

SXSTAR[®]

胸围自动接耳切反装置操作说明书

SC-1900A/B

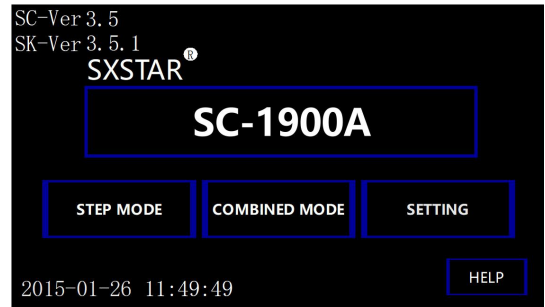
USER MANUAL



1. 主页 home page



系统主页面

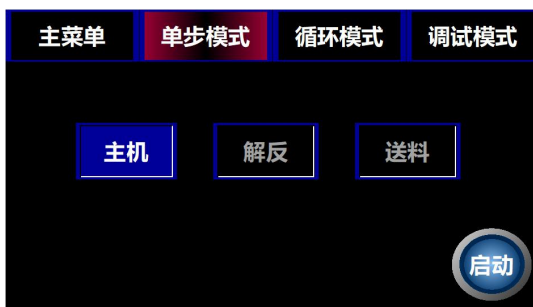


home page

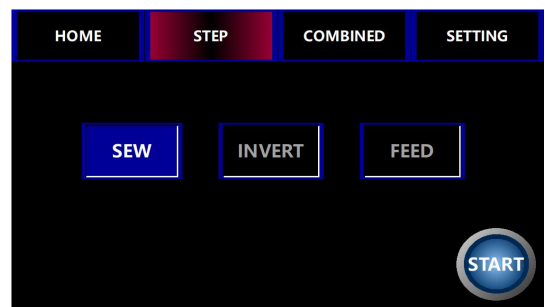
通过点击屏幕上的模式按键进入不同的操作页面，包括单步模式，循环模式以及调试模式页面

To enter the other operation page by pressing button, including STEP MODE、COMBINED MODE and SETTING page

2. 单步模式 STEP MODE



单步模式页面



STEP MODE PAGE

单步模式页面下，通过选择主机、解反、送料三个动作中的一个动作（注：蓝底白字表示选中），按下启动键后进入单一动作工作状态

In step mode , select one of the action (the action including sewing、tape inverting and tape feeding), pressing start button to enter work state

★注： ●主机 → 缝纫机跟随踏板进行车缝动作

★NOTE SEW Sewing following the pedal control

●解反 → 执行反带动作后缝纫机跟随踏板进行车缝动作

INVERT To invert the tape and then sewing following the pedal control

●送料 → 执行送料动作后缝纫机跟随踏板进行车缝动作

FEED Tape feeding and then sewing following the pedal control

3. 循环模式 COMBINED MODE



循环模式选择页面



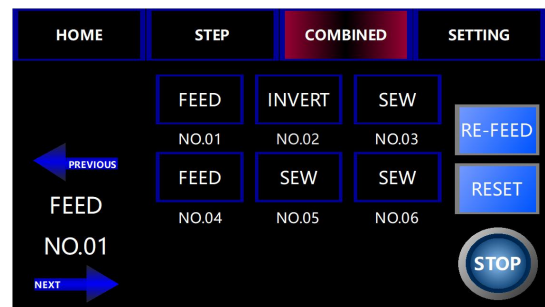
COMBINED MODE PAGE

循环模式下，用户可以通过操作显示屏将主机、送料、解反动作进行自由组合，系统最高支持 6 个工程组编辑和存储，每个工程组最多可以包含 35 个动作组合，确定好动作组合后，点击启动按键即可进入动作循环工作状态（动作组合会在按下启动按键后自动存储到系统存储器中，方便下次使用）

In combined mode, user are free to set up composite action including sewing 、tape inverting and tape feeding. system provide 6 group program, and each program provide up to 35 action combination. pressing start button can enter combined mode work state (the setting will be saved when start button pressing down)



循环模式工作页面



COMBINED MODE PAGE

●循环模式工作状态下，页面会实时显示当前处于哪个动作状态以及动作编号，用户可以通过页面上箭头按键进行动作切换（←表示返回上一个动作，→表示进入下一个动作）

In combined mode work state, panel will display the current action state and action number, user can turn to the previous or next action by flag button (← indicate previous action and → indicate next action)

●按下重新切料按键可以重新进行一次切料送料操作

Pressing RE-FEED button to make new tape feeding

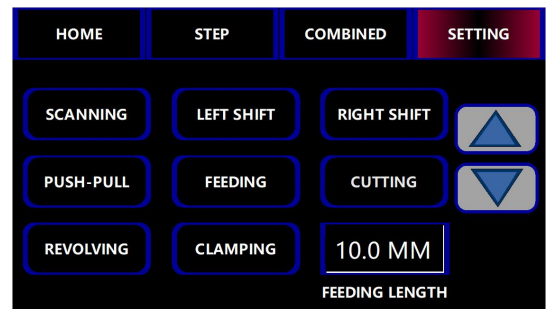
●按下循环复位可以直接返回组合的第一个动作

Pressing RESET button can return to the first action

4. 调试模式 SETTING



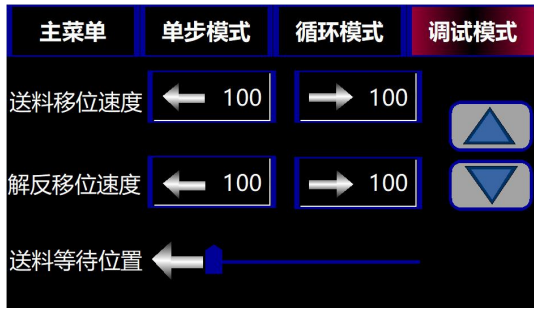
调试页面 1



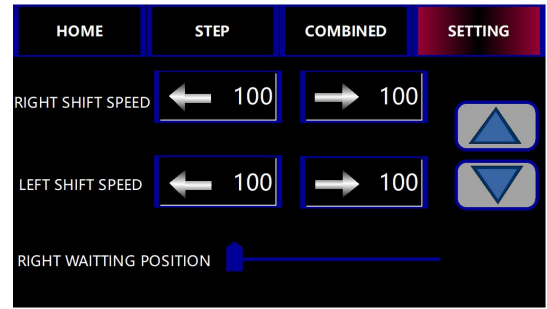
SETTING PAGE 1

调试模式下，用户可以通过显示屏上的相关按键对设备的单一器件进行调试，主要功能如下文列表所示
User can test each part of the device by panel operation, the button function list shown below

<p>SCANNING 行程扫描</p>	<p>进行解反和送料导轨行程扫描（建议在故障或修改参数后进行一次扫描） Slider available length scanning</p>
<p>LEFT SHIFT 解反移位</p>	<p>进行解移位动作 Move tape inverter on the slider</p>
<p>RIGHT SHIFT 送料移位</p>	<p>进行送料移位动作 Move tape feeder on the slider</p>
<p>LEFT SHIFT 解反伸缩</p>	<p>进行解反叉子伸缩动作 Push or pull tape inverter on the slider</p>
<p>LEFT SHIFT 手动送料</p>	<p>按住后进行送料动作，松开后停止送料动作 Tape feeding by pressing feeding button</p>
<p>CUTTING 手动切带</p>	<p>进行剪料动作 Tape cutting</p>
<p>REVOLVING 解反旋转</p>	<p>进行解反叉子旋转动作 To test tape invert action</p>
<p>CLAMPING 夹子调试</p>	<p>进行夹子开合测试 To test tape clamp</p>
<p>10.0MM</p>	<p>设定自动送料长度，单位毫米 To set the length of tape auto feeding, the unit is millimeter</p>



调试页面 2



SEETING PAGE 2

●送料移位速度：←用于设定送料正向移动速度，→用于设定送料反向移位速度

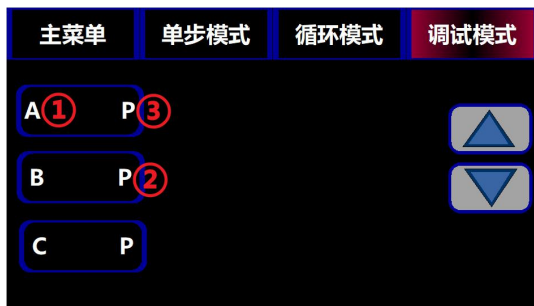
RIGHT SHIFT SPEED: ← indicate tape feeder positive sliding speed
→ indicate tape feeder negative sliding speed

●解反移位速度：←用于设定解反反向移动速度，→用于设定解反正向移位速度

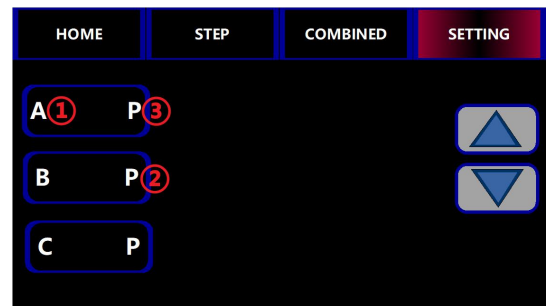
LEFT SHIFT SPEED: ← indicate tape inverter negative sliding speed
→ indicate tape inverter positive sliding speed

●送料等待位置：设定送料正向移动等待位置（压脚未抬起时，送料需要在等待位置）

RIGHT WAITTING POSITION: tape feeder waiting position when presser foot pressing down



调试页面 3



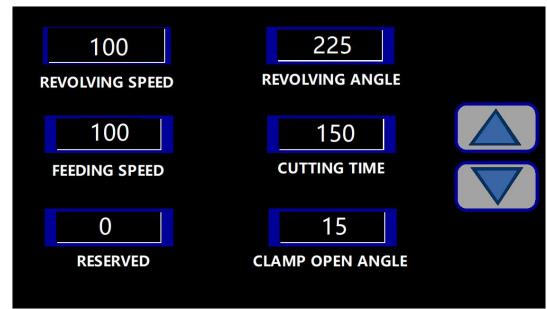
SEETING PAGE 3

调试模式第三页面用于进入二级设置，进入方法按上图所示编号顺序依次单击屏幕上字母区域即可

In this display page ,user can enter second level setting page by pressing these button in turn according to the numbering



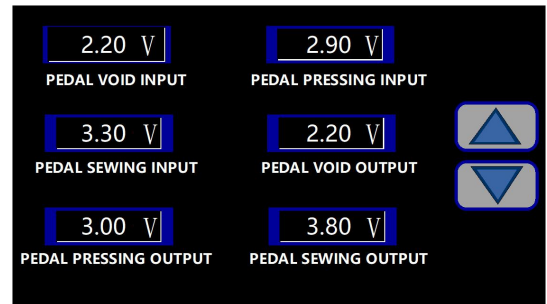
二级设置页面 1



SECOND LEVEL SETTING PAGE 1



二级设置页面 2



SECOND LEVEL SETTING PAGE 2

二级设置页面用于设置设备运行参数，具体参数内容如下表所示

Second level setting page provide system parameter setting , the parameter description refer to the list shown below

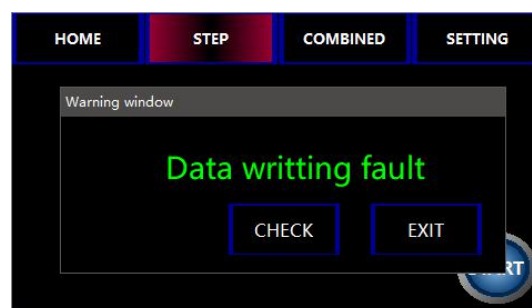
解反速度 REVOLVING SPEED	解反叉子旋转速度设定 tape inverter revolving speed set
解反角度 REVOLVING ANGLE	解反叉子旋转角度设定 Tape inverter revolving angle set
送料速度 FEEDING SPEED	送料电机的旋转速度设定 Tape feeding motor speed set
切刀闭合时间 CUTTING TIME	切刀动作时的闭合时间 Cutter work time set
保留参数 RESERVED	
夹子松开角度 CLAMP OPEN ANGLE	车缝时，夹子打开的角度 Clamp open angle when sewing

空踩输入电压 PEDAL VOID INPUT	踏板没有被下压时的输入电压设定, 用于系统判断踏板状态 Pedal input voltage setting when pedal is not pressing
压脚输入电压 PEDAL PRESSING INPUT	踏板下压至触发压脚下压动作时的输入电压设定 Pedal input voltage setting when pressure foot is pressing down
下针输入电压 PEDAL SEWING INPUT	踏板下压至触发车缝动作时的输入电压设定 Pedal input voltage setting when sewing
空踩输出电压 PEDAL VOID OUTPUT	踏板空踩状态下, 系统输出电压设定 Pedal output voltage setting when pedal is not pressing
压脚输出电压 PEDAL PRESSING OUTPUT	踏板下压至触发压脚下压动作时, 系统输出电压设定 Pedal output voltage setting when pressure foot is pressing down
下针输出电压 PEDAL SEWING OUTPUT	踏板下压至触发车缝动作时, 系统输出电压设定 Pedal output voltage setting when sewing

5. 故障说明 FAULT REFERENCE



异常提示画面



WARNING PAGE

设备运行过程中如果遇到故障，显示屏会弹出故障提示窗口，用户可以通过按下自检按钮尝试自恢复，或者按下退出按钮，对设备故障进行检查和排除，下文列表为设备可能出现的故障提示信息及相关解决方法

Panel will display the warning window when system fault occur, user can pressing CHECK button to try to solve the fault, or pressing EXIT button to find out the cause of the failure. The troubleshooting reference list is shown below

存储器读写异常 Data writing fault	存储芯片损坏, 联系厂家更换 Memory chip damage, contact with Technician
ADC/DAC 芯片读写异常 Voltage converting fault	电压转换芯片损坏, 联系厂家更换 Voltage converter damage, contact with technician
解反行走异常 Tape inverter sliding fault	解反导轨行走过程中出现卡顿或导轨上的传感器出现故障, 检查电机和传感器 Tape inveter sliding is blocked or sensor out of work, check the motor and sensor
送料行走异常 Tape feeder sliding fault	送料导轨行走过程中出现卡顿或导轨上的传感器出现故障, 检查电机和传感器 Tape feeder sliding is blocked or sensor out of work, check the motor and sensor
夹布电机原点回归异常 Tape clamp fault	夹布电机闭合过程中出现卡顿或原点传感器出现故障, 检查电机和传感器 Tape clamp is blocked or sensor out of work, check the motor and sensor
解反电机原点回归异常 Tape inverter revolving fault	解反叉子旋转过程中出现卡顿或原点传感器出现故障, 检查电机和传感器 Tape inverter revolving is blocked or sensor out of work, check the motor and sensor
解反功能未启用 Tape inverter turn off	解反功能处于关闭状态, 如果已经配置解反装置, 请联系技术人员进行功能启用 Tape inverting function turn off, please call the technician to turn it on
送料功能未启用 Tape feeder turn off	送料功能处于关闭状态, 如果已经配置送料装置, 请联系技术人员进行功能启用 Tape feeding function turn off, please call the technician to turn it on
解反伸缩原点回归异常 Tape inverter push-pull fault	解反叉子伸缩装置没有接入气泵或原点传感器出现故障, 检查气管和传感器 Tape inverter push-pull without air jet or sensor out of work, check the air jet and sensor