User Guide

Industrial sewing machine
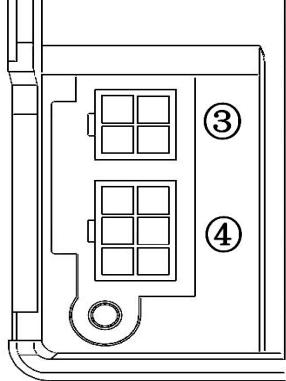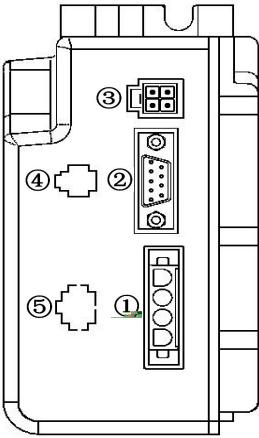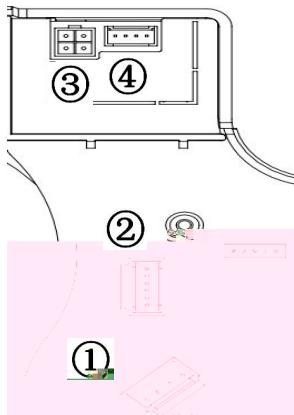
Thank you for purchasing our products.
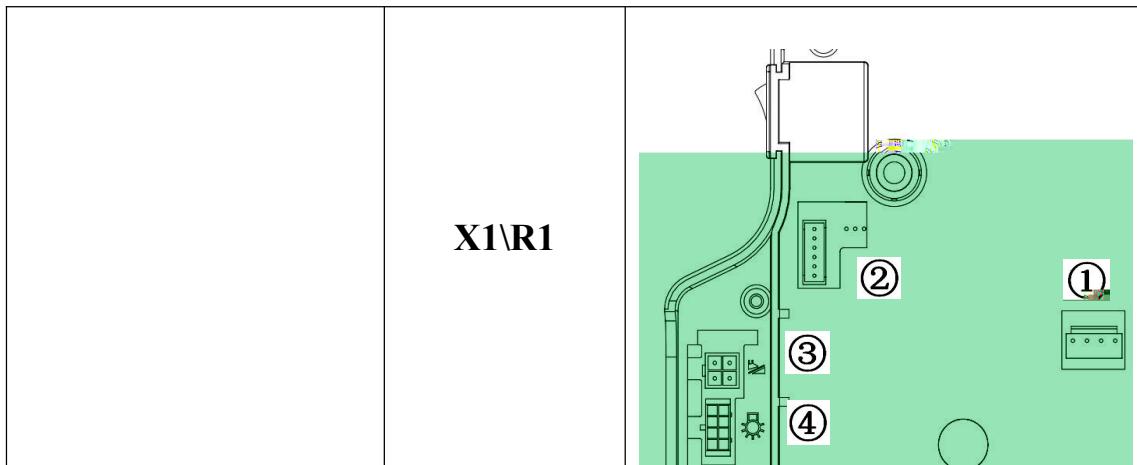
**For your use safety, please must read the instruction manual before use.**
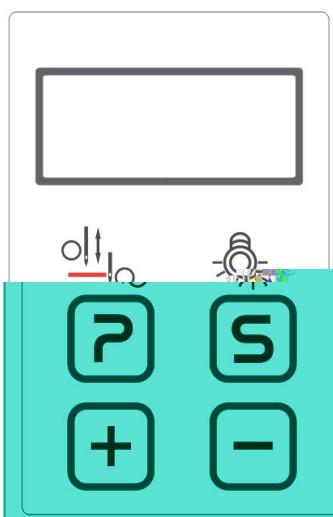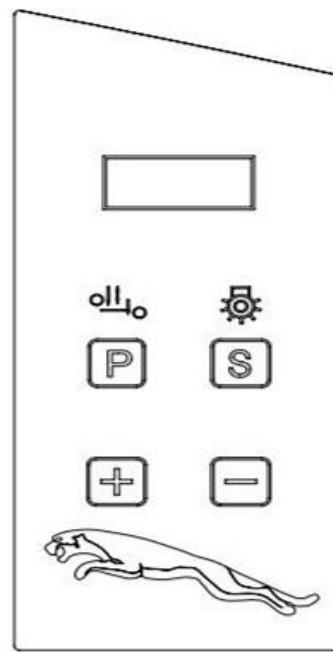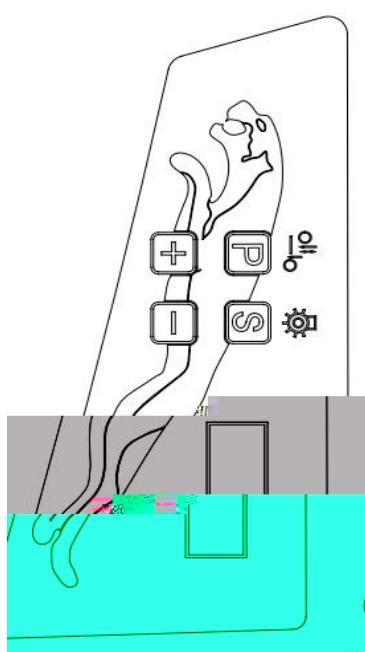
Up-down needle position	Yes（need device of needle position ）	Yes	Yes	Yes
Over current, overload	Yes	Yes	Yes	Yes

Port definition	M-7SE2\ Q1\S1 Built-in	
Port definition **Electric outlet** ② **Encoding outlet** ③ **Pedal switch Socket** ④ **LED light outlet** **Outlay needle position outlet** Please following port definition and outlet color to connection.	**M-7SE2** **Q1\S1** **Built-in**	
	M-6SD2	
	W1\V1** **P1\N1	

	X1\R1	

Operation panel description

1) 🄿 :Working mode,switch the up-down needle position;Parameter mode,setting the parameter.

2) 🅂 : Working mode,switch the LED light;Parameter mode,save the parameter.

3) ➕ 、 ➖ :Working mode,adjust the motor speed;Parameter mode,choice and adjust for parameter.

M-6SD2\M-7SE2\Q1\S1	X1\R1	W1\V1\P1\N1

Parameter adjusting and example

1. The panel is four digital Nixie tube display.

1.1 Adjust the speed by press the " [+] ", " [−] " ,key when in standby interface.

1.2 In standby interface ,press the " [P] " ,when the up needle position indicator light is on ,it is on up needle stop , when the down needle position indicator light is on , it is on down position stop , when the indicator light is off ,the needle position function turn off.

1.3 In standby interface ,press the " [S] " key , can turn on/off the machine head light.

1.4 Enter in and change the system parameter

① When the power is on ,press the " [P] " key for some seconds ,then press the " [+] "key , it enters into the parameter mode. The nixietube shows" **P-00**" ,

②Press the " [+] "、" [−] " key ,can change the parameter.

③After choose the parameter , press the" [P] "key ,enter into the parameter ,then can change the value of the parameter by " [+] "、" [−] " key,

④Press the " [S] " key save the value

1.5 The setting of motor rotate way:

① When the power is on ,press the " [P] " key for some seconds ,then press the " [+] "key , it enters into the parameter mode. The nixietube shows" **P-00**" ,

②Press the " [+] " key can change parameter to "**P-0 2**" ,

③Chosen parameter,press " [P] ",using " [+]

Error code and parameter

Error code

Error code.	Meaning	Possible problem
Er01	The error of needle position	The motor line is broken The wheel magnet fall off The connecting of needle signal line is not good Hanging computer is connected on wrong position （NO.⑤output）about the needle position detection
Er02	Can't test the motor signal	①pedal signal line connect not good or broken.
Er03	The hall or phase of motor is wrong.	①The connecting of 9 needle signal line is not good ②The motor hall is broken.
Er04	The protection of locked-rotor	The motor is overloading. The connecting of motor power line is not good.
Er05	The hardware is over-current.	The motor is overloading. The connecting of motor signal line is not good.
Er07	The serial communication num	

P-05	Accelerate the speed	2000~4000	3500	3500 rpm
P-06	Set the needle sewing	0~999	0	
P-07				Retention parameter
P-08				Retention parameter
P-09				Retention parameter
P-10	Automatic Mode switch	0~1	0	No.1 code it's Automatic mode, the function close when turn off power
P-11			0	Retention parameter
P-12			0	Retention parameter
P-13	Selection of motor	0~1	0	1: Old motor 0: normal motor
P-14	Maximum current	50~1000	280	
P-15	Needle position setting	0~1	1	1:means detecting needle position, 0 :means no detect