

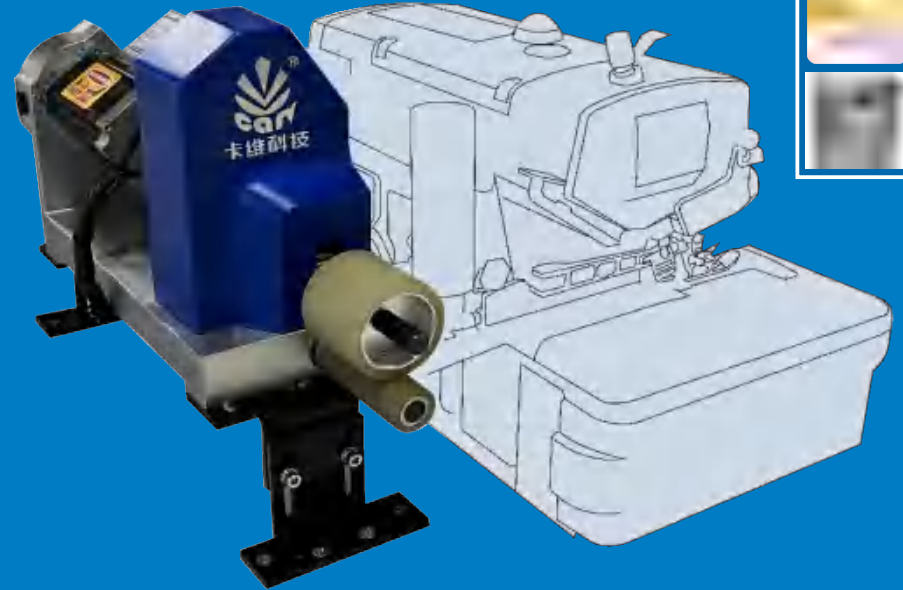
1、操作面板使用说明 Operation Panel Instructions

- 1.1 针距修改：点按P键，针距数字闪烁，按+或-修改针距，数字越大，针脚越密；
1.1 Stitch modify: press "P", stitch number twinkling, press + or - to change stitch distance. the bigger number is, the shorter stitch distance is.
- 1.2 功能选择：点按P键3秒后松开，屏幕会显示P01等字样，按+或-选择功能，再次按P键进入次功能设置模式。
1.2 Function choice: press "P" for 3 seconds then release, And the words "P01" will appear on the screen, press + or - to choose function. Press "P" again to enter the secondary function setup mode.

2、参数设置说明 System parameters setting list

参数编号 NO.	参数范围 Range	出厂值 Default	参数描述 Description
P01	1-200	15	针距：数字越大，针脚越密。 The bigger the number, the shorter the stitch distance is.
P02	F-1/F-2	F-1	普通和同步模式切换： F-1：普通模式 common mode Common and synchronous mode switching F-2：同步模式(机针同步) synchronous mode(machineneedle synchronization)
P05	/	FBL	测编码器分辨率，只适用于同步模式。 Measuring encoder resolution, for synchronous mode only.
P06	yd-1/ yd-2	yd-1	设置同步模式停针原点，只适用于同步模式。 Set synchronization mode stop needle origin, apply to synchronous mode only.
P07	-99-99	0	同步停针位置偏移量，正数为延缓停针。 Synchronous stop position offset, positive number is delayed stop needle.
P08	30-80	55	调整同步轨迹百分比，小范围内可以调整按牙齿同步还是落针同步，只适用于同步模式。 Adjust the percent age of synchronization tracks, a small range can be adjusted by tooth synchronization or drop needle synchronization, only for synchronization mode.
P12	OFF/ 0.2-5	OFF	压脚延时放下，默认OFF关闭，延时范围0.2s-5.0s。 Foot delay down, default "OFF", delay range 0.2s-5.0s.
P13	OFF/ON	OFF	倒缝时抬压脚，默认OFF不抬，ON为抬起。 Lift the foot when back stitch, the default "OFF" is not to lift, "ON" is lift.
P14	OFF/ 0.2-5	OFF	两次抬压脚之间的间隔，默认OFF关闭。 The interval between the two lift feet, the default "OFF" is off.
P15	OFF/ON	OFF	电机转动方向，默认 OFF 正转，ON 为反转。 Motor rotation direction, default "OFF" positive rotation, "ON" is for reversal.
P17	0.0-0.99	0.0	在P01的针距中加入99格微调。 Add 99 tweaks to the stitch distance of "P01".
P18	OFF/ 0.0-9.0	OFF	倒缝时针距倍率，OFF为关闭，可调范围0.1-5.0，1.0时倒缝针距数值和正缝一致，2.0时倒缝针距数值为正缝时的2倍。 When OFF is off, it can be adjusted from 0.1 to 5.0. At 1.0, the value of the inverted stitch distance is consistent with that of the normal stitch; at 2.0, the value of the inverted stitch distance is twice that of the normal stitch.
P20	OFF/ON	OFF	按+键调整至 On，按设置键即可初始化参数。 The key "+" to adjust to on, press the set button to initialize the parameters.
P21	OFF/ON	OFF	OFF上抬压脚时，步进电机释放电流；ON，不释放电流。 OFF, When the foot is lifted up, the stepping motor releases the current; ON, Do not release current.
P22	OFF/ON	OFF	OFF，普通模式输出；ON·跟随P02模式·如果P02是机针同步模式，则同步脉冲也是机针同步。 OFF, normal output mode. ON, FOLLOW P02 mode, if P02 is synchronous mode, so, synchronous pulse is synchronous mode
P23	OFF/ON	OFF	默认OFF不启用，改成ON后，在显示屏默认界面下，按减号键可以抬放压脚。抬放压脚时，针距前面会出现“—”字样，用来观察抬压脚上下限位霍尔传感器是否失灵。 he default OFF is not enabled. After changing to ON, press the "-" to up and down the foot under the default interface of the display screen. When the foot is up and down, the "—" appears in front of the needle distance to see if the Hall sensor at the upper and lower limit of the lifting foot fails.
P24	OFF/0.1-2.0	OFF	默认为OFF，单位为秒，如改为0.5，即压脚提升后0.5秒内不检测落下。 The default value is OFF, and the unit is second. If the value is set to 0.5, the fall is not detected within 0.5 seconds after the presser foot is lifted.
P25	OFF/1-9	OFF	缝纫机停止时，按倒缝输送带倒转。默认OFF关闭，1-9为倒转速度可调。 When the sewing machine stops, press the conveyor belt to reverse. The default value is OFF. The reverse speed is adjustable from 1 to 9.
P26	OFF/1-3	OFF	独立自锁开关功能设定：默认OFF关闭；1为手动抬压脚，2为输送带倒转，3为输送带正转。 Independent self-locking switch function setting: OFF by default; 1 is the manual lifting press foot, 2 is the conveyor belt reverse, 3 is the conveyor belt positive rotation.
P27	1-2.0	OFF	电磁铁倒缝默认都为0，只有极个别电机倒缝的机型需要改为1，例如富士H9500A，一般无需更改，特殊需要更改的机型会有安装说明文档。 The default value of electromagnet backseam is 0. Only a few motor backseam models need to be changed to 1, such as Toyama H9500A. Generally, you do not need to change the model. If you need to change the model, the installation instructions will be provided.
P29	OFF/ 1-2	OFF	可以切换编码器模式，重新开机后生效。此参数P20,P30初始化后不重置，需手工更改OFF - 正常模式(开机H 26) 1 - 低频编码器模式(开机HL 26) 2 - 包缝机模式(霍尔信号)(开机Hb 26) The encoder mode can be switched, and it takes effect after the machine is restarted. This parameter P20,P30 is not reset after initialization, need to manually change the off-normal mode (boot H 26) 1 - Low frequency encoder mode (power on HL 26) 2 - Overstitching machine mode (Hall Signal) (Power on Hb 26)
P30	OFF/ON	OFF	等同于P20 Equivalent to P20

MD双驱后拉电子拖轮安装使用说明书 MD Double smart digital puller Installation and instruction manual



适用于Compatible with:

绷缝机, 包缝机, 多针机, 单双针机

Interlock sewing machine, Overlock sewing machine, Multi-needle, Single double needle

运用家纺、毛毯、窗帘、帐篷等大织物缝制牵引，翻带子、翻猪肠等

Use the home textiles, blankets, curtains, tents and other large fabric sewn traction, ribbon, frit and so on

面料起皱
Fabric wrinkle

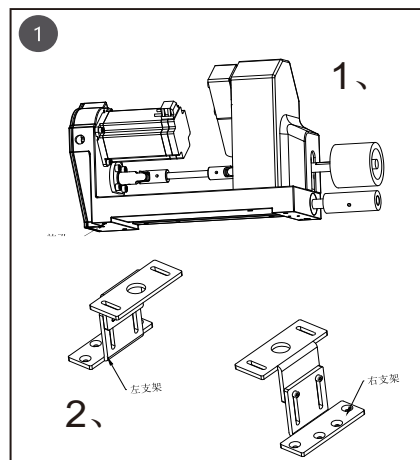
面料打滑
Fabric slip

送料不畅
Not smooth

电子拖轮装置/Digital Puller Device

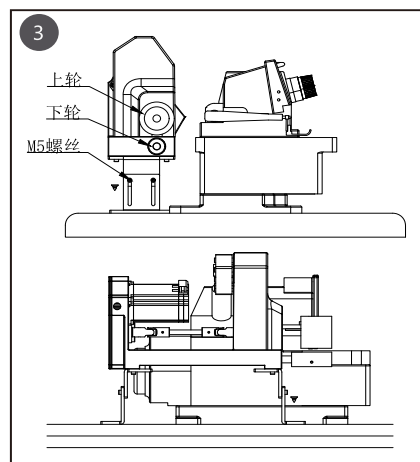
1 Installation order

安装顺序



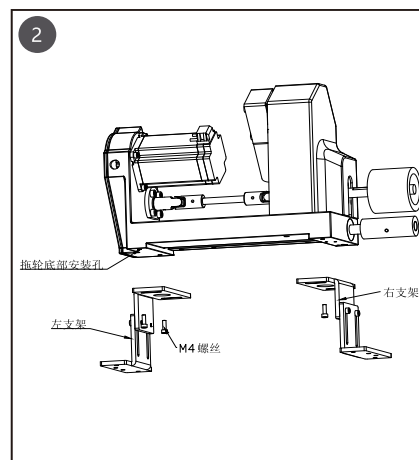
1、从包装盒中取出拖轮主体(图1)与拖轮安装支架(图2)(一左一右), 配件包里面的自攻螺钉、M4*12内六角圆柱头螺丝, 电源线与转接线等。

1. Take out the puller body (FIG. 1), puller mounting bracket (FIG. 2) (one left and one right), tapping screws in the accessories bag, M4*12 hex socket cylindrical head screws, power cables and conversion cables, etc.



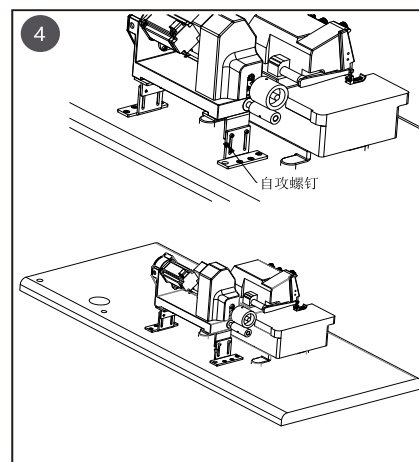
3、把拖轮放置台板上, 靠近缝纫机头左右要平行, 轮子与机针位置居中(工艺原因机针轮子位置会有差异), 然后用自攻螺钉把拖轮固定台面。

3. Place the puller on the table near the sewing machine head, and align the wheel with the needle in the center (the position of the needle wheel may be different due to technological reasons). Then use the tap screw to fix the puller on the table.



2、用M4*12螺丝将左支架与右支架分别固定在拖轮底部安装孔上。

2. Fix the left bracket and the right bracket respectively to the mounting hole at the bottom of the puller with M4*12 screws.



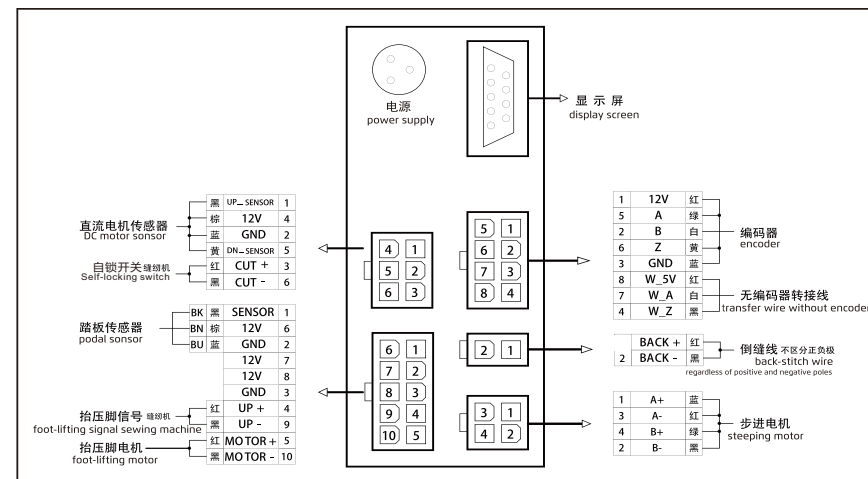
3、根据机头与台面的高低, 可松开左支架和右支架上的M5螺丝, 对拖轮进行高度调节, 尽量调到双拖轮对合处与机台牙齿平齐 (以最佳效果)

3, according to the height of the machine head and table, can loosen the M5 screws on the left bracket and the right bracket, adjust the height of the puller, try to adjust the joint of the double puller and the teeth of the machine (for the best effect)

2

Wire-connect

接线原理



说明: 通过自攻螺钉将电控箱按装在台板下底面, 然后按照电控箱插孔依次插上相应插头。

Explain: Use self-tapping screw to install the control box under the table, and plug in correct position based on the

!

Caution

使用注意事项

- 1、拖轮电控箱与拖轮主件安装时需轻拿轻放;
- 2、本机必须接交流96-230V;
- 3、拖轮主件安装固定好, 需保证滚轮与台面的左右平整;
- 4、同步器与缝纫机连接尽可能同心, 以减少晃动;

1. The control box and the main parts should be carried lightly while installing the main parts;
2. This machine is powered operates with an AC voltage of 96-230 V;
3. The main parts should be fixed well, and the left and right leveling of the roller and the countertop should be ensured;
4. encoder and sewing machine connection as concentric as possible to reduce shloshing;

同步模式设置 (同步编码器或部分无编码器转接线才有同步功能)

Synchronization mode setting (only synchronous encoders or partially encoder free adapter cables have synchronization function)

1、运行模式: 设置P 02, 调整至 F-2.

Operation mode: Set P 02 and adjust to F-2

2、测分辨率: 设置P 05, 出现FBL, 轻踩踏板, 直到FBL字样变为针距。

Resolution measurement: Set P 05, FBL appears, lightly press the pedal until the FBL text changes to needle pitch.

3、停针原点: 设置P 06, 出现yd-1, 按抬压脚, 让针自动定位到上停针, 也可以手轮拨动至上停针位置, 按设置键, 出现yd-2, 然后轻踩踏板(或者匀速转动手轮), 直到yd-2字样变为针距。

Stop needle origin: Set P 06, yd-1 appears, press the lifting foot to automatically position the needle to the upper stop needle position, or turn the handwheel to the upper stop needle position, press the setting button, yd-2 appears, then lightly press the pedal (or rotate the handwheel at a constant speed) until the yd-2 symbol changes to needle spacing.

4、效果测试: 拿模板夹白纸实际测试效果, 同步效果满意, 则结束, 不满意可以微调同步偏移量。

Effect testing: Use a template to clip white paper and test the actual effect. If the synchronization effect is satisfactory, it ends. If not satisfied, you can adjust the synchronization offset.

5、同步偏移: 设置 P 07, 按可以调整偏移脉冲量, 同步模式下, 电机启动早了, 则调整为负数。电机启动晚了, 则调整为正数。

Synchronous offset: Set P 07 and press to adjust the offset pulse. In synchronous mode, if the motor starts early, adjust it to a negative value. If the motor starts late, adjust it to a positive number.