

Version-1

Num.	Parameter	Name	Value	Unit	Mark-1	Mark-2
1	1	Automatic feeding motor speed	9999	pulse		
2	2	Manual feed motor speed	1250	pulse		
3	3	Fine-tune dwell motor speed	520	pulse		
4	4	Feeding alarm length	3200	pulse	The larger the value, the farther the sensor travels	
5	5	Manufacturer's internal testing	1	Number		
6	6	Cutter cutting speed	8200	pulse		
7	7	Cutter retraction speed	8000	pulse		
8	8	Cutter stroke	2000	pulse		
9	9	After cutting the pins, open the distance	1300	pulse	When set to 0, it will not go back after cutting. When set to non-0, the cutting return is returned according to the set value.	You can directly set this to a large size After cutting the feet, release the cutter immediately
10	J	Manufacturer's internal testing	0			
11	K	Time interval for picking up and refeeding components	0	ms	The longer the delay, the longer the interval between material removal and feeding. Default setting: 0	
12	L	Host computer starts	0	switch	Set to 0, the host computer does not need to be started, and it will always start when you press start. Set to 1, when the host computer is not started, Feida will no longer feed materials automatically.	
13	M	The rise and fall of the required signal	1	switch	Default setting: 0 Set to 0, it is a rising edge, and it will act as soon as it is triggered. Set to 1, it is a falling edge, and it will only act when the trigger signal ends.	When using rising and falling edges Directly through the machine's communication line, rising edge Release delay and drop can be adjusted during communication along Release the cutter without delaying the disconnection.
14	N	Nozzle sensing delay	0	ms	X12 is not enabled when set to 0. X12 is enabled and delayed when the bit is set to a non-0 value.	When using nozzle induction, you can control the cutter looseness by changing this delay.
15	O	Protective function	10	Analog quantity	Initial use period 1 month	
16	P	Cutter release delay while rising	0	ms	The rise delay is used to determine how long the signal is delayed to release the cutter.	When using the rising edge, you can change this delay to control when the cutter is released.
17	Q	Feeding several grids and cutting lead	1		Set 1 with split slices (alarm number related)	

Remark:

When communication is used, M is set to 1; when fiber optic sensing nozzle is used, M is set to 0.

1: Automatic operation display: Auto1; Manual operation display: Manu2: Press and hold the stop button on Manu2 to enter the parameter modification interface 1-9; J-O, press the start button to exit parameter modification.

3: Press and hold the stop button in Manu2 to enter the parameter changing interface. Continue to press and hold the stop button. The MMMMMM mode appears, which is the mode for adjusting the material residence position. At this point model, press the last button to sense the material, press the forward and backward buttons to achieve position compensation, and press the start button to exit the fine-tuning position.

4: When Feeder alarms, ERR appears on the screen

(4.1) err01: The material feeding exceeds the set length, and the material has not been sensed yet, and the alarm is issued. Press reset to clear the alarm.

(4.2) err02: The sensor of the cutter returning to the origin is abnormal. Press reset to clear this alarm.

5: Adjust the driver current of P006 to 2.2A and the percentage to 50%

6: Set the subdivision to 0 subdivision, 1OFF, 2OFF.

7: SD-TX, RD-RX

8: D243: Compensation parameter display value



Version-2

Num.	Parameter	Value	Unit	Mark
1	A	70	pulse	The smaller the value, the faster the speed
2	B	100	pulse	The smaller the value, the faster the speed. This value is always smaller than the M value.
3	C	500	pulse	The larger the value, the greater the cutter stroke (this value increases)
4	D	650	pulse	The larger the value, the farther the sensor travels
5	E	1		
6	F	40	ms	The longer the delay, the longer the interval between material removal and feeding.
7	G	1	switch	Default setting: 0 Set to 0, the cutter will loosen the material after cutting; set to 1, the cutter will not loosen the material after cutting.
8	H	0	switch	Default setting: 0 Set to 0, the cutter will loosen the material after cutting; set to 1, the cutter will not loosen the material after cutting.
9	I	1	switch	Default setting: 0 Set to 0: No material request signal is required; Setting 1: Material request signal from the host computer is required
10	J	0		
11	K	4	pulse	The smaller the value, the faster the speed
12	L	70	pulse	Set this value to 50
13	M	138	pulse	The smaller the value, the faster the speed. This value is always greater than the B code parameter.
14	N	1	switch	Default setting: 0 Set to 0, it is a rising edge, and it will act as soon as it is triggered. Set to 1, it is a falling edge, and it will only act when the trigger signal ends.
15	O	70	pulse	The smaller the value, the faster the speed
16	P	20	ms	When set to 0, X12 is not enabled. If the bit is set to a value other than 0, X12 is enabled and is a delay.
17	Q	10	Analog quantity	
18	R	50	ms	When set to 0, there is always a material signal, and the setting bit value other than 0 is a delay
19	S	100	pulse	When set to 0, it will not go back after cutting. When set to non-0, the cutting return is returned according to the set value.
20	T	30	pulse	The smaller the value, the faster the speed. At this time, the pulse setting should be larger and the motor will move forward slowly.

Remark:

- (1) When I is enabled (when using line communication), P must be set to 0.
- (2) When X12 in P is enabled, I should be set to 1.
- (3) During automatic operation, when the P parameter is enabled, press the cutter button to keep the cutter from loosening, and press the start button again to release the cutter from loosening.
- (4) MMMMMM mode is the mode for adjusting the material stop position. In this mode, the material position will be automatically saved after adjustment.

Instructions:

- 1: Press start to execute AUTO automatic operation.
- 2: When changing parameters, long press MANU, and the codes A, B, and C will appear for more than 3 seconds. At this time, press the up and down keys to change the parameters. After changing, continue to modify the next parameter.
To exit the parameter changing interface, directly press Start or the cutter button to quickly exit the parameter changing interface.
- 3: When 6 M appear on the screen: press the forward and backward buttons to adjust the position where the material stays.
- 4: When Feida alarms, ERR appears on the screen
 - (4.1) err01: The material feeding exceeds the set length, and the material has not been sensed yet, and the alarm is issued. Press reset to clear the alarm.
 - (4.2) err02: The sensor of the cutter returning to the origin is abnormal. Press reset to clear this alarm.
- 5: Adjust the driver current of P006 to 2.2A and the percentage to 50%
- 6: Set subdivision to 0 subdivision, 1OFF, 2OFF

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