

#### 4. Parameter settings

HD-SING G40

Parameter NO.	Function Name	Range	Value	Lockstitch	Twin needle	High Post	Over lock	Cover stitch
P0	Maximum sewing speed	1~65	*100spm	40	20	15	60	38
P1	Low speed	10~50	*10spm	23	23	23	23	23
P2	Motor pulley dimension	50~G0	*1m/m	90	75	65	90	A0
P3	Machine pulley dimension	50~G0	50 ~ 160	75	80	70	55	65
P4	Pulley's ratio setting mode selection	ON/OFF	ON: Use P2&P3 to calculate the ratio OFF: Automatic calculation	OFF	OFF	OFF	OFF	OFF
P5	Sewing speed	-----	-----	---	---	---	---	---
P6	Needle up position	0 ~ 35	*10°	0	0	0	0	0
P7	Virtual down position for synchronizers with one positioning Disc	9~30	*10°	18	18	18	18	18
P8	Future use	ON/OFF	ON: Valid OFF: Invalid	OFF	OFF	OFF	OFF	OFF
P9	Future use	L/H	L:LOW H:HIGH	L	L	L	L	L
PA	Slow start operation mode	ON/OFF	ON: Valid OFF: Invalid	OFF	OFF	OFF	OFF	OFF
PB	Soft start speed	10~50	*10spm	20	20	20	20	20
PC	Stitch numbers for soft start	1~9	*1 Stitch	2	2	2	2	2
PD	Soft start at the first cycle of power ON	ON/OFF	ON: Slow speed at first stitch OFF: Refer to P7	OFF	OFF	OFF	OFF	OFF
PE	Motor braked at normal stop	ON/OFF	ON: Locked OFF: Unlocked	OFF	OFF	OFF	OFF	OFF
PF	Weak braking torque scale	0.1~5.0	Ampere value	2.0	2.0	2.0	2.0	2.0
PE	Acceleration time	10~50	*10ms	30	30	30	30	40
PH	Deceleration time	10~50	*10ms	26	26	30	26	26
PI	Reverse after pedal heel down	ON/OFF	ON: Valid OFF: Invalid	OFF	OFF	OFF	OFF	OFF
PJ	Setting of reversing angle	10~30	*10°	18	18	18	18	18
PK	Needle up after pedal heel down	ON/OFF	ON: Valid OFF: Invalid	OFF	OFF	OFF	OFF	OFF
PL	One stitch on way of sewing	ON/OFF	ON: Valid OFF: Invalid	OFF	OFF	OFF	OFF	OFF
PM	Half stitch at first stitch after needle up	ON/OFF	ON: Valid OFF: Invalid	OFF	OFF	OFF	OFF	OFF
PZ	Select machine code	A0 ~ E9	-----	A0	B0	C0	D0	E0
FL	Recovery to factory setting	Y/N	Y: Recover factory presetting N:-----	---	---	---	---	---
FS	Save factory setting	Y/N	Y: Saves factory presetting N:-----	---	---	---	---	---