

MType-Delta

Parameter List










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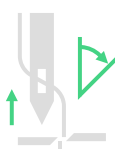
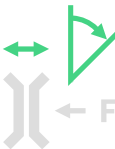




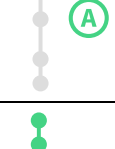

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Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---|--|---|
| T 02 03 | - | - | 1 | Thread trimmer |  | Thread trimmer On/Off |
| T 02 05 | - | - | - | KFA Version |  | Select the version of the KFA thread trimmer system |
| T 02 00 | 500 | 50 | 150 | Speed |  | Speed of the machine during thread cutting. (Value range 50 - 250 [rpm]) |
| T 02 10 | 359 | 0 | 125 | Start thread trim |  | Needle position when the magnet of the thread cutter is activated. (Value range 0 - 359 [°]) |
| T 02 11 | 359 | 0 | 20 | Stop thread trim |  | Needle position when the magnet of the thread cutter is deactivated. (Value range 0 - 359 [°]) |
| T 08 12 | 359 | 0 | 120 | Lower needle position |  | Lower needle position at stop during the sewing process. (Value range 0 - 359 [°]) |
| T 08 13 | 359 | 0 | 70 | Needle position after thread trimming |  | Needle position after thread cutting before reversal. (Value range 0 - 359 [°]) |
| T 12 00 | - | - | 1 | Turn back |  | Reversal after cutting the thread is active or inactive. (Value range On/Off) |
| | 1000 | 0 | 80 | Duration till thread trimmer reactivate after thread trimming |  | Duration till trimming start |

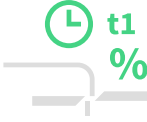

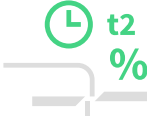



Parameter List

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|---------------|------------|------------|----------------|---|--|--|
| | 1000 | 0 | 80 | Duration till thread trimmer deactivate after thread trimming |  | Duration till trimming end |
| T 12 01 | 359 | 0 | 30 | Needle position after turn back |  | Needle position after thread cutting (reversal position); the needle is set upward to reach the full lifting height, and the needle lever is then no longer at top dead center. (Value range 0 - 359 [°]) |
| T 09 10 | 359 | 0 | 340 | Needle thread tension open |  | Needle position at which the needle thread tension switches to the value for thread cutting. (Value range 0 - 359 [°]) |
| T 09 11 | 359 | 0 | 71 | Needle thread tension close |  | Needle position at which the standard needle thread tension is used again after thread cutting. (Value range 0 - 359 [°]) |
| T 09 12 | 50 | 0 | 0 | Needle thread tension thread trim |  | Needle thread tension during thread cutting (Value range 0 - 50 [%]) |
| T 09 13 | 5 | 0 | 0 | Needle thread tension thread trim (left) |  | Needle thread tension during thread cutting (left) (Value range 0 - 50 [%]) |
| T 09 21 | 200 | 0 | 20 | t needle thread tension thread trim |  | Delay, until the standard needle thread tension is used again. (Value range 0 - 200 [ms]) |
| T 31 02 | - | - | 0 | Automatic start short stitches |  | Short stitches at seam begin are automatically switched on when the defined stitch length is exceeded. |
| T 31 03 | 12 | 0 | 7 | Stitch length switch level |  | Value of stitch length from which short stitches will be performed. |


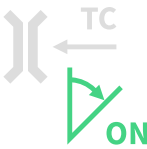
Parameter List

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|---------------|------------|------------|----------------|--|---|---|
| T 31 00 | 99 | 0 | 0 | Number of short stitches at seam begin |  | Number of short stitches at the seam start; advisable for neat starts to sewing. (Value range 0 - 99) |
| T 31 01 | 99 | 0 | 1 | Number of short stitch at seam end |  | Number of short stitches at the seam end, to ensure that the length difference between the needle thread and the hook thread is (visually) as small as possible. (Value range 0 - 99) |
| T 31 10 | 12 | -12 | 1.5 | Stitch length |  | Stitch length of the short stitches, generally between 1.0 - 1.5 [mm]. |
| T 02 20 | - | - | 0 | Change of stitch length |  | Adjust parameter of stitch length adaption (On/Off) |
| T 02 21 | 10 | 1 | 1 | Stitch length |  | Optimisation of remaining thread length for different trimming systems (KFA = 1, very short; LFA = 10; very long) |
| T 02 22 | 359 | 0 | 180 | On |  | Needle position at which the stitch length change is activated. (Value range 0 - 359 [°]) |
| T 02 23 | 359 | 0 | 60 | Off |  | Needle position at which the stitch length change is disabled. (Value range 0 - 359 [°]) |
| T 02 04 | - | - | 0 | Thread trimming backward stitch |  | Thread cutting during backward stitch. (Value range On/Off) |
| T 02 50 | 1000 | 0 | 500 | Activation time t1 [ms] |  | t1 [ms] Activation duration of the thread cutter in time period t1. (Value range 0 - 1000 [ms]) |

Parameter List

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| T 02 51 | 100 | 0 | 100 | Duty cycle t1 [%] |  | Duty cycle t1 [%] Duty cycle in time period t2 (Value range 0 - 100 [%]) |
| T 02 52 | 600 | 0 | 50 | Time t2 |  | t2 [s] Activation duration of the thread cutter in time period t2. (Value range 0 - 1000 [ms]) |
| T 02 53 | 100 | 0 | 40 | Duty cycle t2 |  | Duty cycle t2 [%] Duty cycle in time period t2 (Value range 0 - 100 [%]) |
| T 02 54 | - | - | 1 | Boost |  | Voltage increasing when thread trimmer is activated 0= no, 1= yes |
| T 01 03 | - | - | 0 | Needle thread clamp |  | Needle thread clamp (On/Off) |
| T 01 00 | 10 | 0 | 6 | Mode |  | Mode of thread clamp 0 = TC switch-on angle = T 01 01, TC switch-off angle = T 01 02, Without FL; 1 = TC switch-on angle = 213°, TC switch-off angle = 13°, Without FL; 2 = TC switch-on angle = 154°, TC switch-off angle = 225°, Without FL; 3 = TC switch-on angle = 154°, TC switch-off angle = 295°, Without FL; 4 = TC switch-on angle = 213°, TC switch-off angle = 13°, FL switch-on angle = 213°, FL switch-off angle = 259°; 5 = TC switch-on angle = 213°, |

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| | | | | | | <p>TC switch-off angle = 13°, FL switch-on angle = 149°, FL switch-off angle = 259°; 6 = TC switch-on angle = 180°, TC switch-off angle = 320°, FL switch-on angle = 165°, FL switch-off angle = 225°, FL switch-off angle, additionally stroke-dependent; 7 = Without TC, FL switch-on angle = T 01 11, FL switch-off angle = T 01 12, 8 = TC switch-on angle = T 01 01, TC switch-off angle = T 01 02, FL switch-on angle = T 01 11, FL switch-off angle = T 01 12; 9 = Without TC, FL switch-on angle = T 01 11, FL switch-off angle = 5.2.2.3.2, FL switch-off angle, additionally stroke-dependent; 10 = TC switch-on angle = T 01 01, TC switch-off angle = T 01 02, FL switch-on angle = T 01 11, FL switch-off angle = T 01 12, FL switch-off angle, additionally stroke-dependent;</p> |
| T 01 04 | - | - | 0 | Material thickness compensation |  | Compensation for material thickness. (Value range On/Off) |
| T 01 01 | 359 | 0 | 180 | On |  | Needle position for activating the thread clamp. (Value range 0 - 359 [°]) |







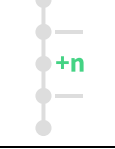


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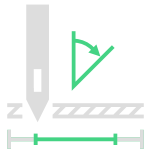
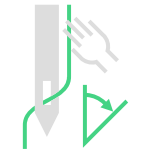
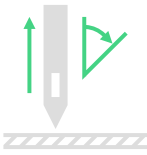
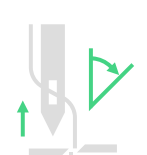
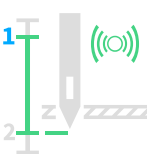
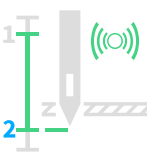
| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------|------------|--|
| T 01 02 | 359 | 0 | 320 | Off | | Needle position for deactivating the thread clamp. (Value range 0 - 359 [°]) |
| T 01 11 | 359 | 0 | 165 | On | | Needle position for lifting the sewing feet, to release a thread jammed underneath. (Value range 0 - 359 [°]) |
| T 01 12 | 359 | 0 | 260 | Off | | Needle position for lowering the sewing feet, to release a thread jammed underneath. (Value range 0 - 359 [°]) |
| T 01 13 | 12 | 1 | 2 | Height | | Lifting height of the sewing feet. (Value range 1.0 - 12.0 [mm]) |
| T 01 14 | 20 | 0 | 1 | PrePressure | | Reduced value for sewing foot pressure during clamping cycle (0 = off). |
| T 01 15 | 9 | 0 | 1 | PreStroke | | Reduced value for sewing foot stroke during clamping cycle (0 = off). |
| T 01 20 | 3 | 0 | 2 | Option | | Mode of thread clamp 0 – at seam start only 1 – at seam start and during turn back after trimming 2 – at seam start and during sewing foot lift 3 – at seam start and during turn back after trimming and sewing foot lift |
| T 01 50 | 1000 | 0 | 200 | Activation time t1 [ms] | | t1 [ms] Activation duration of the thread clamp in time period t1. (Value range 000 - 1000 [ms]) |
| T 01 51 | 100 | 0 | 100 | Duty cycle t1 [%] | | Duty cycle t1 [%] Duty cycle in time period t2 (Value range 0 - 100 [%]) |

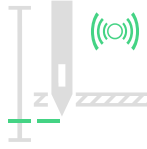
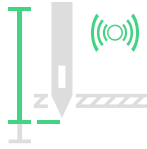

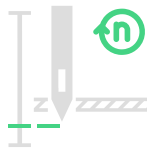

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|---------------|------------|------------|----------------|---------------|------------|---|
| T 01 52 | 600 | 0 | 60 | Time t2 | | t2 [s] Activation duration of the thread clamp in time period t2. (Value range 0 - 600 [s]) |
| T 01 53 | 100 | 0 | 30 | Duty cycle t2 | | Duty cycle t2 [%] Duty cycle in time period t2 (Value range 0 - 100 [%]) |
| T 01 54 | - | - | 1 | Boost | | Voltage increasing when thread clamp is activated. 0 = no, 1 = yes |
| T 01 30 | - | - | 0 | On/Off | | Thread clamp On/Off for NSB |
| T 01 31 | 1000 | 0 | 40 | Time delay | | Delay for switch on the NSB after thread trimming. |
| T 01 32 | 359 | 0 | 49 | Off | | Position to switch off the knife in first stitch. |
| T 01 34 | 359 | 0 | 52 | Off | | Switch-off angle of knife clamp in second stitch. |
| T 01 35 | 359 | 0 | 167 | On | | Position for the start of exhaust removal (Value range 000 - 359 [°]) |
| T 01 36 | 99999 | 0 | 500 | Off | | Duration of the exhaust removal (Value range 0 - 99999 [ms]) |

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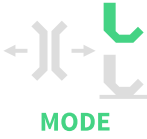
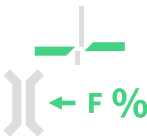
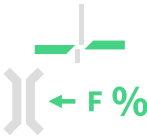
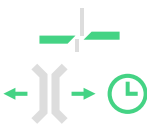
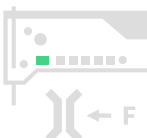
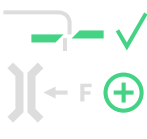

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|---------------|------------|------------|----------------|-------------------------------|--|---|
| T 08 00 | 4000 | 500 | 2800 | Max. Speed |  | Maximum permissible speed; it can no longer be exceeded on the operator level. (Value range 500 - 3800 [rpm], depending on subclass) |
| T 08 01 | 400 | 50 | 150 | Min. Speed |  | Minimum speed at which an individual stitch is made; a lower speed is no longer possible on the operator level. (Value range 50 - 400 [rpm]) |
| T 08 02 | 700 | 10 | 150 | Position speed |  | Position speed; the last stitch is made slower during stopping of the sewing procedure. (Value range 10 - 700 [rpm]) |
| T 05 00 | 1000 | 10 | 400 | Soft start speed |  | Speed for the soft start. (Value range 10 - 1000 [rpm]) |
| T 05 01 | 10 | 0 | 1 | Number of soft start stitches |  | Number of stitches to be made during a soft start. (Value range 0 - 10) |
| T 08 03 | 40 | 1 | 25 | Acceleration |  | Steepness of acceleration ramp (Value range 10 - 40 [rpm/ms]) |
| T 08 04 | 40 | 1 | 30 | Deceleration |  | Steepness of deceleration ramp (Value range 10 - 40 [rpm/ms]) |
| T 08 40 | 9999 | 150 | 3000 | Speed limitation DB3000 |  | Speed limitation DB3000 in rpm |
| T 08 41 | 9999 | 150 | 1800 | Speed limitation DB2000 |  | Speed limitation DB2000 in rpm |

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|------------------------------------|--|--|
| T 08 12 | 359 | 0 | 120 | Lower needle position |  | Lower needle position at stop during the sewing process. (Value range 0 - 359 [°]) |
| T 08 15 | 359 | 0 | 60 | Threading position |  | Needle position for the proper function of the threader, e.g. with thread lever at top dead center. (Value range 0 - 359 [°]) |
| T 08 16 | 359 | 0 | 30 | Needle position top |  | Holding position of the needle outside of the material. (Value range 0 - 359 [°]) |
| T 12 01 | 359 | 0 | 30 | Needle position after turn back |  | Needle position after thread cutting (reversal position); the needle is set upward to reach the full lifting height, and the needle lever is then no longer at top dead center. (Value range 0 - 359 [°]) |
| T 08 34 | 359 | 1 | 30 | Length of output function 'Pos. 1' |  | This parameter configures the rotary length (= angle) the output function "Pos. 1" is staying active. Whenever the "Lower needle position at stop during sewing process" (T 08 12) is reached the output "Pos. 1" is switched on and after turning forward for the here defined angle the output is switched off again. This function is usually needed for automation purposes to give feedback to a superior control system. (Value range 1 - 359 [°]) |
| T 08 35 | 359 | 1 | 30 | Length of output function 'Pos. 2' |  | This parameter configures the rotary length (= angle) the output function "Pos. 2" is staying active. Whenever the "Needle position after thread cutting (reversal position)" (T 12 01) is reached the output "Pos. 2" is switched on and after turning forward for the here defined angle the output is switched off again. This function is usually needed for automation purposes to give feedback to a superior control system. (Value range 1 - 359 [°]) |

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---|--|---|
| T 08 37 | 359 | 0 | 100 | Start angle of output function 'Pos.' |  | <p>This parameter configures an independent needle position at which the output signal "Pos." is getting active. Whenever the needle passes this position the output "Pos." is switched on.</p> <p>This function is usually needed for automation purposes to give feedback to a superior control system. (Value range 0 - 359 [°])</p> |
| T 08 38 | 359 | 1 | 180 | <p>This parameter configures the rotary length (= angle) the output function "Pos." is staying active. Whenever the independent needle position (T 08 37) is reached the output "Pos." is switched on and after turning forward for the here defined angle the output is switched off again. This function is usually needed for automation purposes to give feedback to a superior control system. (Value range 1 - 359 [°])</p> |  | TID_Help_SGP_PosLength |
| T 08 60 | - | - | 0 | Change speed on position |  | Change speed on position |
| T 08 61 | 330 | 0 | 270 | Position of speed change |  | Position of speed change |
| T 03 01 | 16 | 1 | 16 | Max. sewing foot lift |  | <p>Maximum lift height that the system may lift the sewing feet. (Value range with standard thread cutter 1.0 - 20.0 [mm]) (Value range for short thread cutter 1.0 - 18.0 [mm] due to raised throat plate)</p> |








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|---------------|------------|------------|----------------|--|------------|--|
| T 03 02 | 60 | 1 | 20 | Step motor speed | | Speed at which the sewing feet will be lifted. (Value range 1 - 60) |
| | 105 | 75 | 90 | Position to lift foot | | Start position angle for foot up |
| | 195 | 165 | 180 | Position to lower foot | | Start position angle for foot down |
| T 03 10 | 9 | 0 | 0.2 | Time till foot down | | Duration till foot down |
| T 03 11 | 9 | 0 | 0.04 | Duration till foot up after motor stop in seam | | Activation delay of sewing foot lift during a machine standstill |
| T 03 12 | 9 | 0 | 0.1 | Duration till foot up after motor stop at seam end | | Activation delay of sewing foot lift at seam end |
| T 03 13 | 9 | 0 | 0.2 | Time till foot up | | Duration till foot up |
| T 03 04 | 3 | 0 | 1.5 | Foot lighten position | | Foot lighten position |
| | - | - | 0 | Allow stitch with foot lifted | | |

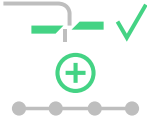

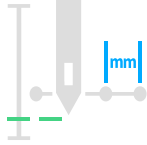

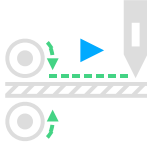
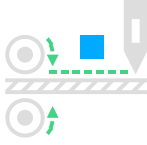
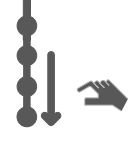
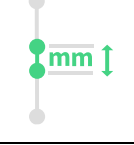
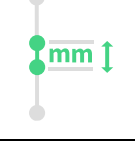
| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--|--|---|
| T 09 00 | 3 | 0 | 0 | Mode needle thread tension at sewing foot lift |  | <p>Mode for lifting the needle thread tension during active sewing foot lift.</p> <p>0 = Needle thread tension is not lifted</p> <p>1 = The needle thread tension is lifted as the sewing feet are lifted during sewing</p> <p>2 = The needle thread tension is lifted after thread cutting</p> <p>3 = The needle thread tension is lifted as the sewing feet are lifted during sewing and after thread cutting</p> |
| T 09 07 | - | - | 0 | Active |  | Pre-Tension active |
| T 09 01 | 99 | 0 | 0 | Pre-tension |  | <p>Setting of the pretension during thread cutting. A value of 0 is recommended as the pretension is generated by a mechanical tension.</p> <p>(Value range 0 - 99 [%])</p> |
| T 09 02 | 7 | 0.1 | 5 | Delay time |  | <p>The needle thread tension remains closed for a defined period of time after thread cutting and prevents the needle thread from being pulled further when the sewing material is removed. Without a thread cutter, this menu item should be set to a very low value.</p> <p>(Value range 0.1 - 7.5 [s])</p> |
| T 09 06 | - | - | 0 | Tension close by needle movement |  | With this function, the needle thread tension is activated when sewing start is done with jog dial (electronic handwheel) or via single stitch button. |
| T 09 04 | - | - | - | State After thread trimming |  | State after thread trimming for 2nd thread tension |
| T 09 05 | - | - | - | State After power on |  | State after power on for 2nd thread tension |

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------------------|------------|---|
| T 09 40 | - | - | 0 | Thread tension open at service stop | | Thread tension is open when service stop is active. |
| T 09 20 | - | - | - | Calibrations points | | Adjust the number of calibration points |
| T 09 03 | - | - | 0 | Additional thread tension | | If the second sewing foot stroke is switched on, the second needle thread tension is automatically activated (except in the case of material thickness detection). (Value range On/Off) |
| T 10 08 | 255 | 0 | 0 | Number of stitches 2. stroke off | | Number of stitches after which the second sewing foot stroke is automatically deactivated. (Value range 0 - 255) |
| T 10 10 | 4000 | 0 | 0 | Speed level | | Speed at which the second sewing foot stroke height is automatically activated. (Value range 0 - 4000 [rpm], depending on subclass) |
| T 10 11 | - | - | 0 | Quick stroke adjustment in tack | | 2nd sewing foot stroke height is automatically activated, even in backtack. (Value range On/Off) |
| T 10 01 | 4000 | 50 | 1800 | Speed | | As from the set value of the Min Stroke for the sewing foot stroke, the speed is reduced down to the desired value for the Max Stroke for the sewing foot stroke. (Value range 50 - 3800 [rpm], depending on subclass) |
| T 10 02 | 9 | 0 | 3 | Min. Sewing foot stroke | | Sewing foot stroke at which the speed reduction is initiated. (Value range 0.0 - 9.0 [mm]) |




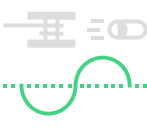
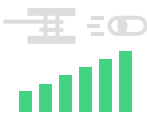
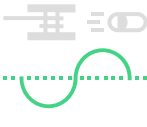


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------------------|--|---|
| T 10 03 | 9 | 0 | 6 | Max. Sewing foot stroke |  | Sewing foot stroke at which the reduced speed is reached. (Value range 0.0 - 9.0 [mm]) |
| T 30 10 | 9 | 3 | 6 | Max. stitch length |  | Maximum stitch length possible during sewing; this will vary depending on the sewing equipment and MUST be adjusted when changing the sewing equipment. When the value is changed, the machine requests a reset, i.e. switching off and on again. (Value range 2.0 - 12.0 [mm], depending on subclass) |
| T 30 11 | - | - | 1 | Manual stitch length adjustment |  | Stitch adjustment lever for manual adjustment of the stitch length active or inactive; optional equipment. (Value range On/Off) |
| T 30 12 | 4000 | 50 | 2000 | Sewing speed as from limitation end |  | Value of the sewing speed the stitch length dependent speed limitation ends its continuous limitation and goes on with constant limitation. (Value range 50 - 3800 [rpm], depending on subclass) |
| T 30 13 | 4000 | 50 | 3000 | Sewing speed at limitation start |  | Value of the sewing speed the stitch length dependent speed limitation starts with. (Value range 50 - 3800 [rpm], depending on subclass) |
| T 30 14 | 12 | 1 | 6.1 | Stitch length for limitation start |  | The sewing speed is limited continuously beginning from this set stitch length. (Value range 1.0 - 12.0 [mm], depending on subclass) |
| T 30 15 | 12 | 1 | 12 | Stitch length for limitation end |  | The sewing speed is limited continuously till this set stitch length. Above this stitch length the sewing speed is limited constantly. (Value range 1.0 - 12.0 [mm], depending on subclass) |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--|--|---|
| T 30 04 | - | - | - | State After thread trimming |  | State after thread trimming for 2nd stitch length |
| T 30 05 | - | - | - | State After power on |  | State after power on for 2nd stitch length |
| T 30 20 | - | - | 0 | Change stitch length at position |  | Change stitch length at position |
| T 30 30 | - | - | - | Feeding method |  | Transport mode of the wheel feeding Constant = Even transport Intermittent = Transport only with needle outside of material |
| T 30 21 | 350 | 0 | 150 | Start |  | Start angle for feed |
| T 30 22 | 350 | 0 | 210 | Stop |  | Stop angle for feed |
| | 5 | 0.1 | 2 | Manual stitch condensing stitch length |  | Stitch length for manual stitch condensing |
| T 30 22 | - | - | 1 | Auto reduced stitch length |  | Automatic stitch length setting for reduced stitch |
| T 30 23 | 6 | 0 | 2 | Stitch length of manual short stitch |  | Stitch length setting for manual short stitch |






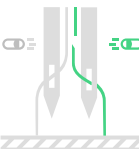
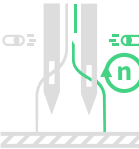
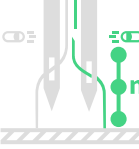
Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------------|--|--|
| T 06 00 | - | - | 0 | CAN - Bobbin monitor |  | Activation of the bobbin rotation monitor 0 = PCB 9850 867003 1 = CAN version (right bobbin) |
| T 06 01 | 1 | 0 | 1 | Mode of RFW |  | RFW 0 = Dynamic; 1 = Static |
| O 06 00 | - | - | - | Bobbin monitor mode |  | Mode of bobbin monitor Off = No monitoring of remaining thread capacity Software = Monitoring of remaining thread capacity by stitch counting Monitor = Use of remaining thread monitor (RFW) as optional equipment |
| T 06 04 | 4 | 0 | 1.7 | RFW Threshold |  | RFW Threshold left side |
| T 06 05 | 4 | 0 | 1.7 | RFW Intensity |  | RFW Intensity left side |
| T 06 02 | 4 | 0 | 1.7 | RFW Threshold |  | RFW Threshold right side |
| T 06 03 | 4 | 0 | 1.7 | RFW Intensity |  | RFW Intensity right side |
| O 06 20 | - | - | 1 | Sewing monitoring On/Off |  | With this function the sewing process monitoring can be activated/deactivated with regard to skip stitch detection (SSD), bobbin rotation monitoring (BRM) and remaining thread monitor (RFW). |

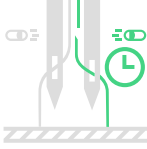
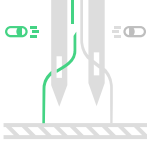
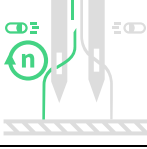
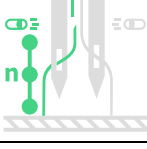
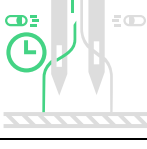



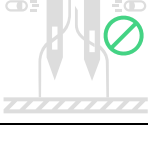
Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--|--|--|
| O 06 21 | - | - | - | Sewing monitoring side selection |  | Selection of the sensor at which the sewing process monitoring is deactivated when the function is switched off |
| O 06 06 | - | - | 0 | Motor stop |  | Sewing stops and a notice is shown on the display when the bobbin is detected to be nearly empty. If the parameter is not activated, only the LEDs on the machine arm give a warning if the bobbin is empty. |
| O 06 07 | - | - | 0 | Sewing foot lower position |  | The sewing feet will be in lower position after trimming. Sewing foot lift is blocked. |
| O 06 08 | - | - | 0 | Reset necessary |  | It is only possible to resume sewing after changing the bobbin and confirming the message on the control panel. |
| O 06 12 | - | - | - | Clean Mode |  | Clean Mode 0 = After Thread Cutting; 1 = During short stitches; |
| O 06 09 | 1000 | 0 | 200 | t Clean |  | Duration for which the lens is blown clear with compressed air. The process takes place as the thread is cut. |
| O 06 13 | 9000 | 0 | 100 | Cleaning interval |  | Interval (number of stitches) after which the lens is blown clear with compressed air. |
| T 06 05 | - | - | 0 | Repeat message after trim |  | The error message will be repeated after trimming (Value range On/Off) |
| T 06 06 | - | - | 0 | Confirmation after sewing stop necessary |  | The sewing process will be released by confirming the error message during sewing stop (Value range On/Off) |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------|--|---|
| T 06 07 | - | - | - | Hook surface |  | Adjust the hook surface |
| T 06 10 | - | - | 0 | Loop Control |  | Loop control (Value range On/Off) |
| T 06 16 | 100 | 0 | 100 | SSD Cleaning Threshold |  | SSD sensor contamination threshold. When this value is exceeded, an error message about SSD sensor contamination is displayed and the SSD sensor is blown. Entering a value of 0 disables the SSD sensor contamination check. |
| T 06 11 | - | - | 0 | Bobbin Rotation Monitor |  | Bobbin rotation monitor (Value range On/Off) |
| T 06 12 | 255 | 0 | 20 | Length |  | Delayed seam length before the bobbin rotation monitor starts. The machine calculates the number of stitches automatically depending on the value entered. (Value range 0 - 255) |
| T 06 23 | - | - | 0 | On/Off |  | Thread monitor right side On/Off |
| T 06 20 | 1000 | 50 | 200 | Speed |  | TID_SGP_ThreadMonitorRightStartSpeed |
| T 06 21 | 255 | 0 | 5 | Stitch delay |  | TID_SGP_ThreadMonitorRightDelayStitch |

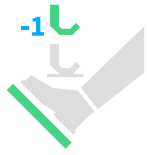


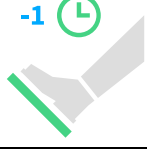
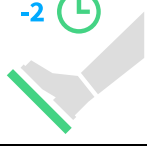
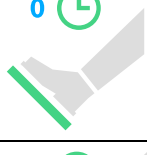


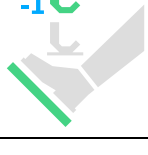
Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------|--|--|
| T 06 22 | 5000 | 0 | 2000 | Debouncing |  | TID_SGP_ThreadMonitorRightDebouncing |
| T 06 33 | - | - | 0 | On/Off |  | TID_SGP_ThreadMonitorLeftActive |
| T 06 30 | 1000 | 50 | 200 | Speed |  | TID_SGP_ThreadMonitorLeftStartSpeed |
| T 06 31 | 255 | 0 | 5 | Stitch delay |  | TID_SGP_ThreadMonitorLeftDelayStitch |
| T 06 32 | 5000 | 0 | 2000 | Debouncing |  | TID_SGP_ThreadMonitorLeftDebouncing |
| T 06 40 | - | - | 0 | Active |  | Active the bobbin thread monitor |
| T 06 41 | 2 | 0 | 0.1 | Delay |  | TID_Help_SGP_BobbinMonitorDelay |
| T 06 42 | 2 | 0 | 0.1 | Debouncing |  | TID_Help_SGP_BobbinMonitorDebounce |
| T 06 24 | - | - | 0 | Motor stop |  | Stops the motor if the needle thread is broken |



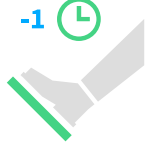


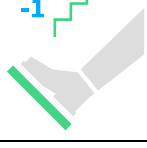
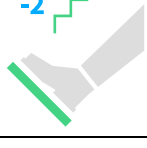
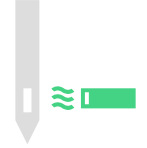

Parameter List


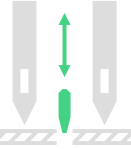

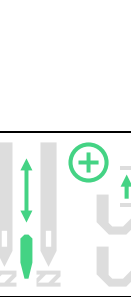
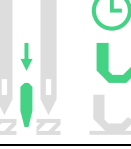

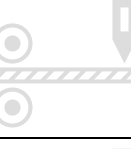

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---------------------------------|--|--|
| T 09 30 | - | - | 0 | On/Off |  | Sub menu for needle thread tension sensor |
| T 09 31 | - | - | 0 | Thread tension sensor mode |  | Every Stitch Signal |
| T 09 32 | - | - | 0 | Minimum value search |  | Minimum value search |
| T 09 40 | - | - | 0 | Needle thread tension regulator |  | Needle thread tension regulator |
| T 08 06 | - | - | - | Mode |  | Off = Holding force inactive On = Holding force active Hold Pos. = Position control; position is checked and resets itself |
| T 08 07 | 50 | 0 | 20 | Max. current |  | Holding current of the motor (Value range 0 - 50) |
| T 08 08 | 100 | 0 | 30 | Response |  | Response time for the continuous current (Value range 0 - 100) |
| T 08 25 | - | - | - | Type |  | DA Analog/Digital Choice between an analog and digital pedal. |
| T 08 26 | - | - | 1 | Inverted |  | Inversion of the signals given by the pedal (possibly necessary for digital setpoint devices). (Value range On/Off) |

Parameter List

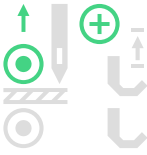
| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------|--|---|
| T 08 27 | - | - | - | Mode Pedal Pos. -1 |  | Toggle foot lifting |
| T 08 21 | 64 | 0 | 24 | Pedal steps |  | Number of speed steps processed by the pedal. (Value range 0 - 64) |
| T 08 22 | 7 | 0 | 0 | Curve |  | Speed curve of the pedal. |
| T 08 23 | 255 | 0 | 50 | t Position -1 |  | Debouncing of position -1 (Value range 0 - 255 [ms]) |
| T 08 24 | 255 | 0 | 15 | t Position -2 |  | Debouncing of position -2 (Value range 0 - 255 [ms]) |
| T 08 44 | 255 | 0 | 50 | t Position 0 |  | Debouncing of position 0 (Value range 0 - 255 [ms]) |
| T 08 75 | - | - | 0 | Enable Pedal 2 |  | Enabling a second analog pedal |
| T 08 76 | - | - | 1 | Inverted |  | Inversion of the signals given by the pedal (possibly necessary for digital setpoint devices). (Value range On/Off) |
| T 08 77 | - | - | - | Mode Pedal Pos. -1 |  | Toggle foot lifting |

Parameter List

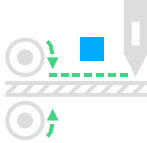
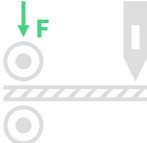

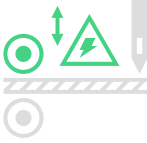

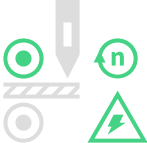
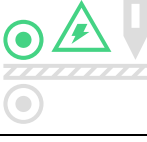


| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---------------------|--|---|
| T 08 71 | 64 | 0 | 24 | Pedal steps |  | Number of speed steps processed by the pedal. (Value range 0 - 64) |
| T 08 72 | 7 | 0 | 0 | Curve |  | Speed curve of the pedal. |
| T 08 73 | 255 | 0 | 50 | t Position -1 |  | Debouncing of position -1 (Value range 0 - 255 [ms]) |
| T 08 74 | 255 | 0 | 15 | t Position -2 |  | Debouncing of position -2 (Value range 0 - 255 [ms]) |
| T 08 45 | 255 | 0 | 50 | t Position 0 |  | Debouncing of position 0 (Value range 0 - 255 [ms]) |
| T 08 78 | 70 | 40 | 44 | Pedal factor for -1 |  | Pedal factor for -1 |
| T 08 79 | 70 | 1 | 54 | Pedal factor for -2 |  | Pedal factor for -2 |
| T 13 00 | - | - | - | Mode |  | Off = Needle cooling is deactivated. On = Needle cooling is activated. At Speed = Needle cooling is activated in relation to a defined speed Edge Trimmer = Needle cooling is activated when the edge trimmer is also activated. |
| T 13 01 | 10 | 0 | 2.5 | t Delay |  | Lag time, after which the needle cooling is deactivated. (Value range 0.0 - 10.0 [ms]) |

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-----------------------------------|--|--|
| T 13 02 | 6000 | 0 | 2000 | Cool Speed |  | Speed at which the needle cooling is activated. (Value range 0 - 3800 [rpm]) |
| T 14 06 | - | - | 0 | Seam center guide |  | Seam center guide (On/Off) |
| T 14 00 | - | - | - | Automatic functions |  | Mode for automatic raising of the seam center guide. Off = Raising of the seam center guide is deactivated; it is not raised automatically. On Tack = Raising of the seam center guide when sewing the backtack. On Lift = Raising of the seam center guide when lifting the sewing foot. Tack+Lift = Raising of the seam center guide when sewing the backtack and lifting the sewing foot. |
| T 14 01 | - | - | 0 | Raise by quick stroke adjustment |  | When the second stroke height is activated, the seam center guide is automatically raised. (Value range On/Off) |
| T 14 40 | 1000 | 0 | 100 | Delay lowering after foot lifting |  | Delay [ms] for lowering the seam center guide after start lowering the foot |
| T 14 41 | 1000 | 0 | 100 | Delay lifting after foot lifting |  | Delay [ms] for lifting the seam center guide after start to lift the foot |
| T 14 02 | - | - | 0 | Puller |  | Puller (On/Off) |
| T 14 03 | - | - | - | Automatic raise |  | Mode for automatic raising of the puller. Off = Raising of the puller is deactivated; it is not raised automatically. |



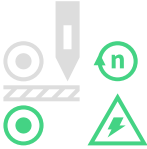





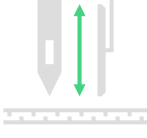
Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-----------------------------------|--|--|
| | | | | | | <p>On Tack = Raising of the puller when sewing the backtack.</p> <p>On Lift = Raising of the puller when lifting the sewing foot.</p> <p>Tack+Lift = Raising of the puller when sewing the backtack and lifting the sewing foot.</p> |
| T 14 04 | - | - | 0 | Raise by quick stroke adjustment |  | <p>When the second stroke height is activated, the puller is automatically raised. (Value range On/Off)</p> |
| T 14 05 | 999 | 0 | 110 | Lowering delay length |  | <p>Lowering the puller after seam begin. Depends on stitch length and application. (Value range 0.0 - 999.9 [mm])</p> |
| T 14 50 | 1000 | 0 | 100 | Delay lowering after foot lifting |  | <p>Delay [ms] for lowering the puller after start lowering the foot</p> |
| T 14 51 | 1000 | 0 | 100 | Delay lifting after foot lifting |  | <p>Delay [ms] for lifting the puller after start to lift the foot</p> |
| T 14 10 | - | - | - | Mode |  | <p>Setting defining which puller roller is supposed to run.</p> <p>Top+Bottom = Both wheels run actively under power</p> <p>Upper = The upper roller runs actively under power</p> |
| T 14 11 | - | - | - | Feeding method |  | <p>Transport mode of the rollers</p> <p>Constant = Even transport</p> <p>Intermittent = Transport adapted to the rhythm of the machine's feed dog</p> |
| T 14 12 | 359 | 0 | 135 | Start |  | <p>Setting of the start and stop angle under Start/Stop has been adapted to the machine. The values should not be changed.</p> |

Parameter List





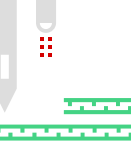
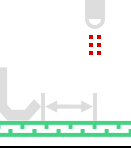
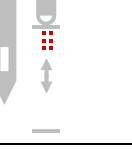
| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---------------------------------|--|---|
| T 14 13 | 359 | 0 | 255 | Stop |  | Setting of the start and stop angle under Start/Stop has been adapted to the machine. The values should not be changed. |
| T 14 14 | - | - | - | Pressure |  | Set the puller pressure Yes = Pressure is supplied constantly and regulated via the gage at the puller. HPNo = Pressure is generated actively except for the 2nd stroke height. No = No active pressure from puller. |
| T 14 15 | - | - | 0 | Switch off on sewing motor stop |  | Puller is not active when the sewing motor is stopped. Holding force of the roller is off; sewing material can be pulled out from between the rollers. |
| T 14 16 | - | - | 0 | Active when raised |  | Puller is always on even when raised. |
| T 14 20 | 65 | 0.01 | 1 | Transmission |  | Transmission, puller (Value range 0.0 - 65.0) |
| T 14 22 | 5 | 0.1 | 3.5 | Current feed (active) |  | Motor current, puller (Value range 0.0 - 5.0 [A]) |
| T 14 23 | 5 | 0.1 | 1 | Current feed (passive) |  | No-damage current, puller (Value range 0.0 - 5.0 [A]) |
| T 14 24 | 9999 | 1 | 50 | Diameter |  | Diameter, roller (Value range 0 - 9999 [mm]) |
| T 14 25 | - | - | 0 | Direction |  | Rotational direction, roller 0 = right 1 = left |

Parameter List

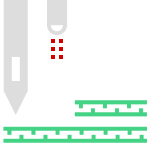
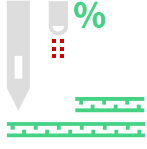





| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|------------------------|--|--|
| T 14 26 | - | - | 1 | Closed Loop |  | 0 = non-regulated (controlled operation) 1 = regulated |
| T 14 30 | 65 | 0.01 | 1 | Transmission |  | Transmission, puller (Value range 0.0 - 65.0) |
| T 14 32 | 5 | 0.1 | 3.5 | Current feed (active) |  | Motor current, puller (Value range 0.0 - 5.0 [A]) |
| T 14 33 | 5 | 0.1 | 1 | Current feed (passive) |  | No-damage current, puller (Value range 0.0 - 5.0 [A]) |
| T 14 34 | 9999 | 1 | 49 | Diameter |  | Diameter, roller (Value range 0 - 9999 [mm]) |
| T 14 35 | - | - | 1 | Direction |  | Rotational direction of roller 0 = right 1 = left |
| T 14 36 | - | - | 1 | Closed Loop |  | 0 = non-regulated (controlled operation) 1 = regulated |
| T 32 00 | - | - | 0 | Edge guide |  | Edge guide (On/Off) |
| T 32 20 | - | - | - | Edge guide mode |  | Please select the desired edge guide type 0 = Motor driven edge guide with 1-axis (X) and internal stepper motor card (DAC) 1 = Motor driven edge guide with 1-axis (X) and external stepper motor card (separate module) 2 = Motor driven edge guide with 2-axis (X |

Parameter List

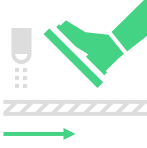







| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---------------------------------|------------|--|
| | | | | | | and Z) and external stepper motor cards (integrated in edge guide unit) |
| T 32 03 | - | - | 1 | Motor driven | | Selection whether it is an electromotive driven or an electro-pneumatic edge guide |
| T 32 04 | 1000 | 1 | 1000 | Transmission | | Edge guide transmission |
| T 32 01 | 60000 | 5000 | 25000 | Speed | | Travel speed of the edge guide. (Value range 500 - 60000 [Hz]) |
| T 32 02 | 36 | 1 | 8 | Min. gap | | Smallest possible gap between the sewing foot and the edge guide. This will vary depending on the sewing equipment and MUST be adjusted when changing the sewing equipment. CAUTION The entered value is the gap measured between the NEEDLE and the edge guide. (Value range 1.0 - 36.0 [mm]) |
| T 32 14 | 1000 | 1 | 1000 | Transmission (Height) | | Transmission of the edge guide |
| T 32 11 | 60000 | 5000 | 25000 | Speed (Height) | | Travel speed of the edge guide for the height |
| T 32 12 | 12 | 0.1 | 0.1 | Min. height | | Smallest possible height between throat plate and edge guide (straight or roll) (Value range 0.1 - 12.0 [mm]) |
| T 32 13 | - | - | 0 | Switch off collision protection | | Attention: The electronic edge guide is protected by security zones, it is impossible to drive the edge guide to these positions to prevent collisions. By activating this function, |

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--|--|---|
| | | | | | | you switch this collision protection off! There is a higher risk to drive crashes between edge guide and machine components. |
| T 27 00 | - | - | 1 | Material thickness detection |  | Material thickness detection (On/Off) |
| T 27 01 | 2 | 0 | 0.2 | Hysteresis |  | Tolerance at which the material thickness detection based on the second stitch length, the second needle thread tension and/or the second sewing foot stroke switches back. This tolerance is designed to ensure that there is no constant alternating between activation and deactivation in the boundary range. (Value range 0.0 - 2.0 [mm]) |
| T 27 02 | - | - | 0 | Pressure compensation |  | With extremely thick material the foot pressure increases above the standard set value due to the material thickness. To a certain extent, the machine can compensate itself for the influence of thick material. (Value range On/Off) |
| T 27 03 | - | - | 1 | Fabric compensation in backtack |  | Fabric compensation in backtack |
| | - | - | 0 | Perfect Quality Sensor (PQS) active |  | Enabled the functions of the Perfect Quality Sensor(PQS). Works only to a speed of 2200 1/min. |
| | 40 | 1 | 12 | Distance from the measuring point to the sewing foot |  | Please enter the distance from the measuring point to the sewing foot. It is necessary for the calculation of stitch delay. |
| | 100 | 0 | 65 | Configuration distance of the PQS |  | Distance from the measuring point to the PQS. It is the reference to calculate the thickness of the sewing material. |







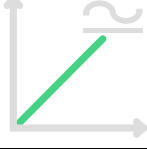


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---|--|--|
| | 100 | -10 | 0 | Measured fabric thickness before needle |  | It is the measured fabric thickness of the PQS. |
| | 100 | 0 | 0 | Signal quality PQS |  | This value shows the signal quality of the measurement by the Perfect Quality Sensor (PQS) in percent. 100% represents excellent signal quality. If the signal quality falls below 10%, no valuation is possible. |
| T 28 01 | 2000 | 0 | 100 | Hysteresis |  | Tolerance at which the correction of the effects of high speed based on the second stitch length, the second needle thread tension and/or the second sewing foot stroke switches back. This tolerance is designed to ensure that there is no constant alternating between activation and deactivation in the boundary range. (Value range 0.0 - 2.0 [mm]) |
| T 16 01 | - | - | 0 | Light barrier |  | Light barrier (On/Off) |
| T 16 00 | 2000 | 10 | 1000 | Speed |  | The last stitches after the detection of the end of the material (approx. 50 mm) can be sewn at a defined speed. (Value range 10 - 2000 [rpm]) |
| T 16 02 | - | - | 0 | Pedal start |  | Free = Pedal start On = Pedal can be pressed and the machine sews as soon as the material breaks the light barrier Off = Pedal is pressed but the machine does not start sewing; must be started from neutral position |
| T 16 04 | - | - | - | Sense |  | Dark = The signal is given when the light barrier is broken. Bright = The signal is given when the light barrier is complete. |








Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------|--|---|
| T 16 05 | - | - | 0 | Automatic |  | This setting is relevant only the material end detection is activated on the Operator level. On = The pedal starts a program, which runs automatically. Off = The pedal starts a program; the user determines the speed through the end of the program. |
| T 16 06 | 2 | 0 | 0 | Debouncing |  | Debouncing off the light barrier |
| T 07 10 | - | - | - | Length |  | Length = Seam sections are measured via the length specification (in mm). By Count = Seam sections are measured via the stitch count. |
| T 03 03 | - | - | - | Sewing foot lift |  | Down = The sewing foot is lowered in threading mode. Up = The sewing foot is lifted in threading mode. Pedal = The sewing foot can be lifted or lowered with the pedal in threading mode. |
| T 50 03 | - | - | 0 | Mode |  | Foot position during threading 0 = Foot position will not change 1 = Foot can lift and lowered with pedal |
| T 50 04 | - | - | 1 | Stitch length |  | Stitch length change active during machine blockage 0 = Off 1 = On |
| T 50 05 | - | - | 0 | All Inputs |  | All Inputs are active if machine blockage is active |
| T 00 47 | 4000 | 150 | 4000 | Max. sewing speed |  | Speed limitation for manual backtack 0 = Off |




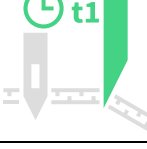
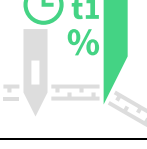

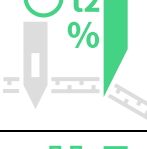

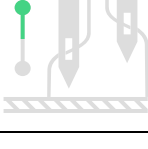
Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------------|--|--|
| T 00 48 | 1000 | 0 | 0 | t Change |  | Setting: Waiting time at turning point (t Change) of Manual Backtack The waiting time at the turning points (for example for a change of sewing direction) is set at this point. A short waiting time in milliseconds should ensure consistent seam quality (ornamental stitch backtack). |
| T 17 00 | - | - | 1 | Jog dial |  | Jog dial (On/Off) |
| T 17 01 | 255 | 0 | 22 | Transmission ratio |  | Transmission ratio for electronic handwheel |
| T 17 02 | - | - | 1 | Direction of rotation |  | Direction for electronic handwheel |
| T 17 03 | - | - | - | Reverse mode |  | Mode for reverse turning of electronic handwheel |
| T 17 04 | - | - | 0 | Stitch counting in programs |  | Stitches sewn by electronic handwheel are counted as stitches in segment. |
| T 26 00 | 4 | 1 | 2 | Progression of fullness curve |  | Adjustments for progression of fullness curve |
| | 50 | -50 | 0 | Fullness Minor Difference |  | |
| T 26 01 | 50 | -50 | 0 | Flat sewing top synced |  | Adjust parameter of fullness |

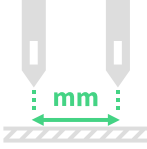








Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------------------------------|--|--|
| T 26 02 | 50 | -50 | 0 | Flat sewing bottom synced |  | |
| T 26 03 | - | - | 0 | Pulling instead of ruffling mode |  | Switches the machine from ruffling mode into pulling mode |
| T 15 01 | - | - | 0 | On/Off |  | Exist Edge trimmer |
| T 15 00 | 7 | 0 | 0 | Mode |  | <p>Mode for automatic raising of the edge trimmer</p> <p>0 = deactivated</p> <p>1 = foot lifting</p> <p>2 = after thread trim or stitch counting</p> <p>3 = after thread trim or stitch counting or foot lifting</p> <p>4 = backtack</p> <p>5 = backtack or foot lifting</p> <p>6 = backtack, after thread trim or stitch counting</p> <p>7 = backtack, after thread trim or stitch counting or foot lifting</p> |
| T 15 03 | 255 | 0 | 0 | Stitches to lower |  | Number of stitches until edge trimmer is lowered |
| T 15 04 | 255 | 0 | 0 | Stitches to raise |  | Number of stitches until edge trimmer is raised (only mode 2, 3 or 6) |
| T 15 12 | 100 | 0 | 50 | Min. duty cycle |  | Minimum edge trimmer motor PWM duty cycle |






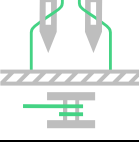

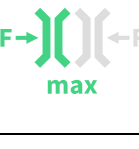

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---|--|---|
| T 15 13 | 100 | 0 | 100 | Max. duty cycle |  | Maximum edge trimmer motor PWM duty cycle |
| T 15 14 | 4000 | 0 | 1500 | Sewing speed reaching max. PWM duty cycle |  | Sewing speed at which the edge trimmer motor reaches the maximum PWM duty cycle |
| T 15 15 | 2 | 0 | 0.25 | t Delay |  | Delay for switching off the edge trimmer motor |
| T 15 50 | 1000 | 0 | 200 | Activation time t1 [ms] |  | Duration of the time period t1 (Value range 0 - 1000 [ms]) |
| T 15 51 | 100 | 0 | 100 | Duty cycle t1 [%] |  | Duty cycle in time period t1 (Value range 0 - 100 [%]) |
| T 15 52 | 600 | 0 | 500 | Time t2 |  | Duration of the time period t2 (Value range 0 - 60 [s]) |
| T 15 53 | 100 | 0 | 50 | Duty cycle t2 |  | Duty cycle in time period t2 (Value range 0 - 100 [%]) |
| T 15 54 | - | - | 0 | Boost |  | Voltage increasing when edge trimmer is activated 0 = Off 1 = On |
| | - | - | 0 | Switchable needle bar with stitch |  | Needle bar is switched automatically with additional stitch |


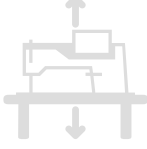
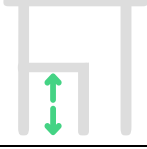
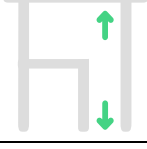





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--|--|---|
| | 14 | 2 | 10 | Distance between needle bars |  | Distance between the needle bars |
| T 08 32 | - | - | 0 | User start referencing manual |  | The user must press pedal -2 to start the referencing process |
| T 11 90 | - | - | 0 | Only one active function module is permitted |  | Only one active function module is permitted. |
| T 11 11 | - | - | 0 | Inverted |  | The function inverts the output. |
| T 11 21 | - | - | 0 | Inverted |  | The function inverts the output. |
| T 11 31 | - | - | 0 | Inverted |  | The function inverts the output. |
| T 11 41 | - | - | 0 | Inverted |  | The function inverts the output. |
| T 11 51 | - | - | 0 | Inverted |  | The function inverts the output. |
| T 11 61 | - | - | 0 | Inverted |  | The function inverts the output. |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|------------------------------------|--|---|
| T 11 71 | - | - | 0 | Inverted |  | The function inverts the output. |
| T 11 81 | - | - | 0 | Inverted |  | The function inverts the output. |
| T 63 00 | - | - | 0 | Scanner |  | Scanner (On/Off) |
| | - | - | 0 | Scan Program Barcode Strings |  | Enables loading a sewing program connected to a specific barcode string |
| | - | - | 0 | Release sewing by scanning barcode |  | Allows to prevent to sew until a specific barcode string has been scanned |
| | - | - | 0 | Barcode identification active |  | Activates the barcode identification |
| | - | - | 0 | Needle thread right side |  | Activates scanner for needle thread right side |
| | - | - | 0 | Needle thread left side |  | Activates scanner for needle thread left side |
| | - | - | 0 | Bobbin thread |  | Activates scanner for bobbin thread |





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------------|--|---|
| T 63 20 | - | - | 0 | RFID Scanner |  | Adjust parameter of the RFID scanner |
| | - | - | 0 | Desk height adjustment enable |  | Activates the desk height adjustment and measurement. |
| | 80 | -60 | 0 | Desk height offset |  | The offset between point of measuring and the ground. Adjust for correct desk height display. |
| | 140 | 0 | 1 | Desk height |  | Shows the current desk height which is calculated through the measurement and offset |
| | - | - | 0 | Poka yoke 1 detect mode |  | |
| | 250 | 0 | 50 | TID_PokaYoke1_DetectDelay |  | |
| | 2 | 0 | 0.5 | TID_PokaYoke1_TriggerDuration |  | |
| | 8 | 0 | 1 | TID_PokaYoke1_NmbrOutputs |  | |
| | - | - | 0 | Poka yoke 1 busy |  | |


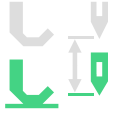



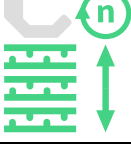



Parameter List



| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------------|--|--------------|
| | 25 | 0 | 5 | TID_PokaYoke1_DetectTimeout |  | |
| | - | - | 0 | Poka yoke 2 detect mode |  | |
| | 250 | 0 | 50 | TID_PokaYoke2_DetectDelay |  | |
| | 2 | 0 | 0.5 | TID_PokaYoke2_TriggerDuration |  | |
| | 8 | 0 | 1 | TID_PokaYoke2_NmbrOutputs |  | |
| | - | - | 0 | Poka yoke 2 busy |  | |
| | 25 | 0 | 5 | TID_PokaYoke2_DetectTimeout |  | |
| | - | - | 0 | Poka yoke 3 detect mode |  | |
| | 250 | 0 | 50 | TID_PokaYoke3_DetectDelay |  | |

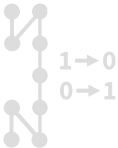
Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------------|--|--------------|
| | 2 | 0 | 0.5 | TID_PokaYoke3_TriggerDuration |  | |
| | 8 | 0 | 1 | TID_PokaYoke3_NmbrOutputs |  | |
| | - | - | 0 | Poka yoke 3 busy |  | |
| | 25 | 0 | 5 | TID_PokaYoke3_DetectTimeout |  | |
| | - | - | 0 | Poka yoke 4 detect mode |  | |
| | 250 | 0 | 50 | TID_PokaYoke4_DetectDelay |  | |
| | 2 | 0 | 0.5 | TID_PokaYoke4_TriggerDuration |  | |
| | 8 | 0 | 1 | TID_PokaYoke4_NmbrOutputs |  | |
| | - | - | 0 | Poka yoke 4 busy |  | |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---|--|---|
| | 25 | 0 | 5 | TID_PokaYoke4_DetectTimeout |  | |
| T 03 20 | - | - | 0 | Needle follows foot |  | Activate the function that the needle follows the sewing foot |
| T 03 21 | - | - | 0 | Pinch protection before sewing start active |  | Automatic obstacle detection under the sewing foot according to threshold criteria. |
| T 03 22 | 12 | 0 | 3 | Pinch protection threshold |  | Automatic obstacle detection is active for measured values above a set threshold. |
| T 27 05 | - | - | 0 | Fabric control under foot |  | Checks the presence of fabric under sewing foot to avoid sewing without material (please mind the threshold setting). |
| T 27 06 | 6 | 0 | 0.5 | Threshold for fabric control under foot |  | Sewing is locked if the measured fabric thickness falls below this threshold. |
| T 63 10 | - | - | - | Mode |  | 0 = Off 1 = Scanner |
| T 63 12 | 250000 | 9600 | 115200 | Baudrate |  | Transfer rate of the scanner (Value range 19200 - 115200) |
| T 63 11 | - | - | - | Mode |  | 0 = Off 1 = Scanner |


| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------------|--|---|
| T 63 13 | 250000 | 9600 | 115200 | Baudrate |  | Transfer rate of the scanner (Value range 19200 - 115200) |
| - | - | - | - | Threading mode |  | <p>A mode can be allocated to the tiles</p> <ul style="list-style-type: none"> 0 = No function 1 = Threader 2 = Backtack suppression/activation 3 = Manual backtack 4 = Half stitch 5 = Whole stitch 6 = Indicator position 7 = No function 8 = Needle high 9 = No function 10 = No function 11 = Additional thread tension 12 = Stitch length switching 13 = No function 14 = No function 15 = Seam center guide / puller 16 = No function 17 = No function 18 = Light barrier 19 = No function 20 = Operation lock active when contact open (N.O.) 21 = Stroke quick-adjustment 22 = No function 23 = Switch to next segment 24 = No function 25 = 2nd edge guide position 26 = Foot lighten position (Shoe machines) 27 = Additional fullness 28 = Tape tension 29 = Puller 30 = No function 31 = Operation lock active when contact closed (N.C.) 32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.) |

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---------------------|--|--|
| | | | | | | 33 = Trigger program selection 34 = Program select bit 0 35 = Program select bit 1 36 = Program select bit 2 37 = Program select bit 3 38 = Program select bit 4 39 = Program select bit 5 40 = Program select bit 6 41 = Program select bit 7 42 = Program select bit 8 43 = Program select bit 9 44 = Short stitch 45 = 2nd edge guide position (height) 46 = 2nd edge guide positions (gap and height) 47 = DB3000 48 = DB2000 49 = Function module 1 50 = Function module 2 51 = Function module 3 52 = Function module 4 53 = Function module 5 54 = Function module 6 55 = Function module 7 56 = Function module 8 57 = Sewing light 58 = Machine head light |
| | - | - | - | Supression backtack |  | A mode can be allocated to the tiles 0 = No function 1 = Threader 2 = Backtack supression/activation 3 = Manual backtack 4 = Half stitch 5 = Whole stitch 6 = Indicator position 7 = No function 8 = Needle high 9 = No function 10 = No function 11 = Additional thread tension 12 = Stitch length switching 13 = No function |


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------|------------|--|
| | | | | | | <p>14 = No function</p> <p>15 = Seam center guide / puller</p> <p>16 = No function</p> <p>17 = No function</p> <p>18 = Light barrier</p> <p>19 = No function</p> <p>20 = Operation lock active when contact open (N.O.)</p> <p>21 = Stroke quick-adjustment</p> <p>22 = No function</p> <p>23 = Switch to next segment</p> <p>24 = No function</p> <p>25 = 2nd edge guide position</p> <p>26 = Foot lighten position (Shoe machines)</p> <p>27 = Additional fullness</p> <p>28 = Tape tension</p> <p>29 = Puller</p> <p>30 = No function</p> <p>31 = Operation lock active when contact closed (N.C.)</p> <p>32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.)</p> <p>33 = Trigger program selection</p> <p>34 = Program select bit 0</p> <p>35 = Program select bit 1</p> <p>36 = Program select bit 2</p> <p>37 = Program select bit 3</p> <p>38 = Program select bit 4</p> <p>39 = Program select bit 5</p> <p>40 = Program select bit 6</p> <p>41 = Program select bit 7</p> <p>42 = Program select bit 8</p> <p>43 = Program select bit 9</p> <p>44 = Short stitch</p> <p>45 = 2nd edge guide position (height)</p> <p>46 = 2nd edge guide positions (gap and height)</p> <p>47 = DB3000</p> <p>48 = DB2000</p> <p>49 = Function module 1</p> <p>50 = Function module 2</p> |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-----------------|--|--|
| | | | | | | 51 = Function module 3 52 = Function module 4 53 = Function module 5 54 = Function module 6 55 = Function module 7 56 = Function module 8 57 = Sewing light 58 = Machine head light |
| | - | - | - | Manual backtack |  | <p>A mode can be allocated to the tiles</p> 0 = No function 1 = Threader 2 = Backtack suppression/activation 3 = Manual backtack 4 = Half stitch 5 = Whole stitch 6 = Indicator position 7 = No function 8 = Needle high 9 = No function 10 = No function 11 = Additional thread tension 12 = Stitch length switching 13 = No function 14 = No function 15 = Seam center guide / puller 16 = No function 17 = No function 18 = Light barrier 19 = No function 20 = Operation lock active when contact open (N.O.) 21 = Stroke quick-adjustment 22 = No function 23 = Switch to next segment 24 = No function 25 = 2nd edge guide position 26 = Foot lighten position (Shoe machines) 27 = Additional fullness 28 = Tape tension 29 = Puller 30 = No function 31 = Operation lock active when contact |


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------|--|---|
| | | | | | | <p>closed (N.C.)</p> <p>32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.)</p> <p>33 = Trigger program selection</p> <p>34 = Program select bit 0</p> <p>35 = Program select bit 1</p> <p>36 = Program select bit 2</p> <p>37 = Program select bit 3</p> <p>38 = Program select bit 4</p> <p>39 = Program select bit 5</p> <p>40 = Program select bit 6</p> <p>41 = Program select bit 7</p> <p>42 = Program select bit 8</p> <p>43 = Program select bit 9</p> <p>44 = Short stitch</p> <p>45 = 2nd edge guide position (height)</p> <p>46 = 2nd edge guide positions (gap and height)</p> <p>47 = DB3000</p> <p>48 = DB2000</p> <p>49 = Function module 1</p> <p>50 = Function module 2</p> <p>51 = Function module 3</p> <p>52 = Function module 4</p> <p>53 = Function module 5</p> <p>54 = Function module 6</p> <p>55 = Function module 7</p> <p>56 = Function module 8</p> <p>57 = Sewing light</p> <p>58 = Machine head light</p> |
| | - | - | - | Half stitch |  | <p>A mode can be allocated to the tiles</p> <p>0 = No function</p> <p>1 = Threader</p> <p>2 = Backtack suppression/activation</p> <p>3 = Manual backtack</p> <p>4 = Half stitch</p> <p>5 = Whole stitch</p> <p>6 = Indicator position</p> <p>7 = No function</p> <p>8 = Needle high</p> <p>9 = No function</p> |


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------|------------|--|
| | | | | | | <p>10 = No function</p> <p>11 = Additional thread tension</p> <p>12 = Stitch length switching</p> <p>13 = No function</p> <p>14 = No function</p> <p>15 = Seam center guide / puller</p> <p>16 = No function</p> <p>17 = No function</p> <p>18 = Light barrier</p> <p>19 = No function</p> <p>20 = Operation lock active when contact open (N.O.)</p> <p>21 = Stroke quick-adjustment</p> <p>22 = No function</p> <p>23 = Switch to next segment</p> <p>24 = No function</p> <p>25 = 2nd edge guide position</p> <p>26 = Foot lighten position (Shoe machines)</p> <p>27 = Additional fullness</p> <p>28 = Tape tension</p> <p>29 = Puller</p> <p>30 = No function</p> <p>31 = Operation lock active when contact closed (N.C.)</p> <p>32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.)</p> <p>33 = Trigger program selection</p> <p>34 = Program select bit 0</p> <p>35 = Program select bit 1</p> <p>36 = Program select bit 2</p> <p>37 = Program select bit 3</p> <p>38 = Program select bit 4</p> <p>39 = Program select bit 5</p> <p>40 = Program select bit 6</p> <p>41 = Program select bit 7</p> <p>42 = Program select bit 8</p> <p>43 = Program select bit 9</p> <p>44 = Short stitch</p> <p>45 = 2nd edge guide position (height)</p> <p>46 = 2nd edge guide positions (gap and height)</p> |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------|--|---|
| | | | | | | 47 = DB3000 48 = DB2000 49 = Function module 1 50 = Function module 2 51 = Function module 3 52 = Function module 4 53 = Function module 5 54 = Function module 6 55 = Function module 7 56 = Function module 8 57 = Sewing light 58 = Machine head light |
| | - | - | - | Pointing position |  | <p>A mode can be allocated to the tiles</p> 0 = No function 1 = Threader 2 = Backtack suppression/activation 3 = Manual backtack 4 = Half stitch 5 = Whole stitch 6 = Indicator position 7 = No function 8 = Needle high 9 = No function 10 = No function 11 = Additional thread tension 12 = Stitch length switching 13 = No function 14 = No function 15 = Seam center guide / puller 16 = No function 17 = No function 18 = Light barrier 19 = No function 20 = Operation lock active when contact open (N.O.) 21 = Stroke quick-adjustment 22 = No function 23 = Switch to next segment 24 = No function 25 = 2nd edge guide position 26 = Foot lighten position (Shoe machines) 27 = Additional fullness |


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------|--|--|
| | | | | | | 28 = Tape tension 29 = Puller 30 = No function 31 = Operation lock active when contact closed (N.C.) 32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.) 33 = Trigger program selection 34 = Program select bit 0 35 = Program select bit 1 36 = Program select bit 2 37 = Program select bit 3 38 = Program select bit 4 39 = Program select bit 5 40 = Program select bit 6 41 = Program select bit 7 42 = Program select bit 8 43 = Program select bit 9 44 = Short stitch 45 = 2nd edge guide position (height) 46 = 2nd edge guide positions (gap and height) 47 = DB3000 48 = DB2000 49 = Function module 1 50 = Function module 2 51 = Function module 3 52 = Function module 4 53 = Function module 5 54 = Function module 6 55 = Function module 7 56 = Function module 8 57 = Sewing light 58 = Machine head light |
| | - | - | - | 2nd thread tension |  | A mode can be allocated to the tiles 0 = No function 1 = Threader 2 = Backtack suppression/activation 3 = Manual backtack 4 = Half stitch 5 = Whole stitch |

Parameter List

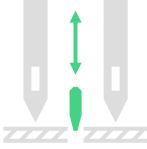
| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------|------------|---|
| | | | | | | <p>6 = Indicator position 7 = No function 8 = Needle high 9 = No function 10 = No function 11 = Additional thread tension 12 = Stitch length switching 13 = No function 14 = No function 15 = Seam center guide / puller 16 = No function 17 = No function 18 = Light barrier 19 = No function 20 = Operation lock active when contact open (N.O.) 21 = Stroke quick-adjustment 22 = No function 23 = Switch to next segment 24 = No function 25 = 2nd edge guide position 26 = Foot lighten position (Shoe machines) 27 = Additional fullness 28 = Tape tension 29 = Puller 30 = No function 31 = Operation lock active when contact closed (N.C.) 32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.) 33 = Trigger program selection 34 = Program select bit 0 35 = Program select bit 1 36 = Program select bit 2 37 = Program select bit 3 38 = Program select bit 4 39 = Program select bit 5 40 = Program select bit 6 41 = Program select bit 7 42 = Program select bit 8 43 = Program select bit 9</p> |

Parameter List

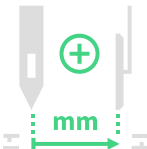
| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------|---|---|
| | | | | | | 44 = Short stitch 45 = 2nd edge guide position (height) 46 = 2nd edge guide positions (gap and height) 47 = DB3000 48 = DB2000 49 = Function module 1 50 = Function module 2 51 = Function module 3 52 = Function module 4 53 = Function module 5 54 = Function module 6 55 = Function module 7 56 = Function module 8 57 = Sewing light 58 = Machine head light |
| | - | - | - | 2nd stitch length |  | <p>A mode can be allocated to the tiles</p> 0 = No function 1 = Threader 2 = Backtack suppression/activation 3 = Manual backtack 4 = Half stitch 5 = Whole stitch 6 = Indicator position 7 = No function 8 = Needle high 9 = No function 10 = No function 11 = Additional thread tension 12 = Stitch length switching 13 = No function 14 = No function 15 = Seam center guide / puller 16 = No function 17 = No function 18 = Light barrier 19 = No function 20 = Operation lock active when contact open (N.O.) 21 = Stroke quick-adjustment 22 = No function 23 = Switch to next segment |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------|------------|---|
| | | | | | | <p>24 = No function</p> <p>25 = 2nd edge guide position</p> <p>26 = Foot lighten position (Shoe machines)</p> <p>27 = Additional fullness</p> <p>28 = Tape tension</p> <p>29 = Puller</p> <p>30 = No function</p> <p>31 = Operation lock active when contact closed (N.C.)</p> <p>32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.)</p> <p>33 = Trigger program selection</p> <p>34 = Program select bit 0</p> <p>35 = Program select bit 1</p> <p>36 = Program select bit 2</p> <p>37 = Program select bit 3</p> <p>38 = Program select bit 4</p> <p>39 = Program select bit 5</p> <p>40 = Program select bit 6</p> <p>41 = Program select bit 7</p> <p>42 = Program select bit 8</p> <p>43 = Program select bit 9</p> <p>44 = Short stitch</p> <p>45 = 2nd edge guide position (height)</p> <p>46 = 2nd edge guide positions (gap and height)</p> <p>47 = DB3000</p> <p>48 = DB2000</p> <p>49 = Function module 1</p> <p>50 = Function module 2</p> <p>51 = Function module 3</p> <p>52 = Function module 4</p> <p>53 = Function module 5</p> <p>54 = Function module 6</p> <p>55 = Function module 7</p> <p>56 = Function module 8</p> <p>57 = Sewing light</p> <p>58 = Machine head light</p> |

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------|--|--|
| | - | - | - | Center guide |  | <p>A mode can be allocated to the tiles</p> <ul style="list-style-type: none"> 0 = No function 1 = Threader 2 = Backtack suppression/activation 3 = Manual backtack 4 = Half stitch 5 = Whole stitch 6 = Indicator position 7 = No function 8 = Needle high 9 = No function 10 = No function 11 = Additional thread tension 12 = Stitch length switching 13 = No function 14 = No function 15 = Seam center guide / puller 16 = No function 17 = No function 18 = Light barrier 19 = No function 20 = Operation lock active when contact open (N.O.) 21 = Stroke quick-adjustment 22 = No function 23 = Switch to next segment 24 = No function 25 = 2nd edge guide position 26 = Foot lighten position (Shoe machines) 27 = Additional fullness 28 = Tape tension 29 = Puller 30 = No function 31 = Operation lock active when contact closed (N.C.) 32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.) 33 = Trigger program selection 34 = Program select bit 0 35 = Program select bit 1 36 = Program select bit 2 |


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|------------|--|---|
| | | | | | | 37 = Program select bit 3 38 = Program select bit 4 39 = Program select bit 5 40 = Program select bit 6 41 = Program select bit 7 42 = Program select bit 8 43 = Program select bit 9 44 = Short stitch 45 = 2nd edge guide position (height) 46 = 2nd edge guide positions (gap and height) 47 = DB3000 48 = DB2000 49 = Function module 1 50 = Function module 2 51 = Function module 3 52 = Function module 4 53 = Function module 5 54 = Function module 6 55 = Function module 7 56 = Function module 8 57 = Sewing light 58 = Machine head light |
| | - | - | - | Edge guide |  | A mode can be allocated to the tiles 0 = No function 1 = Threader 2 = Backtack suppression/activation 3 = Manual backtack 4 = Half stitch 5 = Whole stitch 6 = Indicator position 7 = No function 8 = Needle high 9 = No function 10 = No function 11 = Additional thread tension 12 = Stitch length switching 13 = No function 14 = No function 15 = Seam center guide / puller 16 = No function 17 = No function |


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------|------------|---|
| | | | | | | <p>18 = Light barrier</p> <p>19 = No function</p> <p>20 = Operation lock active when contact open (N.O.)</p> <p>21 = Stroke quick-adjustment</p> <p>22 = No function</p> <p>23 = Switch to next segment</p> <p>24 = No function</p> <p>25 = 2nd edge guide position</p> <p>26 = Foot lighten position (Shoe machines)</p> <p>27 = Additional fullness</p> <p>28 = Tape tension</p> <p>29 = Puller</p> <p>30 = No function</p> <p>31 = Operation lock active when contact closed (N.C.)</p> <p>32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.)</p> <p>33 = Trigger program selection</p> <p>34 = Program select bit 0</p> <p>35 = Program select bit 1</p> <p>36 = Program select bit 2</p> <p>37 = Program select bit 3</p> <p>38 = Program select bit 4</p> <p>39 = Program select bit 5</p> <p>40 = Program select bit 6</p> <p>41 = Program select bit 7</p> <p>42 = Program select bit 8</p> <p>43 = Program select bit 9</p> <p>44 = Short stitch</p> <p>45 = 2nd edge guide position (height)</p> <p>46 = 2nd edge guide positions (gap and height)</p> <p>47 = DB3000</p> <p>48 = DB2000</p> <p>49 = Function module 1</p> <p>50 = Function module 2</p> <p>51 = Function module 3</p> <p>52 = Function module 4</p> <p>53 = Function module 5</p> <p>54 = Function module 6</p> |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------|--|---|
| | | | | | | 55 = Function module 7 56 = Function module 8 57 = Sewing light 58 = Machine head light |
| | - | - | - | Sewing foot stroke |  | <p>A mode can be allocated to the tiles</p> 0 = No function 1 = Threader 2 = Backtack suppression/activation 3 = Manual backtack 4 = Half stitch 5 = Whole stitch 6 = Indicator position 7 = No function 8 = Needle high 9 = No function 10 = No function 11 = Additional thread tension 12 = Stitch length switching 13 = No function 14 = No function 15 = Seam center guide / puller 16 = No function 17 = No function 18 = Light barrier 19 = No function 20 = Operation lock active when contact open (N.O.) 21 = Stroke quick-adjustment 22 = No function 23 = Switch to next segment 24 = No function 25 = 2nd edge guide position 26 = Foot lighten position (Shoe machines) 27 = Additional fullness 28 = Tape tension 29 = Puller 30 = No function 31 = Operation lock active when contact closed (N.C.) 32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.) |

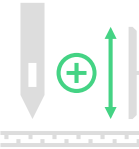
Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|--|
| | | | | | | 33 = Trigger program selection 34 = Program select bit 0 35 = Program select bit 1 36 = Program select bit 2 37 = Program select bit 3 38 = Program select bit 4 39 = Program select bit 5 40 = Program select bit 6 41 = Program select bit 7 42 = Program select bit 8 43 = Program select bit 9 44 = Short stitch 45 = 2nd edge guide position (height) 46 = 2nd edge guide positions (gap and height) 47 = DB3000 48 = DB2000 49 = Function module 1 50 = Function module 2 51 = Function module 3 52 = Function module 4 53 = Function module 5 54 = Function module 6 55 = Function module 7 56 = Function module 8 57 = Sewing light 58 = Machine head light |
| | - | - | - | Puller |  | A mode can be allocated to the tiles 0 = No function 1 = Threader 2 = Backtack suppression/activation 3 = Manual backtack 4 = Half stitch 5 = Whole stitch 6 = Indicator position 7 = No function 8 = Needle high 9 = No function 10 = No function 11 = Additional thread tension 12 = Stitch length switching 13 = No function |


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------|------------|--|
| | | | | | | <p>14 = No function</p> <p>15 = Seam center guide / puller</p> <p>16 = No function</p> <p>17 = No function</p> <p>18 = Light barrier</p> <p>19 = No function</p> <p>20 = Operation lock active when contact open (N.O.)</p> <p>21 = Stroke quick-adjustment</p> <p>22 = No function</p> <p>23 = Switch to next segment</p> <p>24 = No function</p> <p>25 = 2nd edge guide position</p> <p>26 = Foot lighten position (Shoe machines)</p> <p>27 = Additional fullness</p> <p>28 = Tape tension</p> <p>29 = Puller</p> <p>30 = No function</p> <p>31 = Operation lock active when contact closed (N.C.)</p> <p>32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.)</p> <p>33 = Trigger program selection</p> <p>34 = Program select bit 0</p> <p>35 = Program select bit 1</p> <p>36 = Program select bit 2</p> <p>37 = Program select bit 3</p> <p>38 = Program select bit 4</p> <p>39 = Program select bit 5</p> <p>40 = Program select bit 6</p> <p>41 = Program select bit 7</p> <p>42 = Program select bit 8</p> <p>43 = Program select bit 9</p> <p>44 = Short stitch</p> <p>45 = 2nd edge guide position (height)</p> <p>46 = 2nd edge guide positions (gap and height)</p> <p>47 = DB3000</p> <p>48 = DB2000</p> <p>49 = Function module 1</p> <p>50 = Function module 2</p> |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------------------|--|--|
| | | | | | | 51 = Function module 3 52 = Function module 4 53 = Function module 5 54 = Function module 6 55 = Function module 7 56 = Function module 8 57 = Sewing light 58 = Machine head light |
| | - | - | - | Height of edge guide |  | <p>A mode can be allocated to the tiles</p> 0 = No function 1 = Threader 2 = Backtack suppression/activation 3 = Manual backtack 4 = Half stitch 5 = Whole stitch 6 = Indicator position 7 = No function 8 = Needle high 9 = No function 10 = No function 11 = Additional thread tension 12 = Stitch length switching 13 = No function 14 = No function 15 = Seam center guide / puller 16 = No function 17 = No function 18 = Light barrier 19 = No function 20 = Operation lock active when contact open (N.O.) 21 = Stroke quick-adjustment 22 = No function 23 = Switch to next segment 24 = No function 25 = 2nd edge guide position 26 = Foot lighten position (Shoe machines) 27 = Additional fullness 28 = Tape tension 29 = Puller 30 = No function 31 = Operation lock active when contact |








Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------------------|--|---|
| | | | | | | <p>closed (N.C.)</p> <p>32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.)</p> <p>33 = Trigger program selection</p> <p>34 = Program select bit 0</p> <p>35 = Program select bit 1</p> <p>36 = Program select bit 2</p> <p>37 = Program select bit 3</p> <p>38 = Program select bit 4</p> <p>39 = Program select bit 5</p> <p>40 = Program select bit 6</p> <p>41 = Program select bit 7</p> <p>42 = Program select bit 8</p> <p>43 = Program select bit 9</p> <p>44 = Short stitch</p> <p>45 = 2nd edge guide position (height)</p> <p>46 = 2nd edge guide positions (gap and height)</p> <p>47 = DB3000</p> <p>48 = DB2000</p> <p>49 = Function module 1</p> <p>50 = Function module 2</p> <p>51 = Function module 3</p> <p>52 = Function module 4</p> <p>53 = Function module 5</p> <p>54 = Function module 6</p> <p>55 = Function module 7</p> <p>56 = Function module 8</p> <p>57 = Sewing light</p> <p>58 = Machine head light</p> |
| | - | - | - | Edge guide positions |  | <p>A mode can be allocated to the tiles</p> <p>0 = No function</p> <p>1 = Threader</p> <p>2 = Backtack suppression/activation</p> <p>3 = Manual backtack</p> <p>4 = Half stitch</p> <p>5 = Whole stitch</p> <p>6 = Indicator position</p> <p>7 = No function</p> <p>8 = Needle high</p> <p>9 = No function</p> |

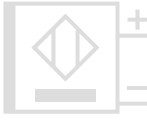
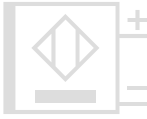

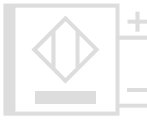
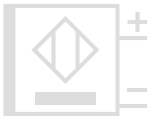


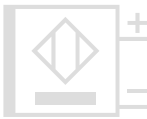

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------|------------|--|
| | | | | | | <p>10 = No function</p> <p>11 = Additional thread tension</p> <p>12 = Stitch length switching</p> <p>13 = No function</p> <p>14 = No function</p> <p>15 = Seam center guide / puller</p> <p>16 = No function</p> <p>17 = No function</p> <p>18 = Light barrier</p> <p>19 = No function</p> <p>20 = Operation lock active when contact open (N.O.)</p> <p>21 = Stroke quick-adjustment</p> <p>22 = No function</p> <p>23 = Switch to next segment</p> <p>24 = No function</p> <p>25 = 2nd edge guide position</p> <p>26 = Foot lighten position (Shoe machines)</p> <p>27 = Additional fullness</p> <p>28 = Tape tension</p> <p>29 = Puller</p> <p>30 = No function</p> <p>31 = Operation lock active when contact closed (N.C.)</p> <p>32 = Operation lock in seam (Stop after backtack is finished or thread trimming is done) (N.C.)</p> <p>33 = Trigger program selection</p> <p>34 = Program select bit 0</p> <p>35 = Program select bit 1</p> <p>36 = Program select bit 2</p> <p>37 = Program select bit 3</p> <p>38 = Program select bit 4</p> <p>39 = Program select bit 5</p> <p>40 = Program select bit 6</p> <p>41 = Program select bit 7</p> <p>42 = Program select bit 8</p> <p>43 = Program select bit 9</p> <p>44 = Short stitch</p> <p>45 = 2nd edge guide position (height)</p> <p>46 = 2nd edge guide positions (gap and height)</p> |

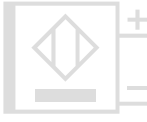
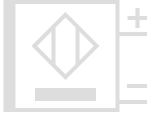







Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------------------------------|--|--|
| | | | | | | 47 = DB3000 48 = DB2000 49 = Function module 1 50 = Function module 2 51 = Function module 3 52 = Function module 4 53 = Function module 5 54 = Function module 6 55 = Function module 7 56 = Function module 8 57 = Sewing light 58 = Machine head light |
| T 53 00 | - | - | - | Mode (machine blockage input) |  | Each input can be assigned to a mode |
| T 53 04 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 10 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 14 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 20 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 24 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 30 | - | - | - | Mode |  | Each input can be assigned to a mode |

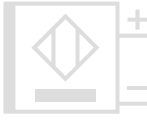








Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|--------------------------------------|
| T 53 34 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 40 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 44 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 50 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 54 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 60 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 64 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 70 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 74 | - | - | 0 | Stored |  | On = stored Off = not stored |

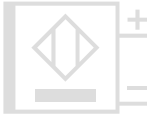
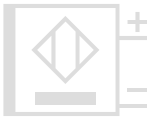
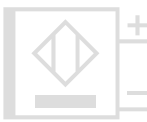
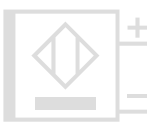





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-----------------------------------|--|--------------------------------------|
| T 54 00 | - | - | - | Mode (foot stroke adjustment) |  | Each input can be assigned to a mode |
| T 54 04 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 54 10 | - | - | - | Mode (manual backtack S1) |  | Each input can be assigned to a mode |
| T 54 14 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 54 20 | - | - | - | Mode (backtack suppression S3) |  | Each input can be assigned to a mode |
| T 54 24 | - | - | 1 | Stored |  | On = stored Off = not stored |
| T 54 30 | - | - | - | Mode (2nd thread tension S5) |  | Each input can be assigned to a mode |
| T 54 34 | - | - | 1 | Stored |  | On = stored Off = not stored |
| T 54 40 | - | - | - | Mode (foot stroke adjustment) |  | Each input can be assigned to a mode |

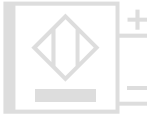
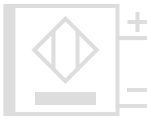
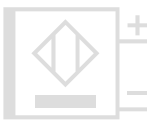
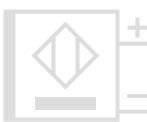





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------------------|--|--------------------------------------|
| T 54 44 | - | - | 1 | Stored |  | On = stored Off = not stored |
| T 54 50 | - | - | - | Mode (half stitch S2) |  | Each input can be assigned to a mode |
| T 54 54 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 54 60 | - | - | - | Mode (2nd stitch length S4) |  | Each input can be assigned to a mode |
| T 54 64 | - | - | 1 | Stored |  | On = stored Off = not stored |
| T 54 70 | - | - | - | Mode (next segment S6) |  | Each input can be assigned to a mode |
| T 54 74 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 00 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 04 | - | - | 0 | Stored |  | On = stored Off = not stored |

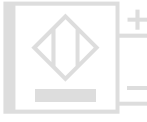
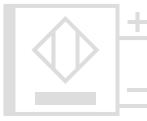
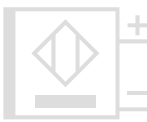
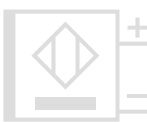





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------------------------|--|--------------------------------------|
| T 55 10 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 14 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 20 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 24 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 30 | - | - | - | Mode (point position jog dial S1) |  | Each input can be assigned to a mode |
| T 55 34 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 40 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 44 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 50 | - | - | - | Mode |  | Each input can be assigned to a mode |

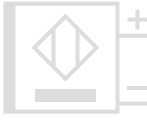
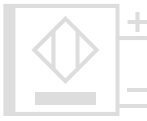
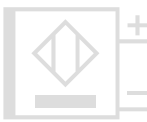
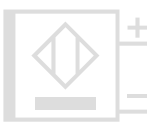





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|--------------------------------------|
| T 55 54 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 60 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 64 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 70 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 74 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 00 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 04 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 10 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 14 | - | - | 1 | Stored |  | On = stored Off = not stored |

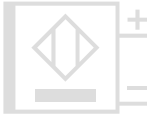
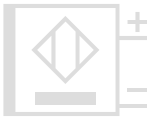
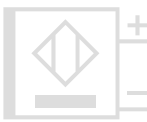
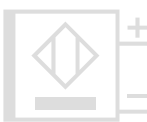





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|--------------------------------------|
| T 53 20 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 24 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 30 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 34 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 40 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 44 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 50 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 54 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 60 | - | - | - | Mode |  | Each input can be assigned to a mode |

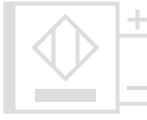
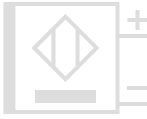

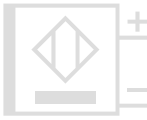
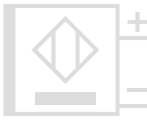


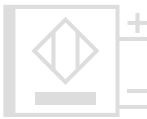

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|--------------------------------------|
| T 53 64 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 53 70 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 53 74 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 54 00 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 54 04 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 54 10 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 54 14 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 54 20 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 54 24 | - | - | 1 | Stored |  | On = stored Off = not stored |

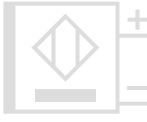
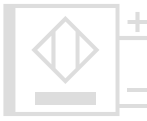
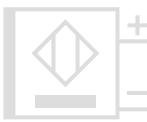
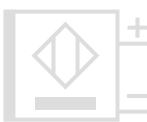





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|--------------------------------------|
| T 54 30 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 54 34 | - | - | 1 | Stored |  | On = stored Off = not stored |
| T 54 40 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 54 44 | - | - | 1 | Stored |  | On = stored Off = not stored |
| T 54 50 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 54 54 | - | - | 1 | Stored |  | On = stored Off = not stored |
| T 54 60 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 54 64 | - | - | 1 | Stored |  | On = stored Off = not stored |
| T 54 70 | - | - | - | Mode |  | Each input can be assigned to a mode |

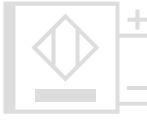
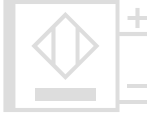







Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|--------------------------------------|
| T 54 74 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 54 80 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 54 84 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 54 90 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 54 94 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 00 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 04 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 10 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 14 | - | - | 0 | Stored |  | On = stored Off = not stored |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|--------------------------------------|
| T 55 20 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 24 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 30 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 34 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 40 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 44 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 50 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 54 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 60 | - | - | - | Mode |  | Each input can be assigned to a mode |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------------------|--|---------------------------------------|
| T 55 64 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 70 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 74 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 55 80 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 55 84 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 56 00 | - | - | - | Mode (Pos 1/PCB X22 ML) |  | Each output can be assigned to a mode |
| T 56 10 | - | - | - | Mode (Needle cooling/PCB X22 NK) |  | Each output can be assigned to a mode |
| T 56 20 | - | - | - | Mode (Clean Signal/PCB X16 RA) |  | Each output can be assigned to a mode |
| T 56 30 | - | - | - | Mode (PCB X17 STL) |  | Each output can be assigned to a mode |

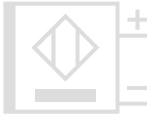
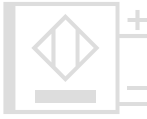

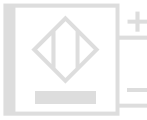
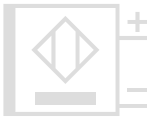


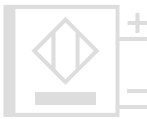

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--|--|---------------------------------------|
| T 56 40 | - | - | - | Mode (PCB X18 STL(FA)) |  | Each output can be assigned to a mode |
| T 56 50 | - | - | - | Mode (PCB X22 FL) |  | Each output can be assigned to a mode |
| T 56 60 | - | - | - | Mode (puller seam center guide/PCB X22 FF3 OUT) |  | Each output can be assigned to a mode |
| T 56 00 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 56 10 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 56 20 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 56 30 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 56 40 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 57 00 | - | - | - | Mode |  | Each output can be assigned to a mode |

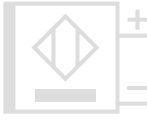
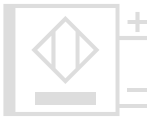
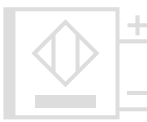
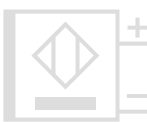





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|---------------------------------------|
| T 57 10 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 57 20 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 57 30 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 57 40 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 57 50 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 57 60 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 57 70 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 57 00 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 57 04 | - | - | 0 | Stored |  | On = stored Off = not stored |

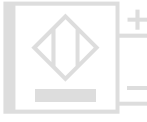
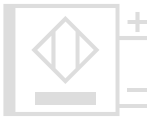
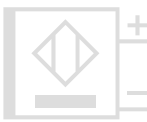
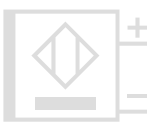





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|--------------------------------------|
| T 57 10 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 57 14 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 57 20 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 57 24 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 57 30 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 57 34 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 57 40 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 57 44 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 57 50 | - | - | - | Mode |  | Each input can be assigned to a mode |

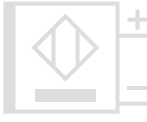
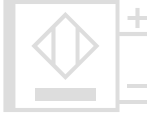







Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|--------------------------------------|
| T 57 54 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 57 60 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 57 64 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 57 70 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 57 74 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 58 00 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 58 04 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 58 10 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 58 14 | - | - | 0 | Stored |  | On = stored Off = not stored |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|--------------------------------------|
| T 58 20 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 58 24 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 58 30 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 58 34 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 58 40 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 58 44 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 58 50 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 58 54 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 58 60 | - | - | - | Mode |  | Each input can be assigned to a mode |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|---------------------------------------|
| T 58 64 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 58 70 | - | - | - | Mode |  | Each input can be assigned to a mode |
| T 58 74 | - | - | 0 | Stored |  | On = stored Off = not stored |
| T 59 00 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 59 10 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 59 20 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 59 30 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 59 40 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 59 50 | - | - | - | Mode |  | Each output can be assigned to a mode |


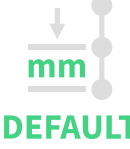
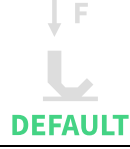

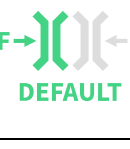
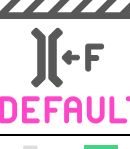



Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------|--|---------------------------------------|
| T 59 60 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 59 70 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 64 00 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 64 10 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 64 20 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 64 30 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 64 40 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 64 50 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 64 60 | - | - | - | Mode |  | Each output can be assigned to a mode |







Parameter List




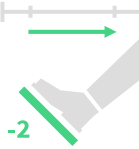

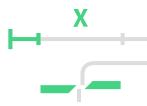
| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--|--|--|
| T 64 70 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 65 00 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 65 10 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 65 20 | - | - | - | Mode |  | Each output can be assigned to a mode |
| T 65 30 | - | - | - | Mode |  | Each output can be assigned to a mode |
| | - | - | 0 | Allow login with file on USB flash drive |  | Permits user login with USB flash drive that contains a file with login information. Caution: This function is a potential security vulnerability! |
| T 51 62 | - | - | 0 | Energy saving while service stop |  | Activate or Deactivate the energy saving during service stop |
| T 51 61 | 2400 | 0 | 60 | Energy Saving Delay |  | Help Energy Saving Delay |
| T 51 63 | 2400 | 0 | 60 | Energy saving signal delay |  | Delay time for activation of delayed output signal after machine entered energy saving mode. |

Parameter List


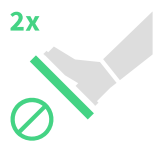






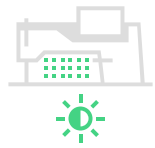
| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------------|--|---|
| T 51 64 | - | - | 0 | Invert energy saving signal |  | Invert of delayed output signal, when machine goes to energy saving mode. |
| T 07 20 | 6 | 0.1 | 4.5 | Stitch length default |  | Stitch length used as default value in programming mode |
| T 07 22 | 20 | 1 | 15 | Sewing foot pressure default |  | Sewing foot pressure used as default value in programming mode |
| T 07 23 | 99 | 1 | 30 | Needle thread tension default |  | Needle thread tension used as default value in programming mode |
| T 07 24 | 99 | 1 | 30 | Needle thread tension (left) |  | Needle thread tension (left) used as default value in programming mode |
| T 07 24 | 99 | 1 | 30 | Hook thread tension default |  | Hook thread tension used as default value in programming mode |
| T 07 28 | 9 | 1 | 4.5 | Sewing foot stroke |  | Sewing foot stroke used as default value in programming mode |
| T 07 25 | - | - | - | Fullness feed type default |  | Fullness type used as default in programming mode |
| T 07 26 | 16 | -0.1 | 0 | Fullness default |  | Fullness used as default value in programming mode |

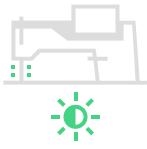

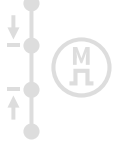
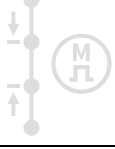
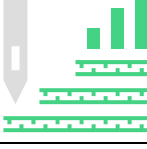
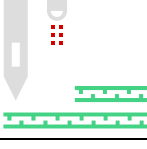
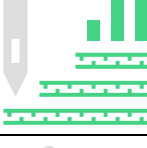
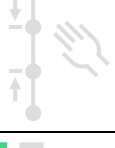

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---------------------------------|--|--|
| O 26 22 | 50 | 0 | 0 | Flat Sew |  | Adjust parameter of fullness |
| T 07 30 | - | - | 0 | Backtack at seam begin |  | Setting whether the backtack at seam begin is automatically activated in a new program (On/Off). The values for the backtack at seam begin are taken from the Manual mode. |
| T 07 31 | - | - | 0 | Backtack at seam end |  | Setting whether the backtack at seam end is automatically activated in a new program (On/Off). The values for the backtack at seam begin are taken from the Manual mode. |
| T 07 30 | - | - | 0 | Stitch condensing at seam begin |  | Stitch condensing at seam begin On/Off |
| T 07 31 | - | - | 0 | Stitch condensing at seam end |  | Stitch condensing at seam end On/Off |
| T 07 32 | - | - | 1 | Thread trimmer |  | Setting whether the thread trimmer is automatically activated in a new program (On/Off). |
| T 07 40 | - | - | - | Counter Mode |  | Daily piece counter, can be set to count either up or down. When the daily piece counter is activated, it must be reset once after entering a value to ensure it counts correctly. |
| T 07 41 | 999 | -999 | 0 | Reset |  | Enter the value to which the daily pieces counter should return when it is reset. (Value range -999 - 999) |

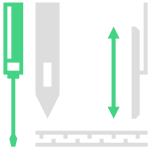
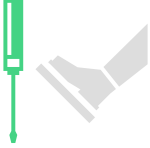
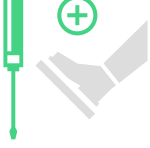






| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---------------------------------|--|---|
| T 07 07 | - | - | 1 | Count stitches (push button) |  | Count stitches made by push button (On/Off) |
| T 07 08 | - | - | 1 | Correction of backward stitches |  | Manual backward stitches will be corrected in terms of necessary forward stitches by using the stitch count function 0 = No 1 = Yes |
| T 07 02 | - | - | 1 | Forward Sound |  | Acoustic signal at segment switch (On/Off) |
| T 07 06 | - | - | 0 | Segment switch by pedal |  | A switch between two seam sections is usually carried out with the ► button. This function can also be assigned to Position -2 on the pedal. (Value range On/Off) Notice: Position -2 actually causes a cancelation when actuated during a seam section. If the section change function is assigned to Position -2, the softkey menu can be used for a cancelation (it is still possible to continue sewing from that point; for a full cancelation of the program, press the pedal in Position -2 again). |
| T 07 05 | - | - | - | Mode |  | Position = After the cancelation, the needle is merely brought to ist end position and the thread is cut (if activated). Seg.End = Ending of the program with all configurations that are set for this seam section. |
| T 07 04 | - | - | - | Thread trimmer |  | The thread trimmer becomes active or remains inactive when a seam section is canceled. (Value range On/Off/Abort as at seam end) |







Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------------|--|--|
| | - | - | 0 | Short stitch |  | Enable short stitches for segment abort. CAUTION Short stitches at seam end have have to be set to a number greater than 0 for this option to have effect. |
| T 07 00 | - | - | - | Pedal Abort |  | Abort a program by pressing the pedal in Position -2 twice. (Value range On/Off) |
| O 51 02 | - | - | - | Language |  | Language selection |
| O 52 01 | 0 | 1 | 0 | Brightness |  | This function adjusts the brightness of the control panel |
| O 52 02 | 100 | 0 | 0 | Panel Audio Volume |  | This function allows to adjust the volume of the audio output. |
| | - | - | 0 | Invert screen |  | Inverts the screen so that panel can be turned around |
| | - | - | 0 | Automatic logout |  | |
| | 120 | 1 | 10 | Automatic logout delay |  | |
| O 51 01 | 10 | 1 | 6 | Machine head light brightness |  | Design light The desired brightness of the under arm lighting (Design light) can be adjusted to individual needs. Value range: 1 (dark) to 10 (very bright) |



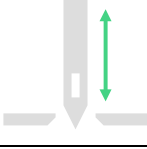
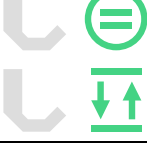
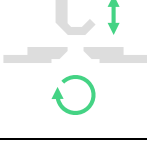

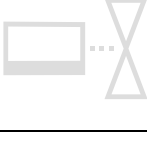


| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--|--|--|
| O 51 00 | 10 | 1 | 6 | Sewing light brightness (integrated LED sewing light) |  | Integrated LED sewing light The desired brightness of the integrated LED sewing light can be adjusted to individual needs. Value range: 1 (dark) to 10 (very bright) |
| T 62 00 | - | - | 0 | Feed calibration |  | Calibration of the stitch length and/or the feed |
| T 62 09 | - | - | 0 | Feed bottom front calibration |  | Calibration of the stitch length and/or the feed |
| T 62 08 | - | - | 0 | Feed top calibration |  | Calibration of the stitch length and/or the feed |
| T 62 01 | - | - | 0 | Material thickness detection |  | Calibration of the material thickness detection |
| | - | - | 0 | PQS calibration |  | The PQS system will be calibrated new. Please take all sewing material out of the sewing area. |
| T 62 01 | - | - | 0 | Material thickness detection |  | Calibration of the material thickness detection |
| T 62 02 | - | - | 0 | Manual stitch length adjustment |  | Calibration of the stitch adjustment lever (optional equipment) |
| T 62 03 | - | - | 0 | Edge guide |  | Please select the desired edge guide type 0 = Motor driven edge guide with 1-axis (X) and internal stepper motor card (DAC) 1 = Motor driven edge guide with 1-axis (X) and external stepper motor card (separate module) |

Parameter List










| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------------------------|--|--|
| | | | | | | 2 = Motor driven edge guide with 2-axis (X and Z) and external stepper motor cards (integrated in edge guide unit) |
| T 62 04 | - | - | 0 | Height of edge guide |  | Calibration of the height of the motor driven edge guide (optional equipment) |
| T 08 20 | - | - | 0 | Pedal |  | Calibration of the pedal |
| T 08 70 | - | - | 0 | Pedal 2 |  | Calibration of the pedal |
| T 61 30 | - | - | 0 | Needle thread tension |  | Calibration Window for thread tension |
| T 61 32 | - | - | 0 | Needle thread tension left |  | Calibration Window for thread tension |
| T 61 31 | - | - | 0 | Hook thread tension |  | Calibration Window for thread tension |
| T 61 33 | - | - | 0 | Hook thread tension left |  | Calibration Window for thread tension |
| T 62 05 | - | - | 0 | Needle thread tension |  | Calibration Window for thread tension |
| T 62 06 | - | - | 0 | Needle thread tension left |  | Calibration Window for thread tension |

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------------------|--|---|
| T 62 10 | - | - | 0 | Stroke Speed Limiter |  | |
| T 62 10 | - | - | 0 | Teach Transmission |  | <p>Especially with twin-needle machines, the transmission from the motor to the arm shaft is translated to increase the penetration force. For the correct display of the speed and for the exact positioning of the machine, the transmission ratio must be known. This function allows the transmission ratio to be taught. This value is determined and stored by manually turning the handwheel in the running direction.</p> <p>For single-needle machines (without gear ratio), this value is 1000.</p> <p>For two-needle machines with standard gear ratio, this value is approx. 750.</p> |
| T 62 11 | - | - | 0 | Reference position |  | <p>This function is used to set the reference position in order to match the handwheel position on the display exactly to the mechanics of the machine. Here, the position indication on the display is set and saved exactly to the value of 202° in the lock pin position (hook timing position).</p> |
| T 62 07 | 100 | 0 | 40 | Foot gap value |  | Calibration value of gap between foot and wheel feeder |
| T 61 00 | - | - | 0 | Assemble |  | Assembling and removing feed dog |
| T 61 01 | - | - | 0 | Position to needle |  | Setting the feed dog position to the needle |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------------|--|--|
| T 61 02 | - | - | 0 | Feed dog movement |  | Setting the feed dog feed movement |
| T 61 10 | - | - | 0 | Timing |  | Setting the loop stroke position |
| T 61 11 | - | - | 0 | Needle bar |  | Setting the needle bar height |
| T 61 20 | - | - | 0 | Equal sewing foot stroke |  | Setting an even sewing foot stroke of feeding and presser foot |
| T 61 21 | - | - | 0 | Feed Move |  | setting the feeding foot movement |
| T 61 30 | - | - | 0 | Needle thread tension |  | Calibration Window for thread tension |
| T 60 00 | - | - | 0 | Test Output |  | Test of the outputs |
| Test | - | - | 0 | X120B.9 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120B.10 |  | Check of outputs according to wiring diagram |










Parameter List






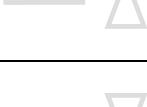


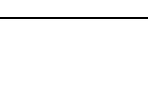
| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------|--|--|
| Test | - | - | 0 | X120B.11 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120B.12 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120B.22 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120B.23 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120B.24 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120B.25 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120T.9 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120T.10 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120T.11 |  | Check of outputs according to wiring diagram |

Parameter List










| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------|--|--|
| Test | - | - | 0 | X120T.12 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120T.22 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120T.23 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120T.24 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120T.25 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100B.2 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100B.3 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100B.5 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100B.6 |  | Check of outputs according to wiring diagram |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------|--|--|
| Test | - | - | 0 | X100B.9 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100B.10 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100B.13 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100B.14 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100T.2 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100T.3 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100T.5 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100T.6 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100T.9 |  | Check of outputs according to wiring diagram |










| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------|--|--|
| Test | - | - | 0 | X100T.10 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100T.13 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X100T.14 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X90.12 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X90.13 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X90.14 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X90.15 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X90.16 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X90.18 |  | Check of outputs according to wiring diagram |

Parameter List










| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------|--|--|
| Test | - | - | 0 | X120.9 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120.10 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120.11 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120.12 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | X120.13 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | LED S1 (A9.X12.10) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | LED S2 (A9.X12.9) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | LED S3 (A9.X12.8) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | LED S4 (A9.X12.7) |  | Check of outputs according to wiring diagram |

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------|--|--|
| Test | - | - | 0 | LED S5 (A9.X12.6) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | LED S6 (A9.X12.5) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | LED SR (A9.X12.4) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | LED SG (A9.X12.3) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | LED SB (A9.X12.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | Laser LED (A9.X6.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | Logo LED (A9) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | Thread clamp (A9.X10.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | Sewing Light (A9.X8.2) |  | Check of outputs according to wiring diagram |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------------|--|--|
| Test | - | - | 0 | Design Light (A9.X12.12) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | Oil pump (A9.X5.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | OUT01 (A2.X25.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | OUT02 (A2.X26.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | OUT03 (A2.X27.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | OUT04 (A2.X28.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | OUT05 (A2.X21.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | OUT06 (A2.X22.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | OUT07 (A2.X23.2) |  | Check of outputs according to wiring diagram |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-----------------------------|--|--|
| Test | - | - | 0 | OUT08 (A2.X24.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | LED Bobbin On/Off (A2.X6.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | Oil monitor (A2.X8.4) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | Thread trimmer 1 (A2.X12.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | Thread trimmer 2 (A2.X11.2) |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100A.9 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100A.10 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100A.11 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100A.12 |  | Check of outputs according to wiring diagram |

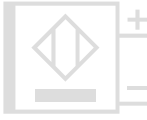








Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------|--|--|
| Test | - | - | 0 | M1.X100A.22 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100A.23 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100A.24 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100A.25 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100B.9 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100B.10 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100B.11 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100B.12 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100B.22 |  | Check of outputs according to wiring diagram |

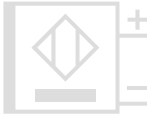








Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------|--|--|
| Test | - | - | 0 | M1.X100B.23 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100B.24 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X100B.25 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X120.2 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X120.4 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X120.6 |  | Check of outputs according to wiring diagram |
| Test | - | - | 0 | M1.X120.8 |  | Check of outputs according to wiring diagram |
| T 60 02 | - | - | 0 | Test Input |  | Test of the inputs |
| Test | - | - | 0 | X120B.2 |  | Sub menu for input test |

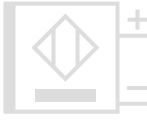
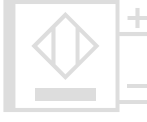







Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------|--|-------------------------|
| Test | - | - | 0 | X120B.3 |  | Sub menu for input test |
| Test | - | - | 0 | X120B.4 |  | Sub menu for input test |
| Test | - | - | 0 | X120B.5 |  | Sub menu for input test |
| Test | - | - | 0 | X120B.15 |  | Sub menu for input test |
| Test | - | - | 0 | X120B.16 |  | Sub menu for input test |
| Test | - | - | 0 | X120B.17 |  | Sub menu for input test |
| Test | - | - | 0 | X120B.18 |  | Sub menu for input test |
| Test | - | - | 0 | X120T.2 |  | Sub menu for input test |
| Test | - | - | 0 | X120T.3 |  | Sub menu for input test |

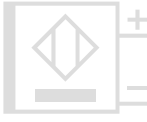
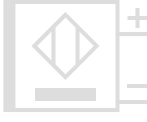







Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------|--|-------------------------|
| Test | - | - | 0 | X120T.4 |  | Sub menu for input test |
| Test | - | - | 0 | X120T.5 |  | Sub menu for input test |
| Test | - | - | 0 | X120T.15 |  | Sub menu for input test |
| Test | - | - | 0 | X120T.16 |  | Sub menu for input test |
| Test | - | - | 0 | X120T.17 |  | Sub menu for input test |
| Test | - | - | 0 | X120T.18 |  | Sub menu for input test |
| Test | - | - | 0 | X100B.4 |  | Sub menu for input test |
| Test | - | - | 0 | X100B.7 |  | Sub menu for input test |
| Test | - | - | 0 | X100B.11 |  | Sub menu for input test |

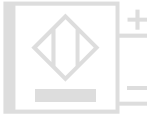
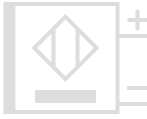


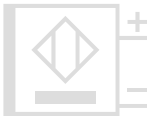


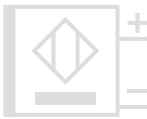

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------|--|-------------------------|
| Test | - | - | 0 | X100B.15 |  | Sub menu for input test |
| Test | - | - | 0 | X100T.4 |  | Sub menu for input test |
| Test | - | - | 0 | X100T.7 |  | Sub menu for input test |
| Test | - | - | 0 | X100T.11 |  | Sub menu for input test |
| Test | - | - | 0 | X100T.15 |  | Sub menu for input test |
| Test | - | - | 0 | X90.1 |  | Sub menu for input test |
| Test | - | - | 0 | X90.2 |  | Sub menu for input test |
| Test | - | - | 0 | X90.3 |  | Sub menu for input test |
| Test | - | - | 0 | X90.4 |  | Sub menu for input test |

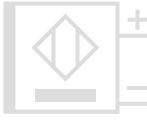
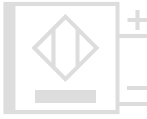

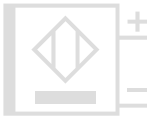
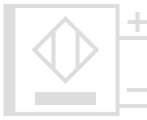


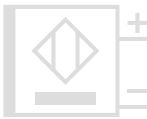

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------|--|-------------------------|
| Test | - | - | 0 | X90.5 |  | Sub menu for input test |
| Test | - | - | 0 | X90.6 |  | Sub menu for input test |
| Test | - | - | 0 | X90.7 |  | Sub menu for input test |
| Test | - | - | 0 | X90.8 |  | Sub menu for input test |
| Test | - | - | 0 | X100.1 |  | Sub menu for input test |
| Test | - | - | 0 | X100.2 |  | Sub menu for input test |
| Test | - | - | 0 | X100.3 |  | Sub menu for input test |
| Test | - | - | 0 | X100.4 |  | Sub menu for input test |
| Test | - | - | 0 | X100.6 |  | Sub menu for input test |

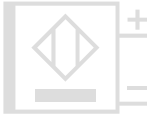
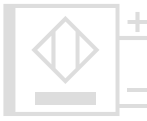
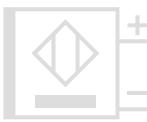
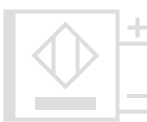





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------------|--|-------------------------|
| Test | - | - | 0 | X120.3 |  | Sub menu for input test |
| Test | - | - | 0 | X120.4 |  | Sub menu for input test |
| Test | - | - | 0 | X120.5 |  | Sub menu for input test |
| Test | - | - | 0 | CAN.2 |  | Sub menu for input test |
| Test | - | - | 0 | CAN.6 |  | Sub menu for input test |
| Test | - | - | 0 | S1 (A9.X12.18) |  | Sub menu for input test |
| Test | - | - | 0 | S2 (A9.X12.19) |  | Sub menu for input test |
| Test | - | - | 0 | S3 (A9.X12.20) |  | Sub menu for input test |
| Test | - | - | 0 | S4 (A9.X12.21) |  | Sub menu for input test |

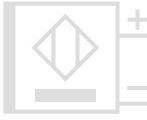
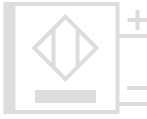

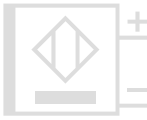
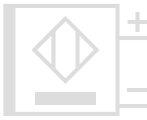


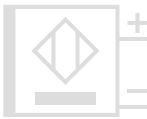

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------------------------------|--|-------------------------|
| Test | - | - | 0 | S5 (A9.X12.22) |  | Sub menu for input test |
| Test | - | - | 0 | S6 (A9.X12.23) |  | Sub menu for input test |
| Test | - | - | 0 | F1 (A9.X12.25) |  | Sub menu for input test |
| Test | - | - | 0 | F2 (A9.X12.24) |  | Sub menu for input test |
| Test | - | - | 0 | Jog dial push button (A9.X12.17) |  | Sub menu for input test |
| Test | - | - | 0 | LS (A3.X7.2) |  | Sub menu for input test |
| Test | - | - | 0 | IN01 (A2.X35.2) |  | Sub menu for input test |
| Test | - | - | 0 | IN02 (A2.X36.2) |  | Sub menu for input test |
| Test | - | - | 0 | IN03 (A2.X37.2) |  | Sub menu for input test |

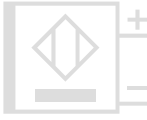








Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------|--|---------------------------------------|
| Test | - | - | 0 | IN04 (A2.X38.2) |  | Sub menu for input test |
| Test | - | - | 0 | IN05 (A2.X31.2) |  | Sub menu for input test |
| Test | - | - | 0 | IN06 (A2.X32.2) |  | Sub menu for input test |
| Test | - | - | 0 | IN07 (A2.X33.2) |  | Sub menu for input test |
| Test | - | - | 0 | IN08 (A2.X34.2) |  | Sub menu for input test |
| Test | - | - | 0 | ENG_ON (A2.X5.2) |  | Sub menu for input test |
| Test | - | - | 0 | Right bobbin cover |  | Right bobbin cover is open (ENG ON 1) |
| Test | - | - | 0 | Left bobbin cover |  | Left bobbin cover is open (ENG ON 2) |
| Test | - | - | 0 | Needle area cover |  | Needle area cover is open (ENG ON 3) |

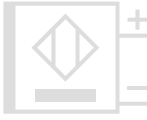
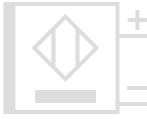

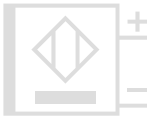
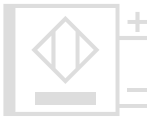


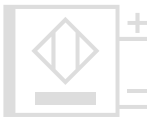

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------|--|-------------------------|
| Test | - | - | 0 | Tilt sensor active |  | Tilt sensor is active |
| Test | - | - | 0 | M1.X100A.2 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100A.3 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100A.4 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100A.5 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100A.15 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100A.16 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100A.17 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100A.18 |  | Sub menu for input test |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------|--|-------------------------|
| Test | - | - | 0 | M1.X100B.2 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100B.3 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100B.4 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100B.5 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100B.15 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100B.16 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100B.17 |  | Sub menu for input test |
| Test | - | - | 0 | M1.X100B.18 |  | Sub menu for input test |
| Test | - | - | 0 | IN01 (Reference sensor) |  | Sub menu for input test |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------|--|---------------------------|
| Test | - | - | 0 | IN02 (Reference sensor) |  | Sub menu for input test |
| Test | - | - | 0 | IN03 (Reference sensor) |  | Sub menu for input test |
| Test | - | - | 0 | IN04 (Reference sensor) |  | Sub menu for input test |
| Test | - | - | 0 | IN05 (Reference sensor) |  | Sub menu for input test |
| Test | - | - | 0 | IN06 (Reference sensor) |  | Sub menu for input test |
| Test | - | - | 0 | Synchronizer signal |  | Sub menu for input test |
| T 60 03 | - | - | 0 | Test analog Input |  | Test of the analog inputs |
| - | 1024 | 0 | 0 | X120B.7 |  | Sub menu for input test |
| - | 1024 | 0 | 0 | X120B.20 |  | Sub menu for input test |



















Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------|------------|---|
| - | 1024 | 0 | 0 | X120T.7 | | Sub menu for input test |
| - | 1024 | 0 | 0 | X120T.20 | | Sub menu for input test |
| | 1024 | 0 | 0 | LMH_X9.4 | | Sub menu for input test |
| | 1024 | 0 | 0 | LMH_X9.5 | | Sub menu for input test |
| | 1024 | 0 | 0 | X120.7 | | Sub menu for input test |
| | 1024 | 0 | 0 | X120.8 | | Sub menu for input test |
| T 60 05 | - | - | 0 | Test Sewing Motor | | Use this subitem to test the functionality of the sewing motor. |
| Test | - | - | 0 | Active | | Activate the sewing motor |
| - | 4000 | 0 | 100 | Speed | | Actual max sew speed |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------|--|--|
| T 60 06 | - | - | 0 | Test Stepper Motor |   | You use this subitem to test stepper motors for stitch length adjustment, sewing foot lifting/sewing foot pressure and stroke adjustment. The machine can move to defined positions (steps), where 2000 steps = 360° |
| Test | - | - | 0 | Active |   | Activate the stepper 1 |
| - | 1000 | 0 | 1 | Position |   | Position of the stepper 1 |
| Test | - | - | 0 | Active |   | Activate the stepper 2 |
| - | 1400 | -2000 | 1 | Position |   | Position of the stepper 2 |
| Test | - | - | 0 | Active |   | Activate the stepper 3 |
| - | 1700 | 0 | 1 | Position |   | Position of the stepper 3 |
| Test | - | - | 0 | Active |   | Activate the stepper 4 |
| - | 10000 | 0 | 1 | Position |   | Position of the stepper 4 |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------|--|---------------------------|
| Test | - | - | 0 | Active |   | Activate the stepper 5 |
| - | 0 | 0 | 1 | Position |   | Position of the stepper 5 |
| Test | - | - | 0 | Active |   | Activate the stepper 6 |
| - | 0 | 0 | 1 | Position |   | Position of the stepper 6 |
| Test | - | - | 0 | Active |   | Activate the stepper 7 |
| - | 400 | 0 | 1 | Position |   | Position of the stepper 7 |
| Test | - | - | 0 | Active |   | Activate the stepper 8 |
| - | 0 | 0 | 1 | Position |   | Position of the stepper 8 |
| Test | - | - | 0 | Active |   | Activate the stepper 9 |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|------------|--|---|
| - | 9000 | 0 | 1 | Position |  | Position of the stepper 9 |
| Test | - | - | 0 | Active |  | Activate the stepper 10 |
| - | 0 | 0 | 1 | Position |  | Position of the stepper 10 |
| Test | - | - | 0 | Active |  | Activate the stepper 11 |
| - | 0 | 0 | 1 | Position |  | Position of the stepper 11 |
| Test | - | - | 0 | Active |  | Activate the stepper 12 |
| - | 0 | 0 | 1 | Position |  | Position of the stepper 12 |
| T 60 07 | - | - | 0 | Test Pedal |  | This subitem is used to check the various pedal positions of the analog pedal (X6b). The positions are indicated by measured and automatically calculated calibration values. |
| - | 1024 | 0 | 0 | DA Analog |  | Actual analog pedal value |




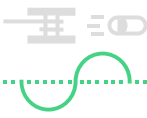
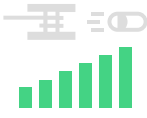




Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---------------|--|--|
| - | 128 | -2 | 0 | Digital |  | Actual digital pedal value |
| - | 1024 | 0 | 0 | Position -2 |  | Value for Position -2 |
| - | 1024 | 0 | 0 | Position -1 |  | Value for Position -1 |
| - | 1024 | 0 | 0 | Position 0 |  | Value for Position 0 |
| - | 1024 | 0 | 0 | Position Nmax |  | Value for Position Nmax |
| T 60 10 | - | - | 0 | Test Pedal 2 |  | This subitem is used to check the various pedal positions of the second analog pedal. The positions are indicated by measured and automatically calculated calibration values. |
| - | 1024 | 0 | 0 | DA Analog |  | Actual analog pedal value |
| - | 128 | -2 | 0 | Digital |  | Actual digital pedal value |
| - | 1024 | 0 | 0 | Position -2 |  | Value for Position -2 |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------------------|--|--|
| - | 1024 | 0 | 0 | Position -1 |  | Value for Position -1 |
| - | 1024 | 0 | 0 | Position 0 |  | Value for Position 0 |
| - | 1024 | 0 | 0 | Position Nmax |  | Value for Position Nmax |
| T 60 08 | - | - | 0 | Test Material Thickness Sensor |  | Use this subitem to test the functionality of the material thickness sensor. |
| Test | - | - | 0 | Signal quality |  | TID_Help_TST_SignalQuality |
| - | 20 | 0 | 0 | Foot height |  | Actual foot height |
| - | 9 | 0 | 0 | Sewing foot stroke |  | Actual foot stroke |
| - | 20 | 0 | 0 | Sewing foot pressure |  | Actual foot pressure |
| - | 4000 | 0 | 0 | Speed |  | Actual max sew speed |


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------------------------|--|--|
| - | 100 | 0 | 0 | Needle thread tension |  | Actual thread tension |
| - | 100 | 0 | 0 | Needle thread tension left |  | Actual thread tension (left) |
| T 60 09 | - | - | 0 | Test Loop control |  | Window for testing the SSD |
| T 06 02 | 4 | 0 | 1.7 | RFW Threshold |  | RFW Threshold right side |
| T 06 03 | 4 | 0 | 1.7 | RFW Intensity |  | RFW Intensity right side |
| - | 1024 | 0 | 0 | Bobbin thread counter |  | Function test procedure: Turn the bobbin. The counter increments every half turn. |
| - | 1024 | 0 | 0 | Bobbin thread value |  | Function test procedure: Slowly turn the empty bobbin into the reflection area. The measured value must be greater than 1500 if the setting is correct. |
| Test | - | - | 0 | Bobbin thread signal |  | Signal of the reflection surface |
| - | 1024 | 0 | 0 | Bobbin rotation counter |  | Function test procedure: Turn the bobbin. The counter increments several times per revolution. |






Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-----------------------|--|--|
| - | 1024 | 0 | 0 | Bobbin rotation value |  | Function test procedure: Slowly turn the bobbin into the reflection area. The measured value must be greater than 1500 if the setting is correct. |
| - | 1024 | 0 | 0 | Skip stitch counter |  | Function test procedure: Simulate the thread circulation. The counter increments at each thread pass. |
| - | 1024 | 0 | 0 | Skip stitch value |  | Function verification: The measured value must be between 700 and 900 if the setting is correct. |
| - | 1024 | 0 | 0 | Degree of pollution |  | Degree of pollution |
| T 06 04 | 4 | 0 | 1.7 | RFW Threshold |  | RFW Threshold left side |
| T 06 05 | 4 | 0 | 1.7 | RFW Intensity |  | RFW Intensity left side |
| - | 1024 | 0 | 0 | Bobbin thread counter |  | Function test procedure: Turn the bobbin. The counter increments every half turn. |
| - | 1024 | 0 | 0 | Bobbin thread value |  | Function test procedure: Slowly turn the empty bobbin into the reflection area. The measured value must be greater than 1500 if the setting is correct. |
| Test | - | - | 0 | Bobbin thread signal |  | Signal of the reflection surface |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-------------------------------------|--|--|
| - | 1024 | 0 | 0 | Bobbin rotation counter |  | Function test procedure: Turn the bobbin. The counter increments several times per revolution. |
| - | 1024 | 0 | 0 | Bobbin rotation value |  | Function test procedure: Slowly turn the bobbin into the reflection area. The measured value must be greater than 1500 if the setting is correct. |
| - | 1024 | 0 | 0 | Skip stitch counter |  | Function test procedure: Simulate the thread circulation. The counter increments at each thread pass. |
| - | 1024 | 0 | 0 | Skip stitch value |  | Function verification: The measured value must be between 700 and 900 if the setting is correct. |
| - | 1024 | 0 | 0 | Degree of pollution |  | Degree of pollution |
| - | - | - | 0 | Show maintenance messages as popups |  | When enabled, maintenance messages are shown with a popup dialog. In any case, maintenance messages are moved to the message queue for later inspection. |
| T 51 08 | - | - | - | Communication |  | Selection of QONDAC communication interface |
| T 51 09 | - | - | - | Customer ID |  | Editor that lets you set the customer ID |
| - | - | - | - | Server address |  | IP address of the QONDAC server |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---|--|--|
| T 51 20 | - | - | 0 | Reset Parameter | | All parameters are reset to the factory settings; this does not apply to the programs and the calibration values. |
| T 51 21 | - | - | 0 | Reset Programs | | All created programs are erased. |
| T 51 22 | - | - | 0 | Reset calibration | | All calibration values are reset to the factory settings. |
| T 51 23 | - | - | 0 | Reset all data (except calibration) | | All parameters, programs, machine and user data are reset to the factory settings. This does not apply the calibration values. |
| | - | - | 0 | Remove User Tutorials |  | All User Tutorials will be removed |
| | - | - | 0 | Remove vendor tutorials |  | All vendor tutorials will be removed |
| | - | - | 0 | Remove log data |  | All existing log data in the system will be removed |
| | - | - | 0 | Remove backup data |  | All existing backup data in the system will be removed |
| | - | - | 0 | Delete log files from panel and control |  | Delete log files from panel and control |









Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------------------|--|---|
| | - | - | 0 | Apply network settings changes |  | Applies all settings in this submenu |
| | - | - | - | Network Media Type |  | Select the network media type |
| | - | - | - | Wifi SSID |  | Enter the Wifi SSID |
| | - | - | - | Wifi Password |  | Enter the Wifi Password |
| | - | - | - | IP assignment |  | Selectable address allocation types: - Static IP address - Dynamic allocation (DHCP) - Dynamic allocation (DHCP) from QONDAC network |
| | - | - | - | Server identifier |  | Identification name of the QONDAC DHCP server the client shall use for connecting |
| | - | - | - | Client identifier |  | Identification name of the client (machine) at the QONDAC DHCP server |
| | - | - | - | IP address |  | IP address of the machine |
| | - | - | - | Subnet mask |  | Subnet mask of the machine |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------|--|---|
| | - | - | - | Gateway |  | Address of the gateway to other subnets (optional) |
| | - | - | - | Name server |  | Address of the name server / DNS server (optional) |
| | - | - | - | Connection state |  | Shows the current connection state |
| | - | - | - | Network Media Type |  | Select the network media type |
| | - | - | - | Wifi SSID |  | Enter the Wifi SSID |
| | - | - | - | IP assignment |  | Select method how to assign an IP address |
| | - | - | - | Server identifier |  | Identification name of the QONDAC DHCP server the client shall use for connecting |
| | - | - | - | Client identifier |  | Identification name of the client (machine) at the QONDAC DHCP server |
| | - | - | - | IP address |  | IP address of the machine |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|---------------------------------|--|--|
| | - | - | - | Subnet mask |  | Subnet mask of the machine |
| | - | - | - | Gateway |  | Address of the gateway to other subnets (optional) |
| | - | - | - | Name server |  | Address of the name server / DNS server (optional) |
| | - | - | - | MAC address |  | MAC address of the machine |
| T 51 32 | - | - | 0 | Store to USB | | TID_Help_DAT_ActionStoreToUsbComplete |
| | - | - | 0 | Get last log files from control |  | Get last log files from control |
| | - | - | 0 | Get all log files from control |  | Get all log files from control |
| | - | - | 0 | Hardware drivers |  | Add logger modules |
| | - | - | 0 | Operation panel |  | Add logger modules |










Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|--------------------|--|--------------------|
| | - | - | 0 | Data configuration |  | Add logger modules |
| | - | - | 0 | Startup measures |  | Add logger modules |
| | - | - | 0 | Thread trimmer |  | Add logger modules |
| | - | - | 0 | Sewing motor |  | Add logger modules |
| | - | - | 0 | Pedal |  | Add logger modules |
| | - | - | 0 | Machine process |  | Add logger modules |
| | - | - | 0 | Backtack |  | Add logger modules |
| | - | - | 0 | Edge trimmer |  | Add logger modules |
| | - | - | 0 | PWM |  | Add logger modules |


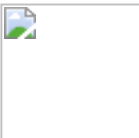
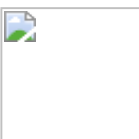


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|----------------|--|--------------------|
| | - | - | 0 | Stitch length |  | Add logger modules |
| | - | - | 0 | Thread tension |  | Add logger modules |
| | - | - | 0 | Foot lift |  | Add logger modules |
| | - | - | 0 | Foot pressure |  | Add logger modules |
| | - | - | 0 | Foot stroke |  | Add logger modules |
| | - | - | 0 | Fabric sensor |  | Add logger modules |
| | - | - | 0 | Speed manager |  | Add logger modules |
| | - | - | 0 | Light barrier |  | Add logger modules |
| | - | - | 0 | SSD |  | Add logger modules |



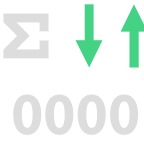


Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|------------------------------------|--|--------------------|
| | - | - | 0 | Function I/Os |  | Add logger modules |
| | - | - | 0 | File operations |  | Add logger modules |
| | - | - | 0 | Remote |  | Add logger modules |
| | - | - | 0 | Smart bobbin winder |  | Add logger modules |
| | - | - | 0 | Fabric thickness predictive sensor |  | Add logger modules |
| | - | - | 0 | Thread tension sensor |  | Add logger modules |
| | - | - | 0 | Desk height |  | Add logger modules |
| | - | - | 0 | Edge Guide |  | Add logger modules |
| | - | - | 0 | Bobbin winder |  | Add logger modules |



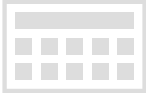





Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-----------------------|--|--|
| | - | - | 0 | Stitch Information |  | Add logger modules |
| | - | - | 0 | Needle thread monitor |  | Add logger modules |
| | - | - | 0 | QONDAC |  | Add logger modules |
| | - | - | 0 | SSH |  | SSH connection active |
| | - | - | 0 | Core dump generation |  | Activates generation of core dump files on application crash |
| | - | - | - | |  | |
| | - | - | - | Time zone |  | Select time zone |
| | - | - | - | Time format |  | Setting time format 12h/24h |
| | - | - | - | Application |  | Version of Application |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|------------------------------|--|--|
| | - | - | - | Application tag |  | Version tag of Application |
| | - | - | - | Machine |  | Software Version of connected machine |
| | 9999999 | 0 | 0 | Total piece counter | | Piece counter total |
| | 60000 | 0 | 0 | Daily piece counter | | Piece counter daily |
| | 100000000 | 0 | 0 | Total stitch counter | | Stitch counter total |
| | 100000000 | 0 | 0 | Stitch counter bobbin thread | | Stitch counter bobbin thread |
| | - | - | - | Qondac Piece Counter Mode |  | Qondac Piece Counter Mode |
| | - | - | - | Working time |  | Working time for the whole time of the machine |
| | - | - | - | Working time daily |  | Working time from the last start |

Parameter List

| Parameter ID: | Max value: | Min value: | Default value: | Name: | Icon Path: | Description: |
|---------------|------------|------------|----------------|-----------------------------|--|---|
| | - | - | - | Control unit |  | Control unit type |
| | - | - | - | Serial number |  | This is the serial number of the control unit |
| | - | - | - | Panel Type |  | Show the panel type |
| | - | - | - | Machine class |  | Selected machine class |
| | - | - | - | Machine subclass |  | Selected machine subclass |
| | - | - | - | Machine thread tension type |  | |
| | - | - | - | Serial number |  | This is the serial number of the machine |
| | - | - | - | Production date |  | This is the production date of the machine |
| | - | - | 0 | Generate parameter sheets | | |



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