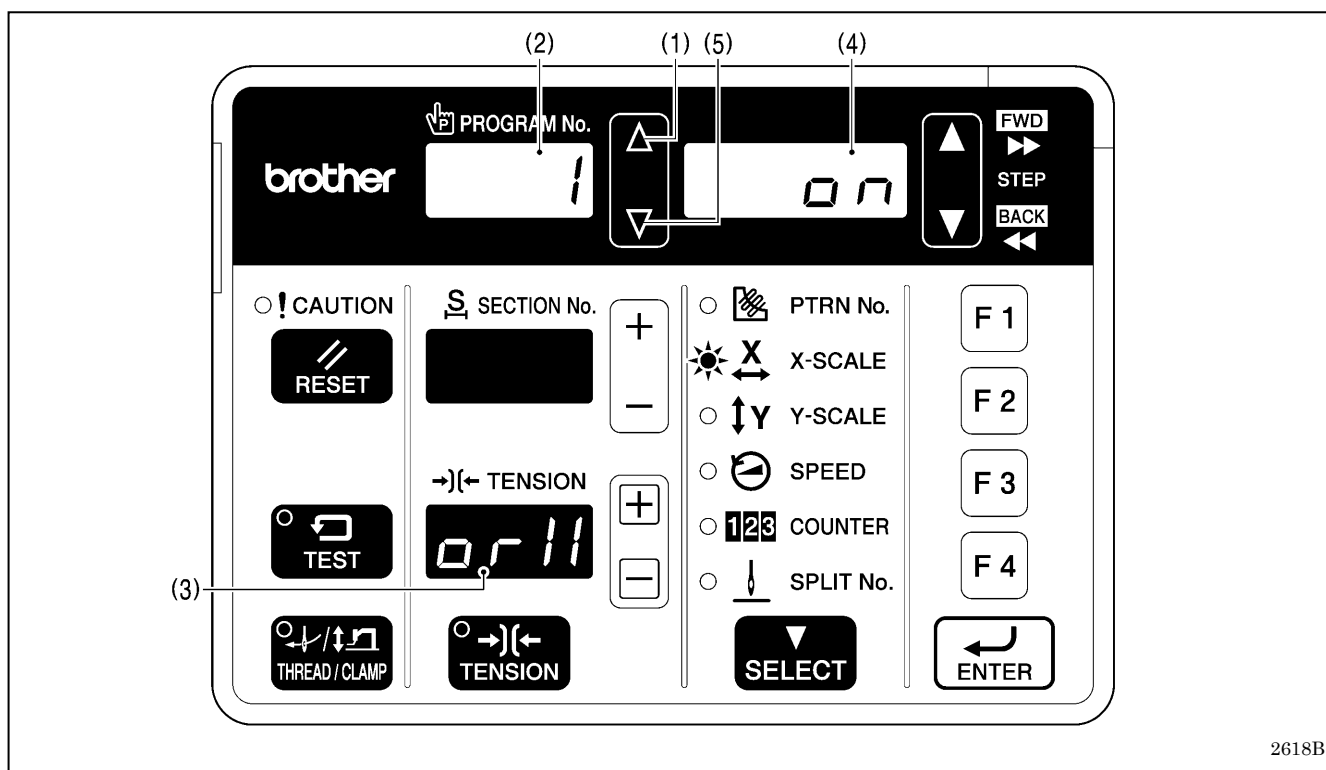


. INPUT Check



1. Press Δ key (1) + Power ON
 - ⇒ Program Number display (2) = Check Code
 - ⇒ Tension display (3) = Abbreviation
 - ⇒ Menu display (4) = Input status

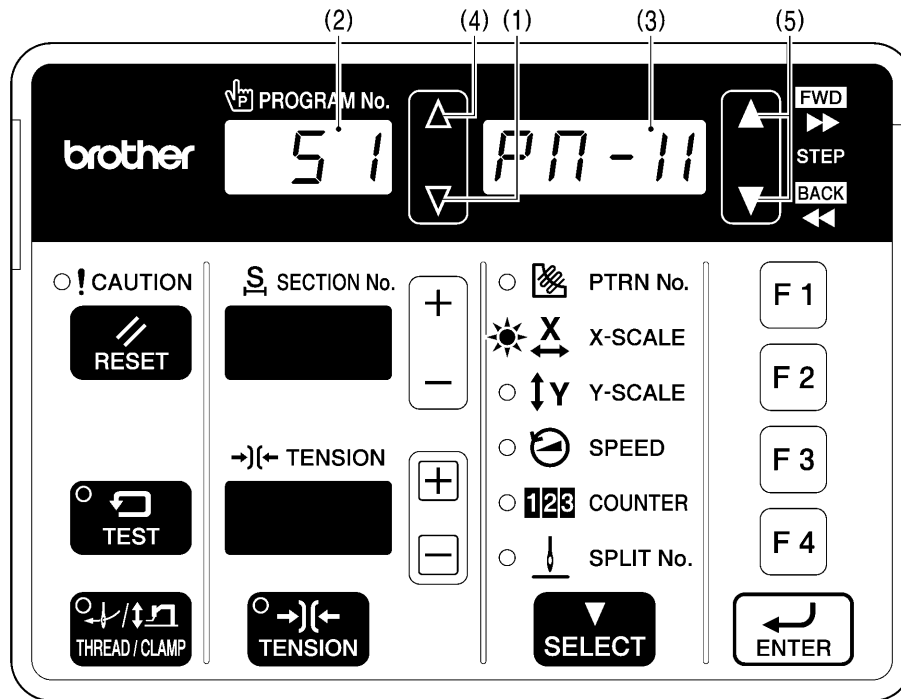
<Input check list>

Check code	Abbreviation	Input status	Check items and checking methods
[1]	[orX]	[on] / [oFF]	X-feed shaft motor home position sensor position Move the feed mechanism manually in the X-feed direction
[2]	[EnX]	[-999] ~ [999]	X-feed shaft motor encoder counter value
[3]	[orY]	[on] / [oFF]	Y-feed shaft motor home position sensor position
[4]	[EnY]	[-999] ~ [999]	Y-feed shaft motor encoder counter value

Check code	Abbreviation	Input status	Check items and checking methods
[5]	[orP]	[on] / [oFF]	Work clamp motor home position sensor position
[6]	[EnP]	[−999] ~ [999]	Work clamp motor encoder counter value
[7]	[dEG]	[000] ~ [359]	Upper shaft 360 degree rotation signal
[8]	[UP]	[on] / [oFF]	Needle up signal
[9]	[voL]	[* * *]	Power supply voltage
[10]	[PnL]	[※] / [oFF]	Operation panel key input check
		※ON display	Key name
		[rESt]	RESET key
		[tESt]	TEST key
		[tHrE]	THREAD/CLAMP key
		[tEn]	TENSION key
		[SELE]	SELECT key
		[UP-M]	▲ key
		[dn-M]	▼ key
		[UP-S]	SECTION+ key
		[dn-S]	SECTION− key
		[UP-t]	TENSION+ key
		[dn-t]	TENSION− key
		[F1]	F1 key
		[F2]	F2 key
		[F3]	F3 key
		[F4]	F4 key
		[Ent]	ENTER key
[11]	[FtA]	[0] ~ [255]	Foot switch analog value
[12]	[FtS]	[back] / [oFF] / [CLnP] / [strt]	Foot switch signal back : backward oFF : neutral CLnP : first step Strt : second step
[13]	[CL1]	[on] / [oFF]	Work clamp switch 1st step
[14]	[CL2]	[on] / [oFF]	Work clamp switch 2nd step
[15]	[Stt]	[on] / [oFF]	Start switch

Check code	Abbreviation	Input status	Check items and checking methods
[16]	[EMC]	[no] / [oFF] / [on]	Stop switch(option)
[17]	[HEd]	[on] / [oFF]	Machine head switch
[18]	[orn]	[on] / [oFF]	Thread nipper home position sensor Press the ▲ key to move the thread nipper in the home position direction. Press the ▼ key to move the thread nipper in the retract direction.
[19]	[Enn]	[-999] ~ [999]	Thread nipper encoder position
[20]	[in1]	[on] / [oFF]	Option input (IN1)
[21]	[in2]	[on] / [oFF]	Option input (IN2)
[22]	[in3]	[on] / [oFF]	Option input (IN3)
[23]	[in4]	[on] / [oFF]	Option input (IN4)
[24]	[in5]	[on] / [oFF]	Option input (IN5)
[25]	[in6]	[on] / [oFF]	Option input (IN6)
[26]	[in7]	[on] / [oFF]	Option input (IN7)
[27]	[in8]	[on] / [oFF]	Option input (IN8)
[28]	[in9]	[on] / [oFF]	Option input (IN9)
[29]	[i10]	[on] / [oFF]	Option input (IN10)

4-1. OUTPUT check



2619B

1. ▽ key (1) + Power ON
⇒ PROGRAM No. display (2) = check code
⇒ menu display (3) = abbreviated output name
2. Press the ▲ or ▼ key (5) to check the operations for check codes 51 - 54.
3. For check code 55 and after, depress the foot switch to the 2nd step.
4. When returning to normal operation, turn power off and then on again.

Check code	Abbreviation	Function
[51]	[PM-X]	When you press the ▲ key, the work clamps move to the left. When you press the ▼ key, the work clamps move to the right.
[52]	[PM-y]	When you press the ▲ key, the work clamps move forward. When you press the ▼ key, the work clamps move back.
[53]	[PM-P]	When you press the ▲ key, the work clamps rise. When you press the ▼ key, the work clamps drop.
[54]	[PM-n]	When you press the ▲ key, the thread nipper moves toward the home position. When you press the ▼ key, the thread nipper moves toward the retract position.

[55]	[CL-r]	The valve for the right work clamp turns on (*)
[56]	[CL-L]	The valve for the left work clamp turns on (*)
[57]	[Foot]	The valve for the stepping foot turns on (*)
[58]	[FLiP]	The valve for the inner clamping device turns on. (*)
[59]	[CooL]	The valve for the needle cooler turns on. (*)
[60]	[7SEG]	The LEDs on the panel illuminate in sequence, and then each of the seven segments of the PROGRAM No. display and menu display illuminate.
[61]	[CUt]	The thread trimmer solenoid turns on.
[62]	[dtEn]	The tension release solenoid turns on.
[63]	[WiP]	The external wiper solenoid turns on.(*)

[64]	[oP 1]	Option output 1 turns on. (*)
[65]	[oP 2]	Option output 2 turns on. (*)
[66]	[oP 3]	Option output 3 turns on. (*)
[67]	[oP 4]	Option output 4 turns on.
[68]	[oP 5]	Option output 5 turns on.
[69]	[oP 6]	Option output 6 turns on.
[70]	[oP 7]	Option output 7 turns on.
[71]	[oP 8]	Option output 8 turns on.
[72]	[oP 9]	Option output 9 turns on.
[73]	[oP10]	Option output 10 turns on.
[74]	[oP11]	Option output 11 turns on.
[75]	[oP17]	Option output 17 turns on.
[76]	[oP18]	Option output 18 turns on.
[77]	[oP19]	Option output 19 turns on.
[78]	[oP20]	Option output 20 turns on.

- * Spare for the KE-430F and BE-438