






## 新绣422+叠片组合装置说明（以左侧为例）

### S422-Four beads and dual sequin device instruction (L device)

#### 1.正常情况下屏显及按键功能

#### Display and key function under normal situation

<p>数码管显示“-.”横杠 Keyboard display “-.”</p> 	<p>表示在绿灯（工作）状态 Machine head light is green (Work statue)</p>
<p>数码管显示“H” Keyboard display “H”</p> 	<p>表示在拨红灯（补绣）状态 Machine head light is red (Make up the design statue)</p>
<p>数码管显示“-”下横杠 Keyboard display “-”</p> 	<p>表示关机头（非工作）状态 Device is off (No working)</p>

# KEY FUNCTION FOR BEAD SWITCH (AB BEAD, 119 card, CD BEAD,117

OK 键  
OK key



**短按3次:** 在1, 2, 3中来回切换。“1”表示送珠动作; “2”表示回退接珠动作; “3”表示去预备位置动作。

**Short press 3 times:** 1,2,3 can be shifted.

"1" ----sending bead;

"2" ----the original position of bead sending motor and the bead are clamped by the bead pusher;

"3" ----the bead are in ready position;

以下情况需要用到此功能件:

Following situation will use this key:

A.装置首次装在机器。

A.Device is attached on machine firstly.

A-1 需要查看在“1”的状态下, 珠子是否准确送到针位以及珠子是处于加紧还是放松状态。如果不到位或是珠子被夹太紧或是太松, 需要到调节模式F2的状态下进行调节;

A-1.Make "1" displayed and check if the bead is under the needle position; also to check the bead if it is clamped loosely or tightly, any condition, please go to Adjustment mode "F2" to adjust it. (See F2 instruction)

A-2 查看“2”的状态, 手动往后拉拨叉, 拉不动说明原点正确; 如果还能往后拉, 说明原点没到位, 此时需要松开螺丝, 把拨叉拉到最后, 再拧紧螺丝。

A-2.Make "2" displayed and pull the bead swing level in back, if can't pull more, means motor position is right, otherwise loose the screw on the swing level and pull the level in back then tight the screw.

B.当有漏珠, 掉珠或是飞珠的情况, 需要用到此功能键来, 方法同上面A过程。

When the bead is missed or can't be stitched, "OK" key is used. The way is same as A step.

**长按按键:** 对拨叉松轴处理, 松轴同时数码管显示 F.


**Long press:** Loose the shaft of motor, at the time "F" is displayed.

\*\* 在不改变原点的情况下, 更换推车夹头组件。可以用此功能。


\*\* This function can be used when the bead pusher set is to be changed without changing the original position of the bead sending motor.

119 and 117 card same function.

<p>上键 UP key</p> 	<p><b>短按按键:</b>换色按键，A珠和B珠相互切换或C珠和D珠相互切换</p> <p><b>Short press:</b> 119 card:Bead A and Bead B is shifted. 117 card: bead C and bead D is shifted.</p>
<p>下键 DOWN key</p> 	<p><b>短按按键:</b> 1.手动下珠（钢丝上）及结束下珠 2.报错时，按此键进行复位。</p> <p><b>Short press:</b> 1.press one time, the bead on steel is down, press one time again, the bead is stopped on steel. 2. When there is Error occure, press this key for to re get original position of bead sending motor.</p> <p><b>长按按键:</b>A珠或是B珠,C珠或D珠换珠处理，长按至显示“U”松开即可始，再次短按下键结束动作</p> <p><b>Long press:</b> Change color for A Bead or B bead(119 card) or C bead and D bead (117 card). Long pressue this key until “U” is display, at this time, the bead on steel come down.Short press again, stop the bead coming down.</p> <p>当A珠或是B珠，C珠或D珠需要换颜色时，需要用此键来去掉钢丝上的珠子。</p> <p>119 card:When Bead A or Bead B need change color,this key is to be used to move the bead on the steel.</p> <p>117 card: When Bead C or Bead D need change color, this key is to be used to move the bead on the steel.</p>
<p>Model 键 Model key</p> 	<p><b>短按按键:</b>AB珠板件退避动作切换；CD珠板件暂无该功能</p> <p><b>Short press:</b> for 119 card only, this key is for sequin device retracking.</p> <p><b>长按按键:</b>进入调参模式。</p> <p><b>Long press:</b> Enter the adjustment model.</p>

<p>气阀键 Up and down key</p> 	<p><b>短按按键:</b>气阀升降功能按键。 <b>Short press:</b> device up and down.</p> <p><b>长按按键:</b>进入补绣选择模式, 0: 默认为 0 即全部补.1: 不补绣珠; 2: 只补绣 AB 珠或CD; 3: 只补绣 A或C珠; 4: 只补绣B或D珠; 5: 只补绣AB珠;6: 只补绣AC珠;7. 只补绣BC珠 Long press until any number of followings appear for make up design:</p> <div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p><b>AB CARD(119)</b> 0: All design is made up. 1: No any bead is made up. 2: Just AB beads design part is made up. 3.Just A beads design part is made up. 4.Just B beads design part is made up. 5.Just sequin is made up.</p> </div> <div style="width: 45%;"> <p><b>CD CARD(117)</b> 0: All design is made up. 1: No any bead is made up. 2: Just CD beads design part is made up. 3.Just C beads design part is made up. 4.Just D beads design part is made up.</p> </div> </div> <p>***长按住待数码管显示对应数字松开即选择对应补绣模式。 Long press until displaying the value as needed and then loose the keyboard.</p>
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## KEY FUNCTION FOR SEQUIN SWITCH (SEQUIN DEVICE, 116 card )


	<p>A 电机: A送片 A Motor: A sequin sending B 电机: B送片 B Motor: B sequin sending 切片: 切片动作 Cut: Cutting</p>
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2.调试模式

Adjustment model

长按[Mode] 键,直到任意一个数字出, 说明进入调节模式. 短按Mode键, 实现不同的调节模式。  
Press the [Model] key for a long time until any word is shown on keyboard to enter the adjustment mode. At this time, you will get F light on, short press [Mode] key to get different adjustment situation.

KEY FUNCTION FOR BEAD SWITCH (AB BEAD, 119;CD BEAD 117)

调试模式 Adjustment model	代表相应调试模式 Function of different mode
<div>1次 press 1 time</div> <div></div> <div>F1 对应 LED 灯亮 F1 light on</div>	<p>代表调试夹子预备位置也就是送珠等待位置。正常情况下，接珠夹头要超过过珠定位块，但不能超过底板位置。按上下键调整夹子停的位置。</p> <p>119板：A 颜色下代表调试 A 珠送珠位置，按上下键调整夹子停的位置。B 颜色下代表调试 B 珠送珠位置； 117板：C 颜色下代表调试 C 珠送珠位置，按上下键调整夹子停的位置。D 颜色下代表调试 D 珠送珠位置 It is under state that bead is ready to be sent out. Normally the bead pusher is over the locating block but not over the bottom plate. Press the[ up] or [down] key for fine adjustment.</p> <p>119 card: When A is displayed, it is for adjusting bead A. When B is displayed, it is for adjusting bead B. Press the [up] or [down] key for fine adjustmen; 117 card:When C is displayed, it is for adjusting bead C. When D is displayed, it is for adjusting bead D. Press the [up] or [down] key for fine adjustmen</p> <p>调试完可按 OK 退出或者再按 Mode 键进入下一模式（默认值为 0）。 After that, press [OK] to exit or [Mode] for next adjustment.(Default value 0) .</p> <p><b>**此种状态下，通常不需要做调整。 ** Under this situation, normally no need make adjustment as it has been checked mechanically when the device is in the factory.</b></p>

2次  
press 2



F2 对应 LED 灯亮  
F2 light on

珠子处于送珠位置时，夹珠张紧度的调整。  
It is under state that the bead are sent out for stitched. Under this state, we can check the bead is clamped loosely or tightly.

119板： A 颜色下代表调试 A 珠送珠位置，按上下键调整夹子停的位置。 B 颜色下代表调试 B 珠送珠位置，按上下键调整夹子停的位置。  
117板： C 颜色下代表调试 C 珠送珠位置，按上下键调整夹子停的位置。 D 颜色下代表调试 D 珠送珠位置，按上下键调整夹子停的位置。

119 card: When A is displayed, it is for adjusting bead A. When B is displayed, it is for adjusting bead B. Press the [up] or [down] key for fine adjustmen.  
117 card: When C is displayed, it is for adjusting bead C. When D is displayed, it is for adjusting bead D. Press the [up] or [down] key for fine adjustmen.

调试完可按 OK 退出或者再按 Mode 键进入下一模式（默认值为 0）。退出后，短按"OK"键，直到“1”出现，确认珠子的松紧度。（默认值为 0）

After this press [OK] to exit or [Mode] for next adjustment. if exit, Press [OK] again until "1" is displayed to check the bead if it is normal or not.(Default value 0) .

3次  
press 3 times



F3 对应 LED 灯亮  
F3 light on

代表调试夹子接珠位置，按上下键调整夹子停的位置。（默认值为 0）  
It is under state that the bead are seated in the bead pusher. Press the [up] or [down] key for fine adjustmen. After this press[OK]to exit or [Mode] for next adjustment.(Default value 0) .

119板： A 颜色下代表调试 A 珠送珠位置，按上下键调整夹子停的位置。 B 颜色下代表调试 B 珠送珠位置，按上下键调整夹子停的位置。  
117板： C 颜色下代表调试 C 珠送珠位置，按上下键调整夹子停的位置。 D 颜色下代表调试 D 珠送珠位置，按上下键调整夹子停的位置。

119 card: When A is displayed, it is for adjusting bead A. When B is displayed, it is for adjusting bead B. Press the [up] or [down] key for fine adjustmen.  
117 card: When C is displayed, it is for adjusting bead C. When D is displayed, it is for adjusting bead D. Press the [up] or [down] key for fine adjustmen.

调试完可按 OK 退出或者再按 Mode 键进入下一模式（默认值为 0）。  
After this press [OK] to exit or [Mode] for next adjustment.

**\*\*此种状态下，通常不需要调整。但是如果换了送珠电机或是其编码盘，就要重新调原点。  
\*\* Under this situation, normally no need make adjustment as it has been checked mechanically when the device is in the factory.However, when the motor or encode of bead sending motor is changed, then the original position is to be adjusted again. Please refer to instruction of A-2.**

4次  
press 4 times

4次 LED灯不亮  
Press 4 times  
All LED light OFF



### 调节下珠料盘转速

**119板:** A颜色下代表调试散珠A下珠档位, 按上下键调整档位, 数字越大越快, 数字越小越慢。  
B颜色下代表调试散珠B下珠档位, 按上下键调整档位, 数字越大越快, 数字越小越慢。  
**117板:** C颜色下代表调试散珠C下珠档位, 按上下键调整档位, 数字越大越快, 数字越小越慢。  
D颜色下代表调试散珠D下珠档位, 按上下键调整档位, 数字越大越快, 数字越小越慢。  
调试完可按OK退出或者按Mode键退出。

Adusting running speed of bead bowl.

**119 card:**

When A is displated, press [up] or [down] key to choose value. The value is bigger, the bowel of it run faster and vice versa.

When B is displated, press [up] or [down] key to choose value. The value is bigger, the bowel of it run faster and vice versa.

**117 card:**

When C is displated, press [up] or [down] key to choose value. The value is bigger, the bowel of it run faster and vice versa.



When D is displated, press [up] or [down] key to choose value. The value is bigger, the bowel of it run faster and vice versa.

After that, press [OK] to exit or [Mode] for next adjustment.



### 3. 报错及调试说明


#### Error show and adjustment instructin




## KEY FUNCTION FOR BEAD SWITCH (AB BEAD 119 card ;CD BEAD 117 card)





数码管显示 Display	Failure mode 失效模式	常见原因 Main reason	解决方案 Solution
数码管“ <b>A</b> ”闪烁 <b>“A”</b> is shinking 	A珠缺珠 Bead A can't be pick up in the bowl	1. A珠钢丝前端（料杯里）珠子是否有破损。 Check if there is any defected bead or stucked bead at the end of steel in the bead A bowl. 2.A珠钢丝前端没穿进珠子。 The bead A can't be picked up in bowl.	1.取出钢丝前端破损珠子,排除问题后按 <b>[OK]</b> 键或者 <b>[下]</b> 键解除错误。（需等待6秒左右再进行下一个操作） Move the defected bead or stucked bead and Press <b>[OK]</b> or <b>[down]</b> key to clear the error.After 6s, then process next step.
数码管显示“ <b>A</b> ”以及 F1F2F3 灯均闪烁 <b>“A”</b> is displayed and F1/F2/F3 light all shrinking. 	A珠满珠 Bead A is stucked	霍尔A一直未检测珠子有滑落 Hall A fail in detecting the bead.  A珠子堵在过珠定位块位置 Bead A is stucked in the bead locating block  A珠子破损挤压到过珠滑块与底板之间, 拨叉不能工作。 Bead A is damaged and stucked between the bead locating block and the bottom plate, and the bead swing lever cant move.	正常时, 检测夹闭合时, HALL A是亮着的, 张开时 (2mm or more), HALL A 是不亮的。 1.检查感应片上的磁铁是否被感应到。 Check if the magnet was reacted by the sensor. 2.检查线或霍尔板是否有损坏 Check the cable of Hall A of if HALL A is damaged. 3.排除问题后按 <b>[OK]</b> 键或者 <b>[下]</b> 解除错误。（需等待6秒左右再进行下一个操作） Press <b>[OK]</b> or <b>[down]</b> key to clear the error.After 6s, then process next step.  取出堵在过珠定位块位置的珠子,排除问题后按 <b>[OK]</b> 键或者 <b>[下]</b> 键解除错误。（需等待6秒左右再进行下一个操作） Move the bead stucked in the bead locating block and Press <b>[OK]</b> or <b>[down]</b> key to clear the error.After 6s, then process next step.  取出破损的珠子,排除问题后按 <b>[OK]</b> 键或者 <b>[下]</b> 键解除错误。 Move the the defected bead Press <b>[OK]</b> or <b>[down]</b> key to clear the error.After 6s, then process next step.



<p>数码管“b”闪烁 “b” is shrinking.</p> 	<p>B珠缺珠 Bead B can't be pick up in the bowl</p>	<p>B珠钢丝前端（料杯里）珠子是否有破损 Check if there is any defected bead or stucked bead at the end of steel in the bead B bowl. 2.B珠钢丝前端没穿进珠子。 The bead B can't be picked up in bowl.</p>	<p>取出钢丝前端破损珠子,排除问题后按 [OK]键或者[下]键解除错误。（需等待6秒左右再进行下一个操作）  Move the defected bead or stucked bead and Press [OK] or [down] key to clear the error.After 6s, then process next step.</p>
<p>数码管显示“b”以及 F1F2F3 灯均闪烁 “b”is displayed and F1/F2/F3 light all shrinking.</p> 	<p>B珠满珠 Bead B is stucked</p>	<p>霍尔B一直未检测珠子有滑落 Hall B fail in detecting the bead.</p>	<p>正常时， 检测夹闭合时， HALL B是亮着的， 张开时（2mm or more), HALL B 是不亮的。 1.检查感应片上的磁铁是否被感应到。 Check if the magnet was reacted by the sensor. 2.检查线或霍尔板是否有损坏 Check the cable of Hall B of if HALL B is damaged. 3.排除问题后按 [OK] 键或者[下]键解除错误。 Press [OK] or [down] key to clear the error</p>
		<p>B珠子堵在过珠定位块位置 Bead B is stucked in the bead locating block</p>	<p>取出堵在过珠定位块位置的珠子,排除问题后按 [OK] 键或者[下]键解除错误。（需等待6秒左右再进行下一个操作） Move the bead stucked in the bead locating block and Press [OK] or [down] key to clear the error..After 6s, then process next step.</p>
		<p>B珠子破损挤压到过珠滑块与底板之间, 拨叉不能工作。 Bead B is damaged and stucked between the bead locating block and the bottom plate, and the bead swing lever cant move.</p>	<p>取出破损的珠子,排除问题后按 [OK] 键或者[下]键解除错误。  Move the the defected bead. Press [OK] or [down] key to clear the error..After 6s, then process next step.</p>

数码管“C”闪烁 “C” is shrinking.		C珠缺珠 Bead C can't be pick up in the bowl	1. C珠钢丝前端（料杯里）珠子是否有破损。 Check if there is any defected bead or stuck bead at the end of steel in the bead C bowl. 2.C珠钢丝前端没穿进珠子。 The bead C can't be picked up in bowl.	1.取出钢丝前端破损珠子,排除问题后按 [OK] 键或者 [下] 键解除错误。（需等待6秒左右再进行下一个操作） Move the defected bead or stuck bead and Press [OK] or [down] key to clear the error.After 6s, then process next step.
数码管显示“C”以及 F1F2F3 灯均闪烁 “C”is displayed and F1/F2/F3 light all shrinking.		C珠满珠 Bead C is stucked	霍尔D一直未检测珠子有滑落 Hall D fail in detecting the bead.	正常时，检测夹闭合时，HALL C是亮着的，张开时（2mm or more), HALL C是不亮的。 1.检查感应片上的磁铁是否被感应到。 Check if the magnet was reacted by the sensor. 2.检查线或霍尔板是否有损坏 Check the cable of Hall C of if HALL C is damaged. 3.排除问题后按[OK]键或者[下]解除错误。（需等待6秒左右再进行下一个操作） Press [OK] or [down] key to clear the error.After 6s, then process next step.
			C珠子堵在过珠定位块位置 Bead C is stucked in the bead locating block	取出堵在过珠定位块位置的珠子,排除问题后按 [OK] 键或者 [下]键解除错误。（需等待6秒左右再进行下一个操作） Move the bead stucked in the bead locating block and Press [OK] or [down] key to clear the error.After 6s, then process next step.
			C珠子破损挤压到过珠滑块与底板之间，拨叉不能工作。 Bead C is damaged and stucked between the bead locating block and the bottom plate, and the bead swing lever cant move.	取出破损的珠子,排除问题后按 [OK]键或者[下]键解除错误。 Move the the defected bead Press [OK] or [down] key to clear the error.After 6s, then process next step.
数码管“d”闪烁 “d” is shrinking.		D珠缺珠 Bead D can't be pick up in the bowl	1. D珠钢丝前端（料杯里）珠子是否有破损。 Check if there is any defected bead or stuck bead at the end of steel in the bead D bowl. 2.D珠钢丝前端没穿进珠子。 The bead D can't be picked up in bowl.	1.取出钢丝前端破损珠子,排除问题后按 [OK] 键或者 [下] 键解除错误。（需等待6秒左右再进行下一个操作） Move the defected bead or stucked bead and Press [OK] or [down] key to clear the error.After 6s, then process next step.

<p>数码管显示“d”以及 F1F2F3 灯均闪烁 “d”is displayed and F1/F2/F3 light all shrinking.</p> 	<p>D珠满珠 Bead D is stucked</p>	<p>霍尔D一直未检测珠子有滑落 Hall D fail in detecting the bead.</p>	<p>正常时，检测夹闭合时，HALL D是亮着的，张开时（2mm or more), HALL D是不亮的。 1.检查感应片上的磁铁是否被感应到。 Check if the magnet was reacted by the sensor. 2.检查线或霍尔板是否有损坏 Check the cable of Hall D of if HALL D is damaged. 3.排除问题后按[OK]键或者[下]解除错误。（需等待6秒左右再进行下一个操作） Press [OK] or [down] key to clear the error.After 6s, then process next step.</p>
<p>数码管显示“E”以及 F1F2F3 灯均闪烁 “E”is displayed and F1/F2/F3 light all shrinking.</p> 		<p>D珠子堵在过珠定位块位置 Bead D is stucked in the bead locating block</p>	<p>取出堵在过珠定位块位置的珠子,排除问题后按 [OK] 键或者 [下] 键解除错误。（需等待6秒左右再进行下一个操作） Move the bead stucked in the bead locating block and Press [OK] or [down] key to clear the error.After 6s, then process next step.</p>
<p>数码管显示“E.”以及 F1F2F3 灯均闪烁 “E.”is displayed and F1/F2/F3 light all shrinking.</p> 		<p>D珠子破损挤压到过珠滑块与底板之间，拨叉不能工作。 Bead D is damaged and stucked between the bead locating block and the bottom plate, and the bead swing lever cant move.</p>	<p>取出破损的珠子,排除问题后按 [OK]键或者[下]键解除错误。 Move the the defected bead Press [OK] or [down] key to clear the error.After 6s, then process next step.</p>
	<p>散珠B或D拨叉卡珠报错 Bead B/Bead D is stucked</p>	<p>1. 接珠位置卡珠报错 1. The bead were stucked when it is clamped by the bead pusher. 2.钢丝没有在卡槽位置 The steel of bead was free from clips.</p>	<p>排除问题后短按[下]键拨叉重新找原点并解除错误（需等待6秒左右再操作） Move the bead, press [down] key to re get original position.After 6s, then process next step.</p>
	<p>散珠B或D拨叉找原点超时 Bead B/Bead D sending motor is over time when getting original position</p>		

数码管显示“F”以及 F1F2F3 灯均闪烁 “F” is displayed and F1/F2/F3 light all shrinking. 	散珠A或C拨叉卡珠报错 Bead A/Bead C is stucked	1. 接珠位置卡珠报错 1. The bead were stucked when it is clamped by the bead pusher. 2. 钢丝没有在卡槽位置 The steel of bead was free from clips.	排除问题后短按 [下]键拨叉重新找原点并解除错误（需等待6秒左右再操作） Move the bead, press [down] key to re get original position.After 6s, then process next step.
数码管显示“F.”以及 F1F2F3 灯均闪烁 “F.” is diaplayed and F1/F2/F3 light all shrinking. 	散珠A或C拨叉找原点超时 Bead A/Bead C sending motor is over time when getting original position		
数码管显示“H”以及 F1F2F3 灯均闪烁 Keyboard display “H” and F1/F2/F3 light all shrinking. 	机器断线报错 Thread is broken		穿好线后重新拉杆解除错误。 Thread and pull the bar.
数码管显示“9”以及 F1F2F3 灯均闪烁 “9” is displayed and F1/F2/F3 light all shrinking. 	退避电机报错（金片） Alarm given by retract motor	a,光耦感应位置出片偏差 The sheet can't be reacted by sensor.	调节光耦感应片位置（光耦灯亮为感应位置）。 Check the sheet position until the sensor is on.
		b,光耦线接触不良 The sensor is disconnected	更换光耦线。 Change sensor cable
		c,光耦损坏 The sensory is damaged	更换光耦。 Change sensor
		排除问题后按 [model]键退避装置重新复位并解除错误。 After solution, Press[model] to re get the positon of retract motor.	
数码管显示“2”以及F1F2F3灯均闪烁 When "2" is displayed and F1/F2/F3 light all blinking 	1. 花样可能漏了一针或者两针 One or two stitches missed. 2. 拨叉负载过重导致拨叉动作异常。 The bead sending fork is too heavy to move.	1. 更改花样 Make the design correct 2.清理底板 Clean the bottom plate.	1.修改正确的花样后， 拉杆解除报错 Change the design and pull the bar 2. 清理底板后短按 [OK] 键或[下] 键装置重新复位并解除错误（需等待6秒左右再操作） After clear the bottom plate, press [OK] or [down] key to re get original position..After 6s, then process next step.

4. 电控参数设置: Computer parameter setting:		
机器参数 Mahn. Para setting	设置值 Value set	
F09 金片 F09 sequin	ON	
F10金片装置类型 F10 sequin device type	Device1	
F12 散珠 F12 Glass bead	On	
金片参数编号 Sequin Device Parameter	设置值 Value set	备注 Remark
C32（左金片限定速度） C32 Speed for sequin L <300,1200>	850	
D61（左金片装置电机数） D61 Motor number of L sequin	4 ( 5 if pure bead, without sequin)	
D62 - D66 (左金片装置金片拨片大小设置) D62--D66 L sequin	3mm	Lever/11.7
	4mm	Lever/13.5
	5mm	Lever/19.8
	7mm(6.75)mm	Lever/19.8
	9mm	Lever/23.4
C63 C左金片装置C大小颜色 C63 C Size&Color L Sequin	3mm	当片不能被送出时， 根据实际情况进行相应的调整 When the sequin can't be sent out, set this value basing on actual situation.
C64 D左金片装置D大小颜色 C64 D Size &Color L Sequin	5mm	
C66 左金片间隙气阀动作时间 C66 Adj Sequin Gap L sequin	2	

JF左侧切刀启动角度补偿 <0, 31>	15	此参数只用于i当D片大于C片时 when D Sequin is bigger than C sequin.
D84（左侧切刀启动角度调整） D84 L. knife start angle adj. <0,31>	18	数值越小，切刀启动越早，数值越大，切刀启动越晚。 The knife will cut earlier when the the value is smaller and will cut later when the value is bigger.
JF02（左侧切刀幅度） JF02 L.Knife Range <0,31>	12	该参数调整切刀切片幅度，数值越小，切得越浅，数值越大，切得越深。 The knife will cut more deep when when the value is bigger.
SH02（单针机工作针位） SH02 Single needle head work needle	9针(左侧/末针) 9th needle(left or last needle)	根据实际情况，如机头是6针或是9针，装置在左侧，那就选择6或是9 If the head is 6 needle or 9 needle, when the device is in left side, then choose 6 or 9( last needle).
SH03（单针机工作方式） SH03 Single needle head working mode	金片+散珠 Sequin+glass bead	
SH04（金片退避电机启动角度调整） SH04 Sequin retract motor start angle adjustment <1,120>	120	该参数越小退避启动时机越早，建议参数调整为 120 The value of parameter is small and the movement motor start early. 1 should be enough for it.
SH05单针机头金片工作方式 SH05 Single needle head sequin working mode	普通 Common	
SH06 单针金片机头工作方式 SH06 Single needle sequin head working mode	右金片+左金片 R sequin+L sequin	
珠子参数编号 Bead Device Parameter	设置值 Value set	代表对应功能 Function
H03（送珠到位角度） H03 Angle of glass-bead arriving <0,359>	50	该参数配合散珠拨叉送珠到位早晚，参数需要配合调至 45-50; This value is for sending bead to the needle positon earlier or later.
GB04 是否插入换珠码 GB04 Intert Change Bead code	NO	
E88 左侧玻璃珠子电机个数 E88 COUNT OF I bead motor	有/YES	
GB31 左侧散珠装置类型 GB31 L glass bead device type <1~50>	15	

GLA01 左侧A珠最高转速 GLA01 Left Bead A max Speed <400,1200>	850	
GLB01 左侧B珠最高转速 GLB01 Left Bead B max Speed <400,1200>		
GLC01 左侧C珠最高转速 GLC01 Left Bead C max Speed <400,1200>		
GLD01 左侧D珠最高转速 GLD01 Left Bead D max Speed <400,1200>		
GLA04 左侧穿珠A电机转速调整 GLA04 Adj speed of L soeed motor A <0~15>	6	数值越大越快，越小越慢 Value is more bigger, the speed is more higher and vise
GLB04 左侧穿珠B电机转速调整 GLB04 Adj speed of L soeed motor B <0~15>		
GLB04 左侧穿珠C电机转速调整 GLB04 Adj speed of L soeed motor C <0~15>		
GLB05 左侧穿珠D电机转速调整 GLB04 Adj speed of L soeed motor D <0~15>		
GLA05 左侧珠子A时间参数 GLA05 Time para for L bead A <0, 50>	35	
GLB05 左侧珠子B时间参数 GLB05 Time para for L bead B <0, 50>		
GLB05 左侧珠子C时间参数 GLB05 Time para for L bead C <0, 50>		
GLB06 左侧珠子D时间参数 GLB06 Time para for L bead D <0, 50>		

GLA06 左装置散珠A回退角度补偿 GLA06 Left device back angle compenstate A <-30,30>	0	<p>该参数需要与拨叉动作时间匹配，控制散珠拨叉回退早晚，越小越早,越大越晚，目前默认调 0.</p> <p>The parameter should match the running of swing level of bead A The value is more bigger, the swing level get back more later; the value is more less, the swing level get back more earlier. The default value is 0</p>
GLB06 左装置散珠B回退角度补偿 GLB 06 Left device back angle compenstate B		
GLC06 左装置散珠C回退角度补偿 GLC 06 Left device back angle compenstate C		
GLD06 左装置散珠D回退角度补偿 GLD 06 Left device back angle compenstate D		
GLA07 左侧下料电机A启动颗数 GLA07 Left motor A start number <0,50>	20 (1.7, 2.0, 2.5) 15 (3.0 tube, 3.0 pearl) 8 (4.0 pearl, crystal) 3 (3*6 rice pearl)	A珠启动后出多少颗开始启动下珠，参数调试范围6-56颗，对应界面数值0-50. The bead A is to come down from bowl after the specified quantity bead is embroidered.
GLB07 左侧下料电机B启动颗数 GLB07 Left motor B start number <0,50>		B珠启动后出多少颗开始启动下珠，参数调试范围6-56颗，对应界面数值0-50. The bead B is to come down from bowl after the specified quantity bead is embroidered.
GLC07 左侧下料电机C启动颗数 GLC07 Left motor C start number <0,50>		C珠启动后出多少颗开始启动下珠，参数调试范围6-56颗，对应界面数值0-50. The bead C is to come down from bowl after the specified quantity bead is embroidered.
GLD07 左侧下料电机D启动颗数 GLD07 Left motor D start number <0,50>		D珠启动后出多少颗开始启动下珠，参数调试范围6-56颗，对应界面数值0-50. The bead C is to come down from bowl after the specified quantity bead is embroidered.
GLA08 左侧散珠A报警灵敏度 GLA08 Left bead A alarm sensor <0,180>	160 (1.7, 2.0, 2.5) 120 (3.0 tube, 3.0 pearl) 90 (4.0 pearl, crystal,3*6 rice pearl)	A珠缺珠报警颗数（料盘开始下珠后出多少珠子仍然没有检测满珠就报缺珠），参数调整范围20-200颗，对应界面数值0-180 Bead A quantity alarm(After this quantity is selected from the bowl and the bead still not sensitive, then it will be alarmed.)
GLB08 左侧散珠B报警灵敏度 GLB08 Left bead B alarm sensor <0,180>		B珠缺珠报警颗数（料盘开始下珠后出多少珠子仍然没有检测满珠就报缺珠），参数调整范围20-200颗，对应界面数值0-180 Bead B quantity alarm(After this quantity is selected from the bowl and the bead still not sensitive, then it will be alarmed.)
GLC08 左侧散珠C报警灵敏度 GLC08 Left bead C alarm sensor <0,180>		C珠缺珠报警颗数（料盘开始下珠后出多少珠子仍然没有检测满珠就报缺珠），参数调整范围20-200颗，对应界面数值0-180 Bead C quantity alarm(After this quantity is selected from the bowl and the bead still not sensitive, then it will be alarmed.)
GLD08 左侧散珠D报警灵敏度 GLD08 Left bead D alarm sensor <0,180>		D珠缺珠报警颗数（料盘开始下珠后出多少珠子仍然没有检测满珠就报缺珠），参数调整范围20-200颗，对应界面数值0-180 Bead D quantity alarm(After this quantity is selected from the bowl and the bead still not sensitive then it will be alarmed )