SiRUBA

# 電控參數說明書

# ELECTRONIC CONTROL PARAMETER MANUAL

## ASK-ACS100

# ASK-ACS100 中文觸控面板圓領裝置操作說明

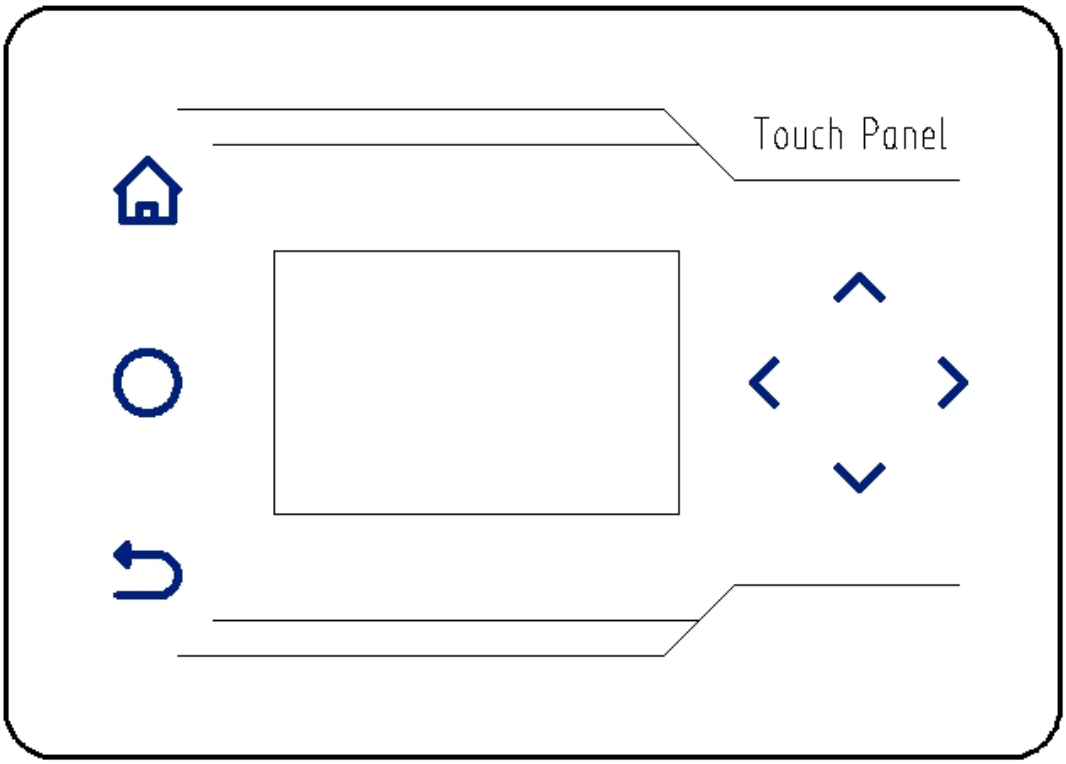



圖 1

## 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：

在按下 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：

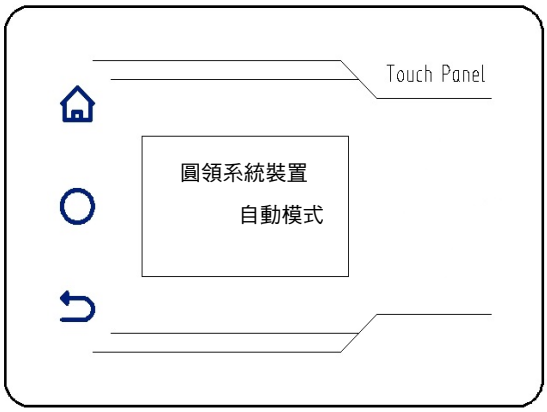



圖 2

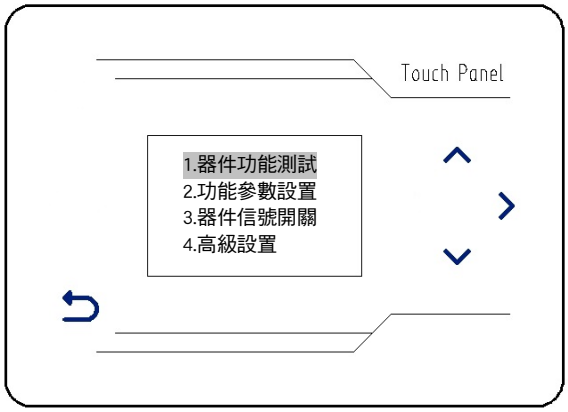



圖 3

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：

短按⌂ 再長按 ⌂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。【初始化設定，初始化系統到預設參數設置（密碼 1234）】。

## 四、介面操作說明

### (一)、器件功能測試：

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）:

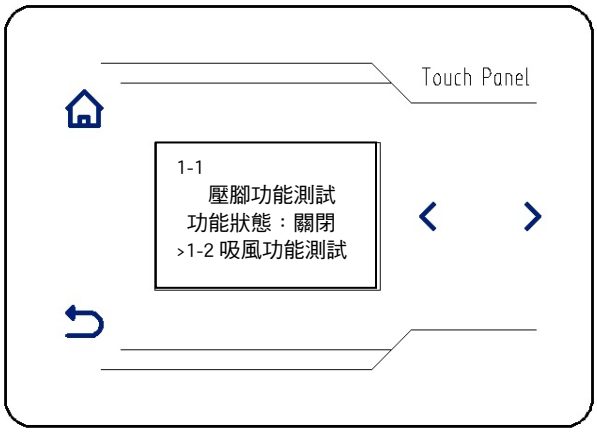



圖 4

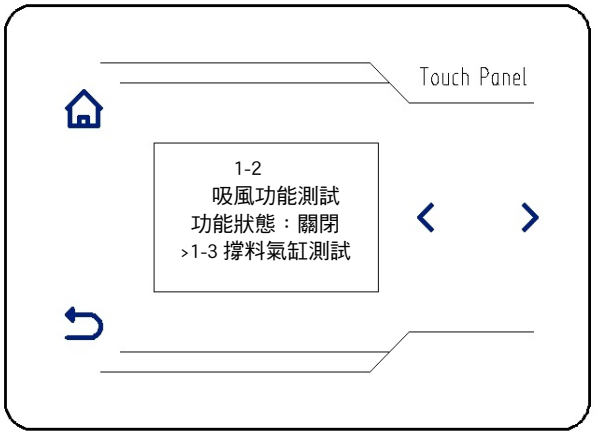



圖 5

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

1-9 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

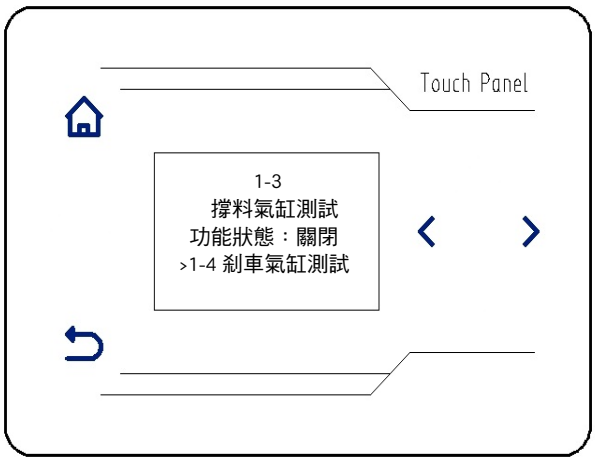
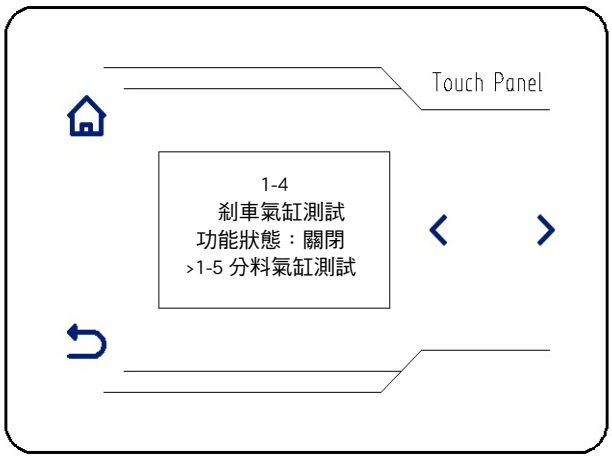



圖 6

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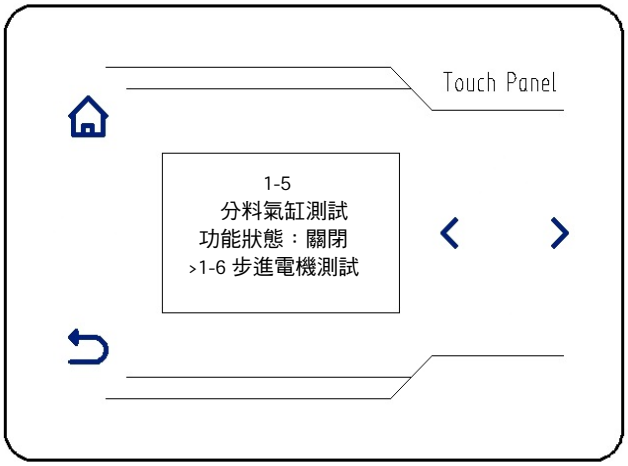



圖 8

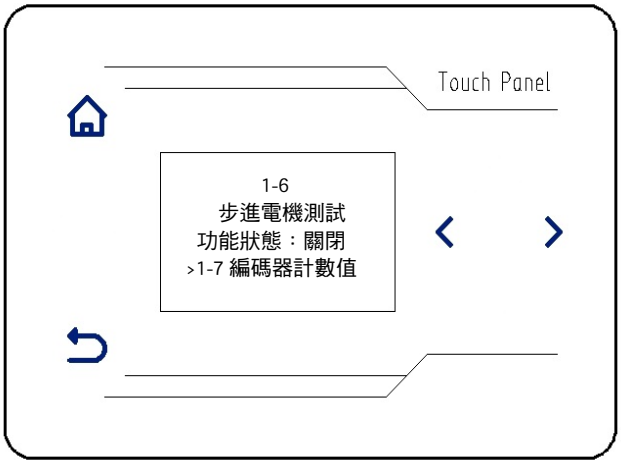



圖 9

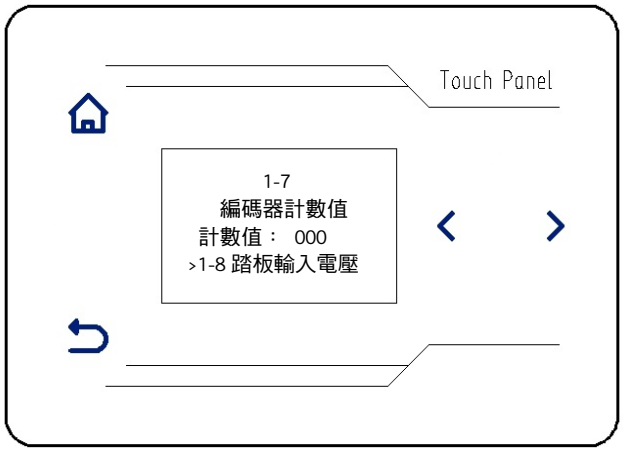



圖 10

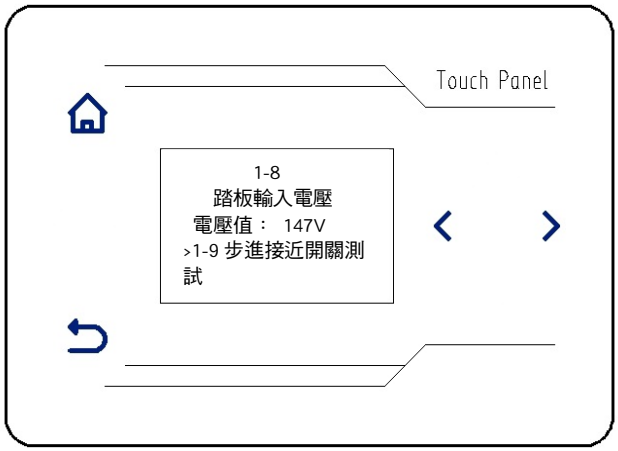



圖 11

## 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，（通過<左鍵、>右鍵）選擇“1-7 編碼器計數值”選項，轉動機器上手輪，每轉（正反轉皆可）一圈編碼器計數值會增加 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（預設狀態下顯示 140V-150V 之間）的調試，（通過<左鍵、>右鍵）選擇“1-8 踏板輸入電壓”選項，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。

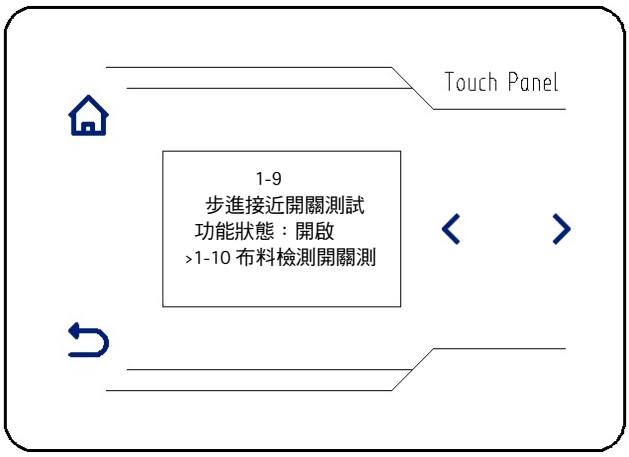



圖 12

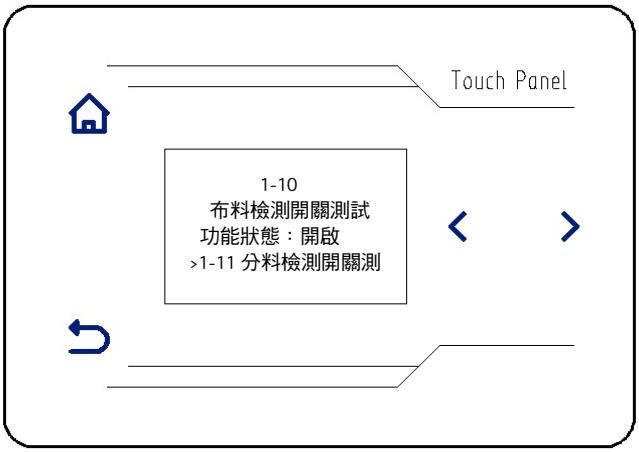



圖 13

## 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。

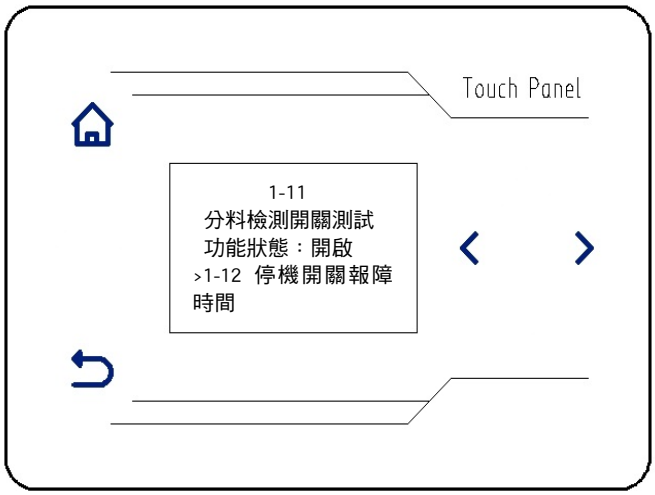



圖 14

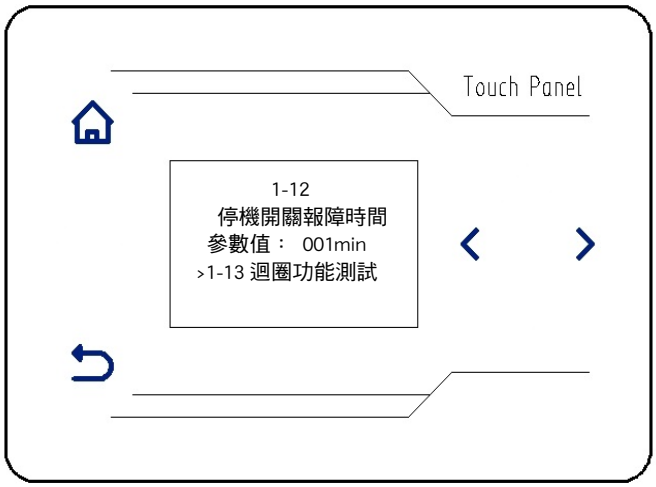



圖 15

## 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。

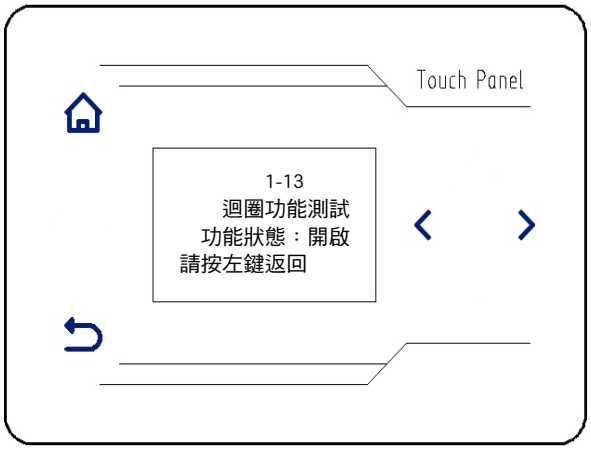



圖 16

## 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）。

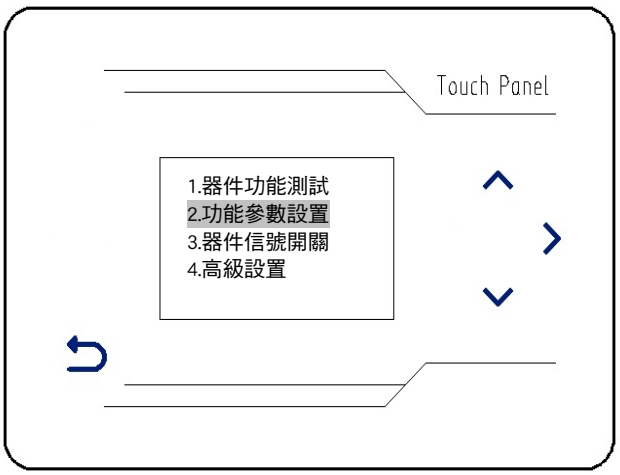



圖 17

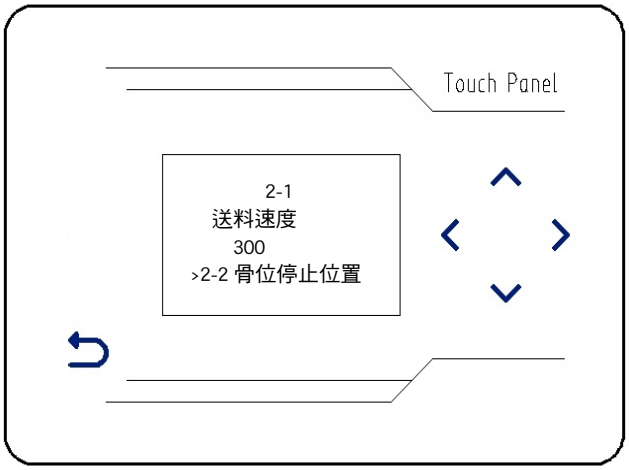



圖 18

## （二）、功能參數設置：

按∧、∨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∧、∨加減鍵，可調節送料速度或關閉。

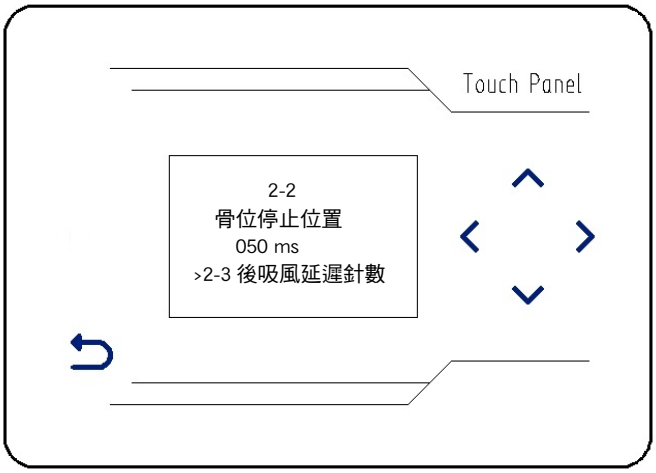



圖 19

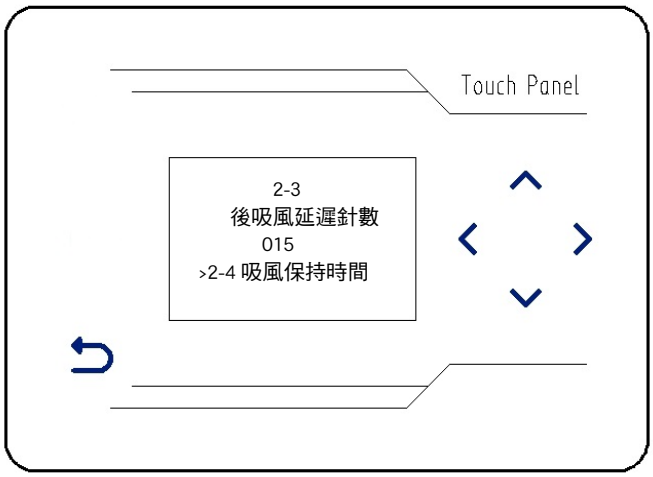



圖 20

### 2-2 骨料停止位置（圖 19）

骨料停止位置（默認 50ms）設置，通過∧、∨ 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∧、∨加減鍵，可調節針數以控制吸風開始時間。

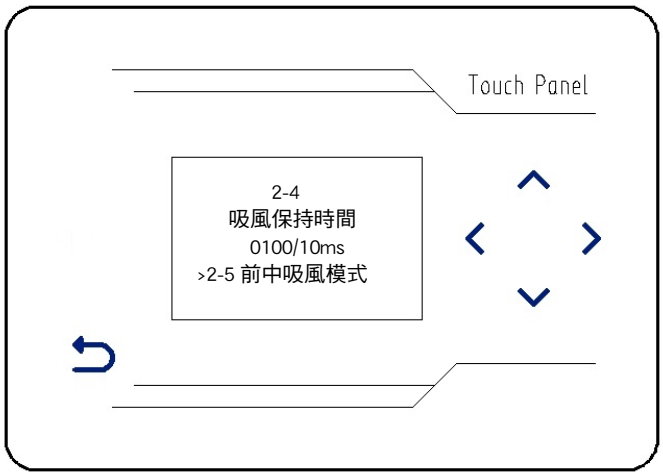



圖 21

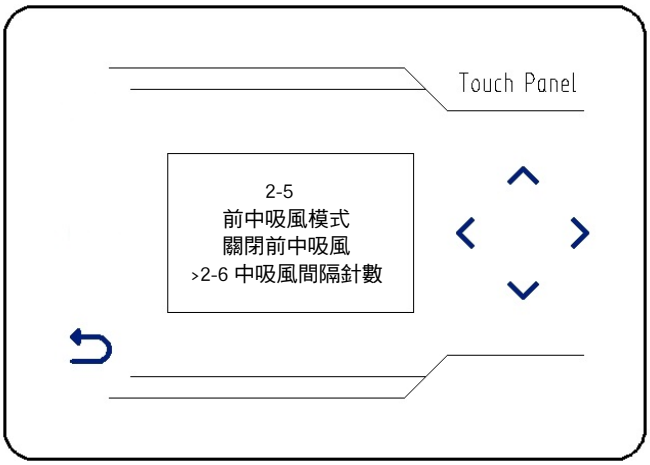



圖 22

### 2-4 吸風保持時間（圖 21）

吸風保持時間（默認 1000ms）設置，通過∧、∨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∧、∨加減鍵，可打開或者關閉前中吸風。

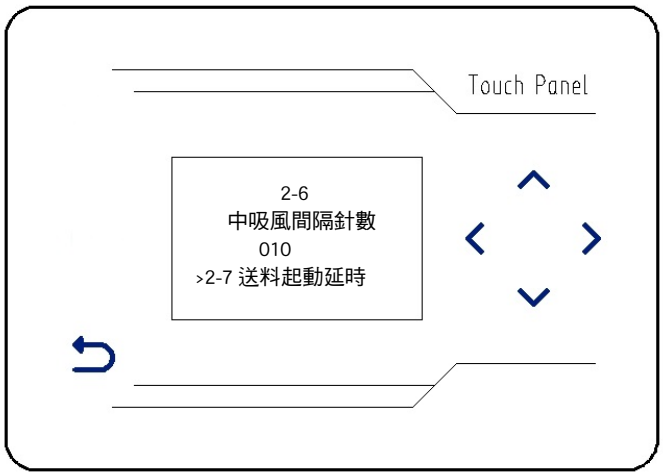



圖 23

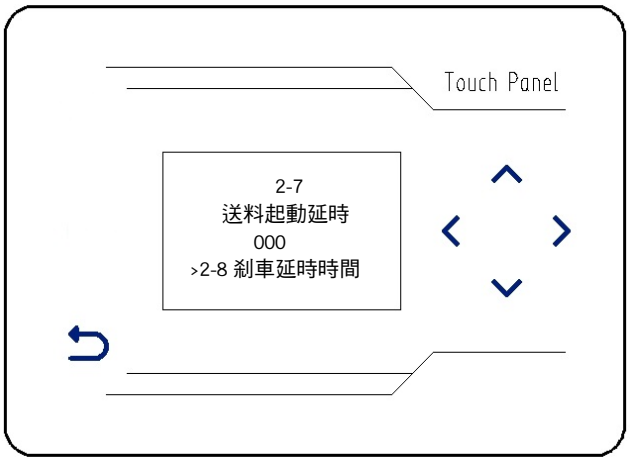



圖 24

## 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∧、∨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∧、∨加減鍵，可調節送料起動延時時間。

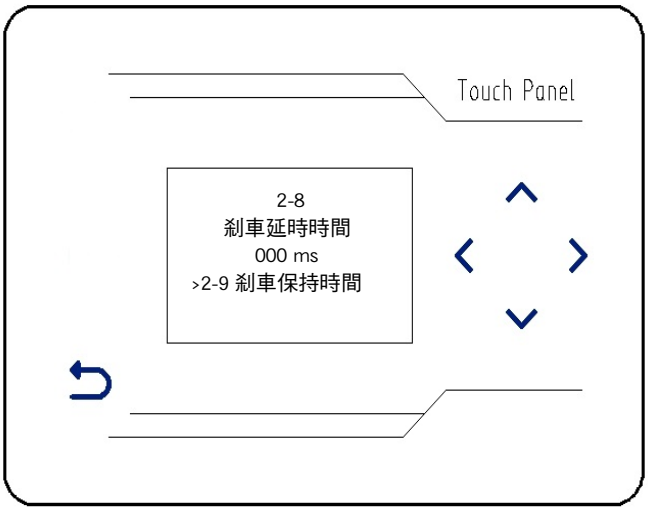



圖 25

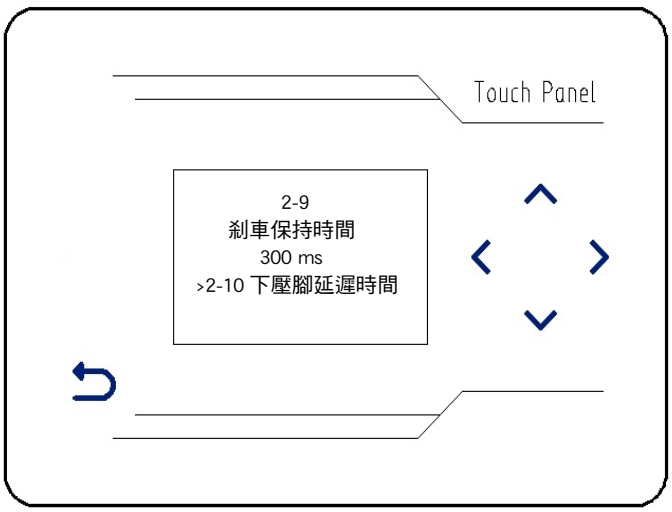



圖 26

## 2-8 剎車延時時間（圖 25）

剎車延時時間（默認 0ms）設置，通過∧、∨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∧、∨加減鍵，可調節剎車保持時間。

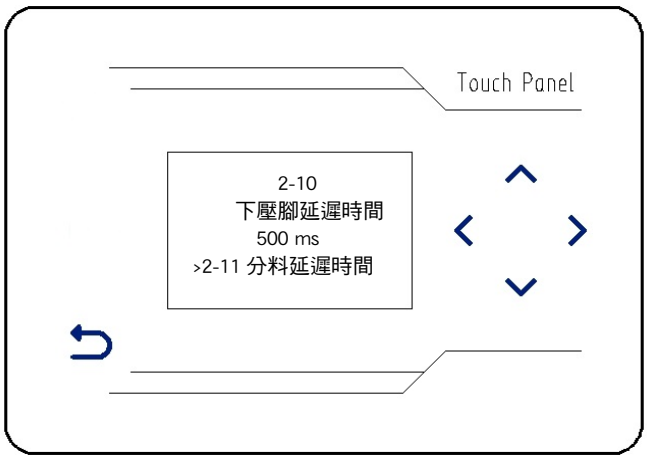



圖 27

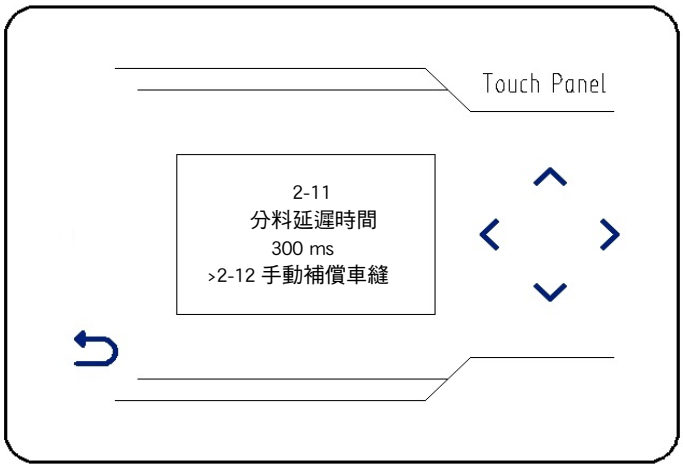



圖 28

## 2-10 下壓腳延時時間（圖 25）

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

## 2-11 分料延遲時間（圖 26）

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

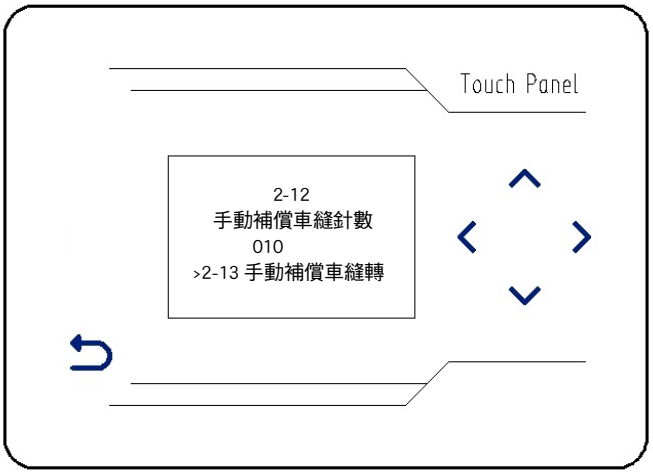



圖 29

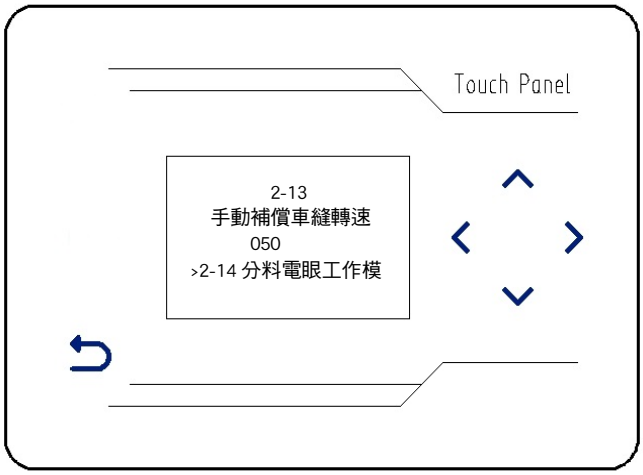



圖 30

## 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∧、∨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∧、∨加減鍵，可調節補償車縫轉速。

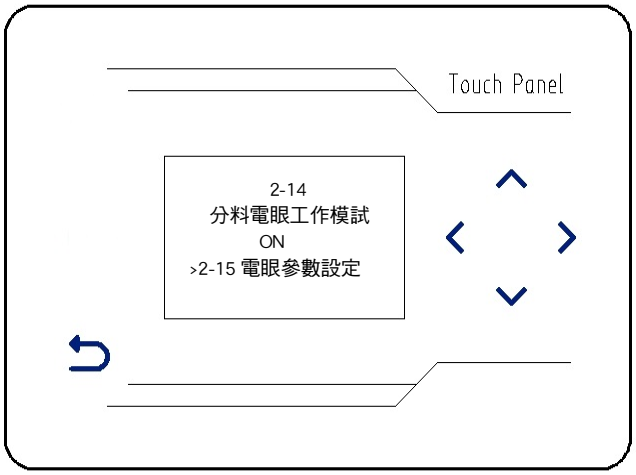



圖 31

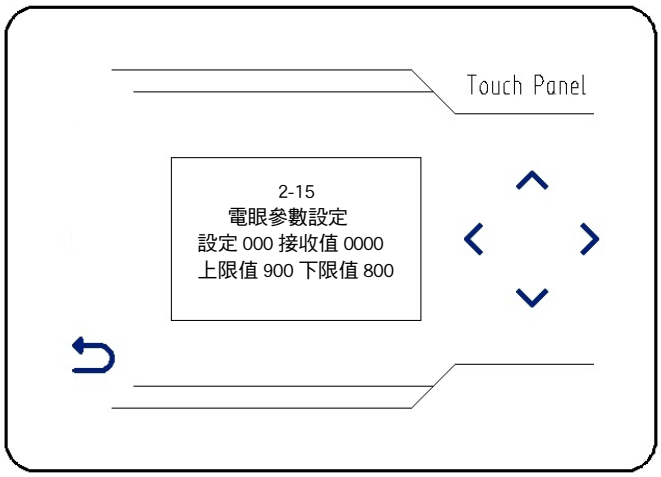



圖 32

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。

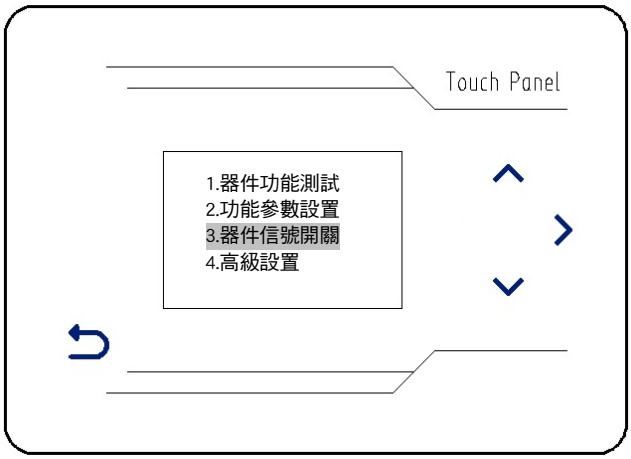



圖 33

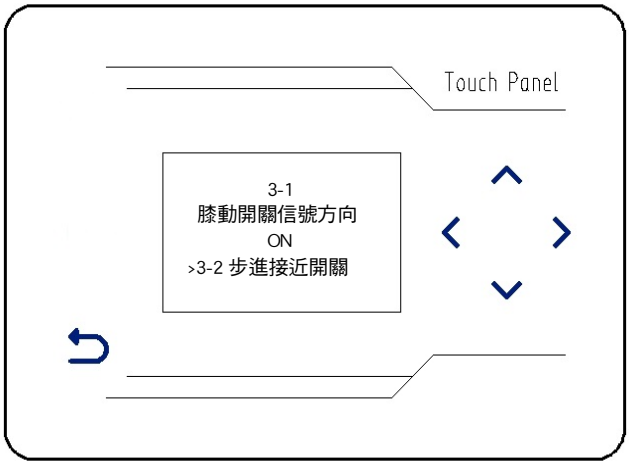



圖 34

## （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。

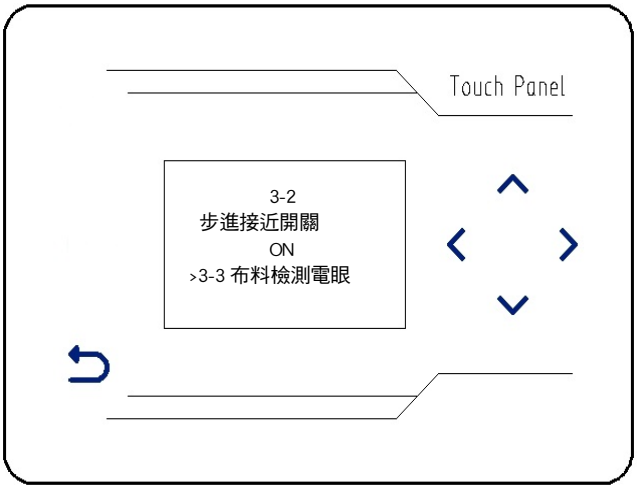



圖 35

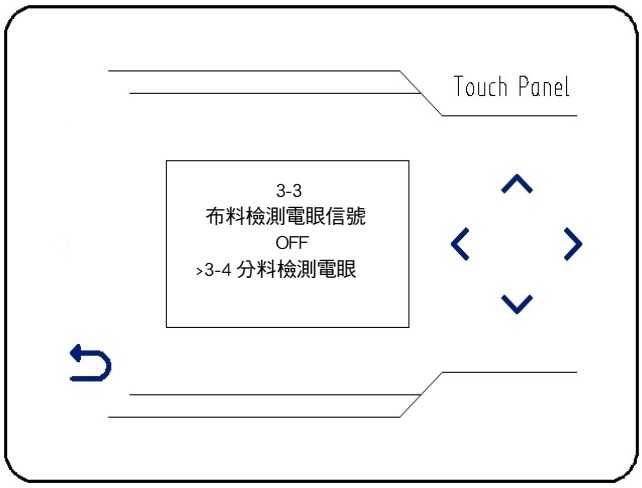



圖 36

## 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。

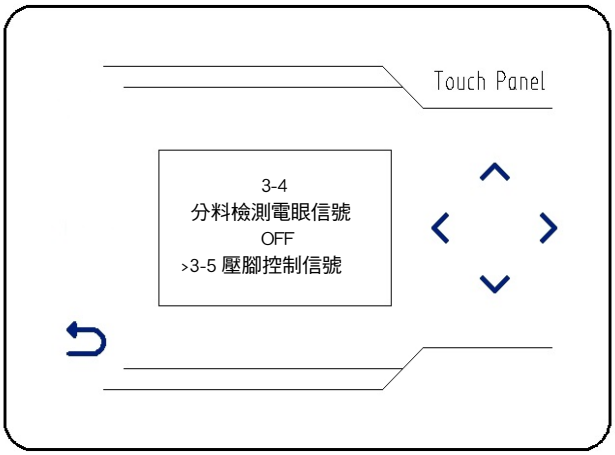



圖 37

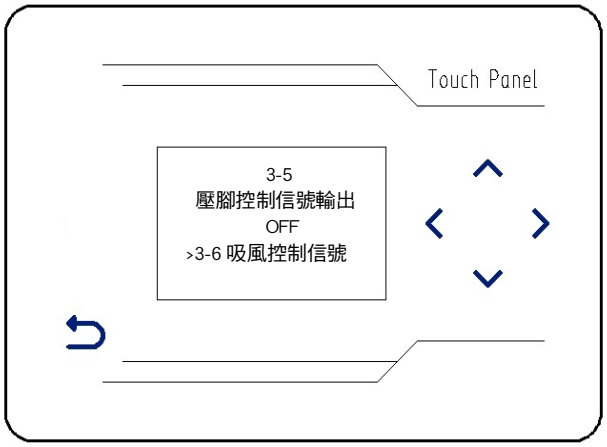



圖 38

## 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。

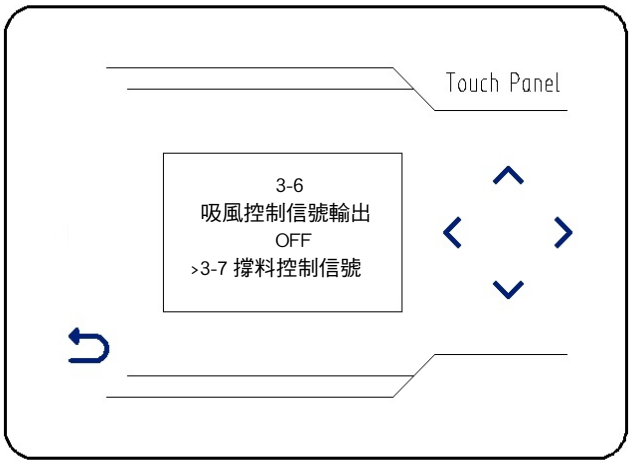



圖 39

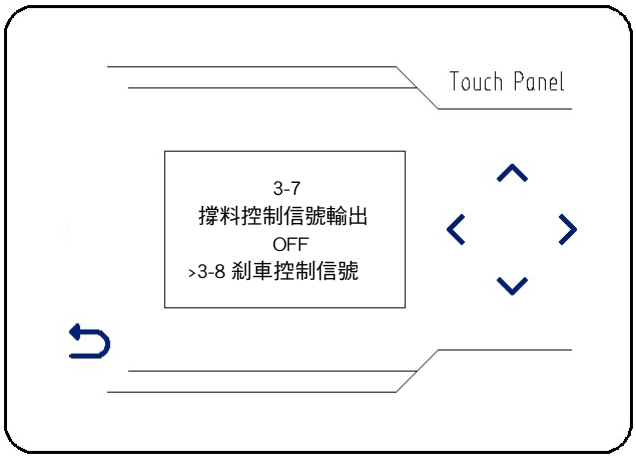



圖 40

## 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，通過 ^ 、 v 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 ^ 、 v 加減鍵，可打開或關閉壓腳控制信號輸出。

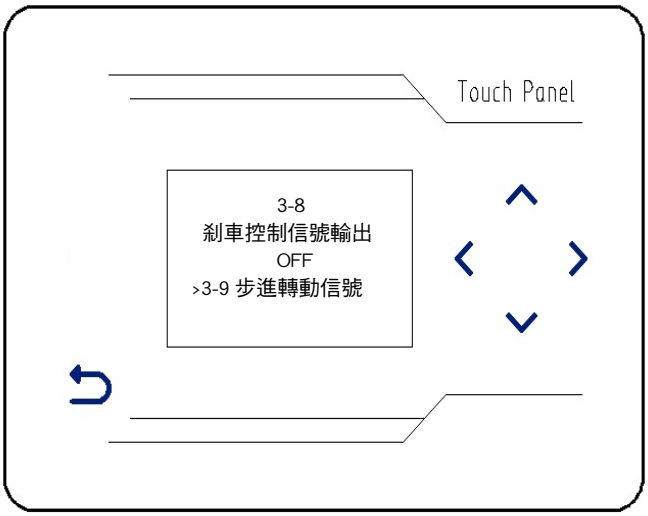



圖 41

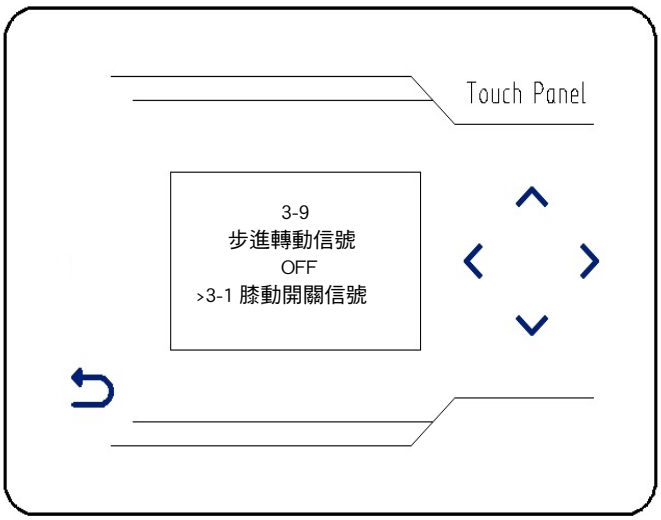



圖 42

## 3-8 剎車控制信號輸出（ 圖 41 ）

剎車控制信號輸出（ 預設 OFF ）設置，通過 ^ 、 v 加減鍵，可打開或關閉剎車控制信號輸出。

## 3-9 步進轉動信號輸出（ 圖 42 ）

步進轉動信號輸出（ 預設 OFF ）設置，通過 ^ 、 v 加減鍵，可打開或關閉步進轉動信號輸出。

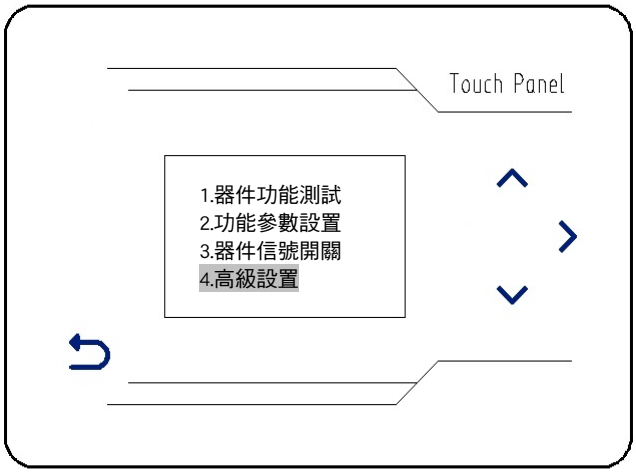



圖 43

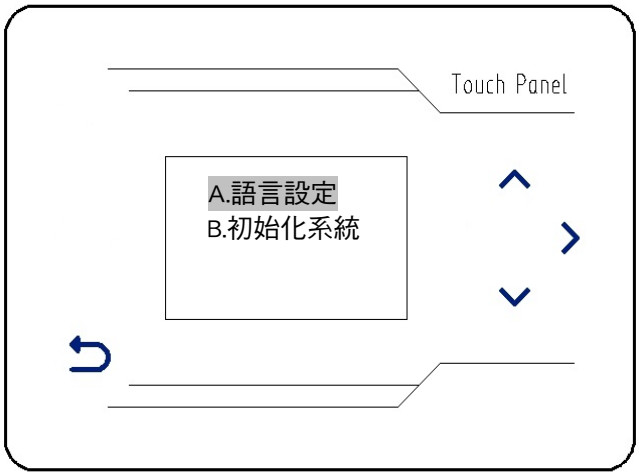



圖 44

## （四）、高級設置：

按∧、∨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∧、∨加減鍵，可選擇系統語言“簡體中文”或者“English”（英語）。

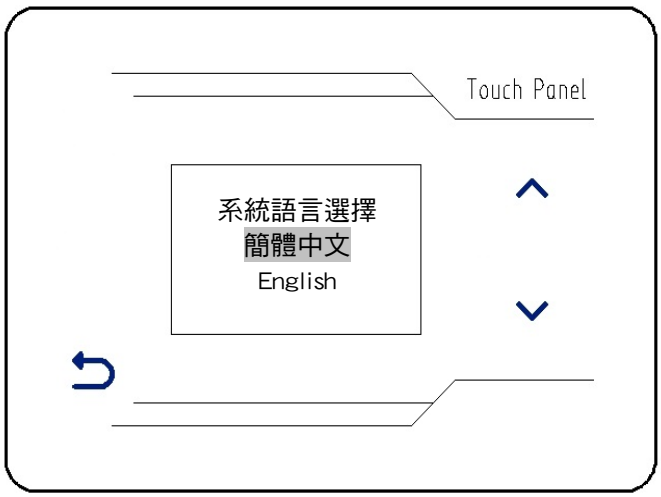



圖 45

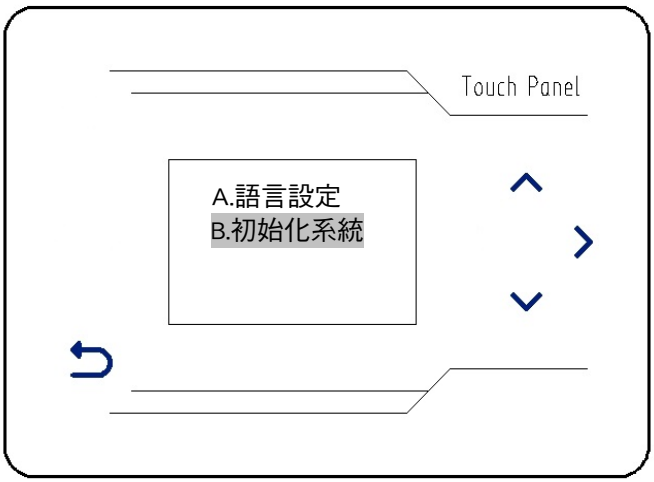


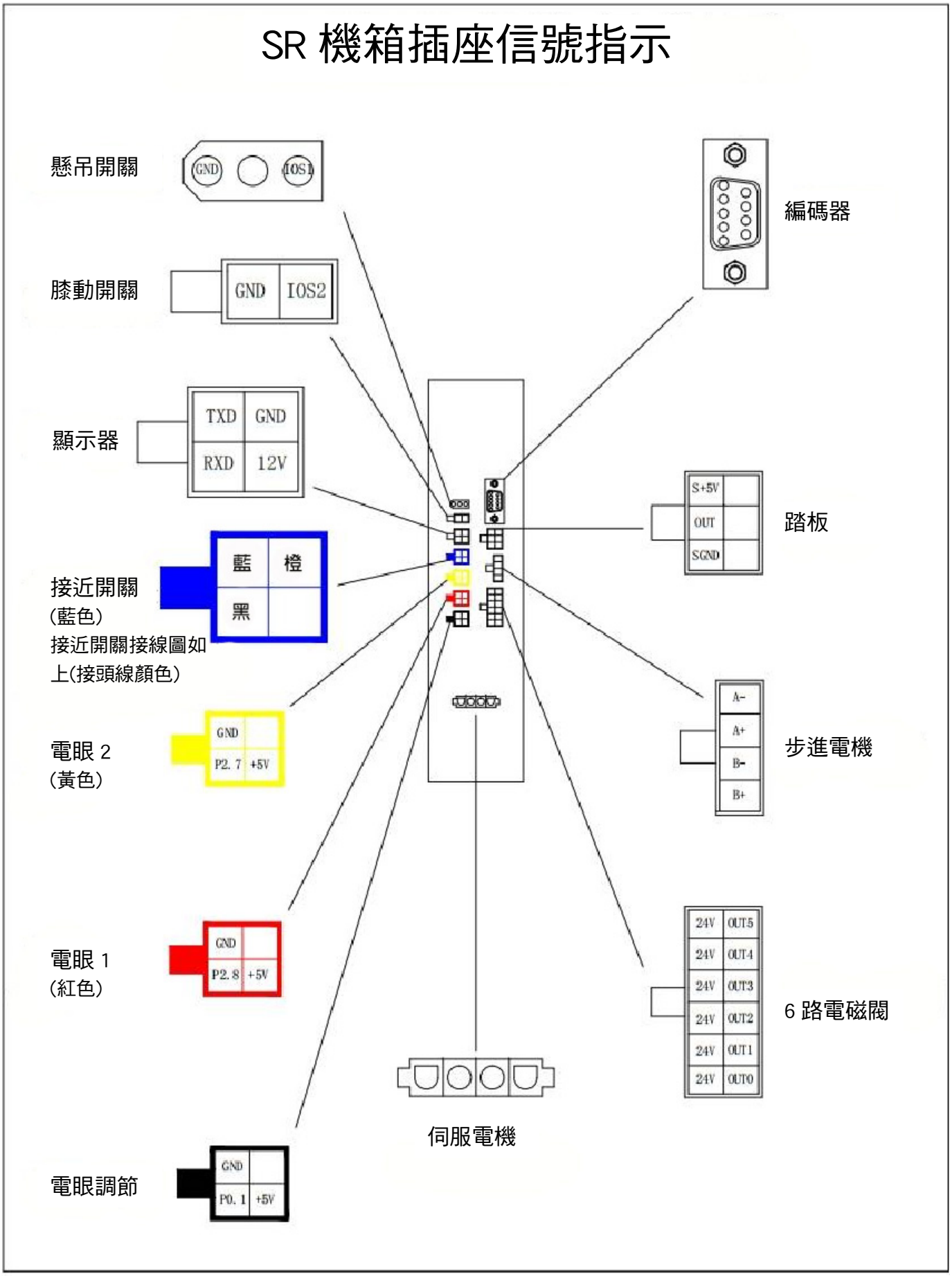

圖 46

B 初始化系統（圖 46）

在“高級設置”（圖 43）的子功能表介面下，按∧、∨加減鍵，選中“初始化系統”（圖 44），按下>右鍵，系統將恢復出廠設置，即“初始化系統”。

# 主機殼端子圖

## SR 機箱插座信號指示



# ACS100 English touch panel collar device operation instructions

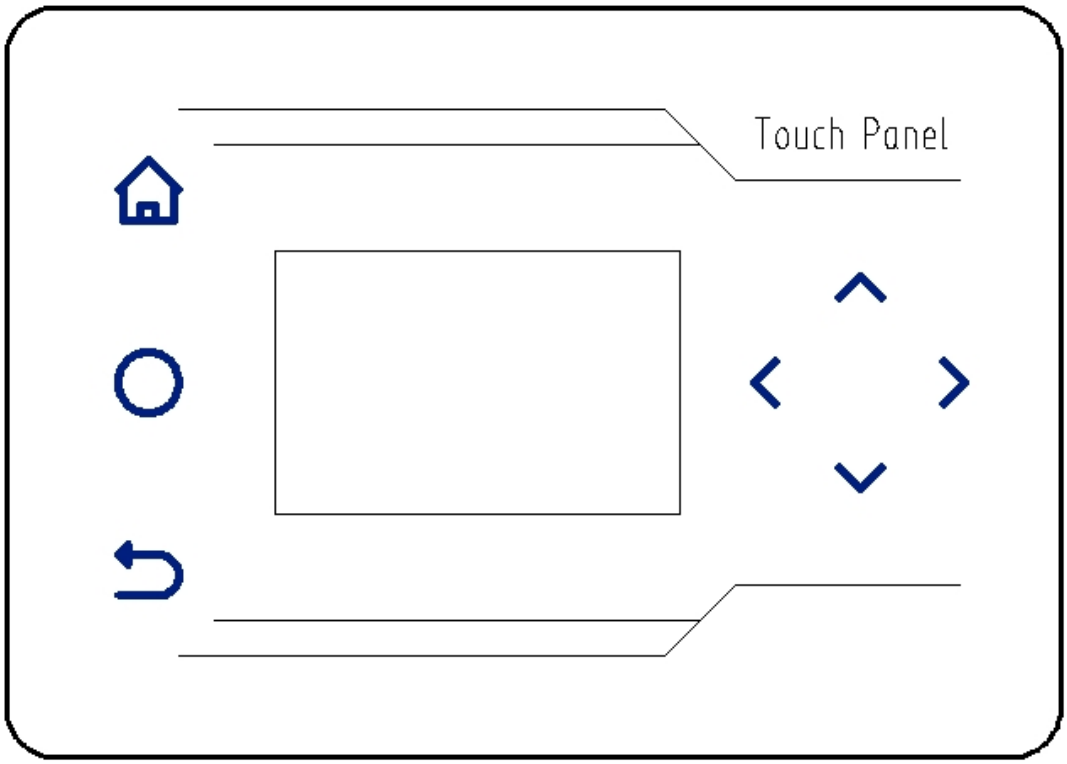



figure **1**

## 一、instructions for the use of keys

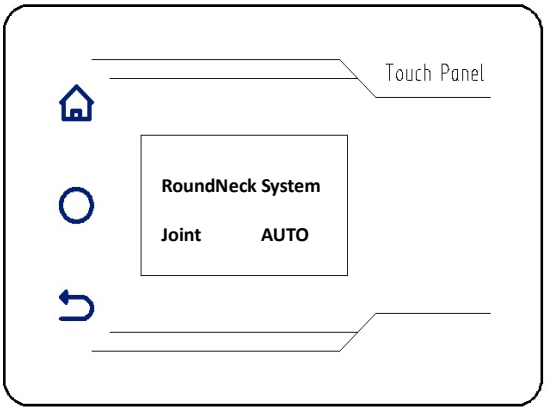
1. **Menu key, long press 3 seconds to enter the system parameter modification options.**
2. **Compensation key, used only in automatic state.**
3. **Return key, exit parameter modification page, return to work page, and save data.**
4. **Move the keys left and right. Move the parameters to modify the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

## 二、 Working mode, the left shift right shift key role.

In the 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-ck to display the data for the next project value.

## 三、Description of display window



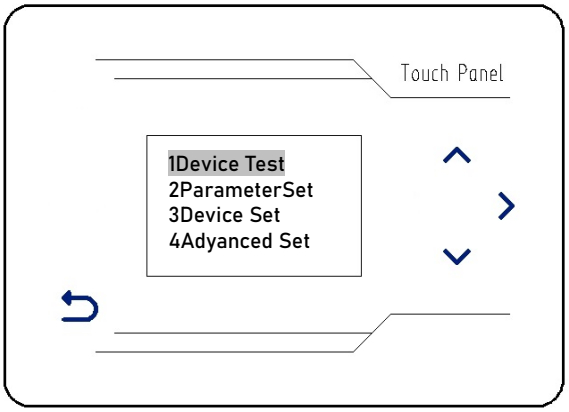




figure **2** figure **3**

Working status display:

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

Parameter function setting display interface:

Short press ⌂ According to the longer ⌂ Enter the parameter setting interface in 3 seconds (figure 3) :

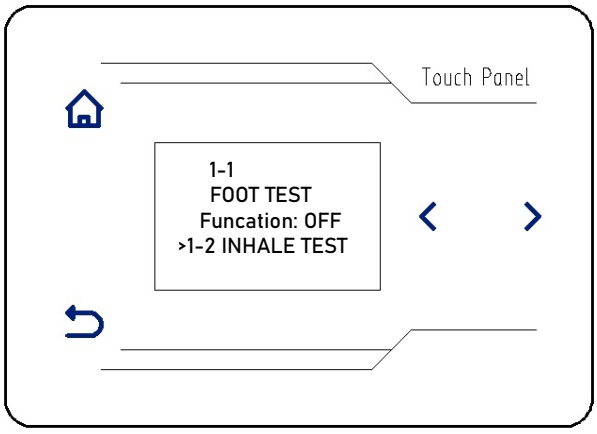
1. Device Test
2. Parameter Set
3. Device Set
4. Adyanced Set

[initialization Settings, initialize the system to default parameter Settings (password 1234)]

## 四. Interface operation instructions

### （一） device function test:

Pass ^ 、v Add button,Select "device test",Pass > Right click , Enter the sub-menu interface (figure 4) :



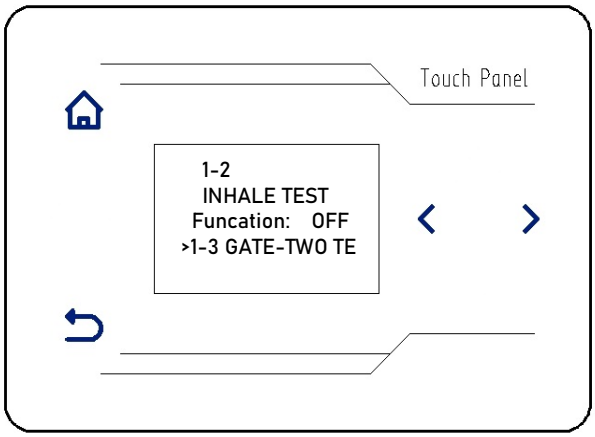




figure **4** figure **5**

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

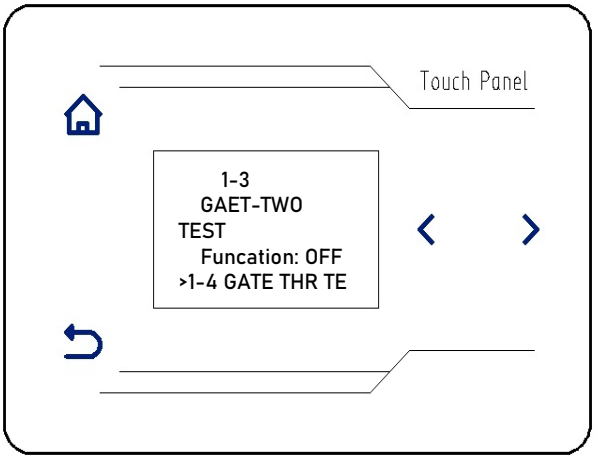



figure **6**

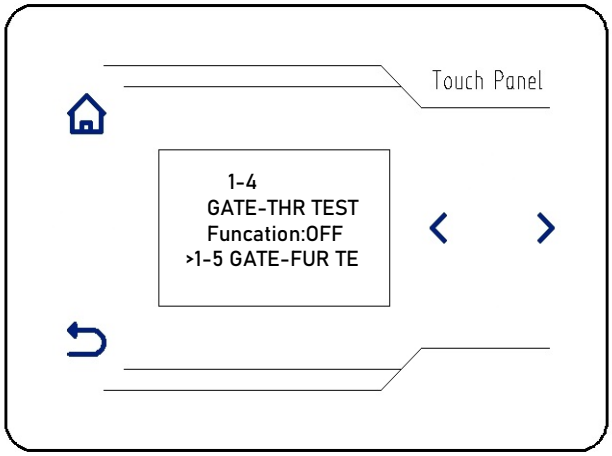



figure **7**

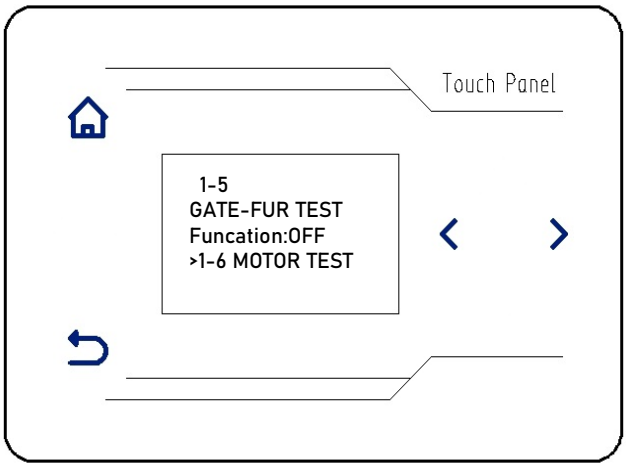



figure **8**

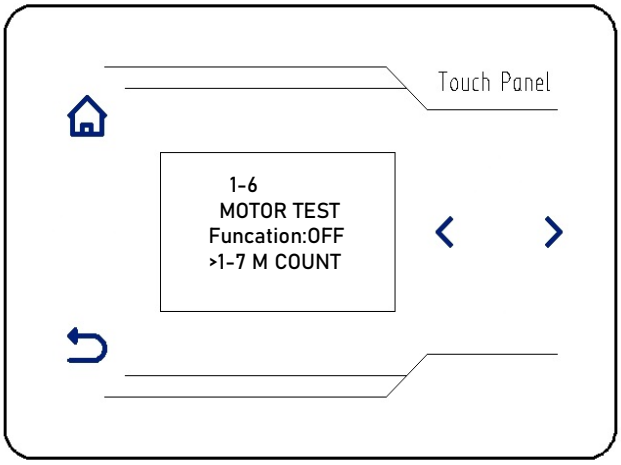



figure**9**

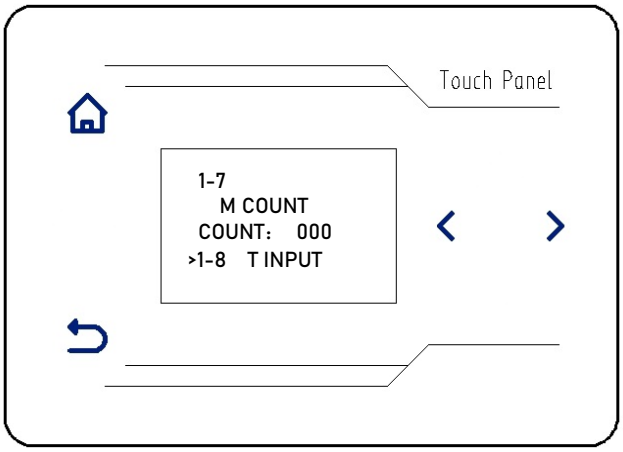



figure **10**

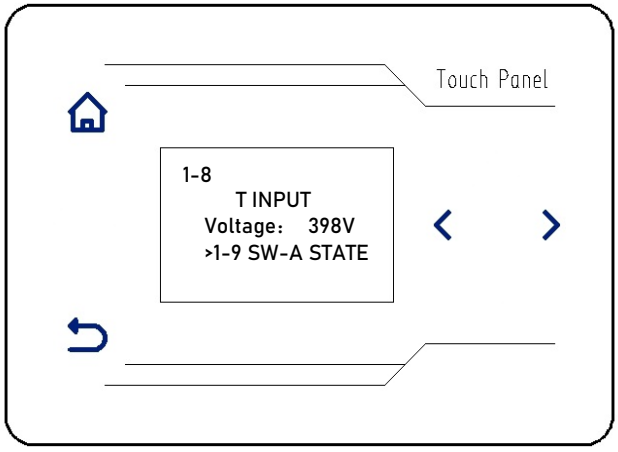



figure **11**

## 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.

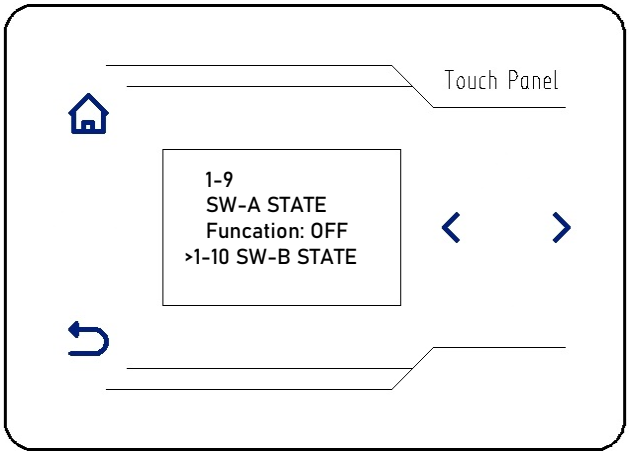



figure **12**

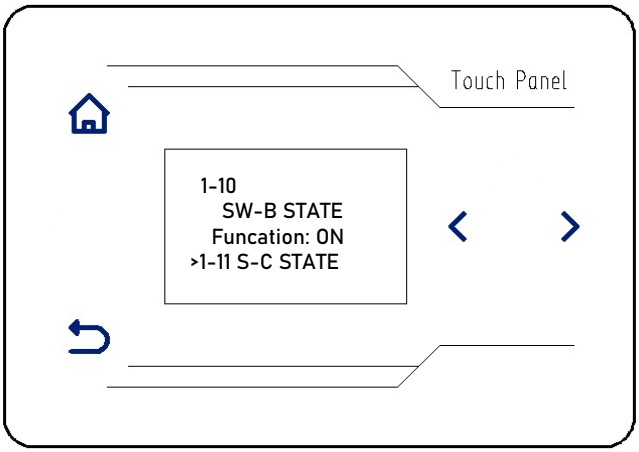


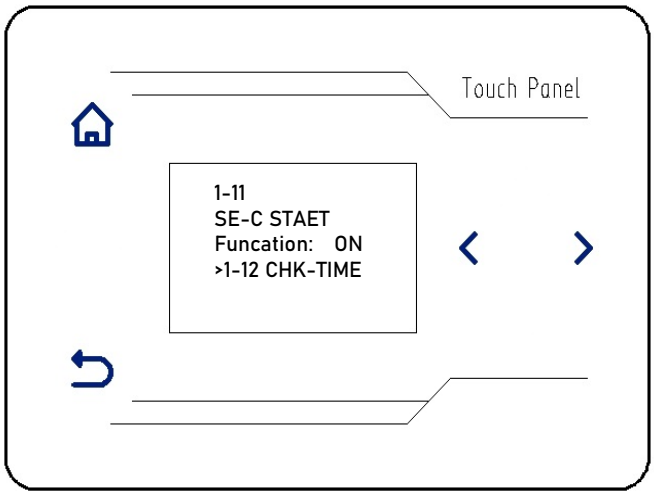

figure **13**

## 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.



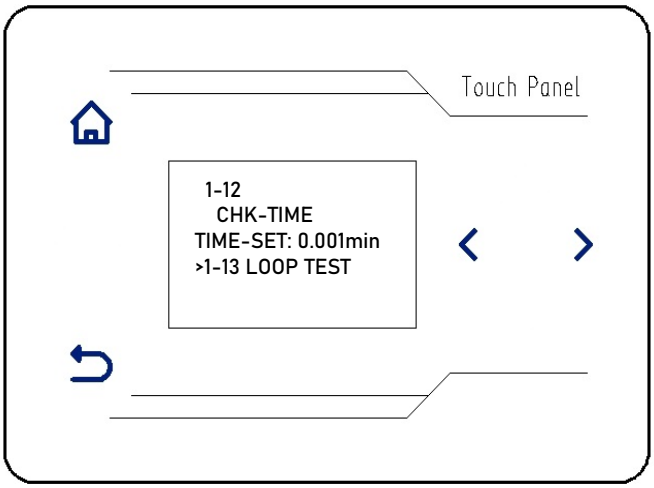




figure 14figure 14

## 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.

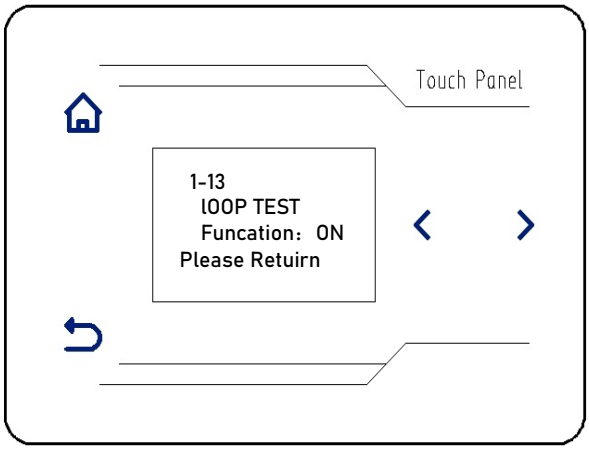



figure 16

## 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).

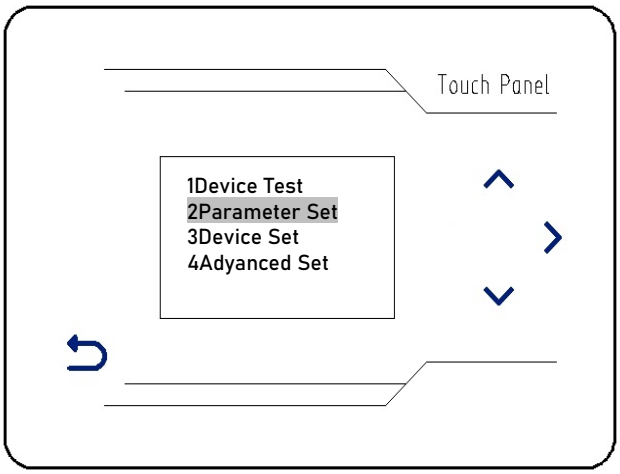



figure 17

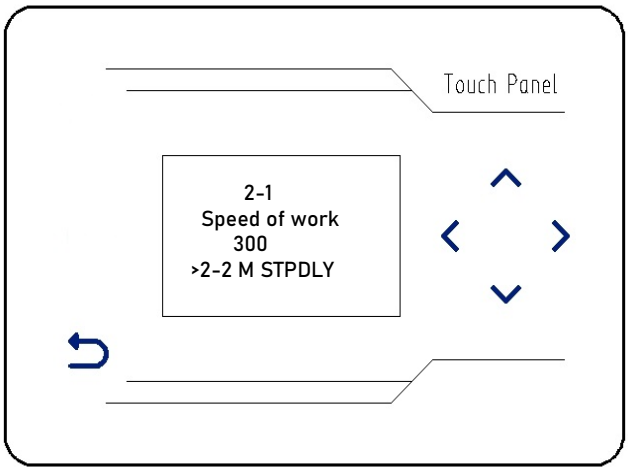



figure 18

## （二）Function parameter setting

Press ∧、∨add or subtract, select "function parameter setting" (FIG. 17), press the >right button, and enter the sub-menu interface (FIG. 18) :
2-1 feeding speed (figure 18)

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

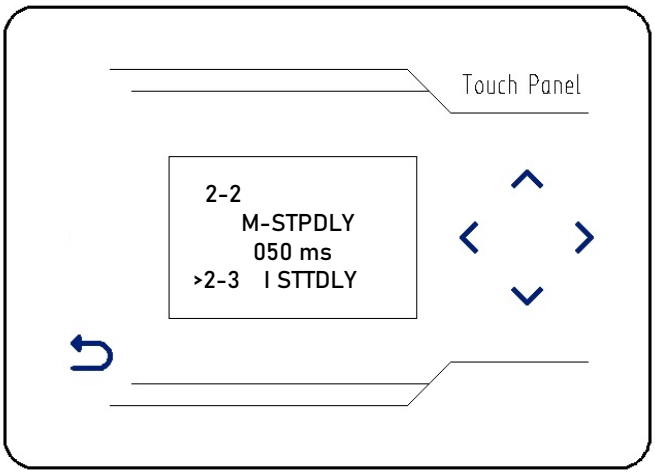



figure 19

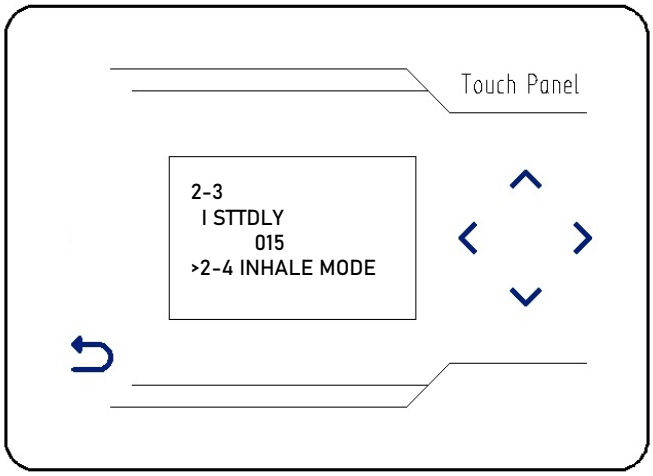



figure 20

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.

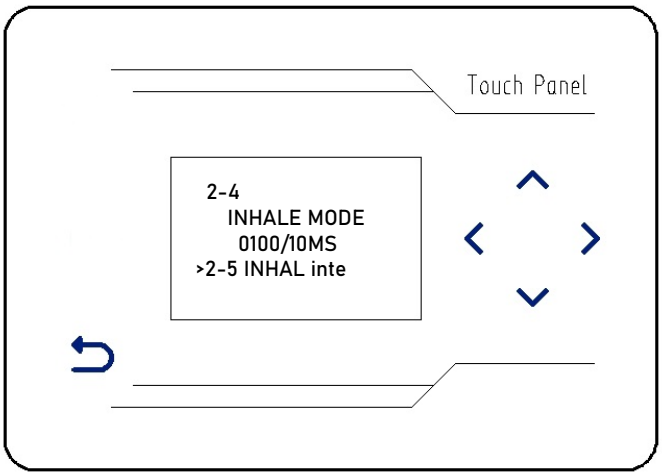



figure 21

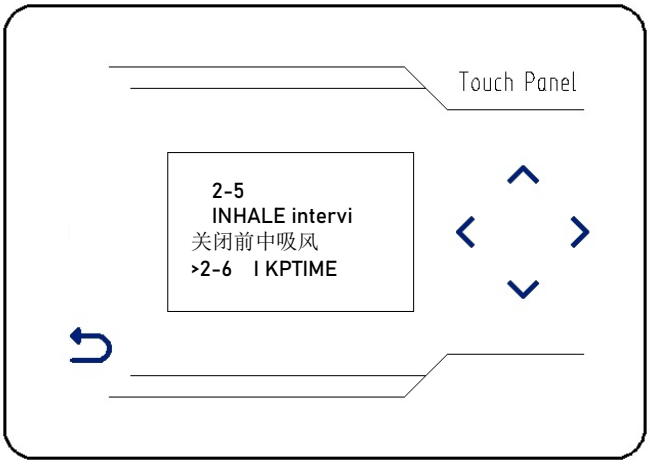



figure 22

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.

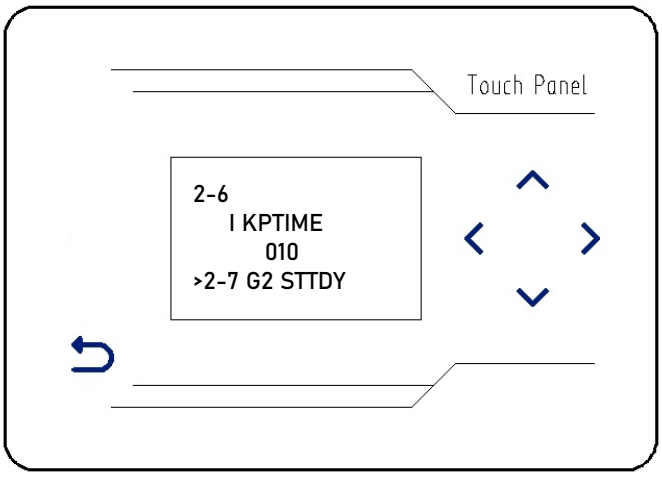



figure 23

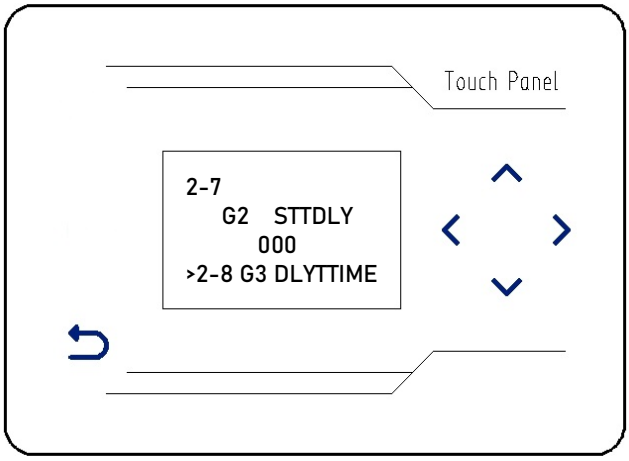



figure 24

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.

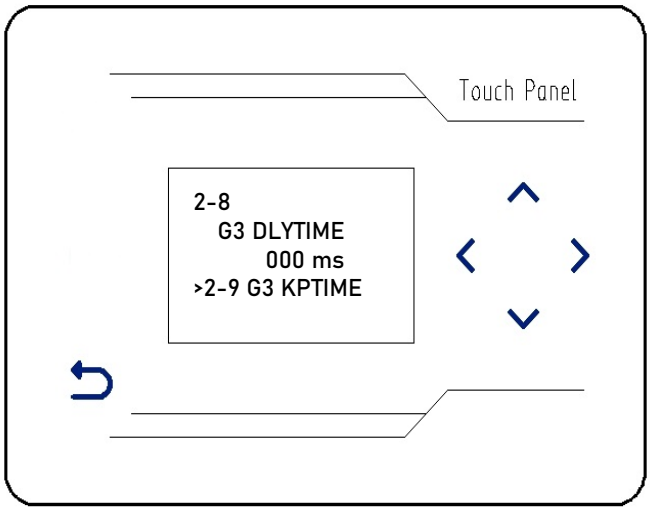



figure 25

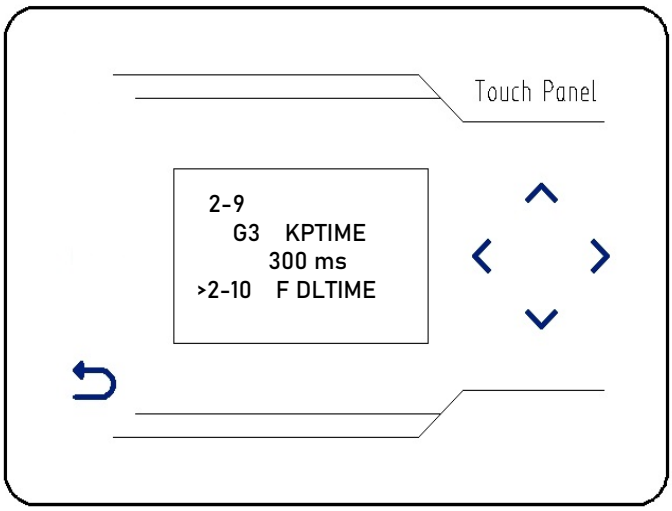



figure 26

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.

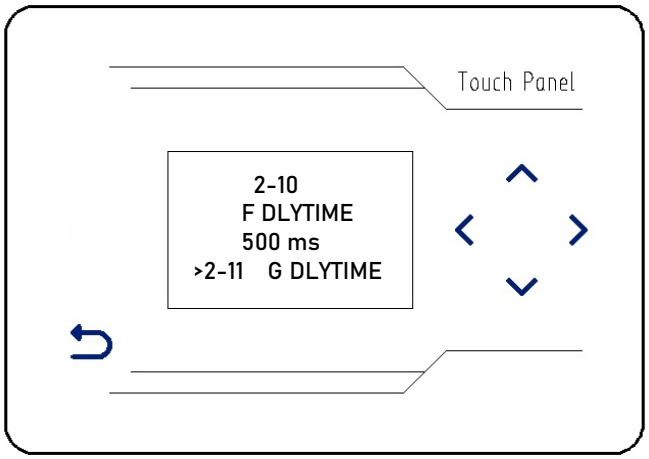



figure 27

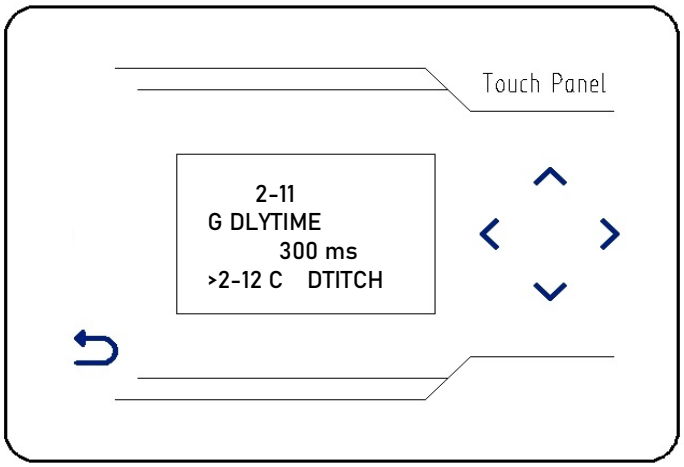



figure 28

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

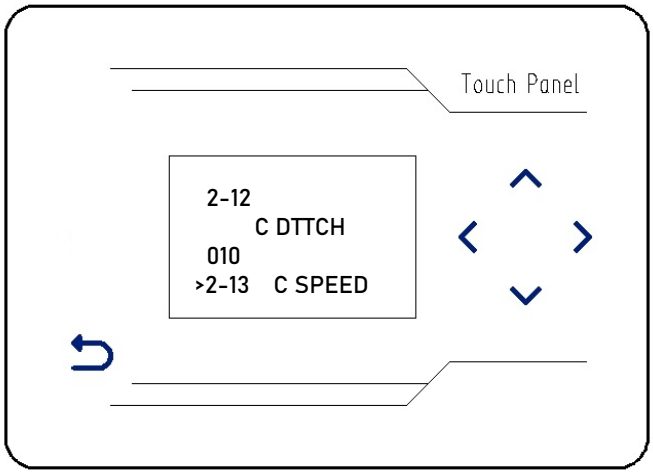



figure 29

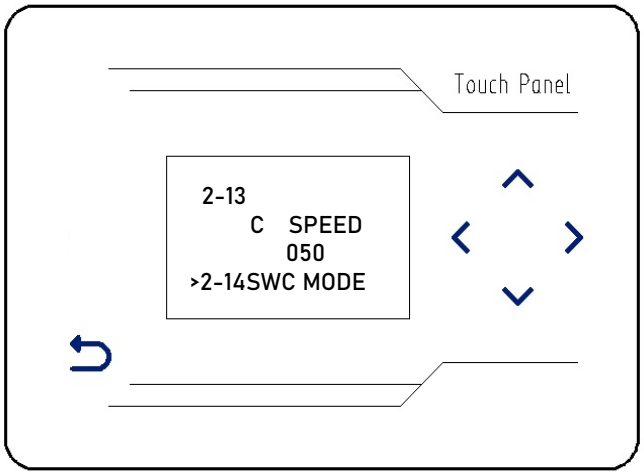



figure 30

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.

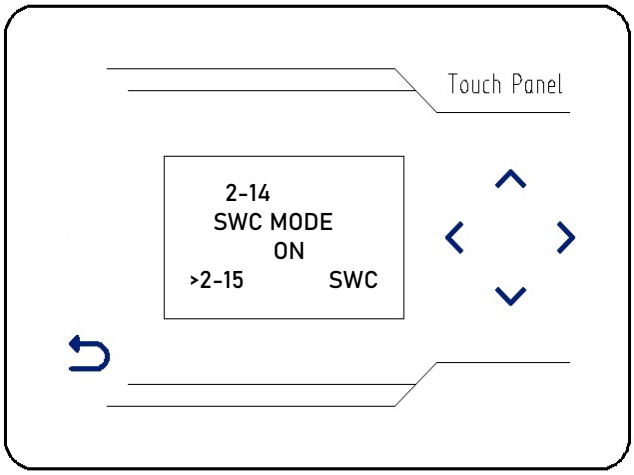



figure 31

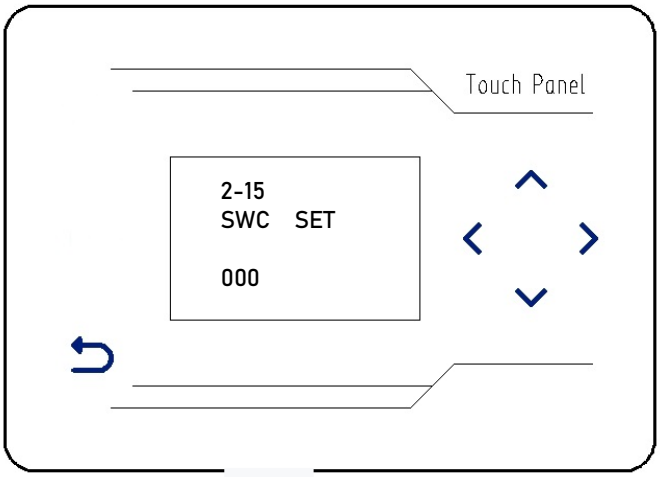



figure 32

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.

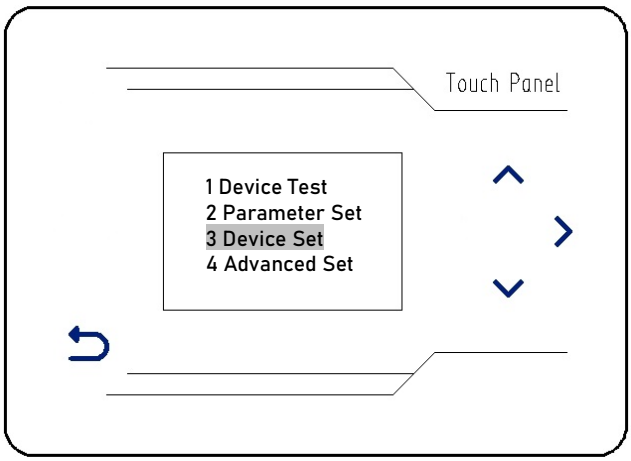



figure 33

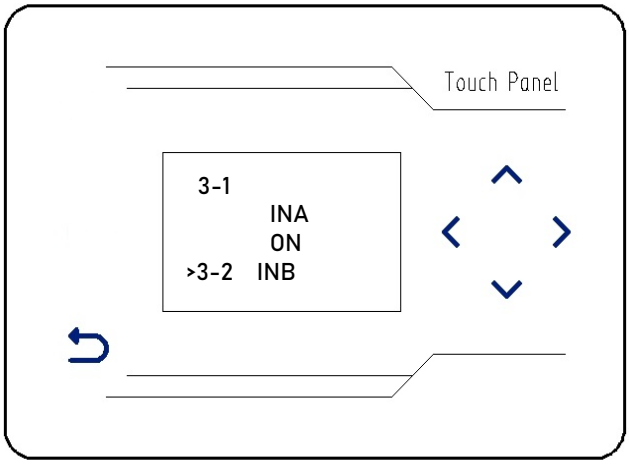



figure 34

## （三）Device signal switch

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

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

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

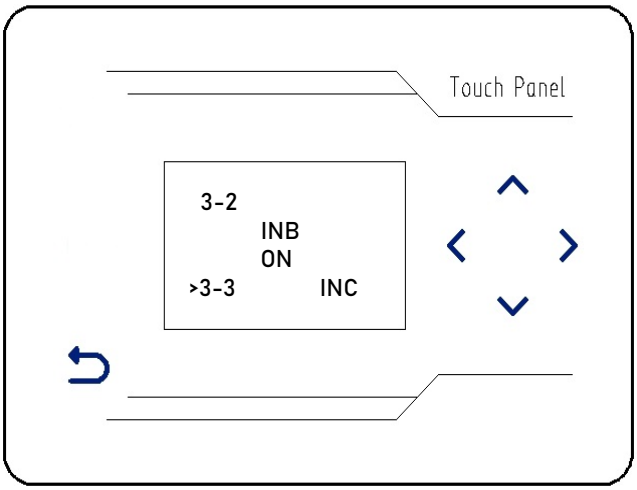



figure35

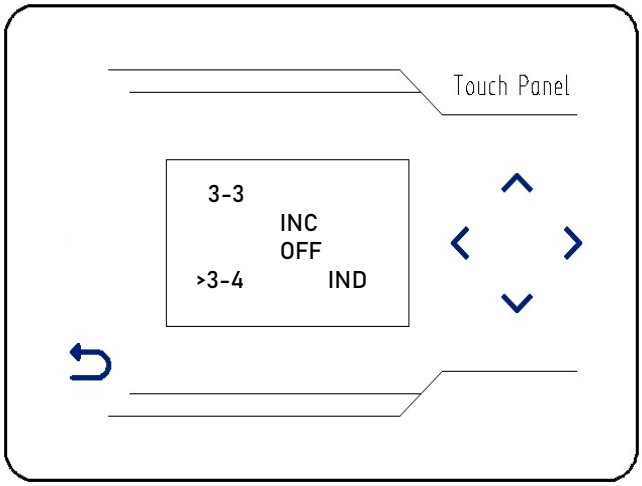



figure36

3-2 step approach switch (figure 35)

Step proximity switch (default ON) setting, ∧、∨through the key, add or 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, ∧、∨through the key, add and subtract, can open or close cloth detection electrical eye signal

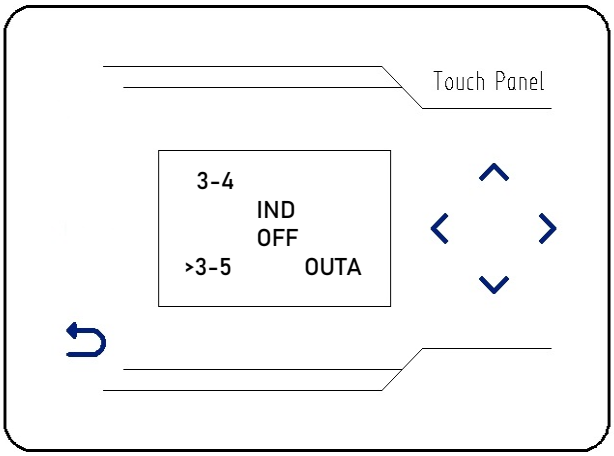



figure37

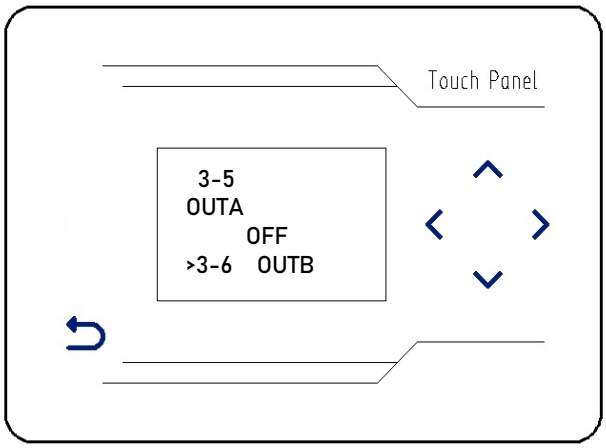



figure38

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 adding or subtracting keys.

3-5 pressure pin 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 or subtracting keys.

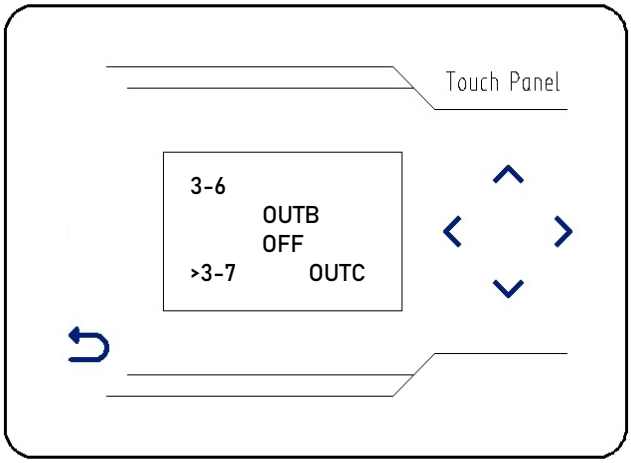



figure39

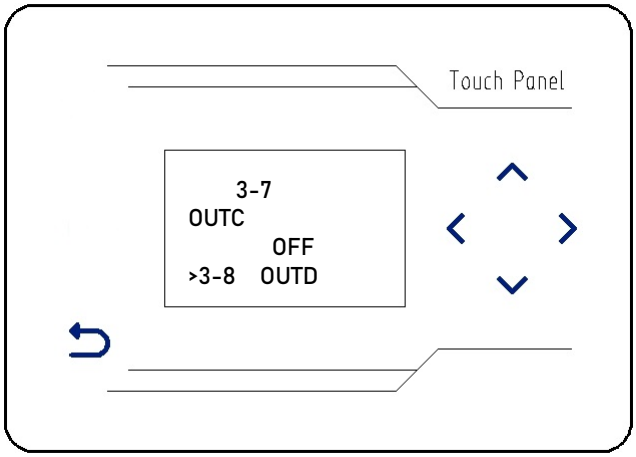



figure40

3-6 signal output of risk absorption control system (figure 39)

Risk absorption control signal output (default OFF) setting, ^ 、v can be turned on or OFF by adding or subtracting keys.

3-7 support control signal output (figure 40)

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

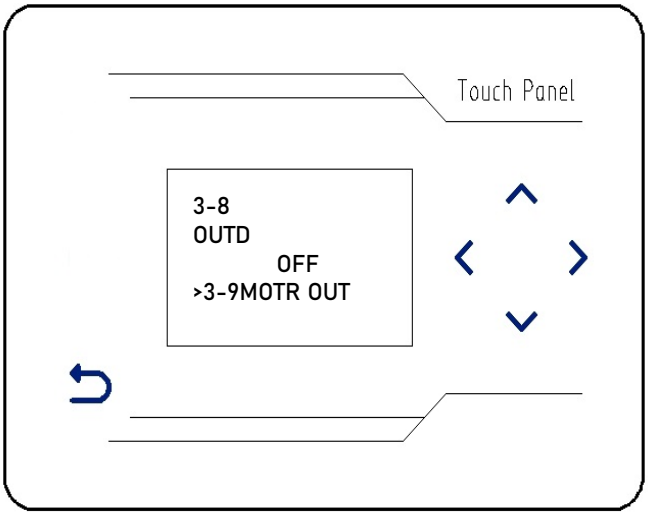



figure41

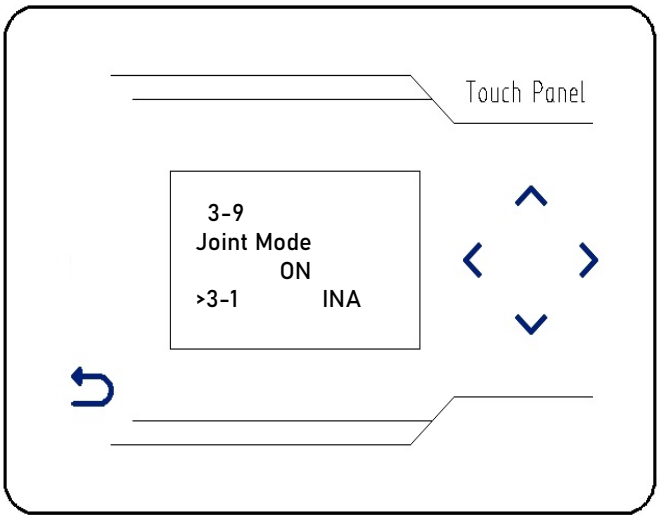



figure42

3-8 brake control signal output (figure 41)

The output of brake control signal (default OFF) is set. ^ 、 v The output of brake control signal can be turned on or OFF by adding or subtracting keys.

Step 3-9 Joint detection (figure 42)

Joint detection (default ON) setting, ^ 、 v through the key, add and subtract, Can turn on or off the bone position detection function

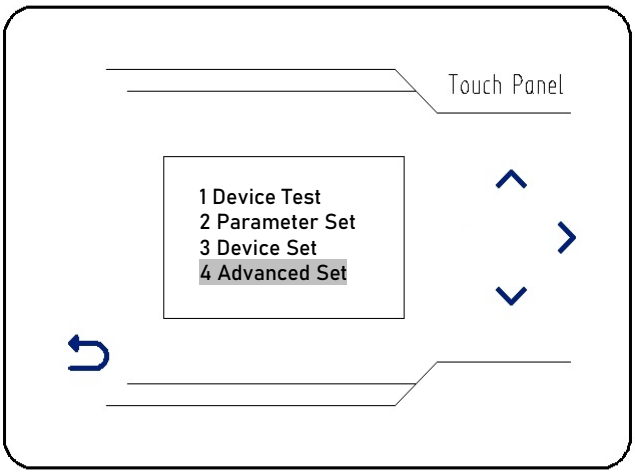



figure43

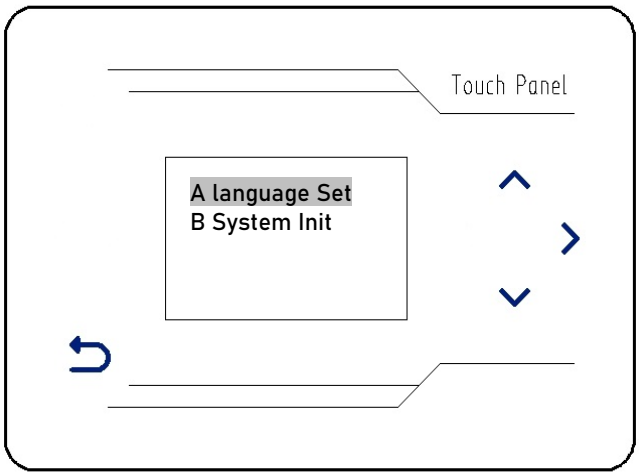



figure44

## （四）Advanced Settings

Press, ^ 、 v add or subtract, select "advanced Settings" (FIG. 43), press > the right button, and enter the sub-menu interface (FIG. 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"

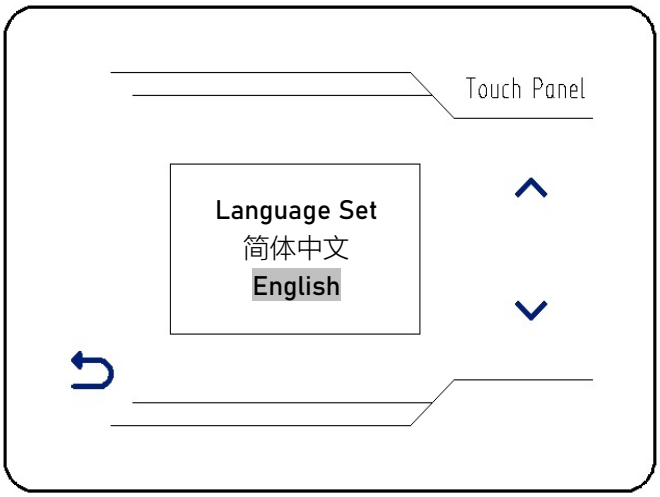



figure45

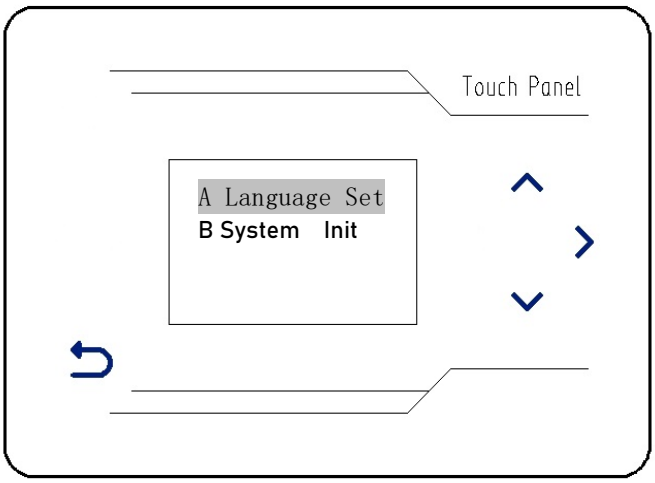


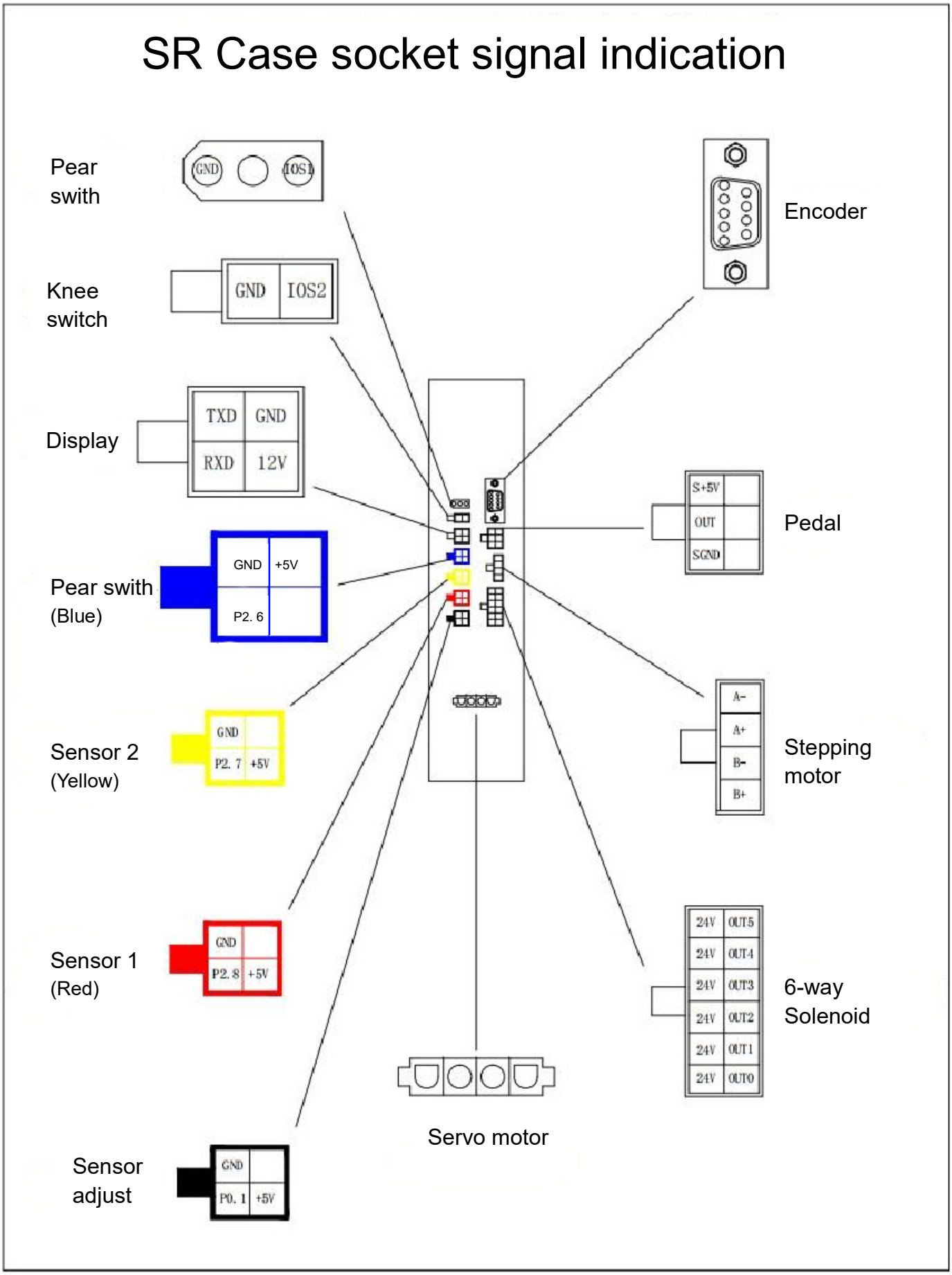

figure46

BInitialize the system (figure 46)

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

Chassis terminal diagram

# SR Case socket signal indication

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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.

GS-18V02.JAN.2022