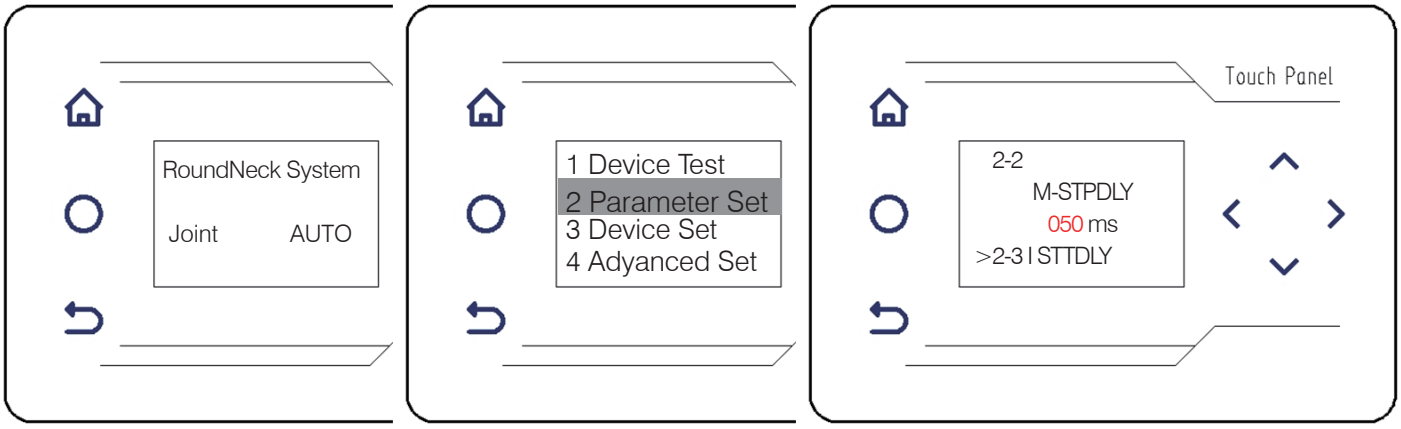
Thread stock issue solution





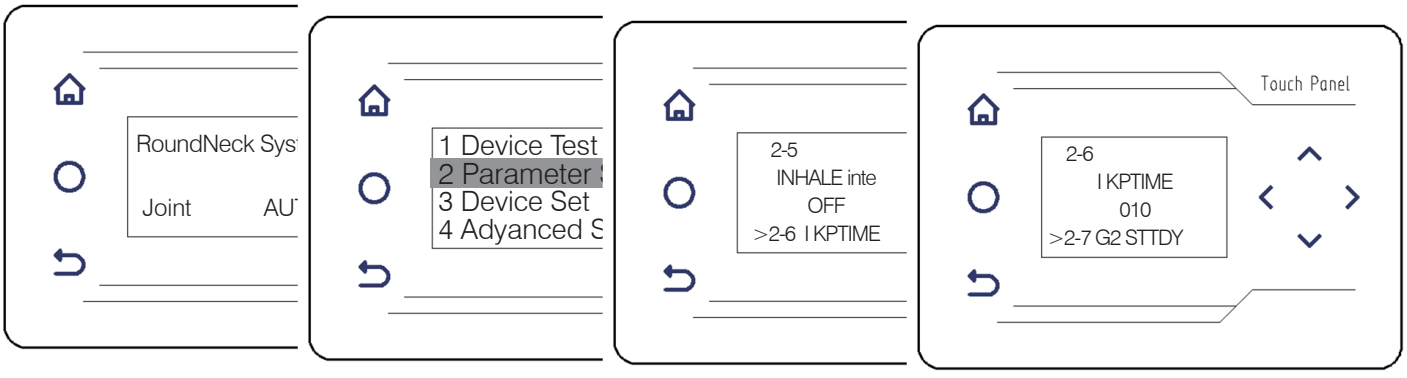
step motor feed tape roller. single direction rolling. negative position rolling would make it unsmooth and fail rib-fabric seaming and thread stock. need to take off feeding tape roller and clean.

Stopping auto position setting



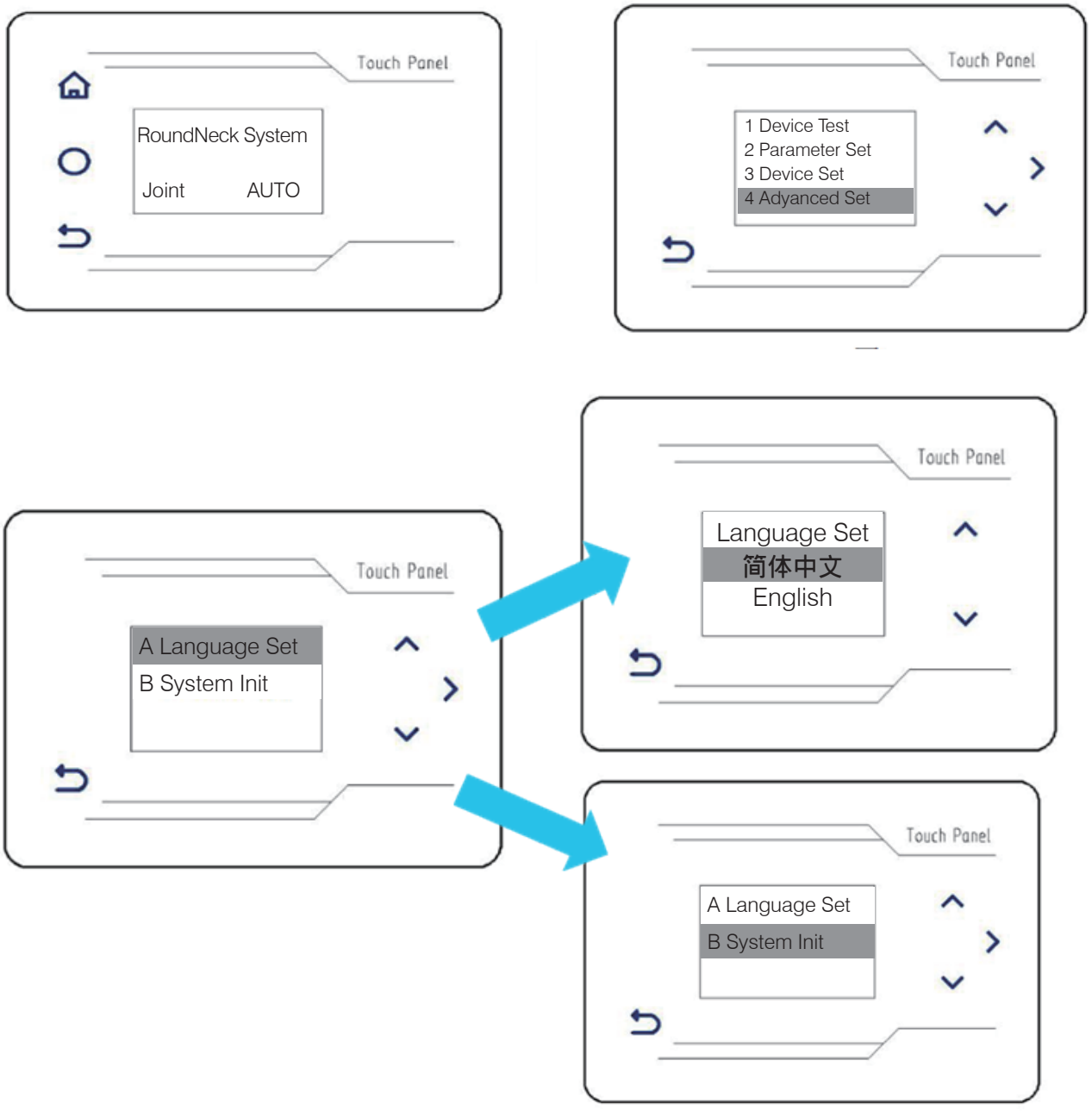
1.long press 3 second. entering to data setting.
2.right press "function setting", enter into sub menu.
3.right press 2-2 seeming stop position, up and down to adjust data. the more seaming data the stop position more back, the less seaming data the stop position more front. back to menu and save.

Setting to long suction



1.long press 3 second. enter into setting menu.
2.press "function setting" right press, enter into sub menu.
3.right press 2-5. front inner suction mode. press inner suction adjustment.
4.right press 2-6. inner suction step needle number. press adjustment set to 0. back to menu and save.

Language chooses and initialization data



1.long press  for 3 second. enter into setting menu.

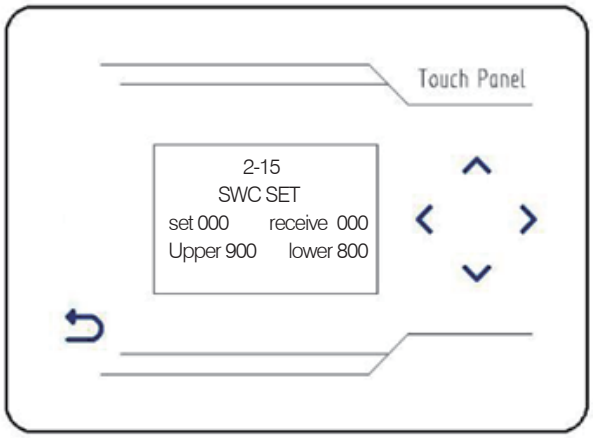
2.select 4.adventage setting. right press enter into menu.

3.press up and down select A. language setting B. initialization system. right press enter into sub menu.

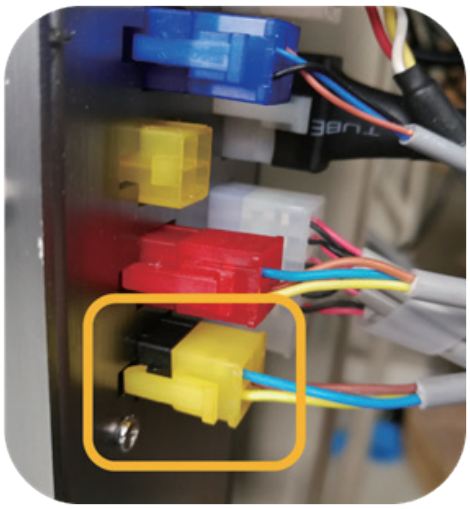
4.press up and down select simple Chinese or English. back to menu.

5.press down select B. initialization system, right press 2 second. initialization done automatic back to menu.

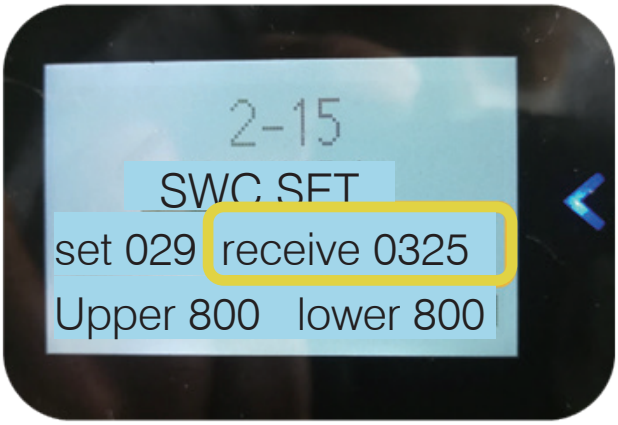
Fabric sensor adjustment.



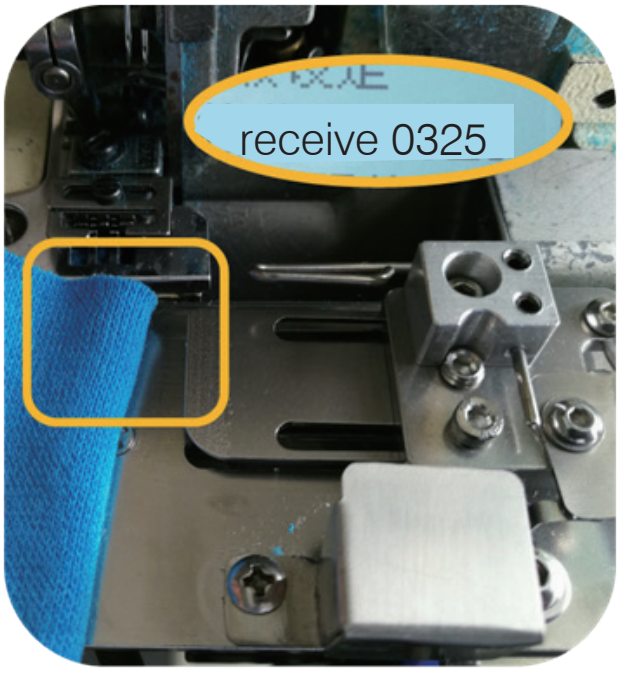
1.long press menu for 3 second. > function setting > 2-15 sensor data setting.



2. rib-fabric sensor plug (yellow), plug into black.

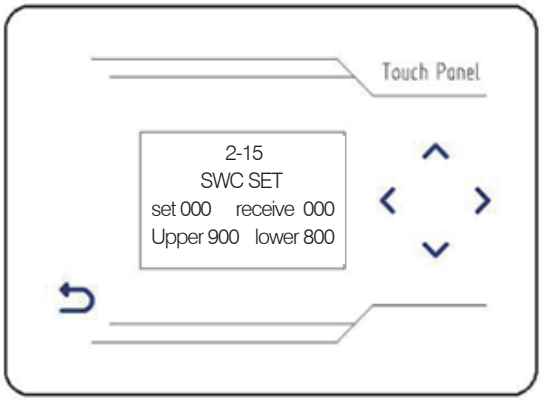


3. press up and down adjust data between 300-400.

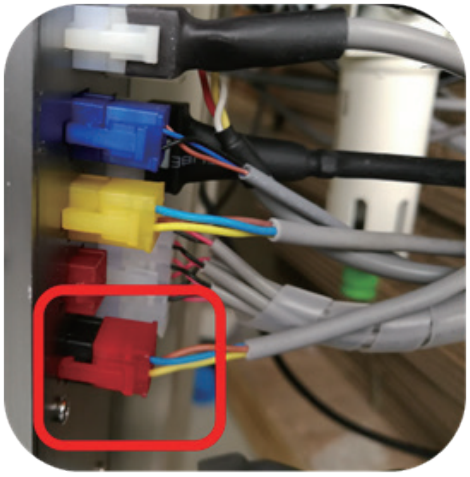


4. covering sensor by fabric, receive data is 1023. If not enough 1023, press up and down to adjust data to 1023.
if receive data non change, need check senor or change senor.

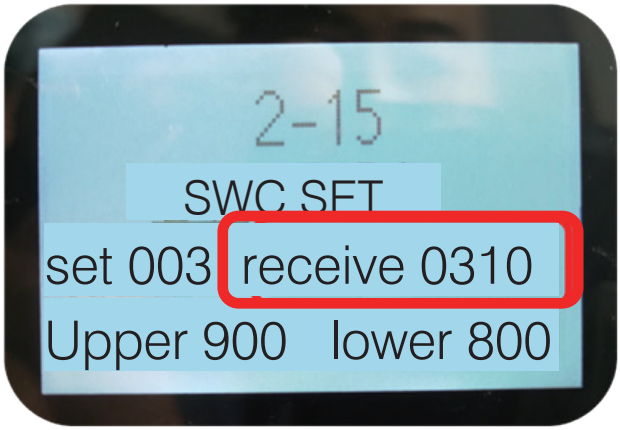
Auto positioning distribution material sensor adjustment



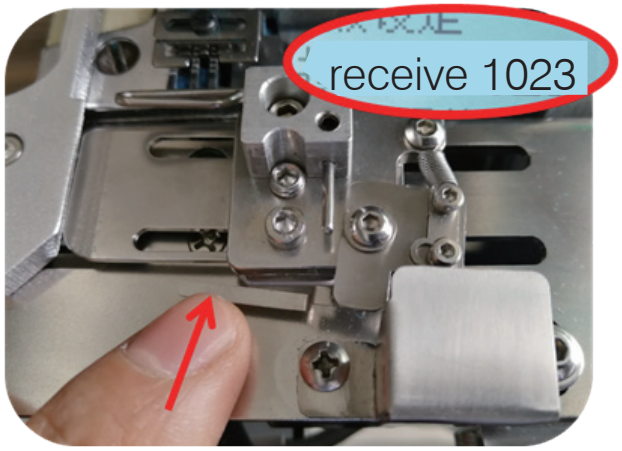
1. long press 3 second > function data setting



2. rib-fabric sensor (red) plug to black socket.

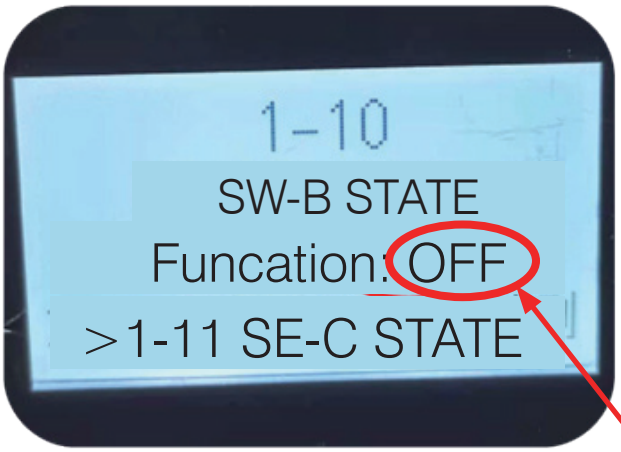


3. press up / down to adjust data between 300-400.



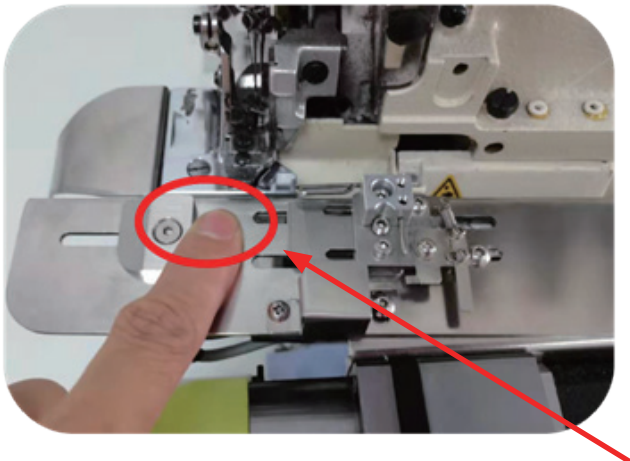
4.use finger push metal sheet cover sensor, data is 1023, if under 1023 press up/down adjust till 1023. if data id 1023 still have no change, need recheck or replace sensor.

Issue solution of feeding roller of ACS-200 opposite press pedal

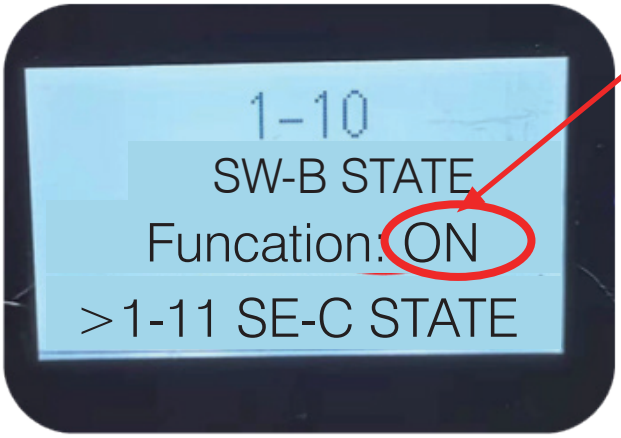


check the switch of fabric detection

1.check step motor wire, unplug or damaged.
2.check seeming sensor and fabric sensor work or not. if no work need enter to screen solve the issue.
3.enter into server detection solve back press pedal voltage.

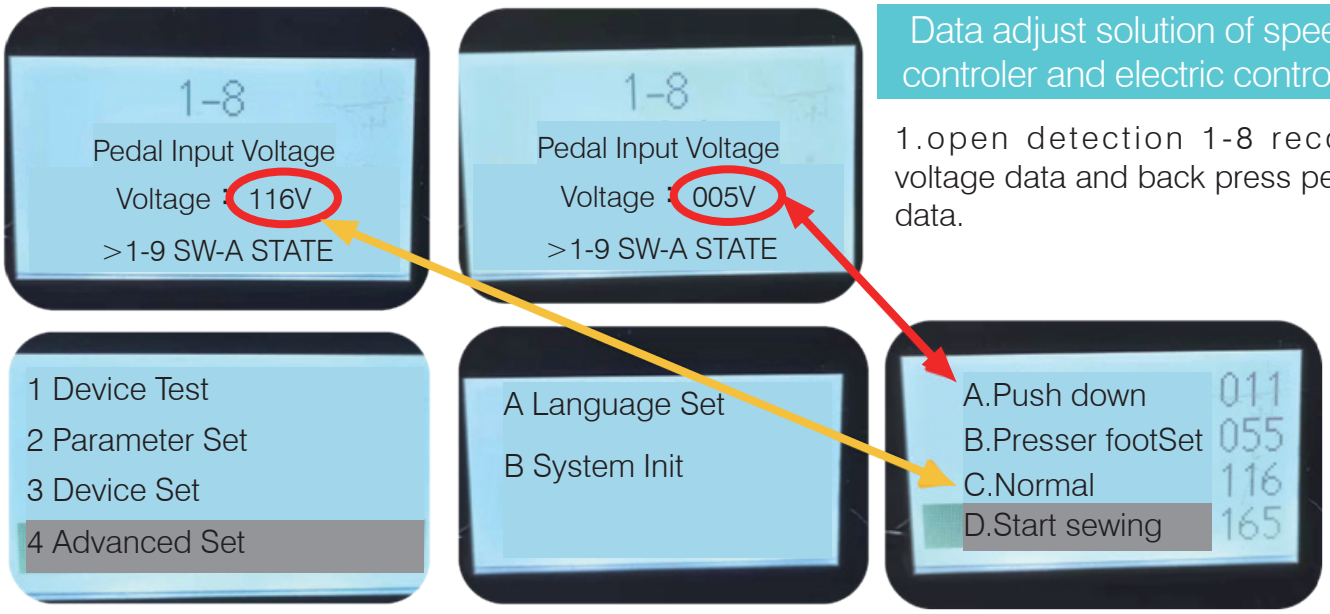


detection option, 1-10 without covering the sensor need shows close.



cover sensor need shows open. if no change need check sensor (yellow plug) if contact properly or adjust sensor data.

Issue solution of feeding roller of ACS-200 opposite press pedal



Data adjust solution of speed controler and electric controler

1.open detection 1-8 record voltage data and back press pedal data.

2.Open Advantage Settings.
Adjust until A and B have no background color, and enter the data setting.

A. back press: use for enter feeding mechatronic, data adjust over than back press pedal voltage 005v. if smaller 005v cannot enter.

B. lift presser foot: data adjust to regular number.

C. regular: data adjust pedal voltage 116V.D. begin sewing data need over than regular data 116V>

***If begin sewing data lower than regular data, machine will auto work when open machine.

高林股份有限公司
KAULIN MFG. CO., LTD.

由於對產品的改良及更新 , 本產品零件圖及外觀的修改恕不事先通知 !
The specification and/or appearances of the equipment described in this parts list are subject to change because of modification which will without previous notice.
ACS200.JAN.2023