

BMAC-X INTELLIGENT HIGH-SPEED DOUBLE-SIDED WEAVING GLOVE MACHINE

BMAC-X-7G/10G/13G/15G/18G/21G

COMPUTER USER MANUAL (V1.0)



浙江百翔科技股份有限公司
ZHEJIANG BAIXIANG TECHNOLOGY CO., LTD

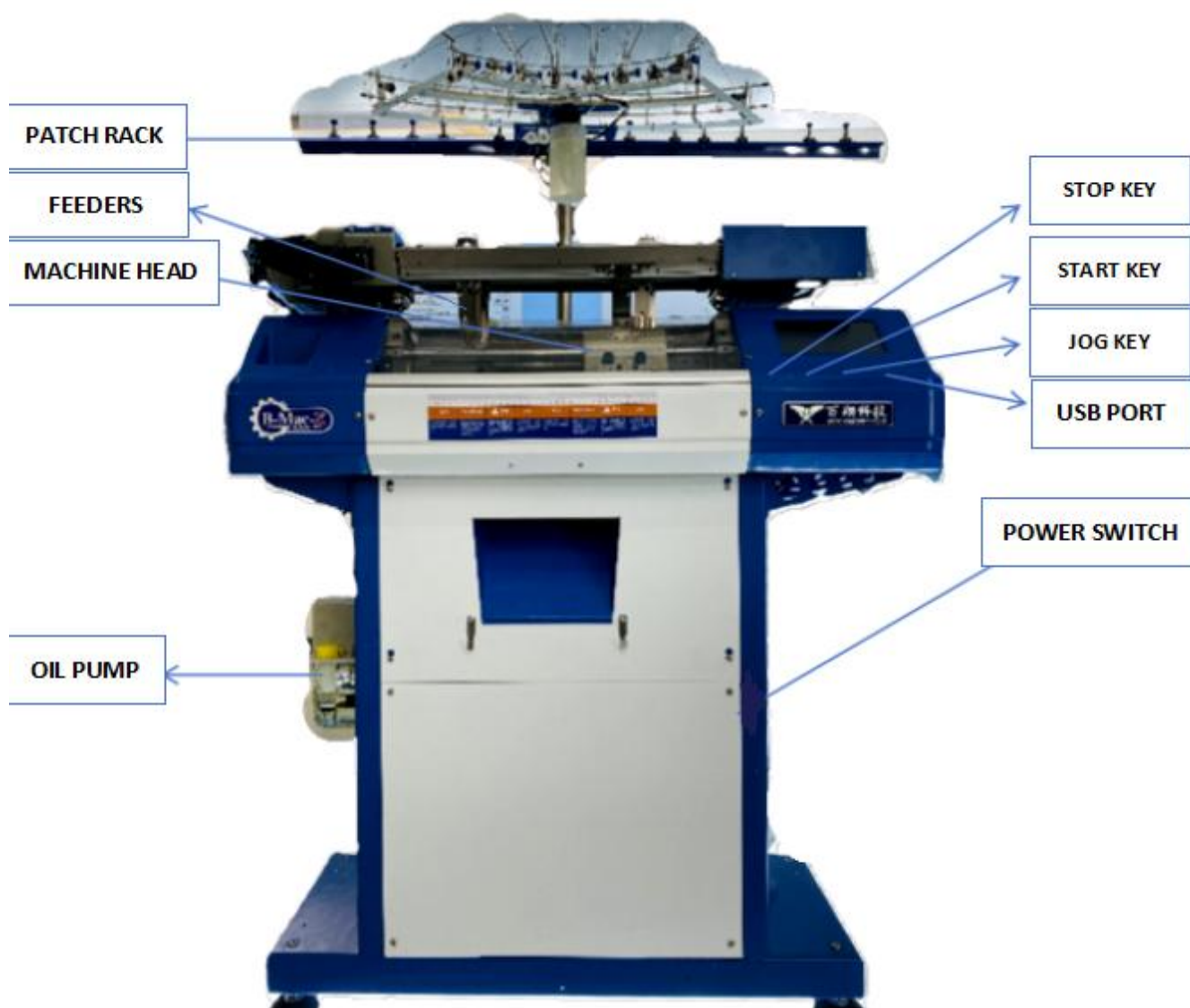
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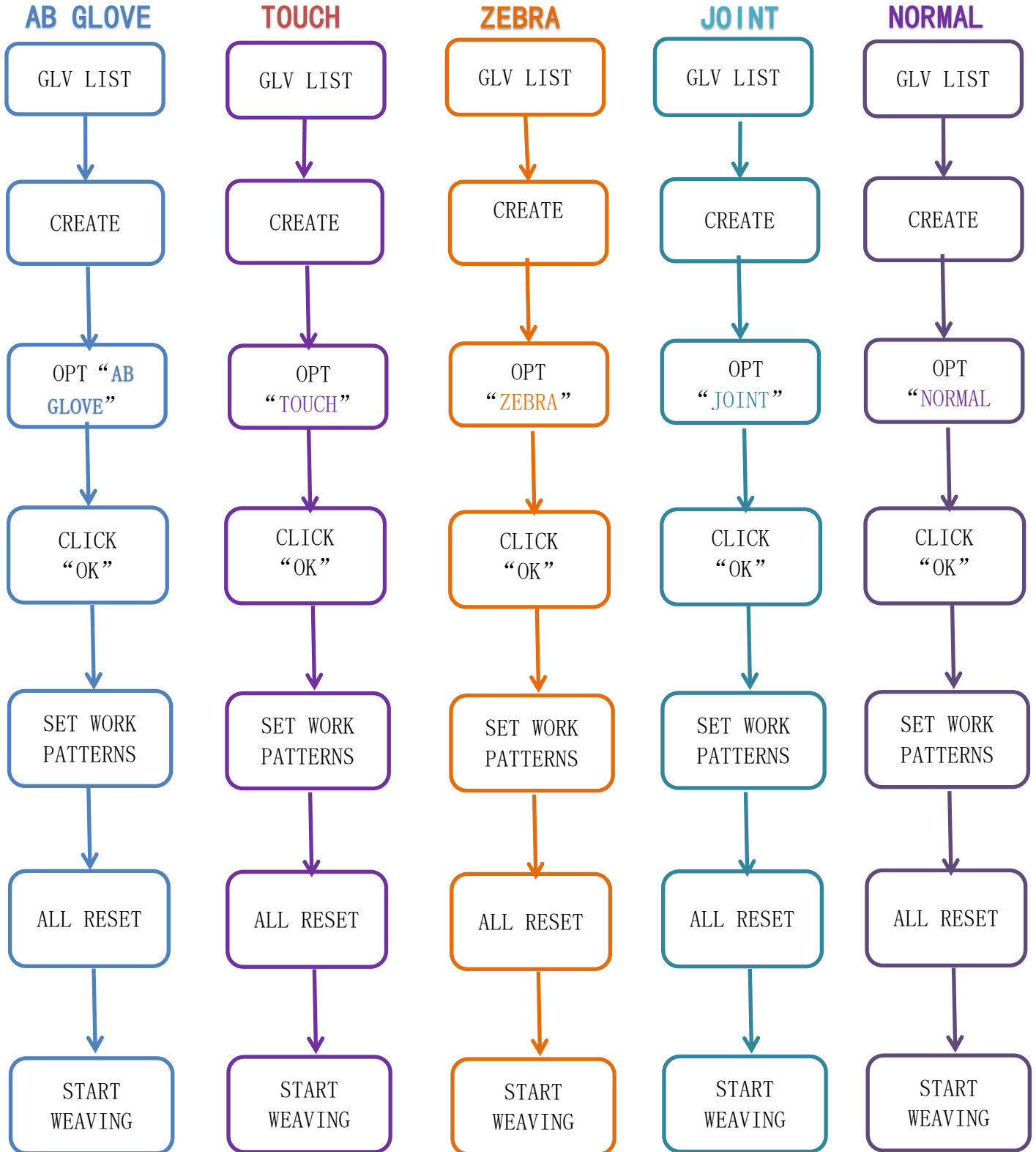
Instructions

Welcome to our company's product. The instructions for using this product are as follows: turn the power switch upwards to start the machine, wait for a moment, and a prompt window will pop up saying "Please manually reset to the far right, press the stop button to the left, and press the jog button to the right". Click OK to enter. Before using the machine, please set the desired pattern (see Pattern Management and Glove Parameters for details), then check if the yarn is properly connected and if there is any breakage. Finally, start the overall reset. After completing the reset, click the green button and the machine will start working. (Note: When setting the pattern, it is necessary to choose the same size as the aluminum drum, otherwise it may cause needle collision and damage to the machine)



QUICK USE SETTINGS

The following are the commonly used steps for glove weaving. Follow the steps to select the glove pattern that needs to be woven, After returning to the homepage, press the red button once and then the green button to reset the entire device. Once completed, press the green button to start weaving



1. MAIN INTERFACE



Figure 1

RESET: Control all controllable components of the machine to return to zero position (note: before performing the overall reset, please move the machine head and brush to the right, the yarn feeder to the left, and then click the start button to start the overall reset)

L-CUTTER: Control the main yarn scissors to cut yarn, and can be used after the overall reset

LAMP: Turn on or off the lighting on both sides of the glove machine cable rack and rack

LOCK: Click to switch between Shazui Motor Lock Shaft or Loose Shaft status

HI-LOW: Click to switch between high-speed or low-speed operation

1/MUL: Click to switch between weaving one glove or continuously weaving multiple gloves

R-CUTTER: Control the right scissors to cut yarn, and can be used after overall reset

UP/DOW: On the conveyor belt of the whole punching machine, the pressing glove rod is lifted for easy access and placement of gloves.

ACTION EX.: Click on the pull-out menu to control the reset of the whole machine, move the front and rear drum forward or backward by one pin, and reset the fork knife

GLV LIST: Create glove patterns and some functional settings (see Pattern Management "Page 8" for details)

PARAMETER: glove speed setting and glove function setting (see glove parameters on page 29)

FEEDER SET: Set yarn feeder number, debug position, allocate and other functions

TEST: Check whether the electrical part is faulty (see page 43 of the electrical testing for details)

SYSTEM MENU: Machine Upgrade, Important Parameter Management Settings Interface (see System Management "Page 50" for details)

LITTLE: The total number of turns in the current glove weaving area and the current number of turns

POSITION: machine travel and current position of the machine head

PRODUCTS: the theoretical output of gloves produced by the machine in 24 hours, and the time required to complete a single glove

COUNT: Display the preset number of woven gloves (click to set or clear the number of gloves)

SPEED: The current weaving glove location speed of the machine (click the +/- button to change the speed)

RUBBER: Control the width of the glove collar (click the +/- button to change its value)

STACKER QTY: Display the current number of gloves to be woven (click the +/- button to set the number of gloves). The middle part displays the current time, weaving position, weaving speed, glove machine model, and size

2. GLV LIST



Figure 2

CREATE: Generate a new pattern based on the current machine parameters, model size, etc

EDIT: Edit the selected glove type and some functions within the pattern

RENAME: You can rewrite the name of the currently selected pattern

SELECT 1: Select the first working pattern

SELECT 2: Select the second working pattern

SORT: Sort by Number Size

BACKUP: Backup the currently selected pattern

SINGLE: only weave working pattern 1

ALTERNATION: After weaving pattern 1, start using pattern 2 to weave, and cycle alternately to weave gloves in sequence

2.1 CREATING PATTERNS

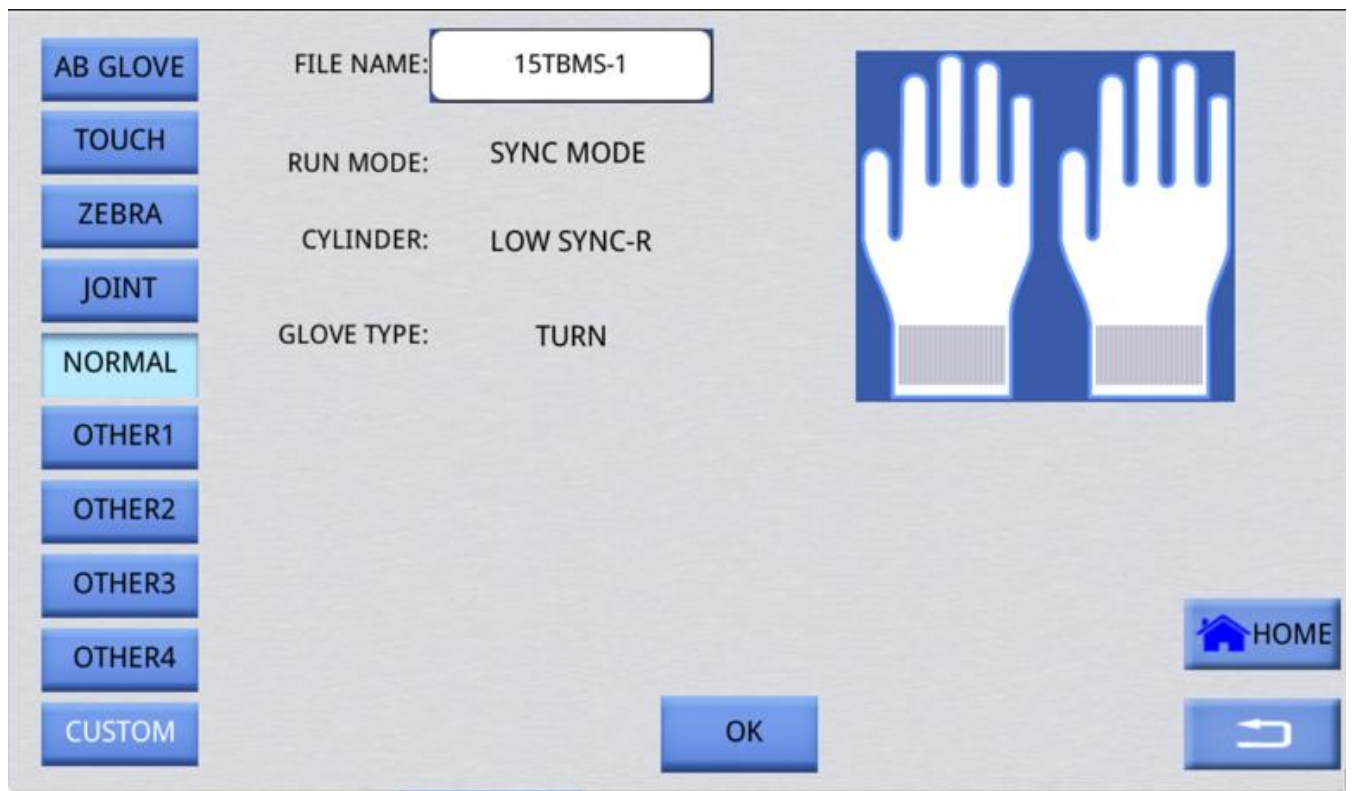


Figure 3

AB GLOVE: Refers to two different colors woven from the same glove (operating mode: asynchronous non swapping, drum type: low fork asynchronous backhand, glove type: ordinary backhand)

TOUCH: refers to the special gloves with touch screen function that can be woven separately by fingertips when weaving gloves (operating mode: asynchronous non swapping, drum type: low fork asynchronous backhand, glove type: ordinary backhand)

ZEBRA: refers to wearing zebra patterns when weaving gloves (operating mode: asynchronous exchange, drum type: low fork asynchronous backhand, glove type: ordinary backhand)

JOINT: refers to the ability to insert other colors of weaving into the knuckles when weaving gloves (operating mode: asynchronous non swapping, drum type: low fork asynchronous backhand, glove type: regular backhand)

NORMAL: Front and rear head synchronized weaving gloves (operating mode: synchronization mode, drum type: low fork synchronized backhand, glove type: ordinary backhand)

OTHER 1-4: Reserve default special glove weaving patterns (currently the system

defaults to the above 5 styles)

CUSTOM: refers to the ability to change the glove pattern that needs to be woven according to one's own needs (see Figure 4)

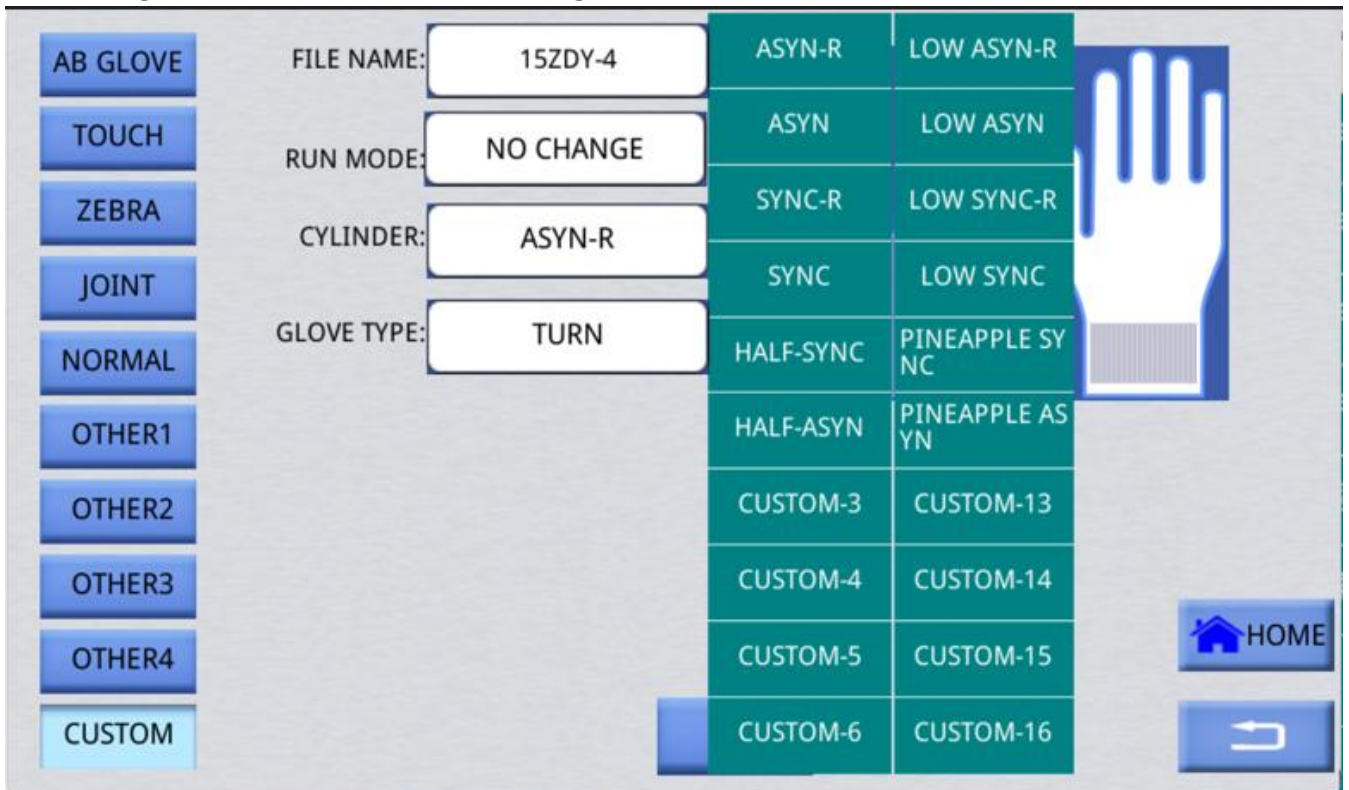


Figure 4

OK: After selecting, clicking this button will generate a new pattern and prompt whether to set this pattern as a working pattern (Image 5)



Figure 5

2.2 EDIT

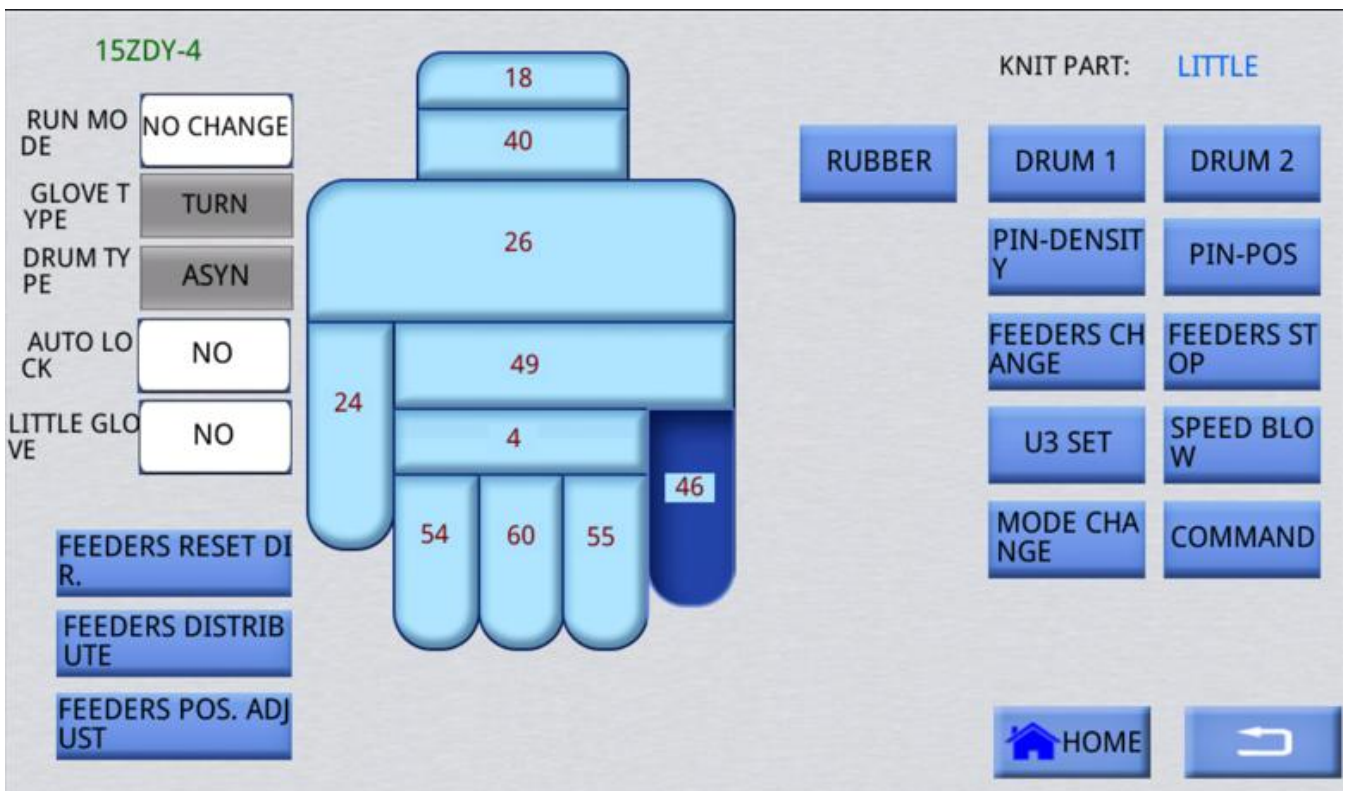


Figure 6

RUN MODE: According to the established pattern, there are options including asynchronous no exchange, asynchronous exchange, synchronous mode 1, and synchronous mode 2.

GLOVE TYPE: According to the established pattern, gray indicates that it cannot be changed

DRUM TYPE: According to the established pattern, gray indicates that it cannot be changed

AUTO LOCK: Choose whether to automatically lock the edges

LITTLE GLOVE: Choosing whether to weave small gloves allows for one click adjustment of the number of turns in the glove weaving area.

FEEDERS RESET DIR.: Reset the stop direction position of the yarn feeder (see page 39 of the yarn feeder management for details)

FEEDERS DISTRIBUTE: Allocate corresponding yarn feeders to the control section (see yarn feeder management on page 37 for details)

FEEDERS POS.ADJUST: Fine adjust the specific position of the yarn feeder when it is working or stopping (see page 40 of the yarn feeder management for details)

KNIT PART: Display the glove part with the corresponding name

2.2.1 RUBBER

RATIO	INSERT	CUTTER	BEGIN	END	SPEED	CUTTER OFF
0	0	0	0	0	0	0
0	0	0	0	0	0	0
0	0	0	0	0	0	0
0	0	0	0	0	0	0
0	0	0	0	0	0	0
0	0	0	0	0	0	0
0	0	0	0	0	0	0
0	0	0	0	0	0	0
0	0	0	0	0	0	0

PAGE UP PAGE DOWN 1/2 CLEAR ↶

Figure 7

RATIO: Refers to the interval of weaving rubber bands in a loop, for example, inputting "3" means that "3" forms a loop

INSERT: Refers to the number of rubber bands carried in a cyclic interval

CUTTER: Control the rubber band scissors to cut the line. "1" means cutting the rubber band line. "0" means not cutting the rubber band line. When the value is greater than "1", it means cutting the line in that row (filling in "10" means cutting the rubber band line in the 10th row)

BEGIN: It refers to the need to set the starting line number for this data segment

END: It refers to the need to set the number of ending rows for this data segment

SPEED: Used to modify the width of glove cuffs, the default value is "50" and can be set by oneself

CUTTER OFF: Control the number of loops in the rubber scissors, usually set to "1" for forehand and "12" for backhand by default

CLEAR: Clear all data filled in on all pages

2.2.2 DRUM 1:

Refers to the position of the drum movement and the number of jumping pins before and after weaving gloves to the corresponding position (the drum table is the default value and is not recommended to be changed)(Figure8)

FIRST PIN

N PIN

NO YARN PIN

B-DRUM		
ACT LINE OF L	ACT POS.	TARGET PIN
2	0	9
1	0	10
0	0	0
0	0	0
0	0	0

F-DRUM		
ACT LINE OF L	ACT POS.	TARGET PIN
2	0	9
1	0	10
0	0	0
0	0	0
0	0	0

PAGE DOWN 1/3 CLEAR ↩

Figure 8

2.2.3 DRUM 2:

Refers to the setting of the drum needle position at the corresponding position when weaving gloves (Figure 9)

TARGET PIN	LOOP	INSERT	BEGIN	END	ACT POS.	B/F DRUM	
0	0	0	0	0	0	0	B/F DRUM
0	0	0	0	0	0	0	0:B DRUM
0	0	0	0	0	0	0	1:F CYLINDE
0	0	0	0	0	0	0	2:B&F DRUM
0	0	0	0	0 .	0	0	ACT POS.:
0	0	0	0	0	0	0	0:LEFT JUMP
0	0	0	0	0	0	0	1:RIGHT JU
0	0	0	0	0	0	0	
0	0	0	0	0	0	0	
0	0	0	0	0	0	0	
0	0	0	0	0	0	0	

PAGE UP PAGE DOWN 1/2 CLEAR ↶

Figure 9

TARGET PIN: It refers to the actual number of rows corresponding to the drum pin

LOOP: How many rows constitute a cycle

INSERT: How many target numbers are inserted in a loop

BEGIN: It refers to the need to set the starting line number for this data segment

END: It refers to the need to set the number of ending rows for this data segment

ACT POS: '0' indicates that the machine head jumps from the left to the drum, '1' indicates that the machine head jumps from the right to the drum

B/F DRUM: '0' indicates the use of the rear drum, '1' indicates the use of the front drum, and '2' indicates the use of the front and rear drums

CLEAR: Clear all data filled in on all pages

2.2.4 PIN-DENSITY:

It refers to the density of sealing between fingers in woven gloves (Figure 10)

F-DENSI	F-RUBBER	BEGIN	END	ACT POS.	B-DENSI	B-RUBBER	BEGIN	END	ACT POS.
280	0	1	1	1	280	0	2	2	0
1	0	2	2	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0

PAGE UP PAGE DOWN 1/2 CLEAR ↶

Figure 10

F-DENSI: The height at which the front density top rod rises during sealing, with a density value of 1-70. The lower the value, the denser the glove

B-DENSI: The height at which the back density top rod rises during sealing, with a density value of 1-70. The lower the value, the denser the glove

F-RUBBER: Control the operating angle of the front top rod

B-RUBBER: Control the operating angle of the rear top rod

BEGIN: It refers to the need to set the starting line number for this data segment

END: It refers to the need to set the number of ending rows for this data segment

ACT POS.: '0' indicates that the machine head jumps from the left to the drum, '1' indicates that the machine head jumps from the right to the drum

COPY: Copy the set parameters to all fingers except for the little finger (if the density value required by the little finger is different from others, it needs to be set separately)

2.2.5 PIN-POS :

Set the action positions of the front and rear top rods for each weaving part (Figure 11)

FRONT PIN						BACK PIN					
TYPE	LOOP	INSERT	BEGIN	END	ACT POS	TYPE	LOOP	INSERT	BEGIN	END	ACT POS
0	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	0
0	0	0	0	0	0	0	0	0	0	0	0

1/2
TYPE:1-HALF NDL, 2-SEAL, 3-WOR
K

Figure 11

TYPE: Refers to the position of the front and rear top rods, the "1" half needle position, the "2" sealing position, and the "3" working position

LOOP: How many rows constitute a cycle

INSERT: How many target numbers are inserted in a loop

BEGIN: It refers to the need to set the starting line number for this data segment

END: It refers to the need to set the number of ending rows for this data segment

ACT POS: '0' indicates that the machine head jumps from the left to the drum, '1' indicates that the machine head jumps from the right to the drum

CLEAR: Clear all data filled in on all pages

2.2.6 FEEDERS CHANGE:

Replacing the yarn feeder during the process of setting up woven gloves (Figure 12)

YARN ID	REPLACE	BEGIN	END	LEFT/R	NO YAR	CUT-TWO	CUT-MEL	L-CUT	L-RELEA	R-CUT	R-RELEA
0	0	0	0	0	0	0.0	0.0	0.0	0	0.0	0
0	0	0	0	0	0	0.0	0.0	0.0	0	0.0	0
0	0	0	0	0	0	0.0	0.0	0.0	0	0.0	0
0	0	0	0	0	0	0.0	0.0	0.0	0	0.0	0
0	0	0	0	0	0	0.0	0.0	0.0	0	0.0	0
0	0	0	0	0	0	0.0	0.0	0.0	0	0.0	0
0	0	0	0	0	0	0.0	0.0	0.0	0	0.0	0
0	0	0	0	0	0	0.0	0.0	0.0	0	0.0	0
0	0	0	0	0	0	0.0	0.0	0.0	0	0.0	0
0	0	0	0	0	0	0.0	0.0	0.0	0	0.0	0

PAGE UP PAGE DOWN 1/2 L-CUT/L-RELEASE: A value of +2000 indicates the action of scissor 2 CLEAR ↩

Figure 12

YARN ID: Refers to the yarn mouth that needs to be replaced for weaving

REPLACE: Refers to the yarn feeder that needs to be replaced

BEGIN: It refers to the need to set the starting line number for this data segment

END: It refers to the need to set the number of ending rows for this data segment

LEFT/R: The movement position of the machine head is indicated by "0" on the left and "1" on the right

NO YAR: Wrap the end of the wire after cutting it around the pin (this function is currently not supported).

CUT-TWO: After setting the end line count, use the right scissors to cut the line (two-color scissors)

CUT-MELT: Cut the line with the left front scissors (hot melt scissors) after completing the set number of lines

L-CUT: Refers to using the front main yarn scissors to cut the thread after completing the set number of lines

L-RELEASE: After completing the set number of lines, the main yarn scissors

release the thread

R-CUT: Cut the line with the front right scissors after completing the set number of lines

R-RELEASE: After completing the set number of lines, use the right scissors to lay out the lines

CLEAR: Clear all data filled in on all pages

Explanation: The value "x.y" x filled in below the scissors indicates that the scissors are working on line x. y: This indicates that the scissors are cutting yarn from the y-size yarn feeder. As shown in Figure 11, "15.2" indicates that the left scissors cut the yarn from feeder 2 before line 15.

When opening the double layer scissors, the double layer scissors 2 function is required for the main yarn scissors and the main yarn unwinding. The main yarn scissors and the main yarn unwinding need to increase the "2000" value before they can be used (for example, the original unwinding position value was 10, and when using the double layer scissors 2, the value is 2010).

2.2.7 FEEDERS STOP:

Set the yarn stop function during the process of weaving gloves (Figure 13)

YARN ID.	LINE	ACT POS.	STOP/FOLLO	STOP POS.	HEAD	WAIT	
0	0	0	0	0	0	0	WAIT:
0	0	0	0	0	0	0	0:HEAD DON'T W
0	0	0	0	0	0	0	1:WAIT YARN STO P
0	0	0	0	0	0	0	ACT POS.:
0	0	0	0	0	0	0	0:LEFT
0	0	0	0	0	0	0	1:RIGHT
0	0	0	0	0	0	0	STOP/FOLLOW:
0	0	0	0	0	0	0	0:STOP YARN
0	0	0	0	0	0	0	1:FOLLOW BACK
0	0	0	0	0	0	0	2:FOLLOW FRONT
0	0	0	0	0	0	0	

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Figure 13

YARN ID: Refers to the yarn mouth that needs to be replaced for weaving

LINE: At which line does the yarn stop following

ACT POS: '0' indicates that the machine head jumps from the left to the drum, '1' indicates that the machine head jumps from the right to the drum

STOP/FOLLO: '0' indicates stopping the yarn feeder, '1' indicates that the yarn feeder follows the machine head behind, and '2' indicates that the yarn feeder follows the front machine head

STOP POS: The location where the feeder is parked during operation

HEAD: According to the number of rows filled in, execute the yarn feeder stop following command based on the position of the front and rear machine heads moving left or right. Fill in "0,1" for the rear machine head and "2" for the front machine head

WAIT: Fill in "0" to indicate that the machine head is not waiting for the yarn feeder to stop and continue working, and "1" to indicate that the machine head is waiting for the yarn feeder to stop before working

2.2.8 U3 SET:

LOOP	INSERT	BEGIN	END	BACK/FORNT	
0	0	0	0	0	BACK/FORNT:
0	0	0	0	0	0:STOP ALL U2
0	0	0	0	0	1:STOP BACK U2
0	0	0	0	0	2:STOP FRONT U2
0	0	0	0	0	
0	0	0	0	0	
0	0	0	0	0	
0	0	0	0	0	
0	0	0	0	0	
0	0	0	0	0	

PAGE UP PAGE DOWN 1/2 COPY CLEAR ↩

Figure 14

LOOP: How many rows constitute a cycle

INSERT: How many target numbers are inserted in a loop

BEGIN: It refers to the need to set the starting line number for this data segment

END: It refers to the need to set the number of ending rows for this data segment

BACK/FORNT: '0' refers to the machine head before and after the U2 feeder stops, '1' refers to the machine head after the U2 feeder stops, and '2' refers to the machine head before the U2 feeder stops

COPY: Copy the set parameters to other fingers

CLEAR: Clear all data filled in on all pages

2.2.9 SPEED-BLOW:

Set the specified number of turns for weaving speed and assist in weaving gloves with air blowing function (Figure 15)

SPEED	BEGIN	END
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0

BLOW	BEGIN	END
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0
0	0	0

PAGE UP PAGE DOWN 1/2 CLEAR ↩

Figure 15

SPEED: Refers to the weaving speed within the set number of turns

BEGIN: It refers to the need to set the starting line number for this data segment

END: It refers to the need to set the number of ending rows for this data segment

BLOW: Blowing setting, "0" indicates no blowing, "1" indicates full circle blowing, "2" indicates blowing when the head is on the left, "3" indicates blowing when the head is on the right

BEGIN: It refers to the need to set the starting line number for this data segment

END: It refers to the need to set the number of ending rows for this data segment

CLEAR: Clear all data filled in on all pages

2.2.10 MODE CHANGE:

RUN MODE	LOOP	INSERT	BEGIN	END	ACT POS.	USE YARN I	
0	0	0	0	0	0	0	USE YARN I
0	0	0	0	0	0	0	0:USE BACK YARN
0	0	0	0	0	0	0	1:USE FRONT YARN
0	0	0	0	0	0	0	RUN MODE:
0	0	0	0	0	0	0	1:ASYNC NOT CHANGE
0	0	0	0	0	0	0	2:ASYNC CHANGE YARN
0	0	0	0	0	0	0	3:SYNC MODE
0	0	0	0	0	0	0	
0	0	0	0	0	0	0	
0	0	0	0	0	0	0	

PAGE UP PAGE DOWN 1/2 COPY CLEAR ↻

Figure 16

RUN MODE: 1. Asynchronous does not exchange yarn feeder, 2. Asynchronous requires yarn feeder exchange, 3. Synchronous mode

LOOP: How many rows constitute a cycle

INSERT: How many target numbers are inserted in a loop

BEGIN: It refers to the need to set the starting line number for this data segment

END: It refers to the need to set the number of ending rows for this data segment

ACT POS: '0' indicates that the machine head jumps from the left to the drum, '1' indicates that the machine head jumps from the right to the drum

USE YARN ID: The "0" synchronization mode drives the rear machine head yarn feeder, while the "1" synchronization mode drives the front machine head yarn feeder

COPY: Copy the set parameters to other fingers

CLEAR: Clear all data filled in on all pages

2.2.11 COMMAND:

	COMMAND	LINE	ACT POS	ACT POS	B/F HEAD	PARA. 1	PARA. 2
1	NONE	0	0	<<LEFT	B-HEADER	无	0
2	NONE	0	0	<<LEFT	B-HEADER	无	0
3	NONE	0	0	<<LEFT	B-HEADER	无	0
4	NONE	0	0	<<LEFT	B-HEADER	无	0
5	NONE	0	0	<<LEFT	B-HEADER	无	0
6	NONE	0	0	<<LEFT	B-HEADER	无	0
7	NONE	0	0	<<LEFT	B-HEADER	无	0
8	NONE	0	0	<<LEFT	B-HEADER	无	0
9	NONE	0	0	<<LEFT	B-HEADER	无	0

PAGE UP PAGE DOWN 1/8 COPY CLEAR ↻

Figure 17

	COMMAND	LINE	ACT POS	ACT POS	B/F HEAD	PARA. 1	PARA. 2
1	NONE	7#FEEDER	S-PINEAPPLE	AD	DER	无	0
2	NONE	MODE	8#FEEDER	A-PINEAPPLE	DER	无	0
3	NONE	B-HEAD	CUTTER		DER	无	0
4	NONE	F-HEAD	HEEL	LEFT	B-HEADER	无	0
5	NONE	1#FEEDER	B-DRUM	LEFT	B-HEADER	无	0
6	NONE	2#FEEDER	F-DRUM	LEFT	B-HEADER	无	0
7	NONE	3#FEEDER	LOOP	LEFT	B-HEADER	无	0
8	NONE	4#FEEDER	B-PIN	LEFT	B-HEADER	无	0
9	NONE	5#FEEDER	F-PIN	LEFT	B-HEADER	无	0
		6#FEEDER	HEAD POS				

PAGE UP PAGE DOWN CLEAR ↻

Figure 18

COMMAND: Select the instructions that need to be set up for execution (see Figure 18 for details)

LINE: The starting point for executing instructions in knitted gloves

ACT POS: Refers to the position point where the machine head executes instructions, "0" refers to the machine head on the right, and "1000" refers to the machine head on the left

ACT POS: Refers to the direction of machine head operation, left/right

B/F HEAD: The instructions set are executed according to the front/rear machine head

PARA.1: Change according to instruction type

PARA.2: Change according to instruction type

COPY: Copy the set parameters to other fingers

CLEAR: Clear all data filled in on all pages

Example: The instruction type is mode switching. Parameter 1: The instruction is divided into (asynchronous exchange, asynchronous non exchange, synchronous mode). Parameter 2 can only be used when parameter 1 is in synchronous mode. Filling in "0" indicates that the machine head starts from the left, and "1" indicates that the machine head starts from the right.

Example: The instruction type is yarn feeder. Parameter 1 instruction is divided into (not working, following the front machine head, following the rear machine head). When parameter 1 is not working, the value filled in parameter 2 has no effect. Only when parameter 1 is set to follow the front and rear machine heads and parameter 2 is set to the yarn feeder parking position can it be used

2.2.12 FEEDERS RESET DIR:

The direction of the yarn feeder parking position after the overall reset is completed (Figure 19)



Figure 19

1-8#FEEDERS RESET DIR.: During the overall reset process, you can choose to stop in both left and right directions separately

2.2.13 FEEDERS DISTRIBUTE:

Refers to assigning different numbers of yarn feeders according to the weaving yarn (Figure 20) (see page 37 of yarn feeder management for yarn feeder numbers)



Figure 20

2.2.14 FEEDERS POS.ADJUST:

The yarn feeder has the functions of shifting the front/rear machine head, yarn changing parking, weaving parking, thread cutting parking, and resetting the parking position adjustment during the process of weaving gloves. (Figure 21) (See recommended yarn feeder position on page 40 for details)

	OFFSET F-HEAD		OFFSET B-HEAD		OFFSET KNIT		OFFSET CHANGE		OFFSET CUT		OFFSET RESET
	<<LEFT	RIGHT>>	<<LEFT	RIGHT>>	<<LEFT	RIGHT>>	<<LEFT	RIGHT>>	<<LEFT	RIGHT>>	
1#FEEDERS	11.1	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	70.0
2#FEEDERS	22.0	8.0	8.0	8.0	10.0	10.0	25.0	25.0	19.0	19.0	68.0
3#FEEDERS	33.0	8.0	8.0	7.0	8.0	8.0	25.0	48.0	15.0	15.0	60.0
4#FEEDERS	44.0	6.0	6.0	6.0	14.0	14.0	33.0	36.0	22.0	22.0	83.0
5#FEEDERS	55.0	8.0	6.0	6.0	22.0	22.0	13.0	39.0	12.0	12.0	73.0
6#FEEDERS	66.0	8.0	8.0	1.0	12.0	12.0	18.0	22.0	20.0	20.0	83.0
7#FEEDERS	77.0	-46.0	-46.0	-46.0	6.0	6.0	0.0	0.0	0.0	0.0	88.0
8#FEEDERS	88.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	77.7






Figure 21

3.PARAMETER

3.1 SPEED:

Set the weaving speed for each part of the woven glove(Figure22)



Figure 22

FINGER SPEED: The minimum speed for weaving fingers is "20" and the maximum is "300". The recommended speed is "220", and the speed can be adjusted within this range.

PALM SPEED: The speed for weaving three finger palms, four finger palms, and five finger palms ranges from a minimum of "20" to a maximum of "300". The recommended speed is "220", and the speed can be adjusted within this range.

RUBBER SPEED:The minimum speed for weaving rubber bands is "20" and the maximum is "300". The recommended speed is "180", and the speed can be adjusted within this range.

X-YARN SPEED:The minimum speed for weaving hot melt is "20" and the maximum is "300". The recommended speed is "160", and the speed can be adjusted within the range.

EMPTY LINE SPEED:The minimum and maximum speeds of the machine head during idle operation are "20" and "300", respectively. The recommended speed is "160", and the speed can be adjusted within this range.

STITCH CHANGE SPEED:The minimum speed for changing needles during weaving is "20" and the maximum is "300". The recommended speed is "180", and the speed can be adjusted within this range.

CLOSE SPEED:The minimum speed for weaving and sealing is "20" and the maximum is "300". The recommended speed is "120", and the speed can be adjusted within the range.

COLOR CHANGE SPEED:The minimum weaving color change speed is "20" and the maximum is "300". The recommended speed is "120", and the speed can be adjusted within the range.

KNIFE PRESS SPEED:The minimum and maximum speeds of the weaving press knife are "20" and "300", and the recommended speed is "100". The speed can be adjusted within this range.

RUBBER BEGIN SPEED:The starting speed of the rubber band is a minimum of "20" and a maximum of "300". The recommended speed is "100", and the speed can be adjusted within this range.

PALM FIRST LINE SPEED : High speed=corresponding palm speed, medium speed=needle changing speed, low speed=sealing speed

3.2 FUNCTION:

Selection and setting of some functions in woven gloves(Figure23)



Figure 23

DROP CHECK: After the "enable" function is turned on, the glove weaving is completed and detected by the falling sensor. If the falling sensor does not detect the glove, an alarm will be triggered. If the glove is blocked and not falling, an alarm will also be triggered 30 seconds later. 'Disabled' refers to the glove falling sensor not being activated and not sounding an alarm.

AUTO SCREEN OFF: Set the time to automatically turn off the display screen (default 0-100 minutes), with "0" indicating constant brightness

SPEED ADJUST ENABLE: When enabled, the weaving speed and high/low speed options can be adjusted on the main interface. When disabled, the speed cannot be adjusted.

X-YARN SELECT: Select the corresponding hot melt yarn feeder "front left hot melt" and "rear right hot melt" when weaving the hot melt area

TAKEOFF SEQUENCE: Refers to setting the order of glove detachment after weaving, which can be divided into "synchronous front detachment first", "synchronous back detachment first", and "asynchronous simultaneous detachment" according to requirements

SEAL SEQUENCE OF MAIN-CUTTER: The cutting and sealing sequence of the main scissors is divided into "SEAL->CUT" and "CUT->SEAL"

SEAL SEQUENCE OF R-CUTTER: The order of cutting and sealing with the right scissors is divided into "SEAL->CUT" and "CUT->SEAL"

DROP BLOW: Enable or disable the air blowing function when the glove falls down after weaving is completed

3 PALM SEAL: Control the "point pin" to "enable" or "disable" this function when sealing the 3-finger palm

4 PALM SEAL: Control the "point pin" to "enable" or "disable" this function when sealing the 4-finger palm

5 PALM SEAL: Control the "point pin" to "enable" or "disable" this function when sealing the 5-finger palm

RING HALF NEEDLE: Control the "enable" or "disable" of the second half needle of the ring finger

MIDDLE HALF NEEDLE: Control the "enable" or "disable" of the second half needle of the middle finger

X-YARN CUT POS: After the hot melt part is woven, the cutting position of the scissors is divided into "left cutting" and "right cutting"

3.3 PARA.SET:

Parameter settings for some functions in woven gloves(Figure24)

DROP CYCLES [0,50]:5	8	R-CUTTER MOVE(mm) [0,300]:10	5	SPEED
L-CUTTER RELEASE CYCLES [0,100]:3	8	END CUTTER MOVE(mm) [0,300]:10	5	FUNCTION
L-CUTTER PULL CYCLES [0,300]:1	1	RUBBER CUTTER BEGIN POS. [0,300]:0	0	PARA.SET
L-CUTTER CUT CYCLES [0,300]:1	1	RUBBER CUTTER END POS. [0,300]:0	0	
FINGER CUTTER MOVE(mm) [0,300]:10	5	X-YARN PRESS POS. [0,300]:260	260	
F. X-YARN HALF STOP CYCLES [0,300]:0	0	CUT CYCLE [1,7]:2	2	DEFAULT
F. X-YARN HALF STOP POS. [0,300]:0	0	RUBBER INTERVAL	2 BY 1	
R-CUTTER RELEASE CYCLES [0,100]:3	8	SPECIAL PART MILL	DISABLE	


RESET


L-CUTTER


LAMP


LOCK


HI-LOW


1/MUL


R-CUTTER


UP/DOW


ACTION E


HOME

Figure 24

DROP CYCLES: The number of empty runs of the glove after weaving.

L-CUTTER RELEASE CYCLES: The number of turns the fingers have completed weaving when the scissors are opened and a portion of the yarn is released.

L-CUTTER PULL CYCLES: The number of hot melt turns made when the main scissors hook the line.

L-CUTTER CUT CYCLES: The number of turns made by the hot melt when the main scissors cut the thread.

FINGER CUTTER MOVE(mm): The distance that the scissors move when cutting the thread.

F. X-YARN HALF STOP CYCLES, F. X-YARN HALF STOP POS.: These two parameters are used when doing finger dual color, in order to prevent direct cutting when the finger dual color ends, the "number of turns" refers to the number of

turns to delay cutting the line, and the "position" refers to the position from the left row of the machine head to half stop

R-CUTTER RELEASE CYCLES: After cutting the thread with the scissors on the right, how many circles should be waited for before releasing the thread

R-CUTTER MOVE(mm): The distance that the right scissors move after cutting the line.

END CUTTER MOVE(mm): The distance that the right scissor rod moves when cutting thread with the right scissor.

RUBBER CUTTER BEGIN POS.: The position of the machine head when the rubber band scissors start working

RUBBER CUTTER END POS.: The position of the machine head at the end of the rubber band scissors' work

X-YARN PRESS POS.: The position of the machine head when encrypting the top rod before the last round of hot melt

CUT CYCLE: After the sealing is completed, the number of turns for the scissors to lay the thread

RUBBER INTERVAL: The arrangement ratio of rubber high and low pins is divided into "2 BY 1" and "1 BY 1"

SPECIAL PART MILL: Refers to disabling or enabling the high pin detachment of gloves

4.FEEDERS SET

Control the functional parameter settings of the yarn feeder area

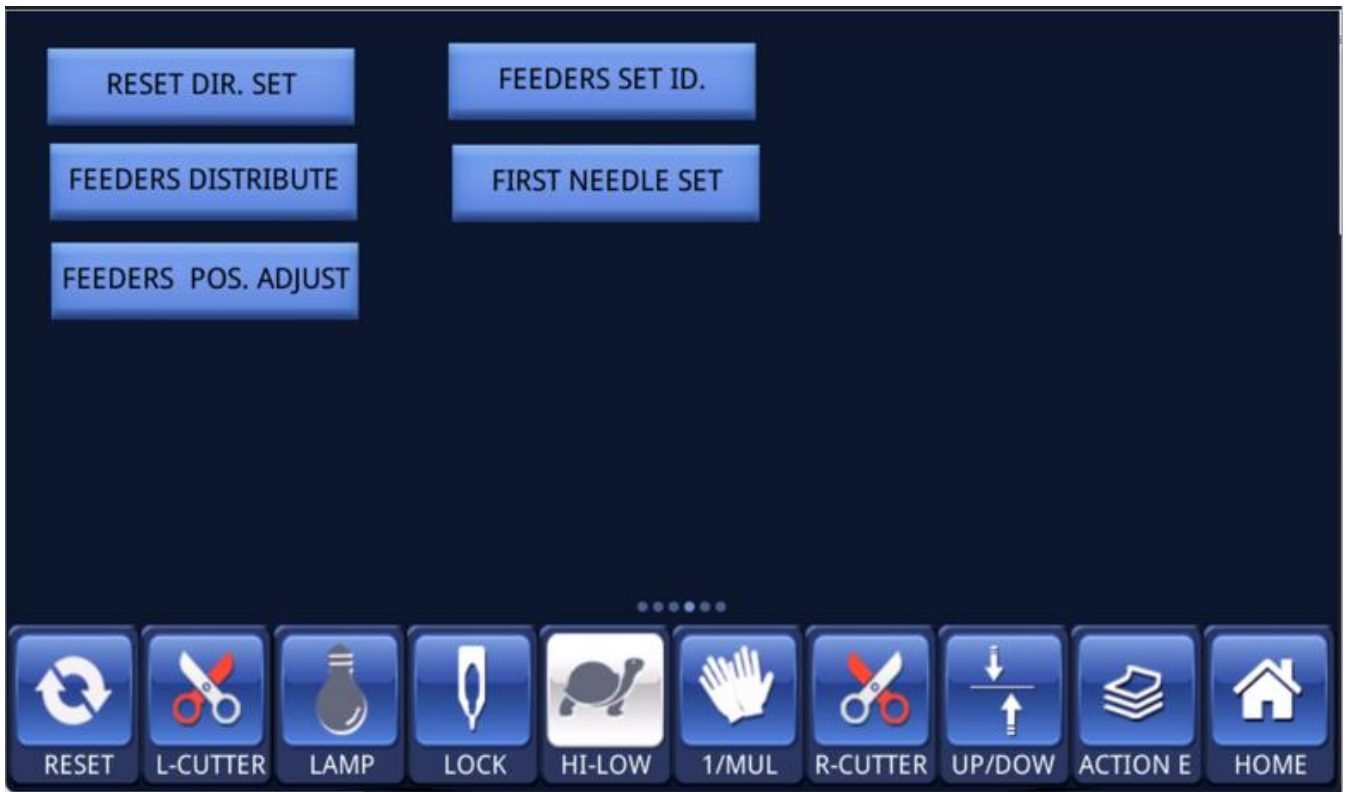


Figure 25

FEEDERS SET ID: Finger feeders are numbered in sequence (see 4.1 for details)

FEEDERS DISTRIBUTE: Distribution of yarn feeders according to weaving positions (see 4.2 for details)

RESET DIR.SET: The direction and position where the yarn feeder stops after resetting (see 4.3 for details)

FEEDERS POS.ADJUST: Fine tune the weaving and parking position of the yarn feeder during the weaving process (see 4.4 for details)

FIRST NEEDLE SET: Set the first needle position of the yarn feeder according to the number (see 4.5 for details)

4.1 FEEDERS SET ID:

Number the yarn feeder motors used in order. (Replacing the yarn feeder motor requires renumbering) (Figure 26)

The four yarn feeder motors on the top left of the machine are numbered 1, 2, 3, and 4 from right to left. The four yarn feeder motors on the back of the machine are numbered 5, 6, 7, and 8 from right to left. The rear rubber band is numbered 9, and the front rubber band is numbered 10.

- 1、click **START** The indicator light for the yarn feeder motor on the machine will flash rapidly individually.
- 2、Check the number of the yarn feeder motor flashing rapidly, and then click according to the corresponding yarn feeder number **SET**, Corresponding motor It will become 'OK'.
- 3、Repeat the second step of the above steps in sequence until the setting of 10 yarn feeder motor numbers is completed.



Figure 26

START: After clicking on the start numbering button, the yarn feeder motor indicator light will flash rapidly and individually, indicating the numbering process.

END: End the instruction after the yarn feeder motor number is completed.

SET: Refers to completing the number setting

4.2 FEEDERS DISTRIBUTE

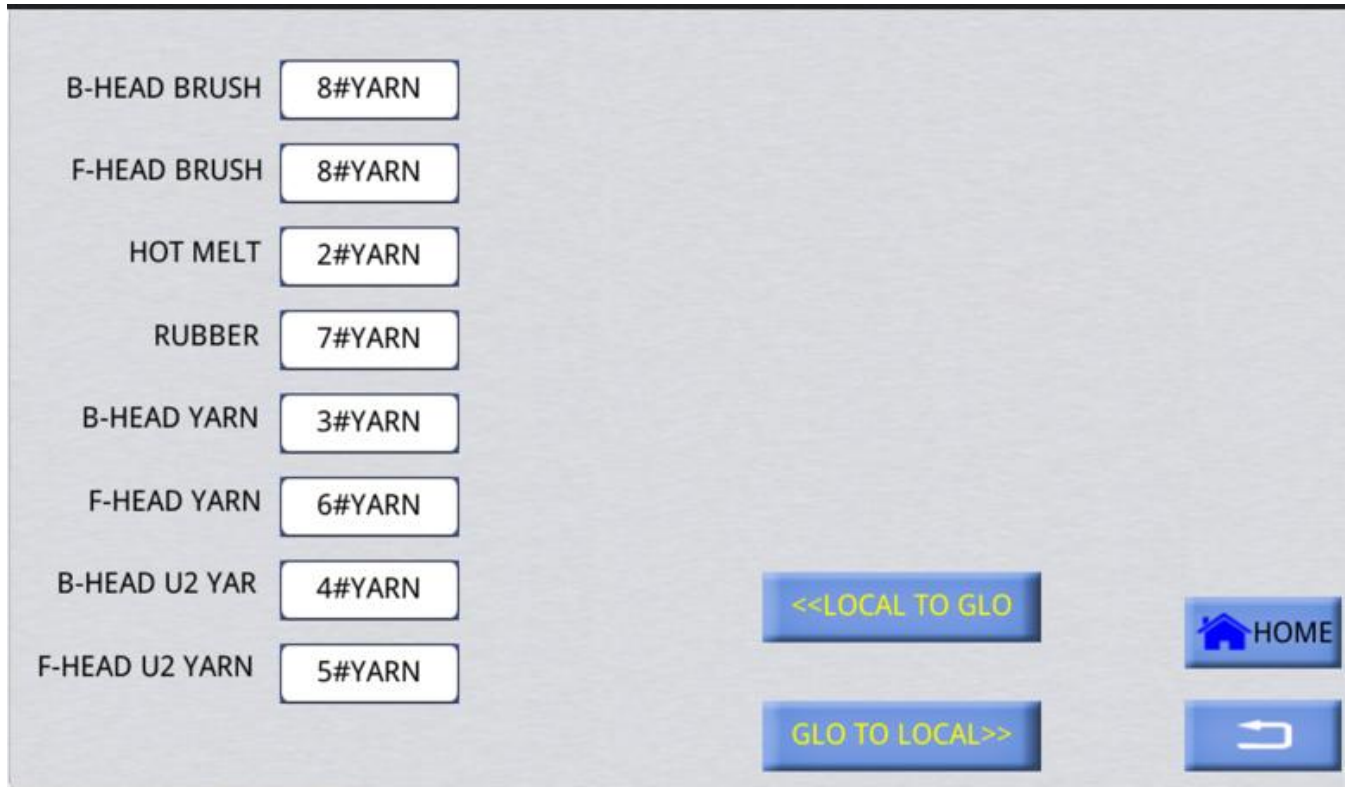


Figure 27

B-HEAD BRUSH: Depending on the actual situation, which feeder motor can be used to drive or turn off (usually using feeder motor 1 by default)

F-HEAD BRUSH: Depending on the actual situation, which feeder motor can be used to drive or turn off (usually using feeder motor number 8 by default)

HOT MELT: Depending on the actual situation, which feeder motor can be used to drive or turn off (usually using feeder motor 2 by default)

RUBBER: Depending on the actual situation, which feeder motor can be used to drive or turn off (usually using feeder motor number 7 by default)

B-HEAD YARN: Depending on the actual situation, which feeder motor can be used to drive or turn off (usually using feeder motor number 3 by default)

F-HEAD YARN: Depending on the actual situation, which feeder motor can be used to drive or turn off (usually using feeder motor number 6 by default)

B-HEAD U2 YARN: Depending on the actual situation, which feeder motor can be used to drive or turn off (usually using feeder motor number 4 by default)

F-HEAD U2 YARN: Depending on the actual situation, which feeder motor can be used to drive or turn off (usually using feeder motor number 5 by default)

<<LOCAL TO GLO: Copy the modified parameters from the machine parameters to the pattern parameters (the modified yarn feeder parameters in the pattern are not synchronized with the local yarn feeder parameters, and can be copied to each other if one party makes the wrong changes)

GLO TO LOCAL>>: Copy the modified parameters from the pattern parameters to the machine parameters (if the modified yarn feeder parameters in the pattern are not synchronized with the local yarn feeder parameters, and one party makes an error in the modification, they can be copied to each other)

4.3 RESET DIR.SET



Figure 28

The reset direction of the 1-8 feeder motor can be divided into "left reset" and "right reset" according to the actual situation (by default, the 1-8 feeder is reset with the brush feeder and random head on the right)

<<LOCAL TO GLO: Copy the modified parameters from the machine parameters to the pattern parameters (the modified yarn feeder parameters in the pattern are not synchronized with the local yarn feeder parameters, and can be copied to each other if one party makes the wrong changes)

GLO TO LOCAL>>: Copy the modified parameters from the pattern parameters to the machine parameters (if the modified yarn feeder parameters in the pattern are not synchronized with the local yarn feeder parameters, and one party makes an error in the modification, they can be copied to each other)

4.4 FEEDERS POS.ADJUST

	OFFSET F-HEAD		OFFSET B-HEAD		OFFSET KNIT		OFFSET CHANGE		OFFSET CUT		OFFSET RESET
	<<LEFT	RIGHT>>	<<LEFT	RIGHT>>	<<LEFT	RIGHT>>	<<LEFT	RIGHT>>	<<LEFT	RIGHT>>	
1#FEEDERS	11.1	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	70.0
2#FEEDERS	22.0	8.0	8.0	8.0	10.0	10.0	25.0	25.0	19.0	19.0	68.0
3#FEEDERS	33.0	8.0	8.0	7.0	8.0	8.0	25.0	48.0	15.0	15.0	60.0
4#FEEDERS	44.0	6.0	6.0	6.0	14.0	14.0	33.0	36.0	22.0	22.0	83.0
5#FEEDERS	55.0	8.0	6.0	6.0	22.0	22.0	13.0	39.0	12.0	12.0	73.0
6#FEEDERS	66.0	8.0	8.0	1.0	12.0	12.0	18.0	22.0	20.0	20.0	83.0
7#FEEDERS	77.0	-46.0	-46.0	-46.0	6.0	6.0	0.0	0.0	0.0	0.0	88.0
8#FEEDERS	88.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	77.7

<<LOCAL TO GLV GLV TO LOCAL>> HOME ↩

Figure 29

OFFSET F-HEAD: Adjusting the yarn feeder to offset the center position of the front machine head

OFFSET B-HEAD: Adjust the center position of the machine head after adjusting the yarn feeder offset

OFFSET KNIT: Adjust the position of the yarn feeder parking point to the left or right according to the AB position during weaving

OFFSET CHANGE: After changing the yarn, adjust the yarn feeder parking position to the left or right according to the AB position

OFFSET CUT: After cutting the thread, adjust the yarn feeder parking position to the left or right according to the AB position

OFFSET RESET: After weaving is completed, the yarn feeder is parked at a position away from the collision points on both sides after resetting

<<LOCAL TO GLO: Copy the modified parameters from the machine parameters to the pattern parameters (the modified yarn feeder parameters in the pattern are not synchronized with the local yarn feeder parameters, and can be copied to each other if one party makes the wrong changes)

GLO TO LOCAL>>: Copy the modified parameters from the pattern parameters to the machine parameters (if the modified yarn feeder parameters in the pattern are not synchronized with the local yarn feeder parameters, and one party makes an error in the modification, they can be copied to each other)

4.5 FIRST NEEDLE SET

Before loading, please ensure that the front machine head has been reset once and strictly follow the sequence: 1. Pull down the sand feeder to the far right and hold it, then click "right positioning", 2. Pull the yarn feeder to the far left and hold it, then click "left positioning", 3. Pull the yarn feeder to the first needle position, then click "load first needle". Complete all the first needle settings for the yarn feeder according to the above actions.

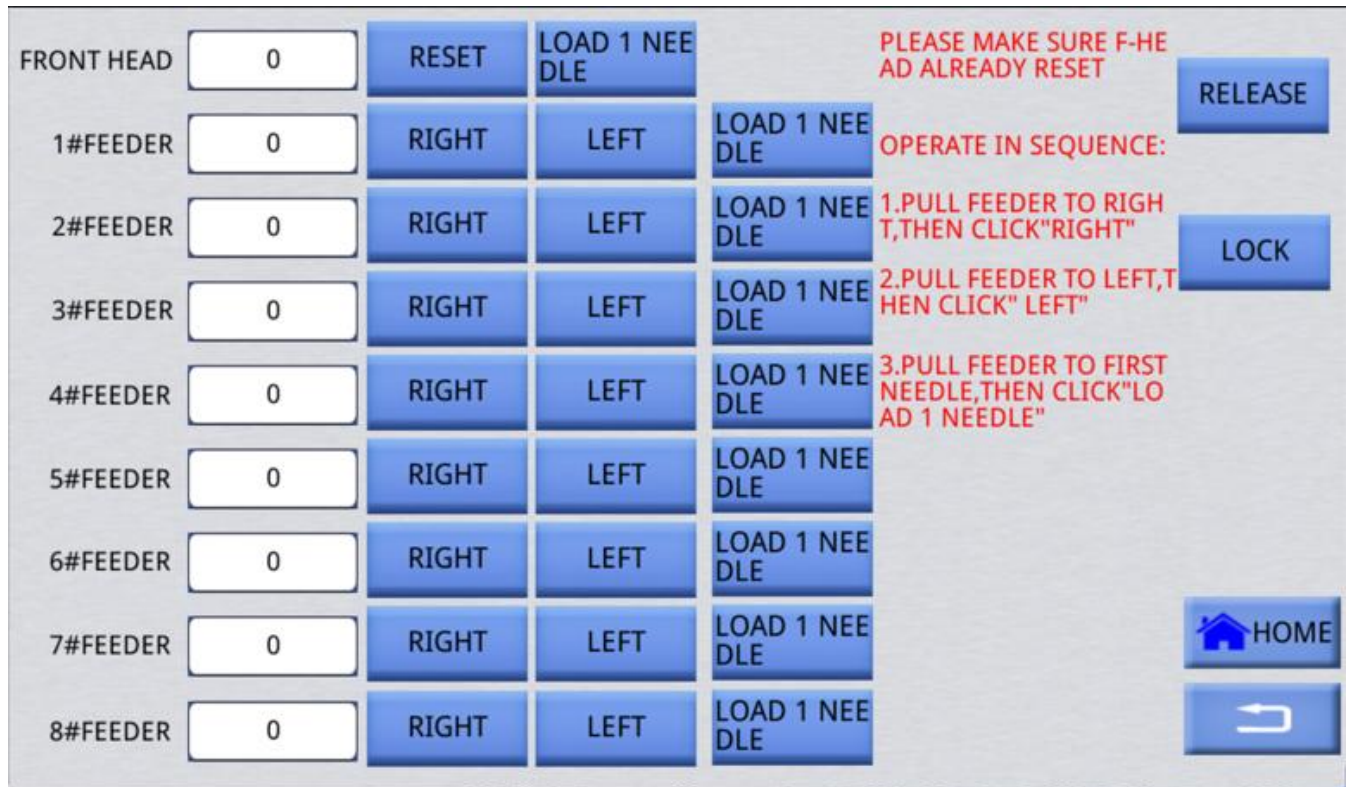


Figure 30

RESET: Restore the initial position set by the front machine head

RIGHT: Move the yarn feeder to the rightmost position on the machine

LEFT: Move the yarn feeder to the leftmost position on the machine

LOAD 1 NEEDLE: The position of the first needle when installing the loading machine head needle

RELEASE: Release all yarn feeder motors from the locked state

LOCK: Lock all yarn feeder motors tightly

5.TEST

This interface is an electrical testing interface used to detect whether there is a fault in the electrical part

5.1 MOTO TEST

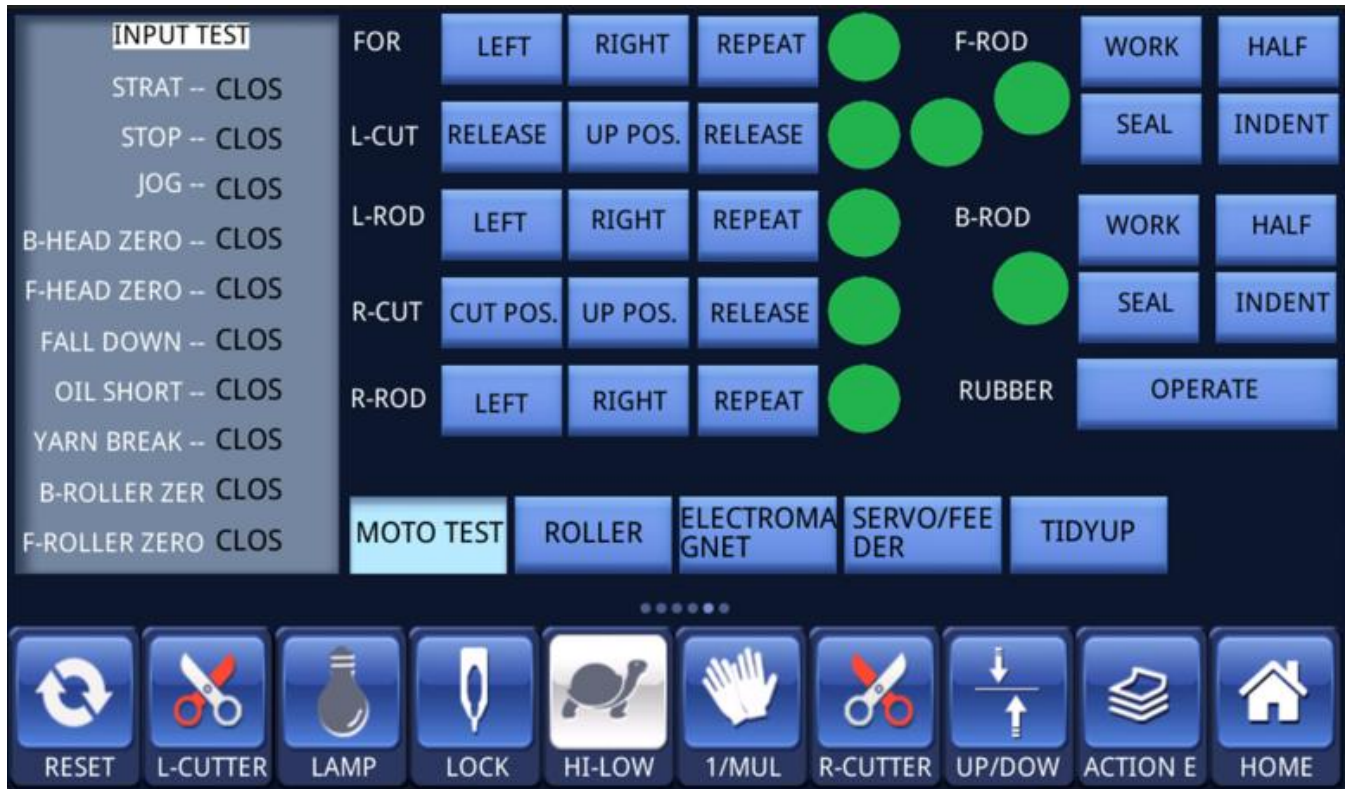


Figure 31

INPUT TEST: Check whether the input signal of the machine is normal, divided into "closed" and "open" states.

Output control: Check whether the motor is running and oriented normally, and whether the motor zero position is normal

5.2 DRUM/RUBBER TEST



Figure 32

F/B DRUM: Current location; Refers to the number of sales that the drum is currently jumping on; Zero position angle refers to the angle of the current set origin position of the drum, Check whether the current drum motor is running normally and whether the zero position is normal. (drum zero position adjustment: The zero position values of the front and rear drum of this machine are changed to 1, and then the drum is reset. After stopping, release the shaft and manually adjust the drum to rotate to the fourth pin with the pins on both sides flat. Check the number displayed in the parentheses at the current position. If the value is greater than 80 (display value -80) and less than 80 (display value +360-80), obtain the value and fill it into the corresponding front and rear drum zero position items of this machine's parameters.)

FRONT/REAR RUBBER BANDS: Check whether the front and rear rubber motors are running normally and whether the zero position is normal.

5.3 ELECTROMAGNET TEST

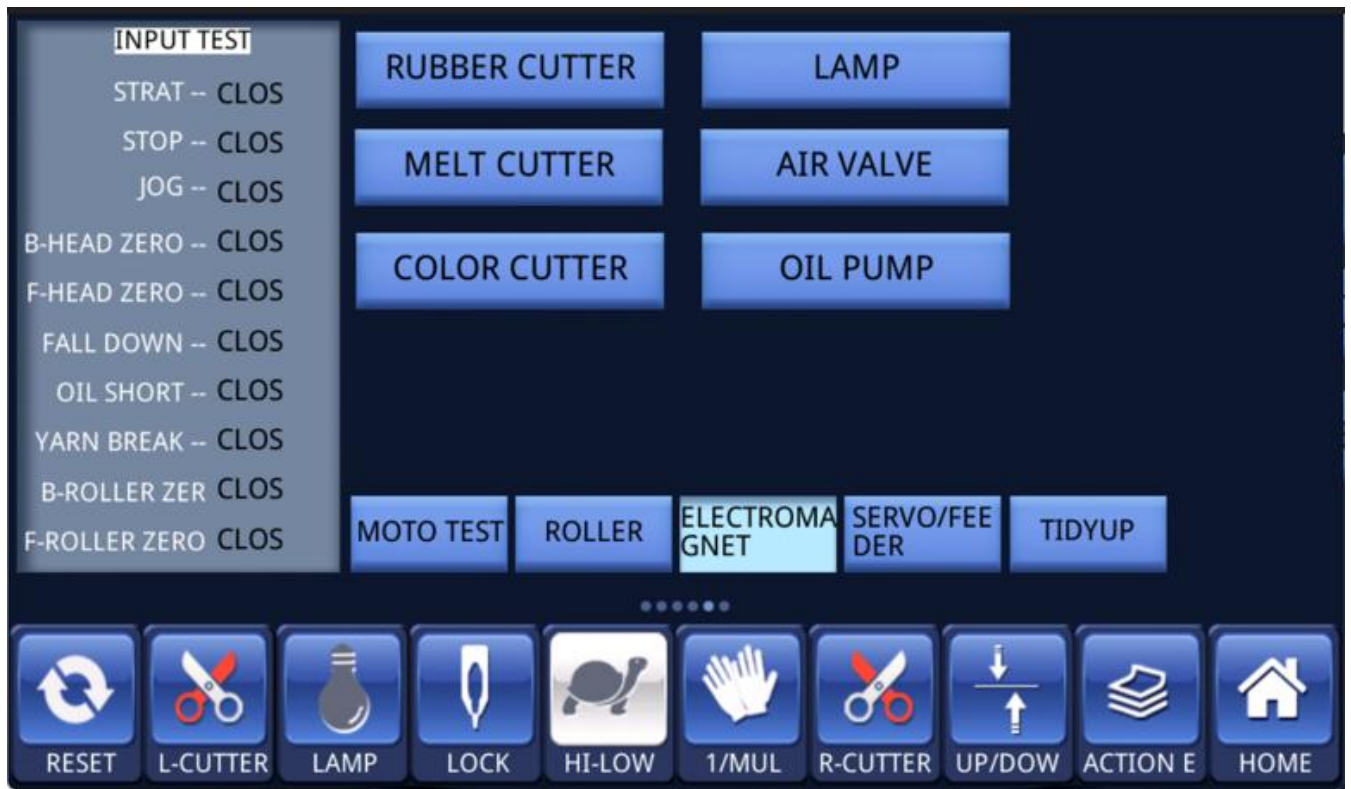


Figure 33

RUBBER CUTTER: Test whether the rubber band scissors are working properly

MELT CUTTER: Test whether the hot melt scissors are working properly

COLOR CUTTER: Test whether the two-color scissors are working properly

LAMP: Test whether the lighting is working properly

AIR VALVE: Test whether the air valve is normal

OIL PUMP: Test whether the oil pump is normal

5.4 SERVO/FEEDERS TEST



Figure 34

B-HEAD: Test the loose shaft, locked shaft, left row, and right row status of the machine head behind

F-HEAD: Test the front machine head for loose shaft, locked shaft, left row, and right row status

1#-8#YARN: Test the loose shaft, locked shaft, left row, and right row states of the yarn feeder

5.5 TIDY UP TEST



Figure 35

COUNT: The number of gloves woven will be sorted according to the highest setting value after setting

ALL RESET: Restore all motors of the sorting machine to their initial settings and return to zero

POS.1: Test the position where the clamp board rises for the first time, opens and waits

POS.2: Open the second lift of the opening clamp and wait for the position to be opened

POS.3: The position where the opening clamp rises for the third time to clamp the gloves

TAKE OFF: Test the automatic removal of gloves that have been woven currently

UP/DOWN: Detecting the up and down movement of the lifting motor, the "maximum position" refers to the value set when the lifting motor is turned to the maximum position, used to test the position at which the entire set of gloves is lifted

TURN: Test the forward and reverse rotation of the rotating motor. "Initial position" refers to the maximum angle position on the conveyor belt when the rotating motor rotates to clamp the glove after clicking.

OPEN: Test the function of the opening motor, and determine the position of the opening motor at positions 1, 2, and 3 corresponding to the waiting positions 1, 2, and 3

PRESS: Test the up and down functions of the compression motor

COVER: Test the rotation function of the conveyor motor

PARA SET.: Specific parameter settings for the sorting machine (see page 65 for details on the machine parameters)

5.6 REVERSE FUNCTION TEST



Figure 36

COUNT: The number of gloves woven will be sorted according to the highest setting value after setting

ALL RESET: Restore all motors of the sorting machine to their initial settings and return to zero

POS.1: Test the position where the clamp board rises for the first time, opens and waits

POS.2: Open the second lift of the opening clamp and wait for the position to be opened

POS.3: The position where the opening clamp rises for the third time to clamp the gloves

TAKE OFF: Test the automatic removal of gloves that have been woven currently

TAKE POS1: Calibrate the position of removing gloves

PUT POS1: Calibrate the placement of gloves

UP/DOWN POS1: Calibrate the position of the upper and lower molds

PUT MANUAL: Manually place gloves and flip them over

UP/DOWN: Detecting the up and down movement of the lifting motor, the "maximum position" refers to the value set when the lifting motor is turned to the maximum position, used to test the position at which the entire set of gloves is lifted

TURN: Test the forward and reverse rotation of the rotating motor. "Initial position" refers to the maximum angle position on the conveyor belt when the rotating motor rotates to clamp the glove after clicking.

OPEN: Test the function of the opening motor, and determine the position of the opening motor at positions 1, 2, and 3 corresponding to the waiting positions 1, 2, and 3

PRESS: Test the up and down functions of the compression motor

MOTOS: Test the forward and reverse rotation function of the casing motor

DOOR MOTOR: Test the forward and reverse rotation function of the door panel motor

FORK MOTOR: Test the forward and reverse rotation function of the fork rake motor

HOOK MOTOR: Test the forward and reverse rotation function of the hook and pull motor

TRAY MOTOR: Test the forward and reverse rotation function of the tray motor

TRANSLATION MOTOR: Test the forward and reverse rotation function of the translation motor

PARA SET.: Specific parameter settings for the sorting machine

6 SYSTEM MENU:



Figure 37

UPGRADE: Refers to checking the system program software version date and using USB flash drive to upgrade program functions

语言/LANGUAGE: Click on Chinese/English/Russian to switch languages

ERROR RECORD: Refer to viewing system error log information

SERVO PARA.ADJUST: View servo, drum, and yarn feeder function parameters and modify and debug functions

INSTALLMENT: Decrypt and load installment payment files based on customer situation

DISK MANAGMENT: Import and export pattern files, machine parameters, system parameters, whole machine parameters, and delete functions using a USB drive

SYSTEM PARA.: View and modify various speed functions of the main motor and stepper motor

MACHINE PARA.: View and modify machine woven glove size, AB position, drum parameters, and other settings (see machine parameters on page 61 for details)

TIME SET: Modify system time

ASSEMBER: For assembly personnel and inspection personnel to fill in their own numbers and view information of other assembly personnel, after the factory parameter inspector fills in the numbers inside, the machine automatically saves the current factory parameters. This parameter can be used to restore factory settings

LOAD DEFAULT: Restore to the initial configuration parameters at the factory (e.g. changed parameters but forgot to change location, this function can be used when the machine encounters an error)

PASSWORD SET: View and modify the password required to access the system

TIDY UP PARA.: Enter the settings page of the whole machine (see "page 65" of the whole machine parameters for details)

LOCAL SET: Enter the basic settings of the machine (see page 69 for details on local settings)

PRODUT RECORD: Statistics on the weaving glove information of this machine (see page 71 of the statistics management for details)

6.1 UPGRADE



Figure 38

MAIN VERSION: Display the current upgraded version and date of the main control program. "V2401021248" refers to January 2, 2024 at 12:48 pm

TIDY UP VERSION: Display the current upgraded program version of the whole printer

SERVO VERSION: Display the current upgraded program version of the servo motor (displayed as "0" because the version needs to be connected to the servo)

DRUM VERSION: Display the current upgraded program version of the stepper motor (displayed as "0" because the version needs to be connected to the stepper motor)

LCD VERSION: Display the upgraded program version and date of the current display screen. "V231227" refers to December 27, 2023

1#YARN-8#YARN: Display the current upgraded program version of the yarn feeder (displayed as "0" because the version number can only be displayed after connecting the yarn feeder motor)

USB: When connected to the USB drive, the program that needs to be upgraded will be displayed, with the suffix ". xp1" as the main control program, ". prb" as the stepper

motor program, ". pra" as the servo motor program, and ". prc" as the yarn feeder upgrade program.

6.2 语言/LANGUAGE

After clicking this function, you can choose to switch the system to multiple languages such as Chinese/English/Russian (Figure 39)



Figure 39

6.3 ERROR RECORD

View and delete system error log information, including error time, error description, statistics, and summary (Figure40)

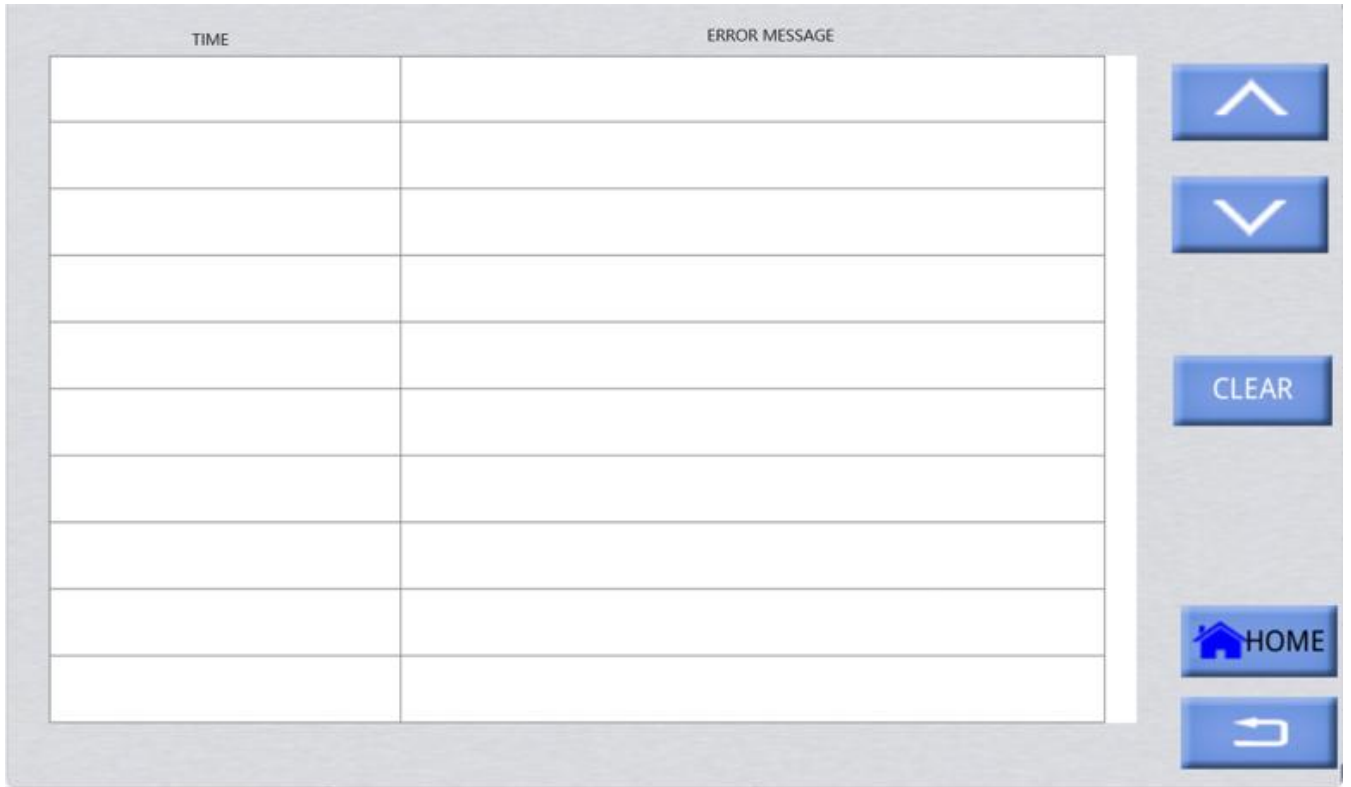


Figure 40

6.4 SERVO PARA.ADJUST

View servo, drum, and yarn feeder function parameters and modify and debug functions(Figure41)

同步模式前机头偏移值	<input type="text" value="0"/>	10	<input type="text" value="0"/>	19	<input type="text" value="0"/>	WHO:
6#纱嘴回退修正	<input type="text" value="0"/>	11	<input type="text" value="0"/>	20	<input type="text" value="0"/>	<input type="text" value="NO CHANG"/>
7#纱嘴回退修正	<input type="text" value="0"/>	12	<input type="text" value="0"/>	21	<input type="text" value="0"/>	PARA. ID:
前后顶杆N次动作后自动找零	<input type="text" value="0"/>	13	<input type="text" value="0"/>	22	<input type="text" value="0"/>	<input type="text" value="1"/>
最高速限制	<input type="text" value="230"/>	14	<input type="text" value="0"/>	23	<input type="text" value="0"/>	PARA. VAL:
6	<input type="text" value="0"/>	15	<input type="text" value="0"/>	24	<input type="text" value="0"/>	<input type="text" value="0"/>
7	<input type="text" value="0"/>	16	<input type="text" value="0"/>	25	<input type="text" value="0"/>	<input type="button" value="READ"/>
8	<input type="text" value="0"/>	17	<input type="text" value="0"/>	26	<input type="text" value="0"/>	<input type="button" value="WRITE"/>
9	<input type="text" value="0"/>	18	<input type="text" value="0"/>	27	<input type="text" value="0"/>	<input type="button" value="HOME"/>
						<input type="button" value="↩"/>

Figure 41

Example: View servo parameter 24 (rear drum) 1024 (front drum) (communication terminal selects drum → parameter number fills in 24 or 1024 → read)

This parameter table is the default parameter and generally cannot be changed.

6.5 INSTALLMENT

Decrypt and load installment payment files based on customer situation
(Figure42)

The screenshot displays a software interface for managing installment payments. At the top, a teal bar contains the date '2024-07-30'. Below this is a table with 12 empty rows, organized into three columns of four rows each. The bottom of the interface features a navigation bar with five blue buttons: 'IMPORT LOCK', 'ALL UNLOCK', 'UNLOCK', 'HOME' (with a house icon), and a back arrow icon.

Figure 42

6.6 DISK MANAGMENT

Use USB flash drive to import and export pattern files, machine parameters, system parameters, whole machine parameters, and delete functions (Figure 43)

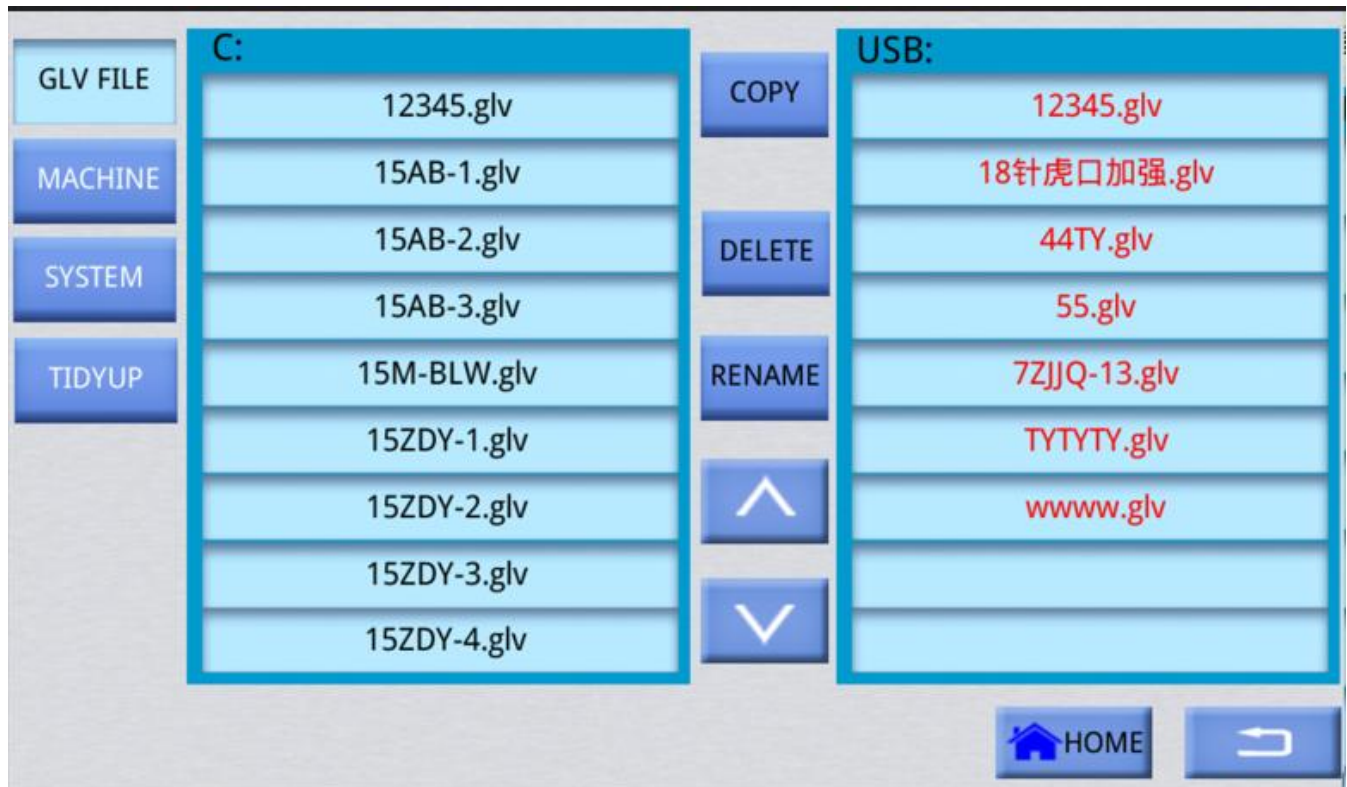


Figure 43

C: Refers to the parameter files inside this machine

USB: Refers to the parameter files connected to the USB drive (red file names indicate that there are identical files on the local machine)

GLV FILE: The parameter file for weaving glove styles after setting is completed

MACHINE: Refers to the specific parameter files required during the operation of this model

SYSTEM: Refers to the system parameter files required during the operation of this model

TIDY UP: Refers to the parameter files specifically set for the sorting machine

COPY: Refers to copying files from the local machine to a USB drive or copying files from a USB drive to the local machine (requires selecting files)

DELETE: Refers to deleting files from the local machine or deleting files from the USB drive (requires selecting files)

RENAME: Change the local parameter file name or USB parameter file name (file

selection required)

6.7 SYSTEM PARA.

View and modify various speed functions of the main motor and stepper motor (Figure 44)

SERVO LOW SPEED [10,100]:30	100	FORK MOTO SPEED [20,600]:120	100
SERVO JOG SPEED [10,100]:50	25	LEFT CUTTER SPEED [20,120]:60	60
SERVO RESET SPEED [10,100]:30	10	LEFT CUTTER PIN SPEED [20,300]:120	60
B-RUBBER PIN SPEED [100,2000]:800	20	RIGHT CUTTER SPEED [20,120]:60	150
F-RUBBER PIN SPEED [100,2000]:800	100	RIGHT CUTTER PIN SPEED [20,300]:120	100
ROLLER FINGER SPEED [100,600]:600	100	FINGER MIN. LINES [0,50]:0	8
ROLLER PALM SPEED [100,600]:600	211	PALM MIN. LINES [0,50]:0	2
ROLLER RESET SPEED [100,500]:400	212	RUBBER MIN. LINES [0,50]:0	8
FRONT PIN SPEED [20,600]:120	188		
BACK PIN SPEED [20,600]:120	100		

Figure 44 shows a control interface with three buttons on the right: 'DEFAULT', 'HOME', and a refresh button.

Figure 44

SERVO LOW SPEED: The speed of the main motor ranges from a minimum of "10" to a maximum of "100", with a recommended speed of "30". The speed can be adjusted within this range

SERVO JOG SPEED: When the main motor is jog, the speed is at a minimum of "10" and a maximum of "100". The recommended speed is "50", and the speed can be adjusted within the range

SERVO RESET SPEED: When the main motor is reset, the speed should be at a minimum of "10" and a maximum of "100". The recommended speed is "30", and the speed can be adjusted within the range

B-RUBBER PIN SPEED: The minimum and maximum speeds for the action of the rear rubber top rod are "100" and "2000", respectively. The recommended speed is "800", and the speed can be adjusted within this range

F-RUBBER PIN SPEED: When the front rubber band top rod moves, the speed should be at least "100" and at most "2000". The recommended speed is "800", and the speed can be adjusted within the range

DRUM FINGER SPEED: The drum motor has a minimum speed of "100" and a maximum speed of "600" when weaving the fingers. The recommended speed is "600", and the speed can be adjusted within the range

DRUM PALM SPEED:The drum motor has a minimum speed of "100" and a maximum speed of "600" during the weaving palm movement. The recommended speed is "600", and the speed can be adjusted within the range

DRUM RESET SPEED: The drum motor has a minimum speed of "100" and a maximum speed of "500" when performing the reset action. The recommended speed is "400", and the speed can be adjusted within the range

FRONT PIN SPEED: When the front pole motor is working, the minimum speed is "20" and the maximum speed is "600". The recommended speed is "120", and the speed can be adjusted within the range

BACK PIN SPEED: When the rear top pole motor is working, the minimum speed is "20" and the maximum speed is "600". The recommended speed is "120", and the speed can be adjusted within the range

FORK MOTO SPEED: When the fork knife motor is working, the minimum speed is "20" and the maximum speed is "600". The recommended speed is "120", and the speed can be adjusted within the range by oneself

LEFT CUTTER SPEED: When the left scissor motor is working, the minimum speed is "20" and the maximum speed is "120". The recommended speed is "60", and the speed can be adjusted within the range

LEFT CUTTER PIN SPEED: The speed of the left scissor lever motor during operation ranges from a minimum of "20" to a maximum of "300". The recommended speed is "120", and the speed can be adjusted within this range

RIGHT CUTTER SPEED: When the right scissor motor is working, the minimum speed is "20" and the maximum speed is "120". The recommended speed is "60", and the speed can be adjusted within the range

RIGHT CUTTER PIN SPEED: When the motor of the right scissor bar is working, the minimum speed is "20" and the maximum speed is "300". The recommended speed is "120", and the speed can be adjusted within the range

FINGER MIN. LINES: The minimum number of turns on the fingers of knitted gloves ranges from "0" to "50", with a recommended value of "0". The range can be adjusted by oneself

PALM MIN. LINES: The minimum number of turns on the palm of the knitted glove ranges from "0" to "50", with a recommended value of "0", which can be adjusted within the range

RUBBER MIN. LINES: The minimum number of turns in the ribbed area of the knitted glove is "0" and the maximum is "50". The recommended value is "0", which can be adjusted within the range

6.8 MACHINE PAPA.

View and modify machine woven glove size, AB position, drum parameters, and other settings(Figure45)

NEEDLE CELL	15G	HEAD POS. INCREASE	20
SIZE	M	TAKING OFF HEAD POS.	8
LOW FORK	ENABLE	ADD OIL TIME(SEC)	3
MACHINE HEAD POS.	ENTER	ADD OIL INTERVAL (MIN)	777
FORK POS.	ENTER	AFTER OIL SPEED	120
LEFT CUTTER PIN POS.	ENTER	AFTER OIL SLOW LINES	3
PRESS & RUBBER START STOP	ENTER	RIGHT CUTTER LIN	150
YARN AB POS. SET	ENTER	CHANGE NEEDLE MODE	DISABLE
PIN POS. SET	ENTER		
ROLLER TABLE SET	ENTER		



 HOME


Figure 45

NEEDLE CELL: Refers to the number of needles per inch of the machine

SIZE: Size of woven gloves

LOW FORK: Select 'Enable' or 'Disable' based on the model

MACHINE HEAD POS.: Machine head AB position parameter setting

FORK POS.: Setting of parameters for the working position of fork knife weaving

LEFT CUTTER PIN POS.: Parameter Setting for Scissor Rod Working Position

PRESS & RUBBER START STOP: Parameter settings for needle pressing position and rubber start stop position of woven gloves

YARN AB POS. SET: Parameter settings for the working position of the yarn mouth in woven gloves

PIN POS. SET: Motor position for front and rear pole weaving gloves during work, half needle and needle pressing

drum TABLE SET: The drum parameters of the current machine

HEAD POS. INCREASE: Increase the travel of the machine head during replacement

TAKING OFF HEAD POS.: Refers to the forward and backward stroke of the machine head, with a minimum of "10" and a maximum of "40" according to the set number of needles. The recommended value is "20", which can be adjusted within the range

ADD OIL TIME(SEC):The minimum duration for refueling is "10" and the maximum is "300", with a recommended value of "10", which can be adjusted within the range

ADD OIL INTERVAL (MIN) : The minimum interval for refueling after automatic refueling of the machine is "10", the maximum is "3000", and the recommended value is "200", which can be adjusted within the range

AFTER OIL SPEED: When refueling, the speed can be set and appropriately reduced to prevent oil splashing at high speeds. The minimum speed is "60" and the maximum is "200". The recommended speed is "150", which can be adjusted within the range

AFTER OIL SLOW LINES: Refers to the number of laps the machine weaves at a slow speed after refueling

RIGHT CUTTER LIN: Point to the position of the right scissors rod when sealing the line with the right scissors

CHANGE NEEDLE MODE: After pressing the needle, replace it with "enable" or "disable"

6.9 TIME SET

System time modification settings

2024-07-30 11:29:01

YEAR:	2024	HOUR:	11
MONTH:	07	MINTUE:	28
DAY:	30	SENCOD:	58

HOME

↻

Figure 46

6.9 ASSEMBER

For assembly personnel and inspection personnel to fill in their own numbers and view information of other assembly personnel, after the factory parameter inspector fills in the numbers, the machine automatically saves the current factory parameters, which can be used to restore the factory settings.(Figure47)

	WORKER ID.	CHECK RESUL	
1.STEP	0	WAIT	MACHINE ID: 0
2.STEP	0	WAIT	DEBUG CHECKER: 0
3.STEP	0	WAIT	ASSEMBER CHECK 0
4.STEP	0	WAIT	PARA. CHECKER: 0
5.STEP	0	WAIT	CHECK DATE: 0-00-00 00:00:00
6.STEP	0	WAIT	
7.STEP	0	WAIT	
8.STEP	0	WAIT	
9.STEP	0	WAIT	
10.STEP	0	WAIT	
11.STEP	0	WAIT	
12.STEP	0	WAIT	

ALL OK

SAVE

HOME

↩

Figure 47

6.10 TIDY UP PARA

TIDYUP/REVERSE FUNCTION	ENABLE	LINES OF PULL DOWN	3	COMMAND
COUNT OF TIDYUP	77	LENGTH OF FALLDOWN(mm)	0	
THICK OF 24 GLOVES	150	TIME OF MOVE MOTO(s)	12.3	TEST PAGE
PRESS THICK OF 24 GLOVES	5	POS. TABLE SET	ENTER	
DISTANCE OF PULL (mm)	150	MOTO SPEED & ZERO ADJUST	ENTER	REVERSE DEB UG
TURN MOTO INITIAL DEGREE	3458			
UPDOWN MOTO MAX. POS(m)	300			HOME
PRESS MOTO MOVE UP(mm)	1700			
TURN MOTO DEGREE	0			↩
OPEN MOTO PULSE	1340			

Figure 48

TIDYUP/REVERSE FUNCTION: You can choose to "TIDY UP", "REVERSE" or "DISABLE" this function

COUNT OF TIDY UP: Refers to setting the number of gloves woven by the glove machine to a minimum of "1" and a maximum of "36" per stack, with a recommended value of "24", which can be adjusted within the range

THICK OF 24 GLOVES(mm): After weaving 24 gloves, the thickness of the glove press plate pressing the collar of each pair of gloves ranges from a minimum of "10" to a maximum of "400". It is recommended to use a thickness of "150", which can be adjusted within the range.

PRESS THICK OF 24 GLOVES (mm) : The minimum distance for the maximum thickness of each glove press rod when pressed down is "10", the maximum is "400", and the recommended value is "140". The range can be adjusted by oneself

DISTANCE OF PULL (mm): When releasing the glove cover, the distance of horizontal contraction and dragging of the glove clamp inward can range from a minimum of "1" to a maximum of "1000", with a recommended range of "100", which can be adjusted by oneself within the range

TURN MOTO INITIAL DEGREE: Used to adjust the distance between the first glove and the conveyor belt during debugging, with a minimum of "1" and a maximum of "10000". The recommended value is "1090", which can be adjusted within this range

UPDOWN MOTO MAX. POS(mm): After the glove is clamped by the clamp and flipped outward, the distance that the first glove of the clamp extends outward ranges from a minimum of "100" to a maximum of "300", with a recommended value of "205", which can be adjusted by oneself within the range

PRESS MOTO MOVE UP(mm): Before lifting the clamp, the height of the clamp can range from a minimum of "1" to a maximum of "500", with a recommended value of "120", which can be adjusted within this range

TURN MOTO DEGREE: The minimum angle for the rotating motor to flip outward after clamping the gloves with a clamp is "1", and the maximum is "1000". The recommended value is "100", which can be adjusted by oneself within the range

OPEN MOTO PULSE: When dragging gloves, the minimum number of pulses required for the opening motor to open is "1", the maximum is "10000", and the recommended value is "120". The range can be adjusted by oneself

LINES OF PULL DOWN: Set the minimum "1" and maximum "5" for the starting action of the whole punching machine after the glove has been dropped for a certain number of turns, with a recommended value of "2". The range can be adjusted by oneself

LENGTH OF FALLDOWN(mm): The minimum distance for the downward movement of the lifting motor when dropping the gloves is "0", and the maximum is "10". The recommended value is "5", which can be adjusted within the range by oneself

TIME OF MOVE MOTO(s): The minimum time for the conveyor belt to rotate after the entire weaving process is 4.0 and the maximum is 20.0. The recommended speed is 7.0, which can be adjusted within the range

POS. TABLE SET: Set the vertical position and wait for positions 1/2/3 to lift, rotate, and open the position of the motor

MOTO SPEED & ZERO ADJUST: Modification of speed parameters and zero position adjustment for each motor of the whole machine

COMMAND: Each instruction setting for organizing machine actions (for internal personnel debugging and use, cannot be modified)

TEST PAGE: After clicking, the interface will directly go to the testing page for easy testing

REVERSE DEBUG: Specific position parameter settings when using the inversion machine

6.10.1 REVERSE DEBUG

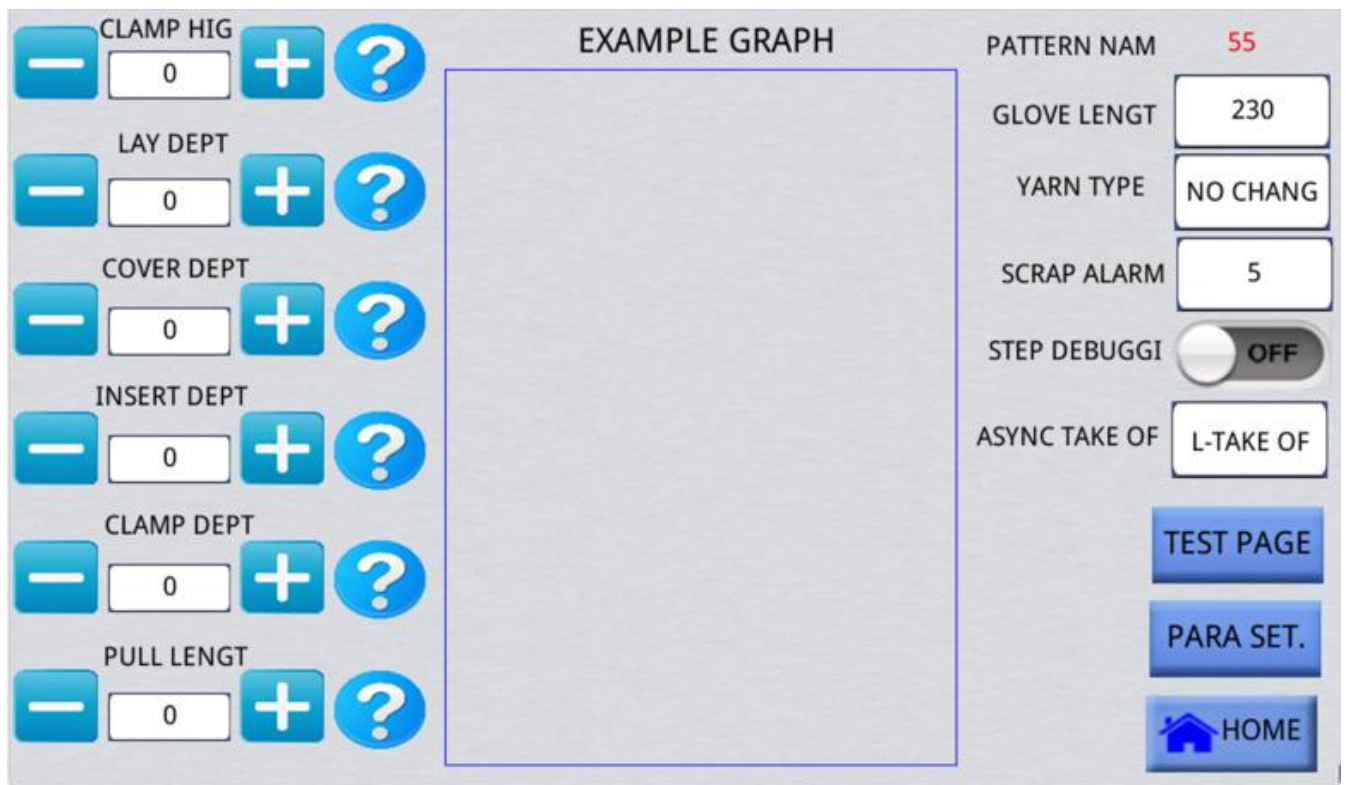


Figure 49

CLAMP HIGH: Refers to the height when debugging and picking up gloves

LAY DEPTH: Refers to the depth at which gloves are placed during debugging

COVER DEPTH: Refers to the depth at which the glove is turned over during debugging

INSERT DEPTH: Depth of insertion of fork rake motor into sleeve

CLAMP DEPTH: Depth of finger hook motor for gripping gloves

PULL LENGTH: The length of the hook and pull motor that pulls up the groove

GLOVE LENGTH(MM): Refers to the total length of the entire glove

YARN TYPE: Refers to the type of yarn used when weaving gloves

SCRAP ALARM: Refers to the number of consecutive glove flipping failures that trigger an alarm

STEP DEBUGGING: This feature is not currently enabled

ASYNC TAKE OF: The order of glove removal is divided into left and right removal

6.11 LOCAL SET

B-HEAD ZERO(mm) [0,300]:6	0.0	MAIN YARN RELEASE POS-1 [-150,150]:0	0
F-HEAD ZERO(mm) [0,300]:6	0.0	MAIN YARN RELEASE POS-2 [-100,150]:0	0
B-RUBBER PIN MOTO ZERO [0,359]:90	0	B-PIN PRESS NEEDLE DEG. [0,359]:180	0
F-RUBBER PIN MOTO ZERO [0,359]:90	0	F-PIN PRESS NEEDLE DEG. [0,359]:180	0
B-ROLLER MOTO ZERO [0,359]:X	0	FALLDOWN B-PIN POS. ADJU [-50,0]:-20	0
F-ROLLER MOTO ZERO [0,359]:X	0	FALLDOWN F-PIN POS. ADJUS [-50,0]:-20	0
LEFT CUTTER TAKING OFF [130,300]:160	0	BREAK CLOSE LINES [0,50]:0	0
RIGHT CUTTER TAKING OFF [130,300]:160	0	RIGHT CUTTER FUNCTION	ENABLE
HEAD DISTANCE ADJUST [0,20]:0	0	RIGHT CUTTER PIN FUNCTIO	ENABLE
RUBBER HEAD DISTANCE ADJ [0,20]:0	0	TOW MAIN CUTTER USE	DISABLE






Figure 50

B-HEAD ZERO(mm): After the reset of the rear machine head is completed, the lowest position it stays at is "0", the highest is "300", and it is recommended to use "6". The specific distance between the rear machine head and the frame edge needs to be measured using a ruler, which is 55MM

F-HEAD ZERO(mm): After the reset of the front machine head is completed, the lowest position it stays at is "0", the highest is "300", and it is recommended to use "6". The specific distance between the front machine head and the frame edge needs to be measured using a ruler, which is 65MM

B-RUBBER PIN MOTO ZERO: After the reset of the rear rubber top rod is completed, the lowest position it stays at is "0" and the highest is "359". It is recommended to use "90", which can be adjusted according to the actual situation

F-RUBBER PIN MOTO ZERO: After the reset of the front rubber top rod is completed, the lowest position it stays at is "0" and the highest is "359". It is recommended to use "90", which can be adjusted according to the actual situation

B-DRUM MOTO ZERO: After the rear drum completes the reset, the lowest position it stays at is "0" and the highest is "359". Adjust the zero position according to the actual drum position and fill it in

F-DRUM MOTO ZERO: The lowest position of the front drum after resetting is "0" and the highest is "359". Adjust the zero position according to the actual drum position and fill it in

LEFT CUTTER TAKING OFF: During the weaving process of the left scissors, the lowest position for thread placement is "130" and the highest is "300". It is recommended to use "160", which can be adjusted according to the actual situation

RIGHT CUTTER TAKING OFF: During the weaving process of the right scissors, the lowest position for thread placement is "130" and the highest is "300". It is recommended to use "160", which can be adjusted according to the actual situation

HEAD DISTANCE ADJUST: When the machine head runs asynchronously, the distance between the front and rear machine heads can be adjusted to a minimum of "0" and a maximum of "20". It is recommended to use "0", which can be adjusted according to the actual situation

MAIN YARN RELEASE POS-1 (Double layer scissors) : When using double-layer scissors on the left side, the lowest "0" and highest "100" positions for the main yarn 1 are recommended to be "30", which can be adjusted according to the actual situation

MAIN YARN RELEASE POS-2 (Double layer scissors) : When using double-layer scissors on the left side, the minimum "-100" and maximum "-1" positions for the main yarn 2 are recommended to be "-30", which can be adjusted according to the actual situation

B-PIN PRESS NEEDLE DEG.: When pressing the needle, the rear top rod pushes the needle to press down the depth of the triangle

F-PIN PRESS NEEDLE DEG.: When pressing the needle, the front top rod pushes the needle triangle downwards to press the depth

FALLDOWN B-PIN POS. ADJUST: Fine tuning the depth of the pressure needle on the top rod after dropping the gloves

FALLDOWN F-PIN POS. ADJUST: Fine adjustment of the depth of the pressure needle on the front top rod of the glove

BREAK CLOSE LINES: After changing to zero, the alarm is normal, but after changing to any number, it does not alarm when the glove falls and the corresponding number of turns breaks the yarn

RIGHT CUTTER FUNCTION: Enable or disable the right scissor function

RIGHT CUTTER PIN FUNCTION: Enable or Disable the Right Scissor Rod Function

TOW MAIN CUTTER USE: Enable or disable the double-layer scissor function

6.12 PRODUT RECORD

NO.	TIME	WORK PATTERN	SINGLE TIME
X	2024-07-30 11:15:16	<0>55.glv	0:00
X	2024-07-30 11:15:10	<0>55.glv	0:00
X	2024-07-30 11:12:47	<0>55.glv	0:00
X	2024-07-30 11:12:42	<0>55.glv	0:00

X;2024-07-30 11:15:16;<0>55.glv;0:00;

Figure 51

NO.: Sort by Arabic numerals

TIME: The completion time of glove weaving

WORK PATTERN: The glove is woven with a certain pattern. The number "<0>" indicates the number of gloves woven with that pattern

SINGLE TIME: The specific time required to weave a single glove

7 SPECIAL INSTRUCTIONS FOR USE

1. During the weaving process, press the stop button twice in a row (red button) and the brush will return to the reset position.

2. Press the stop button (red) for 5 seconds to start refueling.

3. When the copying of the pattern file and parameters fails, enter the "Disk Management" interface in the system management and select the blank space under the "USB" window to delete it continuously 19 times (any deletion of the file in the middle of 19 times needs to be recalculated), and then enter the formatted disk state. Wait for the formatting at the bottom left of the display screen to complete and automatically enter the main interface, then use a USB flash drive to copy the patterns and parameters again.

8 COMMON PROBLEM SOLUTIONS

Fault problem	Troubleshooting and Solutions
8.1 SYSTEM HALTED	<ol style="list-style-type: none">1. Clean up memory: After shutting down, keep holding down the stop button (red) and jog button (yellow) before turning on the device. After the display screen shows completion, it will automatically enter the upgrade page. After entering the upgrade page, release the button to clear the memory. After shutting down and turning on the device, select a new pattern.2. Remove other cables and keep the power and display cables before turning on the computer, and confirm if there are any other issues causing the system to crash.

<p>8.2 CANNOT RESET</p>	<ol style="list-style-type: none"> 1. Open the electrical test item to check if the stop, start, and jog buttons on the display screen are effective. 2. Check if the front and rear nose zero position lights are on 3. Check if the local setting parameters are fully filled in and there should be no -1 value 4. Check if there is any movement in the front and rear rubber bar top rods, and verify if the program version of the front and rear rubber bar top rods on the upgrade interface is "0". If it is "0", check the corresponding motor cable, upgrade the program again, and assign a new number. 5. Check the problems in order of the error items and solve them.
<p>8.3 DISPLAY SCREEN MALFUNCTION</p>	<ol style="list-style-type: none"> 1. Display black screen, flower screen. Suggest replacing the display screen directly. 2. Touch screen calibration: Press and hold the stop button (red) and jog button (yellow) simultaneously for about 15 seconds while the device is turned on to enter the touch screen calibration mode. Press the "5" cursor in sequence to complete the touch screen calibration. 3. Display module abnormality, it is recommended to upgrade the display screen program again.
<p>8.4 SERVO MALFUNCTION</p>	<ol style="list-style-type: none"> 1. Motor overload error: Check if there is a needle collision and the tightness of the main motor belt 2. Check if the upgrade interface can display the servo version (cannot be "0") 3. Reset the machine for abnormal noise: Open the servo parameter adjustment, select the servo

	<p>on the communication terminal → fill in the parameter number with "5" (rear head servo motor) or "12" (front head servo motor) → read and display "6" changed to "7" or "7" changed to "6" → write. (1.6A motor defaults to "6", 2.2A motor defaults to "7")</p> <p>4. There is a noise during operation, and there is high resistance to the movement of the machine head. Lubricating oil is added to the Shengke triangle and Shengke plate.</p>
<p>8.5 DRUM MALFUNCTION</p>	<p>1. drum error, unable to find reset signal: Check if the drum zero position signal board light is on, readjust the drum zero position (change the zero position values of the front and rear drum to "1" according to the machine parameters, then reset the drum, stop and manually adjust the drum to the fourth pin with flat pins on both sides, and check the number displayed in the front position bracket. If the value is greater than 80 (display value -80) and less than 80 (display value +360-80), fill in the corresponding front and rear drum zero position items in the machine setting parameters after obtaining the value</p> <p>2. Drum error 0XA440: Machine parameters or pattern drum parameters are incorrect, import machine parameters or pattern again.</p> <p>3. Open the upgrade interface to check if the drum version is "0". If it is "0", it needs to be upgraded again</p> <p>4. Front and rear drum reversal: Open the servo parameter adjustment, select the drum on the communication terminal → fill in the parameter number "24" (rear drum) or "1024" (front drum) → read and display "3" changed to "0" → write),</p>

	and vice versa.
8.6 FAULTY YARN FEEDER	<ol style="list-style-type: none"> 1. The yarn feeder reports errors 0X500, 0X9, blockage or motor failure, and the sand feeder motor needs to be replaced 2. The motor does not lock the shaft: First, check the cable problem, renumber and upgrade the yarn feeder program 3. The position of the yarn feeder is misaligned: the first needle needs to be recalibrated 4. Unable to number, upgrade, indicator light not on: yarn feeder motor needs to be replaced
8.7 NO ALARM FOR BROKEN YARN	<ol style="list-style-type: none"> 1. If the rubber band breaks, there will be no alarm. If the main yarn breaks, there will be an alarm. Check if the alarm connection wire is properly connected or if the screws are tightened and in contact with the frame. 2. Alarm for broken rubber band and no alarm for broken main yarn: Check if the connecting screws of the wire frame are tightened and in contact with the frame. 3. No alarm for broken rubber main yarn: Check if the number of broken wire alarm cycles in the machine parameters is -1 4. If the yarn is broken and no alarm is triggered, check whether the LED lights on both sides and the LDE circuit of the rack are short circuited to the rack. You can disconnect the LED wiring for troubleshooting. 5. Disconnect the connecting wire at the back of the machine and directly short-circuit test to see if there is an alarm. If there is no alarm, the electrical box needs to be replaced

**8.8 USB DRIVE
MALFUNCTION**

1. Check if the USB flash drive is OK, check if the USB interface pins are bent, and if the connecting wires are disconnected.
2. Does the USB flash indicator light flash normally a few times? (If it keeps flashing, it may indicate a problem with the electrical box. The 24V positive pole may be grounded.)

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