

**△ Safety Instruction**

- Users are required to read the operation manual completely and carefully before installation or operation.
- The product should be installed and pre-operated by well trained persons.
- All the instruction marked with sign **△** must be observed or executed; otherwise, bodily injuries might occur.
- For perfect operation and safety, it is prohibited that using extension cable with multi-outlet for power connection.
- When connecting power supply cords to power sources, it is necessary to make sure that the power voltage is lower than 250 VAC and matches the rated voltage indicated on the motor's name plate.  
**△** **※Attention:** If the Control Box is AC 220V system, please don't connect the Control Box to AC 380V power outlet. Otherwise, the error will occur and motor will not work. If that happens, please turn off the power immediately and check the power voltage.
- Don't operate in direct sun light, outdoors area and where the room temperature is over 45°C or below 5°C.
- Please avoid operating near the heater at dew area or at the humidity below 30% or above 95%.
- Don't operate in area with heavy dust, corrosive substance or volatile gas.
- Avoid power cord being applied by heavy objects or excessive force, or over bend.
- The earth wire of power cord must be connected to the system ground of the production plant by proper size of conductions and terminals. This connection should be fixed permanently.
- All the moving portions must be prevented to be exposed by the parts provided.
- Turing on the machine in the first time, operate the sewing machine at low speed and check the correct rotation direction.
- Turn off the power before the following operation:
  - Connecting or disconnecting any connectors on the control box or motor.
  - Threading needle.
  - Raising the machine head.
  - Repairing or doing any mechanical adjustment.
  - Machines idling.
- Repairs and high level maintenance work should only be carried out by electronic technicians with appropriate training.
- All the spare parts for repair must be provided or approved by the manufacturer.
- Don't use any objects or force to hit or ram the product.

**Guarantee Time**

Warranty period of this product is 1 year dated from purchasing, or within 2 years from ex-factory date.

**Warranty Detail:**

Any trouble found within warranty period under normal operation, it will be repaired free of charge. However, maintenance cost will be charged in the following cases even if within warranty period:

- Inappropriate use, including: wrong connecting high voltage, wrong application, disassemble, repair, modification by incompetent personnel, or operation without the precaution, or operation out of its specification range, or inserting other objects or liquids into the product.
- Damage by fire, Earth quake, lightning, wind, flood, salt corrosive, moisture, abnormal power voltage and any other damage cause by the natural disaster or by the inappropriate environments.
- Dropping after purchasing or damage in transportation by customer himself or by customer's shipping agency

**Note:** We make our best effort to test and manufacture the product for assuring the quality. However, it is possible that this product can be damaged due to external magnetic interference and electronic static or noise or unstable power source more than expected; therefore the grounding system of operate area must guarantee the good earth and it's also recommended to install a failsafe device. (Such as residual current breaker)

**1. Button Displays and operating instructions**

**1.1 Key Description**

Function key enter parameter area		Under normal mode, press the [P] key to enter the user parameter mode Press and hold the [P] key to boot into parameter mode Technician
Enter and determine \ save button		Enter parameter values such items and their contents change after adjustment, need to press the [S] key to save the confirmation. Note: The parameters are saved directly by the [S] key.
On the adjustment key		1. Choose the region parameter items incrementing key 2. Parameter setting value incrementing key 3. Select the shortcut needle position
Under the adjustment key		1. Choose the region parameter items of diminishing key 2. Is decremented key parameter settings 3. Slow play seam selection shortcuts

**2 User Parameter & Technician Parameter**

Parameter	Parameter Function	Range	Default	Description
In the normal screen, press [P]				
P01	Maximum Sewing Speed (r/S)	200-2200	2200	Maximum speed of machine sewing
P02	Speed Curve Adjustment (%)	1-100	80	The Larger the value, the faster to increase speed
P03	Needle UP/ DOWN	0-1	1	UP: Needle Stops at Up Position DN: Needle Stops at Down Position
P07	Soft Start Speed (r/S)	200-1500	400	Soft Start Speed Adjustment
P08	Stitch Numbers for Soft Start	1-100	2	Soft Start Stitches Setting (one unit = half stitch)
P14	Soft Start	0-1	0	ON: Slow start feature is turned on. OFF: Slow start function off.
P15	Make up pin mode	0-4	2	0: Semi-pin: 1: a pin 2: Continuous filling half needle 3: Continuous injection
P24	Foot pedal reverse voltage	30-1000	110	
P30	Thick material angle	0-100	10	
P42	Information Display	N01-N07		N01 Electrically controlled version serial numbers N02 Selected needle cassette version N03 Speed N04 Pedals AD, N05 Positioning angle (0-359), N06 Under the positioning angle N07 Bus voltage AD
P43	Setting Direction of Motor Rotation	0-1	1	CW: Clockwise CCW: Counter Clockwise
Press and hold the [P] key to boot				
P44	Brake force	1-50	18	Efforts to stop the machine when selecting
P48	Low (Positioning) Speed (r/S)	100-500	210	Setting Positioning Speed
P56	Needles Goes Up Automatically as Power turned on	0-2	1	0: always not to find a position 1: always looking for positioning 2: If the motor is positioned on the no longer find location (only with magnet motor)
P58	Up Position Adjustment	0-1440	40	Up Position Adjustment The needle will advance stop when the value decreased. The needle will delay stop when the value increased.

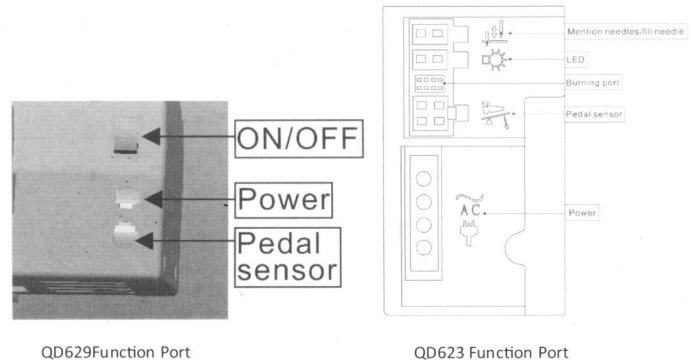
P59	Down Position Adjustment	0-1440	650	Down Position Adjustment The needle will advance stop when the value decreased. The needle will delay stop when the value increased.
P60	Testing Speed (r/S)	200-5000	2200	Setting testing speed.
P61	Testing A	0-1	0	Option of Testing A, after setting press 【060. TV】 to set the speed keep running.
P62	Testing B	0-1	0	Option of Testing B, after setting press 【060. TV】 to set the speed execute the cycle of Start - Sewing - Stop - Trimming
P63	Testing C	0-1	0	Option of Testing C, after setting press【060. TV】 to set the speed execute the cycle of Start - Sewing - Stop without positioning function
P64	Running Time of Testing B and C	1-250	20	Setting running time of testing B and C
P65	Stop Time of Testing B and C	1-250	20	Setting stop time of testing B and C
P66	Machine Protection Switch Testing	0-2	1	0: Disable. 1: Testing zero signal. 2: Testing positive signal
P67	Trimming Protection Switch Testing	0-1	0	OFF: Disable ON: Enable
Press and hold the [P], [S] key while the boot				
P70	The factory Type Selection	1-10		
P72	The needle position correction	0-1440	-	Hand rotation manual to the appropriate position, press S key to save
P73	Under needle position correction	0-1440		Hand rotation manual to the appropriate position, press S key to save
P84	Thick start angle	0-359	9	
P85	The thick end angle	0-359	57	
P92	Encoder start angle		160	View manual 1.5 chapter

**3 Error Code List**

Error Code	Problem	Strategies
E01	1) Power ON, the main voltage detection is too high 2) When the supply voltage is too high	Turn off the system power supply, and detect whether the supply voltage is correct. (Or exceed the rated voltage specified in use.) If correct, please replace the control box and inform the factory
E02	1) Power ON, the main voltage detection is too high 2) When the supply voltage is too high	Turn off the system power supply, and detect whether the supply voltage is correct. (Or exceed the rated voltage specified in use.) If correct, please replace the control box and inform the factory
E03	Operation panel and CPU transmission communication exception	Turn off the system power, check the operation panel interface is loose If contact is good, please change the operation panel. If it is not operated, the control box is damaged, please change
E05	Control of the contact of the device	Off the system power supply, check and control the connector is loose or fall off, Will resume normal after the restart system If you still can not work normally, please replace the speed controller and notify the manufacturer.

E07	a) Motor plug wiring contact is not transferred b) Lock head or motor belt foreign body in the card die c) The machine is too thick, the motor torque is not enough. d) Module driven output exception	Rotating head motor hand wheel observation is stuckIf stuck, the first rule out mechanical failure Such as rotation normal Check the motor encoder connector and motor power cable joints are loose If there is a loose please revise Such as good contact Check the supply voltage of the power supply voltage is too high or too high if you have to adjust As normal, please replace the control box and notify the manufacturer.
E9 E11	Synchronizer signal error.	Power off system Check the motor encoder interface is loose or off Will resume normal after the restart system If you still can not work normally, please inform the factory and replace the motor.
E14	Encoder signal exception	Turn off the system power Check the motor encoder interface is loose or off Will resume normal after the restart system If you still can not work normally, please replace the motor and notify the manufacturer.
E15	Power module is not normal overcurrent protection	Turn off the system power, and then restart If you still can not work normally, please inform the factory and replace the motor.
E17	Head protection switch is not in the correct position	Turn off the system power, check the nose is opened, the head switch is damaged.
E20	Motor starting failure	After driving the motor does not rotate, do not look for the encoder reference point

**4. Port Outline Diagram**



QD629 Function Port

QD623 Function Port