CONTROL PANEL MANUAL

TRECCIA-C 3F

Automatic industrial cylinder-bed interlock sewing machine

texi

1. General Safety Instructions

1. Do not put your feet on the pedals when the control box and motor is switched on (boot status)
2. Let professionals to install and debug this product
3. Do not open the control box and the motor cover when energized
4. Please turn off the power when changing the needle, threading or replacing the bottom line
5. During installation and removal service, please turn off the power and pull the plug
6. Please turn off the power when turn lift sewing machine
7. When use this product, please stay away from high-frequency electromagnetic waves and radio wave transmitters, etc., in case the electromagnetic waves generated interfere with the servo drive to occur wrong action .

2. Product Instruction

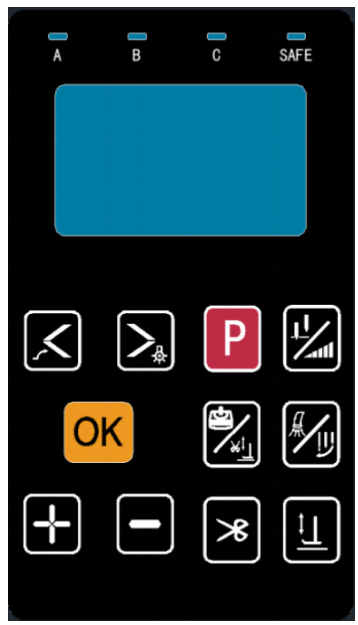
Control system includes control box and pedal.
This control system features is easy to use and features in excellent performance, including quick start, quick stop (sewing machine), accurate needle Position. Furthermore, the modular circuit has Self-Protection System when against lower voltage, over current, over heat etc.
Speed stepless is realized by the pedal speeder.

Specification:

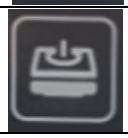
Voltage	220V2 phase
Frequency	50~60HZ
Speed	200-6000RPM
Motor torque	≤2.2NM

3. Control Panel

The control panel interface shown on the next image:



Keys description:

No	Button	Description
1	 (Menu button)	Press and hold P, then press – to enter the System Parameter List (password required). Press and hold P, then press + to enter the User Parameter List (no password required)
2		Needle positioner function button (Long press to enter the parameter of P71 to adjust maximum speed).
3		Parameter confirm button
4		Increasing value (increase speed for 50RPM when pressed in the main interface)
5		Decreasing value (Decrease speed for 50RPM when pressed in the main interface)
6		Left key (switching digits in paramemter mode) (Press to turn on or off the function of slow start)
7		Right key (switching digits in paramemter mode) (LED light adjustment)
8		Foot lifting function button (Long press to enter the parameter P111 - Step motor presser foot lift speed)
9		Foot lifting after thread trimming function button (Long press to enter the parameter P120 - Trimming back slow down speed)
10		Thread trimming function button (Long press to enter the parameter P106 - Step forward knife speed)
11		Waste suction button (optional) Long press to enter the parameter P47 Wiper action time (full power + maintain power)

How to change parameter value:

Turn on the power first.

Press and hold the " P " key, then press the " + " key with your other hand, the screen will display 000.

After entering, you can see the parameter codes. At this point, you can use the + or – keys to switch between parameter codes.

When you reach the parameter you want to modify, press the ▶ key to enter the current parameter adjustment mode.

Then press + or – to adjust the current parameter value.

After finishing the adjustment, press the OK key to save the parameter and exit the system parameter adjustment.

Or press the ◀ key to return to the previous page to modify other parameters.

The operation method is the same as above.

After completing all adjustments, you must press the OK key to save; otherwise, the modified parameters will not take effect.

Commonly used parameter setting:

Code	Function Description	Default Value	Range	Parameter Description
P1	MAX Sewing speed	4500	200–6500	Round / Minute
P2	Start sewing speed	250	150–800	Round / Minute
P3	Pedal acceleration curve	100	10–100 %	
P11	Slow Start Selection	0	0–1	0: Disable | 1: Enabled
P12	Slow start stitch number	2	1–30	Stitch number
P13	Slow start speed	350	200–800	Round / Minute
P22	Motor drive orientation	1	0–1	0: CCW | 1: CW
P23	Displays the current speed	0		Displays the motor speed
P24	Display governor voltage	0		Governor output voltage
P25	Automatic run–run	0	0–1	0: OFF | 1: ON
P34	Angle of up needle position	180		
P35	Angle of down needle position	180		
P36	Delay time for scissors action	10	0–2000	Millisecond
P37	Scissors action time (full + maintain power)	110	10–1000	Millisecond
P38	Full power scissors action time	110	10–990	Millisecond
P40	Scissors maintain power adjustment	50	1–100	Percentage
P41	Scissors release protect time	45	20–800	Millisecond
P43	Scissors reset switch function	0	0–1	0: Disable | 1: Enabled
P46	Wiper delayed start time	40	0–2000	Millisecond
P47	Wiper action time (full + maintain power)	70	10–2000	Millisecond
P48	Wiper full power action time	70	10–990	Millisecond
P50	Wiper maintain power adjustment	50	1–100	Percentage
P51	Wiper release protect time	50	20–800	Millisecond
P56	Foot-lifter delayed start time	110	0–2000	Millisecond
P58	Foot-lifter full power action time	160	10–990	Millisecond
P60	Foot-lifter maintain power time	15	1–90	Percentage
P61	Foot-lifter release protect time	100	20–800	Millisecond
P62	Automatic presser foot lift down time	10	1–120	Second
P65	Back half-pedal foot lifter delay start time	60	0–2000	Millisecond
P70	Motor max electric current	350	50–600	
P71	Maximum speed lock	4500	200–6500	Round / Minute
P72	System password	2014		

Code	Function Description	Default	Range	Notes
P72	System password	2014	0–9999	
P73	Voice volume	25	0–30	
P74	Language selection	0	0–2	0: Chinese / 1: English / 2: Reserved
P76	Air-suction action delay starting time	140	0–2000 ms	
P77	Air-suction action maintain time	20	1–600	
P78	Air-suction action full power time	160	10–990 ms	
P79	Air-suction action full power percentage	100	20–100 %	
P80	Air-suction action maintain power	80	1–100	
P81	Air-suction action releasing time	45	1–800 ms	
P82	Air-suction action protection time	1	1–120 ms	
P83	Air-suction protection switch enable	0	0–1	0: OFF / 1: ON
P84	Air-suction action mode	0	0–4	0: off; 1: long blow; 2: blow at intervals; 3: blow after presser foot lifting; 4: four-step blow
P85	Blow mode	0	0–2	0: blow after presser foot lifting; 1: once; 2: twice; 3: three times; 4: four times
P86	Blow at intervals ON needle numbers	10	1–250	
P87	Blow at intervals OFF needle numbers	30	1–250	
P88	Interlock machine mode selection	0	0–9	
P89	Trimming count	0	0–1	
P90	Display on the main interface	0	0–4	0: off; 1: count; 2: speed; 3: pedal voltage; 4: voltage
P91	Aging running time	5	1–60 s	

P92	Aging running stop time	2	0–60 s	
P93	Aging running speed	4500	200–5500 rpm	
P94	Speed lock	4500	200–6500 rpm	
P95	Virtual speed	100	0–5000	
P99	Display version	DPYVER	0–9999	
P100	Controller version	0	0–9999	
P101	Step direction	0	0–1	
P102	Step origin offset	32	0–400	
P103	Step origin power	10	0–50	
P104	Step thread cutting power	45	5–95	
P105	Step thread cutting angle	910	1–2800	
P106	Step forward knife speed	820	1–950	
P107	Step backward knife speed	600	1–950	
P108	Step forward knife power	2	1–5	
P109	Step backward knife power	3	1–5	
P110	Step motor presser foot lift angle	450	1–2800	
P111	Step motor presser foot lift speed	550	1–1900	
P112	Step motor release presser foot speed	200	1–1900	
P113	Step motor presser foot lift power	5	1–5	
P114	Step motor release presser foot power	2	1–5	
P115	05 mode function			
P116	05 mode fix needle sewing switch			
P117	05 mode feeding material speed			
P118	Trimming starting slow down itinerary	420	5–1200	
P119	Trimming starting slow down speed	300	100–950	
P120	Trimming back slow down speed	950	100–950	
P131	Presser foot lifting slow down itinerary	100	5–1000	
P132	Presser foot lifting slow down speed	100	100–1200	
P133	Presser foot releasing slow down itinerary	160	5–1000	

P134	Presser foot releasing slow down speed	800	100–1200	
P135	Two-paragraph presser foot lifting switch	1	0–1	
P136	Two-paragraph trimming switch	1	0–1	

Common faults and treatments:

Error Code	Meaning	Possible Causes	Solution
ER-01	No find needle position	1. Hand wheel and motor not close 2. Hand wheel magnet off 3. Magnet polarity reversed 4. Nine-pin terminal poor contact 5. Motor hall damaged	Check magnet, terminal, hall sensor
ER-02	Pedals velocimeter signal wrong	1. Velocimeter not plugged 2. Inserted upside 3. Velocimeter wire broken 4. Velocimeter damage	Reconnect/replace velocimeter
ER-03	Motor phase error signal	1. Nine-pin terminal poor contact 2. Hall/rotor deviation 3. Motor hall damage	Check terminal; adjust rotor; replace hall
ER-04	Motor stall protection	1. Sewing overweight/blocked 2. Motor overload 3. -wire motor cable not connected/inserted upside	Remove blockage; reconnect cable
ER-05	Hardware over current	1. Sewing overweight/blocked 2. Motor overload 3. Motor phase signal line not connected 4. Power tube damage	Remove blockage; reconnect lines; replace power tube
ER-07	Serial com-munication timeout	1. Display cable poor contact 2. Motherboard chip damage	Reconnect display cable; replace board
ER-09	Poor memory	Motherboard memory corruption/damage	Replace motherboard memory/board
ER-12/13	Knife not reset the alarm	1. Knife sensor broken 2. Scissors stuck, not reset	Repair detector; free scissors mechanism
ER-16	Overload	The motor drive power supply voltage is too high. The 220V power supply voltage exceeds the limit value (AC310V), or the load inertia is too large, causing the regeneration voltage to exceed the limit value (DC440V), or the voltage detection circuit fails. Note: For 110V control systems, the power supply voltage exceeds the limit value (AC155V), or the load inertia is too large, causing the regeneration voltage to exceed the limit value (DC220V).	
ER-20	Low voltage	The motor drive power supply voltage is too low. The 220V power supply voltage is lower than the limit value (AC91V), or the motor drive power supply voltage is lower than the limit value (DC130V), or the voltage detection circuit fails. Note: For 110V systems, the power supply voltage is lower than the limit value (AC45.5V), or the motor drive power supply voltage is below the limit (DC65V).	
ER-22	Speed Controller Error	Step forward the speed controller when booting on. Troubleshooting: Step forward the speed controller again. Enter parameter P24 and check if the value of the speed controller is 200 15%. If the value is abnormal, adjust it.	
ER-35	Stepper Motor Hardware Over-Current	Sewing overweight or blocked Motor overload Motor phase signal line is not connected Power tube damage	Check stepper motor connection Check whether the stepper motor is stuck or not Replace the controller
ER-37	A-Phase Current Detection Error	Replace the controller box	
ER-38	A-Phase Current Detection Error	Replace the controller box	
ER-39	A and B-Phase Current Detection Error	Replace the controller box	
ER-45	Stepper Motor Encoder Error	Replace the stepper motor encoder	
ER-46	The Starting Point of Stepper Motor Is Not Reset	Check whether the stepper motor structure is installed correctly. Loosen the fixed screw and try again to see if the error disappears.	

NOTES

Dealer: