

■ No. **2012-105** ■ Date: 2012/8/16

Model : **BAS-300G-484**

Title : **Add Memory Switch & Error Code & Table of option input BAS-300G-484**

Additional Memory Switch and Error code for BAS-300G-484

1. Memory Switch

No.	Setting range	Setting detail	Default setting
557	External thread wiper device		2
	0	Disabled	
	1	Solenoid type	
	2	Pneumatic type	
564	Increases maximum tension release force when using a spring-type tension		1
	0	Disabled (Tension release is open at the sewing end.)	
	1	Increases the force. (Tension release is closed approximately 5 minutes.)	
	2	Increases force to the maximum. (Tension release is closed approximately 1 minutes.)	
	3	Increases the force. (Tension release is open.)	
4	Increases force to the maximum. (Tension release is closed approximately 5 minutes.)		
569	Detect timing of the bobbin checker		0
	0	Disabled	
	1	Detect before sewing	
	2	Detect after sewing	
570	Waiting time for ending detect bobbin.		30
	1 - 99	Units [X10 msec]	
571	Waiting time for detecting bobbin.		30
	1 - 99	Units [X10 msec]	
572	Time for bobbin detecting signal output		50
	1 - 99	Units [X10 msec]	
573	On timing of solenoid valve for thread trimmer		0
	0 -200	Units [msec] (Thread trimming timing end of cycle)	
574	Off timing of solenoid valve for thread trimmer		100
	0 -999	Units [msec] (Thread trimming on time)	
575	Tread retracting device		ON
	OFF	Disabled	
	ON	Able	
576	On timing of solenoid valve for thread retracting		260
	40 - 300	Units [degree]	

851	Stepping foot device (only for BAS-300G-484SF) *Won't be changed by initialaization		
	OFF	Disabled	484
	ON	Able	484SF

2. Error Code

The following error code was added. These error can't reset by "RESET" key on the operation panel.

Code	Cause and remedy
E459	An incompatible machine head has been connected. Check that the combination of control box and machine head is correct.
E670	Abnormality of bobbin checker Turn off power.
E671	Inner clamp device (No. 556) and bobbin checker No. 569) both memory switch has been set to on. Select only one memory switch set to on. Turn off power.

3. Table of option input

Option input No.	Combined output		Connector	
	Application	Use condition	Connector No.	Pin No.
1	Ejector right sensor	Memory SW-560 : 1,2	P 23(EXIN1)	2
2	Ejector left sensor Shared with start prohibit signal			5
3	Reset switch			8
4	Sensor for trimming solenoid valve	11		
5	—	14		
6	P no input bit 0	Memory SW-354 : 1,2	P 24(EXIN2)	2
7	P no input bit 1			5
8	P no input bit 2			8
9	P no input bit 3			11
10	P no input bit 4			14
11	Thread nipper front sensor	Memory SW-500 ON	P 10 (SENSOR2)	2
12	Thread nipper rear sensor			5
13	Air switch	Memory SW-558 ON	P 12(AIR1)	12
14	Thread detector	Memory SW-554 ON	P8 (SENSOR1)	11

4. Table of option output

Option output No.	Combined output		Connector	
	Application	Use condition	Connector No.	Pin No.
1	2-step thread tension device	Memory SW-563 ON	P 1 2 (AIR1)	5
2	Air wiper	Memory SW-557 : 2		6
3	Aut eject	Memory SW-560 : 1,2,3		7
4	Right work clamp flip/flop	Memory SW-55 ON	P 2 5 (AIR2)	1
	Pno output bit 0	Memory SW-951 ON		
5	Left clamp flip/flop	Memory SW-55 ON		2
	Pno output bit 1	Memory SW-951 ON		
6	Pno output bit 2			3
7	Pno output bit _3			4
8	—	—		5
9	Signal tower green	Memory SW-559 ON		6
10	Signal tower yellow			7
11	Signal tower red			8
12	Needle cooler	Memory SW-550 ON		P 1 2 (AIR1)
13	Inner clamp device Shared with bobbin checker	Memory SW-556 : 1,2,3	4	
	14	—	3	
15	Left clamp	When using 2-stage clamp	2	
16	Right clamp	In case of air type	1	
17	Air trimmer	Memory SW-575 ON	P 2 6 (AIR2)	1
18	Air trimmer	Memory SW-164 ON		2
19	—	—		3
20	—	—		4