

横织机电脑

Flat Knitting Machine

F1X7

版本号：1.7.0

操作手册

OWNER'S MANUAL

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

Chapter 1 General Information

Thank you for using the Computerized Control System for Flat Knitting Machine developed by Beijing DAHAO Technology Corp., Ltd. It is appreciated that you do read this manual carefully so as to operate the machine correctly and effectively. Besides that, you should keep this manual properly for future use.





1.1 Security Items

 Caution	The machine's power system is strictly restricted on its nameplate, and if the input voltage fluctuation is over a range of $\pm 10\%$, one voltage regulator will be of necessity.
 Caution	The power wires must be fixed and have safety protection.
 Caution	The machine should be grounded with the earth terminal, or you may be struck by electricity.
 Caution	Don't try to repair the electrical components by yourself. Otherwise, it may depress the equipment's capability, thus causes the system's instability, enlarges malfunction's bound or even makes personnel injury and the loss of property.
 Caution	DO NOT open the controller box while power on! Some parts inside box have high voltage!
 Warning	Open the cover of controller box after switching off the power. And you must wait more than 1 minute to let the capacitors discharge before touching the spare parts inside.
 Forbidden	Never touch any running parts at embroidering; otherwise it may easy to cause the injury.
 Forbidden	Never run the machine if the running parts have not shields!
 Forbidden	Never expose the machine to humidity gas, poisonous gas, water, and dust.
 Forbidden	It is forbidden to test the insulation of the circuit loop directly, or the devices may be destroyed.

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 Warning	Don't use the circuit parts that are not from our company. Otherwise, fire, electric shock and serious damages may occur.
 Caution	Replacement of fuse must abide by the specification!

1.2 General Items

 Attention	The power switch of this product has the function of over-current protection. If this function is actuated, the switch can't be closed in 3 minutes.
 Attention	The machine should have a dry, clean and ventilated environment. User need clean the machine regularly.
 Attention	The amendment of the owner's manual shall be performed in term of adding appendix. If the content in the appendixes is different to that in the original owner's manual, the content in the new appendix shall take precedence.
 Attention	We are not responsible for the consequences caused by any unauthorized alteration of this machine.

1.3 Main Technical Specifications

Number of Machine	5~16
Knitting speed	1.2 m/s
System	Single Head Double System
Amount of feeders	16
Device for needle selection	Bipolarity, 24V
Density	Driven by stepping motor. Selection at 24 different parameters for this item is supported. The range for each parameter is at 0~650.
Rocking	Driven by servo motor. One inch for both sides (left and right) respectively. The Selection at 24 different parameters for this item is supported. The range for each parameter is at 0~100.
Roller	Driven by torque motor. The Selection at 24 different parameters on this item is supported (The range for each parameter is at

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	0~100). Or Driven by step motor. The Selection at 24 different parameters on this item is supported (The range for each parameter is at 0~200).
Sinker	Driven by step motor
Main motor	General servo motor
Mode of Transmission	Synchronizing tooth belt, run in reciprocation
Device for Determining Needle Position	Encoder
Circumstances for automatic stop	Thread – floating, yarn-breaking, needle-crashing, knots, reversed cloth, abnormal cloth-falling, over temperature, yarn used-up.
System Voltage	220V
Battery	UPS
Memory	Computer memory: 32MB
Ports for Pattern transfer	1 or 2 USB ports
Screen	10.4 inch or 8.4 inch
Pattern-making Software Supported	Picasso1.0, Picasso2.14, Picasso5.01, Mai Hong2.5, Mai Hong 3.0, Heng Qiang560, Heng Qiang 710, Heng Qiang 750, Zhi Ge3.2.1

1.4 Function Introduction

1.4.1 Adjustment on Speed

The knitting speed is adjustable.

1.4.2 Accuracy Control on Needle Selection

The high-frequency solenoid can pick up each needle accurately.

1.4.3 Yarn-breakage Detection

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If the circumstances, such as yarn breakage, knot, or yarn used –up, occur at the knitting, the system will stop the machine automatically and give warning.

1.4.4 Color-changing

Yarn feeders, (2*8 groups, 16 feeders in total) installed at the both sides of 4 guides, allow the users to shift them at any position on needle bed.

1.4.5 Capacity of Pattern

The external pattern shall be saved into the memory before knitting. The basic memory of this system is 1024*4096 stitches. But this capacity can be enlarged according to the users' demands (for the different models, the basic capacity of memory is not same).

1.4.6 Number of Patterns Stored

The system can store 400 patterns at most (For the different models, the number of patterns stored is not same). This number is the max amount of the patterns stored at the memory.

1.4.7 Pattern Input/output via U Disk

There is USB port on the control box. Via the U disk, user can upload the patterns to the memory. Via the same port, the patterns in the memory can be downloaded to U disk in certain format.

1.4.8 Repetition of Knitting

For the existing pattern, user can use this function to realize the automatic start-up. The number of repetition can be set. After the set rows are knitted, the machine starts to perform the normal knitting.

1.4.9 Cyclic Knitting

When activating this function, the machine will continue the knitting upon the completion of the set cycle.

1.4.10 Jumping Row Knitting

The user can arrange the pointed patterns to jump to a random row for knitting.

1.4.11 Continue after Black-out

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The system can remember the working status at the moment of instantaneous power-off, thus enables the machine to continue the working after the sudden black-out.

1.4.12 Notebook

The system will automatically record the information of problem so that user can easily find out the reason of that problem.

1.4.13 Edition to Pattern in Memory

User can edit the patterns in memory or have parts of the pattern modified.

1.4.14 Touching Panel

User can operate each main function of machine on the touching panel.

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