

# 全自动充绒机说明书

Manual book of Automatic Down Filling Machine

# 目 录





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本章主要介绍全自动充绒机系统的页面以及功能的使用说明，以六循环充绒机系统为模板介绍。

This chapter mainly introduces full automatic down filling machine system and its functions, using the six-circle down filling machine as a template.

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一. 设备装置 Equipment

 A red emergency stop switch with a yellow handle. Above the switch is a label with Chinese characters '总电源开关' and English text 'Main power switch'. The switch handle is currently in the 'OFF' position.	<p>总电源开关： 当前图片所示为 OFF 关闭状态，设备启动电源断开。 向右旋转切换至 ON 开启状态，设备通电但不启动。</p> <p>Main power switch: The picture shows OFF state, the device is disconnected with power. Rotate the switch to right which is ON state, the device is powered, but does not start to work.</p>
 A red emergency stop button with a yellow circular base. The word 'EMERGENCY' is printed in black on the yellow base. The button has a circular arrow symbol on its top surface.	<p>急停按钮： 此按钮只需直接向下压下。就可以快速的让整台设备立马停止，要想再次启动设备必须释放此按钮，也就是只需顺时针方向旋转大约 45°后松开，按钮会弹起</p> <p>Emergency: Simply to press this button down, you can quickly stop the machine immediately. If you want to start the device again, you have to release the button, that is, turn it clockwise about 45° and then release it, the button will pop up.</p>
 A red circular indicator light with a black border. Above the light is a label with Chinese characters '电源指示灯'.	<p>电源指示灯： 指示灯亮代表设备电源线通电，设备为通电状态。</p> <p>Power indicator: When the indicator light is on, it means that the device is powered on.</p>
 A yellow circular button with a silver border. Above the button is a label with Chinese characters '加 绒'.	<p>加绒按钮： 按下后启动加绒风机，再次按下或超过设定的加绒时间会停止加绒。</p> <p>Input down button: Press it to start the down input fan, press it again or over the supposed input time, it will stop.</p>



启动按钮：  
按下后设备电机启动，进入运转。

Start button:  
Press it to start device motor.



湿度控制器：  
加湿器的控制器，湿度 $\leq 55$  启动加湿，  
湿度 $\geq 60$  停止加湿。

Humidity controller:  
Humidifier controller, when  
humidity $\leq 55$  it will start, when  
humidity $\geq 60$  it will be off.



电机调速器：  
可调节搅拌电机的转速，开关RUN时开  
启电机，STOP时停止电机。

Motor governor:  
To adjust the speed of stirring motor.  
The motor is turned on when the switch  
is RUN.  
The motor is stopped when the switch is  
STOP.

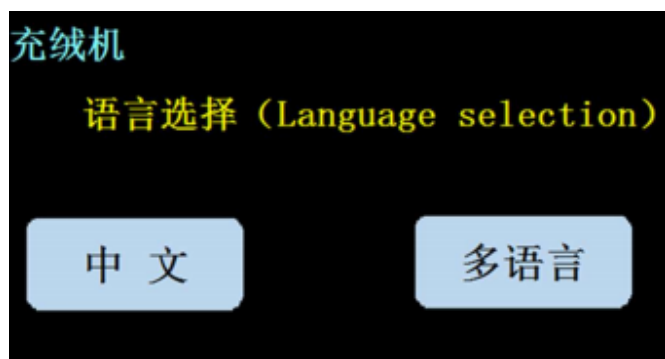


光电开关：  
用来检测下绒箱绒面高度，光线对照到  
反光板落绒门打开，绒面高于光线时落  
绒门关闭

Photoelectric switch:  
To detect the height of down in the down  
box.  
When the light shines on the reflector,  
the door opens.  
When the down surface line is higher  
than the light, the door closes.

## 二. 工作画面 Working screen

### 语言选择 Language selection

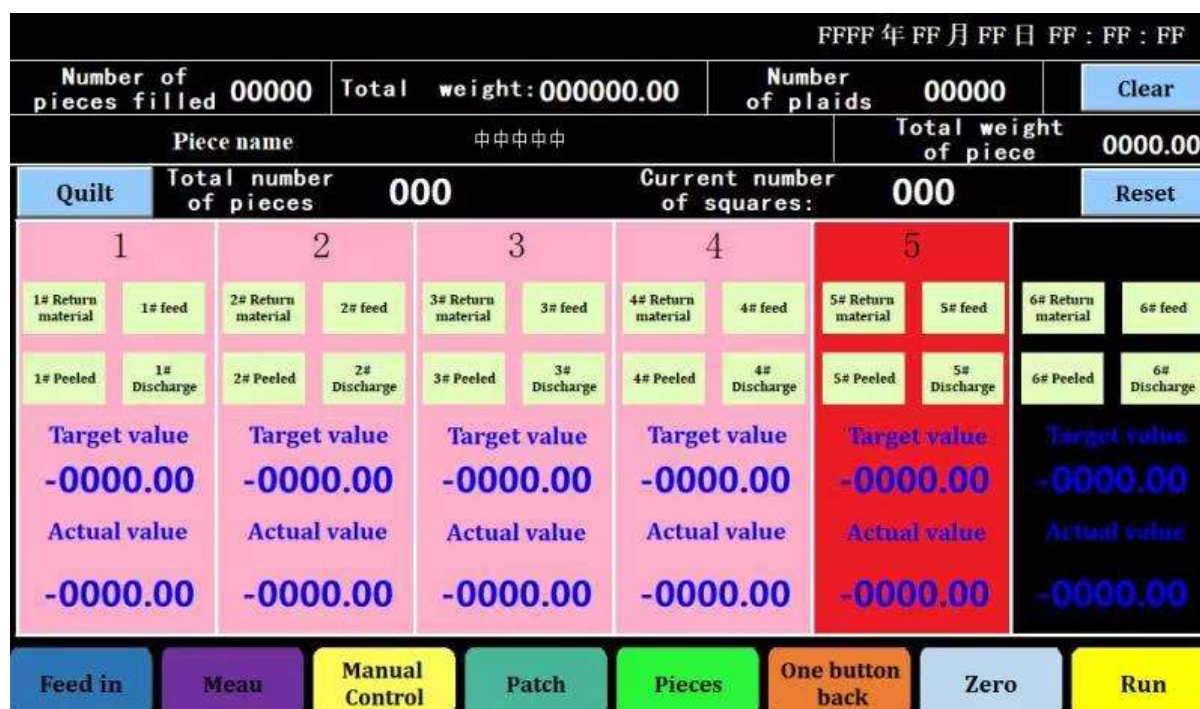


设备通电进入语言选择界面

Power on the device to enter the language selection interface

- 语言选择：可选多种语言并进入工作界面
- Language selection: Multiple languages are available and enter the working interface
- 产品型号：设备的型号
- Item number: the machine model number
- 版本：设备当前软件版本号
- Version: current software version
- 售后：售后技术的联系方式
- After-sale service: technical contact number

## 操作界面 Operation interface

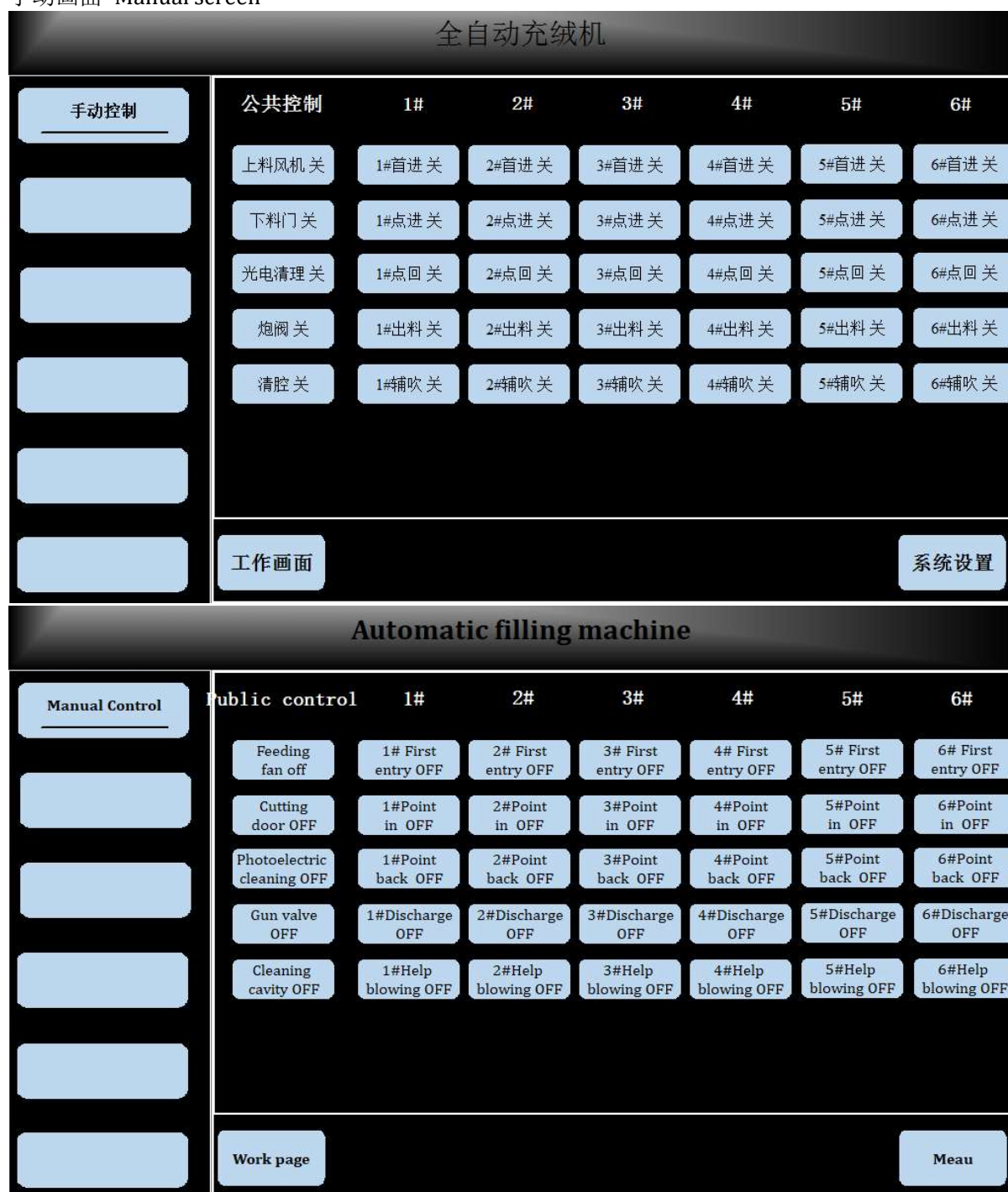


- 售后热线：售后技术联系方式。
- After-sale service: after-sale technical contact
- 已充裁片数：当前已经累计工作裁片总数量。
- Number of pieces filled: the pieces number that has been filled currently
- 已充总重量：当前已经累计充绒总重量。
- Total weight: the weight has been filled currently
- 已充格子数：当前已经累计充绒格子总数。

- **Number of grids: the grids number that has been filled currently**
- 清零：系统未运行状态下，长按 3 秒将已充裁片数、已充总重量、已充格子数清零。
- **Clear: when the system is not running, press and hold for 3 seconds to reset the number of pieces, total weight and number of grids to zero.**
- 款式名称：系统当前读取运行的配方的款式名称。
- **Piece name: The name of running formula currently read by the system.**
- 裁片总重量：系统当前读取运行配方的总重量。
- **Total weight of piece: the total weight of the formula currently read by the system**
- 裁片总格数：系统当前读取运行配方的实际运行所包含的总格数。
- **Total number of piece: the total grids number of running formula currently read by the system**
- 当前格数：当前裁片已运行到的格数编号。
- **Current number of squares: the number of grid that currently running to.**
- 复位：系统未运行状态下，长按 3 秒裁片格子数复位，从第一格开始重新运行。
- **Reset: when the system is not running, press and hold for 3 seconds to reset, and it will restart from the first grid**
- 粉色背景灯：当前工作秤已进料完成变为粉色，待充状态。
- **Pink background light: current working scale has finished feeding and turns to pink, it is ready to be charged.**
- 红色背景灯：当前工作秤出料有剩余，背景灯变为红色报警。
- **Red background light: current working scale has lint left, the background light turns to red alarm.**
- 黑色背景：当前工作秤处于进料未完成状态，或已把此秤关闭。
- **Black background light: current working scale is in the unfinished feeding state, or the scale has been turned off.**
- 回绒：手动回绒按键。
- **Return material: manually returning down button**
- 进绒：手动进绒按键。
- **Feed: manually feeding down button**
- 去皮：手动去皮按键。
- **Peels: manually peeled button**
- 出绒；手动出绒按键。
- **Discharge: manually discharge button**
- 目标值：显示当前秤运行的配方重量。
- **Target value: display the running formula weight of current scale**
- 实际值：显示当前秤进料完成后实际的重量。
- **Actual value: display the actual weight of current scale after the feeding is completed**
- 加绒：按下后启动加绒风机，再次按下或超过设定的加绒时间会停止加绒。
- **Feed in: press it to start the feeding fan, press again or reach the set feeding time will stop feeding**
- 一键回绒：在系统停止状态按下后秤体按照顺序逐个回绒。
- **One button back: After the system is stopped, the scale will be return down one by one in order**
- 一键去皮：在系统停止状态按下后对秤体去皮归零。
- **Zero: tare the scale and reset to zero after pressing down under the stop state**
- 系统运行：系统运行的启动与停止按键。
- **Run: start or stop button for system operation**

### 三. 手动画面 Manual screen

#### 手动画面 Manual screen



主要测试检查各个工作点位的状态，点击按键后对应的功能开启，如不开启说明点位或元件出现故障需要检修。

Mainly to test the status of each working point. If it fails to start after clicking the corresponding button, that means the point or element is faulty and needs to be repaired.



#### 四. 补绒设置 Down replenishment setting

## 补绒选择

裁片共： 000 格；目前已运行到： 000 格。

1: 对应格数补绒

2: 固定克重补绒

000

000.00

返回

## Patch switch

Total pieces: 000 Grid; currently running to: 000 grid

1: Corresponding to  
the number of velvet

2: fixed weight of velvet

000

000.00

Return

当系统出现爆片、漏充时，可以使用补绒功能进行补绒。补绒功能分为两种：对应格数补绒、固定克重补绒两种方式。对应格数补绒为根据裁片的格数补绒，需要补第几格直接在输入框中输入格子数即可；固定克重补绒为根据输入的克重进行补绒。需要补绒时直接点击补绒设置就会出现上图所示画面，窗口自动关闭，选择完成之后系统自动上绒，等待充绒即可。

When the system appears filling burst or filling miss, you can use the down replenishment function. There are 2 ways for down replenishment: corresponding to the number of grids and fixed weight of down

Corresponding to the number of grids: enter the grid number you want to fill

Fixed weight of down: replenish the down according to the fixed weight you entered on screen

After setting the system will add the down automatically, no extra operation for users

## 五. 裁片设置 cut piece setting

### 裁片设置 cut piece setting

# 多格配方

款式名称: 
+

-

数据导入
数据导出

编号	克	编号	克	编号	克	编号	克
1	000.00	6	000.00	11	000.00	16	000.00
2	000.00	7	000.00	12	000.00	17	000.00
3	000.00	8	000.00	13	000.00	18	000.00
4	000.00	9	000.00	14	000.00	19	000.00
5	000.00	10	000.00	15	000.00	20	000.00

格数合计: 
总克量: 
返回
下一页

功能域 功能域 功能域

## Multitablet formulation

Multi-grid mode

Name: 
+

-

Import
Derived

NO.	g	NO.	g	NO.	g	NO.	g
1	000.00	6	000.00	11	000.00	16	000.00
2	000.00	7	000.00	12	000.00	17	000.00
3	000.00	8	000.00	13	000.00	18	000.00
4	000.00	9	000.00	14	000.00	19	000.00
5	000.00	10	000.00	15	000.00	20	000.00

Lattice number: 
Total weight: 
Back
Next

- 款式名称 : 当前配方的款式名称, 点击可编辑修改。
- Name: name of current formula, click to edit
- 加减号 : 中间显示为当前配方的编号, 加减可切换其他编号。
- +/-: the middle shows number of current formula, click to switch to other numbers

- 编号 : 当前格数的编号, 输入时按照充绒顺序输入, 输入一格系统会自动判定为单格模式, 输入多格为多格模式。
- No.: the number of current grid, entering according to the filling order. System will automatically determine it as single-grid mode when you enter only one grid, and multi-grid when you enter more than one grid.
- 克 : 当前格数的充绒克重。
- g: the filling weight of current grid
- 格数合计 : 显示运行的总格数。
- Lattice number: showing the total grids of running currently
- 总克量 : 显示运行配方的总克重。
- Total weight: showing the total weight of current formula
- 下一页 : 切换至当前配方的下一页, 每页配方最多可输入 100 格数据。
- Next: Switch to next page of current formula, each page can enter up to 100 grids

### 多格配方文件表

下一页
进入

编号	名称	编号	名称	编号	名称	编号	名称
0	中中中中中	5	中中中中中	10	中中中中中	15	中中中中中
1	中中中中中	6	中中中中中	11	中中中中中	16	中中中中中
2	中中中中中	7	中中中中中	12	中中中中中	17	中中中中中
3	中中中中中	8	中中中中中	13	中中中中中	18	中中中中中
4	中中中中中	9	中中中中中	14	中中中中中	19	中中中中中

当前配方编号:

---

### Multitablet formulation

Next
Sure

NO.	Name	NO.	Name	NO.	Name	NO.	Name
0	中中中中中	5	中中中中中	10	中中中中中	15	中中中中中
1	中中中中中	6	中中中中中	11	中中中中中	16	中中中中中
2	中中中中中	7	中中中中中	12	中中中中中	17	中中中中中
3	中中中中中	8	中中中中中	13	中中中中中	18	中中中中中
4	中中中中中	9	中中中中中	14	中中中中中	19	中中中中中

NO. :

文件浏览主要用于在配方较多时快速方便的找到所需的配方，找到款式名称后点击对应的编号，下方的当前配方编号会显示选中的编号，选中后点击进入即可进入所需配方页面。

Multitablet formulation is mainly used to find the required formula quickly and conveniently when there are many formulas.

After finding the name you want, click the corresponding number, current formula number below will show the selected number, click it to enter the required formula page.

## 1. 数据导入、数据导出 Data input/output

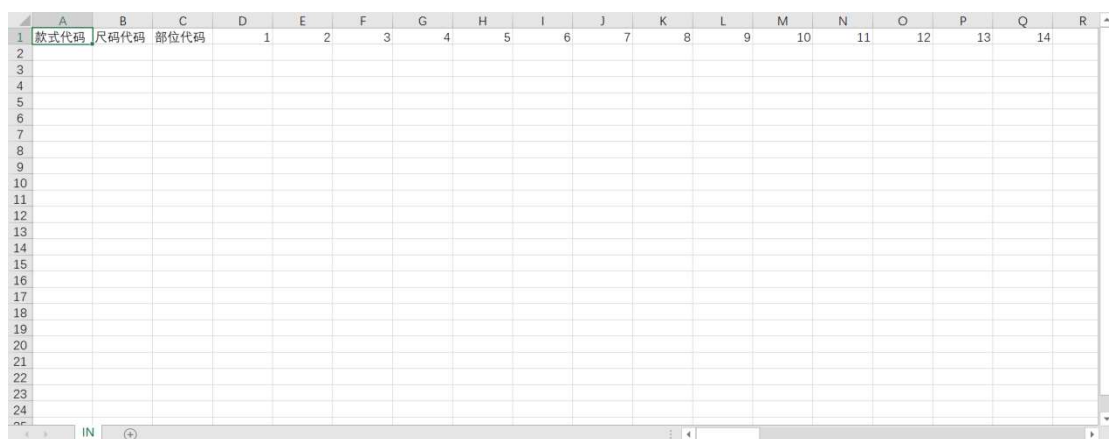
导入部分需要使用导入文件，名称为 IN.csv，这个名称、格式不可随意更改，直接修改内容使用即可，U 盘要求 16G 以下，数据格式 FAT32。

The input part needs to use input file, its name is IN.csv. the name and format can not be changed at will, you can just modify the content to use it.

The U disk requires 16G or less, the format is FAT32

### 1: 使用电脑打开 IN.csv 文件，制作表格，IN 文件如下图所示：

1. use your computer to open the IN.csv file, then make the table. The IN file is as shown below



	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q	R
1	款式代码	尺码代码	部位代码	1	2	3	4	5	6	7	8	9	10	11	12	13	14	14
2																		
3																		
4																		
5																		
6																		
7																		
8																		
9																		
10																		
11																		
12																		
13																		
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15																		
16																		
17																		
18																		
19																		
20																		
21																		
22																		
23																		
24																		
25																		

图片中包括：款式代码、尺码代码、部位代码以及数字 1、2、3 等；款式代码、尺码代码、部位代码对应裁片设置里的对应的代码，数字对应格数。

Above picture includes: style code, size code, part code and number 1,2,3, etc.

The style code, size code and part code correspond to the codes in the cut piece setting. The number 1,2,3...correspond to the number of grids.

表格制作方法：找到需要导入的数据对应的代码，将数据横向填入，点击保存即可。

例如：需要将一个裁片数据 1.4, 2.4, 3.5, 5.6, 1.8, 3.6, 6.7 导入到款式代码 2，尺码代码 3，部位代码 5 的数据里，做出来的效果如下：

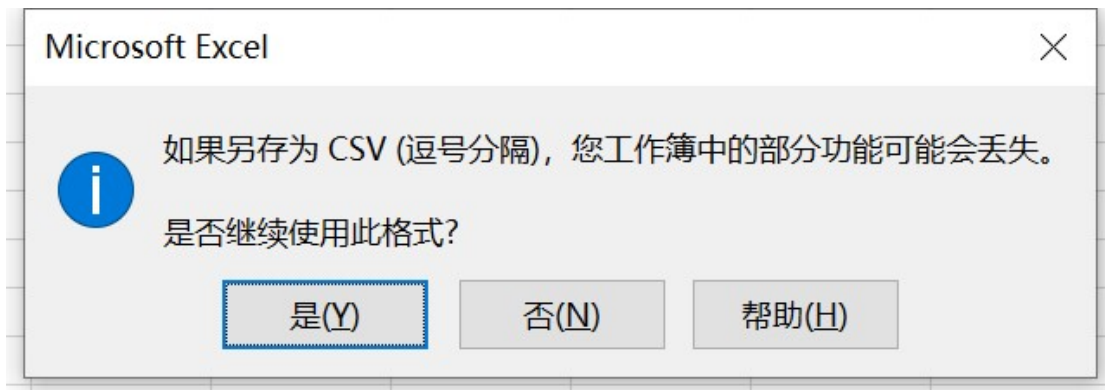
Table making method: find the code which you need to input, fill in the data horizontally, then click save.

For example: a piece data as 1.4, 2.4, 3.5, 5.6, 1.8, 3.6, 6.7, input them to style code 2, size code 3, part code 5, below is the finished table:

	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q	R
1	款式代码	尺码代码	部位代码	1	2	3	4	5	6	7								
2	2	3	5	1.4	2.4	3.5	5.6	1.8	3.6	6.7								
3																		
4																		
5																		
6																		
7																		
8																		
9																		
10																		
11																		
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17																		
18																		
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20																		
21																		
22																		
23																		
24																		
25																		

做完点击保存，弹出窗口，选择是；文件制作完成。

Click SAVE when finishing, a window pops up, click YES, the file is complete.



文件制作完成后，将 U 盘插入显示器后方的 USB 口，点击数据导入然后进入文件浏览查看是否成功导入配方即可。

After finishing the file, insert the U disk into USD port on the back of monitor, click data import and then enter the file browse to check whether the formula is successfully imported.

## 六 . 系统设置 System setting

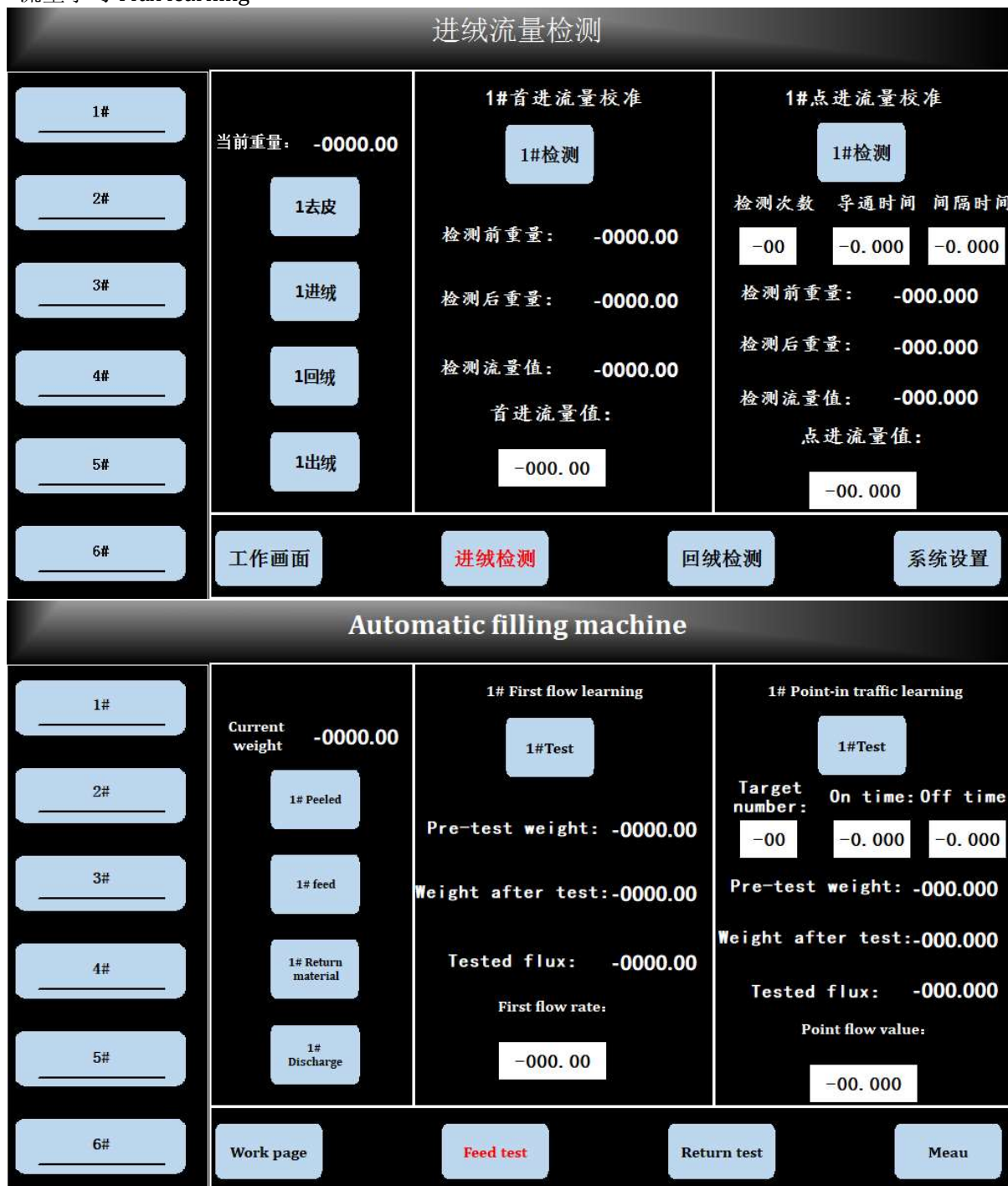
### 系统设置 System setting



- 流量学习 : 检测进绒与回绒流量。
- Flux learning: detect the flow of down input and output
- 出料参数 : 设置出入时间, 辅吹设定等参数。
- Discharge parameter: set access time, auxiliary blowing setting and other parameters
- 进料参数 : 设置进绒速度等参数。
- Feed parameter: set the speed of feeding

- 称重标定 : 用来校准传感器的称重量。
- Weighing calibration: to calibrate the weighing sensor
  
- 分段流量 : 可手动调节流量 (系统会自动调节不需要手动修改, 作为监视用即可)
- Segment flux: the flux can be adjusted manually (system will automatically adjust, manual modification can be used for monitoring)
  
- 公共参数 : 可调节设备装置参数。
- Common parameter: parameters used to adjust the equipment
  
- 厂家参数 : 修改一些高级参数与切换模式, 正常不开放。
- Manufacturer parameter: modify some advanced parameters and switch modes, normally not open for users.
  
- 用户登录 : 进入厂家参数的唯一方法, 需要厂家提供密码。
- User login and logout: the only way to enter manufacturer parameter, requires the manufacturer to provide a password.





- 当前重量：当前实时重量。
- Current weight: the real current weight
- 去皮：触摸屏当前重量归零。
- Peeled: reset the current weight on the screen
- 进绒：将羽绒从绒箱吹进称重箱。
- Feed: blow down from down box into weighting box
- 回绒：将羽绒从称重箱回排到绒箱。
- Return material: return down from weighing box to down box
- 出绒：将羽绒从称重箱充出到裁片中。
- Discharge: fill the down from weighing box to the cut pieces.

首进流量校准:

**First flow learning:**

- 测试: 点击之后开始测试, 得到测试流量值。
- **Test: click to start test and get the test flow value**
- 测试前重量记录: 点击测试前称重箱中的实时重量记录。
- **Pre-test weight: weight record in weighing box before test**
- 测试后重量记录: 测试完成后称重箱中的实时重量记录。
- **Weight after test: weight record in weighing box after test**
- 测试所得流量值: 测试完成后称重箱中的实时重量记录。
- **Test flux: flow record in weighing box after test**
- 系统首进流量值: 系统内部运行的首进流量值。
- **First flow rate: first flow value of internal operation of the system**

点进流量校准:

**Point-in traffic learning:**

- 测试: 点击之后开始测试, 依据设定的数据得出测试流量值。
- **Test: click to start test and get the test flow value**
- 目标测试次数 : 测试时依照设定的导通时间、间隔时间, 执行对应的目标测试次数。
- **Target number: execute the target test times according to the requested ON time and OFF time.**
- 导通时间: 测试时依照设定的导通时间、间隔时间, 执行对应的目标测试次数。
- **On time: execute the target test times according to the requested ON time and OFF time.**
- 间隔时间: 测试时依照设定的导通时间、间隔时间, 执行对应的目标测试次数。
- **Off time: execute the target test times according to the requested ON time and OFF time.**
- 测试前重量记录: 点击测试前称重箱中的实时重量记录。
- **Pre-test weight: weight record in weighing box before test**
- 测试后重量记录: 测试完成后称重箱中的实时重量记录。
- **Weight after test: weight record in weighing box after test**
- 测试所得流量值: 测试完成后称重箱中的实时重量记录。
- **Test flux: flow record in weighing box after test**
- 系统点进流量值: 系统内部运行的点进流量值。
- **Point flow value: point-in flow value of internal operation of the system.**

注: 系统点进流量值需要在测试后自动生成, 流量值大小一般依据实际情况变化, 主要影响因素包括气压、设置的导通时间与间隔时间, 一般建议小点气压在 1-1.5, 依据电磁阀特性一般导通时间在 20-30ms 之间。

Note: the point-in flow value needs to be automatically generated after test, the flow value generally varies according to actual situation, the main influencing factors include air pressure, set on time and off time. Generally small point air pressure is between 1 to 1.5, and general on time is between 20 to 30ms according to the characteristics of the solenoid valve.

出料参数 Discharge parameters

出料参数							
出绒时间	通道	1#	2#	3#	4#	5#	6#
	间隔						
0-0.5g		00.0	00.0	00.0	00.0	00.0	00.0
辅吹设置	0.5-0.7g	00.0	00.0	00.0	00.0	00.0	00.0
0.7-1g		00.0	00.0	00.0	00.0	00.0	00.0
出绒流量	1-1.5g	00.0	00.0	00.0	00.0	00.0	00.0
充被模式 关	1.5-2g	00.0	00.0	00.0	00.0	00.0	00.0
	2-3g	00.0	00.0	00.0	00.0	00.0	00.0
	3-4g	00.0	00.0	00.0	00.0	00.0	00.0
		工作画面	首页	上一页	下一页	尾页	系统目录

Automatic filling machine							
Discharge time	Aisle	1#	2#	3#	4#	5#	6#
	Interval						
0-0.5g		00.0	00.0	00.0	00.0	00.0	00.0
Help blow setting	0.5-0.7g	00.0	00.0	00.0	00.0	00.0	00.0
0.7-1g		00.0	00.0	00.0	00.0	00.0	00.0
Discharge flow	1-1.5g	00.0	00.0	00.0	00.0	00.0	00.0
Quilt	1.5-2g	00.0	00.0	00.0	00.0	00.0	00.0
	2-3g	00.0	00.0	00.0	00.0	00.0	00.0
	3-4g	00.0	00.0	00.0	00.0	00.0	00.0
		Work page	Home	Previous page	Next page	Last page	Meau

- 根据不同的克重来设定各个秤体的出绒时间。
- Set the flocking time of each scale according to different weights
- 充被模式：充被模式连出的开关按键。
- Quilt: the switch button of filling the quilt
- 辅吹设置：辅吹的参数设置
- Help blowing setting: parameters setting of auxiliary blowing
- 出绒流量：通过流量来自动调节出绒时间（不推荐使用）
- Discharge flow: automatically adjust the flocking time by flow rate (not recommended)

出料参数								
出绒时间	通道		1#	2#	3#	4#	5#	6#
	间隔							
辅吹设置	1-1.5g	辅吹次数	000	000	000	000	000	000
		导通时间	0.000	0.000	0.000	0.000	0.000	0.000
		间隔时间	0.000	0.000	0.000	0.000	0.000	0.000
出绒流量	1.5-2g	辅吹次数	000	000	000	000	000	000
		导通时间	0.000	0.000	0.000	0.000	0.000	0.000
		间隔时间	0.000	0.000	0.000	0.000	0.000	0.000
辅吹 关	2-3g	辅吹次数	000	000	000	000	000	000
		导通时间	0.000	0.000	0.000	0.000	0.000	0.000
		间隔时间	0.000	0.000	0.000	0.000	0.000	0.000
起始重量 00.00								
启动延时 0.000								
		工作画面	首页	上一页	下一页	尾页	系统目录	

Automatic filling machine								
Discharge time	Aisle		1#	2#	3#	4#	5#	6#
	interval							
Help blow setting	0-0.5g	Number	000	000	000	000	000	000
		On time	0.000	0.000	0.000	0.000	0.000	0.000
		Off time	0.000	0.000	0.000	0.000	0.000	0.000
Discharge flow	0.5-0.7g	Number	000	000	000	000	000	000
		On time	0.000	0.000	0.000	0.000	0.000	0.000
		Off time	0.000	0.000	0.000	0.000	0.000	0.000
Blow	0.7-1g	Number	000	000	000	000	000	000
		On time	0.000	0.000	0.000	0.000	0.000	0.000
		Off time	0.000	0.000	0.000	0.000	0.000	0.000
Starting weight 00.00								
Start delay 0.000								
Discharge delay 0.000								
		Work page	Home	Previous page	Next page	Last page	Meau	

- 起始重量：辅吹起始克重，当工作克重大于起始克重时，辅吹才会起作用。
- Starting weight: the starting weight of auxiliary blowing, when the working weight is heavier than starting weight, auxiliary blowing will work.
- 启动延时：开始出绒后，根据设置的延时之后辅吹才开始工作。
- Start delay: the auxiliary blow will work only after the start delay time.
- 辅吹次数：辅吹过程中总计辅吹次数。
- Number: the total number if auxiliary blowing in the auxiliary blowing process
- 导通时间：辅吹过程中辅吹工作时间。
- On time: working time during the auxiliary blowing
- 间隔时间：辅吹过程中辅吹间隔时间。
- Off time: interval time during the auxiliary blowing

首进 First flow

### 进料参数

	通道	1#	2#	3#	4#	5#	6#
控制参数	内容						
	首进流量 (克/秒)	00.00	00.00	00.00	00.00	00.00	00.00
首进率	首进稳定时间 (秒)	0.000	0.000	0.000	0.000	0.000	0.000
精度上下限	克重补偿 (克)	-00.00	-00.00	-00.00	-00.00	-00.00	-00.00
		工作画面	首进	点进	点回	去皮	系统目录

### Automatic filling machine

	Aisle content	1#	2#	3#	4#	5#	6#
Control parameters	内容						
	First flow (g/s)	00.00	00.00	00.00	00.00	00.00	00.00
First rate	First settling time(s)	0.000	0.000	0.000	0.000	0.000	0.000
Upper and lower precision	Weight compensation(g)	-00.00	-00.00	-00.00	-00.00	-00.00	-00.00
		Work page	First entry	Point in	Point back	Peeled	Meau

- 首进流量值： 第一阶段首进流量值。
- First flow: the first flow value at first stage
- 首进稳定时间： 第一阶段首进进料完成之后稳定时间。
- First settling time: Stabilization time after first feeding is completed at first stage
- 克重补偿： 在实际值的基础上多进或少进克重，但不显示。
- Weight compensation: Increase or decrease the weight based on actual value, but do not display

点进 point-in

进料参数							
控制参数	通道	1#	2#	3#	4#	5#	6#
	首进率	内容					
精度上下限	点进流量(克/次)	0.000	0.000	0.000	0.000	0.000	0.000
	点进启动重量(克)	00.00	00.00	00.00	00.00	00.00	00.00
	点进导通时间(秒)	0.000	0.000	0.000	0.000	0.000	0.000
	点进间隔时间(秒)	0.000	0.000	0.000	0.000	0.000	0.000
	点进稳定时间(秒)	0.000	0.000	0.000	0.000	0.000	0.000
	点回稳定时间(秒)	0.000	0.000	0.000	0.000	0.000	0.000
<div style="display: flex; justify-content: space-between; align-items: center;"> <span>工作画面</span> <span>首进</span> <span style="color: red;">点进</span> <span>点回</span> <span>去皮</span> <span>系统目录</span> </div>							

Automatic filling machine							
Control parameters	Aisle	1#	2#	3#	4#	5#	6#
	First rate	Content					
Upper and lower precision	Point-in traffic(g/n)	0.000	0.000	0.000	0.000	0.000	0.000
	Starting point weight(g)	00.00	00.00	00.00	00.00	00.00	00.00
	On time(s)	0.000	0.000	0.000	0.000	0.000	0.000
	Off time(s)	0.000	0.000	0.000	0.000	0.000	0.000
	Stable schedule(s)	0.000	0.000	0.000	0.000	0.000	0.000
	Point back stabilization time[s]	0.000	0.000	0.000	0.000	0.000	0.000
<div style="display: flex; justify-content: space-between; align-items: center;"> <span>Work page</span> <span>First entry</span> <span style="color: red;">Point in</span> <span>Point back</span> <span>Peeled</span> <span>Meau</span> </div>							

- 点进流量：系统点进流量值监测。
- Point-in traffic: Point -in flow value monitoring
- 点进启动重量：点进开始重量，例如设置为 0.5 克，目标克重为 5 克时，当实时重量达到 4.5 克时，点进启动，开始进行点进动作。
- Starting point weight: the starting weight of point-in, for example you set 0.5g, and target weight is 5g, when the actual weight reaches 4.5g, point-in flow is started.
- 点进导通时间：单次点进工作导通时间。
- On time: the working time of single point-in work
- 点进间隔时间：点进工作时进料间隔时间（一般无需调整）。
- Off time: the interval feeding time when point-in work (generally no need to adjust)
- 点进稳定时间：每次点进执行完成之后稳定等待时间（调整时间调整的是这个参数）。

- Stable schedule: stable waiting time after each point-in work(this parameter is adjusted by modify the time)
- 点回稳定时间：每次点回执行完成之后稳定等待时间
- Point back stabilization time: stable waiting time after each point flocking execution is completed.

点回 Point back

进料参数							
控制参数	通道	1#	2#	3#	4#	5#	6#
	内容						
首进率	大小点回切换重量(克)	00.00	00.00	00.00	00.00	00.00	00.00
精度上下限	大点回流量(克/次)	00.000	00.000	00.000	00.000	00.000	00.000
	大点回导通时间(秒)	0.000	0.000	0.000	0.000	0.000	0.000
	大点回间隔时间(秒)	0.000	0.000	0.000	0.000	0.000	0.000
	小点回流量(克/次)	00.000	00.000	00.000	00.000	00.000	00.000
	小点回导通时间(秒)	0.000	0.000	0.000	0.000	0.000	0.000
	小点回间隔时间(秒)	0.000	0.000	0.000	0.000	0.000	0.000
		工作画面	首进	点进	点回	去皮	系统目录

Automatic filling machine							
Control parameters	Aisle	1#	2#	3#	4#	5#	6#
	Content						
First rate	Point back switch weight(g)	00.00	00.00	00.00	00.00	00.00	00.00
Upper and lower precision	Big point back flow(g/n)	00.000	00.000	00.000	00.000	00.000	00.000
	Big point back on time(s)	0.000	0.000	0.000	0.000	0.000	0.000
	Big point back off time(s)	0.000	0.000	0.000	0.000	0.000	0.000
	Smala point back flow(g/n)	00.000	00.000	00.000	00.000	00.000	00.000
	Small point back on time(s)	0.000	0.000	0.000	0.000	0.000	0.000
	Small point back off time(s)	0.000	0.000	0.000	0.000	0.000	0.000
		Work page	First entry	Point in	Point back	Peeled	Meau

- 大小点回切换重量：点回分为大点回和小点回，当进料多的克重大于设定的切换克重时，执行大点回，当进料多的克重小于设定的切换克重时，执行小点回。

- Point back switch weight: Point back is divided into big point back and small point back. When the feeding weight is over than requested switching weight, the large point back is executed. When the feeding weight is less than requested switching weight, the small point back is executed.
- 点回稳定时间: 每次点回执行完成之后稳定等待时间 (调整时间调整的是这个参数)
- Point back stable time: stable waiting time after each point back work(this parameter is adjusted by modify the time)
- 大点回导通时间: 单次大点回工作导通时间。
- Big point back on time: on time of single big point back
- 大点回间隔时间: 大点回工作时进料间隔时间 (一般无需调整)。
- Big point back off time: interval time of big point back (generally no need to adjust)
- 小点回导通时间: 单次小点回工作导通时间。
- Small point back on time: on time of single small point back
- 小点回间隔时间: 小点回工作时进料间隔时间 (一般无需调整)。
- Small point back off time: interval time of small point back (generally no need to adjust)

去皮 Peel

### 进料参数

	通道	1#	2#	3#	4#	5#	6#
控制参数	内容						
	去皮时间 (秒)	0.000	0.000	0.000	0.000	0.000	0.000
首进率	去皮上限 (克)	00.00	00.00	00.00	00.00	00.00	00.00
	去皮下限 (克)	-00.00	-00.00	-00.00	-00.00	-00.00	-00.00
精度上下限	精准模式切称时间	0.000	0.000	0.000	0.000	0.000	0.000
	快速模式切称时间	0.000	0.000	0.000	0.000	0.000	0.000
	去皮次数	0000	0000	0000	0000	0000	0000

工作画面
首进
点进
点回
去皮
系统目录

### Automatic filling machine

	Aisle	1#	2#	3#	4#	5#	6#
Control parameters	Content						
	Peeling time(s)	0.000	0.000	0.000	0.000	0.000	0.000
First rate	Peeling upper limit (g)	00.00	00.00	00.00	00.00	00.00	00.00
	Lower peeling limit (g)	-00.00	-00.00	-00.00	-00.00	-00.00	-00.00
Upper and lower precision	Accurate mode switch scale time	0.000	0.000	0.000	0.000	0.000	0.000
	Quick mode switch scale time	0.000	0.000	0.000	0.000	0.000	0.000
	peeling cycle number	0000	0000	0000	0000	0000	0000

Work page
First entry
Point in
Point back
Peeled
Meau



- 去皮时间：单秤去皮时间。
- Peeling time: the peeling time of each scale
- 去皮循环数：去皮循环执行次数，例如设置为 5，则每 5 次去皮 1 次。
- Peeling cycle number: the number of times the peeling cycle is executed. For example, if you set it to 5, then peeling one time every 5 times.
- 去皮上限：去皮判断范围上限。
- Peeling upper limit: Upper range of peeling
- 去皮下限：去皮判断范围下限。
- Lower peeling limit: Lower range of peeling
- 切秤时间：出秤完成后稳定判断时间，两个秤之间的。
- Switch scales time: the stable judgment time after feeding, between 2 scales

首进率 First rate

进料参数							
控制参数 首进率 精度上下限	通道	1#	2#	3#	4#	5#	6#
	内容						
	12-15g	00.0	00.0	00.0	00.0	00.0	00.0
	15-20g	00.0	00.0	00.0	00.0	00.0	00.0
	20-25g	00.0	00.0	00.0	00.0	00.0	00.0
	25-30g	00.0	00.0	00.0	00.0	00.0	00.0
	30-35g	00.0	00.0	00.0	00.0	00.0	00.0
	>35g	00.0	00.0	00.0	00.0	00.0	00.0
<a href="#">工作画面</a> <a href="#">首页</a> <a href="#">上一页</a> <a href="#">下一页</a> <a href="#">尾页</a> <a href="#">系统目录</a>							

Automatic filling machine							
Control parameters First rate Upper and lower precision	Aisle	1#	2#	3#	4#	5#	6#
	Content						
	0-0.5g	00.0	00.0	00.0	00.0	00.0	00.0
	0.5-0.7g	00.0	00.0	00.0	00.0	00.0	00.0
	0.7-1g	00.0	00.0	00.0	00.0	00.0	00.0
	1-1.5g	00.0	00.0	00.0	00.0	00.0	00.0
	1.5-2g	00.0	00.0	00.0	00.0	00.0	00.0
	2-3g	00.0	00.0	00.0	00.0	00.0	00.0
3-4g	00.0	00.0	00.0	00.0	00.0	00.0	
<a href="#">Work page</a> <a href="#">Home</a> <a href="#">Previous page</a> <a href="#">Next page</a> <a href="#">Last page</a> <a href="#">Meau</a>							

- 依据不同区间、不同的秤设置对应的首进率，控制第一阶段进料的比例。
- Set the corresponding first feed rate according to different intervals and different scales, control the feed rate of the first stage.

精度上下限 Accuracy upper/lower limit

进料参数								
控制参数	通道		1#	2#	3#	4#	5#	6#
	内容							
首进率	0-0.5g	精度上限	00.00	00.00	00.00	00.00	00.00	00.00
		精度下限	00.00	00.00	00.00	00.00	00.00	00.00
精度上下限	0.5-0.7g	精度上限	00.00	00.00	00.00	00.00	00.00	00.00
		精度下限	00.00	00.00	00.00	00.00	00.00	00.00
	0.7-1g	精度上限	00.00	00.00	00.00	00.00	00.00	00.00
		精度下限	00.00	00.00	00.00	00.00	00.00	00.00
	1-1.5g	精度上限	00.00	00.00	00.00	00.00	00.00	00.00
		精度下限	00.00	00.00	00.00	00.00	00.00	00.00
	1.5-2g	精度上限	00.00	00.00	00.00	00.00	00.00	00.00
		精度下限	00.00	00.00	00.00	00.00	00.00	00.00
			工作画面	首页	上一页	下一页	尾页	系统目录

Automatic filling machine								
Control parameters	Aisle		1#	2#	3#	4#	5#	6#
	Content							
First rate	0-0.5g	Upper limit	00.00	00.00	00.00	00.00	00.00	00.00
		Lower limit	00.00	00.00	00.00	00.00	00.00	00.00
Upper and lower precision	0.5-0.7g	Upper limit	00.00	00.00	00.00	00.00	00.00	00.00
		Lower limit	00.00	00.00	00.00	00.00	00.00	00.00
	0.7-1g	Upper limit	00.00	00.00	00.00	00.00	00.00	00.00
		Lower limit	00.00	00.00	00.00	00.00	00.00	00.00
	1-1.5g	Upper limit	00.00	00.00	00.00	00.00	00.00	00.00
		Lower limit	00.00	00.00	00.00	00.00	00.00	00.00
	1.5-2g	Upper limit	00.00	00.00	00.00	00.00	00.00	00.00
		Lower limit	00.00	00.00	00.00	00.00	00.00	00.00
			Work page	Home	Previous page	Next page	Last page	Meau

依据不同区间、不同的秤设置对应的精度上下限。

Set the corresponding upper and lower limit according to different intervals and different scales

- 精度上限 : 允许实际值超出目标值的最大误差。
- Upper limit: the upper tolerance which actual value can exceed the target value
- 精度下限 : 允许实际值少于目标值的最大误差。
- Lower limit: the lower tolerance which actual value can be less than the target value

## 称重标定 Weighing calibration

称重校准			
称重标定	1#通道标定 <span style="color:red">禁止</span>	2#通道标定 <span style="color:red">禁止</span>	3#通道标定 <span style="color:red">禁止</span>
	当前重量: -0000.00	当前重量: -0000.00	当前重量: -0000.00
	当前电压: -00.0000	当前电压: -00.0000	当前电压: -00.0000
	1: 零点标定 <span>1#零点标定</span>	1: 零点标定 <span>2#零点标定</span>	1: 零点标定 <span>3#零点标定</span>
	2: 写入砝码值 <span>-000.00</span>	2: 写入砝码值 <span>-000.00</span>	2: 写入砝码值 <span>-000.00</span>
	3: 增益标定 <span>1#加载标定</span>	3: 增益标定 <span>2#加载标定</span>	3: 增益标定 <span>3#加载标定</span>
稳定标志位 <span>溢出标志位</span>	稳定标志位 <span>溢出标志位</span>	稳定标志位 <span>溢出标志位</span>	
标定成功 <span>标定失败</span>	标定成功 <span>标定失败</span>	标定成功 <span>标定失败</span>	
显示比例: <span>000.0</span>	显示比例: <span>000.0</span>	显示比例: <span>000.0</span>	
<span>工作画面</span>	<span>下一页</span>	<span>系统目录</span>	
Automatic filling machine			
Weighing calibration	1#Calibration <span style="color:red">OFF</span>	2#Calibration <span style="color:red">OFF</span>	3#Calibration <span style="color:red">OFF</span>
	Current weight: -0000.00	Current weight: -0000.00	Current weight: -0000.00
	Current voltage: -00.0000	Current voltage: -00.0000	Current voltage: -00.0000
	1: Zero calibration <span>1#Zero calibration</span>	1: Zero calibration <span>2#Zero calibration</span>	1: Zero calibration <span>3#Zero calibration</span>
	2: Weight value <span>-000.00</span>	2: Weight value <span>-000.00</span>	2: Weight value <span>-000.00</span>
	3: Gain calibration <span>1#Gain calibration</span>	3: Gain calibration <span>2#Gain calibration</span>	3: Gain calibration <span>3#Gain calibration</span>
Stable <span>Overflow</span>	Stable <span>Overflow</span>	Stable <span>Overflow</span>	
Success <span>Faliure</span>	Success <span>Faliure</span>	Success <span>Faliure</span>	
Zoom: <span>000.0</span>	Zoom: <span>000.0</span>	Zoom: <span>000.0</span>	
<span>Work page</span>	<span>Next page</span>	<span>Meau</span>	

- 标定步骤: ①: 清空称重箱, 点击零点标定;  
②: 将砝码放置在称重箱上, 输入正确的砝码值;  
③: 点击增益标定, 完成标定。
- Calibration steps: ①empty the weighing box, click on zero calibration  
②place the weight on the weighing box and enter the correct weight value  
③click on gain calibration and complete calibration
- 运行/禁止: 单个称的开关。
- ON/OFF: switch of single scale

- 当前重量： 当前系统的实时重量。
- Current weight: correct current weight in system
  
- 当前电压： 当前实时电压值。
- Current voltage: current voltage value
  
- 稳定标志位： 秤体的稳定标志位。
- Stable: The stability mark of the scale body
  
- 溢出标志位： 传感器溢出标志位，超过 10 溢出标志位置 ON。
- Overflow: sensor overflow, if more than 10, the overflow is ON
  
- 标定成功： 标定成功标志位。
- Success: calibration success
  
- 标定失败： 标定失败标志位。
- Failure: calibration failure
  
- 显示比例： 实际重量与显示重量的比例。
- Zoom: the ratio of actual weight to displayed weight

分段流量 Segmented flow

分段流量							
分段流量	通道	1#	2#	3#	4#	5#	6#
	内容						
	0-1g	000.00	000.00	000.00	000.00	000.00	000.00
	1-3g	000.00	000.00	000.00	000.00	000.00	000.00
	3-5g	000.00	000.00	000.00	000.00	000.00	000.00
	5-7g	000.00	000.00	000.00	000.00	000.00	000.00
	7-10g	000.00	000.00	000.00	000.00	000.00	000.00
	10-13g	000.00	000.00	000.00	000.00	000.00	000.00
	13-16g	000.00	000.00	000.00	000.00	000.00	000.00
<a href="#">工作画面</a> <a href="#">首页</a> <a href="#">上一页</a> <a href="#">下一页</a> <a href="#">尾页</a> <a href="#">系统目录</a>							

Automatic filling machine							
Control parameters	Aisle	1#	2#	3#	4#	5#	6#
	Content						
	0-1g	000.00	000.00	000.00	000.00	000.00	000.00
	1-3g	000.00	000.00	000.00	000.00	000.00	000.00
	3-5g	000.00	000.00	000.00	000.00	000.00	000.00
	5-7g	000.00	000.00	000.00	000.00	000.00	000.00
	7-10g	000.00	000.00	000.00	000.00	000.00	000.00
	10-13g	000.00	000.00	000.00	000.00	000.00	000.00
	13-16g	000.00	000.00	000.00	000.00	000.00	000.00
<a href="#">Work page</a> <a href="#">Home</a> <a href="#">Previous page</a> <a href="#">Next page</a> <a href="#">Last page</a> <a href="#">Meau</a>							

主要用于设置不同克重的进绒流量调节进绒速度，流量越大，进绒速度越慢越准。流量越小，进绒速度越快，但是容易超出。（系统会自动调节流量，不需手动修改）

Mainly used to set different weights of down flow to adjust feeding speed, the larger the flow, the slower and more accurate the filling speed.

The smaller the flow, the faster the filling speed, but it is easy to exceed. (the system will automatically adjust the flow rate, no need to modify manually)

公共参数		
公共参数	切换重量：（克）	00.00
	炮筒时间：大/小（秒）	0.000 0.000
	清腔时间：大/小（秒）	0.000 0.000
	上料风机启动延时：（秒）	0000.0
	加绒风机打开时间：（秒）	0000.0
	上料风机开启间隔时间：（秒）	0000.0
	加料完成落绒门延时开启时间：（秒）	0000.0
<a href="#">工作画面</a> <a href="#">首页</a> <a href="#">上一页</a> <a href="#">下一页</a> <a href="#">尾页</a> <a href="#">系统目录</a>		

Automatic filling machine		
Common parameter	Switch weight: (g)	00.00
	Barrel time: large / small (s)	0.000 0.000
	Clearing time: large / small (s)	0.000 0.000
	Feeding fan start delay: (s)	0000.0
	Plus fan open time: (s)	0000.0
	Feeding fan opening interval: (s)	0000.0
	delay opening of middle controlling door	0000.0
<a href="#">Work page</a> <a href="#">Home</a> <a href="#">Previous page</a> <a href="#">Next page</a> <a href="#">Last page</a> <a href="#">Meau</a>		

- 切换重量：炮筒时间、清腔时间分为大小时间，依据这个重量来区分。
- Switch weight: the barrel time and cleaning time are divided into large and small time, which are distinguished according to this weight
- 炮筒时间：出料完成后炮筒延时关闭时间。
- Barrel time: delayed closing time of the barrel after discharging
- 清腔时间：出料完成后清腔时间。
- Cleaning time: cleaning time after discharging

- 上料风机启动延时：上料风机按钮启动后，延时风机启动。
- Feeding fan start delay: after the feeding fan button is on, the fan starts delayed
- 加绒风机打开时间：上料风机工作时间。
- Plus fan open time: working time of feeding fan
- 上料风机开启间隔时间：上料风机上料完成之后，间隔时间内上料风机不会动作。
- Feeding fan opening interval: after the loading of feeding fan is completed, the fan will not operate within in interval
- 加料完成落绒门延时开启：加绒完成后等待风力完全消失后才会打开落绒门。
- Delay opening of middle controlling door: after feeding down, wait for the wind to completely disappear, then the middle controlling door will open.

公共参数	
公共参数	光电检测时间/下绒门打开时间：（秒） <input type="text" value="000.0"/> <input type="text" value="000.0"/>
	光电清理间隔时间/清理时间：（秒） <input type="text" value="000.0"/> <input type="text" value="000.0"/>
	一键回绒时间：（秒） <input type="text" value="000.0"/>
	首次回绒分批时间：（秒） <input type="text" value="0.000"/>
	工作画面 首页 上一页 下一页 尾页 系统目录
Automatic filling machine	
Common parameter	Photoelectric detection time / lower opening time: (s) <input type="text" value="000.0"/> <input type="text" value="000.0"/>
	Photoelectric cleaning interval / cleaning time: (s) <input type="text" value="000.0"/> <input type="text" value="000.0"/>
	One-click cashback time: (s) <input type="text" value="000.0"/>
	One-button back working time: (s) <input type="text" value="0.000"/>
	One-button back working interval: (s) <input type="text" value="0.000"/>
	One-button back working interval: (s) <input type="text" value="0000"/>
	Batching time of first pile back: (s) <input type="text" value="0.000"/>
	Work page Home Previous page Next page Last page Meau

- 光电检测时间：光电开光照到反光板后达到检测时间才会打开落绒门。
- Photoelectric detection time: after the photoelectric switch shines on the reflector, it will open the middle controlling door while reaching the detection time
  
- 下绒门打开时间：落绒完成后不会立刻关门，需要延时设定时间后才会关闭。
- Lower opening time: the door will not be closed immediately, it will be closed after the set delay time
  
- 光电清理间隔时间：光电清理的停止间隔时间。
- Photoelectric cleaning interval time: the interval time of photoelectric cleaning
  
- 清理时间：光电清理每次工作的时间。
- Photoelectric cleaning time: the time last for photoelectric cleaning
  
- 一键回绒时间：一键回绒单格秤体的回绒时间。
- One-click cashback time: time for the down to get back to single scale
  
- 首次回绒分批时间：首次回绒的切换秤体时间。
- Batching time of first pile back: time for switching the scales when first pile back



全自动充绒机					
功能设定	功能	状态	操作		
限幅参数	工作模式	精准模式	精准模式	快速模式	极速模式
称重模块参数	出绒方式	区间时间	区间时间	流量比例	混合控制
状态监控	零位启动功能	关	开	关	启动范围 00.00
	锁称功能	关	开	关	锁称时间 0.000
	分摊连出	关	开	关	
	克重显示	真实值	显示值	真实值	
	工作画面	下一页	系统设置		
Automatic filling machine					
Function setting	Features	status	operating		
Limiting parameter	Operating mode	Normal mode	Normal mode	Quick mode	Extreme speed mode
module parameters	Cashmere method	Time	Time	Flow	mixing
Status monitoring	Zero start function	OFF	ON	OFF	Starting range 00.00
	Locking function	OFF	ON	OFF	Lock time 0.000
	One foot out	OFF	ON	OFF	
	Weight display	actual value	Display value	actual value	
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- 工作模式：系统包含三种工作模式：精准模式、标准模式、速度模式。依据不同的使用场合选择模式使用，默认使用标准模式。这三种模式的区别主要表现在多秤循环清零数、切秤时间这两组参数上，精准模式每秤去皮，切秤时间最久，可以检测的余料范围最广；标准模式默认多秤一去皮，默认5秤去一次皮，参数可以调整，在进料参数-去皮中调整，切秤时间居中，可以检测范围在0.5克以上，余料克重较少时无法准确检测；速度模式下清零时间和余料检测时间为零，这一模式谨慎使用。
- Operating mode: the system contains 3 working modes: normal mode, quick mode and extreme speed mode. Please choose the mode according to different occasions, and use normal mode by default. Difference between these 3 modes is mainly parameters of multi-scale cycle reset number and scale switch time.

Quick mode peels every single scale, the switching time is longest, the range of residual material that can be detected is the widest.

The normal mode defaults to peel every 5 scales, the parameter can be modified in FEEDING PARAMETERS-PEEL. The switching time is in the middle, and the detection range is above 0.5 grams. when the weight of remaining material is small, it cannot be accurately detected.

In extreme speed mode, the reset time and residual material detection time are zero, so use this mode with caution.

- 出绒方式：出绒方式包含三种：区间时间、流量比例、混合控制。默认使用区间时间方式。区间时间为依据不同克重不同进行时间的设定；流量比例为设定出绒流量，依据出绒的克重自动算出出绒时间；混合控制为小克重依据区间时间，大克重依据流量比例计算时间的方法来控制出料时间。
- Cashmere method: there are 3 methods: time, flow and mixing. Time method is used by fault.  
Time setting is based on different weights.  
Flow setting is to set the down flow. The time for discharge down is automatically calculated according to the weight.  
Mixing setting is that, light weight bases on time and heavy weight bases on flow.
- 零位启动功能：启动范围设置，默认为关。当设置为关的时候，系统在任意克重可以启动，设置为开时，系统只有在设定的范围之内才能启动，启动范围即为设置的启动范围。
- Zero start function: starting range setting which is defaulted to OFF. When set to OFF, the system can be started at any weight. When set to ON, the system can only be started within the set range, and the starting range is which you entered.
- 锁称功能：合格之后等待锁称时间锁称，锁称了之后才可以操作。
- Locking function: Waiting for the lock after being qualified, and it can be operated after being locked.
- 分摊连出：大克重拆分多格之后只需要踩一脚可以多格连出。
- One foot out: after dividing into multiple grids, you only need to step one foot to fill multiple grids.
- 克重显示：真实值为真实重量，实时变化；显示值为锁称时的重量，锁称后不会变化。
- Weight display: actual value is the real weight which changes in the real time; display value is the weight when locking, and it will not change after locked.

厂家参数 Manufacturer parameters

功能设定	功能	状态	操作		
限幅参数	自适应模式	关	开	关	
称重模块参数	回绒功能	关	开	关	
状态监控	克重补偿	关	开	关	
	系统语言	中文	中文	English	Tiếng việt
	单次最大克重	000.00	蜂鸣器开关	关	
	参数初始化	初始化	蜂鸣器导通/关闭时间	000.00	000.00
	工作画面	上一页	系统设置		

Automatic filling machine

Function setting	Features	status	operating		
Limiting parameter	Adaptive mode	OFF	ON	OFF	
module parameters	Cashmere function	OFF	ON	OFF	
State monitoring	Weight compensation	OFF	ON	OFF	
	System language	中文	中文	English	Tiếng việt
	Single maximum weight	000.00	Buzzer	OFF	
	Parameter initialization	Initializing	Buzzer on/off time	000.00	000.00
	Work page	Next page	Meau		

- 自适应模式：系统内部自动修正参数功能，默认为开。
- Adaptive mode: automatic parameter correction function inside the system, the default is ON.
- 回绒功能：回绒功能是否启用。
- Cashmere function: to set the return down function is ON or OFF.
- 克重补偿：克重补偿会将系统的克重整体修正，可以正负修正，开启后在进料参数-首进参数中调整，设置数据为正，克重向多补偿，设置数据为负，克重向少补偿。
- Weight compensation: weight compensation will correct the overall weight of the system, which can be corrected plus or minus. Adjust in the FEEDING PARAMETER-FIRST FLOW. Set the data to be positive number, and the weight will be more compensated; Set the data to be negative number, and the weight will be less compensated.
- 系统语言：系统包括三种语言，中文、英文、越南语，可以自由切换。
- System language: the system includes 3 languages, Chinese, English and Vietnamese, which can be switched freely.
- 单次最大克重：单次单秤所能分配的最大克重，超出部分会进行分摊。

- Single maximum weight: the maximum weight that can be allocated by a single scale at one time, the excess will be allocated.
- 参数初始化: 长按 3 秒会出现初始化弹窗, 确认后系统所有参数恢复成默认值。
- Parameter initialization: long press for 3 seconds and an initialization window will appear. After confirmation, all parameters will be restored to their default values
- 蜂鸣器: 有剩绒的时候蜂鸣器会提示。
- Buzzer: the buzzer will prompt when there is lint left.

限幅参数 Limiting parameters

限幅参数							
功能设定	通道	1#	2#	3#	4#	5#	6#
限幅参数	首进流量最小值	00.00	00.00	00.00	00.00	00.00	00.00
	首进流量最大值	00.00	00.00	00.00	00.00	00.00	00.00
称重模块参数	首进最小时间	0.000	0.000	0.000	0.000	0.000	0.000
	点进流量最小值	00.000	00.000	00.000	00.000	00.000	00.000
状态监控	点进流量最大值	00.000	00.000	00.000	00.000	00.000	00.000
	大点回流量最小值	00.000	00.000	00.000	00.000	00.000	00.000
	大点回流量最大值	00.000	00.000	00.000	00.000	00.000	00.000

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Function setting	Aisle	1#	2#	3#	4#	5#	6#
	Content						
Limiting parameter	First flow minimum	00.00	00.00	00.00	00.00	00.00	00.00
	First flow maximum	00.00	00.00	00.00	00.00	00.00	00.00
module parameters	First entry minimum time	0.000	0.000	0.000	0.000	0.000	0.000
	Point-in flow minimum	00.000	00.000	00.000	00.000	00.000	00.000
Status monitoring	Point-in flow maximum	00.000	00.000	00.000	00.000	00.000	00.000
	Large point return flow minimum	00.000	00.000	00.000	00.000	00.000	00.000
	Large point return flow maximum	00.000	00.000	00.000	00.000	00.000	00.000
	<div style="display: flex; justify-content: space-around; align-items: center;"> <span>Work page</span> <span>Home</span> <span>Previous page</span> <span>Next page</span> <span>Last page</span> <span>Meau</span> </div>						

限幅参数主要是限制系统各个阶段参数，将各个参数限制在一个合理范围之内。

Limiting parameters are mainly to limit the parameters of each stage of system and keep them in a reasonable range.

- 首进流量部分：首进参数包括首进流量最小值、首进流量最大值、首进最小参数。首进流量最大、最小值是指系统内部的首进阶段的流量的上下限；首进最小时间是指首进阶段计算出来的首进时间所允许的最小工作时间。
- First flow parameters: including first flow minimum, first flow maximum and first entry minimum parameters.  
First flow minimum/maximum refers to the upper and lower limits of first flow inside the system.  
First entry minimum time refers to the minimum working time allowed by first entry time calculated in the first entry stage.
- 点进流量部分：点进参数包括点进流量最小值、点进流量最大值。点进流量最大、最小值是指系统内部的点进阶段单次点进的流量的上下限，流量不在这个范围时会根据上下限流量动作。
- Point-in flow parameters: including point-in flow minimum and point-in flow maximum, which refer to the upper and lower limited of the single point-in flow inside the system. when the flow rate is not in this range, it will act according to the upper and lower limit flow.
- 大点回流量部分：大点回参数包括大点回流量最小值、大点回流量最大值。大点回流量最大、最小值是指系统内部的大点回阶段单次大点回的流量的上下限，流量不在这个范围时会根据上下限流量动作。
- Large point return flow parameters: including large point return flow minimum and large point return flow maximum, which refer to the upper and lower limits of the single large point return inside the system. When the flow is out of this range, it will act according to the upper and lower limit flow.

限幅参数 Limiting parameters

限幅参数							
功能设定	通道	1#	2#	3#	4#	5#	6#
	内容						
限幅参数	小点回流量最小值	00.000	00.000	00.000	00.000	00.000	00.000
	小点回流量最大值	00.000	00.000	00.000	00.000	00.000	00.000
称重模块参数	点进单次最多次数	00	00	00	00	00	00
	大点回单次最多次数	00	00	00	00	00	00
状态监控	小点回单次最多次数	00	00	00	00	00	00
<div style="display: flex; justify-content: space-around;"> <span>工作画面</span> <span>首页</span> <span>上一页</span> <span>下一页</span> <span>尾页</span> <span>系统目录</span> </div>							

Automatic filling machine							
Function setting	Aisle	1#	2#	3#	4#	5#	6#
	Content						
Limiting parameter	Small point return flow minimum	00.000	00.000	00.000	00.000	00.000	00.000
	Small point return flow maximum	00.000	00.000	00.000	00.000	00.000	00.000
module parameters	Maximum number of clicks per click	00	00	00	00	00	00
	Big point back maximum	00	00	00	00	00	00
Status monitoring	Small point back maximum	00	00	00	00	00	00
<div style="display: flex; justify-content: space-around;"> <span>Work page</span> <span>Home</span> <span>Previous page</span> <span>Next page</span> <span>Last page</span> <span>Meau</span> </div>							

- 小点回流量部分：小点回参数包括小点回流量最小值、小点回流量最大值。小点回流量最大、最小值是指系统内部的小点回阶段单次大点回的流量的上下限，流量不在这个范围时会根据上下限流量动作。
- Small point return flow parameters: including small point return flow minimum and small point return flow maximum, which refer to the upper and lower limits of the flow for single big point return at the small point return stage inside the system. When the flow is not in this range, it will act according to the upper and lower limit flow.
- 最多次数部分：点进单次最多次数、大点回单次最多次数、小点回单次最多次数。最多次数是控制系统每次动作是计算出来的动作次数的最大值，分别表示三个不同阶段的最大值。
- Maximum number of clicks per click: maximum number of single point-in flow, maximum number of single big point return and maximum number of single small point return.

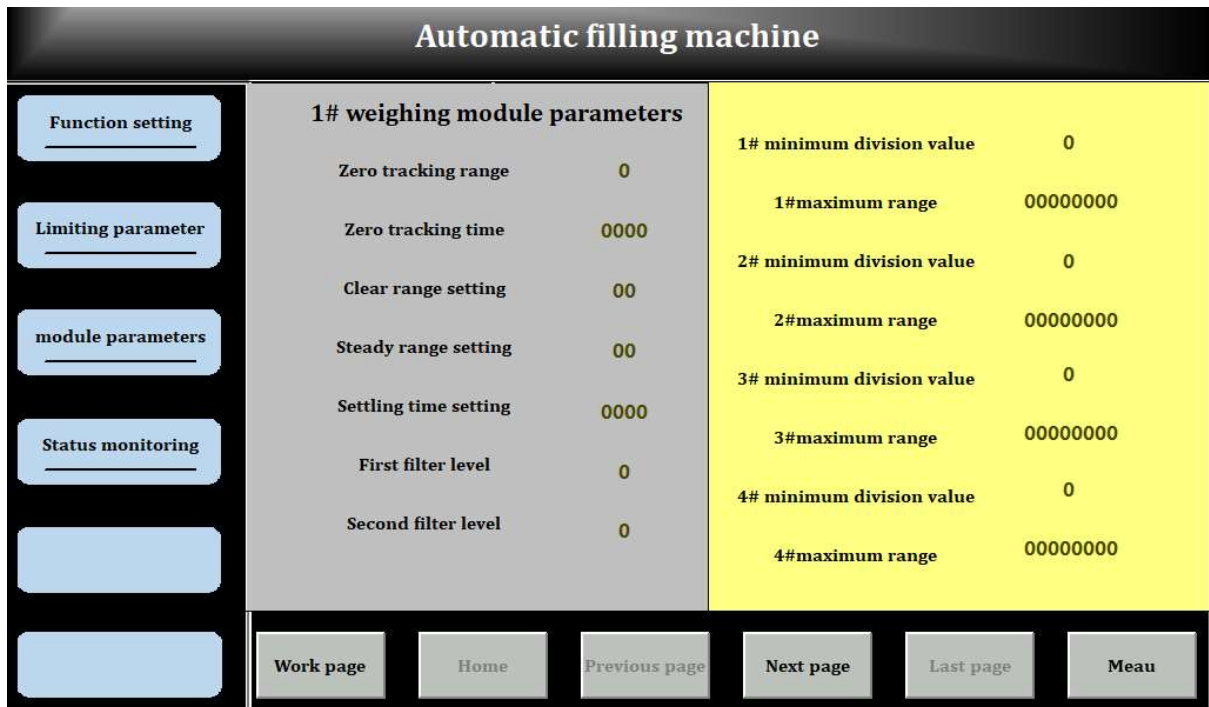
Maximum number is the maximum value that the system calculates based on the action numbers each time, which represents the maximum value of 3 different stages.

称重模块参数 Weighing module parameters

### 称重模块参数

功能设定	1#称重模块参数				
	零点追踪范围	0	1#最小分度值	0	
限幅参数	零点追踪时间	0000	1#最大量程	00000000	
称重模块参数	清零范围设置	00	2#最小分度值	0	
	判稳范围设置	00	2#最大量程	00000000	
状态监控	判稳时间设置	0000	3#最小分度值	0	
	第一滤波等级	0	3#最大量程	00000000	
	第二滤波等级	0	4#最小分度值	0	
			4#最大量程	00000000	

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称重模块参数主要是称重模块的各个参数，一般客户无需调整。  
The parameters of weighing module generally do not need to modify by users.

#### 六. 一般故障识别与处理方法 General fault identification and handling methods

故障现象 Failure phenomenon	故障原因 Cause of failure	处理方法 Handling methods
<p>Piece has no data !</p>	<p>1. 裁片没有设置配方 2. 系统突然断电</p> <p>1.Pieces have no formula 2.Sudden power failure of the system</p>	<p>1. 进入裁片设置输入配方。 2. 重新进入裁片设置后返回。</p> <p>1.Enter the cut piece setting screen to input the formula 2.Enter the cut piece setting screen again then back</p>
<p>There is no switch!</p>	<p>秤未开启 The scale is not turned on</p>	<p>进入称重标定查看秤体开关是否关闭 Enter the weighing calibration to check whether the switch of scale is OFF</p>



<p>Hopper with velvet Please empty the hopper</p> 	<p>1. 料斗内有剩绒未清理干净 2. 料斗清理干净但显示数值未清零 (此故障仅限 V1.0 软件版本, V1.1 版本后请忽略)</p> <p>1. There is lint left in the hopper 2. Hopper is empty but the displayed value is not cleared. (This fault is limited to V1.0 software version please ignore after V1.1 version)</p>	<p>1. 清空料斗 2. 将秤去皮</p> <p>1. Empty the hopper 2. Tare the scale</p>
<p>通讯中断 Communication interrupted</p>	<p>1. PLC 与触摸屏数据线松动未插紧。 2. 数据线出现故障。</p> <p>1. The cable connecting the PLC with screen is loose and not plugged in tightly. 2. The data cable is faulty.</p>	<p>1. 检查后将数据线重新插紧。 2. 更换数据线。</p> <p>1. Plug in the cable tightly 2. Replace the cable</p>
<p>充绒充不净, 系统总提示有余绒 System always prompts that there is lint left</p>	<p>1. 绒粘在料斗内壁上 2. 出绒时间太短 3. 出绒炮筒堵塞 4. 出绒管道堵塞 5. 出绒电磁阀工作单没有气 6. 回气阀气管接反</p> <p>1. Down sticks to the inner wall of hopper 2. The time for discharging down is too short 3. The barrel is blocked 4. The pipe is blocked 5. There is no air for solenoid valve 6. The air tube of air-return valve is reversed</p>	<p>1. 设备是否接地, 湿度是否太低。 2. 适当延长出绒时间。 3. 清理炮筒。 4. 清理出绒管道。 5. 拆掉电磁阀清理或更换(电磁阀属于耗材, 超过使用次数或寿命建议更换)。 6. 调换回气阀气管。</p> <p>1. Whether the equipment is grounded and the humidity is too low. 2. Properly extend the discharge time 3. Clean the barrel 4. Clean the down discharging pipe 5. Remove the solenoid valve for cleaning or replacement (solenoid valve is a consumable part, it is recommended to replace if it exceeds the used of life)</p>
<p>秤的显示数值跳动较大 The displayed value of scale fluctuates greatly</p>	<p>1. 检查出绒回绒吸盘是否触碰料斗(吸盘中间要有间隙, 不可触碰一起) 2. 是否有异物碰到料斗 3. 料斗进料口出料口或表面是否有绒。 4. 传感器线是否松动 5. 传感器损坏</p> <p>1. Check whether the down suction cup touches the</p>	<p>1. 将吸盘调整最佳位置。 2. 将异物清理。 3. 将料斗清理干净。 4. 将传感器线重新接牢靠。 5. 更换传感器。</p> <p>1. Adjust the suction cup to the best position 2. Clean up the foreign objects 3. Clean the hopper 4. Reconnect the sensor wire firmly</p>

	<p>hopper (there should be a gap in the middle of suction cups)</p> <p>2. Check whether there is anything hitting the hopper</p> <p>3. Check whether there is lint on the inlet or outlet of hopper or on the surface</p> <p>4. Check whether the sensor wire is loose</p> <p>5. Check whether the sensor is damaged</p>	5. Change the sensor
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<p>秤的显示是准的，充出之后误差较大</p> <p>Display of the scale is accurate, but the error is large after filling</p>	<p>1. 清空料斗，放上砝码看数字是否准确</p> <p>2. 秤稳定时间较短</p> <p>3. 绒容易留在出绒管道</p> <p>1. Empty the hopper, then put a weight on to see if the value is accurate</p> <p>2. Scale stabilization time is short</p> <p>3. Down is easy to stay in the discharging pipe</p>	<p>1. 不准，将秤重新标定。</p> <p>2. 将秤的稳定时间延长。</p> <p>3. 出绒时间短或出绒气压小，导致绒还未完全充到裁片内。</p> <p>1. If not accurate, recalibrate the scale</p> <p>2. adjust the stabilization time longer</p> <p>3. The discharge time is short or pressure is low, so the down cannot be completely filled into the piece</p>
<p>搅拌电机停止运转</p> <p>Stirring motor stops running</p>	<p>1. 调速器开关关闭</p> <p>2. 调速器转速为 0</p> <p>3. 调速器与电机的插头松开</p> <p>4. 调速器故障</p> <p>5. 落绒较多导致电机过载保护或烧毁</p> <p>6. 电机卡死</p> <p>1. Governor switch is off</p> <p>2. Speed of governor is 0</p> <p>3. The plug connecting governor and motor is loosened</p> <p>4. Governor failure</p> <p>5. Too much lint leads to motor overload protection or burnout.</p> <p>6. Motor stuck</p>	<p>1. 打开调速器开关。</p> <p>2. 将调速器转速调至最佳。</p> <p>3. 将电源断掉后重新对插插头。</p> <p>4. 更换调速器。</p> <p>5. 将绒清理后待电机冷却再次开启，如还未运转请更换电机。</p> <p>6. 将绒清理后再次开启。</p> <p>1. Turn on the governor switch</p> <p>2. Adjust the speed of governor to the best</p> <p>3. Reconnect the plug after disconnecting the power</p> <p>4. Replace the governor</p> <p>5. After cleaning the lint, wait for the motor to cool and turn it on again. If still not running, please replace the motor</p> <p>6. Clean the lint and turn it on again</p>
<p>不进料</p> <p>Fail to feed down</p>	<p>1. 进料电磁阀故障</p> <p>2. 进料管道堵塞</p> <p>3. 进料调压表未调压</p> <p>1. Feeding solenoid valve failure</p> <p>2. Feeding pipe is blocked</p> <p>3. Feeding regulator is not regulated</p>	<p>1. 更换电磁阀。</p> <p>2. 清理进料管道。</p> <p>3. 调节进料调压表。</p> <p>1. Replace the feeding solenoid valve</p> <p>2. Clean the feeding pipe</p> <p>3. Adjust the feeding press regulator</p>

搅拌电机出现异响 Abnormal noise in the stirring motor	1. 长时间未清理绒箱 2. 长时间未对电机保养 3. 电机减速箱损坏 1. The down box has not been cleaned for a long time 2. The motor has not been maintained for a long time 3. The motor gearbox damaged	1. 清理绒箱。 2. 对电机进行保养。 3. 维修或更换减速箱。 1. Clean the down box 2. Maintain the motor 3. Repair or replace the gearbox
料斗灌满堵塞 The hopper is full and clogged	1. 进料电磁阀卡住 2. 进料流量为 0，不停的进绒 3. 按手动进绒按键导致 1. The feeding solenoid valve is stuck 2. The feed flow rate is 0 and the down is continuously being feeding 3. Caused by the manual feeding button	1. 清理或更换电磁阀。 2. 重新学习流量。 （如正常方法无法清理出堵塞的绒，请用气枪一边对料斗出料口吹，另一边点出绒按键即可） 1. Clean or replace the solenoid valve 2. Recleaning the flow (If the clogged lint cannot be cleaned out by normal method, please use an air gun to blow from outlet of hopper, and click the discharge button at the same time)
电磁阀经常容易卡死或出气无力 Solenoid valve is often easy to stuck or blow weakly	检查空压机储气罐是否长期未排水 Check whether the air compressor tank has not been drained for a long time	将空压机储气罐排水，有条件的情况下可安装干燥机，以保护设备各气动元件。 Drain the air storage tank of air compressor. If possible, install a dryer to protect the pneumatic components of the equipment
下绒箱不落绒 The lower down box does not feed	光电开关未对准反光板 The photoelectric switch is not aligned with the reflector	将光电开关调整至对准反光板。 Adjust the photoelectric switch to the reflector

## 七. 设备保养 Equipment maintenance

1. 下班停止设备前请将设备的料斗与称重箱进行清理，保持干净整洁。  
**注意：清理时请勿用力触碰挤压料斗，以免造成料斗和称重传感器损坏。**

1. Please clean the hopper and weighing box before stopping the equipment after get off work to keep clean and tidy.

**Note: Do not squeeze the hopper forcibly during cleaning to avoid damage to the hopper and loading cell.**

2. 吃饭或休息时请将设备停止运转，以免造成电机长时间运转导致的发热烧毁。

(此现象出现较多, 设备运转状态下无人员在旁, 存在安全隐患)

2. Please stop the equipment when eating or resting to avoid heating and burning caused by long-term operation of the motor.

(This phenomenon occurs frequently, and there are no people around when equipment is running, there is a safety hazard)

3. 经常对设备主机绒箱内、电机箱、配电箱、气动元件进行清理, 做到无死角, 使设备故障率降至最低。

3. Frequently clean the down box, motor box, power distribution box and pneumatic components of the equipment to ensure that there are no dead spots and minimize the failure rate of equipment.

4. 加绒时无意吸进去的布条垃圾等异物请及时清理出, 避免造成严重后果。

4. Please clean out the cloth, waste or other objects that you accidentally sucked in when adding the down to avoid serious consequences.