

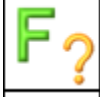































## XS/XY Error Messages









Message (Code)	Description	Trouble shooting
A01 	No or Low Battery Voltage Error	If machine has been powered off for a long period time, or a replacement CPU board was installed, the battery maybe low and need recharged. Leave machine on for 24 hours to recharge battery. If battery doesn't recharge, call tech support for info on replacement.
A05   	Wrong Tape Code or BAUD Rate Error	1. When sending a design via cable from a PC to the machine, the tape code setting on the PC must match the setting set on the machine in "IN COM" mode, otherwise you'll get this error. Barudan = U code Tajima = EL code ZSK = F code Make sure the PC transfer machine setting matches the Machine "In COM" tape setting. 2. Also check that the BAUD rate setting on the machine matches the BAUD output from the PC software program. They must match or you'll get this error. Call tech or software support to help diagnose.
A07 	IC Memory Error	EPROM writing error. Problem with CPU/Control board. Call Tech Support.
A08 	Memory is Full or Design Memory Read Error	1. Check to see if the memory is full first. Delete some designs if full. 2. This could also be a problem reading a design into memory. Try renaming the problem design, or try reading another design that's verified good. 3. If no designs will read into memory, may need to reformat the internal CF memory card. Call tech support.
A11 	No PC or Peripheral Device Connected Error	This error occurs when sending a design to the machine from a PC with a COM/Serial cable, and the cable is disconnected or broken. Check the cable connections first. Next try rebooting the computer and the machine and try again. If the COM connection has never worked before and you're setting this up for the first time, then the PC program settings or cable connections are suspect. Call tech or software support to help diagnose.








Message (Code)	Description	Trouble shooting
A20 	Memory Slot Empty	This is not an error. It's a message that the memory slot you've selected is empty and you cannot make any changes to it.
A21 	All Memory Slots are Empty	This is not an error. It's a message indicating that all the memory locations are empty. Load at least one design into memory to make this message go away
A24 	No More Color Change Codes Found	This message occurs when teaching colors in a design and you've reached the last color change in the design, and no more color changes are found.
A26 	Sock Frame Origin Not Set	The sock frame parameter in the "Program" menu requires that you set the first sock frame origin while the machine is out of Drive mode. Then set the machine in Drive mode, and move the pantograph to origin of the second sock frame. If you do not move the panto to the second sock frame after putting into Drive, you'll get this error.
A27 	No more Function Codes Found	This message occurs when searching or programming function codes in a design and you've reached the last function code.
A28 	Calculating Please wait	This is a message that the machine is busy. Wait till the message disappears before pressing any buttons.
A29 	Memory is Full	This is a message that all the memory locations are full. Delete some designs in order to load more in.
A34 	Too Many Color Changes in Design	This is a message displayed when there are more than 1200 color change functions in a design being read into memory. Edit the design and remove some color changes to less than 1200 to correct the problem.










Message (Code)	Description	Trouble shooting
A35 	Spectacle Frame Error	Spectacle Frame is a special parameter in MC parameters. When Spectacle Frame is turned On, some machine operations are prohibited to protect the machine. This is the error message given when an operation is prohibited. If a spectacle frame is not being used, turn this feature Off in MC.
A36 	Appliqué Error	When manual Appliqué feature is activated, you cannot use the origin key. This is to prevent bending the presser foot. Turn the manual appliqué feature Off to use the origin key.
A37 	USB Memory Device is Full	Delete some designs off of the USB Memory Device.
A38 	No USB Memory Device Inserted	<ol style="list-style-type: none"> <li>1. Check that the USB Memory Device is inserted correctly. If inserted OK and still getting error, check the Automat connector and/or try another USB memory device.</li> <li>2. If still a problem, check the internal CF memory card and/or connection board. Make sure they are not damaged or came loose.</li> </ol>
A39 	USB Read/Write Error	Retry using the USB memory or try another USB memory device.
A40 	Network Error	This error occurs when using Barudan's DFS (Design File Server) or LEM Networking Software to connect to the machine. It means the machine is disconnected from the network. Check that the cable from the PC to this machine is connected properly and not damaged. If OK, close the DFS or LEM software and reopen and retry. If still a problem. Reboot the computer and the machine to see if it corrects the network error. If the problem is intermittent with DFS Protocol mode, try re-routing the cable away from other electrical power cables or try a shorter cable.
A41 	Design Data Reading Error	This error occurs when reading design data that is made with a format problem or with wrong design information header. Try reformatting the bad design with digitizing/editing software or read another good design.

Message (Code)	Description	Trouble shooting
D01 	Needle Bar Not Locked	Color Change Lock sensor is not engaged or not working properly. Manually rotate the Color change assembly so the sensor plate engages the Lock sensor and retry. If still a problem look to see if the Sensor LED is working. If the Color Change assembly is in a bind or jammed, do not force. See Error D05 for possible binds.
D03 	Color Change Lock Error	Color Change Lock sensor is not engaged or not working properly. Manually rotate the Color change assembly so the sensor plate engages the Lock sensor and retry. If still a problem look to see if the Sensor LED is working. If the Color Change assembly is in a bind or jammed, do not force. See Error D05 for possible binds.
D04 	Color Change Needle Sensor Error	Needle Select Board in Color Change Assembly has a sensor for each needle. One sensor at a time should always be engaged and On. First manually rotate the Color change assembly to see if it clears up the problem. Do not force if color change is in a bind. See Error D05 for possible binds. If no binds and still getting this error, check the Needle select board to see if the sensor plate is bent or if any of the sensors are broken. Replace the Needle select board.
D05 	Color Change Error	Machine had an error trying to make a color change. Manually rotate the color change assembly to see if there are any binds in the color change movement. Possible Binds: <ol style="list-style-type: none"> <li>1. One or more of the thread keep solenoids is stuck or out of position causing it to jam a head from moving.</li> <li>2. One or more of the Jump solenoids is not engaging</li> <li>3. One or more take up levers are broken.</li> <li>4. Sewing head side cover is interfering with head movement.</li> <li>5. The Degree wheel is the wrong position.</li> </ol> <p>Correct any of these conditions before continuing. May need to power down and back On to reset the machine, afterwards.</p>







Message (Code)	Description	Trouble shooting
D06 	Main Motor Trip Error	Try to restart the machine. If still getting error, turn Off and try rotating sewing head by hand and check for binds (To rotate the sewing head, remove the main drive pulley cover to get to the degree wheel and turn the degree wheel). See D07 trouble shooting for possible binds.
D07 	Main Motor Overload Error	Turn Off machine and rotate sewing head by hand and check for bind (To rotate the sewing head, remove the main drive pulley cover to get to the degree wheel and turn the degree wheel). If binding, take off the throat plate and check for thread wrapped around back of the sewing hook or sewing hook area. Try oiling the machine to see if it's easier to rotate. If you cannot find bind, call tech support for help.
D08 	Frame Limit Error	Message that the pantograph is beyond one of the soft limits as set in the MC parameters. Re-center the origin of design so it traces inside the limits without getting this error. Call tech support if soft limits need to be reset or changed in MC parameters.
D09 	Start/Stop Switch Error	This error means there is a problem with either the start or stop switch being stuck on. Check switches and wiring.
D11 	Rotary Encoder Error	Problem with encoder. Call tech support.
D12 	Trimmer Slider Error	Trimmer slider is stuck in down position or caught on un-trimmed thread. If caught on un-trimmed thread, break thread by hand and pull about 2 inches (50mm) of thread before letting the trimmer slider pull thread up into the thread catch. If machine continues to have D12 errors because it's not trimming, check and adjust the trimmers. Replace blades and wave washer if necessary. If D12 is happening because slider is sticking, check slider operation by hand and clean or repair as necessary for smooth operation.

Message (Code)	Description	Trouble shooting
D13 	No further Stitch Back or Automending due to 1600 stitch limit	Message that machine cannot stitch back or automend any further due to 1600 Stitch limit. If needing to stitch back/automend further, use float operation, and float back where needed. See operation manual for Float instructions.
D14 	Push Start Button	Message that start button needs to be pushed to continue operation.
D16 	Bobbin Break	Message that machine stopped due to bobbin thread break. Fix or replace bobbin thread. (Optional Bobbin detector installed or parameter turned ON)
D19 	Stopped for Stop Code	Message that machine stopped due to stop code in design.
D20 	End of Automending	Message that machine stopped due to Automend operation finished.
D21 	Stopped by Stop Switch	Message that machine was stopped by the stop switch
D22 	Trimmer Motor Error	Trimmer motor is jammed or not stopping in the correct position. You must turn machine Off to reset this error. Check the trimmer blade adjustment. Birdnesting of thread will knock trimmers out of adjustment when trying to trim. Remove any excess thread from under throat plate and reset trimmer blade if needed.
D23 	Stopped for Appliqué	Message that machine stopped due to stop code in design and Appliqué program feature is turned On.

Message (Code)	Description	Trouble shooting
D25 	Stopped for Thread Break	Message that machine stopped due to thread break. Fix thread break and continue. If thread is not broke (false thread break) check that thread is wrapped around the thread detect wheel on the tension assembly. If false thread breaks occur on small stitches try increasing MC parameter #19, T-Break to a higher value.
D26 	Pulse Motor Circuit Overheat	Message that the machine stopped because the pulse motor drive (pantograph) circuitry has over heated. Power off the machine to let it cool down. Check and clean the fan and fan opening to make sure lint or other debris is not blocking them. Afterwards, power back On, and check that the fan is working. If fan works and still getting D26 error, call tech support.
D27 	Stopped for Temporary Repair Stop	Message that a temporary stop code was inserted in the design on the last run.
D28 	No further Stitch Back or Automending due to Color Change	This is a message indicating that you cannot back up any further unless you do a manual trim. Do a manual trim.
D29 	Servo Driver Error	Something jammed the pantograph while sewing, or there is a problem with the Servo electronics. Power off machine and make sure pantograph is not jammed by trying to move by hand. Remove any binds before powering on again. If no binds, power back On and see if it's OK. If still a problem, call tech support.
D30 	Head/Duct Board Switch Error	More than 2 switches on the Head/Duct board are ON. Please check and make sure switches are set properly. Check ribbon cable from head switch boards to head duct boards. An unplugged or damaged cable from one board will cause this error.
D31 	Driver Box/Board Communication Error	Problem with Automat recognizing that the Driver board is connected. Check cables from Automat to Driver board. Call tech support.

Message (Code)	Description	Trouble shooting
D32 	Stopped for Sub End Code	Message that Roll to Roll feature is turned On, and machine stopped due to Sub End code in design data.
D33 	Power Interrupt Error	A power interruption to the machine has occurred. Power down the machine, then back On to re-set. If you continue to get this error, check for electrical power problems to machine. Try another known good power outlet, or another circuit that's not being used by other equipment.
D34 	Stopped by Light Curtain	Optional light curtain activated. Something is blocking the light beam or light beam is not working properly. Check light curtain.
D35 	Lubrication Error	Optional Device. Check Lubrication device.
D36 	Stopped for Bobbin Counter	When Bobbin counter feature is activated, machine stops, trims the bobbin and gives this message to let you know why it stopped. Change your bobbin, and start machine to reset.
D37 	Sequin Device Error	Check that Sequin Driver box is turned on. Call tech support
D38 	Chenille Driver Error	Turn off the machine and reboot. Make sure the Chenille Driver box is turned On. If the same error message displays again, check the wiring to the Needle Bar rotation motor. Otherwise motor may be faulty or jammed. Call Tech support.
D39 	Looper Motor Error	Turn off the machine and reboot. If still a problem, turn the Looper motor shaft manually until the (top) shaft sensor turns On and retry. Call Tech support for more help.
D40 	Chenille Thread Clamp Motor Error	Turn off the machine and reboot. If still a problem, turn the tension release motor shaft manually until the shaft sensor turns On and retry. Call Tech support for more help.



Message (Code)	Description	Trouble shooting
D41 	Chenille Needle Height Error	This error occurs when the needle bar height or cancel position is wrong. Turn off the machine and reboot. If still a problem, turn off the machine. Then manually rotate the (needle bar) leveling shaft on the problem head and see if the needle bar drive levers inside move smoothly and freely and not in a bind. Fix and correct any binds in the levers before turning the machine on again. Then, rotate the shaft to the lower position and see if the LED for Needle height origin sensor lights when engaged. Call Tech support for further help.
D42 	Chenille Error	This Chenille error occurs when there's a problem other than D38 to D41. Its' most likely a stepper driver board problem in the Chenille Drive box. Call tech support for help.
D43 	Presser Set Error	Call Tech support.
D44 	Lock Stitch Zig-Zag Driver	Call Tech support.
D45 	Lock Stitch Zig-Zag Tension	Call Tech support.
D46 	Lock Stitch Zig-Zag Error	Call Tech support.