



SANTONI

完美袜机

软件使用说明

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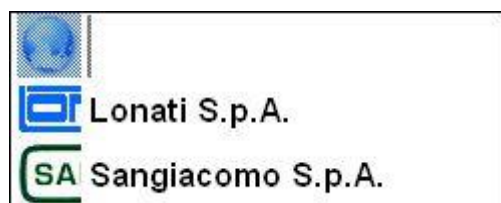
一、 BigBang 说明



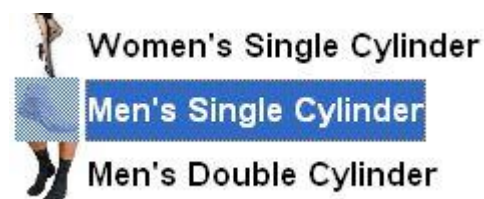
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18
1 新建									10 测试程序								
2 组建									11 格式化磁盘								
3 打开									12 创建机型构架								
4 剪切									13 磁盘创建 CO.文件架构								
5 复制									14 传送 CO.文件到机器的网卡								
6 粘贴									15 从机器网卡里复制一个 CO.文件								
7 删除									16 隐藏/开启窗口								
8 特性									17 信息								
9 增加到搜索栏									18 软件版本								



1	2	3
1 隐藏/开启软盘		
2 隐藏/开启网络驱动器		
3 过滤文件夹		

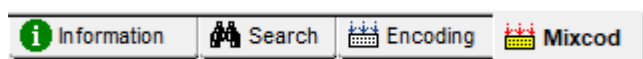
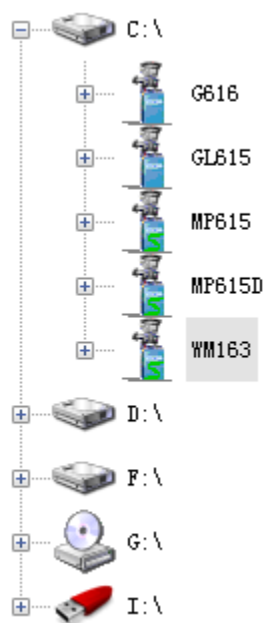


1	2	3
1 常规系列		
2 罗纳地系列		
3 胜歌系列		



1	2	3
1		
2		
3		

-
- 1 丝袜机型
 - 2 单针筒棉袜机型
 - 3 双针筒棉袜机型
-



1 2 3 4

-
- 1 信息 用于查看链条信息
 - 2 搜寻
 - 3 编码
 - 4 配置编码
-

Information



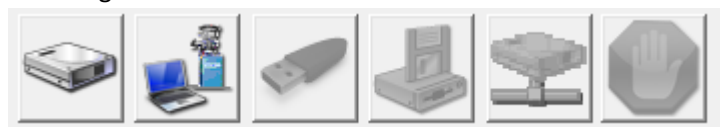
1 2

-
- 1 详细描述，用于显示链条程序备注
 - 2 实物，用于显示链条程序附带图片
-

Search

查找

Encoding



1 2 3 4 5 6

- 1 编码到硬盘
 - 2 编码到机器
 - 3 编码到 USB
 - 4 编码传送到软盘
 - 5 编码到服务器
 - 5 取消编码
-

Mixcod

配置编码

二、 QuasarL 链条编辑软件部分



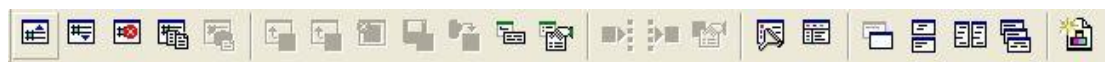
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27

- | | |
|----------------|------------|
| 1 选择机型 | 15 粘贴 |
| 2 新建一个程序 | 16 删除 |
| 3 打开已存的程序 | 17 拷贝入桶内 |
| 4 保存 | 18 自桶内粘贴 |
| 5 另存 | 19 清空桶内内容 |
| 6 打印预览 | 20 下载入桶内 |
| 7 整个程序打印 | 21 保存桶内资料 |
| 8 写程序注解 | 22 返回到前一步 |
| 9 写程序工艺 | 23 搜索/替换资料 |
| 10 展示或隐藏首选窗口 | 24 比对两组链条 |
| 11 展示或隐藏步进马达区域 | 25 显示左边的差别 |
| 12 帮助窗口 | 26 刷新比较的内容 |
| 13 剪切 | 27 显示右边的差别 |
| 14 拷贝 | |



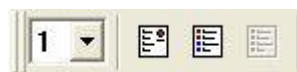
1 2 3 4 5

- | | |
|----------------|--------------|
| 1 检查并保存到硬盘 | 4 检查并保存到 U 盘 |
| 2 检查并保存到软盘 | 5 检查时插入程式源 |
| 3 用 UPM 线输送到机器 | |



1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22

- | | |
|-------------------|--------------|
| 1 向上加空步段 | 12 款式备忘录 |
| 2 向下加空步段 | 13 打开 MACRO |
| 3 删除步段 | 14 关闭 MACRO |
| 4 步段内容拷贝 | 15 MACRO 写备注 |
| 5 步段内容粘贴 | 16 展示或隐藏资料 |
| 6 选择作者的部段款式 | 17 资料状态 |
| 7 选择 LONATI 的部段款式 | 18 新视窗 |
| 8 更换已选的部段款式 | 19 水平铺贴 |
| 9 储存部段款式 | 20 竖直铺贴 |
| 10 部段款式的结合 | 21 串连状铺贴 |
| 11 部段款式简叙， | 22 程式资料集 |



1 2 3 4

- | | |
|---------|----------|
| 1 选择尺码 | 3 按种类排列 |
| 2 按角度排列 | 4 电脑自动排列 |



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

- | | |
|-------------|----------------|
| 1 写备忘 | 12 覆盖花型 |
| 2 速度 | 13 打松花型 |
| 3 循环圈数 | 14 立体花型 |
| 4 信号功能 | 15 固定选针 |
| 5 袜跟加减针改变宽度 | |
| 6 零件功能 | 16 裁剪记号线固定选针 |
| 7 三角零件 | 17 哈夫盘升降马达位置参数 |
| 8 梭子 | 18 宏命令 |
| 9 风门 | 19 自定义的宏命令 |
| 10 普通花型 | 20 YOYO 功能信号 |
| 11 橡筋花型 | |

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ELASTIC MOTORS	2
LYCRA MOTORS	3
SINKERS MOTORS	4
YOYO 1-4	5
YOYO 5-8	6

-
- 1 针筒马达密度修改，包含三角马达修改
 - 2 橡筋马达密度修改，包含 2 号橡筋马达和剪刀盘马达
 - 3 氨纶马达密度修改，包含莱卡马达 1 和 2
 - 4 生克片马达密度修改，包含压力马达和角度马达
 - 5 YOYO 马达修改，包含 1234 马达克重
 - 6 YOYO 马达修改，包含 5678 马达克重
-



1 2

-
- 1 [编程首选](#)（按住 Ctrl 点击绿色文字跳转到相应位置）
 - 2 程序架构
-



1 2 3 4

-
- 1 选择资料，对比两个链条
 - 2 保存个性化的资料布局图
 - 3 应用个性化的资料布局图
 - 4 资料布局图在打开的文件上
-

















1 2 3 4

-
- 1 马达管理区域
 - 2 信息，编译信息提示
 - 3 回收桶，复制的链条显示于此
 - 4 立体袜一些提示信息，每一圈正转还是反转，旋转角度提示等
-

三、 Header 链条编辑首选项

GL616DF3 编程软件左侧菜单解释

Type	Parameter
	Needles 144
	Jack butts diagonal = 8
	Oil Program [Oil program: 1 Sinker crown oiling interval in minutes: 0 Lubrication br
	Diameter 3"3/4
	Dial Motor positions table
	Pattern start set-up [Tenth of degree = 0]
	Stitch-cam Gauge 9
	Motorized stitch cam height offset
	Size to activate on machine [Default Size = 1]
	Reverser valve regulation [Step = 0]
	External Closed Toe
	Grams YOYO - Reset machine
	Grams YOYO - Zeroing machine
	Yarn parameter for YOYO motors

Needles

解释：针数，与机器实际针数对应

Jack butts diagonal

解释：选针器 级数，lonati 袜机选针器上一般袜机是 8 个刀头

Oil program

解释：每多少只袜子都开启了油泵一次，与程序内对应，例如数字为 2，意思：两只袜子加油启动一次，对应程序内功能 3 所在步骤加油（当然一个程序内加油功能也可以多次）
此数字只是表示多少只袜子执行程序内的功能

Diameter

解释：机器针筒口径

Dial Motor positions table

解释：哈弗盘升降马达相对值表，对应链条编辑里的 Movement code: 选择 T 时候的 值。



此表内数据是与链条内填写的绝对值一样作用只是方便记忆，和使用

Pattern start set-up

解释：设置花型偏移袜跟中心的角度

Stitch cam Gauge（部分机型隐藏）

解释：成圈三角级数选择，棉袜机一般有 0.60mm； 0.69mm； 0.85mm 三种级数的织针

Stitch-cam Gauge 9 [19.10 > 0 < 20.40]

Stitch cam Gauge 14 [19.80 > 0 < 21.00]

Stitch cam Gauge 22 [21.00 > 0 < 22.10]

Motorized stitch cam height offset

解释：电机控制的成圈三角整体偏移 -30 到 30

Size to activate on machine

解释：使用尺码，与机器内对应，也和编辑链条中的尺寸对应共有 8 个尺码



Reverser valve regulation

解释：不知道什么作用

External Closed Toe

链条编辑软件内缝头菜单部分

Insert/Modify Item


External Closed Toe


Degree

Status Subgroup

Type of stitching: 1 Number of pins at start (=end) per type of seaming 3: 1 Stitching speed: 300 T

Dato	Parameter	Value
<input type="checkbox"/>	Type of stitching:	1
<input type="checkbox"/>	Number of pins at start (=end) per type of seaming 3:	1
<input type="checkbox"/>	Stitching speed:	300
<input type="checkbox"/>	Type of suction on extraction:	1
<input type="checkbox"/>	Pick-up device opening stage:	0
<input type="checkbox"/>	Link transfer:	0
<input type="checkbox"/>	Onboard data modification:	1
<input type="checkbox"/>	Reversed sock ejection:	0
<input type="checkbox"/>	Sock pusher sector speed:	0
<input type="checkbox"/>	Heavy sock ejection:	0
<input type="checkbox"/>	Eliminates control of sock-stretching sectors:	0
<input type="checkbox"/>	Tube rotation of the lower turning device:	0

Main data Suction Fabric data Size 1 Size 2 Size 3 Size 4 Size 5 Size 6 Size 7 Size 8

Step	Status	Degree	Data

☐ Show only changed data

Main data

1. Type of stitching:

Type of seam [1]=pin-pin, [2]=pin-1/2pin, [3]=Setting the number of pins

缝合类型:

[1] =针对针缝合

[2] =半针半针缝

[3] =混合式，左右半针，中间针对针（此模式配合下一菜单选项）

2. Number of pins at start (=end) per type of seaming 3:

Number of pins at start (=end) per type of seaming 3

与上一菜单 3 配合，开始和结束时，半针缝合范围，最多 15 针

隐藏栏（无此栏）

Number of pins at the end per type of seaming 3:

Number of pins at the end per type of seaming 3

备注：与上一菜单一样意思，只控制结束部分

3. Stitching speed:

Stitching speed measured by strokes per minute [From 100 to 450]

缝纫机速度：

以每分钟一分钟的速度测量的速度，从 100 到 450

备注：缝纫机马达转速

4. Type of suction on extraction:

Type of suction on extraction [1]=Pre inclination, [2]=Post inclination

抽吸式：

1=前倾（全程吸风），2=后倾角（转向后吸风）

备注：先启动吸风再移动管子（倾斜管子），2 先倾斜管子再吸风

5. Pick-up device opening stage:

Pick-up opening device stage code [0]=Normal stage, [1]=Advanced stage

传感器设备开放阶段：

启动设备阶段代码 0=正常阶段（先转到缝头装置再打开），1=高级阶段（先打开再转入，
袜子弹性大时）

备注：0 钩爪盘先转到缝头装置再打开，1 转移钩子先打开再转入，袜子弹性大时

6. Link transfer:

Link transfer [0]=Normal, [1]=Pre-turning, [2]=Pre-turning with link pusher

缝头转移：

0=正常（先上筒，再上托盘）

1=预转（先上托盘，再上筒）

2=前转（压环先下，托盘上升，然后反袜筒再上）

备注：

0.中间管子（缝头部分下面的管子）向上翻袜子，之后下面的转移片（缝头部分下面的管子边的）再向上

1.先转移片（缝头部分下面的管子边的）向上压，再中间管子（缝头部分下面的管子）向上翻袜子

2.先转移片（缝头部分下面的管子边的）向上压，之后转移片下来回位后，中间管子再向上翻袜子

7. Onboard data modification:

Onboard data modification [0]=Modification inhibited, [1]=Modification possible

现在没用

8. Reversed sock ejection:

Reversed sock ejection (default 0), [0]=right way, [1]=reversed, [2]=reverse sole liner

逆转袜子弹射:

反转袜子弹射（默认 0），0=右路，1=反向，2=反向鞋底衬

备注：翻袜子的一种装置，出袜后袜子是翻过来的（正面在里，里面翻在外面）

一种特别的装置，目前 LONATI 机器没有看见实物

9. Sock pusher sector speed:

Sock pusher sector speed selection (default 0) [0]=Normal, [1]=Medium, [2]=Low

袜子推杆式部门速度:

完成缝头后推杆向下速度

0=正常（正常速度）

1=中等（中等速度）

2=低（最慢）

备注：翻袜子两个钳子的速度，在缝头装置上方有机玻璃里面有两个对称部分组成的夹子

10. Heavy sock ejection:

Heavy sock ejection (default 0) [0]=Disabled, [1]=Enabled

沉重的袜子弹射:

重袜子弹射（默认 0）0=禁用，1=启用

备注：当你使用独立风扇电机时，它的功率会在机器和缝纫机器人之间进行分配，所以对于重袜子来说，可能空气不足以将袜子取出来。因此，如果这个选项在缝制后机器人将等待推出袜子，直到机器没有完成编织下一只袜子

when you are using the fan motor ,its power will divide between the machine and the sewing robot, so for heavy socks maybe air will be not enough for get the sock out. so if this option after sewing the robot will wait to push out the sock until the machine doesn't finish to knit the next sock

11. Eliminates control of sock-stretching sectors:

Eliminates control of sock-stretching sectors (default 0) [0]=Disabled, [1]=Enabled

消除了对扭曲的部门的控制:

长袜子扭曲控制（默认 0）0=禁用，1=启用

备注：关于上面夹子（有机玻璃罩子里的两个钳子），遇到厚袜子的时候，没有加紧的情况下机器是否停机的选项；如果在设备未关闭时启用此功能，错误将不会出现，因为有时设备关闭不太好，您可以删除错误

12. Tube rotation of the lower turning device:

Tube rotation of the lower turning device (default 0) [0]=Disabled, [1]=Enabled

下旋装置的管旋转:



下旋装置的管旋转（默认为 0）0=禁用，1=启用

备注：这是一个可选的电机，移动管的设备，一般袜机（完美袜机没有）没有此设备

13. Positioning the sock ejection arm:

Positioning the sock ejection arm (default 0) [0]=Normal stage, [1]=Advanced stage

放置袜子弹射臂：

放置袜子弹射臂（默认为 0）0=正常阶段，1=高级阶段

备注：

0.针先起来 之后移动转盘抓取袜子（转移袜子）一般正常情况如此

1.先转移爪盘，再上升织针，最后爪子缩小到织针针舌下

14. Number of knit transfer strokes:

Number of knit transfer strokes (default 1) [From 1 to 4]

针织转移笔数：

从 1 到 4 的针笔划划次数（默认值 1）

备注：向上转移推几次，上下转移片，在缝头设备下方，最新款已经改成塑料的转移片

15. End of stitch transfer:

End of stitch transfer (default 0) [From 0 to 1]

结束缝合针转移：

从 0 到 1 的针脚转移（默认值 0）

备注：可能是最后一针缝合两次，不确定

隐藏:

Positioning the sock ejection arm:

Positioning the sock ejection arm (default 0) [0]=Normal stage, [1]=Advanced stage

16. Stitch transfer phase - pin holder dome unit:

Stitch transfer phase - pin holder dome unit (default 0) [From 0 to 1]

备注: 选择 1 的时候 缝头的对刺会转到缝纫机这边之后再下压, 0 则不会偏转到前面

17. Movement of the vertical sock extraction arm:

Movement of the vertical sock extraction arm (default 0) [0]=Normal, [1]=Double movement

备注: 抓针钩在针筒上方, 上提袜子时 (离开织针时) 马达力量增加

18. Reverser up shutter valve closing delay for sock ejection:

Reverser up shutter valve closing delay for sock ejection (default 0) [min.350ms - max.1500ms]


[0]=Disabled

备注: 字面意思延时, 袜子喷射 350——1500 毫秒, 应该是转移的时候延时多少时间再喷气 (针筒下方)

19. Enable positioning on pins:

Enable positioning on pins (default 0) [0]=Disabled, [1]=Enabled

备注: 字面意思定位针, 没有用过

 **External Closed Toe**

备注：以下是 7 个不同位置吸风，前面三个位置主要控制缝头装置下吸风
后面几个控制缝头位置上吸风，具体可查看测试位置

1. Tilting device down step 1 (timed):
Tilting device down step 1 (timed) (default 73)
反袜管口吸风控制 步骤 1（定时）（默认为 73）
备注：倾斜管直的时候是否吸风

2. Step lower reverser 2:
Step lower reverser 2 (default 73)

反袜管缩回后吸风量

备注：倾斜管倾斜的时候是否吸风

3. Step lower reverser 3:

Step lower reverser 3 (default 0)

袜子完全吸入反袜管，并在反袜筒摆正以后

备注：倾斜管再次变直的时候是否吸风

4. Step lower reverser 4:

Step lower reverser 4 (default 0)

反袜管向上伸时

备注：倾斜管是否吸风

5. Tilting device up step 5:

Tilting device up step 5 (default 0)

缝头结束以后

备注：缝袜子上管是否吸风，上管连接出袜口

6. Step upper reverser 6:

Step upper reverser 6 (default 0)

把袜子吸出到出布口（未知）

备注：缝袜子上管是否吸风，上管连接出袜口

7. Step upper reverser 7:

Step upper reverser 7 (default 73)

备注：缝袜子上管是否吸风，上管连接出袜口

隐藏部分：

1. Valve lower reverser 1:

Valve lower reverser 1 (default A), [L, R, A]



.....

2. Movement index 1:

Movement index 1:

.....

Insert/Modify Item


External Closed Toe


Degree

Default degree



Status
Subgroup

Type of stitching: 1 Number of pins at start (=end) per type of seaming 3: 1 Stitching speed: 300 Type


Dato	Parameter	Value
<input type="checkbox"/>	Type of fabric:	1
<input type="checkbox"/>	Number of fabric points prior to cutting:	1
<input type="checkbox"/>	Shifting of pin-holding unit in tenths of a degree:	1
<input type="checkbox"/>	Enabling fabric strokes after cutting:	0
<input type="checkbox"/>	Number of fabric strokes after cutting:	1

Main data
Suction
Fabric data
Size 1
Size 2
Size 3
Size 4
Size 5
Size 6
Size 7
Size 8

Step	Status	Degree	Data

 Find
☒ Modify
 Insert

☐ Show only changed data

 Help

Fabric data

备注：以下数据 主要控制缝纫机线头长短

1. Type of fabric:

Choice of fabric type (default 1)

[0]=Programmable

[1]=16 stitches; 10 Tenth of degree

[2]= 7 stitches; 22 Tenth of degree

织物类型:

织物类型的选择（默认 1）

[0]=可编程

[1]= 16 针;10 十度

[2]= 7 针;22 十度

备注：0 时候之后两个菜单可选

1 默认 16 针，两头长度

2 默认 7 针 两头长度

2. Number of fabric points prior to cutting:

Number of fabric points prior to cutting (only for fabric type 0) [min.1 - max.30]

切割前织物点的数量：

切割前的织物点的数量（仅适用于织物的 0）分钟。1 - max.30]

备注：可编程长度（根据第一菜单选择 0 时使用），超过最后一针后缝纫多少针后裁剪（剪刀工作）

3. Shifting of pin-holding unit in tenths of a degree:

Shifting of pin-holding unit in tenths of a degree (only for fabric type 0) [min.1 - max.30]

在十分之一程度上把针握单位移到：

将针具单位移到十分之一的程度（仅适用于织物类型 0）。1 - max.30]

备注：可编程长度（根据第一菜单选择 0 时使用），两对齿旋转的角度，转多少角度停止

以上两个菜单关联公式 $X2$ (以上 2 菜单针数)， $X3$ (以上 3 菜单角度除以 10)：

$X2 \cdot X3 / 10 = 13^\circ$ 到 20° 角度之间

可翻转套刺，最少旋转角度 13 最大 20 度；

针数(以上 2 菜单针数)，和每次跳动角度(以上 3 菜单角度除以 10)，的积要在两角度之间即 130 到 200 之间

4. Enabling fabric strokes after cutting:

Enabling fabric strokes after cutting (default 0) [0]=Disabled, [1]=Enabled

切割后的织物笔划:

在切割后启用织物笔画（默认 0）0=禁用，1=启用

备注：0 时候不使用下一个菜单选项长度（袜子缝合结束后不缝纫）

1 时候使用下一个菜单选项长度（袜子缝合结束后缝纫多少针为了下一只袜子开始长度）

5. Number of fabric strokes after cutting:



Number of fabric strokes after cutting [min.1 - max.30]

切割后织物的数量:

切割后的织物笔画数。1 - max.30]

备注：切割后预留给下一只袜子的长度（根据上一个菜单的选项选择 1 时候才有效）

Insert/Modify Item


External Closed Toe


Degree

Default degree




Status
Subgroup

Type of stitching: 1 Number of pins at start (=end) per type of seaming 3: 1 Stitching speed: 300 Type







Dato	Parameter	Value
<input type="checkbox"/>	Size 1 - Tilting device down delay time 1:	0
<input type="checkbox"/>	Size 1 - Turning device inclination:	3200
<input type="checkbox"/>	Size 1 - Turning device tube outlet:	2000
<input type="checkbox"/>	Size 1 - Tilting device inclination stage:	0
<input type="checkbox"/>	Size 1 - Programmed with sock-ejection air blow:	0
<input type="checkbox"/>	Size 1 - Air blast enable Welt:	1
<input type="checkbox"/>	Size 1 - Angular arm approaching step at end of ejection:	0

Main data
Suction
Fabric data
Size 1
Size 2
Size 3
Size 4
Size 5
Size 6
Size 7
Size 8

Step	Status	Degree	Data

 Find
 Modify
 Insert

☐ Show only changed data

 Help
 Update
 Add
 Find
 Replace...
 Delete

Size 1

1. Tilting device down delay time 1:

Tilting device down delay time 1 (default 0 seconds) [From 0 to 10]

倾斜设备延迟时间 1:

反袜管倾斜时间 1（默认 0 秒）从 0 到 10

备注：缝头部分下部分，倾斜管后停留多长时间

2. Turning device inclination:

Turning device inclination measured by steps [From 0 to 3244]



倾斜角度 最好少于 1600（新电控数值可以加大，具体数值可以尝试）

3. Turning device tube outlet:

Turning device tube outlet measured by steps [From 0 to 2165]

管子伸出距离 最好不要超过 600（新电控数值可以加大，具体数值可以尝试）

4. Tilting device inclination stage:

[0] =Normal stage, [1]=Advanced stage, [2]=Early phase without control

备注：0 爪盘从织针处，移出来后，倾斜管开始倾斜，所以以上两个数值可用

1 是软件默认值，先倾斜管子，出管子，再移动爪盘（默认值）不会碰撞机器

2 倾斜管与中间吸风管还有爪盘移动顺序一样，但是出来角度可以修改菜单 2 和菜单 3 可用

注意：通常用 0 或 2，用 2 时候要小心碰撞（下面管子与爪盘碰撞）

5. Programmed with sock-ejection air blow:

Programmed with sock-ejection air blow (default 0), [0]=Blower enabled, [1]=Blower disabled

备注：哈弗盘垂直向下，最底下有个喷嘴（有机玻璃管下方转弯处），吹不吹风，不能控制什么时间吹，只能选择用不用，一般在移出袜子时候使用

6. Air blast enable Welt:

Air blast enable Welt (default 1), [0]=Blower enabled, [1]=Blower disabled

备注：完美机器没有

7. Angular arm approaching step at end of ejection:

Size 1 - Angular arm approaching step at end of ejection (default 0) [From 0 to 500]

备注：这个数值越大，爪盘移动越接近设定零位时候停顿一下 比如设置 250 的时候，爪盘会在中间停顿一下

这个功能是帮助中等长度袜子，被下面管子吸进去。长的短的袜子，都方便被吸进去，一种中等长度的袜子不宜被吸进去

Grams YOYO - Reset machine

解释：机器重置时候 YOYO 的值

YOYO weight in grams in machine Reset mode

Grams YOYO - Zeroing machine

解释：机器按 F0 时候 YOYO 的值

Yarn weight of YOYO in procedure zeroing machine

Yarn parameter for YOYO motors

NULL=machine SETUP parameters - From 1 to 20 see YOYO motor specifications manual

解释：



Yarn parameter control for YOYO motors

此菜单主要功能是定义 YOYO 纱线弹性种类

- 1、棉纱类弹性的纱线
- 2、尼龙类一点点弹性的纱线
- 3、裸氨类高弹性的纱线
- 4、梭子为了，有花型变化的纱线
-没有使用

四、三角

[1] Dial-jacks enter, pos.1	280 +/- 哈夫针收 半位
[2] Dial-jacks enter, pos.2	130 +/- 哈夫针收 全位
[5] Dial jacks exit, pos. 1	230 +/- 哈夫针出 半位
[6] Dial jacks exit, pos. 2	90 +/- 哈夫针出 全位
[8] Return dial jack welt pattern phase	140 +/- 哈夫针进（添纱时用）
[10] Eliminates elastic selectors	橡筋 下拉三角（在主口提花针下方）
[11] Eliminate jacks feed 1	第一路下拉三角（在色纱提花针下方）
[17] Eliminate piker rising needles heel/toe stitch cam	140 +/- 挑针头（在返转 三角上）
[18] Eliminate piker rising needles 1st feed stitch cam	挑针头（主口成圈三角上）
[19] Dropper on the right	240 +/- 右撇针
[20] Dropper on the left	200 +/- 左撇针
[21] Tuck cam feed 1 Pos. A	70 +/- 第一路集圈三角（右活络头 半）
[22] Tuck cam feed 1 Pos. B	70 +/- 第一路集圈三角（右活络头 全 角度 250）
[26] Stitch cam first feed pos. (B)	270+ 520- 顺车（逆时针）成圈三角
[62] Stitch cam heel/toe pos. (B)	100 +/- 倒车成圈三角 全位.
[64] Lowering needles for elastic Pos. B	210 +/- 橡筋压针三角 1... 全位
[83] Needle lowering cam colour 6	190 +/- 6 号色口压针三角
[84] Raising long butt needles entering heel/toe	260 +/- 头跟超针三角...1（使针退出工作）
[86] Lowering needles cam end of heel	240 +/- 头跟压针三角..1.（退出打跟时用）
[97] Raise fabric close toe	关闭脚趾头升针
[99] Routine dropper jacquard on the right	压针右信号
[100] Routine dropper jacquard on the left	压针左信号
[106] Cam rise needles heel/toe return swing Pos. A	215 +/- 头跟往复起针三角（左活络头 半.
[107] Cam rise needles heel/toe return swing Pos. B	215 +/- 头跟往复起针三角（左活络头 原角度 35）全.
[206] Cam raising needle color 6	260+ 290- 三角升针 6 号色

五、 功能信号

- [1] ENTER STEPPED HEEL KNITTING 头跟开始
- [2] Exit heel/toe 头跟结束
- [3] Oiler 加油
- [4] End of scaling second half heel 揪针开始头跟
- [5] Sock ejection 吹气打开出袜盖
- [7] Set cylinder swing to 360 degrees 设置针筒倒转 360 度
- [8] Stop machine with F4 inserted 部段停机按 F4 有效
- [9] Enter upper heel knitting 开始高后跟编织
- [10] Code welt start (for 'F0' zero setting dial jacks) 罗口开始信号（保护哈弗针）
- [11] Set over dial jacks end 罗口结束信号（保护哈弗针）
- [14] Start heel for begin Sole Liner sock style part 1 开始后跟为了脚底加固款式第 1 部分
- [15] Begin Sole Liner sock style part 2 开始短脚底加固第 2 部分
- [16] End heel for Sole Liner sock style 结束后跟为了脚底加固款式
- [18] Sock passage abilitation 接收出袜信号
- [19] Sock passage control 关闭出袜信号
- [20] Set over dial jacks end 1x1 转移哈弗针用
- [21] 1x1 selection begin Sole Liner sock style part 1 选针的脚底加固
- [22] 3x1 selection begin Sole Liner sock style part 1 选针的脚底加固
- [23] Plain selection begin Sole Liner sock style part 1 平纹组织的脚底加固
- [24] 1x1 selection on drum 3 for make-up before welt on first feed
平纹开始的 1×1 选针的脚底加固
- [29] ENTER NARROW HEEL KNITTING 开始小后跟编织
- [30] Enter reverse narrow heel knitting 开始反的小后跟编织
- [31] ENTER REVERSE HEEL KNITTING 开始反袜跟编织
- [32] EXIT REVERSE HEEL KNITTING 结束反袜跟编织
- [39] Make-up selection begin double welt 起口提花，开始双罗口
- [41] Set course heel knitting for ground finger change 交换底梭子的袜跟编织
- [45] Enter stepped reverse heel knitting wide movement 开始反的宽袜跟编织
- [46] Exit reverse heel knitting wide movement 结束反的大后跟编织
- [48] Code to stop pattern in the welt 罗口停止花型
- [49] Code to re-start pattern in the welt 罗口重新启动花型
- [51] ENTER WIDE HEEL KNITTING 开始做大的袜跟、袜头

- [52] EXIT WIDE HEEL KNITTING 结束做大的袜跟、袜头
- [53] Preparation for wide heel exit 准备宽袜跟结束
- [58] Stop yarn cutter saw rotation 停圆盘剪刀转动
- [59] Recovery yarn cutter saw rotation 重起圆盘剪刀转动
- [70] Enable the motor for the variable speed of the saw 起动圆盘剪刀马达
- [71] Stop of the motor for the variable speed of the saw 停止圆盘剪刀马达
- [114] Heel insertion for start of XL insole, part 1 袜跟插入 启动特大鞋垫 ， 部分 1
- [115] Start of XL 2 insole sock 启动特大 2 船袜
- [116] End of heel for XL insole 结束特大船袜
- [146] Exit from heel work for XL insole 从袜跟转移到特大船袜
- [151] Start of sock ejection procedure for seaming 启动袜子喷出程序的编织
- [152] Cylinder stop for normal toe seaming 针筒停止在正常脚趾头编织
- [153] Cylinder stop for reverse toe seaming 针筒停止在反脚趾头编织
- [154] End of sock ejection procedure for seaming 结束袜子喷出程序编织

六、 特殊功能

- [1] Needles latch open 开针器（打勾则退出工作）
- [2] Lower dial 哈夫盘低位
- [3] Sock drop out box stop motion 出袜口盖板闭合感应装置
- [5] Elastic motor 1 start 橡筋输送马达 1
- [6] Elastic motor 2 start 橡筋输送马达 2
- [9] Elastic binder 1 橡筋剪刀 1
- [10] Elastic binder 2 橡筋剪刀 2
- [14] Put knife out of action 抬起剪刀头
- [15] Sinkers extraction for elastic 橡筋眉毛 全出
- [19] Air blowing transfer 扎口转移吹气
- [21] Terry lever feed 1 主口 正转 全毛刀
- [22] Terry lever half cylinder feed 1 主口 正转 半毛刀
- [29] Heel & toe terry lever 反转 全毛刀（低脚和高脚）
- [30] Terry lever for rib feed 1 主口 侧面脚 起毛刀
- [35] Ducking stitch cam first feed 打松三角
- [36] Ducking stitch cam feed 1 intermediate position 第一路打松三角第二位置
- [55] Sinker cap piston 生克罩位置
- [56] Air blast clean sinkers 吹气清洁生克片
- [59] Piston closer throat plate in heel toe feed 1 蝴蝶门
- [61] Heel Toe take-up 1 挑头钢丝
- [62] Heel Toe take-up 2 挑头钢丝
- [63] Heel Toe take-up 3 挑头钢丝
- [64] Heel Toe take-up 4 挑头钢丝
- [66] Needles stop in the back 断针刹车 1 路
- [69] Command stop latches 1 前面第一号感应针舌停车装置 1（打勾则工作）
- [70] Command stop latches 2 前面第一号感应针舌停车装置 2（打勾则工作）
- [76] Turning device position 1 翻袜装置 1 号位置
- [77] Turning device position 2 翻袜装置 2 号位置
- [78] Auxiliary fan for turning device 反袜装置的辅助吸风装置
- [79] Air blower for turning device 反袜装置吹气
- [81] Lycra tension device 1st feed 第一路的莱卡张力装置
- [85] Lycra tension device heel 袜头跟的莱卡张力装置

- [89] Needles latch open 2 2 号开针器 （打勾则进入工作）
- [91] User exit Nr.1 客户自配
- [92] User exit Nr.2 客户自配
- [93] User exit Nr.3 客户自配
- [94] User exit Nr.4 客户自配
- [95] Heel Toe take-up 5 挑头钢丝
- [96] Heel Toe take-up 6 挑头钢丝
- [101] Dropper on the right stop motion 右压针停止工作装置
- [102] Dropper on the left stop motion 左压针停止工作装置
- [108] Sinkers extraction for elastic position 2 橡筋眉毛 半位
- [116] Internal tube position 1 内管位置 1（针筒内铜管）
- [146] Air suction valve 吸风阀门
- [155] Enable Lycra motor 1 氨纶马达 1 启动
- [156] Enable Lycra motor 2 氨纶马达 2 启动
- [188] Disable stop obstructed plato 停用哈夫盘上阻塞感应装置（接近开关）
- [218] Enable stop overturn suction type Solis 启用停止翻转式抽吸式 Solis
- [235] Enable control broken yarn YOYO motor 1
- [236] Enable control broken yarn YOYO motor 2
- [237] Enable control broken yarn YOYO motor 3
- [238] Enable control broken yarn YOYO motor 4
- [261] Lycra binder position A 裸氨位置 A
- [262] Lycra binder position B 裸氨位置 B
- [335] Enable control broken yarn YOYO motor 5
- [336] Enable control broken yarn YOYO motor 6
- [337] Enable control broken yarn YOYO motor 7
- [338] Enable control broken yarn YOYO motor 8
- [371] Enable SUPER POWER motor YOYO 1
- [372] Enable SUPER POWER motor YOYO 2
- [373] Enable SUPER POWER motor YOYO 3
- [374] Enable SUPER POWER motor YOYO 4
- [375] Enable SUPER POWER motor YOYO 5
- [376] Enable SUPER POWER motor YOYO 6
- [377] Enable SUPER POWER motor YOYO 7
- [378] Enable SUPER POWER motor YOYO 8

[381] Additional spandex tensioner 1 附加弹性纤维张力器 1

[382] Additional spandex tensioner 2 附加弹性纤维张力器 2

七、 梭子

Yarnfinger 1 feed 1 主口 1 号纱嘴

Yarnfinger 2 feed 1 主口 2 号纱嘴

Yarnfinger 3 feed 1 主口 3 号纱嘴

Yarnfinger 4 feed 1 主口 4 号纱嘴

Yarnfinger 5 feed 1 主口 5 号纱嘴

Yarnfinger 6 feed 1 主口 6 号纱嘴

Yarnfinger 7 feed 1 主口 7 号纱嘴

Yarnfinger 8 feed 1 主口 8 号纱嘴

Second Position Finger 1 Feed 1 主口 1 号纱嘴 第 2 位置

Second Position Finger 2 Feed 1 主口 2 号纱嘴 第 2 位置

Second Position Finger 3 Feed 1 主口 3 号纱嘴 第 2 位置

Second Position Finger 4 Feed 1 主口 4 号纱嘴 第 2 位置

Second Position Finger 5 Feed 1 主口 5 号纱嘴 第 2 位置

Second Position Finger 6 Feed 1 主口 6 号纱嘴 第 2 位置

Second Position Finger 7 Feed 1 主口 7 号纱嘴 第 2 位置

Second Position Finger 8 Feed 1 主口 8 号纱嘴 第 2 位置

Elastic Finger Feed 1 主口橡筋纱嘴 梭子 0

Second position Elastic Finger Feed 1 主口橡筋纱嘴 梭子 0 第 2 位置

Change position Elastic Finger Feed 1 主口橡筋纱嘴 梭子 0 改变位置

Descrizione per i GUIDAFILI caduta 1 utilizzati per lycra

Yarn finger 1 feed 1 for Spandex 主口梭子 1 为了氨纶

Yarn finger 2 feed 1 for Spandex 主口梭子 2 为了氨纶

Second Position Finger 1 Feed 1 for Spandex 主口梭子 1 第二位置 为了氨纶

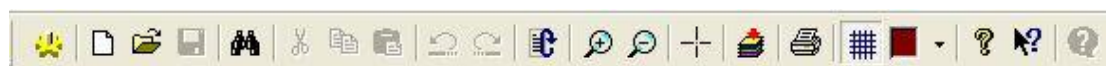
Second Position Finger 2 Feed 1 for Spandex 主口梭子 2 第二位置 为了氨纶

Descrizione per i GUIDAFILI CADUTA 2

Finger 1 elastic feed 橡筋梭子 1

Finger 2 elastic feed 橡筋梭子 2

八、 Photon 画图



1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21

- | | |
|------------|------------------|
| 1 选择机器型号 | 12 放大 |
| 2 新建一个新的花型 | 13 缩小 |
| 3 打开已存的花型 | 14 固定/隐藏相对圆点的坐标 |
| 4 保存花型 | 15 全部平台移动 |
| 5 显示整体的花型 | 16 打印 |
| 6 剪切 | 17 打开或关闭画格 |
| 7 复制 | 18 选择画格颜色 |
| 8 粘贴 | 19 查看绘图软件版本 |
| 9 返前一页 | 20 帮助功能 |
| 10 向后一页 | 21 打开或关闭动画语音提示功能 |
| 11 回到储存之前 | |



1 2 3 4

- | | |
|-----------|-----------|
| 1 整个花型填充 | 3 随意范围内变化 |
| 2 矩形范围内变化 | 4 转换所要范围 |



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

- | | |
|-------------|------------|
| 1 选矩形区域（光标） | 11 填充 |
| 2 不规则区域（光标） | 12 移动相对原点 |
| 3 画笔 | 13 字体 |
| 4 直线 | 14 和图案一起换色 |
| 5 矩形 | 15 闪亮颜色 |
| 6 圆形 | 16 改换颜色 |
| 7 椭圆 | 17 调整图案大小 |
| 8 菱形 | 18 框范围 |
| 9 多点弧线 | 19 图画投影 |
| 10 吸色 | |



1 2 3 4 5 6 7 8 9

- | | |
|-----------|-------------|
| 1 带色框线 | 6 底色透析 |
| 2 用主色填满 | 7 网状图案设计 |
| 3 用底色填满 | 8 在颜色上填充 |
| 4 制作者图案填充 | 9 填充除限定颜色之外 |
| 5 已选图案填充 | |



1 2 3 4 5 6

- | | |
|---------|--------|
| 1 选择字体 | 4 斜体 |
| 2 字体的大小 | 5 加下划线 |
| 3 粗体 | 6 竖直排列 |



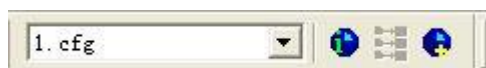
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16

- | | |
|-----------------|------------|
| 1 展示/ 隐藏随意区域控制点 | 9 拉动拷贝 |
| 2 展示/ 隐藏区界 | 10 拉动全面拷贝 |
| 3 左右翻转 | 11 缩放区域 |
| 4 上下翻转 | 12 选择全部针数 |
| 5 区域旋转 | 13 选择全部横列数 |
| 6 水平拖动 | 14 区域内创建图案 |
| 7 上下拖动 | 15 拷贝区域 |
| 8 上下左右拖动 | 16 粘贴区域 |



1 2 3 4 5

- | | |
|---------|--------|
| 1 笔迹粗细 | 4 方形笔头 |
| 2 最细的笔划 | 5 折线 |
| 3 圆形笔头 | |



1 2 3 4

- 1 已存配置
- 2 激活/隐藏 GALOIS INFO
- 3 图案联合颜色

- 4 [设定新的 CFG 功能，到 GALOIS PLUS](#)



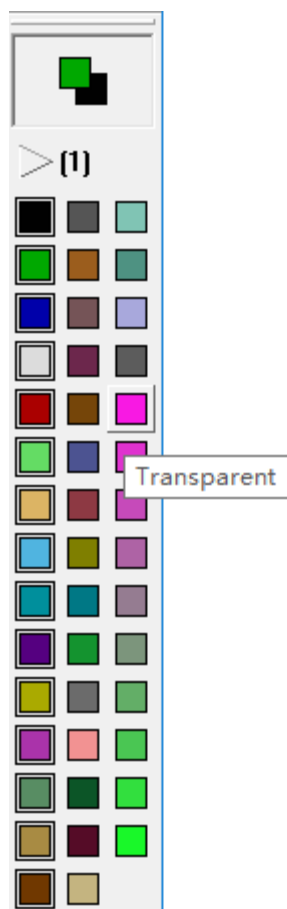
1 2 3

- 1 花型路数
- 2 自动配置路数

- 3 花型交接错位

关于一些隐藏的特别图标：

以下颜色 35 是隐藏的透明颜色图标，但是其他花型打开后没有，只用于叠加花型的编辑中。



九、 配置软件 Configuration



通过花型编辑软件可以跳转到一下菜单

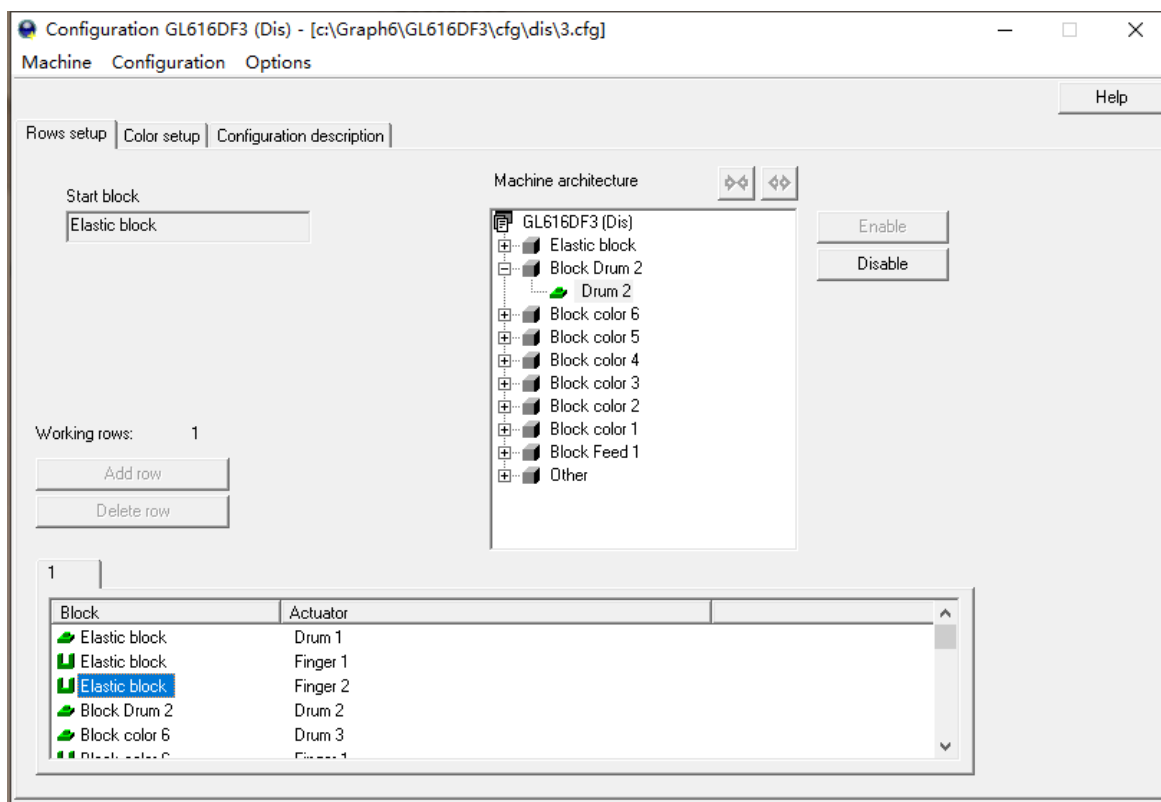
通过 C:\Lonati\Link GR6 D3+\Galois Plus 也可以打开一下软件但是要选择机型，选择配置名字；因

此个人习惯从花型编辑软件中跳转进入

此软件用于配置画图颜色对应什么功能，命令，动作，甚至速度等等

以下以普通花型为例，还有更多种类花型大同小异不一一介绍

1. 普通花型配置



以下说明是默认配置 1.cfg 情况下，上图为配置 3.cfg

Rows setup

查看可以操作的梭子，选针器，速度，功能等
 点击 Machine architecture 内按键选择相应功能加入控制
 Enable 使能
 Disable 禁用

Color setup

Plane Drums

颜色对应选针器

Yarnfingers and Stitch Cams

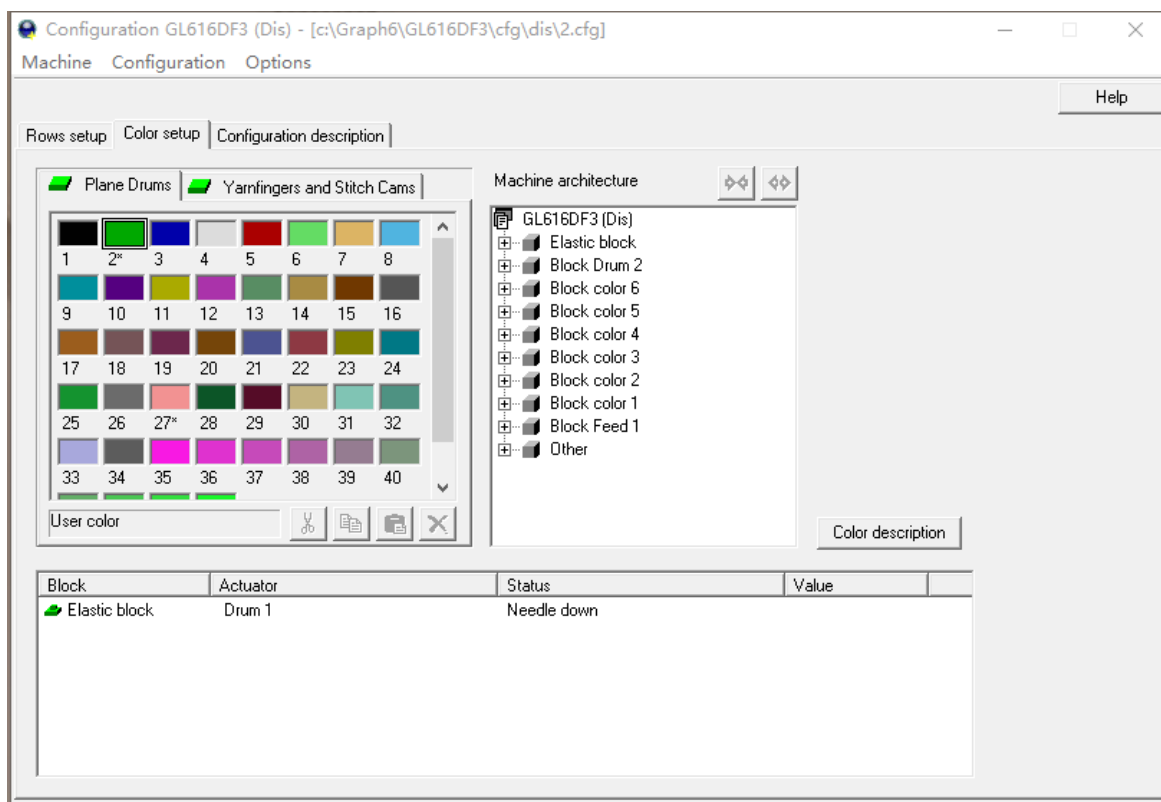
颜色对应梭子和功能



Configuration description

配置描述

2. 普通花型配置 2.cfg 对应橡筋花型



以下说明是默认配置 2.cfg 情况下，上图截自橡筋花型默认配置 2.cfg

Rows setup

查看可以操作的只有 1 号选针器

Color setup

Plane Drums

2 号色：绿色对应针不起来 27 号色：肤色对应橡筋织针起来勾线

Yarnfingers and Stitch Cams

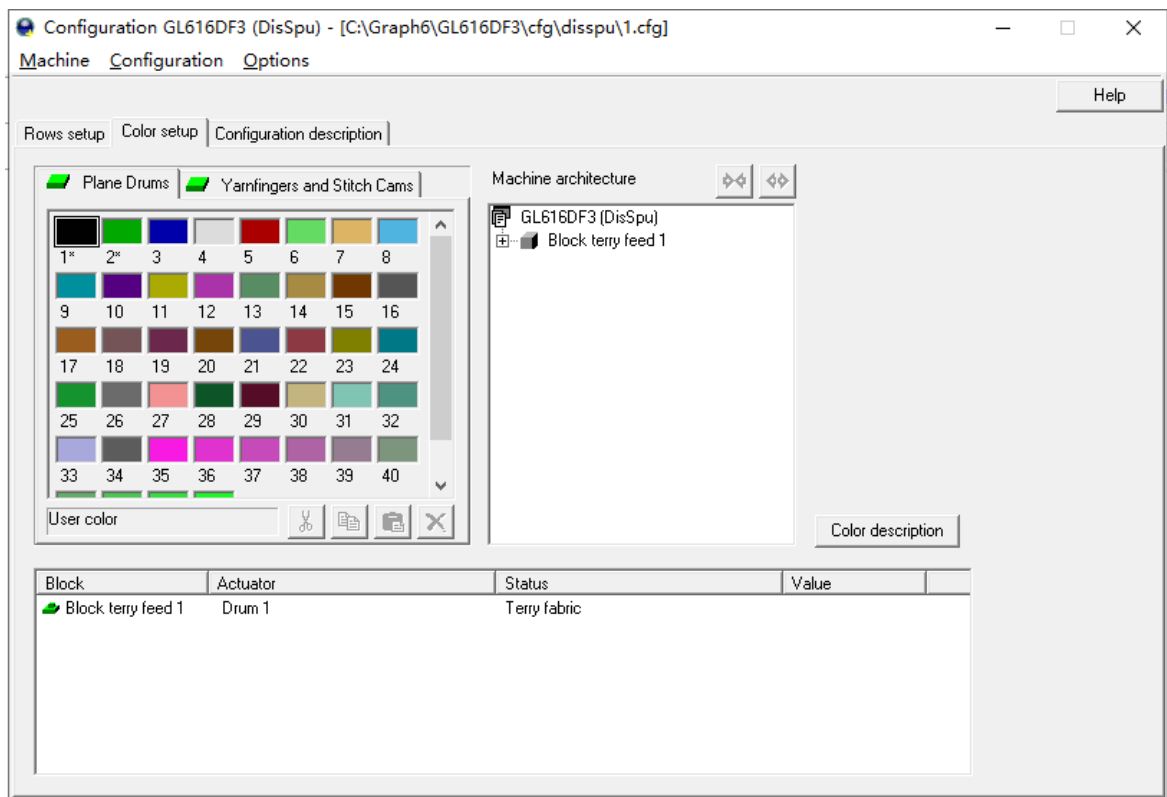
在这个 GL616DF3 机型配置 2.cfg 中没有作用



Configuration description

配置描述

3. 袜跟毛圈花型配置



以下说明是袜跟毛圈花型默认配置 1.cfg 情况下

Rows setup

查看可以操作的只有毛圈选针器

Color setup

Plane Drums

1 号色对应毛圈；2 号色：绿色对应平纹；其他颜色没有作用

Yarnfingers and Stitch Cams

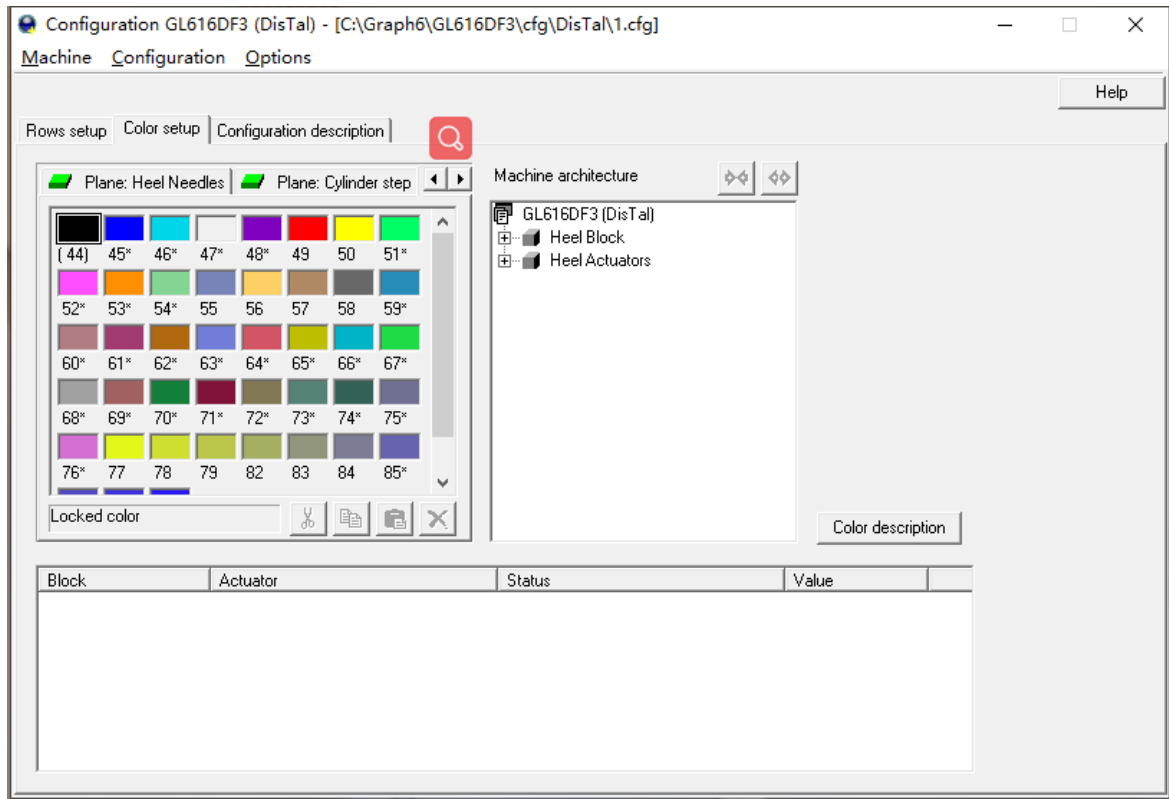
在这个 GL616DF3 机型配置 2.cfg 中，此处颜色没有作用



Configuration description

配置描述

4. 袜跟花型



以下说明是袜跟花型默认配置 1.cfg 情况下

Rows setup

查看可以操作的梭子，选针器，速度，功能等
不可修改

Color setup

Plane: Heel Needles

4 号色对应起针范围
10 号色对应不起针范围

Plane: Cylinder step

0 号色：没有说明
40 号色：[19] Dropper on the right (IN)
41 号色：[19] Dropper on the right (OUT)



42 号色: [20] Dropper on the left (IN)

43 号色: [20] Dropper on the left (OUT)

80 号色: 没有说明

81 号色: Heel limits 旋转极限, 换行反转位置

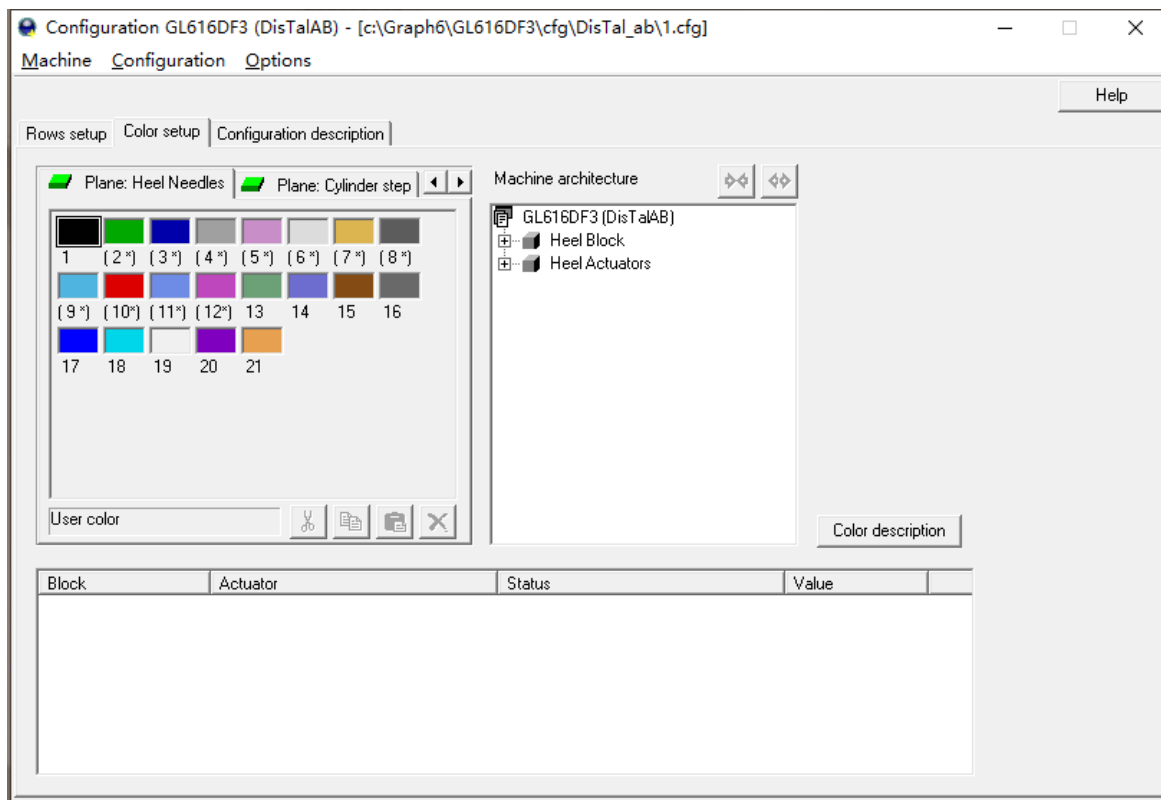
Plane: Heel drums

颜色对应各种功能的开和关, 梭子开和关, 不做介绍

Configuration description

配置描述

5. 低针袜跟花型



以下说明是低针袜跟花型默认配置 1.cfg 情况下

Rows setup

查看可以操作的梭子，选针器，速度，功能等
不可修改

Color setup

Plane: Heel Needles

2 号色: Needle up (T1, T10)

3 号色: Needle up (T1, T10)

4 号色: Needle up (T1, T10)

5 号色: Needle up (T1, T10)

6 号色: Clearing (Needle up T2,T9 ; Needle down T3,T4,T5,T6,T7,T8)清针

7 号色: Tuck-stitch (Needle up T2, ; Needle down T3,T4,T5,T6,T7,T8,T9) 集圈

8 号色: Float stitch(Needle down T2,T3,T4,T5,T6,T7,T8,T9)浮线编织

9 号色: Heel needles raising Drum 1(Needle up T1)

10 号色: Heel needles raising Drum 10(Needle up T10)

11 号色: Jacquard 1(Needle up T1, T10)提花

12 号色: Jacquard 2(Needle up T1, T10)提花

13 号色: 无用

14 号色: 无用

15 号色: 无用

16 号色: 无用

17 号色: 无用

18 号色: 无用

19 号色: 无用

20 号色: 无用

21 号色: 无用

Plane: Cylinder step

0 号色: 没有说明

40 号色: [19] Dropper on the right (IN)

41 号色: [19] Dropper on the right (OUT)

42 号色: [20] Dropper on the left (IN)

43 号色: [20] Dropper on the left (OUT)

80 号色: 没有说明

81 号色: Heel limits 旋转极限, 换行反转位置

82 号色: Heel dimension 袜跟范围

92 号色: [18] Eliminate piker rising needles 1st feed stitch cam (IN) 挑针器工作

93 号色: [18] Eliminate piker rising needles 1st feed stitch cam (OUT) 挑针器退出

94 号色: [17] Eliminate piker rising needles heel/toe stitch cam (IN)挑针器工作

95 号色: [17] Eliminate piker rising needles heel/toe stitch cam (OUT)挑针器退出

96 号色: Pattern suspension position 花型停止位置

Plane: Heel drums

颜色对应各种功能的开和关, 梭子开和关, 不做介绍

Plane: Terry

22 号色: 无用

23 号色: 平纹

24 号色: 起毛



Configuration description

配置描述

十、 选款内容

3D_WM163MC901.FAC	3D END FOR ROSSO PLAIN FABRIC 3D 袜跟结束 ROSSO 平纹织物
3D_WM163MC902.FAC	3D END FOR LINKING PLAIN FABRIC 3D 袜跟结束 LINKING 平纹织物
3D_WM163MC903.FAC	3D END FOR LINKING+ROSSO PLAIN FABRIC 3D 袜跟结束 LINKING+ROSSO 平纹织物
3D_WM163MC904.FAC	3D END FOR ROSSO TERRY 3D 袜跟结束 ROSSO 毛圈织物
3D_WM163MC905.FAC	3D END FOR LINKING TERRY 3D 袜跟结束 LINKING 毛圈织物
3D_WM163MC906.FAC	3D END FOR LINKING+ROSSO TERRY 3D 袜跟结束 LINKING+ROSSO 毛圈织物
3D_WM163MC970.FAC	3D END AUTOM.STANDARD SEAMING TERRY 3D 袜跟结束 自动标准缝合毛圈
3D_WM163MC970_A.FAC	3D END AUTOM.STANDARD SEAMING TERRY 2 3D 袜跟结束 自动标准缝合毛圈 2
3D_WM163MC971.FAC	3D END AUTOM.STANDARD SEAMING PLAIN 3D 袜跟结束 自动标准缝合平纹
3D_WM163MC971_A.FAC	3D END AUTOM.STANDARD SEAMING PLAIN 2 3D 袜跟结束 自动标准缝合平纹 2
3D_WM163MC980.FAC	3D END AUTOM.REVERSE SEAMING TERRY 3D 袜跟结束 自动反的缝合毛圈
3D_WM163MC980_A.FAC	3D END AUTOM.REVERSE SEAMING TERRY 2 3D 袜跟结束 自动反的缝合毛圈 2
3D_WM163MC981.FAC	3D END AUTOM.REVERSE SEAMING PLAIN 3D 袜跟结束 自动反的缝合平纹
3D_WM163MC981_A.FAC	3D END AUTOM.REVERSE SEAMING PLAIN 2 3D 袜跟结束 自动反的缝合平纹 2
END.FAC	END 结束
START.FAC	START 开始

WM163_001.FAC	DOUBLE WELT 1F BEGIN NYLON AND PATTERN 双罗口，1 路开始尼龙和花型
WM163_002.FAC	DOUBLE WELT 1F WITH PICOT AND PATTERN 双罗口，1 路配牙边和花型
WM163_003.FAC	ROLL-TOP 反罗口 一格一橡筋口
WM163_004.FAC	SHORT DOUBLE WELT 1 FEED 短双罗口 1 路（高橡筋运动袜）
WM163_005.FAC	PLAIN DOUBLE WELT ELASTIC AT END 平纹双罗口（开始无橡筋）
WM163_006.FAC	DOUBLE WELT 1 FEED 双罗口 1 路
WM163_007.FAC	DOUBLE WELT 1F WITH ELASTIC BEGIN 双罗口 1 路扎口配橡筋开始内口无橡筋+罗口
WM163_008.FAC	SINGLE WELT 1F 单罗口 1 路
WM163_009.FAC	TURNED DOUBLE WELT WT PATTERN AND PICOT 双罗口开始平纹+花边+平纹+橡筋
WM163_021.FAC	LOADING DIAL FOR TERRY TOE 下沉机头做毛圈袜头
WM163_022.FAC	LOADING DIAL FOR PLAIN TOE 下沉机头做平纹袜头
WM163_031.FAC	DOUBLE WELT WITH HEEL TERRY 1F 双罗口配毛圈袜跟 1 路（往复跟罗口毛圈）
WM163_032.FAC	DOUBLE WELT WITH HEEL PLAIN 1F 双罗口配平纹袜跟 1 路（往复跟罗口平纹）
WM163_041.FAC	DOUBLE WELT WITH SMALL HEEL TERRY 双罗口配小型毛圈袜跟（往复跟罗口小型毛圈）
WM163_042.FAC	DOUBLE WELT WITH SMALL HEEL PLAIN 双罗口配小型平纹袜跟（往复跟罗口小型平纹）
WM163_051.FAC	DOUBLE WELT WITH TERRY REVERSE HEEL 双罗口配反毛圈袜跟
WM163_052.FAC	DOUBLE WELT WITH PLAIN REVERSE HEEL 双罗口配反平纹袜跟
WM163_061.FAC	TERRY SMALL REVERSE HEEL IN WELT 罗口配小反毛圈袜跟

WM163_062.FAC	PLAIN SMALL REVERSE HEEL IN WELT 罗文配小反平纹袜跟
WM163_101.FAC	TRANSFER WITHOUT PATTERN FOR TERRY 由 1 路双罗口转毛圈上统
WM163_103.FAC	TERRY LEG 1F FROM ROLL-TOP 由反罗口转 1 路毛圈上统
WM163_104.FAC	LEG IN TERRY 1F FROM SHORT DOUBLE WELT 由短双罗口转 1 路橡筋+毛圈上统（运动袜）
WM163_106.FAC	TRANSFER WITHOUT PATTERN FOR ELAS.+TERRY 由双罗口转毛圈上统+橡筋（没有花型）
WM163_108.FAC	LEG IN TERRY 1F FROM SINGLE WELT 由单罗口转 1 路毛圈上统
WM163_121.FAC	TRANSFER WITHOUT PATTERN FOR ELASTIC 由双罗口转橡筋上统（没有花型）
WM163_123.FAC	ELASTIC LEG 1F FROM ROLL-TOP 由反罗口转 1 路橡筋上统
WM163_124.FAC	ELASTIC LEG 1F FROM SHORT WELT 1 FEED 由 1 路短罗口转橡筋上统
WM163_128.FAC	ELASTIC LEG 1F FROM SINGLE WELT 1F 由单罗口转 1 路橡筋上统
WM163_133.FAC	TERRY LEG + ELASTIC FROM ROLL-TOP 由反罗口转毛圈上统+橡筋
WM163_134.FAC	LEG IN TERRY 1F + ELAS. FROM SHORT WELT 由短罗口转上统带毛圈+橡筋
WM163_138.FAC	TERRY LEG + ELASTIC FROM SINGLE WELT 由单罗口转毛圈上统+橡筋
WM163_151.FAC	TRANSFER WITHOUT PATTERN FOR PLAIN 由双罗口转 1 路平纹上统（没有花型）
WM163_153.FAC	PLAIN LEG 1F FROM ROLL-TOP 由反罗口转平纹上统
WM163_154.FAC	PLAIN LEG 1F FROM SHORT WELT 1 FEED 由短罗口转平纹上统
WM163_158.FAC	PLAIN LEG 1F FROM SINGLE WELT 由单罗口转平纹上统
WM163_161.FAC	TRANSFER WITHOUT PATTERN FOR MEDICAL 由 1 路双罗口转平纹医疗上统（没有花型）

WM163_163.FAC	MEDICAL LEG FROM ROLL-TOP 由反罗口转医疗上统
WM163_164.FAC	PLAIN MEDICAL LEG FROM SHORT DOUBLE WELT 由短双罗口转平纹医疗上统
WM163_168.FAC	PLAIN MEDICAL LEG FROM SINGLE WELT 由单路口转平纹医疗上统
WM163_190.FAC	LEG WITH GRADUATIONS 修匀上统（长统袜）
WM163_191.FAC	LEG WITH GRADUATIONS 修匀上统（长统袜）
WM163_192.FAC	LEG 腿
WM163_201.FAC	END ELASTIC LEG 1F FOR TERRY 1F 结束橡筋上统开始毛圈
WM163_210.FAC	TERRY LEG 1F FROM PLAIN LEG 1F 由平纹上统转毛圈上统
WM163_231.FAC	ELASTIC BAND 1 FEED 1 路橡筋
WM163_301.FAC	HEEL IN TERRY 毛圈袜跟
WM163_302.FAC	SECTION "Y" Y 跟
WM163_303.FAC	BEGIN HEEL FROM LEG IN TERRY 1F + ELAS. 由上统带毛圈+橡筋转袜跟
WM163_304.FAC	BEGIN REVERSE TERRY HEEL 开始反毛圈袜跟
WM163_305.FAC	BEGIN REVERSE HEEL FROM TERRY LEG + ELAS 由毛圈上统+橡筋开始反袜跟
WM163_311.FAC	HIGH HEEL TERRY 高跟毛圈
WM163_312.FAC	HIGH HEEL TERRY + ELASTIC 高跟毛圈+橡筋
WM163_321.FAC	WIDE HEEL FROM TERRY LEG 1F 由毛圈上统转大袜跟
WM163_323.FAC	WIDE HEEL FROM TERRY LEG + ELASTIC 由毛圈上统转大袜跟+橡筋
WM163_324.FAC	BEGIN REVERSE WIDE HEEL TERRY 开始反毛圈大袜跟

WM163_325.FAC	BEGIN REVERSE WIDE HEEL TERRY + ELA. 开始反毛圈大袜跟+橡筋
WM163_351.FAC	BEGIN HEEL FROM PLAIN LEG 1F 由平纹上统开始袜跟
WM163_352.FAC	WIDE HEEL FROM PLAIN LEG 1F 由平纹上统开始宽袜跟
WM163_353.FAC	BEGIN HEEL FROM PLAIN MEDICAL LEG 由平纹医疗上统开始袜跟
WM163_354.FAC	BEGIN REVERSE PLAIN HEEL 开始反平纹袜跟
WM163_355.FAC	BEGIN REVERSE HEEL MEDICAL 开始反医疗袜跟
WM163_356.FAC	MEDICAL WIDE HEEL 医疗袜宽袜跟
WM163_371.FAC	HIGH HEEL 高跟
WM163_372.FAC	HIGH HEEL MEDICAL 医疗袜高跟
WM163_374.FAC	BEGIN REVERSE WIDE HEEL PLAIN 开始反平纹大袜跟
WM163_375.FAC	BEGIN REVERSE WIDE HEEL MEDICAL 开始反医疗大袜跟
WM163_401.FAC	END OF HEEL FOR FOOT IN TERRY 1F 结束袜跟开始毛圈袜底
WM163_404.FAC	END OF REVERSE HEEL TERRY 结束反毛圈袜跟
WM163_405.FAC	END OF REVERSE HEEL FOR TERRY + ELASTIC 结束反袜跟开始毛圈+橡筋
WM163_411.FAC	END OF HEEL FOR FOOT IN TERRY 1F + ELAS. 结束袜跟开始毛圈袜底+橡筋
WM163_421.FAC	END OF WIDE HEEL TERRY 结束大毛圈袜跟
WM163_423.FAC	END OF WIDE HEEL TERRY + ELA. 结束大毛圈袜跟+橡筋
WM163_424.FAC	END OF REVERSE WIDE HEEL TERRY 结束反大毛圈袜跟

WM163_425.FAC	END OF REVERSE WIDE HEEL TERRY + ELA. 结束反大毛圈袜跟+橡筋
WM163_451.FAC	END OF HEEL FOR PLAIN FOOT 1F 结束袜跟开始平纹袜底
WM163_452.FAC	END OF WIDE HEEL PLAIN 1F 结束宽袜跟开始平纹袜底
WM163_453.FAC	END OF HEEL AND PLAIN MEDICAL FOOT 结束袜跟开始平纹医疗袜底
WM163_454.FAC	END OF REVERSE HEEL PLAIN 结束反平纹袜跟
WM163_455.FAC	END OF REVERSE HEEL MEDICAL 结束反医疗袜跟
WM163_456.FAC	END OF WIDE HEEL AND PLAIN MEDICAL FOOT 结束宽袜跟开始平纹医疗袜底
WM163_474.FAC	END OF REVERSE WIDE HEEL PLAIN 结束反平纹宽袜跟
WM163_475.FAC	END OF REVERSE WIDE HEEL MEDICAL 结束反医疗宽袜跟
WM163_501.FAC	FOOT 脚底
WM163_601.FAC	BEGIN TOE FROM FOOT IN TERRY 1F 由袜底开始袜尖（过桥）
WM163_651.FAC	BEGIN TOE FROM PLAIN FOOT 1F 从平纹袜底开始袜尖
WM163_652.FAC	BEGIN TOE FROM MEDICAL FOOT 从医疗袜底开始袜尖
WM163_700.FAC	CIRCULAR TOE FROM FOOT IN TERRY 1F 从毛圈袜底到圆形袜尖
WM163_701.FAC	STANDARD TERRY TOE 标准毛圈脚趾头
WM163_705.FAC	TERRY STANDARD "R" TOE 标准毛圈 右脚趾头
WM163_706.FAC	TERRY STANDARD "L" TOE 标准毛圈 左脚趾头
WM163_711.FAC	TERRY REVERSE TOE 毛圈反的脚趾头

WM163_715.FAC	TERRY REVERSE "L" TOE 毛圈 反 左脚趾头
WM163_716.FAC	TERRY REVERSE "R" TOE 毛圈 反 右脚趾头
WM163_731.FAC	TERRY TOE WITH DIAL TRANSFER AND ROSSO 哈弗针退了（021 配合）毛圈盲缝
WM163_750.FAC	CIRCULAR TOE FROM PLAIN FOOT 1F 1 路平纹圆形袜头（没有袜头，平板的）
WM163_751.FAC	PLAIN STANDARD TOE 平纹标准脚趾头
WM163_755.FAC	PLAIN STANDARD "R" TOE 平纹标准右脚趾头
WM163_756.FAC	PLAIN STANDARD "L" TOE 平纹标准左脚趾头
WM163_761.FAC	PLAIN REVERSE TOE 平纹反脚趾头
WM163_765.FAC	"L" REVERSE PLAIN TOE 平纹反 左脚趾头
WM163_766.FAC	"R" REVERSE PLAIN TOE 平纹反 右脚趾头
WM163_771.FAC	PLAIN TOE WITH DIAL TRANSFER AND ROSSO 平板袜头 来自哈弗盘转移 和罗速
WM163_801.FAC	DOUBLE WELT END SOCK FROM TERRY 1F 从 1 路毛圈开始双罗口结束袜子，用哈弗针扎口的下罗口毛圈
WM163_802.FAC	DOUBLE WELT END SOCK FROM TERRY+ELAS 毛圈橡筋 转移双罗口结束
WM163_811.FAC	END SOCK ROLL-TOP FROM TERRY 1F 有下罗口的针扎口
WM163_812.FAC	END SOCK ROLL-TOP FROM TERRY + ELASTIC 有下罗口有毛圈+橡筋
WM163_851.FAC	DOUBLE WELT END SOCK FROM PLAIN 1F 平板罗口结束了（有哈弗针）
WM163_852.FAC	DOUBLE WELT END SOCK FROM MEDICAL 平板罗口结束自医疗袜
WM163_861.FAC	END SOCK ROLL-TOP FROM PLAIN 1F

	平板转移一格一反罗口结束
WM163_862.FAC	END SOCK ROLL-TOP FROM MEDICAL
	医疗袜转移一格一反罗口结束
WM163_901.FAC	ROSSO FOR STANDARD PLAIN
	ROSSO 来自标准平纹袜跟
WM163_902.FAC	LINKING LINE FOR STANDARD PLAIN
	LINKING LINE 来自标准平纹袜跟
WM163_903.FAC	LINKING LINE+ROSSO FOR STANDARD PLAIN
	LINKING LINE+ROSSO 来自标准平纹
WM163_904.FAC	ROSSO FOR STANDARD TERRY
	ROSSO 来自标准毛圈袜跟
WM163_905.FAC	LINKING LINE FOR STANDARD TERRY
	来自标准平纹来自标准毛圈袜跟
WM163_906.FAC	LINKING LINE+ROSSO FOR STANDARD TERRY
	来自标准平纹+ROSSO 来自标准毛圈袜跟
WM163_921.FAC	ROSSO FOR REVERSE PLAIN
	ROSSO 来自标准反的平纹袜跟
WM163_922.FAC	LINKING LINE FOR REVERSE PLAIN
	LINKING LINE 来自反的平纹袜跟
WM163_923.FAC	LINKING LINE+ROSSO FOR REVERSE PLAIN
	LINKING LINE+ROSSO 来自反的平纹袜跟
WM163_924.FAC	ROSSO FOR REVERSE TERRY
	ROSSO 来自反的毛圈袜跟
WM163_925.FAC	LINKING LINE FOR REVERSE TERRY
	LINKING LINE 来自反的毛圈袜跟（LINKING LINE 这个单词像是手 工对目）
WM163_926.FAC	LINKING LINE+ROSSO FOR REVERSE TERRY
	LINKING LINE+ROSSO 来自反的毛圈袜跟
WM163_950.FAC	SOCK RELEASE WITHOUT TURNING DEVICE
	出袜不用反裤装置
WM163_951.FAC	SOCK RELEASE FOR TURNING DEVICE AND FAN
	出袜用反袜装置和风机
WM163_952.FAC	SOCK REL. TURNING DEVICE CENTRAL VACUUM
	出袜用反袜装置和中央吸风
WM163_970.FAC	AUTOMATIC STANDARD TOE SEAM TERRY

自动标准脚趾头缝合毛圈

WM163_970_A.FAC	AUTOMATIC STANDARD TOE SEAM TERRY 2 自动标准脚趾头缝合毛圈 2
WM163_971.FAC	AUTOMATIC STANDARD TOE SEAM PLAIN 自动标准脚趾头缝合平纹
WM163_971_A.FAC	AUTOMATIC STANDARD TOE SEAM PLAIN 2 自动标准脚趾头缝合平纹 2
WM163_972.FAC	AUTOMATIC CIRCULAR TOE SEAM 自动圆形脚趾头缝合
WM163_972_A.FAC	AUTOMATIC CIRCULAR TOE SEAM 2 自动圆形脚趾头缝合 2
WM163_980.FAC	AUTOMATIC REVERSE TOE SEAM TERRY 自动反的脚趾头缝合毛圈
WM163_980_A.FAC	AUTOMATIC REVERSE TOE SEAM TERRY 2 自动反的脚趾头缝合毛圈 2
WM163_981.FAC	AUTOMATIC REVERSE TOE SEAM PLAIN 自动反的脚趾头缝合平纹
WM163_981_A.FAC	AUTOMATIC REVERSE TOE SEAM PLAIN 2 自动反的脚趾头缝合平纹 2
WM163_SC301.FAC	HEEL SOLE LINER TERRY 1^ HALF 跟脚底船袜 毛圈 半
WM163_SC303.FAC	HIGH HEEL SOLE LINER TERRY 1^ HALF 高跟脚底船袜 毛圈 半
WM163_SC351.FAC	HEEL SOLE LINER PLAIN 1^ HALF 跟脚底船袜 平纹 半
WM163_SC353.FAC	HIGH HEEL SOLE LINER PLAIN 1^ HALF 高跟脚底船袜 平纹 1 半
WM163_SC401.FAC	HEEL SOLE LINER PLAIN 2^ HALF 跟脚底船袜 平纹 1 半
WM163_SC403.FAC	HIGH HEEL SOLE LINER TERRY 2^ HALF 高跟脚底船袜 毛圈 2 半
WM163_SC451.FAC	HEEL SOLE LINER PLAIN 2^ HALF 跟脚底船袜 平纹 2 半
WM163_SC453.FAC	HIGH HEEL SOLE LINER PLAIN 2^ HALF 高跟脚底船袜 平纹 2 半
WM163_SC501.FAC	TERRY SOLE LINER WITH ELASTIC

毛圈船袜具有橡筋

WM163_SC551.FAC	PLAIN SOLE LINER WITH ELASTIC 平纹船袜具有橡筋
WM163_SC701.FAC	TOE SOLE LINER TERRY 1^ HALF 脚趾头船袜毛圈 1 半
WM163_SC751.FAC	TOE SOLE LINER PLAIN 1^ HALF 脚趾头船袜平纹 1 半
WM163_SC851.FAC	TOE 1^ HALF 脚趾头 1 半
WM163_SC852.FAC	TOE 2^ HALF 脚趾头 2 半
WM163_SC854.FAC	LONG TOE FOR SOLE LINER 长脚趾头来自船袜
WM163_SC901.FAC	TOE SOLE LINER TERRY 2^ HALF 脚趾头船袜毛圈 2 半
WM163_SC951.FAC	HEEL SOLE LINER PLAIN 2^ HALF 脚趾头船袜平纹 2 半
WM163_TD101.FAC	TRANSFER WITH PATTERN FOR TERRY 出袜用反袜装置和中央吸风
WM163_TD106.FAC	TRANSFER WITH PATTERN FOR ELAS.+TERRY 哈弗针转移后花型有毛圈有橡筋
WM163_TD121.FAC	TRANSFER WITH PATTERN FOR ELASTIC 哈弗针转移后有橡筋花型
WM163_TD151.FAC	TRANSFER WITH PATTERN FOR PLAIN 哈弗针转移后平板
WM163_TD161.FAC	TRANSFER WITH PATTERN FOR MEDICAL 哈弗针转移后医疗袜

十一、完美机器选款规则

自由插入链条时候的规则参考

START 备注: BEGIN
START_S
START_L

SC_L

SC_S

START_L 备注: Plain fabric

WM163_001L

WM163_002L

WM163_004L

WM163_005L

WM163_006L

WM163_007L

WM163_009L

WM163_008L

WM163_003L

START_S 备注: Sandwich terry

WM163_001

WM163_002

WM163_004

WM163_005

WM163_006

WM163_007

WM163_009

WM163_008

WM163_003

SC_S 备注: Sole Liner terry

WM163_SC301

WM163_SC303

SC_L 备注: Sole Liner plain

WM163_SC351

WM163_SC353

L_SCARICO_STANDARD 备注: Transfer without pattern

WM163_151

WM163_161

L_SCARICO_DISEGNO 备注: Transfer with pattern

WM163_TD151

WM163_TD161

S_SCARICO_STANDARD 备注: Transfer without pattern

WM163_101
WM163_121
WM163_106
WM163_151S

S_SCARICO_DISEGNO 备注: Transfer with pattern

WM163_TD101
WM163_TD121
WM163_TD106
WM163_TD151S

WM163_001 备注: DOUBLE WELT 1F BEGIN NYLON AND PATTERN

WM163_031
WM163_041
WM163_051
WM163_061
S_SCARICO_STANDARD
S_SCARICO_DISEGNO

WM163_001L 备注: DOUBLE WELT 1F BEGIN NYLON AND PATTERN

WM163_032
WM163_042
WM163_052
WM163_062
L_SCARICO_STANDARD
L_SCARICO_DISEGNO

WM163_002 备注: DOUBLE WELT 1F WITH PICOT AND PATTERN

S_SCARICO_STANDARD
S_SCARICO_DISEGNO

WM163_002L 备注: DOUBLE WELT 1F WITH PICOT AND PATTERN

L_SCARICO_STANDARD
L_SCARICO_DISEGNO

WM163_003 备注: ROLL-TOP

WM163_103
WM163_123
WM163_133
WM163_153S

WM163_003L 备注: ROLL-TOP

WM163_153

WM163_163

WM163_004 备注: SHORT DOUBLE WELT 1 FEED

WM163_104

WM163_124

WM163_134

WM163_154S

WM163_004L 备注: SHORT DOUBLE WELT 1 FEED

WM163_154

WM163_164

WM163_005 备注: PLAIN DOUBLE WELT ELASTIC AT END

S_SCARICO_STANDARD

S_SCARICO_DISEGNO

WM163_005L 备注: PLAIN DOUBLE WELT ELASTIC AT END

L_SCARICO_STANDARD

L_SCARICO_DISEGNO

WM163_006 备注: DOUBLE WELT 1 FEED

WM163_031

WM163_041

WM163_051

WM163_061

S_SCARICO_STANDARD

S_SCARICO_DISEGNO

WM163_006L 备注: DOUBLE WELT 1 FEED

WM163_032

WM163_042

WM163_052

WM163_062

L_SCARICO_STANDARD

L_SCARICO_DISEGNO

WM163_007 备注: DOUBLE WELT 1F WITH ELASTIC BEGIN

WM163_031

WM163_041

WM163_051

WM163_061

S_SCARICO_STANDARD

S_SCARICO_DISEGNO

WM163_007L 备注: DOUBLE WELT 1F WITH ELASTIC BEGIN

WM163_032

WM163_042

WM163_052

WM163_062

L_SCARICO_STANDARD

L_SCARICO_DISEGNO

WM163_008 备注: SINGLE WELT 1F

WM163_108

WM163_128

WM163_138

WM163_158S

WM163_008L 备注: SINGLE WELT 1F

WM163_158

WM163_168

WM163_009 备注: TURNED DOUBLE WELT WT PATTERN AND PICOT

S_SCARICO_STANDARD

S_SCARICO_DISEGNO

WM163_009L 备注: TURNED DOUBLE WELT WT PATTERN AND PICOT

L_SCARICO_STANDARD

L_SCARICO_DISEGNO

WM163_031 备注: DOUBLE WELT WITH HEEL TERRY 1F

WM163_031

WM163_041

WM163_051

WM163_061

S_SCARICO_STANDARD

S_SCARICO_DISEGNO

WM163_032 备注: DOUBLE WELT WITH HEEL PLAIN 1F

WM163_032

WM163_042

WM163_052

WM163_062

L_SCARICO_STANDARD

L_SCARICO_DISEGNO

WM163_041 备注: DOUBLE WELT WITH SMALL HEEL TERRY

WM163_031

WM163_041

WM163_051

WM163_061

S_SCARICO_STANDARD

S_SCARICO_DISEGNO

WM163_042 备注: DOUBLE WELT WITH SMALL HEEL PLAIN

WM163_032

WM163_042

WM163_052

WM163_062

L_SCARICO_STANDARD

L_SCARICO_DISEGNO

WM163_051 备注: DOUBLE WELT WITH TERRY REVERSE HEEL

WM163_031

WM163_041

WM163_051

WM163_061

S_SCARICO_STANDARD

S_SCARICO_DISEGNO

WM163_052 备注: DOUBLE WELT WITH PLAIN REVERSE HEEL

WM163_032

WM163_042

WM163_052

WM163_062

L_SCARICO_STANDARD

L_SCARICO_DISEGNO

WM163_061 备注: TERRY SMALL REVERSE HEEL IN WELT

WM163_031

WM163_041

WM163_051

WM163_061

S_SCARICO_STANDARD

S_SCARICO_DISEGNO

WM163_062 备注: PLAIN SMALL REVERSE HEEL IN WELT

WM163_032

WM163_042

WM163_052

WM163_062

L_SCARICO_STANDARD

L_SCARICO_DISEGNO

WM163_101 备注: TRANSFER WITHOUT PATTERN FOR TERRY

WM163_192S

WM163_190S

WM163_301

WM163_304

WM163_321

WM163_324

WM163_311

WM163_501

WM163_231GS

WM163_801

WM163_811

WM163_TD101 备注: TRANSFER WITH PATTERN FOR TERRY

WM163_192S

WM163_190S

WM163_301

WM163_304

WM163_321

WM163_324

WM163_311

WM163_501

WM163_231GS

WM163_801

WM163_811

WM163_103 备注: TERRY LEG 1F FROM ROLL-TOP

WM163_190S

WM163_301

WM163_304

WM163_321

WM163_324

WM163_311

WM163_501
WM163_231GS
WM163_801
WM163_811

WM163_104 备注: LEG IN TERRY 1F FROM SHORT DOUBLE WELT
WM163_190S
WM163_301
WM163_304
WM163_321
WM163_324
WM163_311
WM163_501
WM163_231GS
WM163_801
WM163_811

WM163_106 备注: TRANSFER WITHOUT PATTERN FOR ELAS.+TERRY
WM163_192SE
WM163_191SE
WM163_303
WM163_305
WM163_323
WM163_325
WM163_312
WM163_802
WM163_812

WM163_TD106 备注: TRANSFER WITH PATTERN FOR ELAS.+TERRY
WM163_192SE
WM163_191SE
WM163_303
WM163_305
WM163_323
WM163_325
WM163_312
WM163_802
WM163_812

WM163_108 备注: LEG IN TERRY 1F FROM SINGLE WELT
WM163_190S
WM163_301

WM163_304

WM163_321

WM163_324

WM163_311

WM163_501

WM163_231GS

WM163_801

WM163_811

WM163_121 备注: TRANSFER WITHOUT PATTERN FOR ELASTIC

WM163_192E

WM163_201

WM163_TD121 备注: TRANSFER WITH PATTERN FOR ELASTIC

WM163_192E

WM163_201

WM163_123 备注: ELASTIC LEG 1F FROM ROLL-TOP

WM163_201

WM163_124 备注: ELASTIC LEG 1F FROM SHORT WELT 1 FEED

WM163_201

WM163_128 备注: ELASTIC LEG 1F FROM SINGLE WELT 1F

WM163_201

WM163_133 备注: TERRY LEG + ELASTIC FROM ROLL-TOP

WM163_191SE

WM163_303

WM163_305

WM163_323

WM163_325

WM163_312

WM163_802

WM163_812

WM163_134 备注: TERRY LEG 1F + EL. FROM SHORT DB WELT

WM163_191SE

WM163_303

WM163_305

WM163_323

WM163_325

WM163_312

WM163_802

WM163_812

WM163_138 备注: TERRY LEG + ELASTIC FROM SINGLE WELT

WM163_191SE

WM163_303

WM163_305

WM163_323

WM163_325

WM163_312

WM163_802

WM163_812

WM163_151 备注: TRANSFER WITHOUT PATTERN FOR PLAIN

WM163_192L

WM163_190L

WM163_351

WM163_352

WM163_354

WM163_374

WM163_371

WM163_501L

WM163_231GL

WM163_851

WM163_861

WM163_151S 备注: TRANSFER WITHOUT PATTERN FOR PLAIN

WM163_192LS

WM163_210

WM163_231GLS

WM163_TD151 备注: TRANSFER WITH PATTERN FOR PLAIN

WM163_192L

WM163_190L

WM163_351

WM163_352

WM163_354

WM163_374

WM163_371

WM163_501L

WM163_231GL

WM163_851

WM163_861

WM163_TD151S 备注: TRANSFER WITH PATTERN FOR PLAIN

WM163_192LS

WM163_210

WM163_231GLS

WM163_153 备注: PLAIN LEG 1F FROM ROLL-TOP

WM163_190L

WM163_351

WM163_352

WM163_354

WM163_374

WM163_371

WM163_501L

WM163_231GL

WM163_851

WM163_861

WM163_153S 备注: PLAIN LEG 1F FROM ROLL-TOP

WM163_190LS

WM163_210

WM163_154 备注: PLAIN LEG 1F FROM SHORT WELT 1 FEED

WM163_190L

WM163_351

WM163_352

WM163_354

WM163_374

WM163_371

WM163_501L

WM163_231GL

WM163_851

WM163_861

WM163_154S 备注: PLAIN LEG 1F FROM SHORT WELT 1 FEED

WM163_190LS

WM163_210

WM163_161 备注: TRANSFER WITHOUT PATTERN FOR MEDICAL

WM163_192M

WM163_353

WM163_356

WM163_355

WM163_375

WM163_372

WM163_852

WM163_862

WM163_TD161 备注: TRANSFER WITH PATTERN FOR MEDICAL

WM163_192M

WM163_353

WM163_356

WM163_355

WM163_375

WM163_372

WM163_852

WM163_862

WM163_158 备注: PLAIN LEG 1F FROM SINGLE WELT

WM163_190L

WM163_351

WM163_352

WM163_354

WM163_374

WM163_371

WM163_501L

WM163_231GL

WM163_851

WM163_861

WM163_158S 备注: PLAIN LEG 1F FROM SINGLE WELT

WM163_190LS

WM163_210

WM163_163 备注: MEDICAL LEG FROM ROLL-TOP

WM163_353

WM163_356

WM163_355

WM163_375

WM163_372

WM163_852

WM163_862

WM163_164 备注: PLAIN MEDICAL LEG FROM SHORT DOUBLE WELT

WM163_353

WM163_356

WM163_355

WM163_375

WM163_372

WM163_852

WM163_862

WM163_168 备注: PLAIN MEDICAL LEG FROM SINGLE WELT

WM163_353

WM163_356

WM163_355

WM163_375

WM163_372

WM163_852

WM163_862

WM163_190L 备注: LEG WITH GRADUATIONS

WM163_351

WM163_352

WM163_354

WM163_374

WM163_371

WM163_501L

WM163_231GL

WM163_851

WM163_861

WM163_190LS 备注: LEG WITH GRADUATIONS

WM163_210

WM163_231GLS

WM163_801

WM163_811

WM163_190S 备注: LEG WITH GRADUATIONS

WM163_301

WM163_304

WM163_321

WM163_324

WM163_311

WM163_501
WM163_231GS
WM163_801
WM163_811

WM163_191 备注: LEG WITH GRADUATIONS
WM163_353
WM163_356
WM163_372
WM163_852
WM163_862

WM163_191SE 备注: LEG WITH GRADUATIONS
WM163_303
WM163_305
WM163_323
WM163_325
WM163_312
WM163_802
WM163_812

WM163_192S 备注: LEG
WM163_190S
WM163_301
WM163_304
WM163_321
WM163_324
WM163_311
WM163_501
WM163_231GS
WM163_801
WM163_811

WM163_192L 备注: LEG
WM163_190L
WM163_351
WM163_352
WM163_354
WM163_374
WM163_371
WM163_501L
WM163_231GL



WM163_851

WM163_861

WM163_192LS 备注: LEG

WM163_210

WM163_231GLS

WM163_192E 备注: LEG

WM163_201

WM163_192SE 备注: LEG

WM163_191SE

WM163_303

WM163_305

WM163_323

WM163_325

WM163_312

WM163_802

WM163_812

WM163_192M 备注: LEG

WM163_353

WM163_356

WM163_355

WM163_375

WM163_372

WM163_852

WM163_862

WM163_201 备注: END ELASTIC LEG 1F ENTRANCE TERRY 1F

WM163_190S

WM163_301

WM163_304

WM163_321

WM163_324

WM163_311

WM163_501

WM163_231GS

WM163_801

WM163_811

WM163_210 备注: TERRY LEG 1F FROM PLAIN LEG 1F

WM163_301
WM163_304
WM163_321
WM163_324
WM163_311
WM163_501
WM163_231GS
WM163_801
WM163_811

WM163_231GS 备注: ELASTIC BAND 1 FEED
WM163_190S
WM163_301
WM163_304
WM163_321
WM163_324
WM163_311
WM163_501

WM163_231GL 备注: ELASTIC BAND 1 FEED
WM163_190L
WM163_351
WM163_352
WM163_354
WM163_374
WM163_371
WM163_501L

WM163_231GLS 备注: ELASTIC BAND 1 FEED
WM163_210

WM163_231PS 备注: ELASTIC BAND 1 FEED
WM163_501

WM163_231PL 备注: ELASTIC BAND 1 FEED
WM163_501L

WM163_301 备注: HEEL IN TERRY
WM163_302
WM163_401

WM163_302 备注: SECTION "Y"

WM163_401

WM163_302

WM163_302L 备注: SECTION "Y"

WM163_451

WM163_302L

WM163_302LW 备注: SECTION "Y"

WM163_452

WM163_302LW

WM163_302E 备注: SECTION "Y"

WM163_411

WM163_302E

WM163_302EL 备注: SECTION "Y"

WM163_453

WM163_302EL

WM163_302ELW 备注: SECTION "Y"

WM163_456

WM163_302ELW

WM163_302SL 备注: SECTION "Y"

WM163_421

WM163_302SL

WM163_302ESL 备注: SECTION "Y"

WM163_423

WM163_302ESL

WM163_302SC 备注: SECTION "Y"

WM163_302SC

WM163_SC451

WM163_302SCS 备注: SECTION "Y"

WM163_302SCS

WM163_SC403

WM163_302SCA 备注: SECTION "Y"

WM163_302SCA

WM163_SC453

WM163_302SCL 备注: SECTION "Y"

WM163_302SCL

WM163_SC852L

WM163_302SCSS 备注: SECTION "Y"

WM163_302SCSS

WM163_SC852

WM163_SC301 备注: HEEL SOLE LINER TERRY 1^ HALF

WM163_302SCS

WM163_SC401

WM163_SC303 备注: HIGH HEEL SOLE LINER TERRY 1^ HALF

WM163_302SCS

WM163_SC403

WM163_SC351 备注: HEEL SOLE LINER PLAIN 1^ HALF

WM163_302SC

WM163_SC451

WM163_SC353 备注: HIGH HEEL SOLE LINER PLAIN 1^ HALF

WM163_302SCA

WM163_SC453

WM163_303 备注: BEGIN HEEL FROM LEG IN TERRY 1F + ELAS.

WM163_302E

WM163_411

WM163_304 备注: BEGIN REVERSE TERRY HEEL

WM163_308S

WM163_404

WM163_305 备注: BEGIN REVERSE HEEL FROM TERRY LEG + ELASTIC

WM163_308SE

WM163_405

WM163_308L 备注: SECTION "Y" REVERSE HEEL

WM163_454

WM163_308L

WM163_308LW 备注: SECTION "Y" REVERSE HEEL

WM163_474
WM163_308LW

WM163_308EL 备注: SECTION "Y" REVERSE HEEL
WM163_455
WM163_308EL

WM163_308S 备注: SECTION "Y" REVERSE HEEL
WM163_404
WM163_308S

WM163_308SE 备注: SECTION "Y" REVERSE HEEL
WM163_405
WM163_308SE

WM163_308SW 备注: SECTION "Y" REVERSE HEEL
WM163_424
WM163_308SW

WM163_308SWR 备注: SECTION "Y" REVERSE HEEL
WM163_425
WM163_308SWR

WM163_308MW 备注: SECTION "Y" REVERSE HEEL
WM163_475
WM163_308MW

WM163_311 备注: HIGH HEEL TERRY
WM163_302
WM163_401

WM163_312 备注: HIGH HEEL TERRY + ELASTIC
WM163_302E
WM163_411

WM163_321 备注: WIDE HEEL FROM TERRY LEG 1F
WM163_302SL
WM163_421

WM163_323 备注: WIDE HEEL FROM TERRY LEG + ELASTIC
WM163_302ESL
WM163_423

WM163_324 备注: BEGIN REVERSE WIDE HEEL TERRY

WM163_308SW

WM163_424

WM163_325 备注: BEGIN REVERSE WIDE HEEL TERRY + ELA.

WM163_308SWR

WM163_425

WM163_352 备注: WIDE HEEL FROM PLAIN LEG 1F

WM163_302LW

WM163_452

WM163_353 备注: BEGIN HEEL FROM PLAIN MEDICAL LEG

WM163_302EL

WM163_453

WM163_351 备注: BEGIN HEEL FROM PLAIN LEG 1F

WM163_302L

WM163_451

WM163_354 备注: BEGIN REVERSE PLAIN HEEL

WM163_308L

WM163_454

WM163_355 备注: BEGIN REVERSE HEEL MEDICAL

WM163_308EL

WM163_455

WM163_356 备注: MEDICAL WIDE HEEL

WM163_302ELW

WM163_456

WM163_371 备注: HIGH HEEL

WM163_302L

WM163_451

WM163_372 备注: HIGH HEEL MEDICAL

WM163_302EL

WM163_453

WM163_374 备注: BEGIN REVERSE WIDE HEEL PLAIN



WM163_308LW

WM163_474

WM163_375 备注: BEGIN REVERSE WIDE HEEL MEDICAL

WM163_308MW

WM163_475

WM163_401 备注: END OF HEEL FOR FOOT IN TERRY 1F

WM163_501

WM163_SC401 备注: HEEL SOLE LINER TERRY 2^ HALF

WM163_SC501

WM163_SC701

WM163_SC403 备注: HIGH HEEL SOLE LINER TERRY 2^ HALF

WM163_SC501

WM163_SC701

WM163_404 备注: END OF REVERSE HEEL TERRY

WM163_190S

WM163_301

WM163_321

WM163_311

WM163_501

WM163_231GS

WM163_801

WM163_811

WM163_405 备注: END OF REVERSE HEEL FOR TERRY + ELASTIC

WM163_191SE

WM163_303

WM163_323

WM163_312

WM163_802

WM163_812

WM163_411 备注: END OF HEEL FOR FOOT IN TERRY 1F + ELAS.

WM163_501

WM163_601

WM163_421 备注: END OF WIDE HEEL TERRY

WM163_501

WM163_423 备注: END OF WIDE HEEL TERRY + ELA.

WM163_501

WM163_601

WM163_424 备注: END OF REVERSE WIDE HEEL TERRY

WM163_190S

WM163_301

WM163_321

WM163_311

WM163_501

WM163_231GS

WM163_801

WM163_811

WM163_425 备注: END OF REVERSE WIDE HEEL TERRY + ELA.

WM163_191SE

WM163_303

WM163_323

WM163_312

WM163_802

WM163_812

WM163_801

WM163_811

WM163_SC451 备注: HEEL SOLE LINER PLAIN 2^ HALF

WM163_SC551

WM163_SC751

WM163_451 备注: END OF HEEL FOR PLAIN FOOT 1F

WM163_501L

WM163_452 备注: END OF WIDE HEEL PLAIN 1F

WM163_501L

WM163_453 备注: END OF HEEL AND PLAIN MEDICAL FOOT

WM163_501L

WM163_651

WM163_SC453 备注: HIGH HEEL SOLE LINER PLAIN 2^ HALF

WM163_SC551

WM163_SC751

WM163_454 备注: END OF REVERSE HEEL PLAIN

WM163_190L

WM163_351

WM163_371

WM163_501L

WM163_231GL

WM163_851

WM163_861

WM163_455 备注: END OF REVERSE HEEL MEDICAL

WM163_191

WM163_353

WM163_356

WM163_372

WM163_501L

WM163_652

WM163_852

WM163_862

WM163_456 备注: END OF WIDE HEEL AND PLAIN MEDICAL FOOT

WM163_501L

WM163_651

WM163_474 备注: END OF REVERSE WIDE HEEL PLAIN

WM163_190L

WM163_351

WM163_371

WM163_501L

WM163_231GL

WM163_851

WM163_861

WM163_475 备注: END OF REVERSE WIDE HEEL MEDICAL

WM163_191

WM163_353

WM163_356

WM163_372

WM163_501L

WM163_652

WM163_852

WM163_862

WM163_SC501 备注: TERRY SOLE LINER WITH ELASTIC
WM163_501

WM163_501 备注: FOOT
WM163_601
WM163_231PS
WM163_801
WM163_811
3D_S

WM163_501L 备注: FOOT
WM163_651
WM163_231PL
WM163_851
WM163_861
3D_L

WM163_SC551 备注: FOOT FROM HEEL SOLE LINER PLAIN
WM163_501L

WM163_601 备注: BEGIN TOE FROM FOOT IN TERRY 1F
WM163_701
WM163_705
WM163_706
WM163_711
WM163_715
WM163_716
WM163_700

WM163_651 备注: BEGIN TOE FROM PLAIN FOOT 1F
WM163_751
WM163_755
WM163_756
WM163_761
WM163_765
WM163_766
WM163_750

WM163_652 备注: BEGIN TOE FROM MEDICAL FOOT
WM163_751
WM163_755



WM163_756

WM163_761

WM163_765

WM163_766

WM163_750

WM163_700 备注: CIRCULAR TOE FROM FOOT IN TERRY 1F

WM163_950

WM163_951

WM163_952

WM163_SC701 备注: TOE FOR TERRY SOLE LINER

WM163_SC851

WM163_SC854

WM163_701 备注: STANDARD TERRY TOE

WM163_904

WM163_905

WM163_906

WM163_970

WM163_970_A

WM163_705 备注: TERRY STANDARD "R" TOE

WM163_904

WM163_905

WM163_906

WM163_970

WM163_970_A

WM163_706 备注: TERRY STANDARD "L" TOE

WM163_904

WM163_905

WM163_906

WM163_970

WM163_970_A

WM163_711 备注: TERRY REVERSE TOE

WM163_924

WM163_925

WM163_926

WM163_980



WM163_980_A

WM163_715 备注: L REVERSE TERRY TOE

WM163_924

WM163_925

WM163_926

WM163_980

WM163_980_A

WM163_716 备注: R REVERSE TERRY TOE

WM163_924

WM163_925

WM163_926

WM163_980

WM163_980_A

WM163_750 备注: CIRCULAR TOE FROM PLAIN FOOT 1F

WM163_950

WM163_951

WM163_952

WM163_972

WM163_972_A

WM163_751 备注: PLAIN STANDARD TOE

WM163_901

WM163_902

WM163_903

WM163_971

WM163_971_A

WM163_SC751 备注: TOE SOLE LINER PLAIN 1^ HALF

WM163_SC851L

WM163_SC854L

WM163_755 备注: PLAIN STANDARD "R" TOE

WM163_901

WM163_902

WM163_903

WM163_971

WM163_971_A

WM163_756 备注: PLAIN STANDARD "L" TOE

WM163_901
WM163_902
WM163_903
WM163_971
WM163_971_A

WM163_765 备注: L REVERSE PLAIN TOE
WM163_921
WM163_922
WM163_923
WM163_981
WM163_981_A

WM163_766 备注: R REVERSE PLAIN TOE
WM163_921
WM163_922
WM163_923
WM163_981
WM163_981_A

WM163_761 备注: PLAIN REVERSE TOE
WM163_921
WM163_922
WM163_923
WM163_981
WM163_981_A

WM163_801 备注: DOUBLE WELT END SOCK FROM TERRY 1F
END

WM163_802 备注: DOUBLE WELT END SOCK FROM TERRY+ELAS
END

WM163_811 备注: END SOCK ROLL-TOP FROM TERRY 1F
END

WM163_812 备注: END SOCK ROLL-TOP FROM TERRY + ELASTIC
END

WM163_SC851 备注: TOE 1^ HALF
WM163_302SCSS
WM163_SC852

WM163_SC851L 备注: TOE 1^ HALF
WM163_302SCL
WM163_SC852L

WM163_SC852 备注: TOE 2^ HALF
WM163_SC901

WM163_SC852L 备注: TOE 2^ HALF
WM163_SC951

WM163_SC854 备注: LONG TOE FOR SOLE LINER
WM163_SC901

WM163_SC854L 备注: LONG TOE FOR SOLE LINER
WM163_SC951

WM163_851 备注: DOUBLE WELT END SOCK FROM PLAIN 1F
END

WM163_852 备注: DOUBLE WELT END SOCK FROM MEDICAL
END

WM163_861 备注: END SOCK ROLL-TOP FROM PLAIN 1F
END

WM163_862 备注: END SOCK ROLL-TOP FROM MEDICAL
END

WM163_SC901 备注: HEEL SOLE LINER TERRY 2^ HALF
END

WM163_SC951 备注: HEEL SOLE LINER PLAIN 2^ HALF
END

WM163_901 备注: ROSSO FOR STANDARD PLAIN
WM163_950
WM163_951
WM163_952

WM163_902 备注: LINKING LINE FOR STANDARD PLAIN
WM163_950

WM163_951

WM163_952

WM163_903 备注: LINKING LINE+ROSSO FOR STANDARD PLAIN

WM163_950

WM163_951

WM163_952

WM163_904 备注: ROSSO FOR STANDARD TERRY

WM163_950

WM163_951

WM163_952

WM163_905 备注: LINKING LINE FOR STANDARD TERRY

WM163_950

WM163_951

WM163_952

WM163_906 备注: LINKING LINE+ROSSO FOR STANDARD TERRY

WM163_950

WM163_951

WM163_952

WM163_921 备注: ROSSO FOR REVERSE PLAIN

WM163_950

WM163_951

WM163_952

WM163_922 备注: LINKING LINE FOR REVERSE PLAIN

WM163_950

WM163_951

WM163_952

WM163_923 备注: LINKING LINE+ROSSO FOR REVERSE PLAIN

WM163_950

WM163_951

WM163_952

WM163_924 备注: ROSSO FOR REVERSE TERRY

WM163_950

WM163_951

WM163_952

WM163_925 备注: LINKING LINE FOR REVERSE TERRY

WM163_950

WM163_951

WM163_952

WM163_926 备注: LINKING LINE+ROSSO FOR REVERSE TERRY

WM163_950

WM163_951

WM163_952

3D_S 备注: 3D Automatic seaming in terry

3D_WM163MC904

3D_WM163MC905

3D_WM163MC906

3D_WM163MC970

3D_WM163MC970_A

3D_WM163MC980

3D_WM163MC980_A

3D_L 备注: 3D Automatic seaming in plain

3D_WM163MC901

3D_WM163MC902

3D_WM163MC903

3D_WM163MC971

3D_WM163MC971_A

3D_WM163MC981

3D_WM163MC981_A

WM163_950 备注: SOCK RELEASE WITHOUT TURNING DEVICE

END

WM163_951 备注: SOCK RELEASE FOR TURNING DEVICE AND FAN

END

WM163_SC952 备注: TOE SOLE LINER PLAIN 2^ HALF

END

WM163_952 备注: SOCK REL. TURNING DEVICE CENTRAL VACUUM

END

WM163_970 备注: AUTOMATIC STANDARD TOE SEAM TERRY

END

WM163_970_A 备注: AUTOMATIC STANDARD TOE SEAM TERRY 2
END

WM163_971 备注: AUTOMATIC STANDARD TOE SEAM PLAIN
END

WM163_971_A 备注: AUTOMATIC STANDARD TOE SEAM PLAIN 2
END

WM163_972 备注: AUTOMATIC CIRCULAR TOE SEAM
END

WM163_972_A 备注: AUTOMATIC CIRCULAR TOE SEAM 2
END

WM163_980 备注: AUTOMATIC REVERSE TOE SEAM TERRY
END

WM163_980_A 备注: AUTOMATIC REVERSE TOE SEAM TERRY 2
END

WM163_981 备注: AUTOMATIC REVERSE TOE SEAM PLAIN
END

WM163_981_A 备注: AUTOMATIC REVERSE TOE SEAM PLAIN 2
END

3D_WM163MC901 备注: 3D END FOR ROSSO PLAIN FABRIC
END

3D_WM163MC902 备注: 3D END FOR LINKING PLAIN FABRIC
END

3D_WM163MC903 备注: 3D END FOR LINKING+ROSSO PLAIN FABRIC
END

3D_WM163MC904 备注: 3D END FOR ROSSO TERRY
END

3D_WM163MC905 备注: 3D END FOR LINKING TERRY



END

3D_WM163MC906 备注: 3D END FOR LINKING+ROSSO TERRY
END

3D_WM163MC970 备注: 3D END AUTOM.STANDARD SEAMING TERRY
END

3D_WM163MC970_A 备注: 3D END AUTOM.STANDARD SEAMING TERRY 2
END

3D_WM163MC971 备注: 3D END AUTOM.STANDARD SEAMING PLAIN
END

3D_WM163MC971_A 备注: 3D END AUTOM.STANDARD SEAMING PLAIN 2
END

3D_WM163MC980 备注: 3D END AUTOM.REVERSE SEAMING TERRY
END

3D_WM163MC980_A 备注: 3D END AUTOM.REVERSE SEAMING TERRY 2
END

3D_WM163MC981 备注: 3D END AUTOM.REVERSE SEAMING PLAIN
END

3D_WM163MC981_A 备注: 3D END AUTOM.REVERSE SEAMING PLAIN 2
END

END 备注: END OF SOCK
CONFERMA

CONFERMA 备注: Press ENTER to confirm

十二、 YOYO 和 PLUS

YOYO 有三个部分，分别是

YOYO 第一部分:

[Grams YOYO - Reset machine](#)

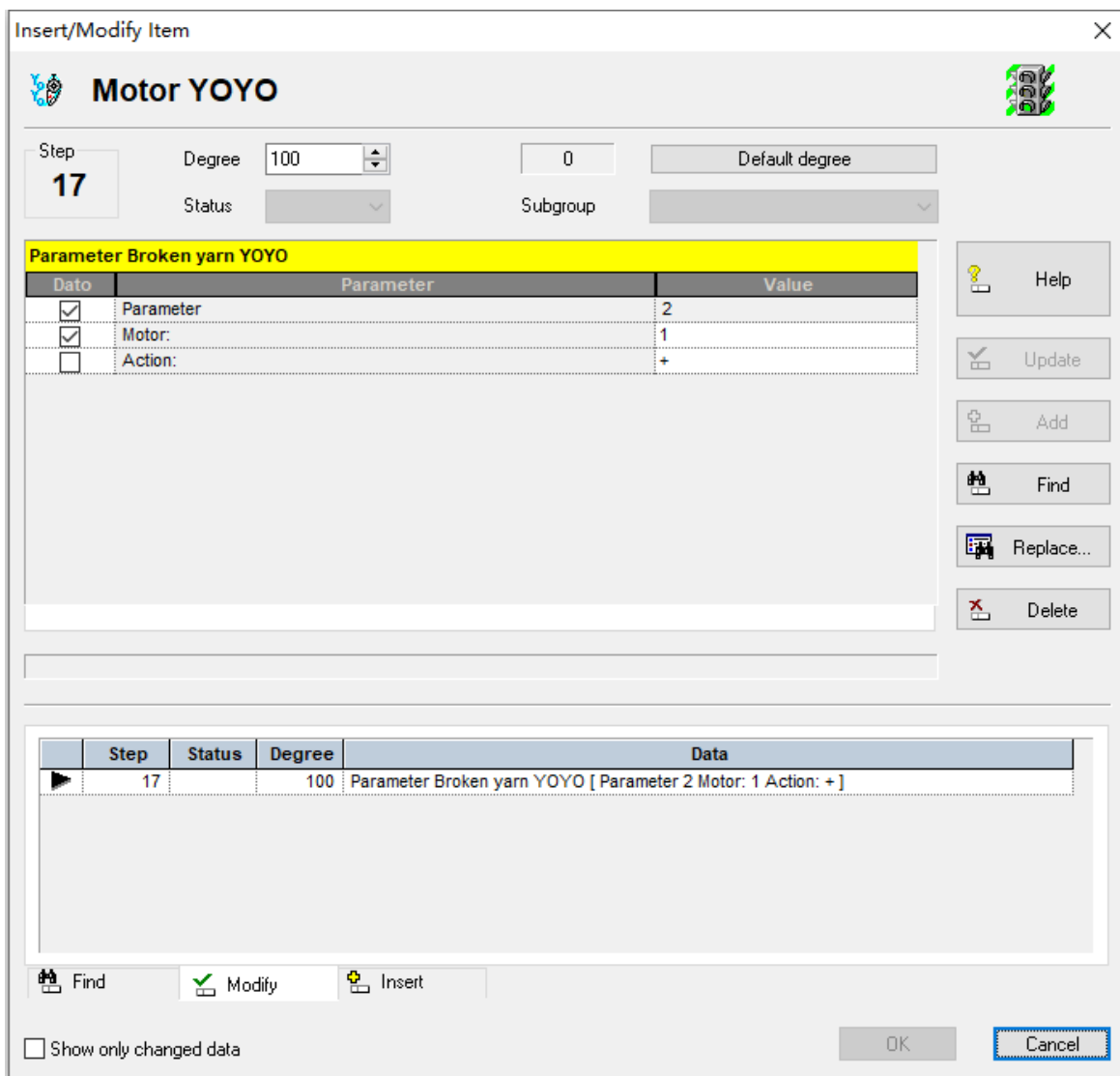
[Grams YOYO - Zeroing machine](#)

[Yarn parameter for YOYO motors](#)

以上属于默认初始的一些设置，按原料选择即可

YOYO 第二部分:

YOYO 功能信号



Insert/Modify Item

Motor YOYO

Step: 17 Degree: 100 Status: Subgroup: 0 Default degree: 0

Parameter Broken yarn YOYO

Dato	Parameter	Value
<input checked="" type="checkbox"/>	Parameter	2
<input checked="" type="checkbox"/>	Motor:	1
<input type="checkbox"/>	Action:	+

Buttons: Help, Update, Add, Find, Replace..., Delete

Step	Status	Degree	Data
17		100	Parameter Broken yarn YOYO [Parameter 2 Motor: 1 Action: +]

Buttons: Find, Modify, Insert

☐ Show only changed data

OK Cancel

Parameter:参数

0= Parameter YOYO yarn weight variation

1= Parameter Direction management YOYO

重量变化参数

方向管理参数



- 2= Parameter BROKEN YARN YOYO 断纱报警参数（棉袜机）
 3= Parameter SUPER POWER （未知）
 4= Parameter Yarn take-up YOYO in reciprocated motion 袜跟回转时候使用（袜跟）

Motor:
 马达对应的号码

Action:
 + : 开启 - : 关闭

Variation:
 克重参数的百分比变化

Direction:
 方向 0= 正转; 1= 反转

Step:
 1 round= 4 step
 一个圆等于 4 个步骤
 最小填入 0 ——最多 80 步骤

Rpm:
 速度的 4% - 100%

YOYO 第三部分:

马达

The screenshot displays the 'Programming of YOYO MOTORS 1-4 blocks for each size - YOYO 1-4' window. It includes a table with columns for Block, I, F, Prot., 1 Gr., 1 dec., 1 Gr., 1 dec., Prot., 2 Gr., 2 dec., 2 Gr., 2 dec., Prot., 3 Gr., 3 dec., 3 Gr., 3 dec., Prot., 4 Gr., 4 dec., 4 Gr., 4 dec.






Size	Block	I	F	Prot.	1 Gr.	1 dec.	1 Gr.	1 dec.	Prot.	2 Gr.	2 dec.	2 Gr.	2 dec.	Prot.	3 Gr.	3 dec.	3 Gr.	3 dec.	Prot.	4 Gr.	4 dec.	4 Gr.	4 dec.
1	WELT	16	28		15	0	15	0		0	0	0	0		5	0	5	0		0	0	0	0
2	LEG	29	42		15	0	15	0		0	0	0	0		0	0	0	0		0	0	0	0
3	HEEL	43	57		15	0	15	0		0	0	0	0		4	0	4	0		0	0	0	0
4	FOOT	58	79		15	0	15	0		0	0	0	0		5	0	5	0		0	0	0	0
5	TOE	80	93		15	0	15	0		0	0	0	0		4	0	4	0		0	0	0	0

I 部段开始

F 部段结束

1 Gr. 克重一号马达 1 dec. 一号马达零点几克重马达
 2 Gr. 克重一号马达 2 dec. 一号马达零点几克重马达
 3 Gr. 克重一号马达 3 dec. 一号马达零点几克重马达

PLUS 第一部分：

Step	Degre	Type	Status	
39+				
40+				
41*	100		<input checked="" type="checkbox"/>	[261] Lycra binder position A 裸氨位置A整体上下
	200		<input checked="" type="checkbox"/>	[262] Lycra binder position B 裸氨位置B夹子打开
42*	220		<input type="checkbox"/>	[262] Lycra binder position B 裸氨位置B夹子打开
	320		<input type="checkbox"/>	[261] Lycra binder position A 裸氨位置A整体上下
	340		<input type="checkbox"/>	[156] Enable Lycra motor 2 氨纶马达2 启动
43+				
44+				


插入功能功能和信号

包括夹子打开 马达启动 等

PLUS 第二部分：

马达部分

C:\Graph6\WM163\CHAIN\200\2019\SWMS03119luoan.sok - Programming of LYCRA MOTORS blocks for each size - LYCRA MO...


Insert Zone Delete Zone Copy Paste **OK** Cancel

Copy Size Paste Size Copy All Sizes Paste All Sizes

Size
☒ 1
☐ 2
☐ 3
☐ 4
☐ 5
☐ 6
☐ 7
☐ 8

	Lycra block name	Step	S	F	Prot.	Lyc.1	S	F	Prot.	Lyc.2	S	F
1	WELT	16	23		<input type="checkbox"/>	3000	3000		<input type="checkbox"/>	2300	2300	
2	LEG	24	37		<input type="checkbox"/>	3000	2000		<input type="checkbox"/>	2300	1700	
3	ANKLE	38	40		<input type="checkbox"/>	2000	2000		<input type="checkbox"/>	1700	1700	
4	ANKLE2	41	42		<input type="checkbox"/>	2000	2000		<input type="checkbox"/>	2300	2300	
5	FOOT	58	79		<input type="checkbox"/>	2000	2000		<input type="checkbox"/>	1700	1900	

All Motors
Stitch
Elastic
Lycra
YOYO

	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31
LYCRA MOTORS					WELT								LEG							

区域和起始位置速度