

AC-1601 自动上圆领机使用手册V1

AC-1601 Automatic round collar machine user manual

1、产品示意图 Product Diagram






2. 操作面板各按键及显示功能详细说明

Detailed description of buttons and display functions on the operation panel

2.1. 主界面各按键及显示功能详细说明

Main interface each key and display function detailed description




功能 Function	显示/按键 Display/Button	图形 Graph	描述说明 Description
主界面 Main Interface	语言转换 Language transformation		中/英文显示转换 Chinese/English display conversion
	尺码选择 Size selection		选择XS-XXXL 7种尺码, 尺码大小可修改, 前一尺寸为复位尺寸, 后一位尺寸为反踩二档的拉开尺寸, 均可调 Choose XS-XXXL 7 sizes, size can be modified, former size is the reset size, and the latter size is the opening size of the reverse step second gear, which can be adjusted
	当前产量current production		每次开机后产量计数显示 Output count display after each startup
	生产效率Production efficiency		每分钟的生产效率显示 Productivity per minute display
	报警信息Alarm information		点开显示器和PLC软件版本, 出现报警会出现故障代码Click on the display and PLC software version, the alarm will appear fault code
	当前清零current reset		按住不松开 2秒后将当前产量的计数值进行清holding for 2 seconds, the current output count will be cleared
	手动画面Manual screen		点击进入手动操作界面 Click to enter the manual operation interface
	参数画面Parameters of the picture		点击进入参数设定界面 Click to enter the parameter setting interface


	模式选择mode selection		每触按一次，进行手动模式和自动模式转换manual mode and automatic mode conversion when press the button once
	状态指示灯Status light		停机：按停止开关显示（绿色）；原点：设备回到原点显示（绿色）；手动：自动和手动转换时显示当前状态Stop: press the stop switch to display (green); Origin: The device is displayed back to the origin (green); Manual: Displays the current status during automatic and manual transitions
	复位键 Resetting key		点击所有动作恢复，拉开回到原点Click on All Actions to restore and pull back to the original point
注：手动模式下，只有拉开电机运行、压布电机运转、吸风、压脚、松线、压布、缝位功能 Note: Manual mode, only open the motor operation, press the motor operation, suction, press foot, loose line, press cloth, sewing position functions			

2.2. 手动界面各按键及显示功能详细说明





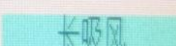

Detailed description of buttons and display functions in manual interface



功能 Function	显示/按键 Display/Button	图形 Graph	描述说明 Description
手动画面 Manual screen	运转 turn round		手动调试时，点击启动压布电机转动Manually debugging, click to start the press motor rotation
	停止 Stop		手动调试时，点击停止压布电机转动Manually debugging, Click to stop the press motor rotation
	增大 enlargement		手动调试时，点击拉码电机拉开Manually debugging, Click the pull code motor to open
	减小 decrease		手动调试时，点击拉码电机缩进 Manually debugging, Click the pull code motor to indent
	松线 thread slack		手动调试时，点击控制松线气缸动作 Manually debugging, click control of thread slack action
	压布 Compresses		手动调试时，点击控制压布动作 Manually debugging, Click to control cloth pressing action
	旋转 rotate		手动调试时，点击控制旋转气缸动作 Manually debugging, Click to control the rotating cylinder action
	压脚 presser foot		手动调试时，点击控制压脚气缸动作 Manually debugging, Click to control presser cylinder action
	缝位 Seam position		手动调试时，点击控制缝位气缸动作 Manually debugging, Click to control slot cylinder action
	吸风 Suction		手动调试时,点击控制吸风动作 Manually debugging, Click to control suction action
	工作画面Work picture		点击返回主界面 Click to return to the main screen

IO监控 IO monitor		点击进入IO监控界面 Tap to go to the I/O monitoring page
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IO监控I/O monitoring	圆领裤腰模式 Round neck waistband pattern	 	触控此按钮显示圆领，表示启用圆领模式；显示裤腰，表示启用裤腰模式 Touch this button to display the round neck mode, and to display the waistband mode, enable the waistband mode
	圆领多段模式 Round neck multi-section pattern	 	触控此按钮显示绿色，表示启用圆领多段模式功能；显示红色，表示不启用圆领多段模式功能 Touch this button, the green color indicates that the multi-segment round neck function is enabled. The red color indicates that the multi-segment round neck function is disabled
	吸风模式 Suction mode	 	触控此按钮显示长吸风，表示启用长吸风功能；显示短吸风，表示启用前后吸风功能 Touch this button to display long suction, indicating that the long suction function is enabled. If short air suction is displayed, the front and rear air suction function is enabled

2.3. 参数设定界面各按键及显示功能详细说明

Detailed description of buttons and display functions on the parameter setting interface



功能 Function	显示/按键 Display/Button	描述说明 Description	参数范围 Parameter scale	默认值 Default
	踏板值 Pedal value	踏板值静止状态实际电压值显示 (单位: V) Pedal value Display of actual voltage at rest (unit: V)	1.0-1.6	
	找股位值 Find stock value	脚踏板后踩第二档电压值, 布遮住电眼后, 后踩起动找股 (单位: V) Step on the second gear voltage after the foot pedal, cover the electric eye, step on the back to start looking for shares (unit: V)	0.05-0.6	0.4

抬压脚值Lift foot value	脚踏板后踩第一档电压值，后踩起压脚可以放布（单位：V） Step on the first gear voltage value after the foot pedal, step on the pressure foot can put cloth (unit: V)	0.4-1.0	0.9
踏板启动值 Pedal starting value	脚踏板前踩过程中，设定缝纫电机启动运转的最低踏板值，保证步进电机与其同步启动运转，同时启动吸风，值可调（单位：V） Set the minimum pedal value of the sewing motor to start and operate in the process of stepping the foot pedal forward to ensure that the stepper motor starts and operates simultaneously with it and starts the suction at the same time, the value is adjustable (unit: V).	1.2-2.5	2.0
前撑开延时 Front stretch delay	自动模式下，过骨时，上布找骨时旋转打开和缝位伸出的延时时间(单位：S) In automatic mode, when the bone is over, the delay time of rotation opening and seam extension when the bone is found on the cloth (unit: S)	0.01-1.0	0.05
松线延时 Loose line delay	自动模式下，布离开电眼后数针松线，松线的延时时间（单位：S） In automatic mode, after leaving the electric eye, the delay time of loosening the thread (unit: S)	0.05-2.0	0.5
找股电机运行速度 Find a motor running speed	设定找股电机动行速度（单位：RPM） Set the speed of the motor (unit: RPM)	300-3500	2000
拉开电机运行速度 Open the motor running speed	设定拉开电机运行速度（单位：RPM） Set the opening motor running speed (unit: RPM)	300-99000	4000
工作画面Work picture	点击返回主界面 Click to return to the main screen		
出厂设置 Factory settings	点击按键 2 秒以上恢复出厂设置 Click the button for more than 2 seconds to restore factory Settings		

特殊-裤腰模式：1) 裤腰模式下，导骨和缝位开关不起作用，膝靠开关手动可以控制旋转和拉开电机；2) 动作过程：布遮住电眼，踩电机吸风，布离开电眼，旋转回收，车完后数针松线及吸风，最后拉开退回。

Special - waistband mode: 1) In waistband mode, the guide bone and seam position switch does not work, and the knee switch can manually control the rotation and opening of the motor; 2) Action process: cover the electric eye with cloth, step on the motor to absorb the wind, remove the cloth from the electric eye, rotate and recycle, after the car is finished, several needles loosen the thread and absorb the wind, and finally pull back.

特殊-多段模式：1) 多段模式下，圆领做到一半时，靠膝靠开关，拉开向后退一定数值，让圆领拉的更紧些。

Special - multi-section mode: 1) In multi-section mode, when the round collar is half done, lean on the knee switch, pull back to a certain value, so that the round collar is pulled tighter.

3.规格参数 Specification parameter

气压 Air Pressure	6KG
机头转速 Rotation Speed	4000RPM
长*宽*高 (L*W*H)	120*76*159CM
尺寸范围 Size Rang	30-170CM
产能效率 Capacity	120Pcs/H

4.注意事项 Precautions

序号No.	事项 Matte
1	缝纫电机控制箱的调速器接口的速度控制线以及数针信号线是热地，对应PLC控制箱尾部接口的DA/AD，严禁裸手触摸，严禁误插PLC控制箱的其它接口 Speed control line and number pin signal line of the governor interface of the sewing motor control box are hot ground. The DA/AD corresponding to the tail interface of the PLC control box are strictly forbidden to touch bare hands or insert other interfaces of the PLC control box by mistake
2	PLC控制箱的接口因输出电压等级不同、有隔离与非隔离设计，误插接口会烧坏控制器 PLC control box interface because of different output voltage levels, isolation and non-isolation design, misplug interface will burn out the controller

5.故障代码说明 Description of the fault code

1.产品开机后，如果PLC关联的（如电控、电眼等）出现故障，会弹出橙色的报警显示，在报警列表中会显示故障的原因 After the product is turned on, if the PLC associated (such as electric control, electric eye, etc.) fails, an orange alarm display will pop up, and the cause of the failure will be displayed in the alarm list

2.退出报警模式的方式：当故障处理完毕后，点“报警清除”，看报警列表中的显示项有无消除，如果有消除，再点“返回主页”，就可以返回主界面正常使用，如果没有消除，表示故障没有处理好，要继续查找问题。How to exit the alarm mode:When the fault is handled, click "alarm clear" to see whether the display items in the alarm list are eliminated, if there is elimination, click "return home", you can return to the normal use of the main interface, if not eliminated, it means that the fault has not been handled well, to continue to find the problem.

主要代码说明Error code display description	处理措施 Treatment measure
数针故障 Needle count failure	缝纫机马达不起动（包括马达电控没开或显示错误代码），只有拖轮转，会显示“数针故障”；sewing machine motor does not start (including the motor electric control is not turned on or the error code is displayed), only the tug wheel is turned, and the "Needle count failure" will be displayed
	X2 信号线损坏或没插，会显示“数针故障”。the X2 signal cable is damaged or not inserted, the "Needle count failure" will be displayed

6.控制箱尾部接口图 Control box tail interface diagram

