

Tajima Machine Error List

_01	No 500 character function code when data set is set	Press RESET and set the data again.
_02	Tajima tape complement error. (The same +/- numerics are entered in a single stitch data	Correct the tape
_03	Data is involved in the tape end code	Correct the tape
_04	Improper function code position. Or, wrong tape format was selected.	Correct the tape, or select proper format.
_06	Memory writing error	Expand memory capacity, or replace memory card.
_08	PTR tape signal trouble	Adjust reader, or replace unit
_09	PTR motion is in disorder. Reader does not read the tape for more than 5 seconds	Check connection of reader cable.
11	Data set incomplete	After properly setting data, start again.
12	Excessive stitch back	Stitch back is possible up to 71 stitches for tape operation and starting point for memory designs.
13	Prohibited forward (When offset is set)	Set the offset value to zero, or move the frame by a distance of offset and move the frame.
16	Tape format 5 is selected although no designs are stored in memory.	Save design to memory
17	After 30 designs have been stored in memory, tape format 2, or 4 was selected.	Only 30 designs can be stored in memory. Remove unnecessary designs.
18	After the data setting, the number of that design is erased.	Save design to memory again.
19	Memory capacity shortage during editing.	Erase unnecessary designs.
30	Stop command by bar switch is given during execution of mode 5, 6, offset or home return	
31	Stop command by bar switch is given during color change	
51	No stop position signal is output	Encoder or machine card trouble.
52	Frame limit switch activated.	Move the frame to its working area.

53	Stepping motor driver trouble (X, Y)	Check PMD drive units.
54	Left and right limits on the color change are detected.	Check machine card, needle position card.
55	Color change takes over 5 seconds	Check machine card, BP card
56	Color change, half-turn cam signal trouble.	Check needle position card, BP card. Check for a mechanical bind in the color change system.
57	Needle position signal trouble	Check needle position card. Check for a mechanical bind in the color change system.
58	One turn of the main shaft motor takes over 5 seconds	
59	The cap frame moves more than 75mm from the cap frame zero point when searching	Inspect the photo interrupter
60	The embroidery space of the cap frame is exceeded.	Move the cap frame to the correct start point or decrease the size of the design.
211	A fixed position signal is not detected. (Main shaft Z signal)	Return the main shaft to the fixed position. Check the encoder signal
212	Needle bar is in lowering position	Move up the needle bar by needle bar operation.
221	The frame has traveled left, exceeding the position set by the frame limit	Move the frame manually so that the design fits in the embroidery area.
222	The frame has traveled right, exceeding the position set by the frame limit	
223	The frame has traveled up, exceeding the position set by the frame limit	
224	The frame has traveled down, exceeding the position set by the frame limit	
225	Travel outside the set embroidery area (When the software frame limit is set, or on cap machines)	
226	Absolute origin limit (+X, -Y) detected	Correct the frame limit position(s)
228	Table up/down operation was attempted although the frame was in the front side position	Move the frame back to the rear most end before moving the table up/down.
234	Faulty laser unit	Turn off power and wait 5 seconds. Turn on power again, if error 234 remains check the laser unit. Check chiller (cooling unit)

242	The-M-axis rotation range (+/-32 rotations) is exceeded when using the M-axis manual rotation function H position	Press the RESET key and then manually rotate the M-axis in the reverse direction. Or, press the RESET key and then start the machine.
251	Low oil in the auto lube pump.	Add oil to the lubrication tank.
252	The status of the air valve (vacuum) does not change	Check the air pressure supplied to the air valve.
253	Lower limit of the laser protect cover is not detected	Check/replace the lower limit sensor, check/adjust air pressure
254	Upper limit of the laser protect cover is not detected.	Check/replace the upper limit sensor, check/adjust air pressure
255 TLFD	A peripheral device is defective	Check the peripheral device and the connection to it.
255 CE	Manual frame travel or frame forward/back is attempted when the Z-axis is not positioned at	Set the Z-axis to H position
272	Manual nipple lifting is performed during coiling embroidery	Press the RESET key
281	The target needle position is not detected within 15 seconds after the start of the color change.	Turn the shaft of the color change box to check to see if needle position display is correct. Correct display, action complete. Incorrect display, check color change sensor(s)
291	* Upper thread Breakage is detected * Tension base card is faulty	* Check the upper/under thread * Replace the tension base card
293	Under thread breakage is detected	Check the bobbin thread
2B1	No response is received for 5 seconds since the operation was started using a serial I/F (Serial I/F device is not correctly connected)	* Check connection of serial device (TFD, PC, etc.) * Repair or correct the design data
2B2	TAJIMA code complement error. Same + and	Correct the design data
2B3	Data exists in an end code	Correct the design data
2B4	Code format error (A stitch code does not exist at the third character.)	Correct the design data
2B5	Reading error, stitch data over 5.1 mm	Correct data
2B6	The serial interface is not ready	Set the serial interface to the Communications mode.

2B7	The machine was started or frame forward was performed although data was not input	Perform data set
2B8	When the pre-reading buffer becomes empty	During operation: Lower main shaft speed. During frame forward operation: Wait until all of the design data is read.
2B9	Memory write error	Check the CPU or memory card. Replace if necessary
2BA	Memory capacity Exceeded	Delete unnecessary designs registered in memory
2BB	Frame back exceeded the allowable range	Do not perform further frame back
2BC	*No design is registered in memory *An attempt was made to erase from memory the current design being embroidered *An attempt was made to edit data (clean-upP.4-14) during embroidery	*Register design in memory *To erase from memory a design currently being embroidered, either set another design or data set the same design * Do not edit (cleanup) design during embroidery
2BD	Either a stop code or end code is detected before the 3rd stitch data.	Correct the design data
2BE	Start code and end code are not set to be a pair in satin convers., sequin, and boring code	Set again to make start code and end code be a pair if necessary.
2C1	The machine is started or frame forward/back is executed during setting the panel	Do not attempt to operate the machine while performing setting on the panel
2C2	Incorrect option setting	Set correctly
2C2 TLFD	ON is set for both boring and laser unit)	Set OFF for DSW2-2 boring device and turn on the power after turning it off once
2C3	"Pack" is not designated	Designate packed designs
2C4	The design stitch count is exceeded	Confirm the number of stitches in the design
2C5	An attempt was made to carry out laser processing during laser preheating	Wait until preheating is complete.
2C6	Machine operation was attempted, although the bobbin changer was running	Do not operate bobbin changer when the machine is running.
2CB	The design is too large to be displayed within the designated software frame limit	Reduce the design to be within the designated software frame limit.
2CD	Power supply is turned OFF during design	Rewrite data to the memory

	deletion or edit mode processing	
2CE	Remote interlock activates	Reset the remote interlock
2CF	An immediate stop came in from an external device	Check the external device or the connection to the external device. (TMLG, connector joint 16 JH08
2D1	Initial setting of laser power is not complete.	Complete initial setting of laser power. (Teaching)
_2E3	Power supply has been interrupted during embroidery	Turn ON the power and perform "Power Resume" operation.
311	*Encoder A signal status does not change for 5 seconds *Motor or belt failure	*Check encoder and encoder signal lines *Check the main shaft driver for excitation Check the main motor and belt
312	Encoder z signal status does not change for 5 seconds	*Check the encoder and encoder signal lines
313	Clutch stopper disengaged	Engage clutch stopper
314	Main shaft rotation failure	Check the encoder/encoder signal line, main motor and belt. Main breaker.
316	A main shaft driver error is detected	Replace the main shaft driver unit or mainn shaft motor
317	The take-up lever clutch has received an abnormal signal	Check or replace the joint-25 card.
321	PMD failure	Check driver and motor.
322	An X-axis pulse motor driver error signal is detected	Replace the X-axis driver unit
323	A Y-axis pulse motor driver error signal is detected	Replace the Y-axis driver unit
324	Frame feed output when the needle penetrates the fabric	Decrease the machine operating speed. Check the rotary encoder and encoder wiring.
32A	Hidden Error, usually occurs when the ATH functions.	Set parameter N-23 to 0 mm. If problem continues install software version BD or later. Change IMM card.
32F	Hidden Error	Make sure machine has at least version BD or later. If problem persists, change IMM card.
325	*Absolute origin could not be detected on the X or Y axis *Cap machine origin search error	*Find faulty origin sensor and adjust or replace. * Check cap origin sensor and harness

331	Bobbin Changer error	Check bobbin changer components.
341 CE/LE	D-axis origin error	
341 LG	An M-axis base point signal is not detected	Replace the M-axis base point sensor or its harness.
342	An M-axis PMD abnormal signal is detected.	Check the mechanical parts related to the M-axis for abnormalities. Check/replace the M-axis incremental encoder or M-axis drive assembly.
345	The M-axis clutch driver has received an abnormal signal	Check/replace the joint-25 card.
346	The zig-zag PMD has received an abnormal signal	Check the parts related to the zigzag swing mechanism. After adjustment, reset the machine.
347	An M-axis PMD abnormal signal is detected	Check the parts related to the M-axis for abnormalities. After adjustment, press the RESET key.
352	The sequin driver has issued abnormal signals	Check/replace sequin card.
371 CE/LE	Needle height position error	Check BP card and needle position card
371 LG	Either an upper or lower position signal cannot be input	Adjust the nipple lifter. Check/replace the sensor.
372 CE	ZB Signal error	
372 LG	The nipples do not move more than 1 second	Press the RESET key. Then check/replace the nipple lifting motor and/or the nipple position sensor.
373	The nipple position sensor issued an abnormal signal	Press the reset key. Then change the nipple stroke by using the keys from 1 to 5. and the return key. Check/replace the nipple position sensor.
373 LE	No input to position sensors	
374	Nipple sensor signal abnormality, both inputs have signals	
375	The Z-axis driver (Z-axis release solenoid) has received an abnormal signal.	Check/replace the joint-25 card.
381	*The FX head needle position input data has an error *The FX head needle position signal is not input while the main shaft is rotating	* Set the number of needles at system software correctly. Check/replace color change sensor *Check/replace color change sensor
382	The needle position signal status during	*Check the color change motor and power supply circuit

	color change does not change for 1 second or more	*Check the potentiometer (Needle position sensor)
383	*Incorrect input of needle position *No needle position signal is detected during rotation of the main shaft	*Check the setting for number of needles in the parameter settings *Check the potentiometer (needle position sensor)
383 CE	Control error of the D-axis drive motor	Turn off the power, and then turn it on again. If code 383 is still displayed, replace the head card of the corresponding CE head.
384	No 1 rotation signal is given while the main shaft is running	Check color change sensor(s)
384 CE	Control error of the looper shaft drive motor	Turn off the power, and then turn it on again. If code 384 is still displayed, replace the head card of the corresponding CE head.
385	Lens does not move to the designated position when during lense switching	Check/adjust/replace: compressor pressure, sensor, sensor wiring, electromagnetic valve & wiring, lens fulcrum axis and shaft
385 CE	Z-axis operation failure	Adjust the Z-axis position of the corresponding head.
391 LE	Thread release input signal error	
3A1	The thread trimming driver has issued abnormal signals	Check the thread trimming drive card and/or the joint -21 card.
3A2	Thread trimming output time exceeded	Check/replace joint card
3A6	Incorrect ATH movable knife retract position	Check the position of the ATH movable knife
3A8	A thread holding driver error signal is detected.	Check thread holding inverter LED. If re LED is lit, change the inverter. If not, check the harness.
3B5	Communication error in the controller	Turn ON the power again
3B6	Communication problem	Check connection IDM and LM1 and LU1 cards.
3C1	The power switch was turned on in the state the machine has been stopped by keeping the bar switch pressed to the left	Turn off the power switch, and then turn it on. If code 3C1 is still displayed, check the bar switch and the switch harness.
3D1	There is abnormality in a battery backup signal	Charge the battery by turning on the power of the machine. Check settings, parameters IDM Card, and design settings.
3D1 CE	There is abnormality in a battery backup signal	Charge the battery by turning on the power of the machine. Check master card
3D2	There is abnormality in a battery backup signal	Charge the battery by turning on the power of the machine. Check settings, parameters

		IMM Card, and design settings.
3D3 CE	There is abnormality in a battery backup signal	Charge the battery by turning on the power of the machine. Check master card
3D3	NMI signal error	Check/replace IMM/IDM/joint/CPU and/or harnesses.
3D4	A ROM data check sum is abnormal	Replace the PROM
3D5	There is an abnormality in the RAM data checksum	Reload data to memory, or check/replace the IDM2 card.
3D6	There is abnormality in the program or CPU card The software is not correctly installed.	Check the CPU card, IDM Install software
3D7	There is abnormality in the main shaft motor speed control data	Check/replace the IDM or IMM card
_3E2	The p24R power supply is abnormal	Check/replace the P24R AVR or capacitor. Check/replace joint-25 card.
3F1 CE-100	Improper tension (looseness) error	
3F1 CE-600	Thread tension control failure	Adjust/replace the tension potentiometer
3F2	Improper tension (tightness) error	
3F3	The thread tension release driver has received an abnormal signal	Chek/replace the joint-25 card.
B01	Floppy disk format has an error. The error occurred during read/write operation.	*Format the floppy disk, or use a new formatted floppy disk *Copy other deigns to a new floppy disk and dispose of the old floppy disk.
B02	Floppy disk management information has an error	Copy data of the floppy disk to a new floppy disk and dispose of the old floppy disk.
B03	The write protect window of the floppy disk is open	Close the write protect window
B04	No floppy disk has been inserted	Insert a floppy disk
BC1	Selected design is not found on the floppy disk or no design is registered on the disk	Select other design
BC2	The design number specified as the writing destination already exists on the floppy disk	Change the design number
BC4	Design data was not correctly written from	Retry writing

	the memory to the floppy disk	
BC5	Available capacity of the floppy disk is not sufficient	Use a floppy disk that has enough available capacity Select correct design number: 2DD 1 to 111, 2HD 1 to 223
C01	The FDD is diconnected or faulty	Check the FDD cable and connection. If there is no problem with the connection then replace the FDD unit.
CE1	Communication speed set for the external device connected serially does not match the communication speed set for the machine.	Check the communication speed setting.

Temporary Stops

1B1	Stop due to frame stepping code	These stop codes are not caused by abnormality or failure. Continue operation by pressing the START key or by conducting the frame back/forward operation, or press any operation key (except the manual frame travel keys)
1B2	Stop due to stop code	
1B3	Stop due to end code 1	
1B4	Stop due to thread trimming code	
1B6	Stop due to automatic free setting offset code	
1B5	Stop due to a sequin code.	Manually move the sequin device up/down and then start the machine.
1C1	Stop occurred because bar switch was pressed during frame stepping	Either start the machine or conduct frame back/forward
1C2	Stop by manual ATH operation	Either start the machine or conduct frame back/forward
1D1	Stop at the start of all-head embroidery due to the stop setting	Reatart the machine
1D2	Stop by preset halt	Press return khey to reset the code number
OIL	Halt for lubrication	Supply oil to the necessary parts, and pree the retuen key to reset the code number.

Neo Maintenance Stop

MAINT. REQUIRD One drop of oil As per Inst. Manual	When this messsage is displyed on the screen, supply oil to the specified spots (p. 13 - 7). After lubrication, press the stop button to release the maintenance mode to continue working
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!CAUTION: Grease Cams Take-up, Presser As per Inst. Manual	When this message is displayed on the screen, grease the specified spots (p. 13 - 8). After greasing, press the stop button to release the maintenance mode to continue working
!CAUTION: Grease Cams Take-up, Presser, Trim Needle Case Drive As per Inst. Manual	When this message is displayed on the screen, grease the specified spots (p. 13 - 8). After greasing, press the stop button to release the maintenance mode to continue working