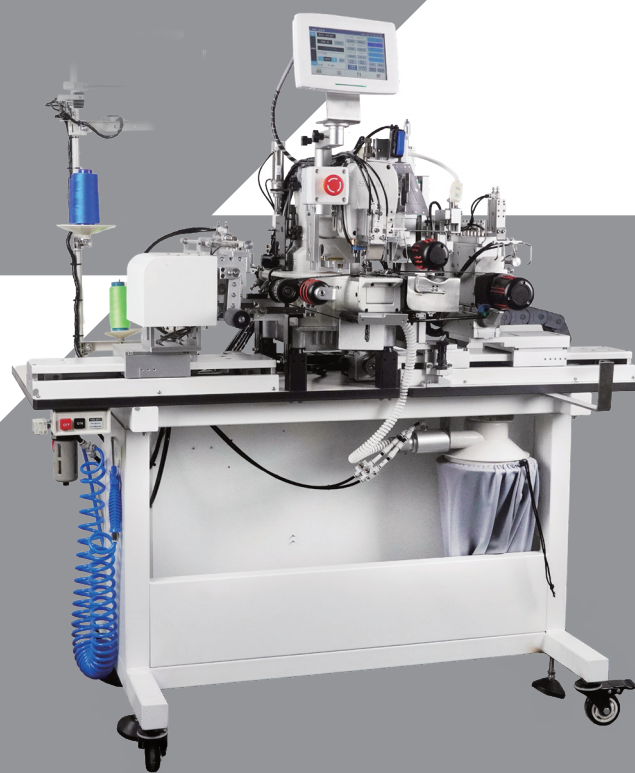


SIRUBA

電控參數說明書

ELECTRONIC CONTROL PARAMETER MANUAL

ASC-EWA100



说明书

版权申明

本公司保留所有权力。

产品使用说明书的内容参照了相关法律基准和行业基准。您在使用我们的产品时，如对本说明书提供的内容有任何疑问，请向购买产品的销售人员咨询，或致电客户服务热线，或致信本公司邮箱。

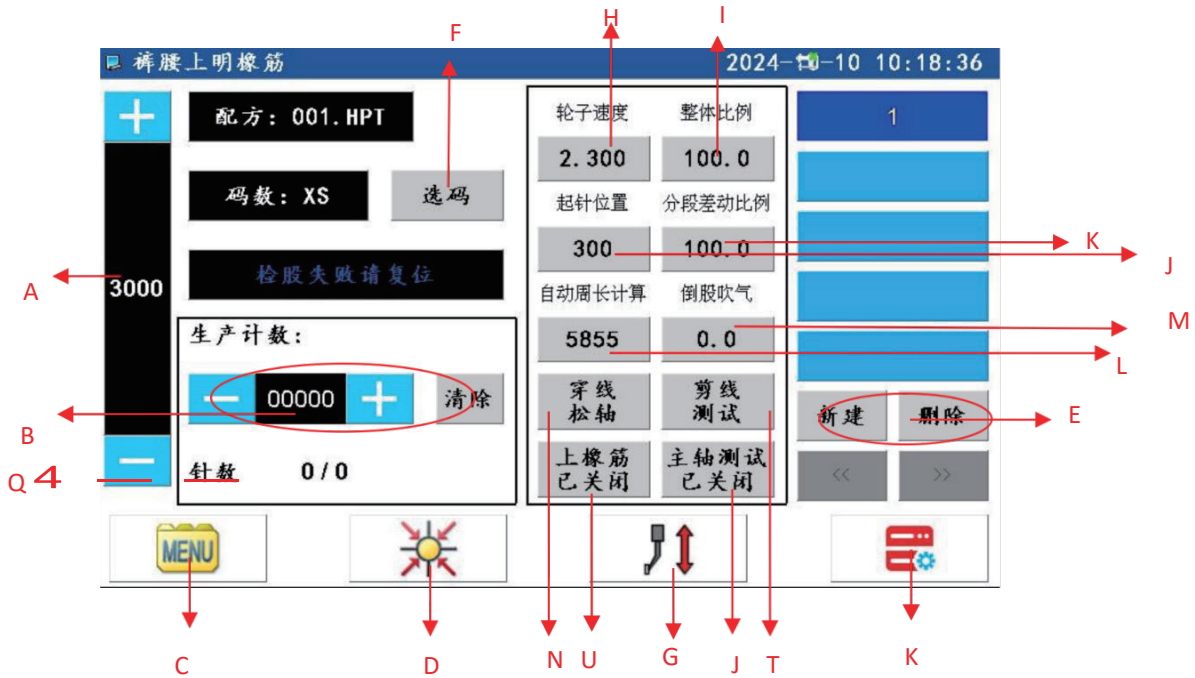
本公司保留在不事先通知的情况下，修改本手册中的产品和产品规格参数等文件的权力。

本公司具有本产品及其软件的专利权、版权和其它知识产权。未经授权，不得直接或者间接地复制、制造、加工、使用本产品及其相关部分。

本公司具有本使用说明书的著作权，未经许可，不得修改、复制使用说明书的全部或部分内容。

第一章:打版款式相关设置及功能	1
1.1 缝制界面	2
1.2 新建款式	3
1.3 删除款式	3
1.4 生产计数	3
1.5 信号检测	4
1.6 股位高点	4
1.7 差动电机	5
1.8 倒股吹气	6
1.9 扩张对应值	6
第二章 :设备检测	7
2.1 设备检测	7
2.2 电机调试	8
2.3 气缸调试	8
2.4 主轴速度检测	9
2.5 主轴电机安装角度校正	9
第三章:系统升级及功能设置	10
3.1 系统升级	10
3.2 功能设置	11
第四章:系统参数	12

第一章:打版款式相关设置及功能



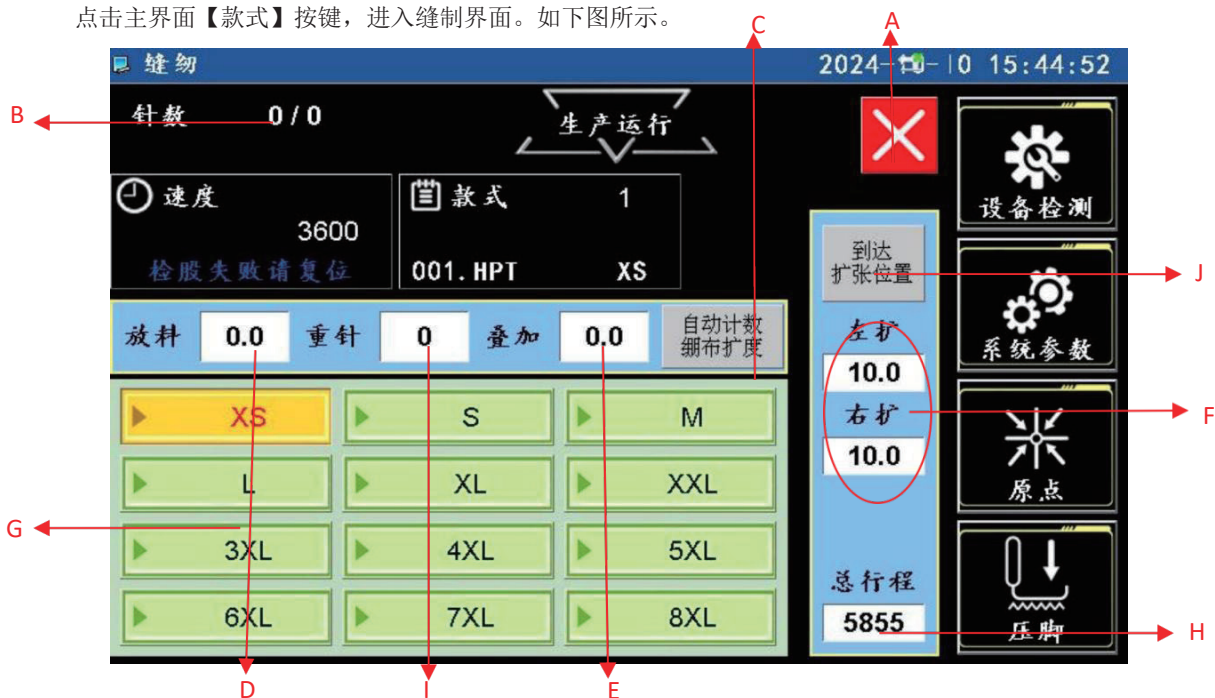
主界面功能说明:

序号	功能	内容
A	速度	设置缝制速度
B	生产计数功能	计数加、减、清零, 点击进入计数设置界面
C	系统参数	点击进入系统参数界面
D	原点	回原点功能
E	新建及删除	新建、删除款式
F	款式信息及缝制界面接口	款式号码、名称及尺码, 点击进入缝制界面
G	压脚	压脚提升/落下
H	轮子速度	设置轮子速度值
I	整体比例	设置整体比例的比例值
J	起针位置	进入股位高点界面设置股位偏移值和股位点数
K	分段差分比例	进入差分电机设置界面, 设置设置差分针距百分比, 对段差分调节
L	自动周长计算	进入扩张对应值界面
M	倒股吹气	进入设置倒股吹气的设置时长和是否打开, 设置倒股位
N	穿线松轴	控制穿线松轴的功能控制
O	主轴测试	按下该按键可以开启或者关闭主轴测试动作
P	设备检测	点击进入设备检测界面
Q	针数	显示的针数

序号	功能	内容
R	信号检测	输入及输出信号检测界面
S	压脚	压脚提升/落下
T	剪线测试	按下改按键可以开始剪线动作
U	上橡筋开启/关闭	按下该按键可以开启或者关闭上橡筋动作

1.1 缝制界面

点击主界面【款式】按键，进入缝制界面。如下图所示。



功能说明：

序号	功能	内容
A	退出	点击退出，进入主界面
B	针数	显示针数
C	自动计数绷布扩度	根据放料、重针、叠加设置的参数激活计数绷布扩度设
D	放料	设置放料值，不同尺码参数值不同 注：自动扩张->自动绷布关闭/打开控制参数显示与隐藏
E	叠加	设置需要叠加的数值
F	左扩，右扩，下扩	设置左扩，右扩，下扩数值
G	尺码选择	有 XS 到 8XL 十二种不同尺码
H	总行程	设置总的行程，进入扩张对应值
I	重针	设置重针数
J	到达扩张位置	将设置扩张值计算后到达扩张值

1.2 新建款式

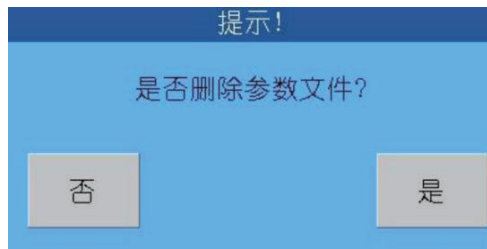
点击主界面【新建】按键，进入界面，设置款式名称及号码。点击【确定】新建款式成功，点击【取消】



退出新建款式设置参数。如上图所示。

1.3 删除款式

点击主界面【删除】按键，弹出提示框。点击【确定】删除款式成功，点击【取消】退出删除款式。



1.4 生产计数

点击主界面【生产计数值】按键，进入加计数设置界面。如下图所示。



包含：

- 1.生产计数设定值（计数总数）设置。
- 2.生产计数当前值设置。
- 3.计数器功能开/关按键。
- 4.清除当前值按键，将当前计数清零。

设定 目标计数：在设置区域，输入需要的 目标计数值。确保输入的而目标数符合生产的需求。

点击确认按键，系统将开始计数生产的过程中的产量数据。

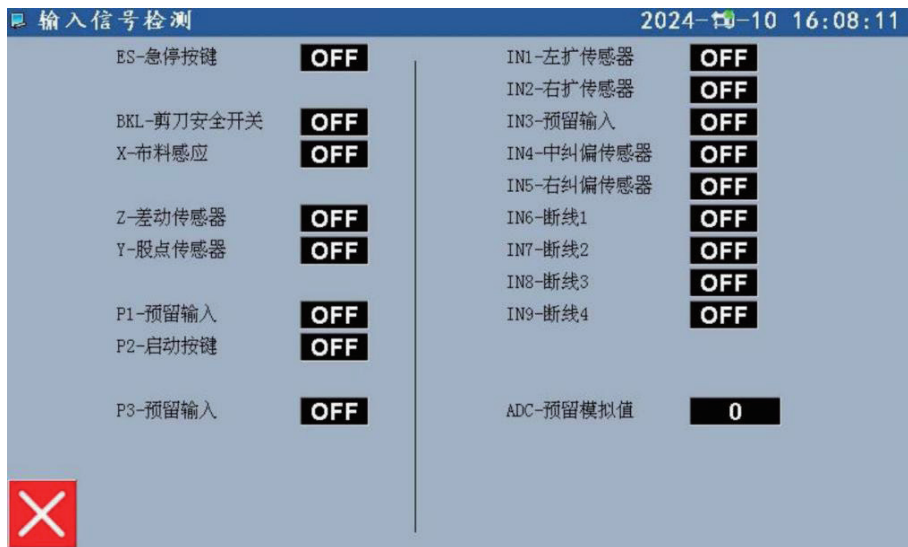
1.5 信号检测

点击主界面【信号检测】按键，进入信号检测界面。在此界面分为输入输出两大模块。实现查询通信来控制信号 OFF/ON。界面包括以下内容显示如下图所示。

1.显示当前检测状态相关信息。

注意事项

在进行任何操作的操作前请确保机械装置已正确的安装和连接，避免因链接导致不当导致的错误。在操作中的，注意安全，避免移动部件，以防止意外伤害。



1.6 股位高点

点击主界面【橡筋股位偏移位置】数值，进入股位高点界面。如下图所示。



包含:

- 1.点击编辑框，设置股位偏移值。
- 2.点击编辑框，设置股点数。
- 3.点击上设置数值后可以自动检股。

1.7 差动电机



界面功能说明:

设置到达保存值位置:

功能: 输入你希望设置的位置的具体百分比值。说明例如, 如果希望电机以 50%的差动针距运行, 您需要输入 50, 这将使电机以 50%的差动针距指定为目标位置, 以实现所需要的操作效果。

自动检股:

功能: 点击“自动检股按钮”, 启动自动检股功能, 说明此功能允许系统自动检测当前的股位状态, 确保设备在正确的位置、启动后, 系统将进行必要的测量和调整。

开关按钮:

功能: 点击“显示1”, 表示开启段差动调节功能, 反之表示关闭。此功能按钮按下后, 启动段差动调节功能, 可以点击进入段差动调节界面在此界面中用户可以使用更多细节调节。

点击主界面【分段差动比例】的编辑框, 进入差动电机界面。如下图所示。



界面包含:

1. 点击进入设置按钮, 跳出提示是否进入这个可以进行设置功能的设置
2. 差动针距设置为大小, 点击差动针距输入大小输入适合的数值。
3. 根据主控的显示的当前位置设置位置比例, 设置每一点的位置比例。
4. 点击回复默认比例按钮恢复默认比例。
5. 根据需要删减一步, 或者新增一步设置需要位置。

1.8 倒股吹气

点击主界面【倒股吹气】按键，进入倒股吹气设定界面。如下图所示。



包含：

1. 点击[进入设置]进入设置按键: 点击此按键进入设置界面，用户可以保存设置参数
2. 倒股吹气倒股位置 1-5: 点击保存按键保存需要到股吹气的位置，并显示在界面上。保存：点击此按键将获取当前倒股位置保存对应的位置上。清除按键，点击此按键清除对应设置的倒股位置。
3. 显示位置百分比：设置上将显示当前倒股位置的百分比，以使用户了解当前的工作进度。
4. 点击倒股吹气开关：用户可以设置倒股启动或禁止倒股吹气的功能
5. 倒股吹气时长设置：用户可以通过此设置吹气时长，输入所需要的数值大小
6. 点击复位倒股吹气复位为默认值。

1.9 扩张对应值

点击主界面【扩张对应值】按键，进入下扩张对应值界面。如下图所示。

1. 自动检测值：用于输入和显示调整总总行程值。
2. 开始检测：电机开始检测值开始检测。
3. 保存参数：保存需要合适的参数。
4. 复位按键：默认的设置值。



第二章：设备检测

2.1 设备检测



界面功能说明:

1. 进入设备测试界面

功能描述:

用户可以通过电机调试界面那进入[动作设置]进入设备检测界面。

2. 输入信号检测

功能描述:

此功能用于检测输入信号的状态、确保系统将接收正确的信号。

使用步骤:

- 1.1 设备检测界面中找到输入信号检测按键。
- 1.2 点击该按键将开始输入信号。
- 1.2 观察界面上显示信号状态，确认信号是否正常。

3. 主轴速度检测界面

功能描述:

此功能用于测试主轴的转速，确保主轴在正常的范围内运行

4. 主轴角度检测

功能描述:

此功能用于主轴角度检测的检测，确保主轴在正常的范围内运行

5. 切刀测试

功能描述:

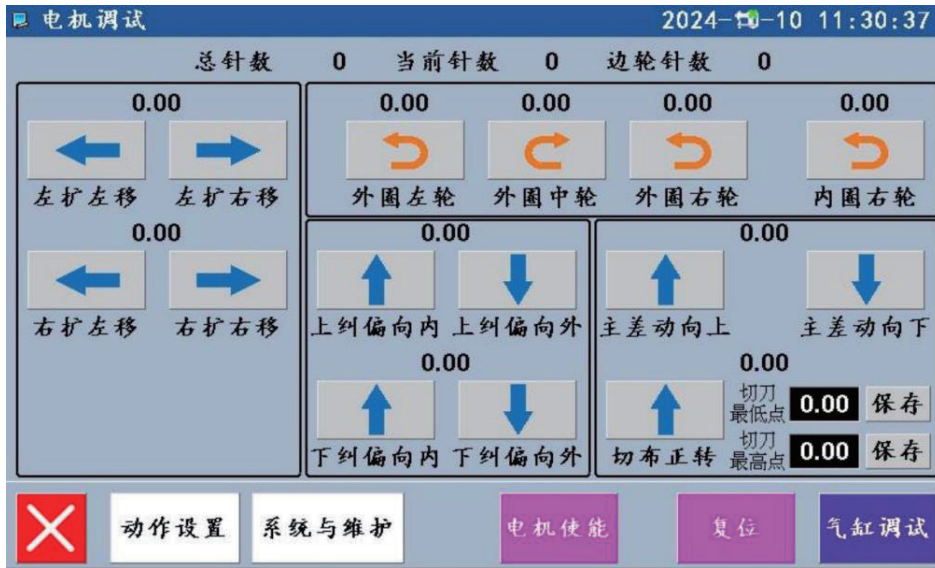
此功能用于测试切刀的工作状态，却败切刀能够正常切割。

6. 退出测试界面

用户点击随时退出测试界面返回主界面。

2.2 电机调试

点击主界面【设备检测】按键，进入电机调试界面。在此界面可以实现多个电机调试及剪线、切刀测试、复位等功能。如下图所示。



使用步骤:

打开电源进入开关界面，等待设备自检完成。根据需要测试的内容，在界面中按键需要设置和对应的功能。点击相应的按钮，观察机器的反应是否符合预期。

2.3 气缸调试

点击电机调试界面【气缸调试】按键，进入气缸调试界面。在此界面可以实现气缸按键状态、气缸调试及倒股、收料测试、复位等功能。如下图所示。



2.4 主轴速度检测



点击电机调试界面【主马达测试】按键，进入主轴速度检测界面。在此界面可以进行主轴速度的调试。如图所示。

- 1.显示实际速度:显示当前主轴的实际速度(RPM)。
- 2.设定速度:允许使用输入或者是按键达到目标转速。
- 3.控制按键:启动、停止、复位等基本操作按键。
- 4.报警:如果设定安全范围，回显示报警信息。
- 5.调整和优化:如果需要调整主轴速度，可以通过重新设置目标设定值。

2.5 主轴电机安装角度校正



点击电机调试界面【主马达定针】按键，进入主轴电机安装角度校正界面。在此界面可以进行主轴电机的调试。如下图所示。

- 1.在调整之前确定采取必要的安全措施。将传感器正确安装到主轴和参考点上。确认它们牢固并位置正确。打开界面，并完成初始化设置。
- 2.在界面中找到“主轴电机释放/锁紧”按键，点击该按键可以解除或者锁紧状态，使其可以自由移动方便进行调整。
- 3.进行测量，转动主轴一定角度，读取多个位置收集数据，计算当前的偏移量，并显示在界面上。
- 4.当调整到满意位置后，在软件界面上找到“主轴电机锁紧”，防止其运行过程中发生位移。
- 5.最终验证，重新再次进行一次完整的测量，以确保所有的参数在允许的公差范围内。

第三章：系统升级及功能设置

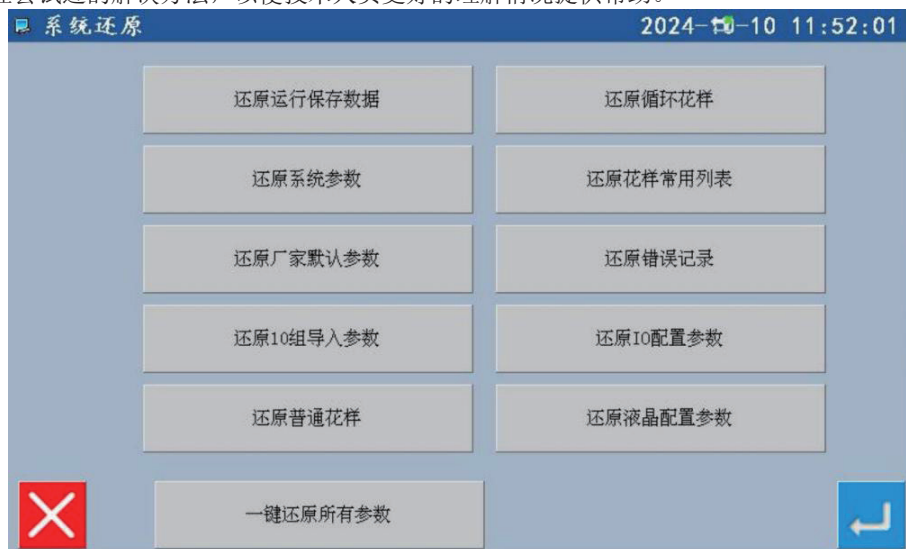
3.1 系统升级

点击电机调试界面【系统与升级】->【系统升级】按键，进入固件版本模式界面。用于查看控制系统的版本编号。例：主控、面板、厂家 LOGO、步进等的版本信息。

点击【升级】按键进入系统升级模式界面。在此界面可以实现版本升级及系统还原功能。如下图所示。



- 1.版本升级:** 查找 U 盘升级文件，系统会提示进行安装，点击【一键升级】按键进行版本升级进程。升级过程中不要关闭电源。升级完成后，弹出提示框，请断电重启电源耐心等待。重启系统后会进入新版本界面，请检查新版本的功能是否正常，确保一切运行顺利。
- 2.**如出现升级错误或者回溯过去版本可以在开机连点点击左上角区域，进入相关设置界面对系统版本进行更改。如果查看错误信息，尝试重新启动设置并进行再次升级。
- 3.系统还原:** 点击【一键恢复】按键，进入系统还原界面。如下图所示。可以一键还原所有参数，也可以选择需要还原的参数项。操作后还原到最初默认值，系统还原完成后，弹出提示框，请重启电源。
- 4.故障排除:**如果升级问题依旧。可以通过查找公司提供的技术支持联系方式。请确保详细描述您遇到的问题已经尝试过的解决方法，以便技术人员更好的理解情况提供帮助。



3.2 功能设置

点击电机调试界面【系统与升级】->【功能设置】按键，进入功能模式界面。此界面分为十个模块。如下图所示。



第四章：系统参数

参数表：

参数名	默认值	范围
同步比例（1组）		
边轮同步比例	350	500-2000
左轮同步比例	863	500-2000
中轮同步比例	939	500-2000
差动次原点位置	0	-1000-1000
中轮气缸开关	打开	打开、关闭
左轮气缸开关	打开	打开、关闭
上橡胶筋动作（2组）		
伸出缩回后多久关闭张开	350	1-30000 毫秒
起缝空转后压脚下压延时	100	0-2000 毫秒
缝中动作（3组）		
缝制后期左轮纠偏的动作	停止纠偏	停止纠偏、向外纠偏
缝中位置 1	6000	1000-10000
缝中位置2	6500	1000-10000
缝中位置3	7000	1000-10000
缝中位置4	1000	1000-10000
外圈左轮往外纠速度	0	1000-10000
中纠偏位置 4 的速度	1	0-9999
中纠偏位置 4 的动作方向	往外纠偏	向外纠偏，向内纠偏
纠偏方式	常规方式	常规方式、压脚落下
断线检测器（4组）		
断线 1 是否有效	无效	无效，有效
断线 2 是否有效	无效	无效，有效
断线 3 是否有效	无效	无效，有效
断线 4 是否有效	无效	无效，有效
断线 1 检测针数	50	1-1000
断线 2 检测针数	50	1-1000
断线 3 检测针数	50	1-1000
断线 4 检测针数	50	1-1000
剪线（5组）		
剪线气缸是否有效	有效	有效，无效

参数名	默认值	范围
剪线打开到到剪关闭间的延时	100	毫秒
剪线关闭到勾线打开间的延时	50	毫秒
勾线是否有效	无效	无效, 有效
勾线打开到勾线关闭的延时	120	10-3000
勾线关闭到勾线关闭的延时	120	10-3000
安全打开检测报警	打开	打开、关闭
计算器 (6 组)		
加算器 (up) 模式	图形	图形, 停止, 循环
减算器 (up) 模式	图形	停止, 图形循环
消除加算器方式		
消除减算器方式		
电源重开时计算器值出厂设定	保持	保持, 清除
禁止加算器 (UP) 被修改	允许	禁止、允许
禁止减算器 (UP) 被修改	允许	禁止、允许
针数计算功能 1 的开关	无效	有效、无效
针数计算功能警告 1 针数	1000	0-9999
针数计算功能2 的开关	无效	有效、无效
针数计算功能警告 2 针数	1000	0-9999
高级参数 (7 组)		
伺服使能延时	100 毫秒	100-999 毫秒
伺服禁止后延时	100 毫秒	100-999 毫秒
暂停开关类型	常开	常开、常闭
断线检测开关类型	常开	常开、常闭
气压检测开关类型	常开	常开、常闭
语言设定 (7 组)		
界面显示的语言	中文	中文、英语、越南语、韩语、土耳其语
切刀 (8 组)		
切刀是否有效	有效	有效、无效
切刀打开时机	1800	0-9999
预留参数		
切刀抬起来的位置	450	1-3000
切刀提前停止的针数	0	0-50
滚轮调节 (9组)		

参数名	默认值	范围
启动是空转的速度	600	50-600
无骨找位时空转的速度	50	1-100
起针位置(10 组)		
起步针针数	5 针	0-15 针
起步慢针速度	1000 转	200-4000 转
起步慢针左滚轮速度微调	100%	20-200%
起步慢针右滚轮速度微调	100%	20-200%
尾针设置(11 组)		
结束慢针针数	5 针	0-15 针
结束慢针速度	1000 转	200-4000 转
结束慢针左滚轮速度微调	100%	20-200%
结束慢针右滚轮速度微调	100%	20-200%
面板设置(12 组)		
故障发生时蜂鸣器报警模式设定	单次	单次、持续
是否显示空走花样设定	显示	隐藏、显示
花样显示缩放区域设定	外压框	外压框、实际花样
是否支持临时花样	不支持	不支持、支持
主界面是否显示加捻图标	显示	隐藏、显示
花样初始放大倍数	1	1-25
放大缩小类型设置	当前针	当前针、原点
语音设定	0n	ON、OFF
与主控通讯设定	OFF	OFF
语音音量设置	100	0-100
方向键与电机转动的方向是否一致	反向	一致、反向
保存花样时是否同时保存到U 盘	否	否、是
是否合并相邻的空送	是	否、是
速度显示方式	速度值	档位、速度值
保存到U 盘是否支持长文件名	支持	支持、不支持
保存时是否使用前花样名	不使用	不使用、使用
预览花样时是否显示空送	不显示	不显示、显示
Next 界面的工作模式	正常模式	正常模式、测试模式
花样缩放方式	主控控制	主控控制, 面板控制
主界面设置(13 组)		
开机界面左侧图标显示语言	中文	中文、英语、越南语、韩语、土耳其语

参数名	默认值	范围
收料动作(14组)		
是否使用收料架	不使用	不使用、使用
收料架上升的距离	3000	100-3000
收料架下降后上橡筋架缩回	2000	20-10000
自动启动(15组)		
是否自动启动缝纫	不自动	不自动、自动启动
自启动的延时时间	1000	1000-30000

Instruction Manual

Version statement

Our company reserves all rights.

The content of this product user manual refers to relevant legal and industry relevant legal and industry standards. Have any questions about the content provided by our product when using it, please consult with the salesperson who purchased the product, call the customer's hotline, or contact our email address

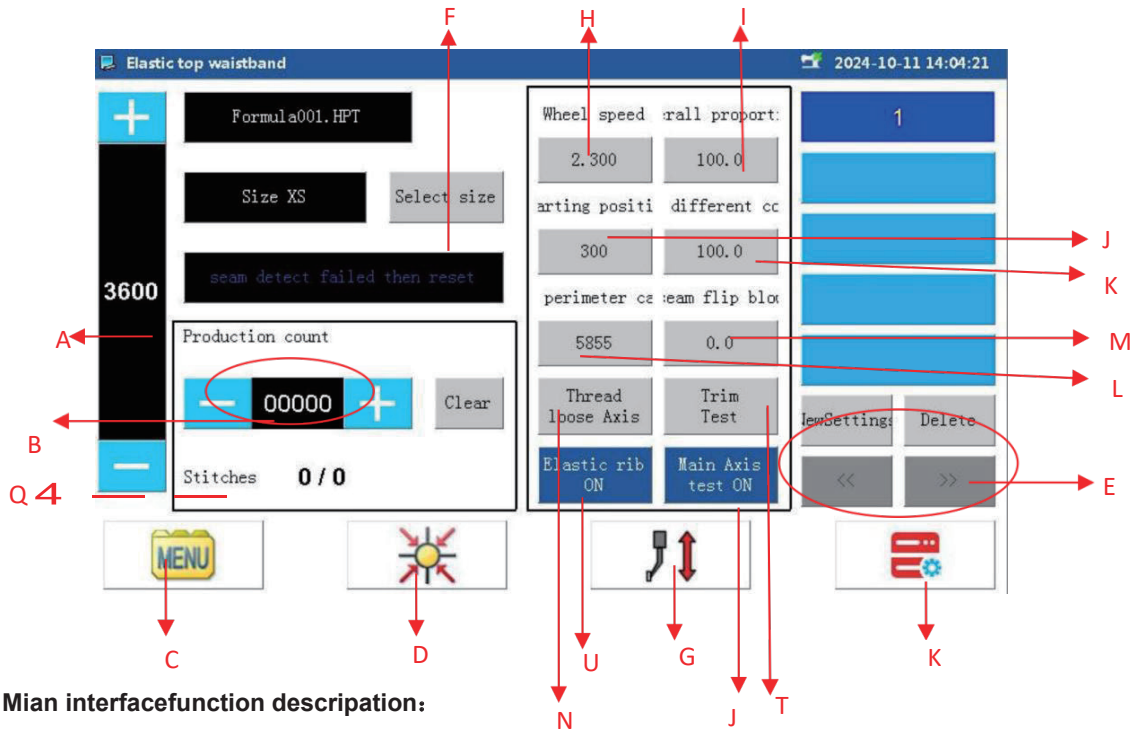
Our company reserves the right to modify the products and product specifications this manual without prior notice.

Our company has the patent rights, versions, and other intellectual property rights of this product and its software. Without authorization, this product and its related part shall not directly or indirectly be copied, manufactured, processed or used.

Our company has the copyright of the user manual, and without permission, we are not allowed to modify or copy all or part of the content of the user manual

CHAPTER 1: SETINGS AND FUNCTIONS RELATED TO LARGE VERSION STYLE	1
1.1 SEWING INTERFACE	2
1.2 NEW STYLE	3
1. DELECTE STYLE	3 3
1.4 PRODUCTIONCOUNT	4
1. INPUT DEACTION	45
1. SEAM HIGH POSITION	65
1.7 DIFFERENTIAL MOTOR	5
1. SEAM FLIP AIR BLOW	8 6
1. EXPAND VALUE	79
CHANPTR 2: DEVICE DETECTION	8
2.1 EQUIPMENT INSPECTION	8
2.2 MOTOR DEBUG	9
2. CYLINDER DEBUG	3 9
2.4 SERVO SPEED DETECTION	10
2. MAINAXLE MOTOR ANGLE CORRECTION	150
CHAPTER 3: SYSTEM UPGRADE AND FUNCTIONS	12
3.1 SYSTEM UPGRADE MODE	12
3.2 FUNCTIONMODE	13
CHAPTER 4: SYSTEMPARAMETERS	14

Chapter 1 : Settings and functions related to large version style



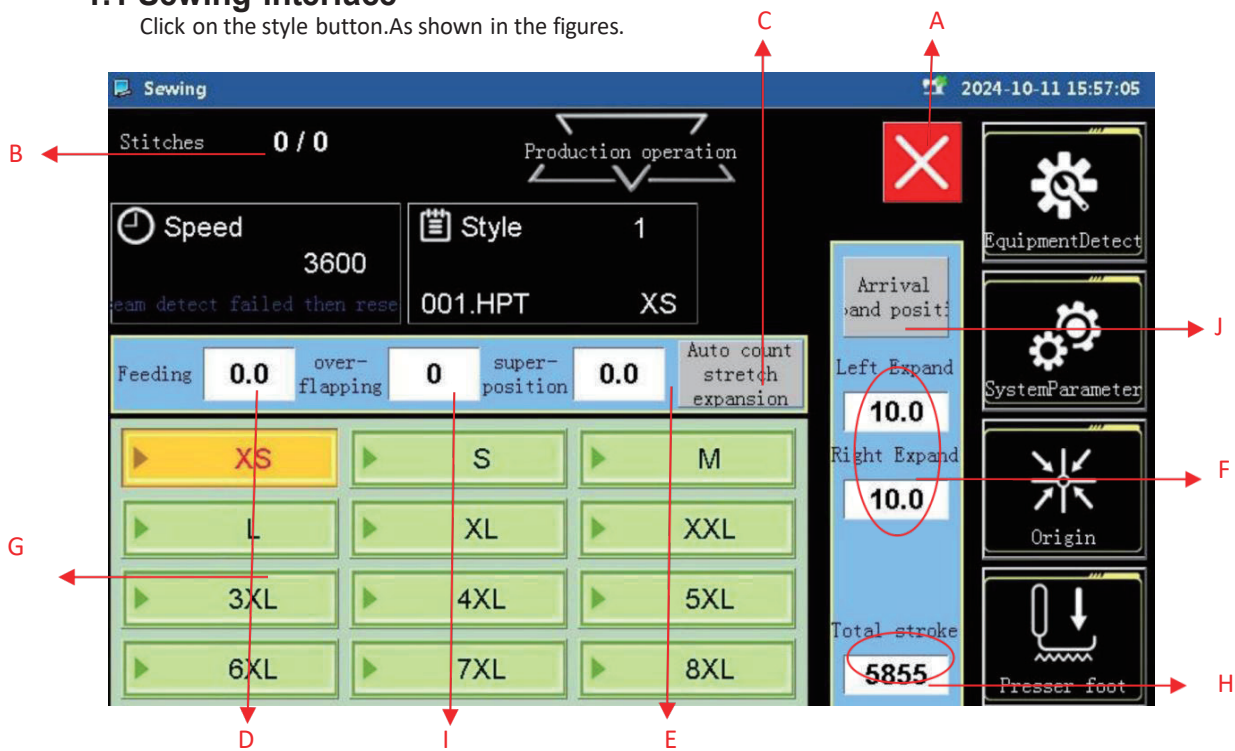
Main interface function description:

order	function	content
A	Speed	Set running speed prompt text displays
B	Production count	Count addition/subtraction, clear to zero, click to enter the count setting interface
C	System para	Click to enter the system para
D	Origin	Click o button back to origin
E	New and Delete	Create and delete style
F	Style information and sewing interface	Click on the style number and size to enter the sewing interface
G	Presser foot	Lift /Raise Presser Foot
H	Wheel speed	Set wheel speed value
I	Automatic perimeter calculation	Set to obtain automatically calculated perimeter values
J	Overall proportion	E overall scale value
K	Segmented different coefficient	Different proportions of display break

order	function	content
L	Automatic perimeter calculation	In the Expand value infitern
M	Seam flip blow	Set Reverse Sitich Blowing Function
N	Thread loose Axis	Click on the threading and axi loosening function
P	Main Axis test OFF\ON	Main Axis test OFF\ON
Q	Sitich	Click to enter the device detection
R	Style List	Style List,choose a larger style
T	Trim test	Click on the thread cutting test function
U	Elastic rib OFF\ON	Elastic rib OFF\ON

1.1 Sewing interface

Click on the style button.As shown in the figures.



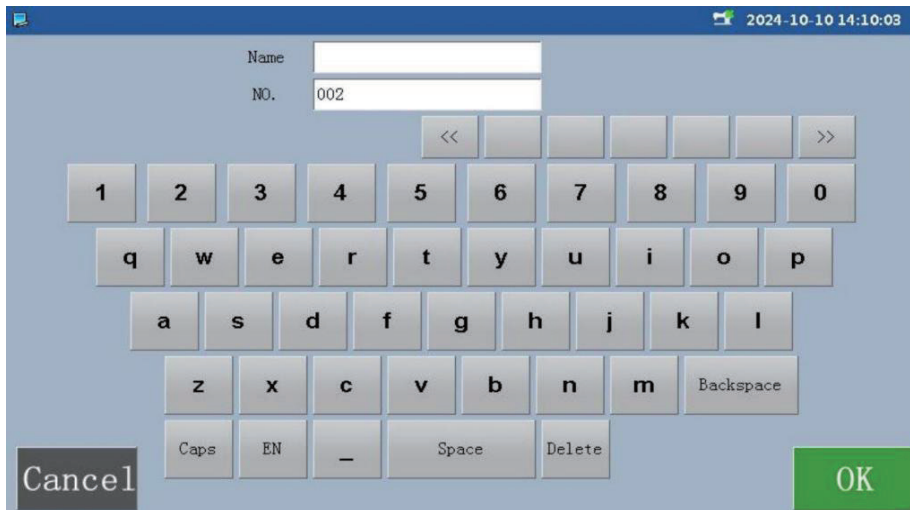
Function description:

order	function	content
A	Exit	Click to exit and enter the main interface
B	Stitches	Display stitch count
C	Auto count stretch expansion	Click to automatically count and expand the self setting value
D	Feeding	The feed function controls the movement of materials within a system key feature include.

order	function	content
E	Super-position	Setting Super-position value
F	Left extension, right extension, down extension	Set left, right, and down values
G	Size Selection	There are twelve different sizes available
H	Total journey	Set the total stroke, enter the expansion corresponding value.
I	Over-lapping	Set the number of stitches
J	Arrival expansion position	Will set the expansion value calculation to reach the expansion.

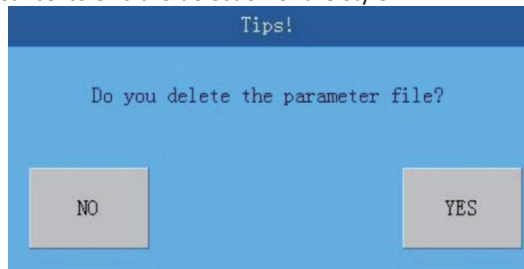
1.2 New style

Click the button "New Settings" on the main interface to enter the interface and set the style and number, Click Cancel to go to Style interface. As shown in the figures.



1.3 Delete Style

Click the delete button on the main interface and a prompt box will popup. Click to confirm the successful deletion of the style, click Cancel to exit the deletion of the style.



1.4 Productioncount

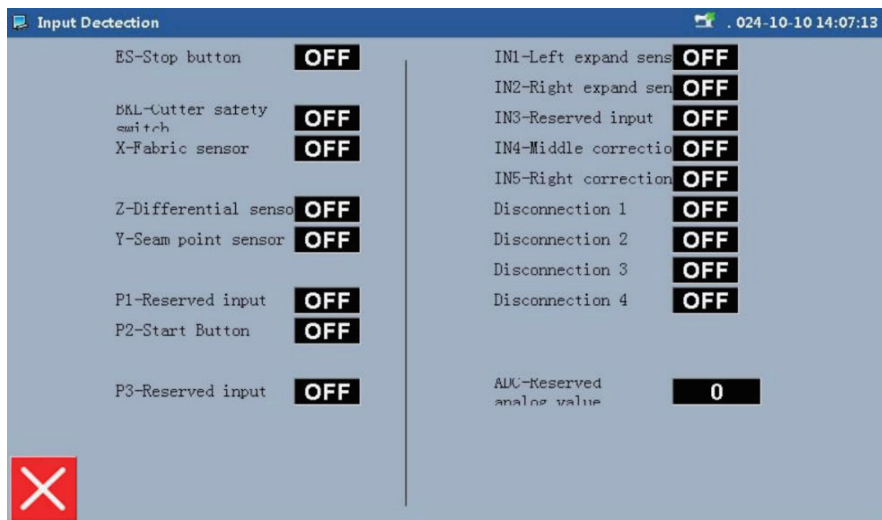
Click the button on the main interface called Production count value,enter the countup setting interface.As shown in the figures.



- 1.Production count setting value (total count setting).
- 2.Production Count Current Value Setting.
- 3.Counter function switch button.
- 4.Clear current value button.

Set target count:In the setting area,enter the desired production target count ,After inputting the number target count.After inputting the number,click the confiremation button to initaiate the counting producess during production.It is essential to ensure that the target number you enter aligns accuately with the required prouction volume,thus maintainga the efficiency and accuracy of the manufacturing process.

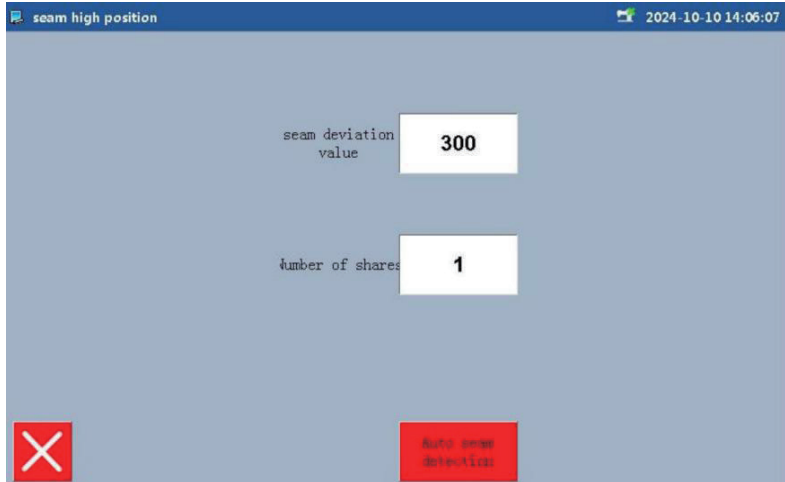
1.5 Input Deaction



Click the input deaction button on the main interface the to enter the signaal detection interface.Ask for communication to cptonal signal off/on.As shown in the figures.

1.6 Seam high position

Click on the text box name start point on the main interface to enter the automatic expansion.As shown in the figures.

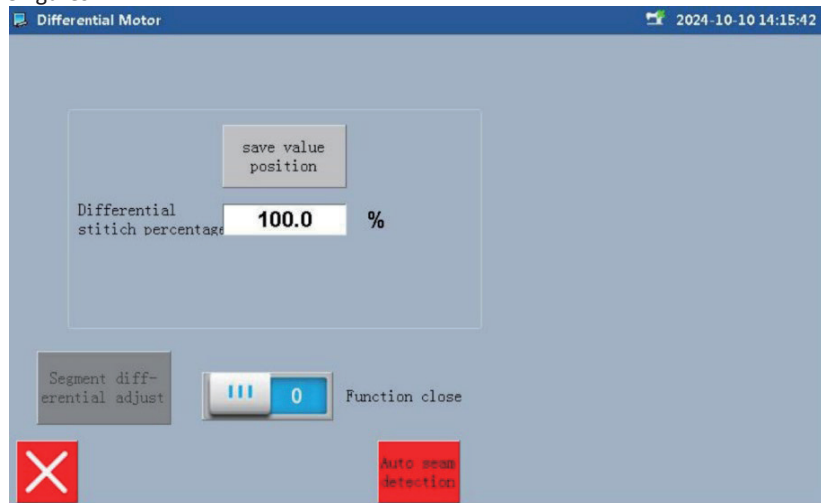


Contain:

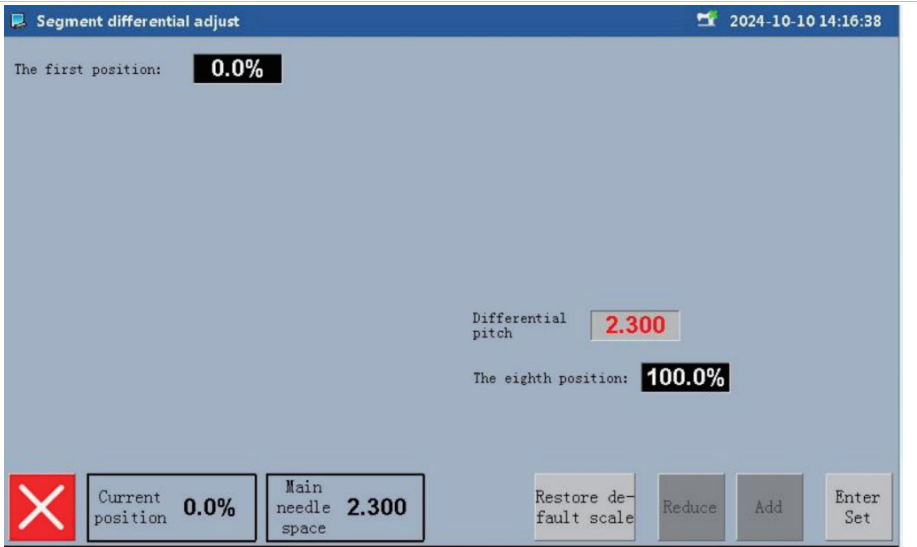
- 1.seamdeviation value.Set seamdeviation value.
- 2.Number of shares,Setting Number of shares.
- 3.Auto seam detection,Click to automatically cjeck the stock function.

1.7 Differential motor

Click on the EditText box “Differnt Moto Prortions” o themain interfaceet ent the sttock conversion.As shown in the figures.



- 1.Set target position:
- 2.unction:input the sepecific percentage value of the psotion you want to set.Description:For example.if you want the motor to operate at 50% differentail needle distance you need to input 50.This will adjust the motor to the specfied target psotion to achieve the desired operational eeffect.
- 2.Automatic stock Detection:
- 3.Function:Click the “Automatic stock detection” button to activate the automatic stock detectetion feature.
- 4.Description:This function allows the system automatically detct the currnet stock position ,ensuring that the device is in the correct location.Once activated,the system will perform necessary measurements and adjustments.
- 5.Toggle switch button:1
6. Function:Clicking this button will display “1”,enabling the button segment differential adjustment feature. Description:After pressing this button,the system will show “1”,indic

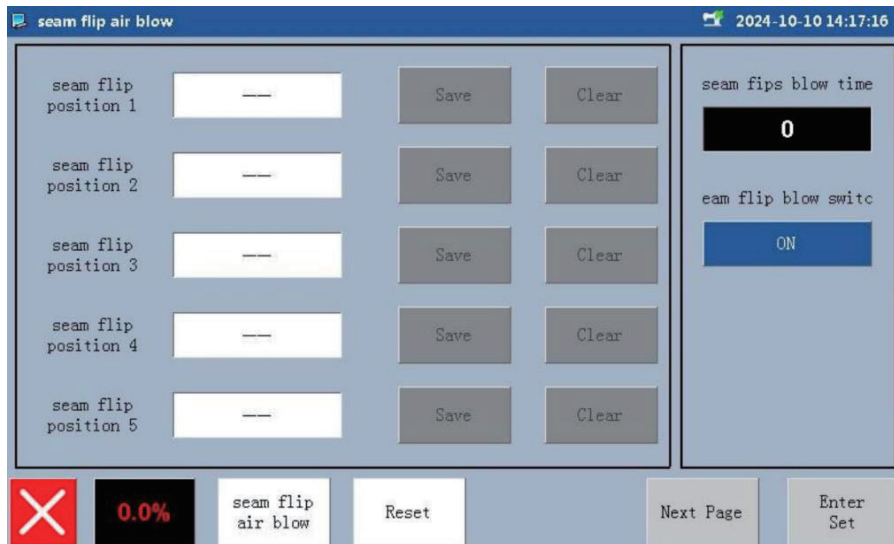


Interface features:

1. Click to enter settings. A prompt will appear asking if you want to proceed to settings where you can configure various options.
2. Differential spacing setting: Set the differential spacing to a specific size. Click on the differential spacing input field to enter the appropriate numerical value.
3. Position ratio setting: Based on the current position displayed by the main controller, set the position ratio for each point.
4. Restore default ratio button: Click to restore the default position ratios.

1.8 Seam Flip Air Blow

Click on the edit text “seam flip air blow” on the main interface to enter the seam flip air blow interface. As shown in the figures.



Contain:

1. Click on [Enter Settings] to enter the settings button. Click this button to enter the settings interface, where users can save the settings parameters.
2. Go to position 1-5 for blowing air and reversing: Click to save position value.
3. Save button : Click this button will retrieve the current stock position and save it to the corresponding location wake up and remove the corresponding set reverse position.
4. Display position percentage: Set to display one hundred and forty percent of the current stock position to allow users to understand the current work progress.
5. Click on the reverse blowing switch: Users can set the function of starting or prohibiting reverse blowing
6. Inverted blowing duration setting: Users can set the blowing duration and input the required numerical value through this setting. Click on reset and blow air to reset to the default value.

1.9 Expand value

Click the " automatic perimeter calculation value" button on the main interface to enter the corresponding value expand interface

1. Automatic detected value: This feature allows users to input and display the total travel value that needs to be adjusted. It provides real-time feedback on the current settings, enabling precise control over the system's operation.

2. Start Detection:

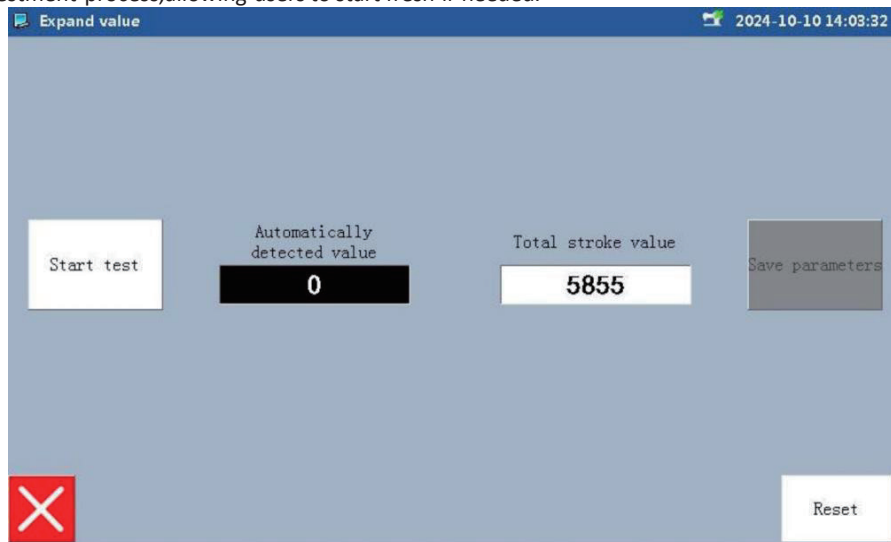
This button initiates the motor's detection process. Once pressed, it will begin to measure the specified values, allowing for accurate adjustments based on the detected parameters.

3. Start Parameters:

This function allows users to save the parameters that have been deemed suitable after adjustments. By saving these settings, users can ensure that the system retains the optimal configurations for future operations.

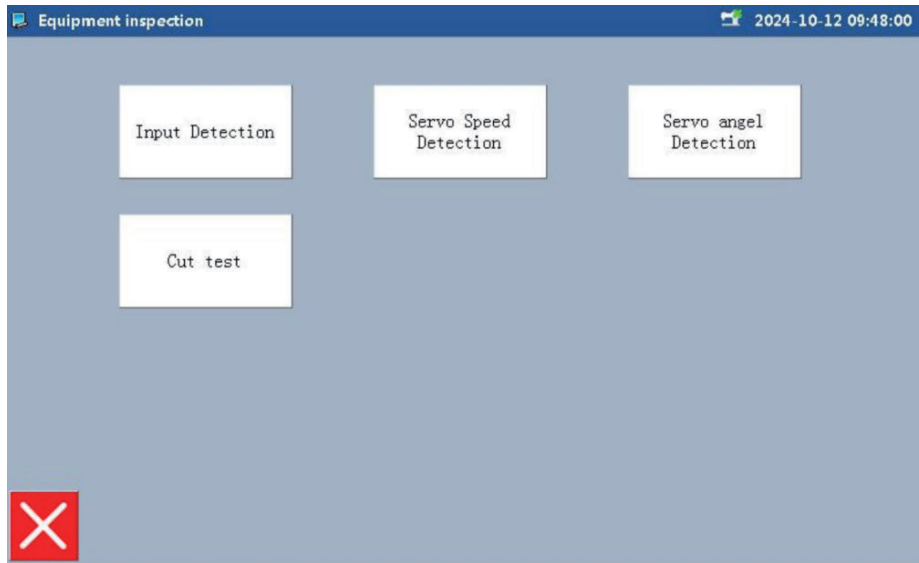
4. Reset button:

This reset button restores the system to its default settings. This is useful for reverting any changes made during the adjustment process, allowing users to start fresh if needed.



Chaptr 2 : Device detect ion

2.1 Equipment inspection



Testing interface of tje testomh interface usage:

1.Enter the device testing infterface:

Function description:

users can center the [auto dirnk 1]device detecion description interface through the motor debugging interface through the motor debugging interfacee

2.Input Signal Detection

Function description:

This function is used to detect the status of input signal to ensure that the system receives the correct signals.

Usege Steps:

- 1.1 In the testing interface,locate the “input signal detection” option.
- 1.2 Click on this option ,and the system will begin detecting the input signals.
- 1.2 Observe the signal status displayed on interface to confirm whether the signals is normal.

3.Spindle Speed Detection

Function description:

This function is used to detect the spindle’s rotation speed to ensure that the spindle operates within the normal range.

4.Spindle Angular Veclocity detection:

Function description:

This function is used to detec the angular veclocity of the spindle to ensure that the angular changes of the spindle meet expectatios.

5.Cutter Test

Function description:

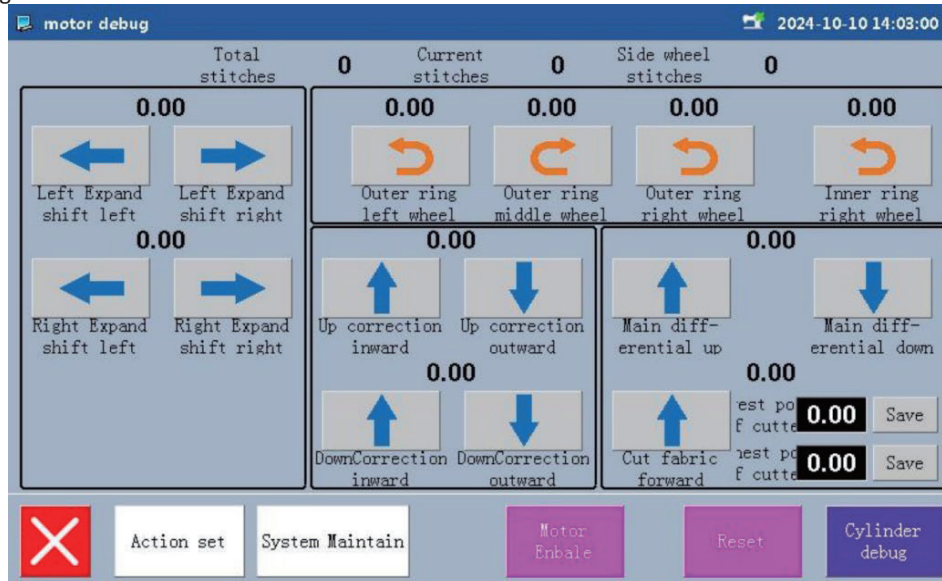
This function is used to test the working status of the cutter to ensure that it can cut normal.

6.Exiting the Testing interface:

Confirm the exit operation,and the system will return to the main interface.

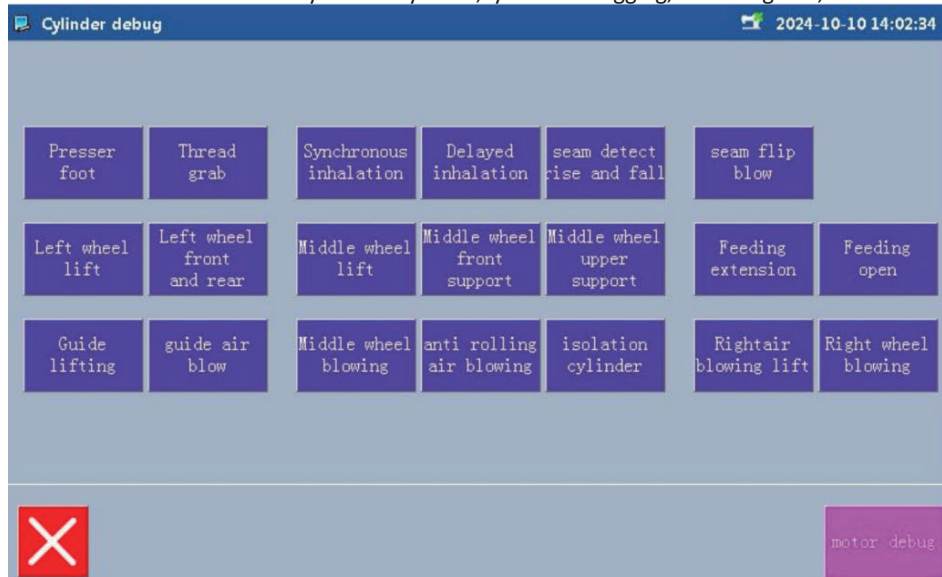
2.2 Motor debug

Click the button named Device Detection on the main interface to enter motor configuration interface. In this interface, functions such as motor debug, thread cutting cutter testing and reset can be achieved. As shown in the figures.



2.3 Cylinder debug

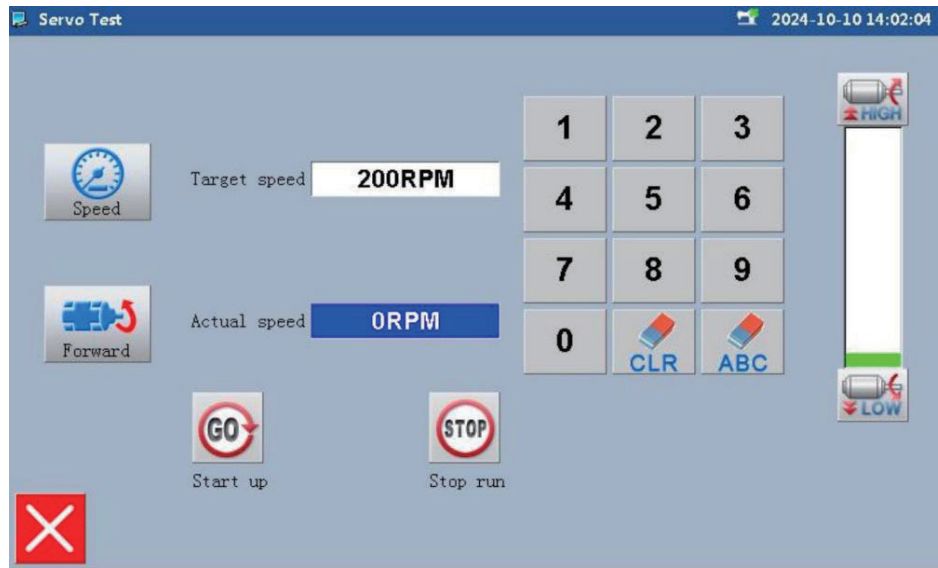
Click the motor debugging interface [Cylinder debug] button to enter the cylinder debugging interface. This interface can realize the functions of cylinder key state, cylinder debugging, rewinding test, etc. As shown below.



2.4 Servo Speed Detection

Click the “Servo Speed Detection” button on the motor debugging interface to enter the spindle testingf interfaces.On this interface ,you can debug the spindle speed.As shown in the figure.

- 1.Disolay the actual speed and show the curent spindle’s actual speed(RPM).
- 2.Ste speed:Allow the useof input or buttons to reach the target speed.
- 3.Control buttons:Basic opeation buttons such as start,stop ,reset,etc.
- 4.Alarm:if a safe range is set ,an alarm message will be displayed.
- 5.Adjustment and optimization:If it is necessary to adjust the spindle speed,the target setting value can reset.



2.5 Mainaxle motor Angle Correction

Click the button named “ Servo angel Detection ” on the device detection and debug interfacen to enter Mianaxle motor angle correction .This interface allows ffor mainale motor Angle Corrextion.As shown in the figure.

- 1.Determine necessary safety measures before making afjustments,Install the sensor correctky onto the spindle and refernce point.Confirm that they are secure and in the cirrrect position.Exctly Open the interface and complete the initlization settings;
- 2.Find the “Spindle Motor Release/Lock” button on the interface.Clicking this button can release or lock th state ,allowing it to move freeky and conveniently.
- 3.Conduct measurements,rotate the spindle by a certain angle ,read data from multiple position
- 4.After adjusting to the satisfactory postion,find “Spindle Motor Lock” on the soft armor interface to prevent it from shifting during operation.
- 5.Final validation,perfrom a complete measurement again to ensure that all parameters are within the allowable tolerance range.

mainaxle motor Angle Correction 2024-10-10 14:01:35

	Current electrical Angle	000	
	corrective Mechanical angel	000	degree
	main axle original singal		

	Needle rod highest position calibration	000	
---	--	-----	---

	Take-up-lever highest position calibration	---	
---	---	-----	---

Chapter 3 : System upgrade and functions

3.1 System upgrade Mode

Click on the testing interface **【System update】** -> **【Update】** ,enter the Version Mode interface.Used to view the version number of the control system.For example: MCtrl version、 Panel information、 LOGO version、 Stepping motor1 version ,etc information.

Click the upgrade button to enter the system upgrade interface.This interface allows for version upgrade and system restore function.As shown in the figure.

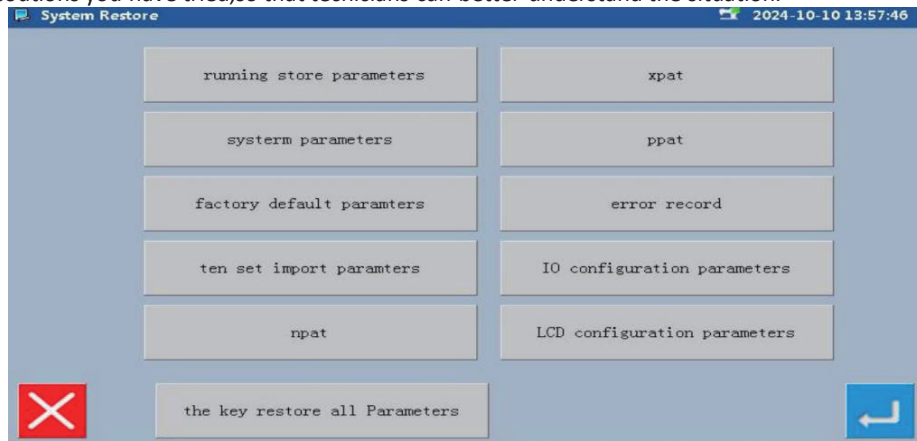


1.Upgrade:Search for USB drive upgrade files and select the upgraded system,Click on the one upgrade button to proceed with the upgrade process.Don't turn off the power during the upgrade process.After upgrading , a prompt box will pop up ,please restart the power supply.

2.Restore: Click the one click recovery button to enter the system restore.As shown in the figure.You can restore all parameters with one click or select the parameter items that need to be restored.Restore the operation to the original default values.After the system is restored ,a prompt box will pop up,please restart the power supply.

3.System restore:Click the [the Click restore] button to enter the system restore interface ;As shown in the following figure interface; As shown in the following figure.You can restore all parameters with one click ,or select the parameter items that need to be restored.After the operation,restore to the original default value.After the system restoration is completed,a prompt box will pop up,please restart the power supply.

4.Troubleshooting: if the upgrade issue persists.You can search for the technical support contact information provided by the company.Please make sure to provide a detailed description of the problem you encountered and the solutions you have tried,so that technicians can better understand the situation.



3.2 Functionmode

Click on the motor debug 【system Maintain】 -> 【Function mode】 button,enter the function mode interface.This interface is divided into 10 modules.As shown in the figure .



Chapter 4 : System parameters

Parameter List:

Parameter Name	Default value	Range
Sync scale (1 Set)		
Side wheel sync scale	815	500-2000
Left wheel sync scale	863	500-2000
Middle wheel sync scale	9.9	500-1600
Middle wheel cylinder switch	ON	ON\OFF
Left Wheel lifting switch	ON	ON \ OFF
Left wheel cylinder switch	ON	ON \ OFF
Put on elastic (2 Set)		
How long to extend after retracting close and open	350	1-30000
After the end of idling and the completion of bone collapse and a amount of time	100	
Sewing action (3 Set)		
Right wheel corection in the later stage of sewing	Stop correct ion	External correct ion
Sewing position 1	6000	1000-10000
Sewing position 2	7000	1000-10000
Sewing position 3	7500	1000-10000
Outer circle right wheel outward correct ion speed	0	0-9999
Speed of center corrent ion position 4	1	0-9999
Direct ion of act ion for pos ition 4 of center correct ion	Outward	Outward、Indward
Correct ion method	Convent ial	Convent ial 、 After the press foot falls
Trim sensor (4 Set)		

Parameter Name	Default value	Range
Whether the disconnection 1 is effective	Valid	Valid, Invalid
Whether the disconnection 2 is effective	Invalid	Valid, Invalid
Whether the disconnection 3 is effective	Invalid	Valid, Invalid
Number of broken thread 1 detection	50	1-1000
Number of broken thread 2 detection	50	1-1000
Number of broken thread 3 detection	50	1-1000
Number of broken thread 3 detection	50	1-1000
Trim (5 Set)		
Whether the thread trimming cylinder is valid	Invalid	Valid, Invalid
Delay from thread trimming opening to closing	100	10-3000
Whether the hook line is effective	50	10-3000
The delay from hooking close to subsequent action	Valid	Valid, Invalid
Security switch detection alarm	120	10-3000
Counter (6 Set)		
Sets function of Up counter	ED	--, ED, CY
Sets function of DOWN counter	ED	--, ED, CY
Method of clearing (UP) counter setting value	--	--, IT, CL
Method of clearing (DN) counter setting value	--	--, IT, CL
Initialize UP/DN counter or not at power on	HOLD	HOLD, CLEAR
Prohibition of UP counter current value correction	ALLOW	ALLOW, FORBID

Parameter Name	Default value	Range
Prohibition of DOWN counter current value correction	ALLOW	ALLOW、FORBID
ON/OFF of stitch counter function 1	OFF	OFF、ON
Setting for warning stitch number of counter 1	1000	0-9999
ON/OFF stitch counter function 2	OFF	OFF、ON
Setting for warning stitch number of counter 2	1000	0-9999
Advanced para (7 Set)		
Servo enable signal delay	100	100-999ms
Time delay after servo ban	100	100-999ms
HALT Switch type	NO	ON、NC
Trim switch type	NO	ON、NC
Pneumatic check switch type	NC	ON、NC
Set language(8Set)		
Language	English	Chinese 、 English 、 Vietnamese、 Korean、 Turkish
Set language(9Set)		
Whether the cutter is valid	Effective	Effective、Invalid
Opening timing of the cutter	1800	0-9999
Reserved Para	3000	200-3500
The position where the cutter is lifted	450	1-3000
Number of stitches that cutter stops in advance	1	0-50
Roller adjustment(10 Set)		
Speed of idling when start	600	50-600
The empty rotate speed in boneless position	50	1-100
Roller adjustment(11 Set)		

Parameter Name	Default value	Range
Start slow stitches	5	0-15
Start slow stitch speed	1000 rotate	200-4000
Fine-tuning the speed the left wheel slow start	100%	20-200
Fine-tuning the speed the right wheel slow start	100%	20-200
Tail stitch position(12 Set)		
End slow stitches	5 stitches	
End slow stitch speed	1000 rotate	200-4000
Fine-tuning the speed the left wheel slow end	100%	20-200
Fine-tuning the speed the right wheel slow end	100%	20-200
Panel set(13 Set)		
Buzzer action can set when fault	Once	
Null Move display or not display can be set	Display	Display, HIDE
Select the display area of pattern	Clamp	Clamp, ACT_PAT
Whether do support TPAT?	NO	NO, YES
Display Trim icon in main window	Show	Show, Hide
Pat ZOOM Multiple	1	1-25
Setting zoom style	Current Stitch	Current Stitch, origin
Sound Setting	ON	OFF, ON
Communication Setting	OFF	
Sound volume setting	100	0-100
Direction key and motor runs direction is unanimous or	unanimous	Unanimous, reverse
Whether save pattern to USB disk when save pattern to memory	NO	NO, YES
The display type of speed value	speed	Gear, speed
Whether support long file name	Support	Don't, Support

Parameter Name	Default value	Range
Whether support previous file name	Not	Not, Use
Whether display empty stitch	Don't	Don't, Support
Next dialog mode	Normal mode	Normal mode, test Mode
Pat zoom way	Main Control	Main Control\Panerol
Main interface set(14 Set)		
Display language of icon on the left of main interface	English	Chinese , English , Vietnamese, Korean, Turkish
Receiving action(15 Set)		
Whether stacker is Used	Not used	Use, Not Use
Lifting distance of stacker	3000	100-30000
How long does the elastic band bracket retract after stacker descend	2000	20-20000
Automatic Start(16 Set)		
Whether to start sewing automatically	no automatic	no automatic, Automatic start
Delay time of automatic start	1000	100-30000
Left expansion and right expansion(17 Set)		
Whether the left expansion origin sensor is useful	Valid	Valid, Invalid
Left expansion range limit	1130x0.1	0-32767
Right expansion range limit	7700x0.1	0-32767
Seam flip blow(18 Set)		
Seam flip blow switch	ON	OFF, ON
Seam flip blow time	0ms	0-500m
First strand position switch	OFF	OFF, ON
Continuous(19 Set)		
Does it not stop during continuous testing	Stop	Stop , Continuous operation
Delayed inhalation(20 Set)		
Delayed inhalation time at the begin	200	1-1000



高林股份有限公司
KAULIN MFG. CO., LTD.

由於對產品的改良及更新，本產品使用說明書中與零件圖之產品及外觀的修改恕不事先通知！
The specification and/or the equipment described in the instruction book and parts list
are subject to change because of modification with out previous notice
ASC-EWA100.MAY.2026