電子送帶機

COMPUTERIZED METERING DEVICE

使 用 說 明 書
OPERATION MANUAL
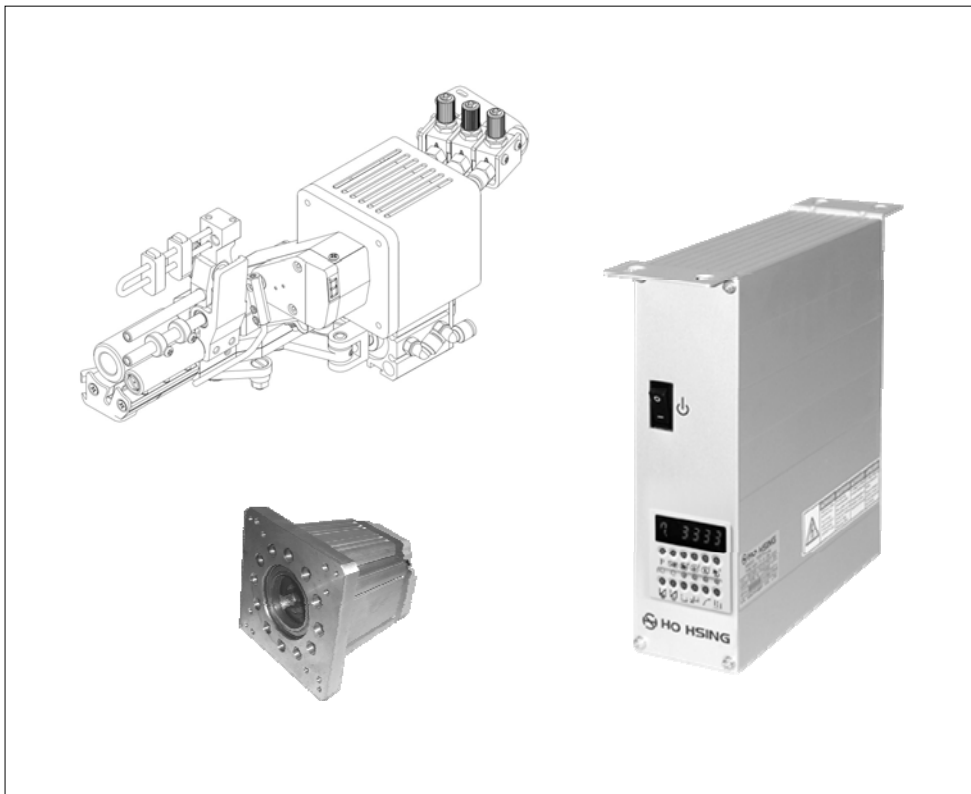
CE

MODEL : MC2 SERIES

中 文 版   **ENGLISH**

目錄 Content

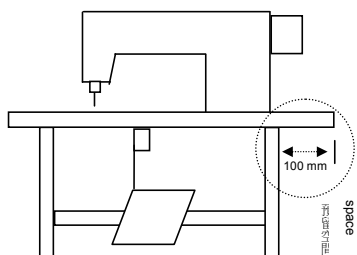# I. 安裝與調整 / Installation and Adjustment

(1).馬達的安裝 ：請參閱各車頭製造廠之說明書。

Motor installation: Please refer to the machine head's instruction.
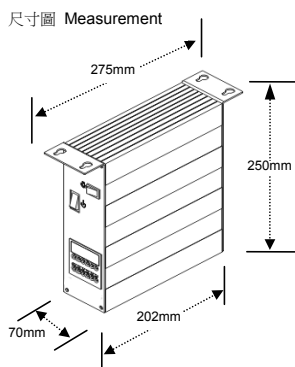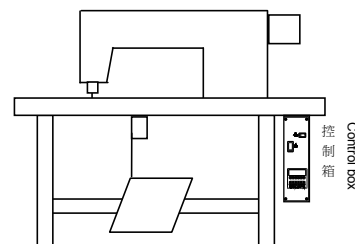
(2).控制箱的安裝 ：

Control Box Installation:

a).車板右側面須預留 100 mm 以上空間
Leave 100 mm space at right

b).將 MC2 控制箱鎖裝於車板下方
Mounting MC2 under the working table

c).安裝後示意圖
Installation layout

尺寸圖 Measurement
275mm
250mm
70mm 202mm

控制箱 Control box

(3).控速器的安裝 ：

Speed Control Unit Installation:

a).控速器與其支架座
Speed Control Unit

b).保持在吊桿成直線下，將控速器連座鎖於車板下方
Keep rod in vertical, secure the unit under the table

c).安裝後示意圖
Installation layout

控速器支架 Support stand

鎖裝螺絲釘 Screws

車 板

控速器 Speed control unit

吊桿 Pedal rod
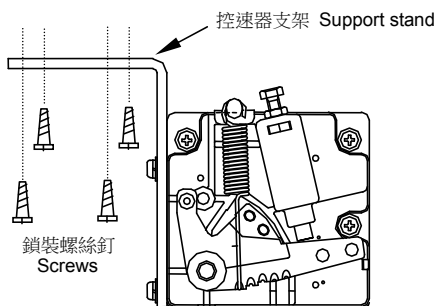
鎖裝螺絲釘時，需以螺絲起子全程鎖裝。

Always use screwdriver to tightly secure screws
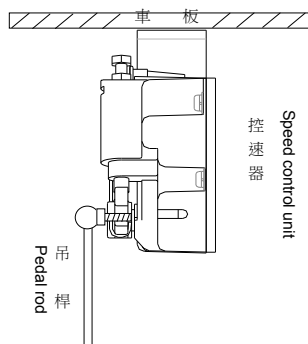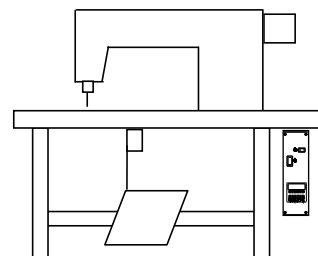
(4).控速器前/後踏力量的調整 ：

Adjust the speed control unit:
控速器各部位名稱 ：如右圖示
Components of the speed control unit: see figure

A：前踏力量彈簧 / Spring for toeing forward force adjustment

B：後踏力量的調整螺栓 / Bolt for heeling backward force adjustment

C：踏板旋臂 / Treadle / Pedal arm

D：腳踏板吊桿 / Pitman Rod for Treadle / Pedal

輕 decrease   重 increase

B
C
D
A

輕 decrease   重 increase

2
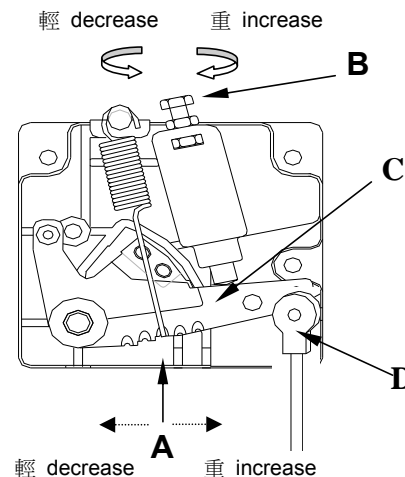
	調整需求 Term of adjustment	調整結果 Adjustment result
1	踏板前踏力量的調整 Toeing forward force adjustment	當彈簧 A 愈向右側勾時，表示力量愈重 Spring A move to right = force increased 當彈簧 A 愈向左側勾時，表示力量愈輕 Spring A move to left = force decreased
2	踏板後踏力量的調整 Heeling backward force adjustment	當螺栓 B 愈向上⟲時，則後踏力量愈輕 Bolt B turn ⟲ = force decreased 當螺栓 B 愈向下⟳時，則後踏力量愈重 Bolt B turn ⟳ = force increased
3	踏板行程長短的調整 Treadle stroke adjustment	當吊桿 D 向右側孔鎖裝時，表示行程較長 Rod D secure at right = stroke is longer 當吊桿 D 向左側孔鎖裝時，表示行程較短 Rod D secure at left = stroke is shorter

各部件的安裝 Installing each component

MC裝置的安裝 Installing the MC device

⚠ 在安裝MC裝置時，請務必關閉電源，並將插座上的電源插頭拔下，然後請專門的技術人員進行操作。
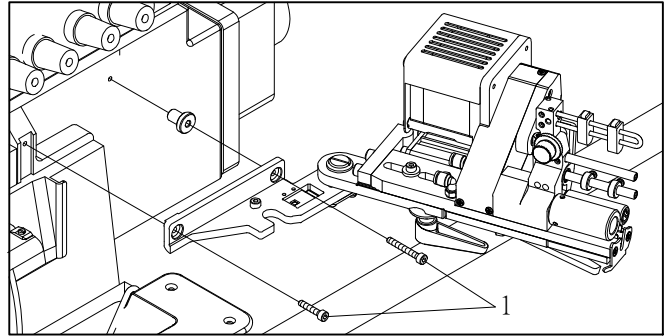
Always turn off the power,unplug the machine from the outlet and then only well-qualified technicians should install the MC device.

請參照右圖，將帶有MC裝置的托架，用螺絲 1 安裝到縫紉機車頭上。

Install the bracket with the MC device on the machine head with screws 1 as shown in the illustration.

流量調節閥的安裝 Installing the flow control valve device

⚠ 在安裝流量調節閥時，務必將電源開關及空氣壓縮機所供給的壓縮空氣切斷之後，然後請專門的技術人員進行操作。

Always turn off the power and air compressor first and then only well-qualified technicians should installing the flow control valve device.
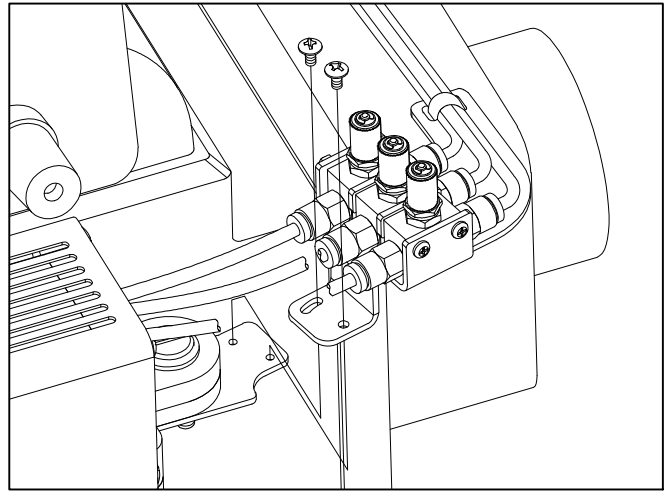
壓布腳的安裝 Installing the press foot

⚠ 在安裝壓布腳時，請務必關閉電源，並將插座上的電源插頭拔下，然後請專門的技術人員進行操作。

Always turn off the power,unplug the machine from the outlet and then only well-qualified technicians should install the press foot.

操作盒的安裝 Installing the operation panel

⚠ 在安裝操作盒時，請務必關閉電源，並將插座上的電源插頭拔下，然後請專門的技術人員進行操作。

Always turn off the power,unplug the machine from the outlet and then only well-qualified technicians should install the operation panel.

1. 請將操作面板 2 安裝到托架 3 上。

1. Install the operation panel 2 on bracket 3.

2. 再請將操作面板 2 和托架 3 安裝到車板上。

2. Mount the operation panel 2 and bracket 3 on the machine table.

各部件的安裝 Installing each component

下吹風裝置的安裝 Installing the under air jet hole device
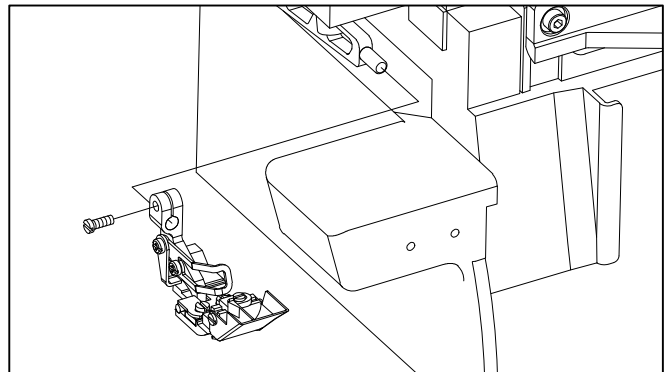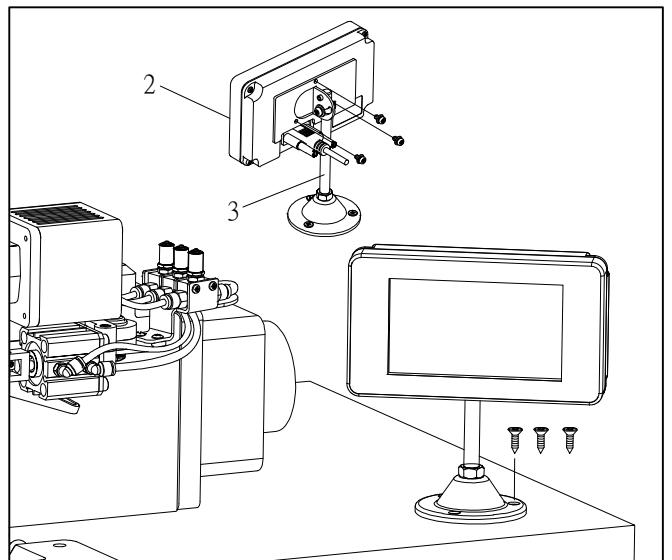
⚠ 在安裝下吹風裝置時，務必將電源開關及空氣壓縮機所供給的壓縮空氣切斷之後，然後請專門的技術人員進行操作。

Always turn off the power and air compressor first and then only well-qualified technicians should installing the under air jet hole device.

送帶吹氣孔
The air jet hole for feeding tape.
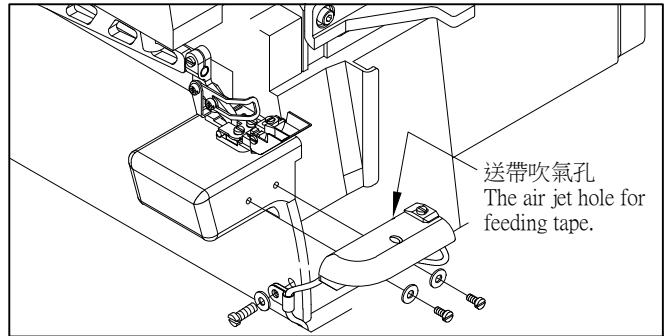
鬆線裝置的安裝 Installing the thread release device

⚠ 在安裝鬆線裝置時，請務必關閉電源，並將插座上的電源插頭拔下，然後請專門的技術人員進行操作。

Always turn off the power,unplug the machine from the outlet and then only well-qualified technicians should install the thread release device.

抬壓腳氣缸裝置的安裝 Installing the PL device

⚠ 在安裝抬壓腳氣缸裝置時，務必將電源開關及空氣壓縮機所供給的壓縮空氣切斷之後，然後請專門的技術人員進行操作。

Always turn off the power and air compressor first and then only well-qualified technicians should installing the PL device.

5

各部件的安裝 Installing each component

電磁閥與調壓過濾器的安裝 Installing the solenoid valve / filter regulator

⚠ 在安裝電磁閥與調壓過濾器時，務必將電源開關及空氣壓縮機所供給的
壓縮空氣切斷之後，然後請專門的技術人員進行操作。

Always turn off the power and air compressor first and then only well-qualified
technicians should installing the solenoid valve / filter regulator.

⚠ 壓縮空氣的供給一定要在風壓管線確實接好後進行。

Connect other lines first before connecting to the air source (air compressor).

請參照右圖，將電磁閥與調壓過濾器安裝在車板的下方。

Install the solenoid valve / filter regulator on the underside of the machine table.

電磁閥
SOLENOID VALVE

調壓過濾器
filter regulator

空壓集屑裝置的安裝 Installing the venturi device

⚠ 在安裝空壓集屑裝置時，務必將電源開關及空氣壓縮機所供給的壓縮
空氣切斷之後，然後請專門的技術人員進行操作。
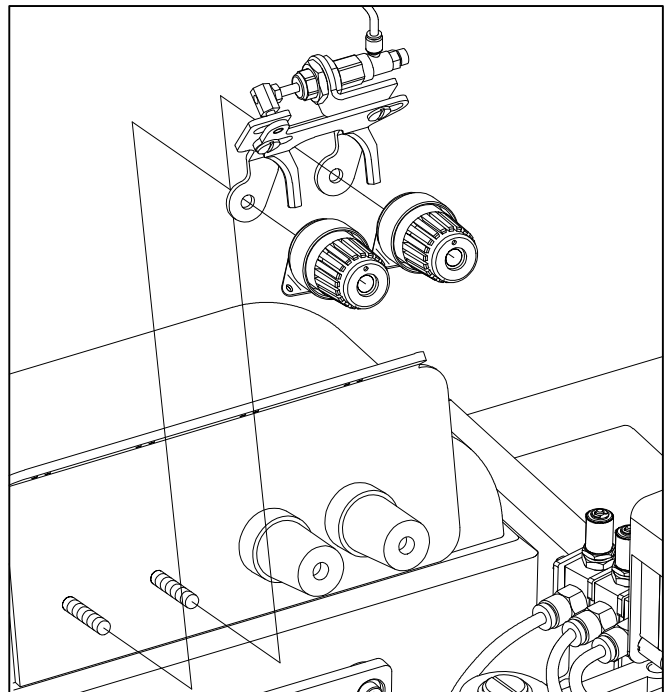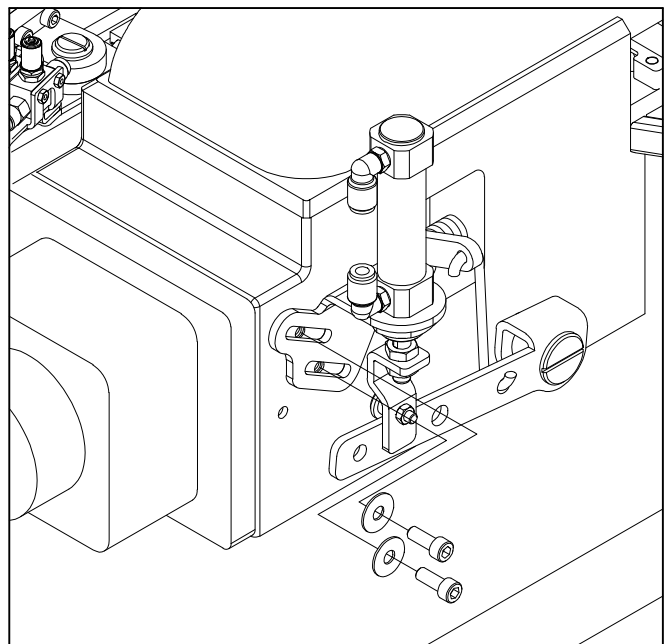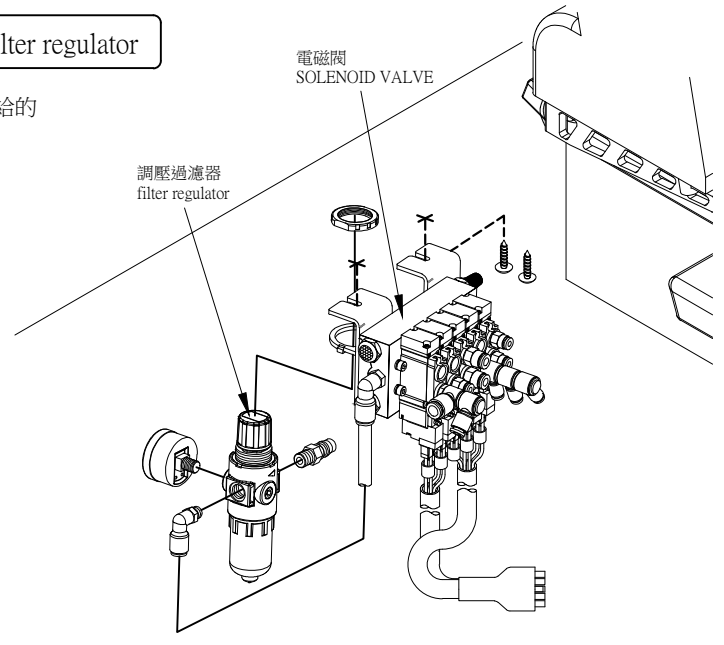
Always turn off the power and air compressor first and then only well-qualified
technicians should installing the venturi device.

請參照下圖，將電磁閥與調壓過濾器安裝在車板的下方。

Install the venturi device on the underside of the machine table.
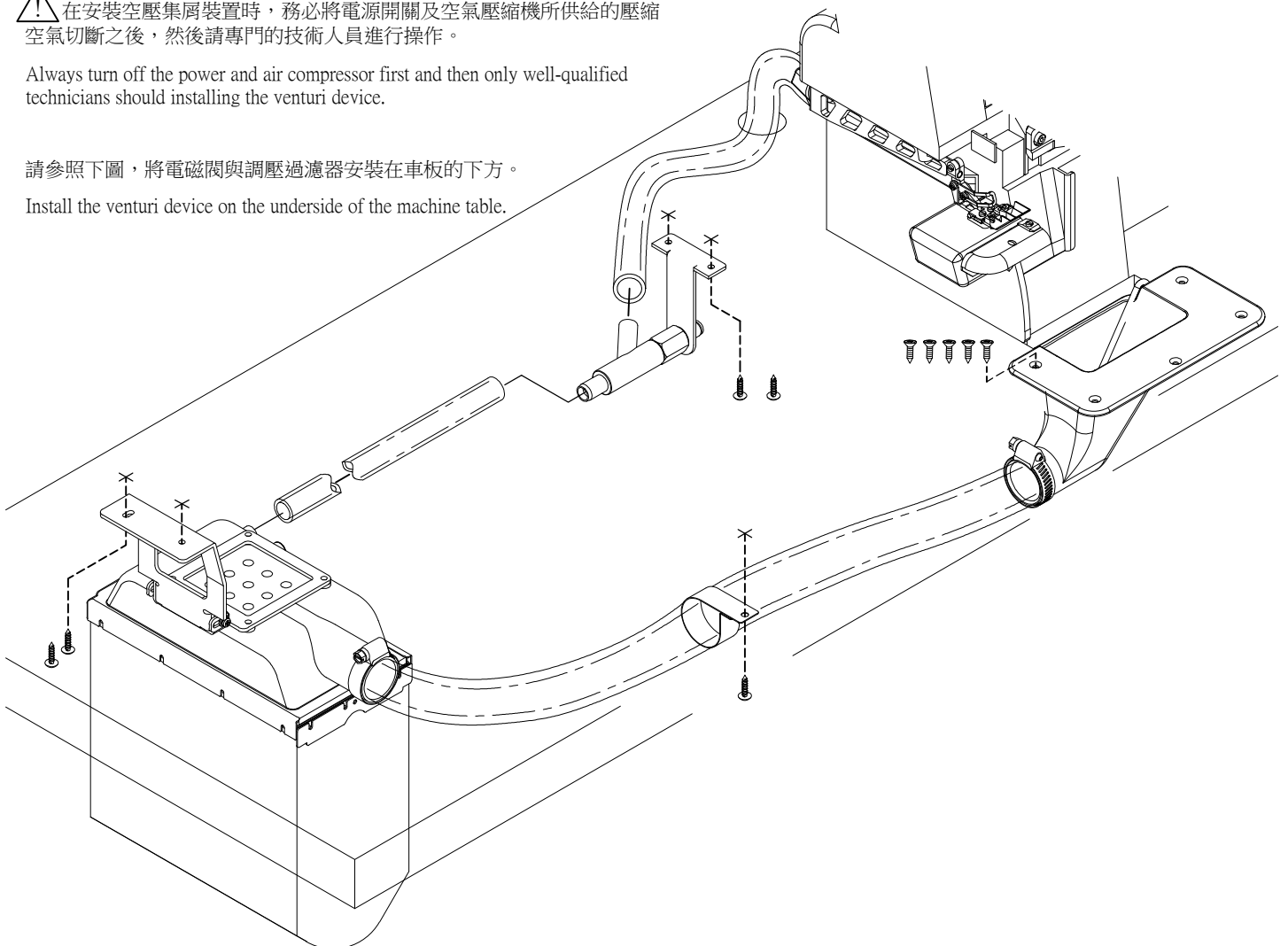
接線圖 Wiring Diagram

⚠ 警告 WARNING

在連接接線時，請務必關閉電源，並將插座上的電源插頭拔下，然後請專門的技術人員進行操作。
Always turn off the power,unplug the machine from the outlet and then only well-qualified technicians should connect the cords.

請確實連接地線，否則當您觸摸i70L控制箱和/或機器時可能會觸電，請注意。
Connect the earth wire correctly. Otherwise you may get an electric shock when you touch the i70L control box and/or the machine.

若接線未正確連接，可能引起錯誤的動作而產生危險。為了防止損壞縫紉機應充分進行確認檢查。
Failure to connect properly may cause hazardous faulty operations and damage to the machine.

電源線
POWER LINE

步進馬達
STEPPING MOTOR

觸控式操作盒
TOUCH PANEL OPERATION PANEL

安全開關
SAFETY SWITCH

段數顯示器
SECTION INDICATOR

伺服馬達
SERVO MOTOR

控速器
SPEED CONTROL UNIT

電磁閥
SOLENOID VALVE

DC12V 50mA

PULSE MOTOR

M

M

SAFETY SWITCH

7. SEGMENT

KNEE SWITCH

SEWING MACHINE

OPTION

膝動開關
KNEE SWITCH
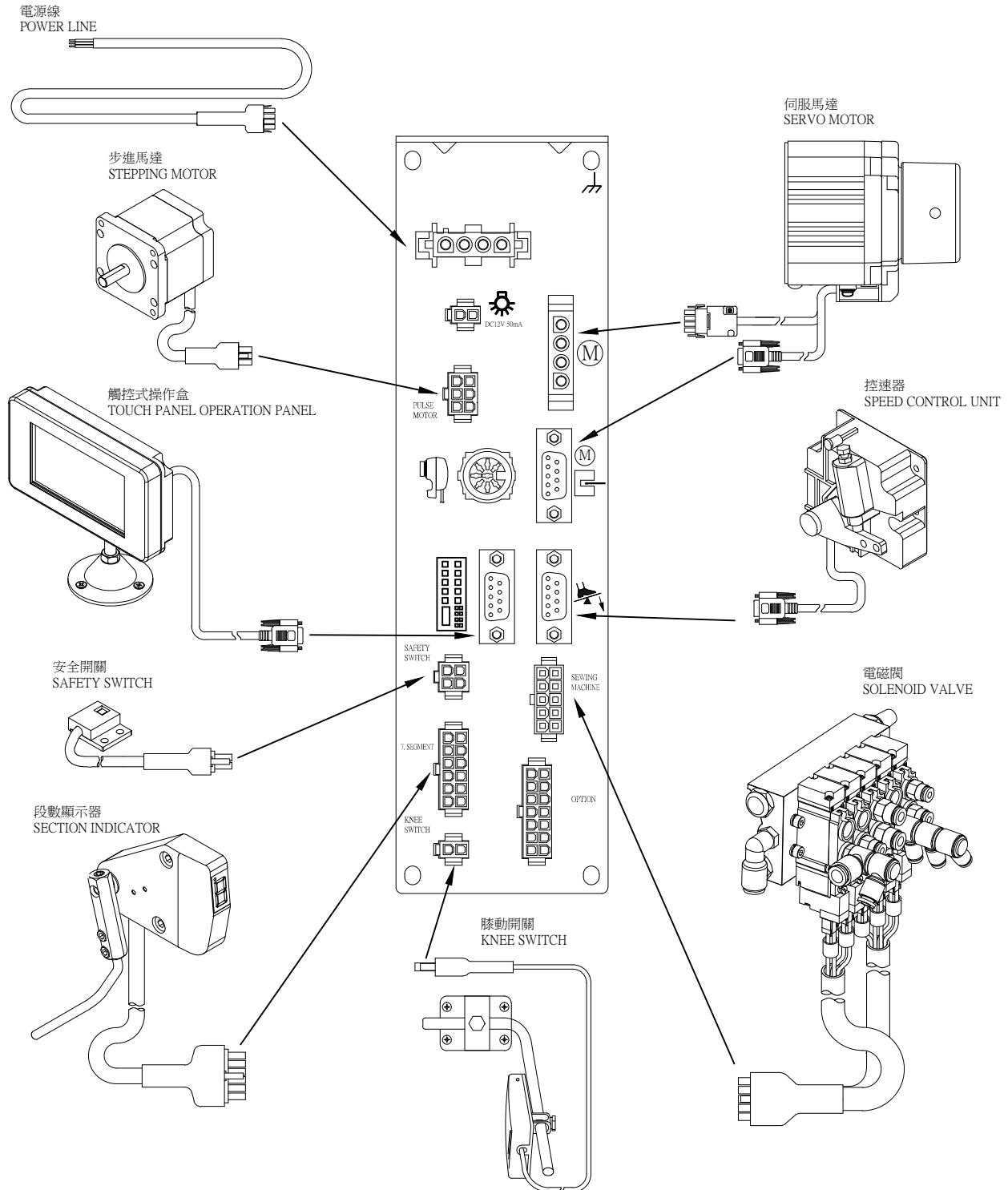
風壓管的連接 Connecting air lines

⚠ 注意 CAUTION

⚠ 在連接風壓管管線時，務必將電源開關及空氣壓縮機所供給的壓縮空氣切斷之後，請專門的技術人員進行操作。
Always turn off the power and air compressor first and then only well-qualified technicians should connect the air lines.

⚠ 壓縮空氣的供給一定要在風壓管線確實接好後進行。
Connect other lines first before connecting to the air source (air compressor).

⚠ 若管線接線未正確連接，可能引起錯誤的動作而產生危險。為了防止損壞縫紉機應充分檢查確認管線的連接。
Failure to connect air lines properly may cause hazardous faulty operations.
To prevent accidents and damage to the machine, check all the air lines for correct piping.

● To connect air tube 1 to joint 2, insert the tube completely to the inlet depth and make sure the tube can not be disconnected by pulling it.

● To disconnect air tube 1, press release ring 3 toward the arrow and pull it out.
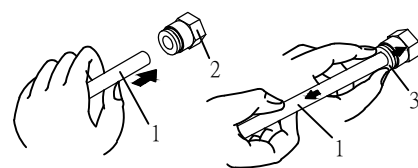
請參照下圖，進行風壓管管線得連接。
Connect the lines by referring to the illustration.

φ4mm
φ6mm
φ8mm

Air source
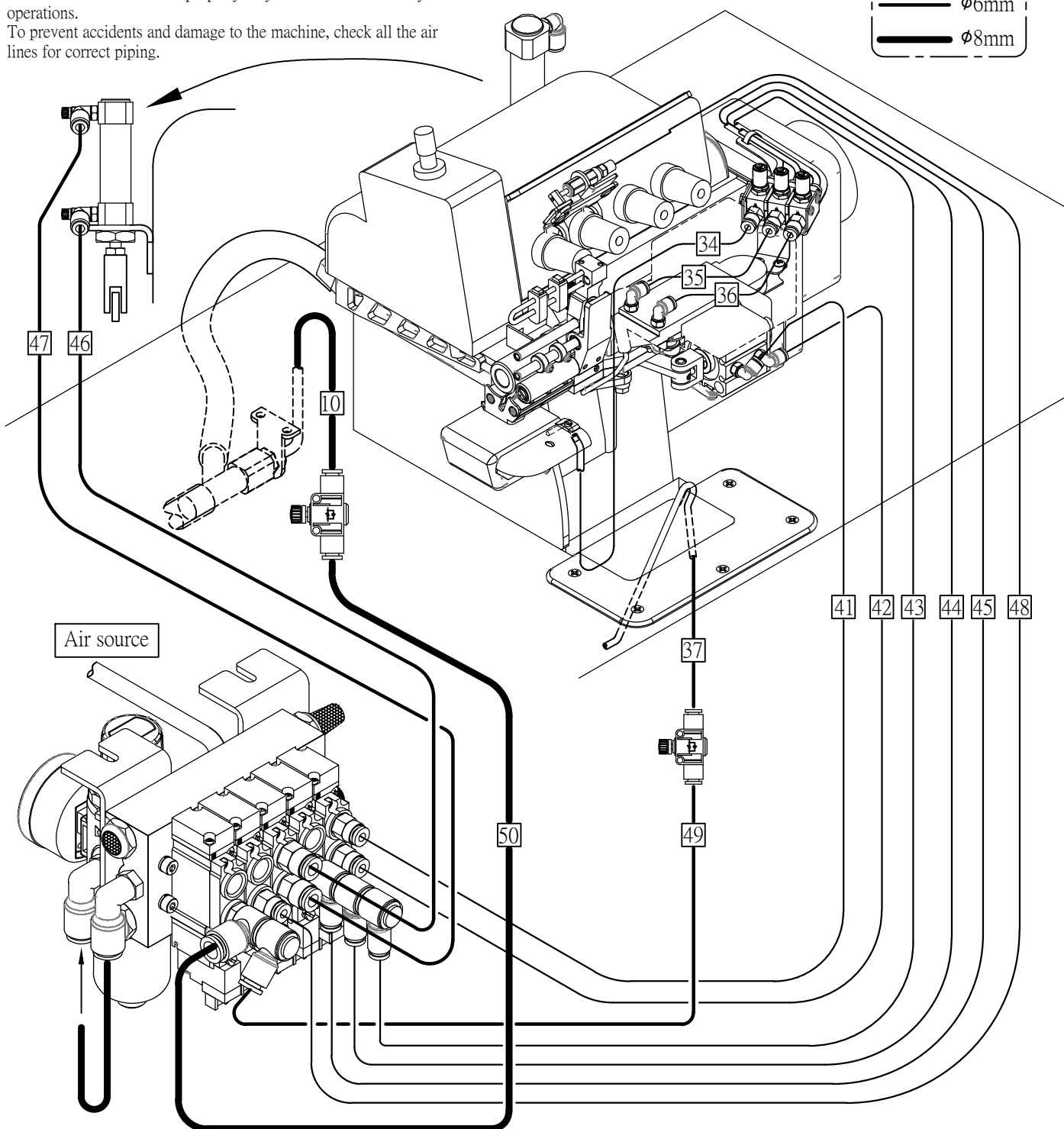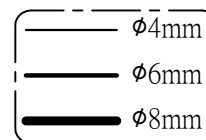
調壓過濾器的調節 Adjusting the filter regulator

(1) 空氣壓力的調節 Adjusting air pressure

向上拉動調壓過濾器的旋鈕 1，則會聽到『喀嚓』一聲，旋鈕稍微向上彈起。這時請轉動旋鈕 1，將空氣壓力調節到 0.5Mpa (5kgf/cm²)。

Pull up knob 1 on filter regulator unit it clicks.
Then set the air pressure at 0.5Mpa (5kgf/cm²).

● 向(+)方向旋轉，壓力增加。

  Turning 1 in the (+) direction increasees the air pressure.

● 向(−)方向旋轉，壓力增加。

  Turning 1 in the (−) direction increasees the air pressure.

(2)積水的排出

當積水深度到達擋蓋 2 的位置之前，請按壓排水按鈕 3 將積水排出。

Drain the filter regulator before collected drainage reaches the level 2 by pressing button 3.

⚠ 注意 CAUTION

調壓過濾器的清掃以及積水的排除應定期進行。積水過多會造成氣壓缸的故障。

Be sure to drain periodically.Otherwise, drainage will flow into solenoid valve and/or air cylinder, causing trouble.

排水時積水與壓縮空氣會一起向外沖出，排水時請格外注意。

Note that drainage and air spout out downward.
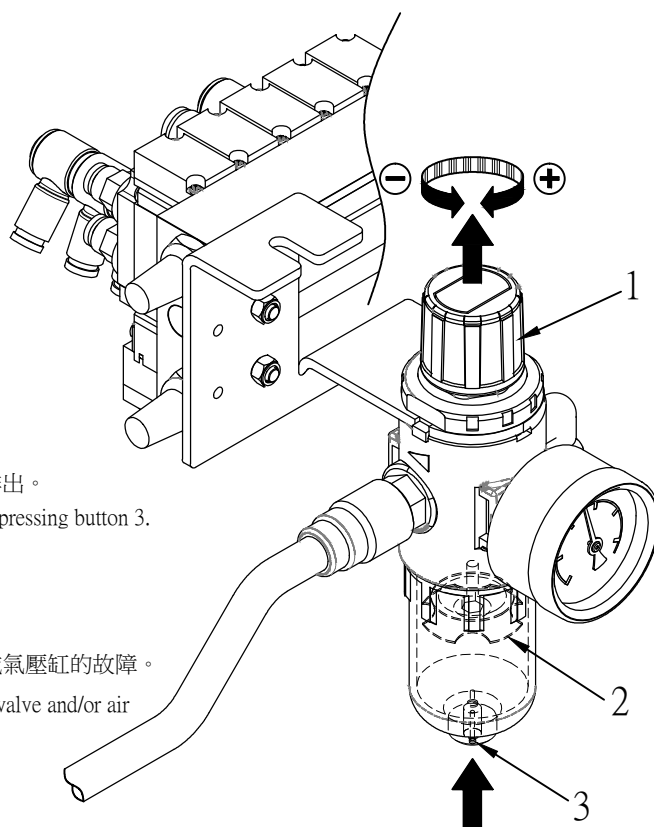
放入鬆緊帶的正確位置 The right position for inserting elastic tape

鬆緊帶
Elastic Tape

鬆開螺絲可調整主體支架的位置
The adjustable screw for main body.

前後 Rear & Front

左右 Right & Left

記號
Mark

送帶吹氣孔
The air jet hole for feeding tape.
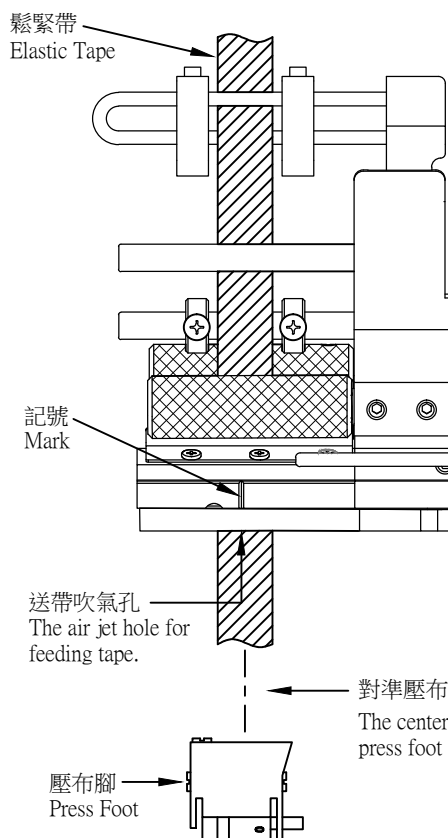
對準壓布腳送帶口的中央
The center of inserting slot of press foot should meet the Mark.

壓布腳
Press Foot

記號(下方為噴氣孔)
Mark(The air jet hole is under the Mark)
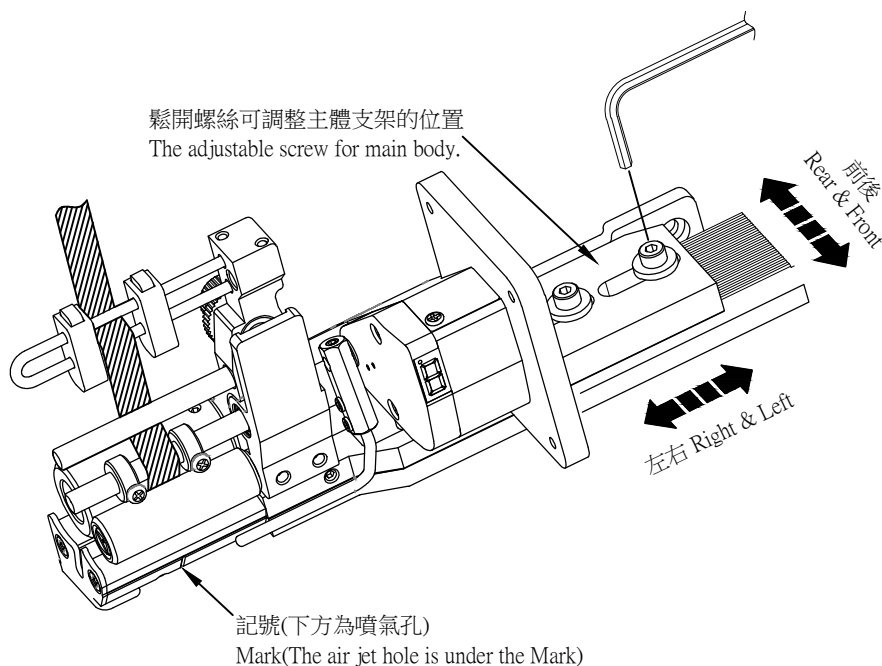
主機的記號必需調整對準壓步腳送帶口的中央。
(送帶用噴氣孔是在記號的下方)
Make sure the center of inserting slot of pressure foot should meet the mark.(The air jet hole is under the mark.)

記號說明 Mark description：

選擇性配件
Option parts

選擇性配件請告知針車廠牌型號
Option parts, please indicate sewing
machine model NO.

四線用
For 4 thread

三線用
For 3 thread

(8~26mm)

(3.5~13mm)

MC2-38 送料機零件圖 MC2-38 Device part list

MC2-38 送料機零件圖 MC2-38 Device part list

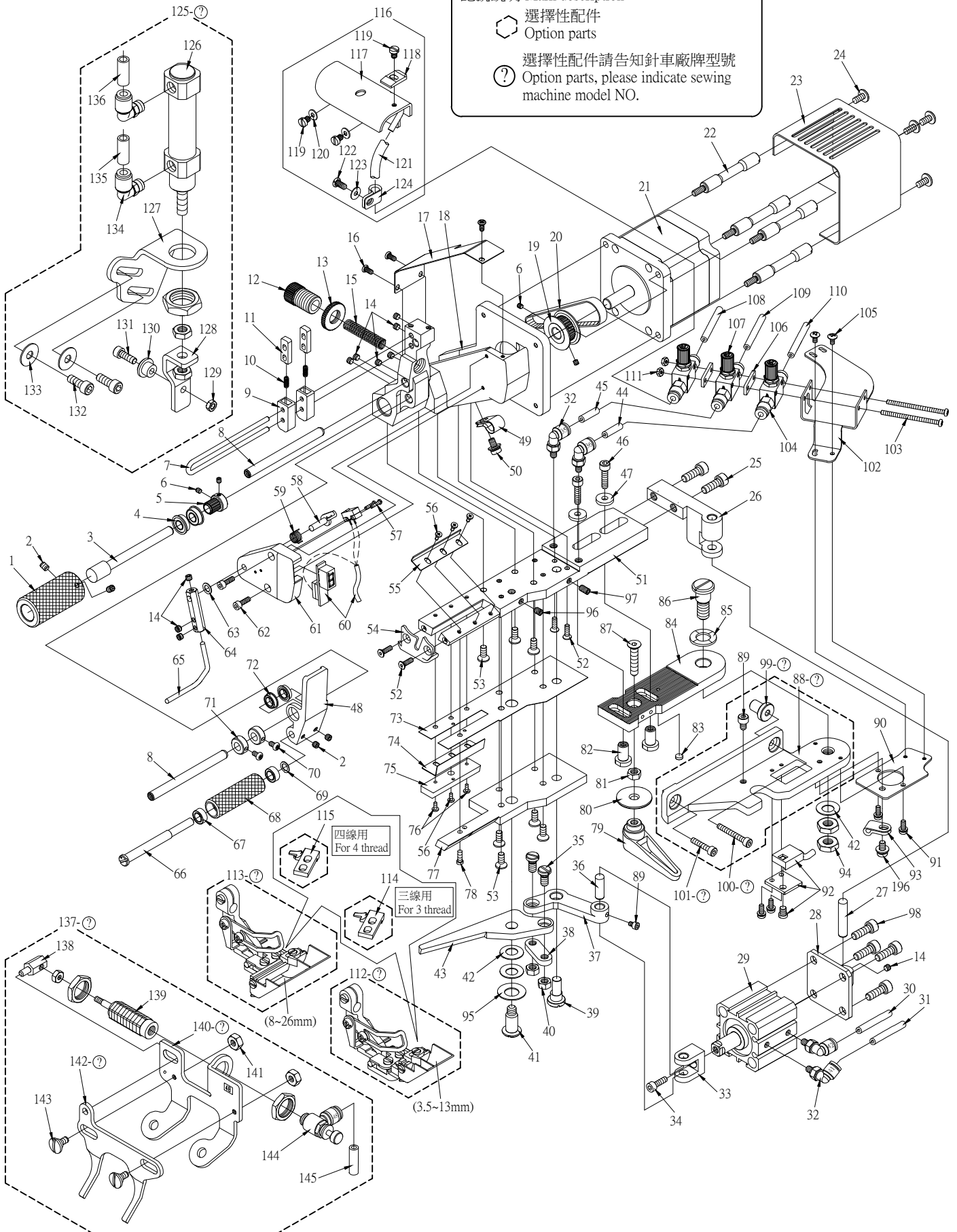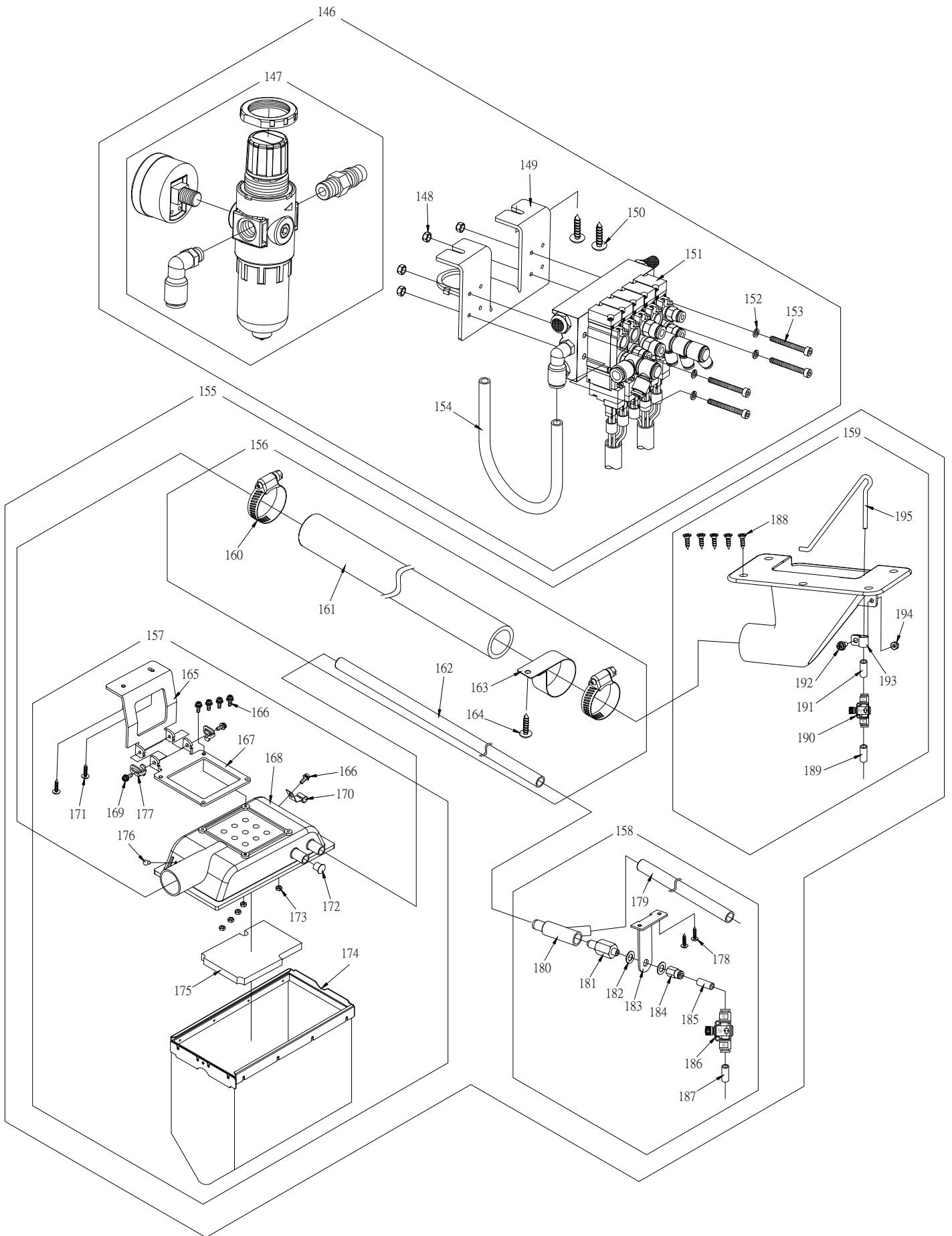| NO.	訂購碼 Order Coder	用量 Qty.	說明 Description	NO.	訂購碼 Order Coder	用量 Qty.	說明 Description
1	313PY8031	1		63	333WP1060	1	φ8*φ4.8*1t
2	331SS1180	4	M4*0.7P*5L	64	313FDD401	1	
3	313FDDF50	1		65	313FDD281	1	
4	313BR4090	2		66	313FDD251	1	
5	312PY1061	1		67	313BR4080	2	
6	331SS1200	4	M3*0.5P*3L	68	313PY8041	1	
7	313FDD201	1		69	333WP1640	1	φ8*φ5.2*0.5t
8	313FDD261	2		70	331SP1530	2	M3*0.5P*4L
9	315FDD180	2		71	313FDD290	2	
10	33BLS2017	2		72	313BR4020	2	
11	315FDD190	2		73	333PK1130	1	
12	313FDD310	1		74	313FDDG30	1	
13	313FDD300	1		75	313FDDG40	1	
14	331SS1320	5	M4*0.7P*3L	76	331SP5180	2	M2*0.4P*9L
15	33BMPC120	1		77	313FDD441	1	
16	331SP5160	3	M3*0.5P*6L	78	331SP5190	1	M3*0.5P*8L
17	313FDDF60	1		79	33ZFDD080	1	
18	312FDD190	1		80	313FDDG50	1	
19	312PY1051	1		81	332NO1400	1	M5*0.8P*4t
20	316BT1051	1	(B89MXL) 89齒	82	313FDD321	2	
21	2MCD3ZSMB09001	1		83	324MGU010	1	φ5*1.5t
22	331SC1340	4	φ8*50L*M4*0.7t*10L	84	313FDD371	1	
23	313FDDD11	1		85	33BWA1020	1	φ14.5*φ10.5*2H*0.3t
24	331SP1B90	2	M4*0.7P*8L	86	331SP5081	1	
25	331HC1270	2	M5*0.8P*20L	87	331SN1180	1	M5*0.8P*25L
26	313FDDF70	1		88	313FDD24*	1	依不同廠牌型號選用 According to different brand models selected
27	313FDDF80	1	φ6*29L	89	331HC1760	2	M4*0.7P*6L
28	313FDD211	1		90	313FDDG60	1	
29	33DCLD220	1	JD 25*15	91	331SP1930	4	M3*0.5P*8L
30	2MCD58PLF09005	1	＃42：＃42	92	2MCDSW030	1	
31	2MCD58PLF09004	1	＃41：＃41	93	33CHB1050	1	
32	33DSPL090	4	φ4；M5*0.8P	94	332NO1390	2	M8*1.25P*4.5t
33	313FDDG00	1		95	333WP1150	1	φ15*φ8*1t
34	331HC1100	1	M5*0.8P*10L	96	331SS1370	1	M4*0.7P*6L
35	331SP5091	2		97	331SS1380	1	M4*0.7P*8L
36	313FDDF81	1	φ6*18L	98	331HC1640	4	M6*1.0P*15L
37	313FDDG10	1		99	313FDDG9*	1	依不同廠牌型號選用 According to different brand models selected
38	313FDD181	1		100	331HC****	1	依不同廠牌型號選用 According to different brand models selected
39	313FDDF90	1		101	331HC****	1	依不同廠牌型號選用 According to different brand models selected
40	332NO5010	2	M5*0.8P*5t	102	313FDDG70	1	
41	331SP5101	1		103	331SP1980	2	M3*0.5P*45L
42	33BWA1190	3	φ16*φ8.2*0.6t	104	33DCUF190	6	
43	313FDD431	1		105	331SP1C60	2	M3*0.5P*4L
44	2MCD58PLF09015	1	＃36：＃36	106	313FDDG80	2	
45	2MCD58PLF09014	1	＃35：＃35	107	33DJVA040	3	
46	331HC1720	2	M4*0.7P*16L	108	2MCD58PLF09018	1	配管標誌＃45：＃45
47	333WP1500	2	φ12*φ4.35*2t	109	2MCD58PLF09017	1	配管標誌＃44：＃44
48	313FDD251	1		110	2MCD58PLF09016	1	配管標誌＃43：＃43
49	33CHB1030	1		111	332NO1340	2	M3*0.5P*2.3t
50	331SP1130	1	M4*0.7P*8L	112	2MCDPF201*	1	依不同廠牌型號選用 According to different brand models selected
51	313FDD422	1		113	2MCDPF202*	1	依不同廠牌型號選用 According to different brand models selected
52	331SN1190	4	M3*0.5P*10L	114	43ZFDD051	2	三線使用
53	331SN1140	7	M4*0.7P*10L	115	43ZFDD050	2	四線使用
54	313FDD191	1		116	2MCDTR021	1	
55	313FDDG21	1		117	313FDDD60	1	
56	331SP5170	4	M2*0.4P*5L	118	313FDDE10	1	
57	331SP2330	2	M2*0.4P*8L	119	331SP5130	3	M3*0.5P*5L
58	313FDD171	1		120	333WP1570	2	φ6*φ3.2*0.5t
59	33BLS4020	1		121	2MCD58PLF09013	1	＃34：＃34
60	2MCDSPW0021	1		122	331SP5120	1	M3*0.5P*8L
61	312FDD200	1		123	333WP1600	1	φ8*φ4*1t
62	331HC1660	2	M3*0.5P*10L	124	33CHB1050	1	

MC2-38 送料機零件圖 MC2-38 Device part list

NO.	訂購碼 Order Coder	用量 Qty.	說明 Description
125	2MCDPF10**	1	依不同廠牌型號選用 According to different brand models selected
126	33DCLD120	1	
127	313SMM260	1	
128	313SMM170	1	
129	332NO5010	1	M5*0.8P*5t
130	313SMM190	1	
131	331HC1230	1	M5*0.8P*15L
132	331HC1090	2	M6*1.0P*16L
133	333WP1130	2	φ19*φ6.7*1t
134	33DSPL010	2	
135	2MCD58PLF08012	1	＃46：＃46
136	2MCD58PLF08013	1	＃47：＃47
137	2MCDTSY0***	1	依不同廠牌型號選用 According to different brand models selected
138	313FDD140	1	
139	33DCUF180	1	
140	313FDDE3*	1	依不同廠牌型號選用 According to different brand models selected
141	332NO1300	2	M3*0.5P*2.6t
142	313FDDE2*	1	依不同廠牌型號選用 According to different brand models selected
143	331SP5110	2	M3*0.5P*8.6L
144	33DJSC040	1	
145	2MCD58PLF09009	1	＃48：＃48
146	2MCD3DALS51011A	1	
147	2VDAR04	1	
148	332NO1060	4	M4*0.7P
149	313IRF140	1	
150	331ST1100	2	
151	2MCD3DALS51001A	1	φ6*29L
152	334WS1020	4	φ7.1*φ4.1*1t
153	331HC1460	4	M4*0.7P*35L
154	2MCD58PLF07001	1	
155	2MCDVD7050P02A	1	
156	2MCDACC001	1	
157	2MCDFBA01	1	
158	2MCDVEN002A	1	
159	2MCDFUN002A	1	
160	339HSE030	2	
161	316PT6040	1	L=800mm
162	315PT1020	1	L=800mm
163	339CB1060	1	
164	331ST1100	1	
165	313SMM520	1	
166	331SP1160	5	
167	313SMM530	1	
168	315VDR040	1	
169	331SP1830	2	
170	313SMM155	1	
171	331ST1100	2	
172	33CHY2090	1	
173	332NO1050	5	M4*0.7P*3.2t
174	33ZSMD04A	1	
175	35ZSMR230	1	
176	33ZSMN220	1	
177	313SMM540	2	
178	331ST1100	2	
179	315PT1020	1	L=250mm
180	33DALS031	1	
181	33DALS020	1	
182	333WP1180	2	
183	313IRF060	1	
184	33DSQG010	1	
185	2MCD58PLF07005	1	＃10：＃10
186	33DJVA030	1	＃50：＃10
187	2MCD58PLF07006	1	＃50：＃50
188	331ST1070	5	
189	2MCD58PLF08014	1	＃49：＃49
190	33DJVA010	1	＃49：＃37
191	2MCD58PLF08011	1	＃37：＃37
192	331SP1160	1	
193	33CHB1050	1	
194	332NO1050	1	M4*0.7P*3.2t
195	315VDR050	1	
196	331SP1160	1	M4*0.7P*12L

MC2-64 送料機零件圖 MC2-64 Device part list

記號說明 Mark description：

⬡ 選擇性配件
Option parts

⑦ 選擇性配件請告知針車廠牌型號
Option parts, please indicate sewing
machine model NO.

四線用
For 4 thread

三線用
For 3 thread

(38~64mm)

MC2-64 送料機零件圖 MC2-64 Device part list

146

147

148

149

150

151

152

153

154

155

156

157

158

159

160

161

162

163

164

165

166

166

167

168

169

170

171

172

173

174

175

176

177

178

179

180

181

182

183

184

185

186

187

188

189

190

191

192

193

194

195

MC2-64 送料機零件圖 MC2-64 Device part list

NO.	訂購碼 Order Coder	用量 Qty.	說明 Description	NO.	訂購碼 Order Coder	用量 Qty.	說明 Description
1	313PY8032	1		63	333WP1060	1	φ8*φ4.8*1t
2	331SS1180	4	M4*0.7P*5L	64	313FDD401	1	
3	313FDDF50	1		65	313FDD281	1	
4	313BR4090	2		66	313FDD252	1	
5	312PY1061	1		67	313BR4080	2	
6	331SS1200	4	M3*0.5P*3L	68	313PY8042	1	
7	313FDD203	1		69	333WP1640	1	φ8*φ5.2*0.5t
8	313FDD262	2		70	331SP1530	2	M3*0.5P*4L
9	315FDD180	2		71	313FDD290	2	
10	33BLS2017	2		72	313BR4020	2	
11	315FDD190	2		73	333PK1131	1	
12	313FDD310	1		74	313FDDG31	1	
13	313FDD300	1		75	313FDDG41	1	
14	331SS1320	5	M4*0.7P*3L	76	331SP5180	3	M2*0.4P*9L
15	33BMPC120	1		77	313FDD442	1	
16	331SP5160	3	M3*0.5P*6L	78	331SP5190	2	M3*0.5P*8L
17	313FDDF60	1		79	33ZFDD080	1	
18	312FDD190	1		80	313FDDG50	1	
19	312PY1051	1		81	332NO1400	1	M5*0.8P*4t
20	316BT1051	1	(B89MXL) 89齒	82	313FDD321	2	
21	2MCD3ZSMB09001	1		83	324MGU010	1	φ5*1.5t
22	331SC1340	4	φ8*50L*M4*0.7t*10L	84	313FDD371	1	
23	313FDDD11	1		85	33BWA1020	1	φ14.5*φ10.5*2H*0.3t
24	331SP1B90	2	M4*0.7P*8L	86	331SP5081	1	
25	331HC1270	2	M5*0.8P*20L	87	331SN1180	1	M5*0.8P*25L
26	313FDDF70	1		88	313FDD24*	1	依不同廠牌型號選用 According to different brand models selected
27	313FDDF80	1	φ6*29L	89	331HC1760	2	M4*0.7P*6L
28	313FDD211	1		90	313FDDG60	1	
29	33DCLD220	1	JD 25*15	91	331SP1930	4	M3*0.5P*8L
30	2MCD58PLF09005	1	＃42：＃42	92	2MCDSW030	1	
31	2MCD58PLF09004	1	＃41：＃41	93	33CHB1050	1	
32	33DSPL090	4	φ4；M5*0.8P	94	332NO1390	2	M8*1.25P*4.5t
33	313FDDG00	1		95	333WP1150	1	φ15*φ8*1t
34	331HC1100	1	M5*0.8P*10L	96	331SS1370	1	M4*0.7P*6L
35	331SP5091	2		97	331SS1380	1	M4*0.7P*8L
36	313FDDF81	1	φ6*18L	98	331HC1640	4	M6*1.0P*15L
37	313FDDG10	1		99	313FDDG9*	1	依不同廠牌型號選用 According to different brand models selected
38	313FDD181	1		100	331HC****	1	依不同廠牌型號選用 According to different brand models selected
39	313FDDF90	1		101	331HC****	1	依不同廠牌型號選用 According to different brand models selected
40	332NO5010	2	M5*0.8P*5t	102	313FDDG70	1	
41	331SP5101	1		103	331SP1980	2	M3*0.5P*45L
42	33BWA1190	3	φ16*φ8.2*0.6t	104	33DCUF190	6	
43	313FDD432	1		105	331SP1C60	2	M3*0.5P*4L
44	2MCD58PLF09015	1	＃36：＃36	106	313FDDG80	2	
45	2MCD58PLF09014	1	＃35：＃35	107	33DJVA040	3	
46	331HC1720	2	M4*0.7P*16L	108	2MCD58PLF09018	1	配管標誌＃45：＃45
47	333WP1500	2	φ12*φ4.35*2t	109	2MCD58PLF09017	1	配管標誌＃44：＃44
48	313FDD251	1		110	2MCD58PLF09016	1	配管標誌＃43：＃43
49	33CHB1030	1		111	332NO1340	2	M3*0.5P*2.3t
50	331SP1130	1	M4*0.7P*8L	112	2MCDPF204*	1	依不同廠牌型號選用 According to different brand models selected
51	313FDD421	1		113	331SP1160	1	M4*0.7P*12L
52	331SN1190	4	M3*0.5P*10L	114	43ZFDD051	2	三線使用
53	331SN1140	7	M4*0.7P*10L	115	43ZFDD050	2	四線使用
54	313FDD191	1		116	2MCDTR021	1	
55	313FDDG21	1		117	313FDDD60	1	
56	331SP5170	7	M2*0.4P*5L	118	313FDDE10	1	
57	331SP2330	2	M2*0.4P*8L	119	331SP5130	3	M3*0.5P*5L
58	313FDD171	1		120	333WP1570	2	φ6*φ3.2*0.5t
59	33BLS4020	1		121	2MCD58PLF09013	1	＃34：＃34
60	2MCDSPW0021	1		122	331SP5120	1	M3*0.5P*8L
61	312FDD200	1		123	333WP1600	1	φ8*φ4*1t
62	331HC1660	2	M3*0.5P*10L	124	33CHB1050	1	

MC2-64 送料機零件圖 MC2-64 Device part list

NO.	訂購碼 Order Coder	用量 Qty.	說明 Description
125	2MCDPF10**	1	依不同廠牌型號選用 According to different brand models selected
126	33DCLD120	1	
127	313SMM260	1	
128	313SMM170	1	
129	332NO5010	1	M5*0.8P*5t
130	313SMM190	1	
131	331HC1230	1	M5*0.8P*15L
132	331HC1090	2	M6*1.0P*16L
133	333WP1130	2	φ19*φ6.7*1t
134	33DSPL010	2	
135	2MCD58PLF08012	1	#46：#46
136	2MCD58PLF08013	1	#47：#47
137	2MCDTSY0***	1	依不同廠牌型號選用 According to different brand models selected
138	313FDD140	1	
139	33DCUF180	1	
140	313FDDE3*	1	依不同廠牌型號選用 According to different brand models selected
141	332NO1300	2	M3*0.5P*2.6t
142	313FDDE2*	1	依不同廠牌型號選用 According to different brand models selected
143	331SP5110	2	M3*0.5P*8.6L
144	33DJSC040	1	
145	2MCD58PLF09009	1	#48：#48
146	2MCD3DALS51011A	1	
147	2VDAR04	1	
148	332NO1060	4	M4*0.7P
149	313IRF140	1	
150	331ST1100	2	φ4.7*19L
151	2MCD3DALS51001A	1	
152	334WS1020	4	φ7.1*φ4.1*1t
153	331HC1460	4	M4*0.7P*35L
154	2MCD58PLF07001	1	
155	2MCDVD7050P02A	1	
156	2MCDACC001	1	
157	2MCDFBA01	1	
158	2MCDVEN002A	1	
159	2MCDFUN002A	1	
160	339HSE030	2	
161	316PT6040	1	L=800mm
162	315PT1020	1	L=800mm
163	339CB1060	1	
164	331ST1100	1	
165	313SMM520	1	
166	331SP1160	5	
167	313SMM530	1	
168	315VDR040	1	
169	331SP1830	2	
170	313SMM155	1	
171	331ST1100	2	
172	33CHY2090	1	
173	332NO1050	5	M4*0.7P*3.2t
174	33ZSMD04A	1	
175	35ZSMR230	1	
176	33ZSMN220	1	
177	313SMM540	2	
178	331ST1100	2	
179	315PT1020	1	L=250mm
180	33DALS031	1	
181	33DALS020	1	
182	333WP1180	2	
183	313IRF060	1	
184	33DSQG010	1	
185	2MCD58PLF07005	1	#10：#10
186	33DJVA030	1	#50：#10
187	2MCD58PLF07006	1	#50：#50
188	331ST1070	5	
189	2MCD58PLF08014	1	#49：#49
190	33DJVA010	1	#49：#37
191	2MCD58PLF08011	1	#37：#37
192	331SP1160	1	
193	33CHB1050	1	
194	332NO1050	1	M4*0.7P*3.2t
195	315VDR050	1	

II. 縫製畫面功能說明 / Function for sewing

Prog	Step	Speed	Stitch	Mode
A	01	55	110	A
06	02	55	110	A ✂
	03	55		M
	04	55	110	A
	05	55	110	A
	06	55	110	A

123

000.3

0123
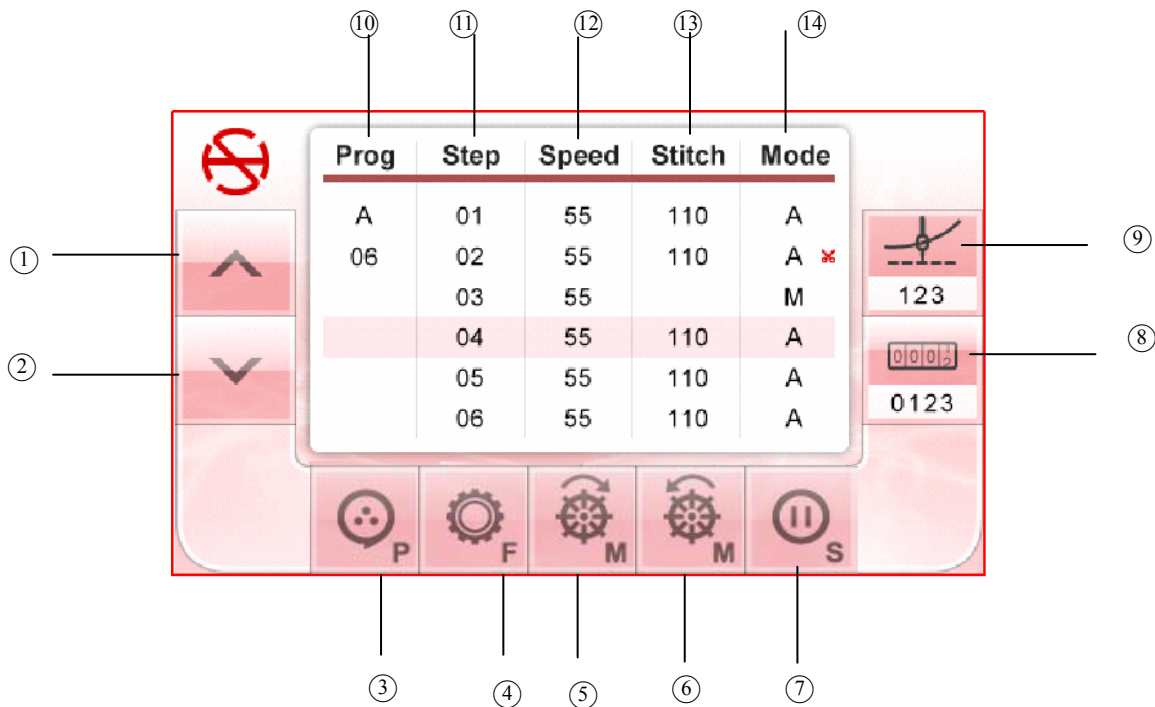
① 銀幕光棒上移鍵 / Shift upward

說明：每按一次上移鍵，光棒則上移一階，利用此鍵可以切換工程段數
Description: moves one step upward when press shift upward key.

② 銀幕光棒下移鍵 / Shift downward

說明：每按一次下移鍵，光棒則下移一階，利用此鍵可以切換工程段數
Description: moves one step when press shift downward key.

③ 進入到編輯畫面鍵 / Enter editing

說明：按此鍵，會切換到編輯畫面，進入後則可依實際需求進行相關設定
Description: enter editing when press this key, process related setting after entered.

④ 進入到參數設定畫面鍵 / Enter parameter setting

說明：按此鍵，會切換到參數設定畫面，進入後則可依實際需求進行相關設定
Description: press the key to enter parameter setting, process related setting after entered.

⑤   送料鍵 ／Forward 說明：按此鍵不放開，正轉送料用步進馬達運轉，按鍵離開

後馬達停止運轉。

Description: press the key to forward the tape.

⑥   退料鍵 ／Reverse

說明：按此鍵不放開，反轉送料用步進馬達運轉，按鍵離開後馬達停止運轉。
Description: press the key to reverse the tape.

⑦   暫停鍵 ／Stop

說明：按此鍵後，馬達停止運轉、輸出裝置停止動作。
Description: press the key to stop the motor and device.

⑧   計數器顯示與按鍵 ／Counter

說明：縫製物計數用，按此鍵可重置計數器。
Description: fabric counting. Press the button to reset the counter.

⑨   針數顯示器 ／Stitches counter

說明：運轉時會顯示每一 Step 之實際車縫針數。
Description: the key display the stitches on each step.

⑩   **Prog**   縫製資料區表示 ／Programming mode

說明：顯示目前選用的工程模式,最多可儲存 27 組(A~Z+[ )不同工程內容的資料
Description: display the model is processing, maximum 27 modes (A~Z+[ ).

⑪   **Step**   縫製段數表示 ／Programming segments

說明：每個工程模式各有 17 個工程段數可供設定
Description: 17 programming segments in each programming mode.

⑫   **Speed**   送料速度(送布量)表示 ／Metering of feeding

說明：顯示每針的送料速度，送料速度範圍為 0~180
Description: display the meter of every stitch, the range of meter is 0 ~ 180.

⑬　**Stitch**　針數表示 / Stitch

說明：顯示每一工程段數所設定之針數

Description: display the set stitches in every programming segment.

⑭　**Mode**　動作模式表示 / Operation mode

說明：顯示每一工程段數的動作模式，動作模式有下列三種：

Description: display operation mode in every program segment, it has 3 modes:

　　　"A"(自動模式):設定針數累計到達時依序進入下一工程段數:

Description: "A"(Auto mode):enter to next segment automatically while the set stitch achieved.

　　　"M"(手動模式):用手動開關進入下一工程段數

　　　"M"(Manual mode):enter to next segment manually.

　"✂"　：該工程段數車縫完成後會自動做切線動作

　　　　trimming automatically after finished the programming segment.

III. 編輯畫面功能說明 / Editing

◎縫製畫面下按 鍵可進入編輯畫面 / Press P key to enter editing
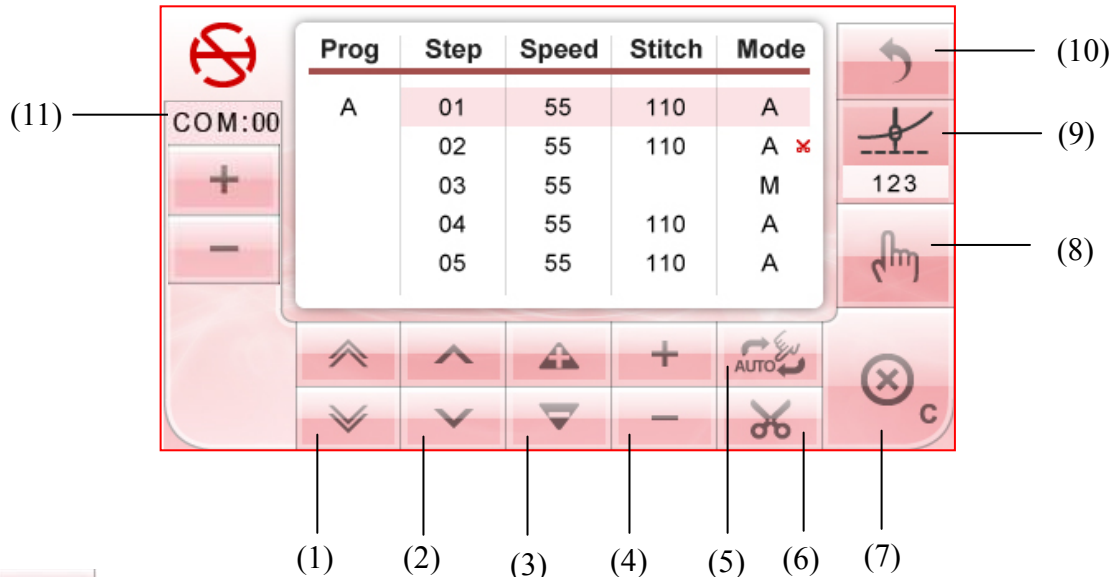
(1)
工程模式切換按鍵 / Programming mode switch key

說明：工程模式存放區共 27 組(A ～ Z+[ )，依實際需求選擇適當之存放區

Description: total 27 zones(A ～ Z+[ ) in programming mode, select the mode you need to store data.

(2)
工程段數切換按鍵 / Programming segment switch key

說明：切換工程段數用，工程段數最多可設定 17 段

Description: for switch programming segment, maximum 17 segments.

(3)
設定送料速度 / Meter feeding setting

說明：每針送料長度的設定，以下是送料量的對照表。

Description: set the feeding meter of every stitch, list below is the reference table.

MC 專用 / For MC

Speed	送料長度(mm) feeding meter	Speed	送料長度(mm) feeding meter
0	0.00	100	2.33
10	0.23	110	2.57
20	0.47	120	2.80
30	0.70	130	3.03
40	0.93	140	3.27
50	1.17	150	3.50
60	1.40	160	3.73
70	1.63	170	3.97
80	1.87	180	4.2
90	2.10		

(4)
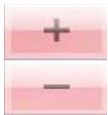
設定車縫針數 / Sewing stitch setting

說明：依需求設定針數，按 " + " 針數往上增加，按 " - " 針數則減少

Description: set the stitch needed, press "+" increment, "-" decrement

(5)

設定該工程段數為自動車縫模式或手動車縫模式 /

Set auto sewing or sewing manually in programming segment

說明：

Description:

"A"(自動):設定針數累計到達時依序進入下一工程段數

"A"(Auto):enter to next segment automatically while the set stitch achieved.

"M"(手動):用手動開關進入下一工程段數

"M"(Manual):enter to next segment manually.

(6)

設定切線模式 / Trimming mode setting

說明：按下此鍵後，在 Mode 欄會顯示剪刀符號，表示此工程段縫製結束後會自動做切線動作。

Description: press the key to show scissors mark in mode, it process trimming after sewing finished.

(7)
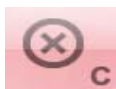
設定工程結束 / Programming ending setting

說明：可設定兩種工程結束的模式,如下:

Description: two modes been selected:

End: 工程結束時自動切線

End: trimming after the ending of programming.

End2: 工程結束時不切線 (ME 專用).

End2: no trimming after the ending of programming (ME dedicated).

Cont: 工程結束時不切線,並自動返回 Step01.

Cont: no trimming after the ending of programming, and automatically return Step01.

(8)　　　　　　　載入針數 / Stitch download

說明：在試縫完成後可將計數器內所顯示的數字(針數)載入 Stitch 欄內作為該工程的針數設
　　　定(注意!原針數會被覆蓋掉)：

Description: the number of stitch after sewing finished can be download to stitch column been new

stitch setting (warning! The original number of stitch will be over written.)

(9)　　　　　　　針數計數器 / Stitch counter

說明：顯示目前針數；在執行"載入針數"時按下針數計數器可以將針數清除為零

Description: display the stitch now processing, the stitch will be zero while press stitch counter key in

executing stitch download.

(10)　　　　　　　返回鍵 / Return

說明：返回縫製畫面

Description: return to sewing

(11)　　　　　　　鬆緊帶張力修正值 / Elastic band correction value

說明：為解決在多段車縫過程中，變換不同工程段落時，鬆緊帶將會產生緩衝段的誤差，
　　　可借由此功能來回拉或補償緩衝段的誤差。

Description: To eliminate the difference at multi-step stitching while elastic band yields carved in
　　　　　　and out, this function serves as a reparation and/or offsetting difference by pull and
　　　　　　push back and forth.

修正方式 / Correction Module:

A. 工程段 1 換到工程段 2 時由工程段 1 修正。

Transit from 1st step to 2nd step: adjust from step one.

B. 工程段 2 換到工程段 3 時由工程段 2 修正。

Transit from 2st step to 3nd step: adjust from step two.

C. 工程段到最後一段返回工程 1 時由最後一段修正。

Rationalize above operation until it goes back to step one: adjust from the last step.

註:鬆緊帶修正值 0=0mm，每增加 1 為 0.35mm。(回拉或補償自動判斷)

Note: Elastic band correction value: 0=0mm，every extend one depicts 0.35mm.(Automatic judgment for pull or push compensation)

| 補償點 Expiation point | 補償點 Expiation point | 補償點 Expiation point | 補償點 Expiation point |

緩衝段 Buffer zone

補償前 Pre-expiation

補償後 Post-expiation

工程段 1 Step1　　工程段 2 Step1　　工程段 3 Step1　　工程段 4 Step1
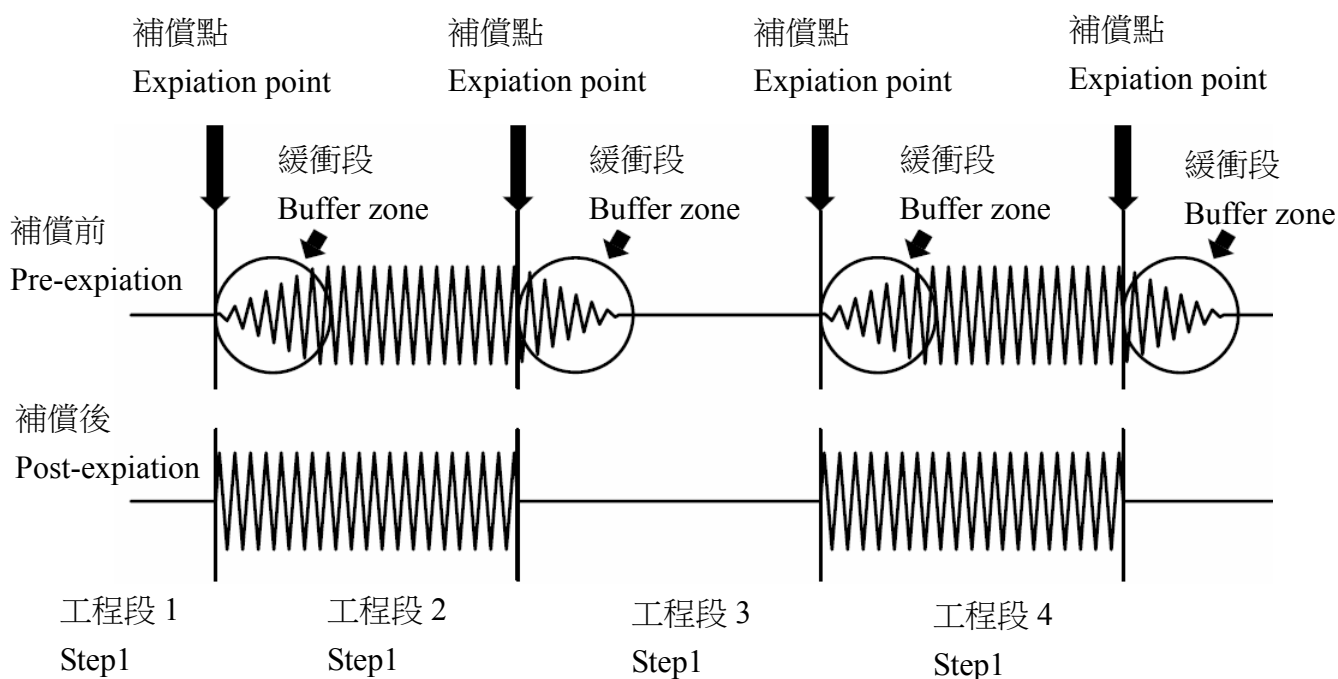
IV.參數設定畫面功能說明 / Parameter setting mode

◎縫製畫面下按 [⚙F] 鍵可以進入參數設定畫面 / Press [⚙F] key to enter parameter setting

No.	Description	Value
01	insert tape	15
02	insert speet	10
03	insert tension	0
04	cutter time	15
05	cut off stitch	10
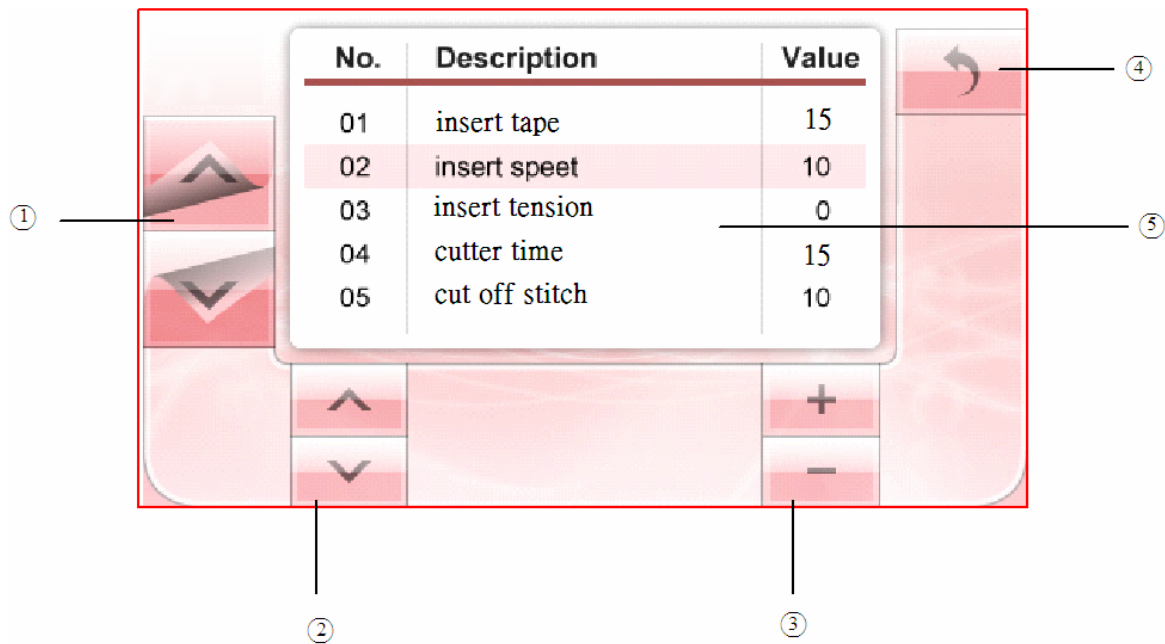
① 參數資料 "上 / 下 " 翻頁鍵 / Flip key for parameter data

說明：每按一次，光棒 "上 / 下"移動五筆參數

Description: press one time to flip 5 parameter data.

② 參數資料 "上 / 下 " 按鍵 / Previous/next parameter data

說明：每按一次，光棒 "上 / 下"移動一筆參數

Description: press one time to move one parameter data.

③ 設定參數值 / Parameter value setting.

說明：設定參數值用

Description: to set the value of parameter.

④ 返回鍵 / Return

說明：返回縫製畫面

Description: return to sewing page.

參數內容 1/3　　Content of parameter 1/3

參數編號 NO.	參數名稱 Name of parameter	參數值 Value	範圍 Range	參數說明 Description					
01	insert tape	10	0~99	送帶長度 meter of feeding, 00=35mm, increases 1=1mm,99=134mm					
02	insert speed	50	0~99	送帶速度設定 feeding speed , 00=50mm,increase =1.9mm,99=238.1mm					
03	insert tension	0	0~99	送料後回拉長度設定 00=0mm,每增加 1=0.35mm,99=34mm meter of pull back after feed, 00=0mm, increase 1=0.35mm,99=34mm					
04	cutter time	15	0~99	切刀時間設定, 00=0.1 秒,每增加 1=0.005 秒,99=0.6 秒 cutter timing, 00=0.1s, increase 1=0.005s,99=0.6s					
05	cut off stitch	15	0~99	切刀後繼續車縫的針數 stitch after cut off					
06	foot up-down	off	on / off	縫製完畢後壓腳自動提升或不自動提升的選擇 to select presser foot lift automatically or not					
07	v - off stitch	10	0~99	始縫時停止吸線頭的針數 sewing stitch after thread suction stop					
08	motor speed	4000	50-7000	最高車縫速度的調整(RPM) Maximum speed adjustments(RPM)					

12　speed com　0　0~9

送料補償:因車速不同所造成的送帶誤差(車速愈快針目會愈大)
Compensation:Tape feeding may be uneven caused by different
sewing speed.(More speed may cause bigger stitch)

轉速 rpm / 補償值 value	3000	4000	5000	6000	7000
*0	00	00	00	00	00
1	00	00	02	02	02
2	00	00	02	02	03
3	00	02	02	02	03
4	00	02	02	03	03
5	00	02	03	03	04
6	02	03	04	05	07
7	02	04	07	09	12
8	02	05	09	13	17
9	02	05	10	14	17

| 16 | buzzer on-off | on | on / off | 蜂鳴器開關　buzzer on /off | | | | | |

參數內容 2/3　　Content of parameter 2/3

參數 編號 NO.	參數名稱 **Name of parameter**	參數值 **Value**	範圍 **Range**	參數說明 **Description**
17	safety switch	off	no / nc / ol / off	安全開關型態: mode of safety switch no:常開式 normally open nc:常閉式 normally close ol:常閉式,但安全開關打開時可當一般拷克車使用 　permanently close, it run as overlock when the safety switch 　be open off:禁用安全開關 disable safety switch
18	restore default	no	no / run	參數切換到 run 時可回復出廠設定值 (需重新開機) return to factory preset value when parameter switch to run (need power on again)
19	lcd auto pwr off	off	on / off	觸控螢幕 1 分鐘後休眠開關 LCD power off one minute later
20	lcd brightness	99	0~99	觸控螢幕背光亮度 set brightness of LCD
24	PL Selection	p	h&p / p / h	H&P:啟用一般踏板和立作業踏板 　　support standard pedal and twinning pedal P: 啟用一般踏板　support standard pedal H: 啟用立作業踏板　support twinning pedal
30	knee sw func	cut1	off/cut1/cut2/step/ PL	膝蓋開關功能切換: function of knee switch off:無效 invalid cut1: 控制 MC 切刀 control MC cutter cut2: 保留 reserved step: 切換工程段數 change program segment PL : 抬壓腳 presser foot lift
31	ext key func	step	off/cut1/cut2/step PL	外部開關功能切換: external key function off:無效 invalid cut1: 控制 MC 切刀 control MC cutter cut2: 保留 reserved step: 切換工程段數 change program segment PL : 抬壓腳 presser foot lift

參數內容 3/3　　Content of parameter 3/3

參數編號 NO.	參數名稱 **name of parameter**	參數值 **value**	範圍 **range**	參數說明 **description**
32*1	cutter2 type	1sol	1sol / 2sol/2sold	ME 切刀用氣壓缸型態: air cylinder for ME 1sol:單動型 one solenoid 2sol:雙動型 double solenoids 2sold:雙動型雙切動作 double cut effected
34	psd on-off	off	off/on1/on2/on3/ KA	車頭型態: code of sewing machine off: MC 拷克車用 / for MC overlock on1: 保留 reserved on2: 保留 reserved on3: 保留 reserved KA:一般三本車模式 for coverstitch
35	psd type	a	a / b	切換不同型態感測器:Sensor selection a:感測器型號 a / type a b:感測器型號 b / type b
39	MC gear ratio	29:14	26:16 / 29:14	MC Device 齒輪比 / MC Device gear ratio
40	pl blow mode	0	0 / 1	壓腳抬起時的吹帶功能開關 When the presser foot is lifted, the blow function switch 0:啟動 Enable 1:關閉 Disable
41	stm dir	cw	cw / ccw	切換送料馬達正反轉(cw/ccw) clockwise/ counter clockwise for feeding motor
42	stm speed cw	3	0~3	馬達送料速度 / feeding speed
43	stm speed ccw	3	0~3	馬達退料速度 / the speed of the return
45	sewing counter	0	0 ~ 9999	縫製計數器 / sewing counter

V. 測試畫面功能說明 / Function test mode

◎在縫製畫面下依序按 [^] → [v] → [🚫] 圖示後將會進入測試畫面,如下:

◎In sewing mode, press [^] → [v] → [🚫] icon sequentially to enter function test mode.
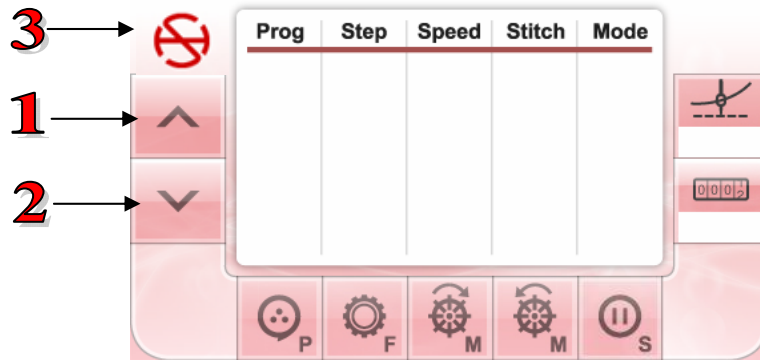
測試畫面 / Function test mode:

	押腳功能測試鍵		蜂鳴器測試鍵
	Presser foot test		Buzzer test
	MC 剪線功能測試鍵		步進馬達功能測試鍵
	MC cutter test		Stepping motor test
	鬆線功能測試鍵		返回縫製畫面
	Tension test		Return to sewing mode
	前吸功能測試鍵		保留
	Front suction test		Reserved
	後吸功能測試鍵		
	Rear suction test		

VI.操作說明(中文) / Operation guide(Chinese)

MC 範例 1.單一工程段數車縫內衣的單一開口,手動切線,送料速度 55

Step	Speed	Stitch
01	55	-
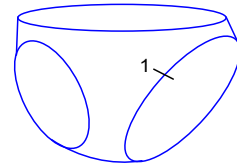
步驟 1.在縫製畫面按下 ⊙ P 進入到編輯畫面

步驟 2. 將 Step 01 的 Speed 欄設定為 55

步驟 3. 按 AUTO 鍵將 Step 01 的 Mode 欄設定為"M"

步驟 4. 確認 Step 02 的 Speed 欄設定為"end",若 Step 02 的 Speed 欄不是"end",則移動光棒到到

Step 02,再按 ⊗ c 鍵設定 Speed 欄為"end",如下圖:
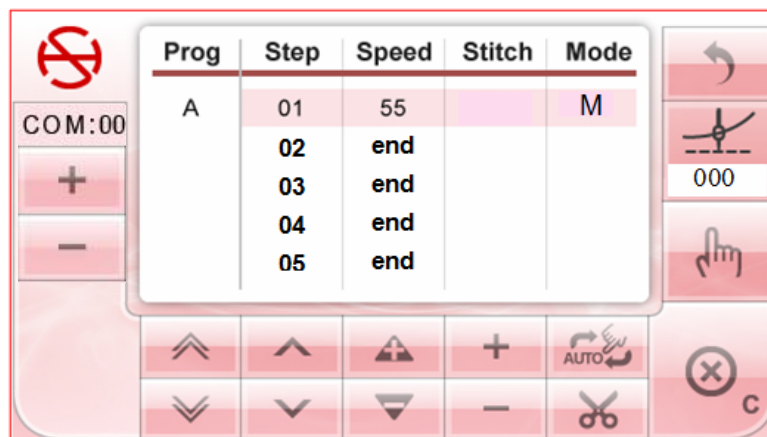
步驟 5.按返回鍵 ↩ 回縫製畫面即可,設定完成後畫面如下:
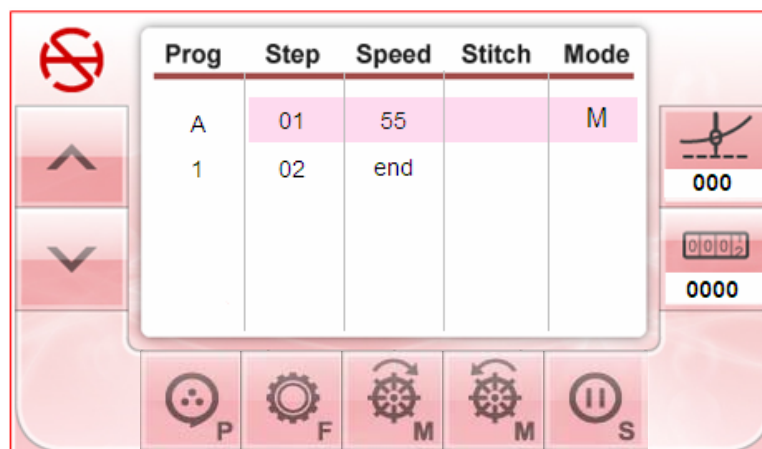
MC 範例 2. 車縫內衣的單一開口,設定 3 個工程段數,1,2 段為自動模式,第 3 段手動模式

Step	Speed	Stitch
01	80	125
02	30	55
03	50	-
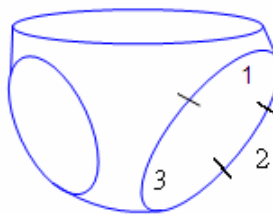
步驟 1.在縫製畫面按下 進入到編輯畫面

步驟 2. 將 Step 01 的 Speed 欄設定為 80, Stitch 欄設定為 125

步驟 3. 將 Step 02 的 Speed 欄設定為 30, Stitch 欄設定為 55

步驟 4. 將 Step 03 的 Speed 欄設定為 50,按 鍵將 Step 03 的 Mode 欄設定為"M"

步驟 5. 確認 Step 04 的 Speed 欄設定為"end",若 Step 04 的 Speed 欄不是"end",則移動光棒到到

Step 04,再按 鍵設定 Speed 欄為"end",如下圖:
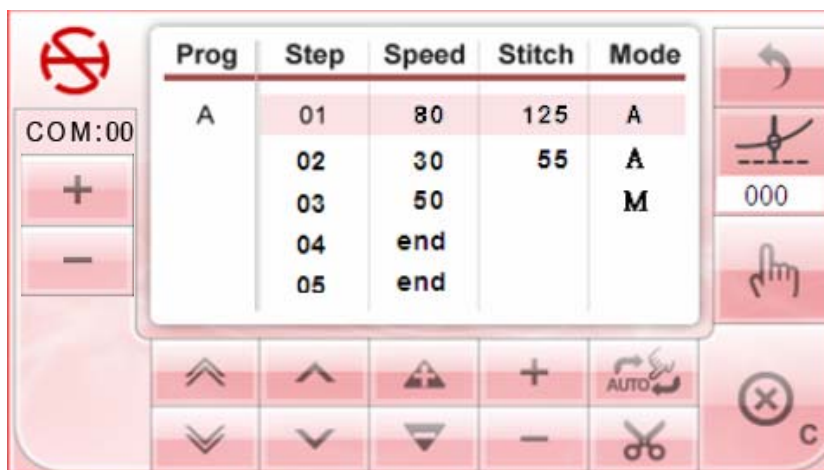
步驟 6.按返回鍵 回縫製畫面即可,設定完成後畫面如下:
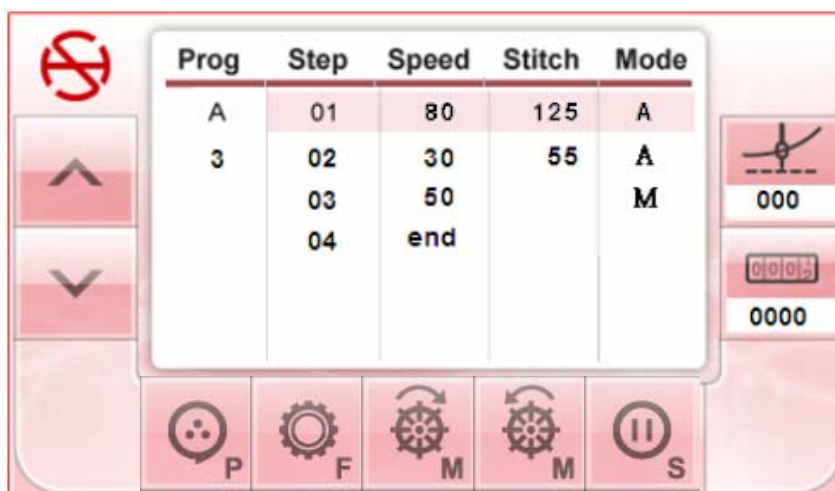
MC 範例 3.車縫兩個開口的內衣,設定 6 個工程段數,1,2 段為自動模式,第 3 段手動切線,第 4,5 段為自動模式,第 6 段為手動切線

Step	Speed	Stitch
01	80	125
02	30	55
03	50	-
04	80	125
05	30	55
06	50	-
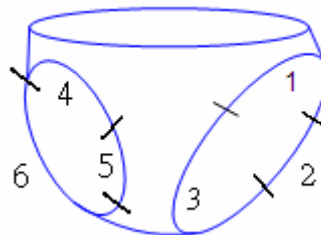
步驟 1.在縫製畫面按下 進入到編輯畫面

步驟 2. 將 Step 01 的 Speed 欄設定為 80, Stitch 欄設定為 125

步驟 3. 將 Step 02 的 Speed 欄設定為 30, Stitch 欄設定為 55

步驟 4. 將 Step 03 的 Speed 欄設定為 50,按 鍵將 Step 03 的 Mode 欄設定為"M",並且按

 鍵設定為切線模式.

步驟 5. 將 Step 04 的 Speed 欄設定為 80, Stitch 欄設定為 125

步驟 6. 將 Step 05 的 Speed 欄設定為 30, Stitch 欄設定為 55

步驟 7. 將 Step 06 的 Speed 欄設定為 50,按 鍵將 Step 06 的 Mode 欄設定為"M"

步驟 8. 確認 Step 07 的 Speed 欄設定為"end",若 Step 07 的 Speed 欄不是"end",則移動光棒到到

Step 07,再按 鍵設定 Speed 欄為"end"

步驟 9.按返回鍵 回縫製畫面即可,畫面如下圖所示
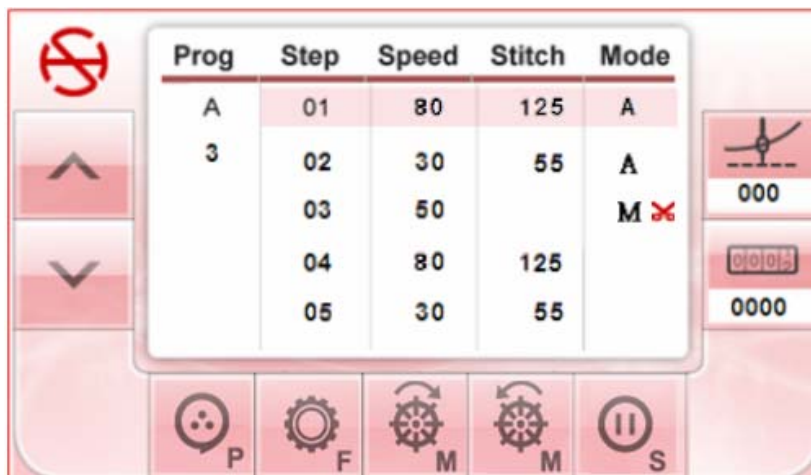
VII.　操作說明(英文) / Operation guide(English)

MC example 1. sewing one single opening of underwear in single program step, cut manually, feed speed
55

Step	Speed	Stitch
01	55	-
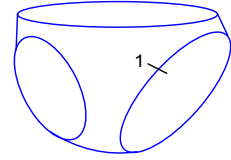
procedure 1. in sewing mode, press [⊙ P] key to enter editing mode

procedure 2. set 55 at speed column in Step 01

procedure 3. press [AUTO] key to set 'M' at mode column in Step 01

procedure 4. pleases check the speed column at step 02 must set "end", if not pleases move to step 02

and press [⊗ c] key to set "end". Illustration as below:

Prog	Step	Speed	Stitch	Mode
A	01	55		
	02	end		
	03	end		
	04	end		
	05	end		

COM:00

000
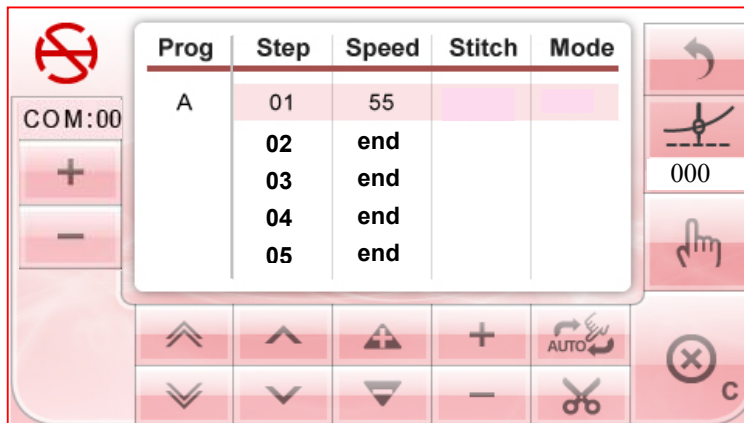
procedure 5. press [↶] key to return to sewing mode, illustrated below if setting completed

Prog	Step	Speed	Stitch	Mode
A	01	55		M
1	02	end		

000

0000
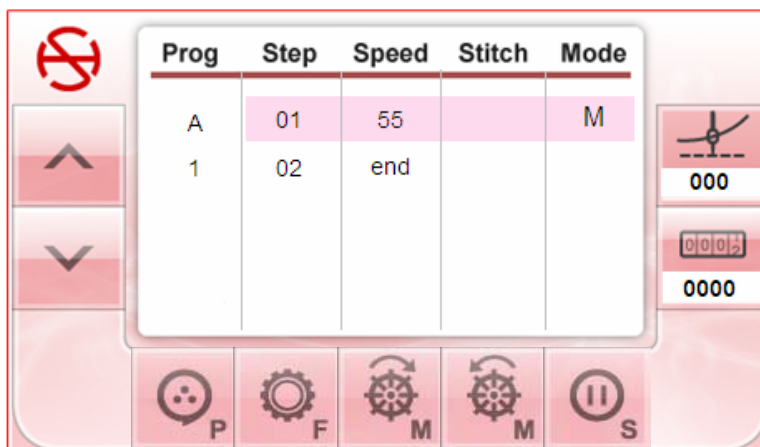
MC example 2. sewing single opening of underwear, set three program steps, step 01 & step 02 are auto
mode, step 03 is manual

Step	Speed	Stitch
01	80	125
02	30	55
03	50	-

procedure 1. in sewing mode, press [P] key to enter editing mode

procedure 2. set 80 at column speed & set 125 at stitch column in step 01

procedure 3. set 30 at speed column & set 55 at stitch column in step 02

procedure 4. set 50 at speed column in step 03, set 'M' at mode column in step 03 while press
[AUTO] key

procedure 5. pleases check the speed column at step 04 must set "end", if not pleases move to step 04
and press [C] key to set "end". Illustration as below:
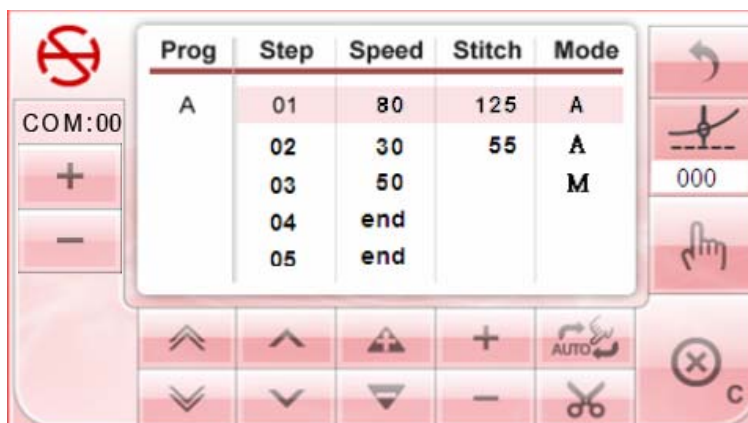
procedure 6. press [↩] key to return to sewing mode, illustrated below if setting completed
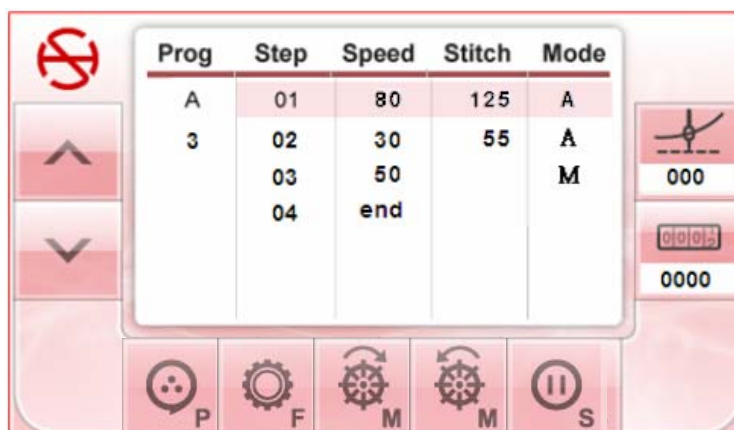
MC example 3. sewing two opening of underwear at 6 program steps, set step 01 & step 02 auto mode, step 03 manual, step 04 & step 05 auto mode, step 06 manual

Step	Speed	Stitch
01	80	125
02	30	55
03	50	-
04	80	125
05	30	55
06	50	-
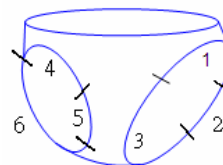
procedure 1. in sewing mode, press key to enter editing mode

procedure 2. set 80 at speed column & set 125 at stitch column in step 01,

procedure 3. set 30 at speed column, 55 at stitch column in step 02

procedure 4. set 50 at speed column in step 03, press key to set 'M' at mode column in step 03, press key to set trimming mode at same time

procedure 5. set 80 at speed column & set 125 at stitch column in step 04

procedure 6. set 30 at speed column & set 55 at stitch column in step 05

procedure 7. set 50 at speed column in step 06, press key to set 'M' at mode column in step 06

procedure 8. pleases check speed column in step 07 must set "end", in case the speed column is not set at "end" pleases move to step 07 and press key to set "end" at speed column

procedure 9. press key to return back to sewing mode, illustrated as below
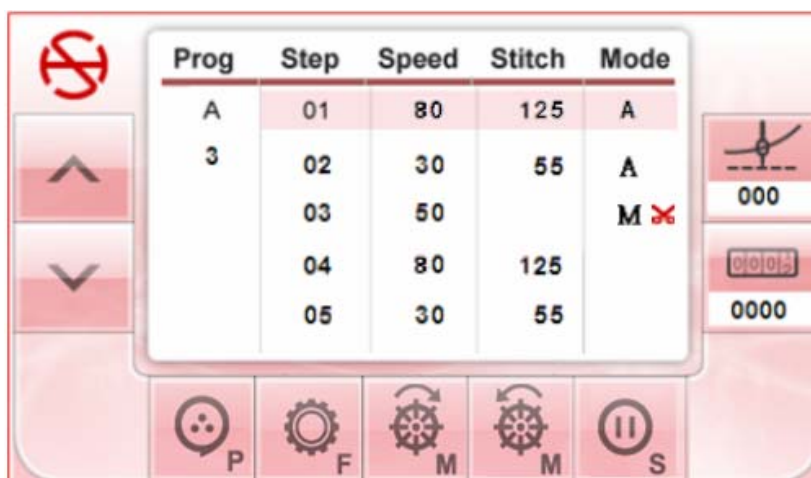
VIII.　提示代碼和錯誤代碼　/ Tip Code list and Error Code list

操作盒用: / For operation box:

提示代碼 **Tip Code**	顯示訊息 **Message**	說明 **Comment**
E098	successfully saved	出廠參數值儲存成功 factory preset value saved successfully
E099	please reboot	已回復出廠參數值,請重啟電源 Has returned to factory preset value, please restart the power

操作盒用: / For operation box:

錯誤代碼 **Error Code**	顯示訊息 **Message**	說明 **Comment**
E000	SAFETY LOCK-ON	安全開關安裝錯誤,請檢查安全開關或參數 17 Safety switch installation errors,check the safety switch or parameter 17
E100	No response from front panel	操作盒和控制箱無法互相通信,請檢查操作盒的連接線是否插好或插錯接口。 Operation box can not communicate to control box, please check the operation box cable is plugged in or plugged into the wrong connector.

控制箱用: / For control box:

錯誤代碼 **Error Code**	故障原因 **Cause of the problem**	說明 **Comment**
ER0.4	1.電源 ON 時，主電壓檢知過高時。 2.插錯電壓或供應電壓過高時。 1. When power on, detected high voltage. 2. Connect the wrong voltage, too high.	馬達與車頭出力將全部關閉成無動作狀態。 請檢查 AC 電源電壓是否正確或是否超過使用規定的額定電壓。 ＊如控制箱為 **AC 220V** 系統，請勿使用 **AC 380V** 的電源，否則 **LED** 於送電 **2** 秒後出現 **ER0. 4** 的故障碼。如果持續送入 **380V** 電源，則主基板上的電解電容(C3,C4) 會在一段時間內爆裂，並造成電源入力的保險絲 **(F1、F2)** 熔斷。 請檢查主基板組控制回路機能是否異常。 Motor and machine will be shutting down. Please check the AC power.　(Too high) ＊**If control box is AC 220V system, don't use the AC 380V power voltage, otherwise the LED will display ER0. 4 after 2**

		second of power ON. If continue supply the 380V power, the electrolytic capacitors (C3,C4) of main board will burst open over a period of time and cause the fuses (F1,F2) of power input open circuit.
		Please check the main pc board.
ER0.7	1.馬達插頭配線接觸不良導致不轉時。 2.定位器(傳感器)信號異常時。 3.定位器(傳感器)為單一觸發信號型式，而參數設定不符合時。 4.車頭機構鎖死或馬達皮帶輪異物捲入卡住。 5.加工物過厚，馬達扭力不足無法貫穿時。 1. Bad connection at the motor connector. 2. Synchronizer (sensor) signal error. 3. Synchronizer is a single position type, and parameter set wrong type. 4. Machine locked or object stuck in the motor pulley. 5. Sewing material is too thick.	馬達與車頭出力將全部關閉成無動作狀態。 請檢查馬達本身或馬達插頭配線等信號是否異常。 請檢查定位器(傳感器)信號是否異常。 請檢查車頭是否卡住或干涉轉動困難。 Motor and machine will be shutting down. Please check the motor or motor connectors' connection. Please check the Synchronizer (sensor) and its signal. Please check machine head to see if objects stuck in the motor pulley, or rotate not smoothly.
ER0.9	1.車頭線圈 (或電磁閥) 短路時。 2.驅動車頭電磁閥之功率電晶體迴路有故障。 1. Machine solenoid shorted. 2. Main board's power transistor is faulty.	馬達可正常運轉，但車頭出力與操作盒之定針式樣縫製功能將全部關閉成無效。 請檢查車頭電磁閥(或線圈)之迴路是否短路。 請檢查主基板組之各功率驅動電晶體是否故障。 Motor still can run, but all output signals and Operation box's pattern sewing function will be invalid. Please check machine's solenoids. Please check all the power transistors which related to solenoid.

七段顯示器字體與實際數值對照表：

7-Segment Display Characters Compare Table

數值字體部份：（**Arabic Numerals**）

實際數值 Actual	0	1	2	3	4	5	6	7	8	9
七段顯示器 Display	0	1	2	3	4	5	6	7	8	9

英文字體部份：（**English Alphabet**）

英文數字 （Actual）	A	B	C	D	E	F	G	H	I	J
七段顯示器 （Display）	A	b	C	d	E	F	G	H	i	J
英文數字 （Actual）	K	L	M	N	O	P	Q	R	S	T
七段顯示器 （Display）	t	L	N	n	o	P	q	r	S	⌐
英文數字 （Actual）	U	V	W	X	Y	Z				
七段顯示器 （Display）	U	u	U	II	Y	Ξ				