

**HIKARI**®

专注高端 电脑包缝机的领导者

FOCUSING ON HIGH-END  
COMPUTERIZED OVERLOCK MACHINE LEADER

**HP-700** OPERATION PANEL  
操作显示盘

**使用说明书**

INSTRUCTION MANUAL BOOK

CE



通过 ISO9001:2008  
质量管理体系认证

# 前 言

感谢您选用本公司的产品，该手册提供了此系统所需的操作指导说明。

为了您更好地使用该产品，在使用之前请仔细阅读本手册。

- 由于产品的改进，本手册内容可能随时变更，恕不另行通知。
- 您在使用中若有任何疑问或对我们的产品和服务有任何意见，请随时与我们售后服务部联系。

## PREFACE

Thank you for selecting our product. The introduction provides necessary knowledge and notes for using.

Please read safety introduction carefully and understand them before using.

- The content of the introduction will be amended with the improvement of our product, the notice is not announced.
- If you have any doubts or comments about our product and service, please contact after-sale service.

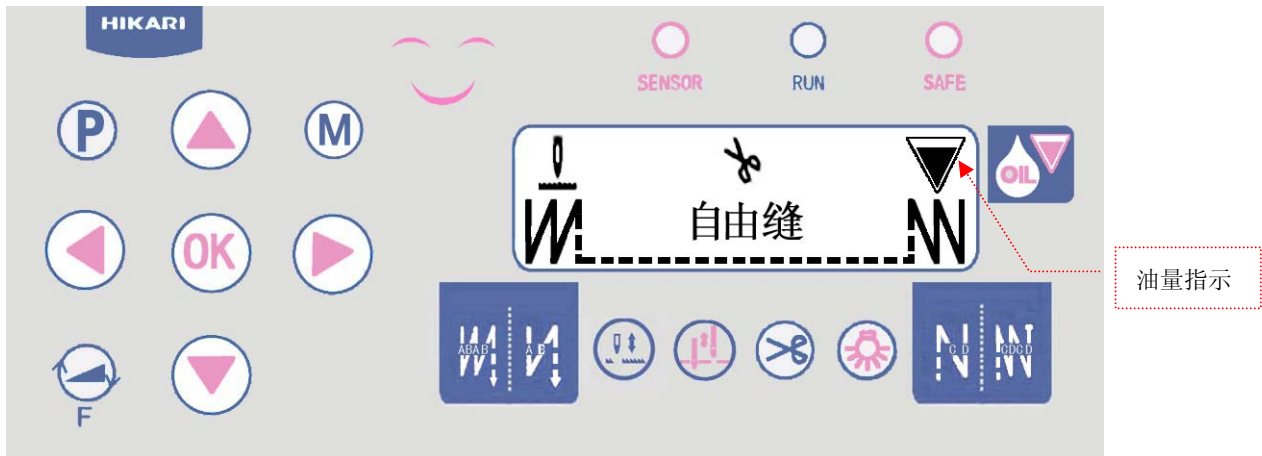
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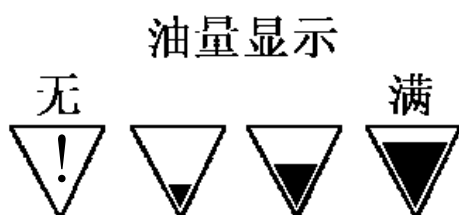
## 1. 显示面板区域说明



## 2. 操作面板按键说明

序号	图标	按键名称	按键功能描述
1		用户参数设定键	1. 按键一次，进入用户参数编辑模式； 2. 按住 3 秒以上，开启/关闭起针夹线器
2		左移键	向左移编辑区
3		用户参数显示切换键/速度设定键	1. 按键一次进行缝纫速度设定； 2. 用户参数编辑时按键一次切换参数显示
4		增大键	增大参数值
5		确认键	存储确认
6		减小键	减小参数值
7		模式转换键	按下进行六种模式转换
8		右移键	向右移编辑区
9		前固缝	无、单、双、四前固缝循环选择
10		补针	每按一次补半针，长按时连续补针
11		停针位置	设定停针时，停上针位还是停下针位
12		剪线开关	
13		LED 亮度调整键	
14		后固缝	无、单、双、四后固缝循环选择

### 3. 油量显示图示



### 4. 缝纫模式

序号	模式名称	参数编辑示例
1	四段缝	
2	八段缝	
3	七段缝	
4	自由缝	
5	定长缝	定长缝针数: 15
6	W 缝	










### 5. 组合键定义

- (1) + : 进入或退出工艺参数设置模式
- (2) + : 显示上操作面板软件版本号。
- (3) + : 显示下位机软件版本号。
- (4) + : 显示机型码。
- (5) + : 开启/关闭自动抬压脚。
- (6) + : 开启/关闭慢启动。


- (7)  +  : 显示底线针数。
- (8)  +  : 底线针数复位。
- (9)  +  : 开启/关闭油量警报
- (10)  +  : 开启/关闭自动缝纫

## 6. 显示模式及操作方法


### 6.1 工艺参数设定

同时按  +  进行工艺参数设置模式，要求输入密码（密码存储在主电控内，默认出厂密码为 2222），通过 、 调整数值，通过 、 进行数位切换，再按一下  键，校验所输入的密码是否正确？如果密码正确则进入工艺参数调整模式，完成参数调整后按  键确认，按  键退出。


### 6.2 缝纫模式设定

按  键进行缝纫模式切换。可选择模式有四段缝，八段缝，七段缝，自由缝，定长缝，W 缝。




### 6.3 前固缝模式

除 W 缝外，按下前固缝  键，可进行加固模式切换，对应的显示区内前固缝图标根据前固缝参数点亮。分为无加固模式，单加固模式和双加固模式

### 6.4 后固缝模式







除 W 缝外，按下后固缝  键，可进行加固模式切换，对应显示区的后固缝图标根据后固缝参数点亮。分为无加固模式，单加固模式和双加固模式


### 6.5 剪线功能设定

按一次  键，则点亮  图标，表示开启剪线功能，当再次按下  时，则关闭剪线

功能， 图标消失

## 6.6 用户参数设定

除无加固的自由缝外，按  一次，进入用户参数编辑模式(图 2)，通过 、 调整参数值，通过 、 进行参数位切换，完成参数调整后按  确认退出。

除自由缝和 W 缝以外，其它的缝纫模式，如果有固缝参数，则不可能在同一时刻把所有参数显示出来，此时，如果想查看其它的参数按  一次，达到查看固缝参数或缝纫针数的功能。

如下图 1 八段缝针数设定和图 2 加固缝针数设定通过切换进行显示和设定。

图 1——八段缝针数设定

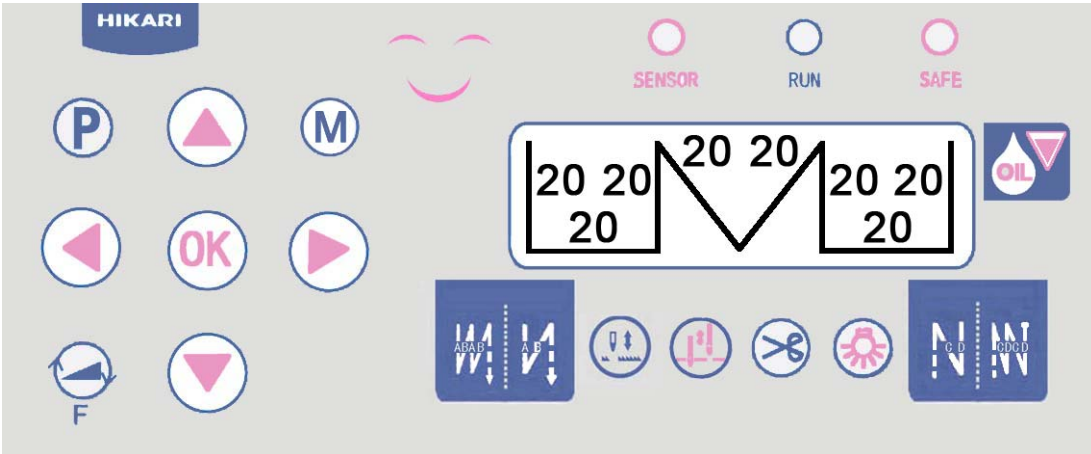
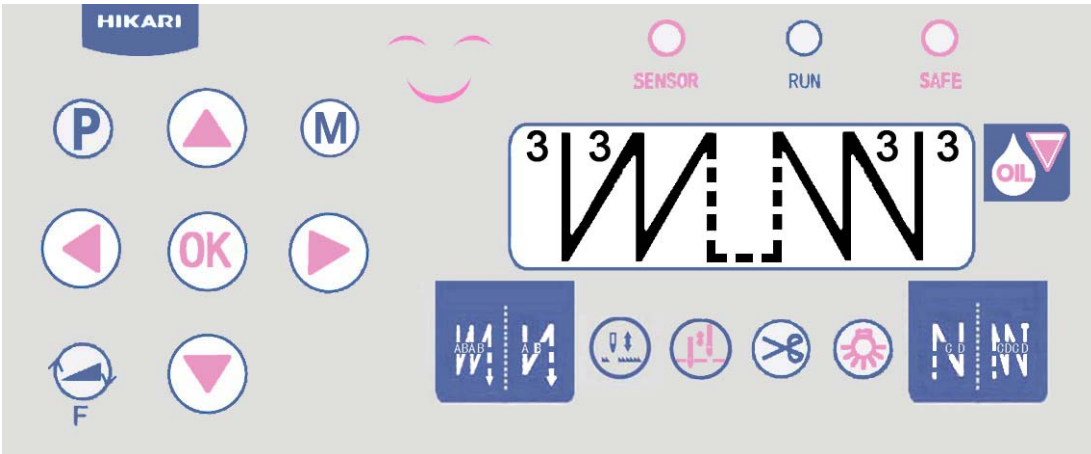



图 2——加固缝针数设定



## 6.7 速度调节

在非调整参数的模式下，连接两下  键松开，即可进入速度修改模式，通过 、 调整具体的速度。

## 6.8 停针位设定

在非调整参数的模式下，按下键即可进行上停针和下停针的切换，对应显示屏上显示上停针图标和下停针图标。

## 6.9 照明灯亮度调节

按下键盘即可调节照明灯的亮度，有 4 档亮度可选择。

## 7. 针迹补偿调整方法

### 7.1 调整前的准备

1. 查看机头针距出厂值。（一般为 3mm，有些厂家的出厂值是 2.5mm）
2. 采用手动倒缝的方式，正倒缝八针，查看针迹重合效果，保证针迹重合良好的情况下，进入下一步调整，否则固缝是很难调好的！

### 7.2 调整步骤

1) 上电后，把缝纫模式设为定长缝模式，关闭前固缝，设单后固缝，将 C 的参数设为 4 针，定长针数为 4 针，开启自动触发功能，脚踏前踩一下，看看针迹是否重合？如果重合，表明参数完全适应，如果出现不重合现象，将会产生以下二种情况，然后再根据情况调整参数即可。

第一种情况：C 段短了一截或少了一针，如图 1-1 所示。

第二种情况：C 段多了一截或多了一针，如图 1-2 所示。

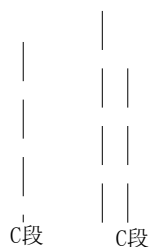


图 1-1

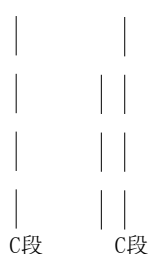


图 1-2

针对第一种情况，可以通过将工艺参数 P42 的数值适当调大来达到完全重合。

针对第二种情况，可以通过将工艺参数 P42 的数值适当调小来达到完全重合。

2) 将后固缝方式改变双后固缝，并将 D 参数设为 4 针，脚踏前踩一下，看看针迹是否重合？如果重合，表明参数完全适应，如果不重合，将会产生以下二种情况，然后再根据情况调整参数即可。

第一种情况（少针）：最后面的 D 段短了一截或少针，如图 1-3 所示。

第二种情况（多针）：最后面的 D 段多了一截或多针，如图 1-4 所示。



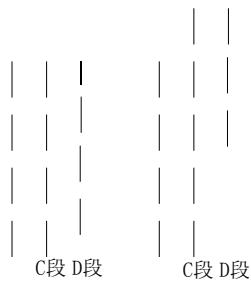


图 1-3

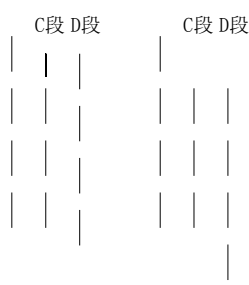


图 1-4

针对第一种情况，可以通过将工艺参数 P43 的数值适当调大来达到完全重合。

针对第二种情况，可以通过将工艺参数 P43 的数值适当调小来达到完全重合。

多段缝的前后固缝的调整方法与 W 缝的调整方法一致。也可以直接把 P42 的参数值直接写入 P40, P44。把 P43 的值写入 P41, P45。当然，如果前后固缝的速度与 W 缝的速度不一样的时候则须要分别重调。

## 8. 操作面板参数说明表

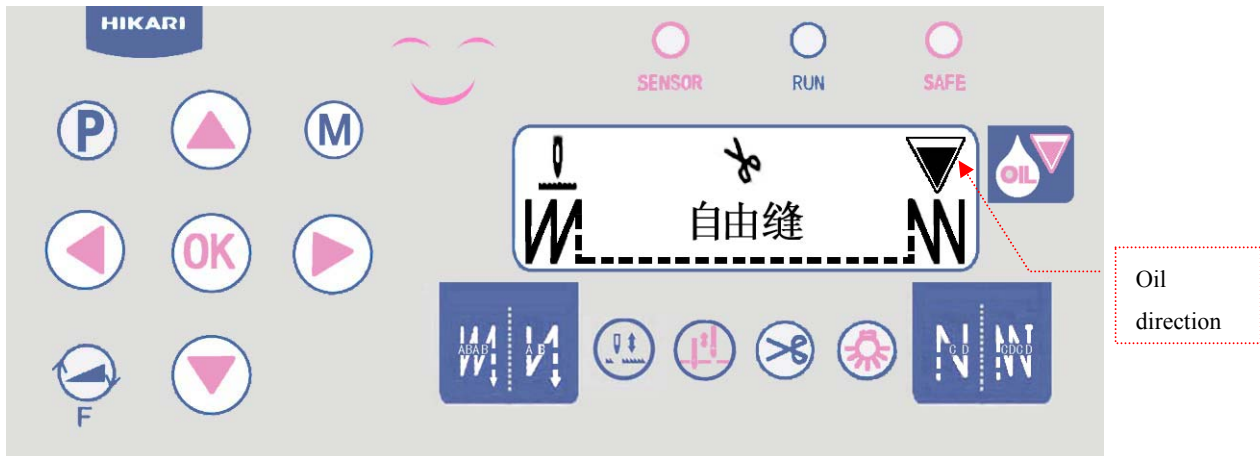
序号	功能参数	默认值	设定范围	单位	参数说明
P0	踏板斜率	50	1~100	%	斜率越大，低速区域越大，速度变化越大；斜率越小，低速区域越小，速度变化越小。
P1	速度比例	8	1—8		自由缝最高速度的限定比例。将自由缝最高速度分成 8 等分，通过调整等分值来改变当前自由缝最高速度
P2	系统最低转速	200	150~500	RPM	缝纫时，机头最低转速限制
P3	自由缝最高转速	3600	150~5000	RPM	自由缝模式时，机头最高转速
P4	定速缝速度	3000	150~4000	RPM	定长缝自动触发时的缝纫速度
P5	前固缝速度	1800	200~3000	RPM	执行前固缝时的缝纫速度
P6	后固缝速度	1800	200~3000	RPM	执行后固缝时的缝纫速度
P7	前固缝完暂停	off	On/off		前固缝完毕暂停，需要踏板触发后模式才继续运行
P8	后固缝前暂停	off	On/off		后固缝前暂停，需要踏板触发才执行后固缝
P9	W 缝速度	1800	200~3000	RPM	W 缝模式时的缝纫速度
P15	倒缝最高速度	2500	200~3000	RPM	倒缝时的最高速度
P16	扫线通电时间	50	20~1000	ms	扫线电磁铁的动作时间
P17	暂停过程中按键是否吸合倒缝电磁铁	on	On/off		当电机不运转时，按倒缝键是否允许倒缝电磁铁动作
P18	针迹/速度优先	0	0~1		缝纫时，针迹或速度的优先级别设定 0: 针迹优先 1: 速度优先
P19*	抬压脚开关	On	On/off		开启或关闭抬压脚功能
P21	计数功能选择	0	0-2		0:无计数功能 1:底线计数功能 2:剪线计数功能

P22	慢启动针数	2	0~15		以慢启动速度缝纫的针数
P23	慢启动速度	500	200~3000	RPM	慢启动缝纫时的速度
P24	底线基数	10	1-100		底线变化多少针时，当前计数变化 1 个单位。
P25	底线总数	2000	1-9999		设定的底线总数
P26	当前计数	2000	0-9999		当前的底线数量
P27	倒缝全额启动时间	200	20~500	ms	倒缝电磁铁的初始出力时间
P28	倒缝通电时间	2	1~50	ms	倒缝电磁铁力度保持时的高电平时间
P29	倒缝断电时间	2	1~50	ms	倒缝电磁铁力度保持时的低电平时间
P31	夹线器开关	1	0/1		设定电子夹线器功能 0: 关闭 1: 开启
P34*	上电找针位	On	On/off		上电后，是否自动找到上针位点。
P36	剪线速度	250	200~500	RPM	剪线时的运转速度
P37*	半后踏自动抬压脚	on	On/off		开启或取消半后踏自动抬压脚
P40	前固缝补偿参数 1	7	0-16		前固缝针迹补偿参数 1
P41	前固缝补偿参数 2	5	0-16		前固缝针迹补偿参数 2
P42	后固缝补偿参数 1	7	0-16		后固缝针迹补偿参数 1
P43	后固缝补偿参数 2	5	0-16		后固缝针迹补偿参数 2
P44	W 缝补偿参数 1	7	0-16		W 缝针迹补偿参数 1
P45	W 缝补偿参数 2	5	0-16		W 缝针迹补偿参数 2
P46	手动老化开关	0	0/1		0: 正常操作模式 1: 老化拖车模式
P47	老化停顿时间	2000	100-9999	ms	老化时每次运行之间的时间间隔
P48	老化运行时间	2000	100 — 9999	ms	老化时每次运行的时间（在没有定位器时有效）
P54	安全开关信号型式	0	0/1		0: 常开 1: 常闭
P55	自动抬压脚的放压脚模式	1	0/1		0: 脚踏松开后受自动放压脚时间控制或再半后踏一次退出抬压脚 1: 脚踏松开后，自动放压脚
P57	抬压脚启动时间	250	20~1000	ms	抬压脚电磁铁的初始出力时间
P58	抬压脚通电时间	2	1~50	ms	抬压脚电磁铁的力度保持时的高电平时间
P59	抬压脚关断时间	3	1~50	ms	抬压脚电磁铁的力度保持时的低电平时间
P60	抬压脚保护时间	20	1~120	s	抬压脚工作保护时间

P61	抬压脚延迟时间	50	20~800	ms	电机停转后,多长时间开始抬压脚
P62	放压脚延迟时间	50	20~800	ms	压脚放下后,多少时间才允许启动
P64*	上电后自动抬压脚时间	0	0-900	s	上电后自动抬压脚的时间
P65	布边传感器功能选择	0	0-1		0: 无布边传感器 1: 有布边传感器
P67	布头布尾速度	800	200-5000	RPM	检测到布头信号后的运转速度
P69	布边延时启动时间	1000	100-9999	ms	检测到布头信号后的延时启动时间
P73	有无布边传感器	off	On/off		是否有外接布边传感器
P74	倒缝/抬压脚气动选择	0	0-3		0: 全部电动 1: 倒缝气动 2: 压脚气动 3: 全部气动
P76	剪线次数	0	0-9999		每剪一次线计数加 1,加满清零
P98	参数恢复默认值	0000h	0-9999		
P99	工艺参数密码	2222h	0-9999		



备注: 1. 常用参数说明: (单位说明: RPM 转/分钟; ms 毫秒; s 秒; hour 小时);  
1. 序号带\*表示该参数修改后需要重新上电才能生效.

## 1. Instruction of the panel display region



## 2. Button instructions of the panel

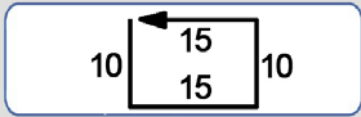
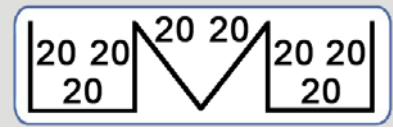
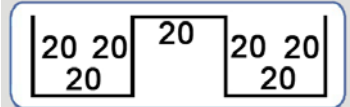
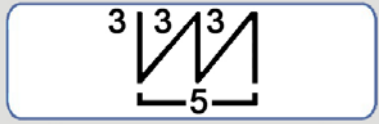
NO.	Icon	Key name	Button function description
1		Parameter set	1. Press once, enter the technical parameter adjustment mode; 2. Holding the button 3s , Turn on/off the thread clamp
2		Left button	Left move editing area
3		Multi-function button	1. Continuously press the button twice enter sewing speed adjustment mode; 2. Press the button once ,switch parameter display when machine is sewing.
4		Increase button	Increase parameter
5		OK button	saving confirm
6		Reduce button	Reduce parameter
7		Sewing mode	Select sewing pattern.
8		Right button	Right move editing area
9		Fore-tacking sewing	Circulate selection of non-, single-, double-, four- fore-tacking sewing
10		Mending stitch	Mending half stitch when pressing the key once, it will continuously mend stitch while holding press.
11		Needle stop position	Selection of needle up position or needle down position when stopping the needle.
12		Thread trimming set	Trimming and sweep when pattern operation finished once or canceling the function.

13		LED brightness adjust button	
14		Back-tacking sewing	Circulate selection of non-, single-, double-, four-, back-tacking sewing







### 3. Oil display icon

















### 4. Sewing pattern

NO.	Pattern name	For example
1	Four-section sewing	
2	Eight-section sewing	
3	Seven-section sewing	
4	Free sewing	
5	Fixed sewing	定长缝针数: 15
6	W sewing	










### 5. Definition of key combination

- (11)  + : Enter or exit the technical parameter set.
- (12)  + : Display the version of the panel software.
- (13)  + : Display the version of the main control box software.


- (14)  +  : Display the type of the machine.
- (15)  +  : Turn on/off the function of foot.
- (16)  +  : Turn on/off the slow-startup.
- (17)  +  : Display the current amount of lower thread.
- (18)  +  : Reset the lower parameter will.
- (19)  +  : Turn on/off the oil alarm
- (20)  +  : Turn on/off the auto sewing.

## 6. Display mode and operating method


### 6.1 Technical parameter set

Press  and  at the same time, it will enter the technical parameter adjustment mode, showing “PSD-0000”. Then input the password(the password is stored in the control box, the default password is 2222).Through pressing the 、 we can change the corresponding number, Through pressing the 、 will switch editing area, then pressing , If the password is correct, it enters the technical parameter adjustment mode.Press  saving confirm , Press  exit the technical parameter adjustment mode.


### 6.2 Sewing pattern set

Press Sewing mode ,will be select sewing pattern。 Circulate selection of four-section sewing, eight-section sewing, seven-section sewing, free sewing, fixed sewing, W sewing.




### 6.3 Fore-tacking sewing mode

Except W mode, press the fore-tacking sewing button , the fore-tacking sewing symbol at the corresponding region will be lighted up according to the fore-tacking sewing parameter. Circulate selection of non-, single-, double-, four-, fore-tacking sewing.







## 6.4 Back-tacking sewing mode


Press the back-tacking sewing button , the back-tacking sewing symbol at the corresponding region will be lighted up according to the back-tacking sewing parameter, except W sewing mode. Circulate selection of non-, single-, double-, four- back-tacking sewing.

## 6.5 Thread trimming set

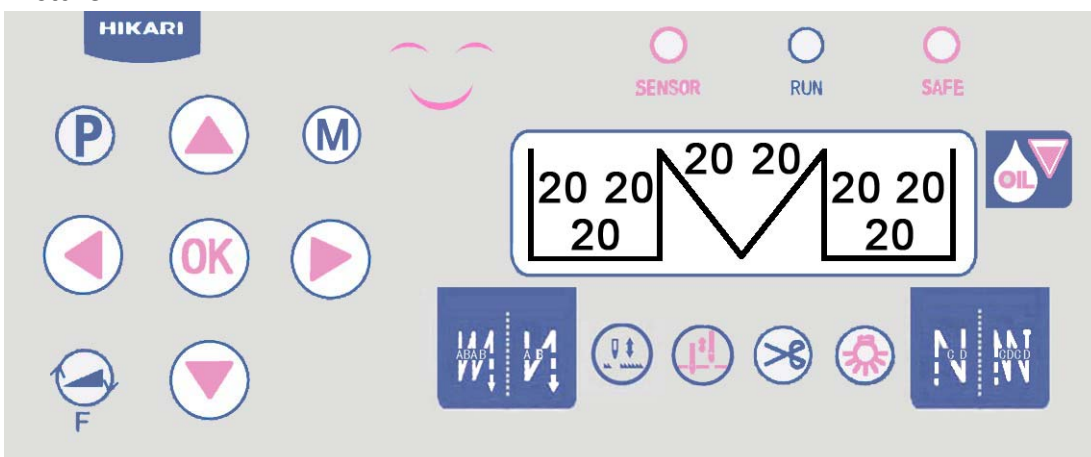
Press the  once, the  will be lighted up, It means the trimming function is startup, then pressing it again, the function will be off, and  will disappear.

## 6.6 User parameter set

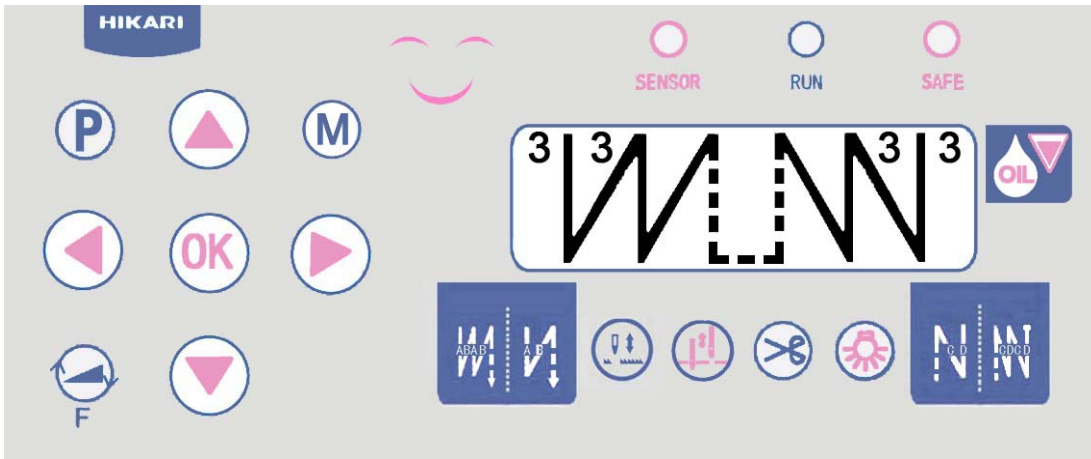
Without the non- Free sewing, press once , it will enter the user parameter adjustment mode (picture 2), Through pressing the ,  to modify parameter number, through pressing the ,  will switch editing area, Press  saving confirm and exit the user parameter adjustment mode.

If there are fixed-parameters, not all parameters can be shown at the same time except free sewing and W sewing, meanwhile, if you want to check other parameter, press the  to switch display window. Then you can see fixed sewing parameters or sewing stitches. for example Picture 1 and Picture 12.




Picture 1




Picture 2



## 6.7 Adjusting the speed

At the non-adjustment parameter mode, press twice , it will enter the speed adjustment mode. Through pressing the ,  to modify speed.

## 6.8 Needle stop position set

At the non-adjustment parameter mode, press once , Selection of needle up position or needle down position when stopping the needle., the symbol at the corresponding region will be lighted up

## 6.9 LED brightness adjust

Press  button will adjusting LED brightness, Circulate selection 5 mode.

## 7. Stitch tracking compensation adjustment

### 7.1 Preparation before adjustment

1. Check the default distance of machine head needle.
2. Take the manual reverse sewing mode, sewing eight stitches and check the overlap effect of stitch tracking. If it is fine, carry on to adjust.

### 7.2 Adjustment step

1. Set the sewing mode to be fixed mode after power on, shut the fore-tacking sewing, set backward single-reinforcement sewing, set the parameter of C to be 4 stitch and fixed stitch to be 4 stitches, startup the auto-trigger. Step the pedal forward and check if the stitch tracking is overlap. If overlaps, it indicates that the parameter is suitable.



Otherwise it will cause two situations, and then adjust the parameter according to the situations.

First situation: C section is shorter than normal, as is shown in Figure 1-1

Second situation: C section is longer than normal, as is shown in Figure 1-2

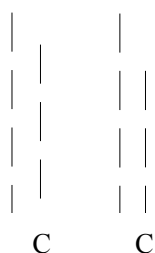


Fig 1-1

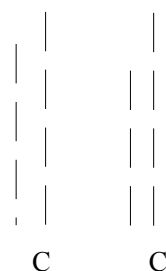


Fig 1-2

For the first situation, we can achieve fully overlap through increasing the value of the technical parameter P42 .

For the second situation, we can achieve fully overlap through decreasing the value of the technical parameter P42.

2. Change the back-tacking sewing mode to double back-tacking sewing mode, set the parameter of D to be 4 stitches. Step the pedal forward and check if the stitch tracking is overlap. If overlaps, it indicates that the parameter is suitable. Otherwise it will cause two situations, and then adjust the parameter according to the situations.

First situation(less needle): the last section of D is shorter than normal, as is shown in Figure 1-3

Second situation(multi-stitch): the last section of D is longer than normal, as is shown in Figure 1-4

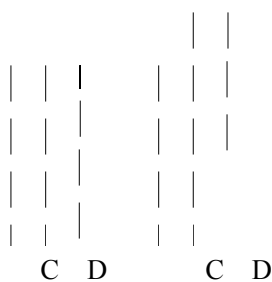


Fig 1-3

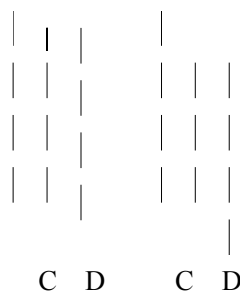


Fig 1-4

For the first situation, we can achieve fully overlap through increasing the value of the technical parameter P43.

For the second situation, it can achieve fully overlap through decreasing the value of the technical parameter P42.

The adjusting way for the forward and backward reinforcement sewing is equal to the way of W sewing. The parameter of P42 can be copy to the P40,P44. and the parameter of P43 can be copy to the P41,P45.

## 8. Description table of operating panel parameter

Sequence	Function parameter	Default	Setting range	Unit	Parameter description
P0	pedal slope	50	1~100	%	The bigger the slope is, the larger the low-speed region is, and the faster the speed change is; the smaller the slope is, the narrower the low-speed region is, and the lower the speed change .
P1	Speed proportion	8	1~8		Presser proportion of the maximum speed of reverse sewing. The maximum seed is equally divided into eight parts, current speed can be modified through adjusting parts.
P2	System minimum speed	200	150~500	RPM	The minimum speed of motor when sewing.
P3	Maximum speed of the free sewing	3600	150~5000	RPM	The maximum speed of motor at the free sewing.
P4	Fixed sewing speed	3000	150~4000	RPM	Auto-trigger speed of fixed sewing.
P5	Fore-tacking sewing speed	1600	200~3000	RPM	Sewing speed of fore-tacking during operation.
P6	Back-tacking sewing speed	1600	200~3000	RPM	Sewing speed of fore-tacking during operation.
P7	Suspend when the fore-tacking finished.	off	On/off		Pedal trigger is needed to continue operating when suspend at fore-tacking finishing.
P8	Suspend when the back-tacking finished.	off	On/off		Pedal trigger is needed to continue operating when suspend at back-tacking finishing.
P9	W sewing speed	1600	200~3000	RPM	Sewing speed at W sewing mode.
P15	Maximum speed of reverse sewing	2500	200~3000	RPM	Maximum speed of reverse sewing.
P16	Working time of thread sweep	50	20~1000	ms	Working time of thread sweep electromagnet.

P17	Whether the reverse sewing key will be absorbed when the motor stops.	on	On/off		When the motor stops, and the key pressed, whether the electromagnet acts or not.
P18	Stitch/speed priority	0	0~1		Stitch or speed priority setting during sewing: 0:stitch priority 1:speed priority
P19*	Foot presser switch	On	On/off		Turn on/off the function of foot presser.
P21	Selection of counting function	0	0~2		0:Non-counting function 1:Bobbin thread counting function 2:Trimming thread counting function
P22	Slow-startup counting	2	0~15		Stitches when sewing at slow-startup speed
P23	Slow-startup speed	500	200~3000	RPM	The sewing speed at slow-startup.
P24	Lower thread base number	10	1~100		How many stitches changes on lower thread, the current count change one unit.
P25	Total number of Lower thread	2000	1~9999		Total number of lower-thread setting.
P26	Current counting	2000	0~9999		Current amount of lower thread.
P27	Full PWM on time of reverse	200	20~500	ms	Initial startup time of reverse sewing electromagnet.
P28	PWM on time of reverse sewing	2	1~50	ms	PWM on time of reverse sewing when the electromagnet holding on.
P29	PWM off time of reverse sewing	2	1~50	ms	PWM off time of reverse sewing when the electromagnet holding on.
P31	The thread tension switch	1	0/1		Set the electric thread tension. 0: turn off 1: turn on
P34*	Automatic finding needle position	On	On/off		Whether automatic finding the needle up position at PWM on time
P36	trimming speed	250	200~500	RPM	Operating speed when trimming.

P37*	Automatic lift foot presser of half back step	on	On/off		Start or cancel automatic lift foot presser of half back step.
P40	Fore-tacking sewing compensation parameter 1	7	0-16		Fore-tacking stitch sewing compensation parameter 1.
P41	Fore-tacking sewing compensation parameter 2	5	0-16		Fore-tacking sewing stitch compensation parameter 2
P42	Back-tacking sewing compensation parameter 1	7	0-16		Back-tacking sewing stitch compensation parameter 1
P43	Back-tacking sewing compensation parameter 2	5	0-16		Back-tacking sewing stitch compensation parameter 2.
P44	W sewing compensation parameter 1	7	0-16		W sewing stitch compensation parameter 1
P45	W sewing compensation parameter 2	5	0-16		W sewing stitch compensation parameter 2
P46	Manual test mode switch	0	0/1		0: normal operation mode 1: test mode
P47	senescent pause time	2000	100-9999	ms	The interval between each operation
P48	Operating time of test mode	2000	100—9999	ms	Each operating time of the test mode.(valid at no localizer)
P54	safety switch signal type	0	0/1		0: open 1: shut
P55		1	0/1		
P57	Startup time of lifting foot presser	250	20~1000	ms	Initial startup time of lifting foot presser electromagnet.
P58	PWM on time of lifting foot presser	2	1~50	ms	PWM on time of lifting foot presser when the electromagnet holding on
P59	PWM off time of lifting foot presser	3	1~50	ms	PWM off time of lifting foot presser when the electromagnet holding on.

P60	Protection time of foot presser lifting	20	1~120	s	Protecting time of foot presser lifting during working
P61	Delay time of lifting foot presser	50	20~800	ms	How long will it be to start to lift foot presser after the motor stops.
P62	Delay time of downing foot presser	50	20~800	ms	How long is it allowed to startup after foot presser is down.
P64*	Automatic lifting foot presser time after power on	0	0-900	s	Time of automatic lifting foot presser after power on.
P65	Function selection of cloth edge sensor	0	0—1		0: no cloth edge sensor 1: cloth edge sensor
P67	Speed of cloth edge	800	200-5000	RPM	Operating speed when detecting cloth edge signal.
P69	Delay-startup time of cloth margin	1000	100-9999	ms	Delay-startup time when detecting cloth head signal.
P73	Cloth edge sensor	off	On/off		Whether there is an external cloth edge sensor.
P74	Selection of back stitch/ foot presser lifting pneumatic	0	0—3		0: all electromotion 1: backstitch pneumatic 2: presser foot pneumatic 3: all pneumatic
P76	Number of trimming	0	0-9999		Adding 1 to the counter after trim, clear the counter to zero when it reaches max.
P98	Parameter recover to default	0000h	0-9999		
P99	Technical parameter password	2222h	0-9999		

Note: 1 common parameter description: (RPM: round per minute; MS: millisecond ; S :second; H :hour)

2 The parameters marked with \*means that they should re-power after amended.

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此说明书仅作参考, 如有更改恕不另作通知。

This manual is only for reference.

IF there is any modification , we apologize for the changing hence caused.