

57X operating manual V1.1

1. Safety instruction

Please read the operation manual and related sewing machinery datasheet carefully before correct use.

- 1.1** (1) Power voltage and frequency: please refer to motor and control box nameplate.
 (2) Interference from electromagnetic wave: please keep far away strong magnetic or high radiation environment in order to avoid obstructions and make to misoperation.
 (3) Grounding: to avoid the noise obstructions or leakage of electricity accident (including sewing machine, motor, control box and positioner).
- 1.2** Please make sure power off at least 1min and then can open control box cover, because there are dangerous high voltage.
- 1.3** Please turn off the power while repairing or wearing needle in order to protect operator's safety.
- 1.4** ⚠ Used where potential dangers exist.

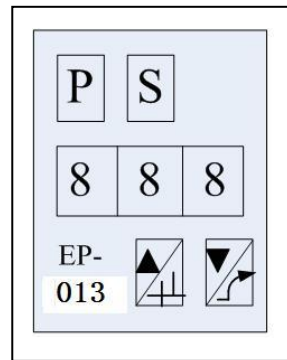
⚡ Used where high voltage and electric danger exist.

- 1.5** Product warranty period of one year on condition that this machine is operated correctly and no man-made damage.

2. Instructions for Operation Box

2.1 key functional specification

No	Keys	Functions
1		Function keys
2		Save button
3		Add key / needle up and down bit composite key
4		Minus key / soft-start composite key.



2.2 Monitor mode

Standby, press the "S" key for 2 seconds into the monitoring status, press ▲ ▼ to change monitor serial number, monitor value can not be modified. Specific display content:

show frame numbers	Item Name	unit	show frame numbers	Item Name	unit
SPD	speed	(*10) rpm	DJ	Angle	limit
CUR	Current	0.01A	VER	version	/
UDC	Voltage	V			

Press the S key to enter to a specific value, press P to exit and return to the standby state.

3. Parameter list of lockstitch sewing machine

No	Items	Settings range	Default	Remarks
1	highest speed of pedal	200~5000rpm	4000	indicates the range from 20 to 500, while the real range is 200 to 5000
2	Soft Start	1~10	2	needle number of soft start
3	soft start speed 1	200~2000rpm	600	
4	soft start speed 2	200~2000rpm	1000	
5	soft start speed 3	200~2000rpm	1500	
8	Simple sewing mode Settings	0~1	0	0: unavailable 1: available
9	Power on and positioning	0~1	0	0: unavailable 1: available
11	Pedal curve selection	0~2	0	0: normal 1: Slow acceleration 2: Quick acceleration
20	return to factory-set parameter	0~2	0	0: Do not restore 1: restore general parameters 2: restore advanced
*21	highest speed of sewing	2000~7000rpm	5000	
*22	Afterburner low speed gear selection	0~15	0	0: no afterburner 1~15: too thick afterburner stalls
*23	Reference position adjustment	0~359	0	The smallest unit 1°
*25	The neutral position of the pedal	-15~+15	0	
*26	Pedal travel upon start	10~50	25	
*27	Pedal travel upon acceleration	10~100	50	
*28	Pedal travel at highest rotation speed	10~150	110	
*29	Pedal travel upon presser foot lift	-99~-10	-30	
*31	The aging rate	300~5000rpm	3500	
*32	Aging run-time	20~600	30	The smallest unit 0.1s
*33	aging pause time	2~60	20	The smallest unit 0.1s

Note: 1 to 11 General parameters, more than 21 for the advanced parameters only into the advanced parameters, P20 can only be set to 2, P20 recovery is completed automatically reset to 0.

4. Error Code Table

Codes	Contents	Checking and treatment	Codes	Contents	Checking and treatment
E1	Over-current of hardware	Check if it is well earthed Whether the damage to the device driver	E10	Low voltage runtime	Check if it is well earthed. Current detection loop system is working properly
E2	Whether the damage to the device driver	Check if it is well earthed Current detection loop system is working properly	E11	HALLA signal loss	Check the motor signal cord
E3	System voltage is too high	System into line voltage is too high	E12	Motor overload	Check the sewing machine is not jammed. Actual operating excessively frequent acceleration and deceleration
E4	System voltage is too low	System into line voltage is too low	E13	EEPROM error	seek technical support
E5	High voltage runtime	System into line voltage is too high	E14	Current detection of non-normal	seek technical support
E6	Needle stop signal failure	Check if the needle connector is loose	E15	Pedal zero point exceeds the range	Pedal zero point exceeds the setting range
E7	Motor HALL Signal failure	Check the motor connector for poor connection.	E16	OZ circuit of non-normal	seek technical support
E8	Locked rotor failure of motor	Check if the motor wire is well connected, and if it is overloaded	E17	Motor reverse	Check motor phase sequence and signal lines
E9	Over-speed failure	Check if the motor wire connection is correct	E18	motor failure angle	Check motor phase sequence and signal lines Check whether the motor is stuck

Note: If the above according to check the project cannot rule out fault, please seek technical support.

5. ACCESSORY

No.	Product name	Amount	Product specification	Confirm	Remarks
1	Electric control box	1			
2	Power cord	1			
3	pedal	1	PL-302		
4	Ball section connecting rod	1			
5	screw	3	M4×20		
6	screw	3	M5×25		
7	The instructions	1			