

拼橡筋机

Elastic Jointer

(MB1008A-BR-BAS311HN-03A)

使用说明书

Instruction Manual

常州智谷机电科技有限公司

CHANGZHOU WISDOM & VALLEY ELECTRICAL TECHNOLOGY CO., LTD

在使用本设备之前请先阅读本使用说明书

Please read the operation manual of the touch
screen interface before using the device

请将本使用说明书放在便于查阅的地方保管

Please keep this operation manual of touch screen
interface in convenient place for referenc

版本信息/ Version

2020.03

感谢购买 IMB 工业用缝纫机。

在使用此机器之前，请仔细阅读以下的说明，这样可以更好地帮到您了解此机器的相关操作。

这些说明是根据现行的条例明确阐述了正确的工作方法。

Thank you for purchasing this industrial sewing machine from IMB

Before using this automatic unit, please read the following instructions, which will help you to

understand how the machine operates.

These instructions illustrate the correct working methods to comply with current regulations.

在没有得到IMB授权许可的前提下，此说明书的任何部分是不可以被复制或者转录的。说明书的内容可能被修改，而不需预先通知。

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The contents of this manual may be subject to change without advance notification.

我们将欣然接受各位提出的改进此说明书的任何建议和指示

We are happy to receive suggestions and/or indications on ways we could improve this manual.

本机介绍说明分为三部分，具体请参照《MB1008A-使用说明书》、《MB1008A-零件手册》、《MB1008A-触摸屏界面操作说明》。

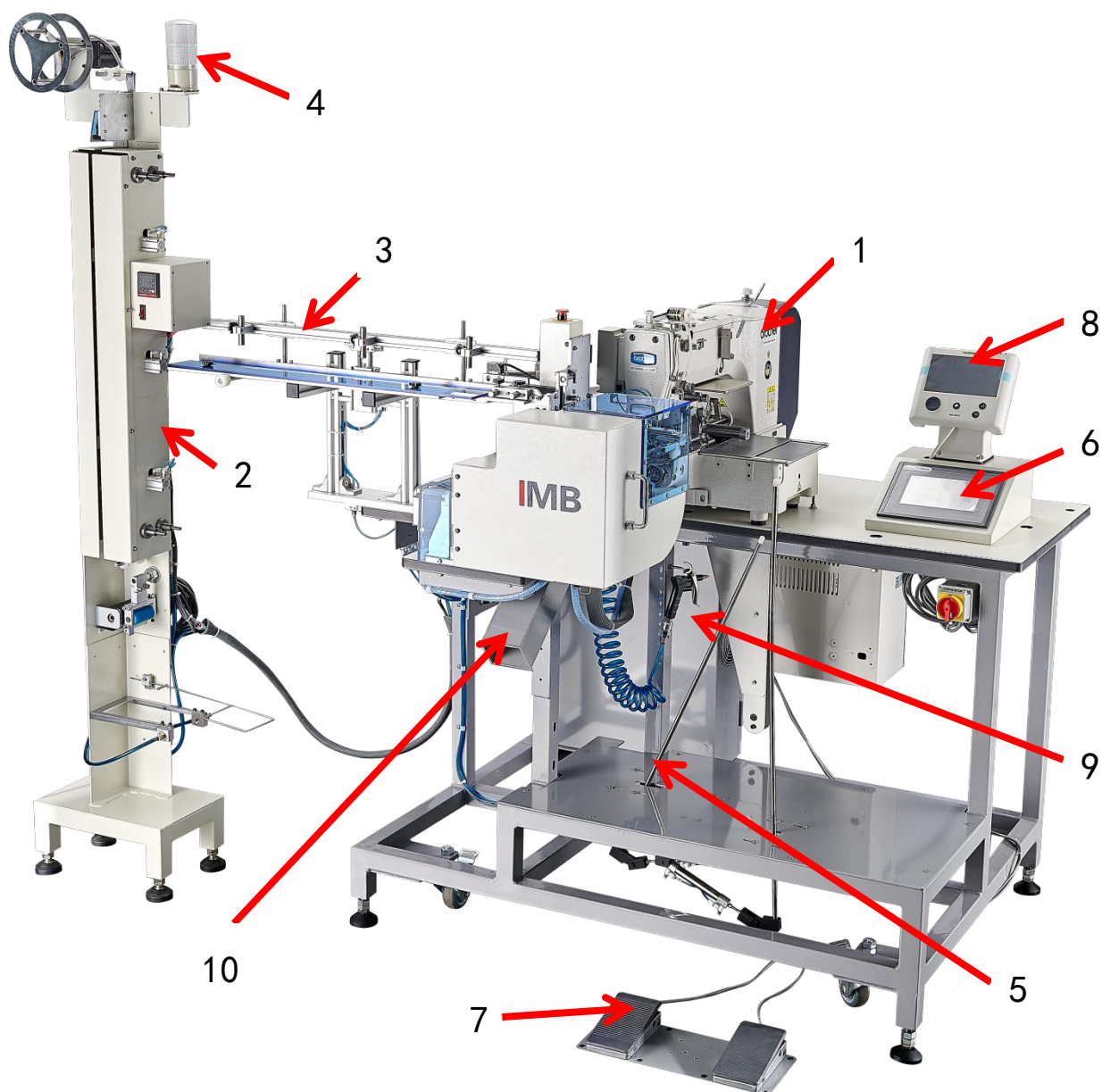
The introduction of this machine is divided into three parts. For details, please refer to 《MB1008A Operation manual》 and 《MB1008A Parts Manual》《MB1008A Touch screen interface operation instructions》

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一、设备基本信息



- 1: BR-BAS-311HN 缝纫机头; 2: 压烫机构; 3: 三眼点位; 4: 警示灯;
- 5: 收料组件; 6: 设备触摸屏; 7: 踏脚板; 8: 机头触摸屏;
- 9: 设备电控箱; 10: 废料漏口;

二、设备技术参数

MB1008A 拼橡筋机		
1	机头配置	brother-BAS-311HN
2	最快缝纫速度/rpm	2800
3	工作电压/V	AC220
4	工作气压/Mpa	0.5
5	缝制针距长度/mm	0.05--12.7
6	标准工时	橡筋宽度15mm, 橡筋长370mm, 针数60 针, 缝制速度2200r/min
7	工作效率	产量857件/小时
8	最短橡筋长度/mm	300
9	最小橡筋宽度/mm	10
10	最大橡筋宽度/mm	50
11	设备尺寸/mm	1750L×1500W×1450H
12	设备重量/kg	287

三、安全注意事项

为了安全地使用自动机的注意事项

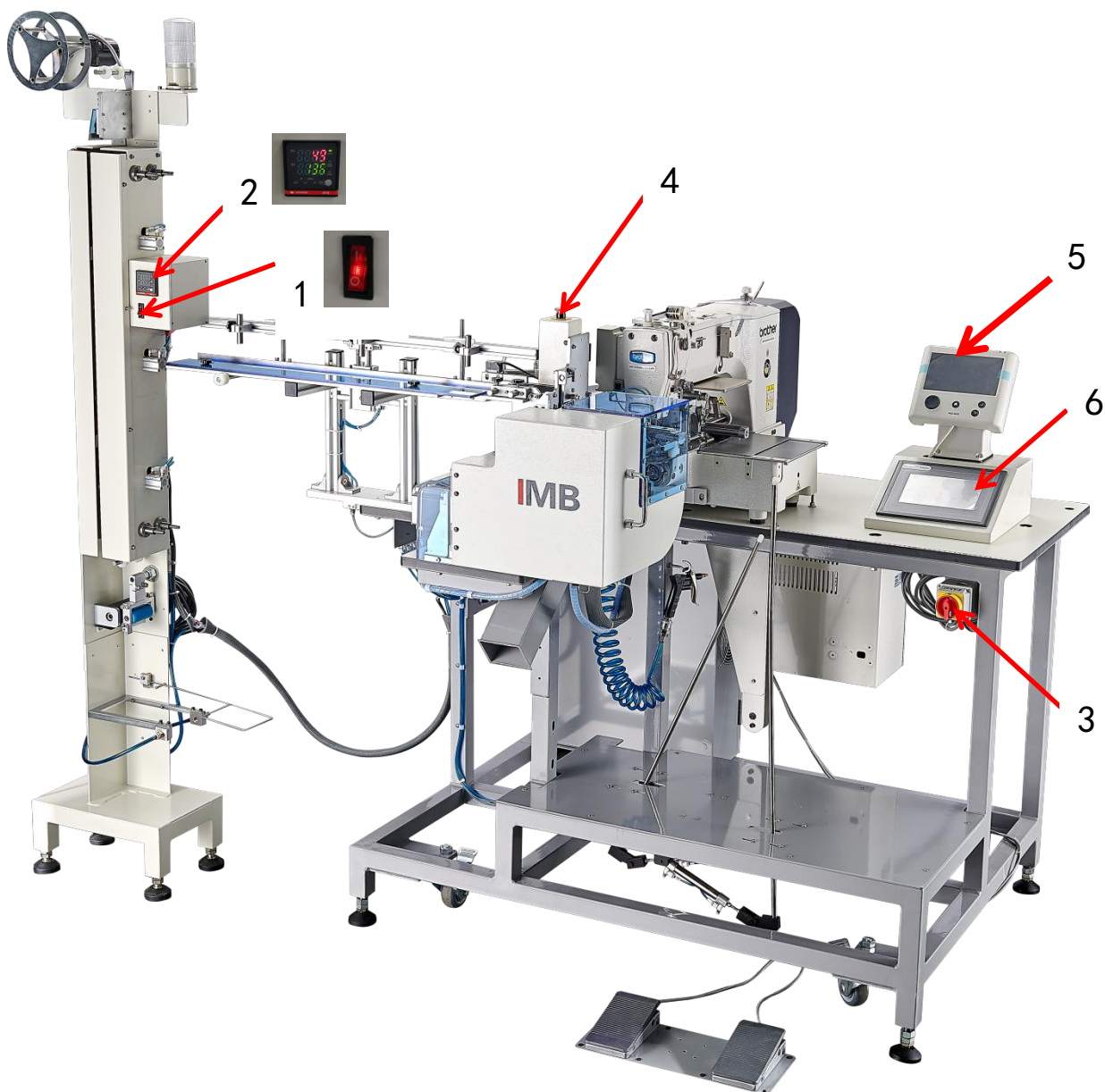
 危险	1. 为了防止因触电造成的事故，在接通了电源的状态下，请不要打开马达电气箱的盖子，也不要触摸电气箱内的零件。
 注意	1. 为了防止对人身的伤害，请不要在卸下了皮带护罩、手指防护器等安全装置的状态下运转机器。 2. 为了防止被卷入机器的人身事故，缝纫机运转中，请不要让手指、头发、衣服靠近皮带轮、V 型皮带、马达附近，也不要物品放到上面。 3. 为了防止对人身的伤害，打开电源时或缝纫机运转中，请不要把手指放到机针附近。 4. 为了防止对人身的伤害，缝纫机运转中，请不要把手指放到挑线杆护罩内。 5. 缝纫机运转时，是以高速转动。为了防止伤害到手，运转中请绝对不要让手靠近切布刀。另外，更换机线时，请一定关闭电源。 6. 为了防止对人身的伤害，缝纫机上下动作时或返回原来位置时，请一定注意不要夹到手指。 7. 缝纫机运转中，请不要切断电源或切断空气供给源。 8. 为了防止突然的起动造成的事故，当准备工作完了，达到可以进行缝制的状态时，请卸下布料导向器。 9. 为了防止因触电造成的事故，在卸下电源地线的状态下，请不要运转缝纫机。 10. 为了防止因触电和电气零件损坏造成的事故，插拔电源插头时，请一定先关掉电源开关。 11. 为了防止因电气零件损坏造成的事故，打雷时，为了安全请停止作业，并拔掉电源插头。 12. 为了防止因电气零件损坏造成的事故，从寒冷的地方立即移动到温暖的地方等时会发生结露现象，因此请待水滴完全干燥之后再接通电源。 13. 因为本产品属于精密机器，所以操作时请充分注意，不要把水、油溅到机器上面，也不要让机器掉落给与机器冲击。 14. 本机器是 A 级工业用机器。在家庭环境下使用此机器的话，有可能发生电波干扰的现象。此时，请使用采取适当的措施解决电波干扰问题。 15. 堆积器动作时关闭了电源开关之后，堆积杆动作，因此请注意不要夹到手指等。

*重要安全信息：

- ✓ 对机器操作不当可能会导致人身伤害，请在操作前仔细阅读本说明并正确操作。
- ✓ 机器正式运行通电前，请先通气。
- ✓ 严禁在通电状态下打开电控箱或触摸屏内部零件。
- ✓ 本机器需要在接受培训后或专人指导下使用，以确保使用者的人身安全。

四、按键功能说明

4.1. 按钮功能说明

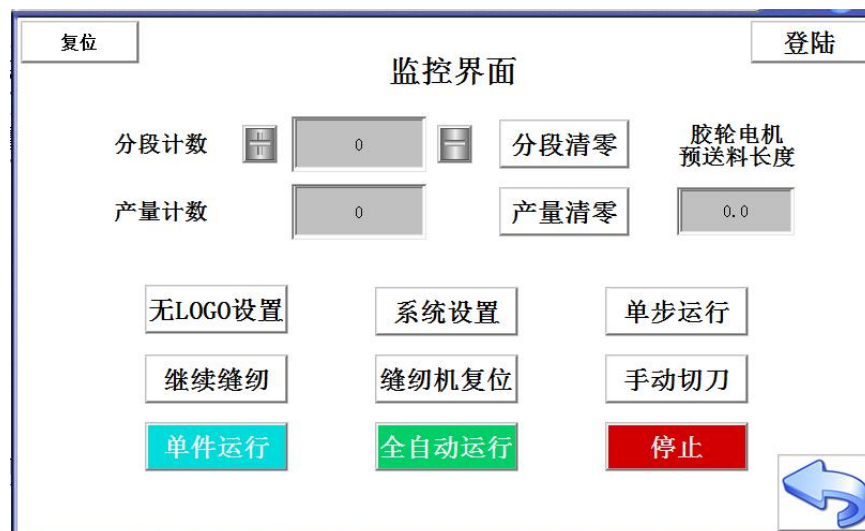


- (1) : 压烫机构电源开关---开启后机构开始加热。
- (2) : 温控表---控制和显示加热温度。
- (3) : 总开关---旋转 90° 后设备通气, 通电。
- (4) : 急停开关---紧急状态下按下此开关, 机械停止动作。
- (5) : 机头触摸屏---详见机头使用说明书。
- (6) : 设备触摸屏---详见《MB1008A 拼橡筋机-界面说明》。

a: 欢迎界面



b: 监控界面



4.2. 复位操作说明

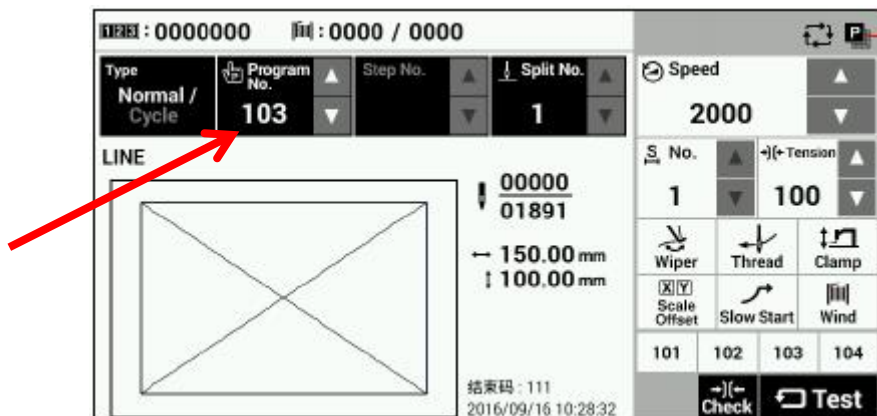
4.2.1 开机复位操作

a. 开启 4.1 (3) 总开关，机头和装置同时自动复位；

b. 检查 4.1 (5) 机头触摸屏上程序号数字是否闪烁（见下图）：

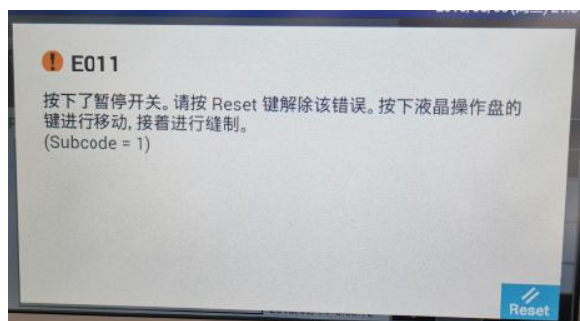
不闪烁：即开机复位完成，设备触摸屏进入欢迎界面 4.1 (6) -a，选择语言进入 4.1 (6) b 监控界面；

闪烁：在设备触摸屏欢迎界面 4.1 (6) -a 选择语言进入 4.1 (6) b 监控界面，按下 **缝纫机复位**，开机复位操作完成。



4.2.2 急停复位操作

状态：机头触摸屏报警，见下图（1）；设备触摸屏报警，见下图（2）；警示灯闪红灯。



(1)



(2)

操作：

①顺时针旋转急停开关至正常位置；

②在机头触摸屏弹出的窗口上按 **Reset** 解除机头报警；

③在设备触摸屏弹出的窗口上按 **复位 RESET** 对设备进行复位。

注意：仅在机头缝纫中断时，在完成②操作后，机头触摸屏会提示是否继续缝纫：

此时按下 YES，再按设备触摸屏上的继续缝纫，设备会继续完成缝纫。

此时按下 NO，缝纫机复位。按下设备屏幕上的复位，装置进行复位。

五、操作说明

5.1. 操作前准备工作

- ✓ 操作人员检查时机头需处于停止状态
- ✓ 检查车缝线是否已经正确穿好
- ✓ 检查机针是否已经安装完成
- ✓ 清理机器台面上的杂物，确保机器运行过程中不会有杂物阻碍运行
- ✓ 检查气压表压力，使其符合机器使用要求

5.2. 操作过程说明

5.2.1 启动设备

a. 90° 旋转电源开关 4.1 (3) 至 ON 位置，设备通电开机。



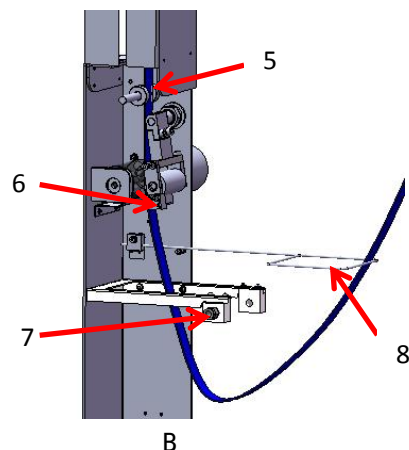
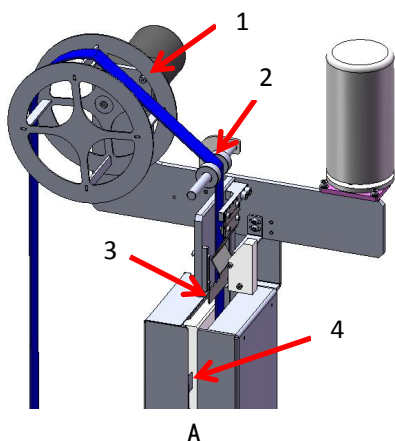
b. 按需要开启压烫开关 4.1 (1) 。橡筋带有折痕可开启压烫装置，无折痕可关闭压烫装置。

5.2.2 复位操作

按 4.2.1 方式进行开机复位操作，下图为复位完成状态。

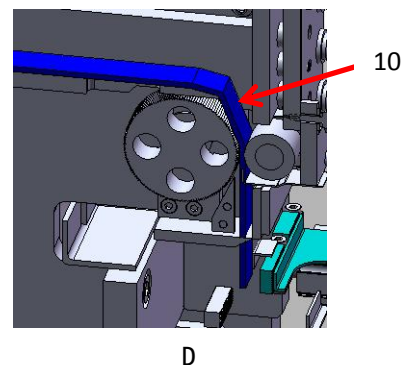
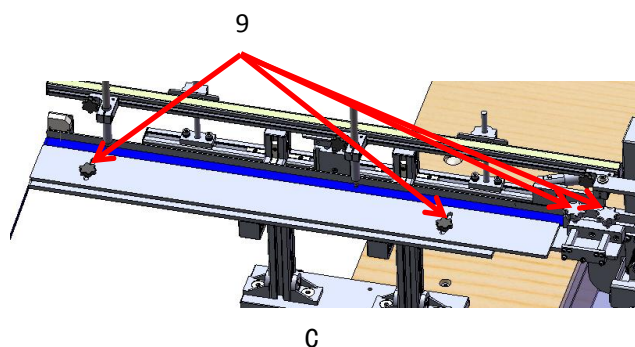


5.2.3 橡筋穿带



a. 将橡筋绕过 1 转盘，通过调整 2 位置的限位辊轮将橡筋夹紧，推开 3 位置的触发板后让橡筋落入 4 压烫板之间，见图 A。

b. 通过调整 5 位置的限位辊轮将橡筋夹紧，推开 6 位置的拨片，穿入 8 拨杆，拉入橡筋使橡筋垂落于 7 感应器之下，见图 B。



c. 橡筋放置于走料板上，通过 9 手旋螺钉，调节挡板的前后位置，使橡筋在送料时保持适当压紧，见图 C。

d. 橡筋穿过压轮，并超过切刀的位置后按下 4.1 (6) -b 监控界面的 手动切刀，切除余料后穿带完成，见图 D。

5.2.4 设置橡筋长度

(1) 在 4.1 (6) -b 监控界面按下 无LOGO设置，打开如下界面

无LOGO参数设置

A橡筋长度:	0mm	A橡筋数量:	0
B橡筋长度:	0mm	B橡筋数量:	0

补偿长度

↩

(2) 橡筋长度和数量设置

可设置两种不同规格的橡筋，并设置不同规格下橡筋的生产数量，即在 A 橡筋按数量生产完成后，警示器闪红灯提示，界面提示缝纫完成（见下图），按下“继续缝纫”，警示灯转为绿灯。同时设备根据 B 橡筋设置参数进行生产，并转换收料杆收料，依次循环。



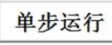
- *1. 如 2 根收料杆在按参数设置中橡筋数量均已完成未取出，警示灯闪红灯提示，设备停止运行。
- 2. 在缝制橡筋过程中，出现故障导致单个或数个橡筋出现缝制问题，需要手动增减橡筋数量，可按下 4.1 (6) -b 的“分段计数”增、减调整计数数量（见下图）。



(3) 补偿长度

不同规格的橡筋，因为材料、弹性等因素，会出现橡筋实际长度与设置长度不符合的现象。可根据实际情况，通过补偿长度进行余量补偿。补偿值可以设置为负数。

5.2.5 缝制运行

按 4.1 (6) -b 监控界面  点动测试机器运行，确认运行无误和产品尺寸无误。按

 或  进行生产。

5.2.6 关机

操作完毕，90° 旋转电源开关至 OFF 位置，设备关机，按下压烫开关关闭压烫机构。

***脚踏板作用：机头可进行独立缝纫，左脚踏抬压脚，右脚踏机头缝制，可用于手工处理一些断料。**

六、调试方法

6.1. 换带操作

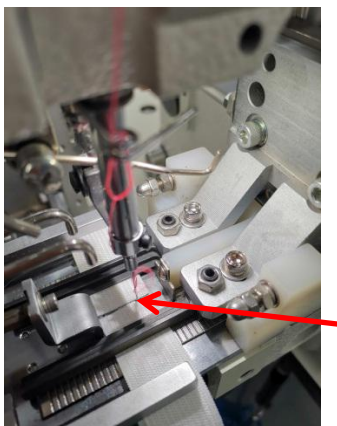
6.1.1 程序号选择：

根据橡筋宽度及所需缝制参数，选择机头触摸屏 6.1（5）里的对应程序号 。见下表：

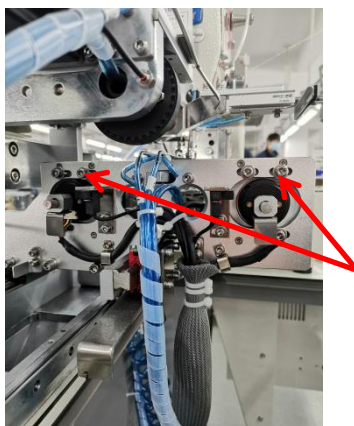
程序编号	针数	长	宽
110	107	8	10
120	167	8	20
130	227	8	30
140	287	8	40
150	347	8	50
210	84	8	10
220	125	8	20
230	173	8	30
240	287	8	40
250	263	8	50
310	71	8	10
320	113	8	20
330	149	8	30
340	185	8	40
350	221	8	50
410	53	8	10
420	77	8	20
430	108	8	30
440	132	8	40
450	162	8	50
510	42	8	10
520	66	8	20
530	85	8	30
540	102	8	40
550	126	8	50

6.1.2 换带调整:

- ① 按 5.2.3 的“橡筋穿带”步骤更换穿带。

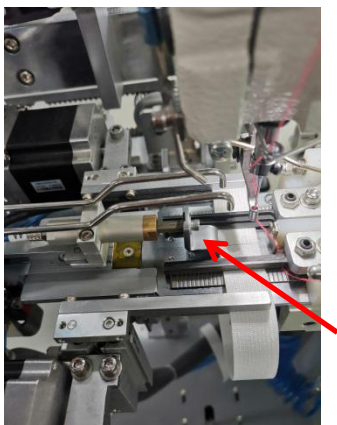


E



F

- ② 调整后连续按 b 监控界面的 单步运行，当运行至如图 E 待缝步骤时，查看机针是否对齐于拼接的接口。如果机针不在接口位置可通过调节电机的安装螺钉使之逢中。



I



J

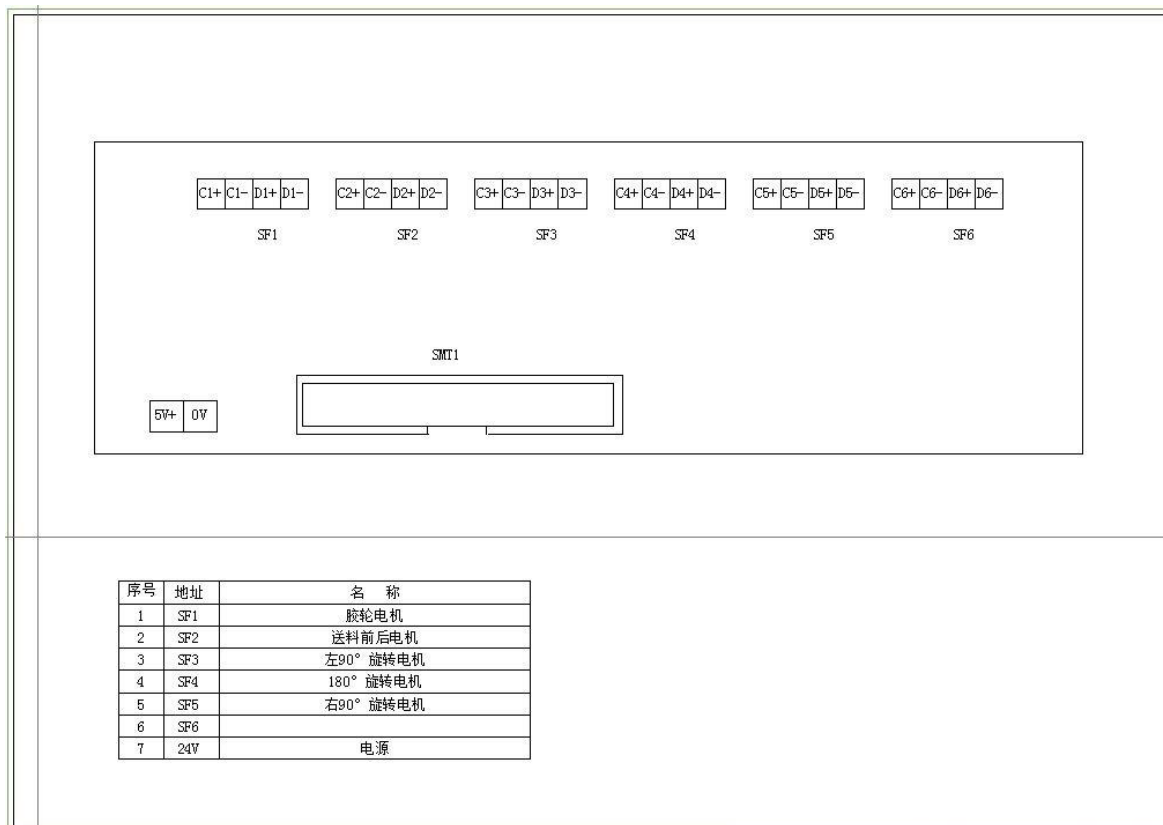
- ③ 通过（图 J）调节挡料滑板的前后位置，使之前端的限位（图 I）贴紧橡筋两头的边。



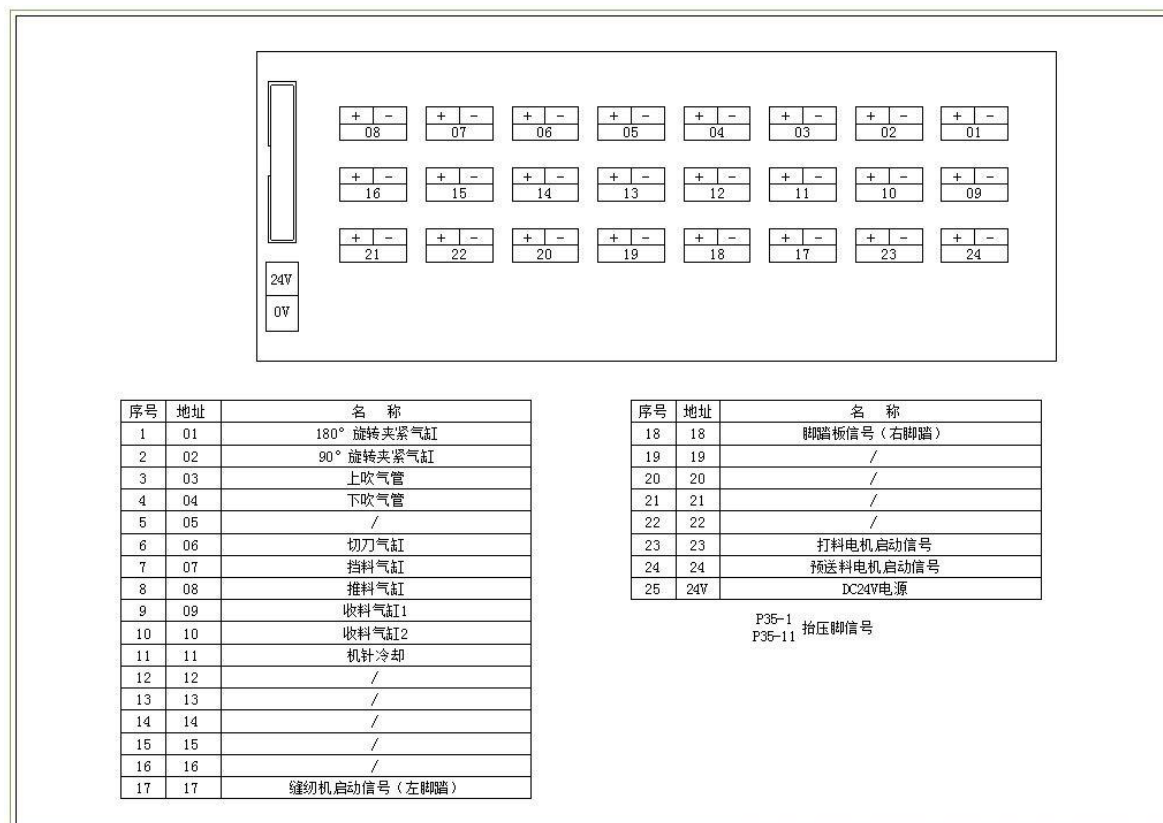
- ④ 调节吹气管的前后位置与气压大小，使吹气管能够吹紧橡筋。

七、电气配线

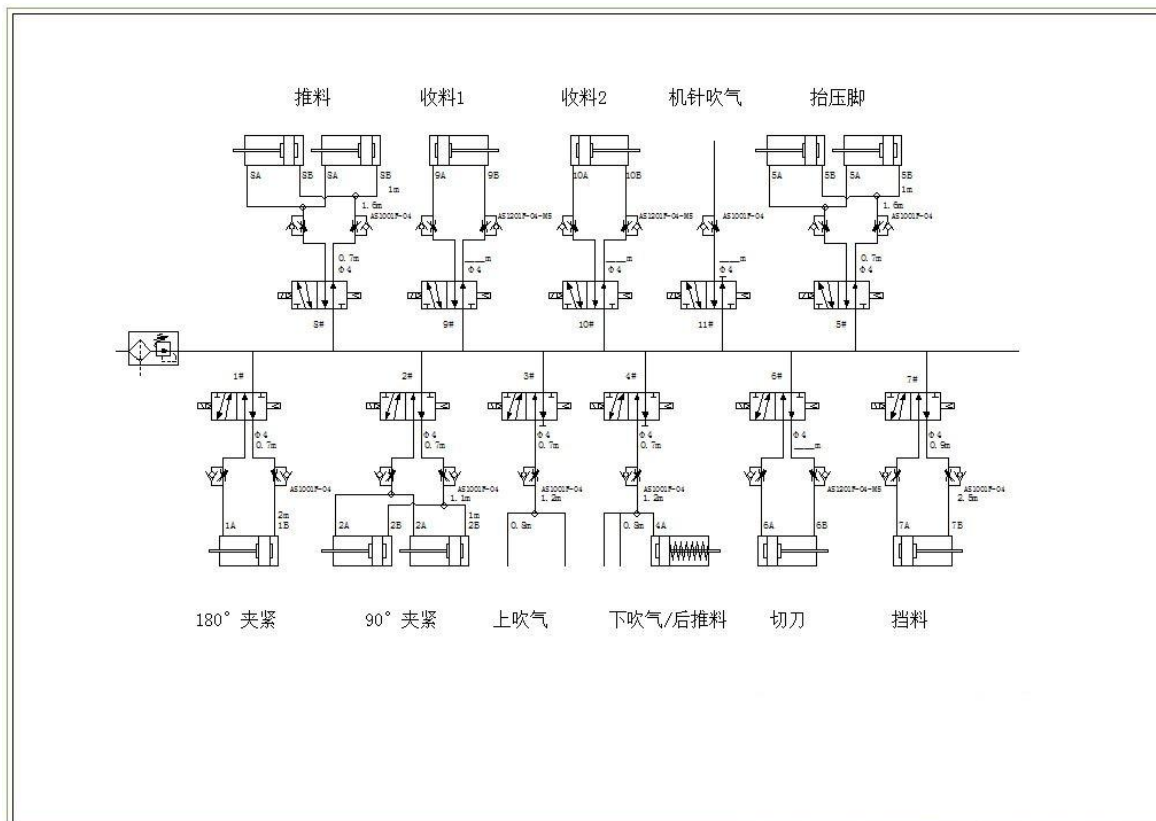
7.1. 电机板：



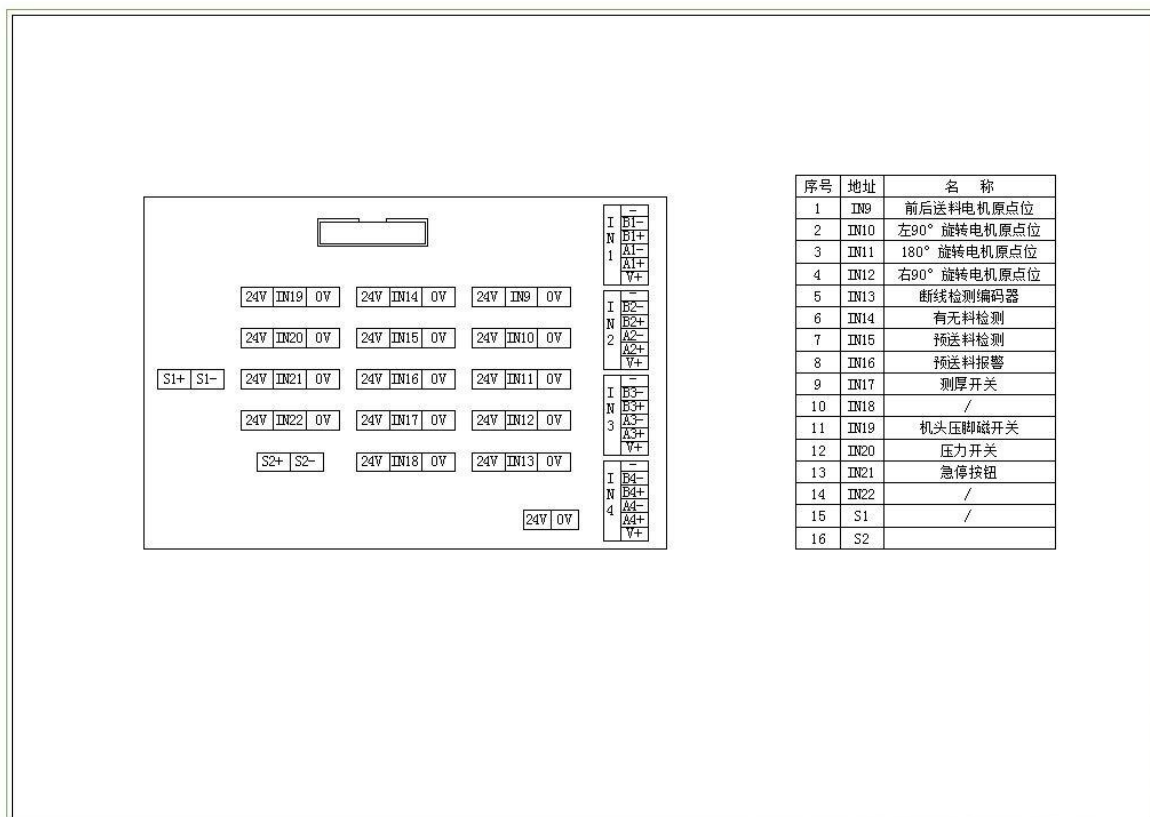
7.2. 输出板：



7.3. 气控图：



7.4. 输入板：



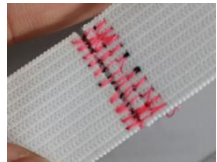
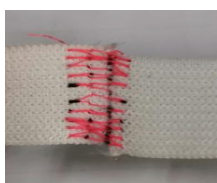
八、附件箱明细

序号 Serial Number	物料代码 Figure Number	物料名称 Name	数量 Number	备注 Remarks
1		线架	1	机头原配件
2		护眼板	1	机头原配件
3		说明书	1	机头原配件
4		机油	1	机头原配件
5		锁芯	1	头原配件已安装
6		线架衬套	1	机头原配件
7		线架说明书	1	机头原配件
8		笔	3	

九、常见问题及解决方法

10.1. 常见问题及解决方法详见下表

10.2. 其他更多页面问题，请见《MB1008A-触摸屏界面操作说明》

现象	图片	原因分析	解决措施
接头堆叠		胶轮电机预送料长度偏长	减少预送料长度
接头间隙		胶轮电机预送料长度偏短	增加预送料长度
接头前后错位		脚轮歪斜或 180° 气缸歪斜	查看并调整脚轮与气缸的安装
橡筋褶皱		1. 压烫机构未开启; 2. 压烫机构温度低;	1、开启压烫机构。 2、调高压烫温度。
吹气管不能将橡筋吹紧在平面上		吹气压力不够	调大吹气管的流量
切料不断		切刀刀钝或切刀安装松动	查看并调整切刀安装

十、日常保养要求

11.1. 设备保养清单及要求详见下表

11.2. 其他更多关于机头的保养要求请参照机头说明书

序号	项目	时间				要点描述
		每天	每周	每月	半年	
1	清理灰尘	√				清除设备表面及零部件灰尘
2	清理油污		√			清理台板、针板、梭芯油污
3	气管接口			√		气管接口紧密，不漏气
4	机头油量			√		机头油量不低于警戒线
5	梭芯			√		检查机头梭芯是否刮花
6	感应器				√	检查灵敏度是否准确，位置是否变化
7	滑动件				√	检查滑动件润滑，如有需要则添加润滑剂
8	电控箱				√	散热风扇运转正常，及时清理灰尘
9	压烫机构	√				检查压烫机构，保证压烫板间无异物
10	切刀切口		√			检查切刀切口，保证无缺口和磨损

十一、知识产品保护声明

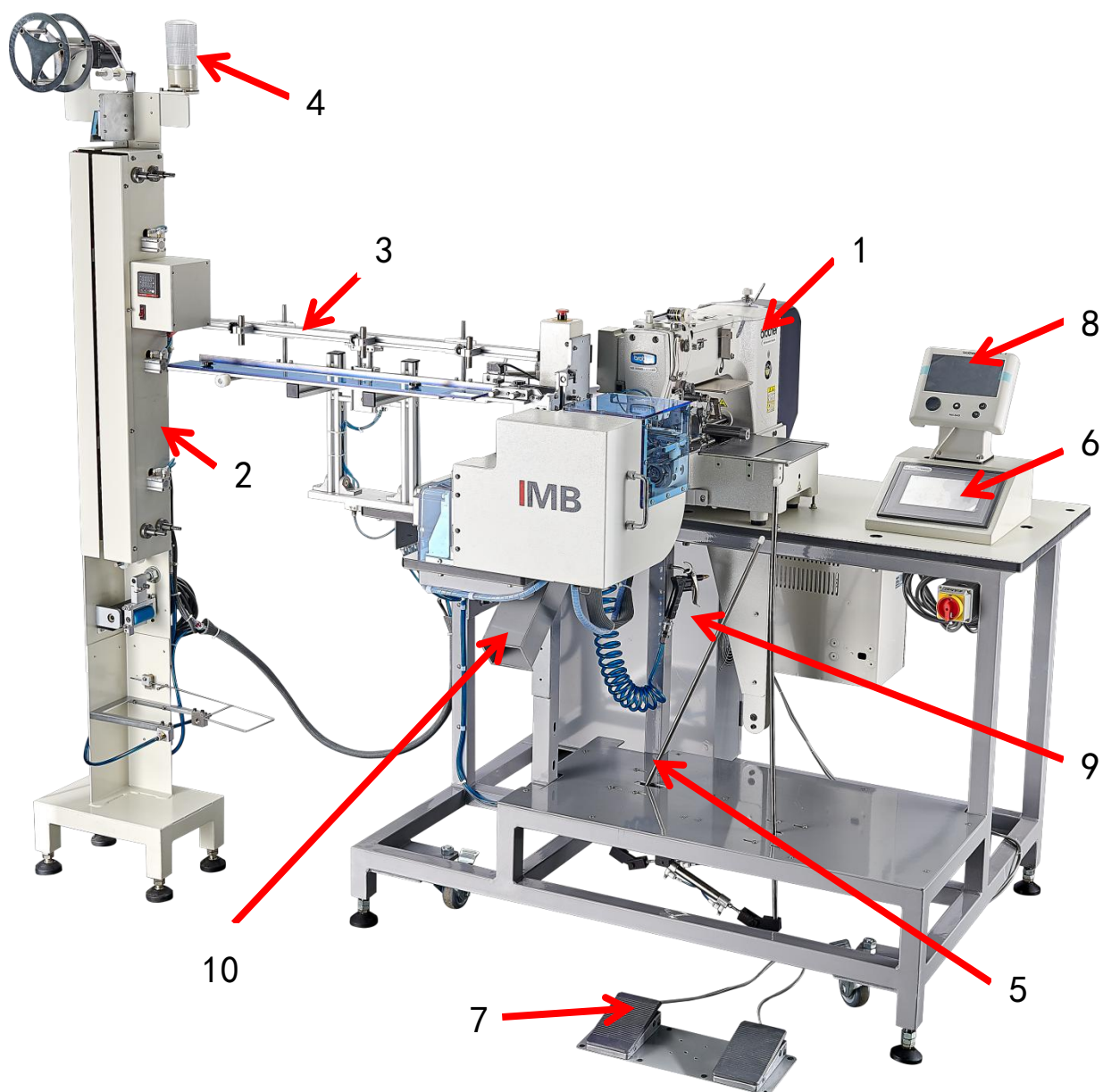
MB1008A 拼橡筋机是常州智谷机电科技有限公司独立自主完成的设计成果。该成果知识产权属于常州智谷机电科技有限公司，受国家知识产权相关法律法规的保护。未经权利人书面许可，不得实施该成果的专利技术，不得复制、销售或通过信息网络传播和该成果有关的信息。任何违法侵权行为，常州智谷机电科技有限公司将依法追究其法律责任。

ENGLISH

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1、Basic information of the equipment



- | | | | |
|-------------------------------|------------------------|--------------------|------------|
| 1: BR-BAS-311HN Machine head; | 2: Pressing mechanism; | 3: Dot mark; | 4: Warning |
| Light | 5: Stacker; | 6: Touch screen; | 7: Pedal; |
| 8: Machine head touch screen; | 9: Control box; | 10: Waste passage; | |

2、Technical parameters of the equipment

MB1008A Elastic jointer		
1	Machine head	brother-BAS-311HN
2	Maximum sewing speed /rpm	2800
3	Working voltage /V	AC220
4	Working pressure /Mpa	0.5
5	Stitch length /mm	0.05--12.7
6	GST	Width:15mm, length:370mm, Stitches number:60, sewing speed 2200r / min
7	Working efficiency	857 PCS/H
8	Minimum rubber length /mm	300
9	Minimum rubber width /mm	10
10	Maximum rubber width /mm	50
11	Size/mm	1750L×1500W×1450H
12	Weight/kg	287

3、Safety precautions

Considerations for safe use of automata

 危険	1. In order to prevent accidents caused by electric shock, please do not open the cover of the electrical box of the motor or touch the parts in the electrical box when the power is connected.
 注意	1. In order to prevent personal injury, please do not operate the machine in the state of removing the belt guard, finger protector and other safety devices. 2. In order to avoid being involved in the machine's personal accident, please do not let your fingers, hair, clothes near the pulley, v-belt, motor, and do not put items on it during the operation of the sewing machine. 3. To prevent personal injury, please do not put your finger near the needle when turning on the power or running the machine. 4. In order to prevent personal injury, please do not put your fingers in the wire pole guard during the operation of the sewing machine. 5. When the machine is running, it turns at a high speed. To prevent damage to the hand, never let the hand near the cutter during operation. In addition, when changing the cable, please be sure to turn off the power. 6. In order to prevent personal injury, please be careful not to pinch your fingers when the machine moves up and down or when you return to the original position. 7. Please do not cut off the power or air supply while the machine is running. 8. In order to prevent accidents caused by sudden starting, please remove the cloth guide when the preparation work is finished and the sewing state is reached. 9. In order to prevent accidents caused by electric shock, please do not operate the sewing machine when the ground wire of the power supply is removed. 10. In order to prevent accidents caused by electric shock and damage to electrical parts, be sure to turn off the power switch before inserting or unplugging the power plug. 11. In order to prevent accidents caused by damage of electrical parts, please stop the operation for safety when it thunders and pull the power plug. 12. In order to prevent accidents caused by damage to electrical parts, condensation will occur when moving from a cold place to a warm place immediately, so please wait until the water drops dry before switching on the power. 13. As this product is a precision machine, please pay full attention to it during operation, do not splash water or oil on the machine, and do not let the machine fall and give the machine impact. This machine is A class A industrial machine. The use of this machine in the home environment may cause the phenomenon of radio interference. At this point, please take appropriate measures to solve the problem of radio interference. 15. After the power switch is turned off when the accumulator moves, the accumulator lever moves, so please be careful not to clip your finger, etc. 16. When the power switch is turned off during the foot press action, please

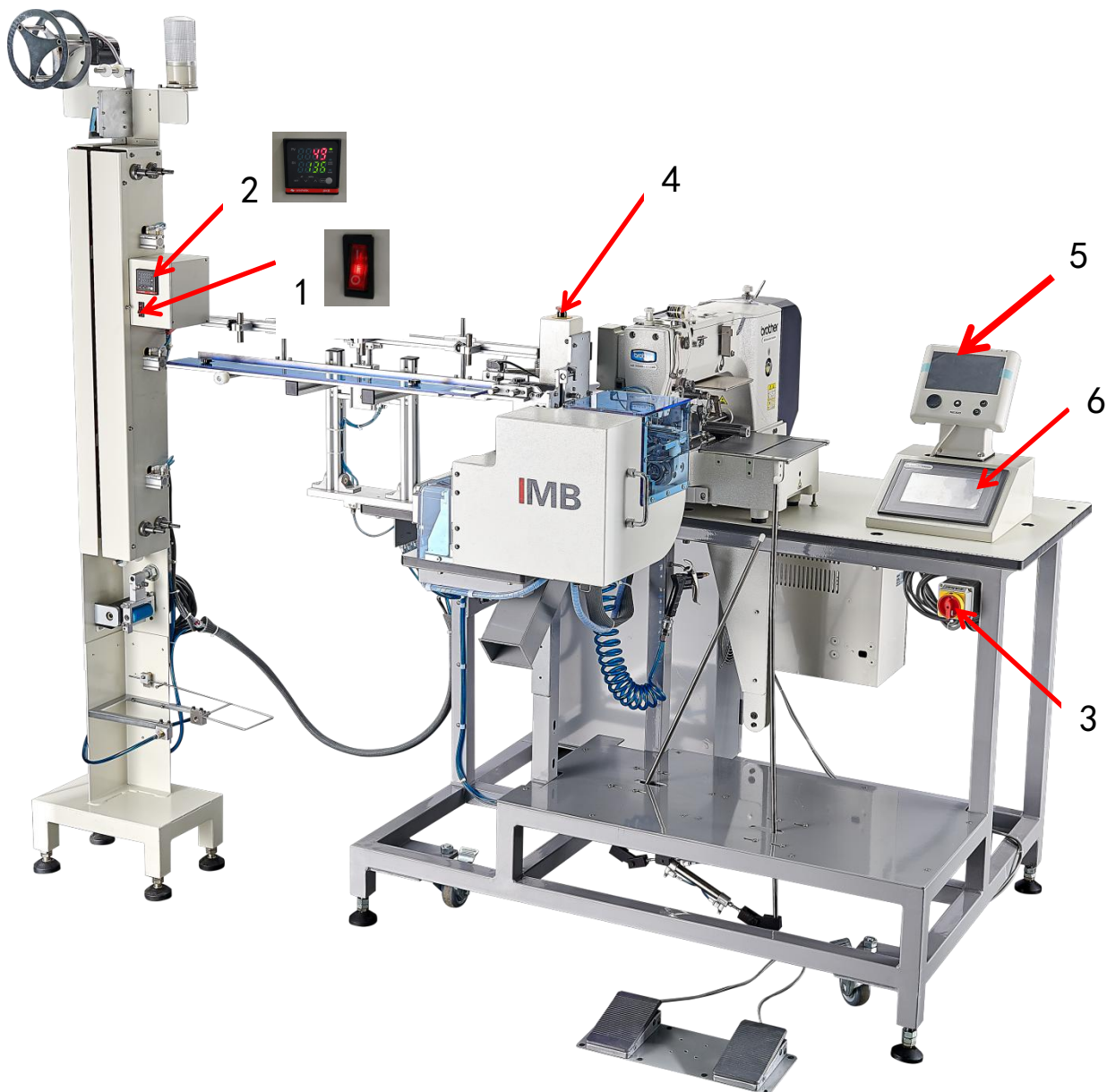
	be careful not to pinch your fingers. 17. During folding operation, please be careful not to clip the cylinder to your finger when putting your finger into the folding machine.
--	--

*** important safety information:**

- ✓ improper operation of the machine may cause personal injury. Please read this instruction carefully and operate correctly before operation.
- ✓ Please ventilate the machine before it is officially powered on.
- ✓ do not turn on the internal parts of the electric cabinet or touch screen while the power is on.
- ✓ this machine should be used after receiving training or under special instruction to ensure the safety of the user.

4、key function description

4.1.Function description of the button

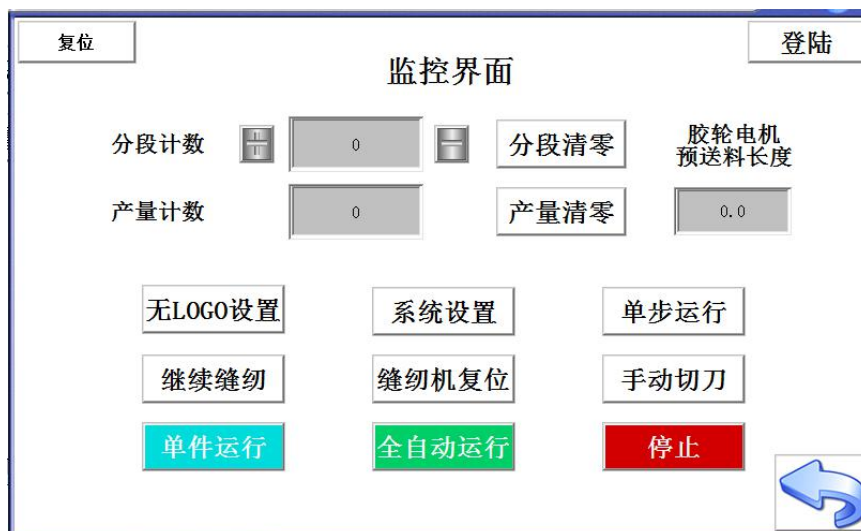


- (1) : Pressing mechanism power switch – the mechanism starts to heat up.
- (2) : Temperature control meter – control and display heating temperature.
- (3) : Main switch: ventilate and power on the equipment after rotating 90 ° 。
- (4) : Emergency stop switch – press this switch in case of emergency to stop the mechanical operation.
- (5) : Head touch screen – see the head operation manual for details.
- (6) : Equipment touch screen--see 《MB1008A interface description》 。

a: Boot interface



b: Monitoring interface



4.2.Reset operation instructions

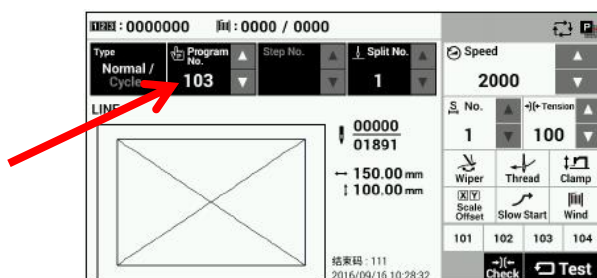
4.2.1 Boot reset operation

a. Turn on the 4.1 (3) main switch, and the head and device will reset automatically at the same time;

b. Check whether the program number on the touch screen of 4.1 (5) head flashes (see the figure below):

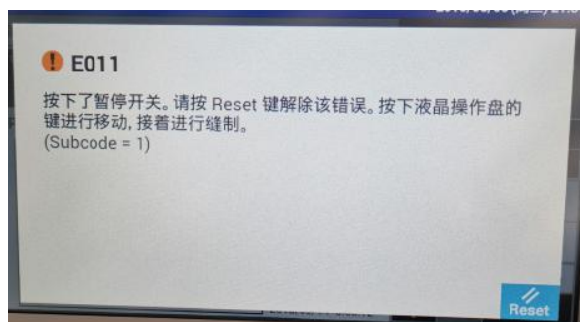
No flashing: that is, the power on reset is completed, the touch screen of the device enters the power on interface 4.1 (6) – A, and the language is selected to enter the 4.1 (6) B monitoring interface;

Flashing: Select language in 4.1 (6) – a of the device touch screen boot interface to enter 4.1 (6) B monitoring interface, Press **缝纫机复位**, Power on reset operation completed.



4.2.2 Emergency stop reset operation

Status: head touch screen alarm, as shown in figure (1); See figure (2) below for equipment touch screen alarm; warning light flashes red.



(1)



(2)

Operation:

- ① Turn the emergency stop switch clockwise to the normal position;
- ② Press **Reset** on the pop-up window of the head touch screen to release the head alarm;
- ③ Press **复位 RESET** on the pop-up window of the touch screen of the device to reset the device.

Note: only when the sewing of the machine head is interrupted, the touch screen of the machine head will prompt whether to continue sewing after ② operation is completed:

At this time, press yes, and then press continue sewing on the touch screen of the device, and the device will continue to finish sewing.

At this time, press no to reset the sewing machine. Press reset on the device

screen to reset the device.

5、Operating instructions

5.1. Preparation before operation

- ✓ The machine head shall be in the stop state when the operator checks it
- ✓ Check whether the sewing thread has been put on correctly
- ✓ Check whether the needle has been installed
- ✓ Clean the sundries on the machine table to ensure that there are no sundries hindering the operation of the machine
- ✓ Check the pressure of the air pressure gauge to make it meet the use requirements of the machine

5.2. Operation process description

5.2.1 Boot device

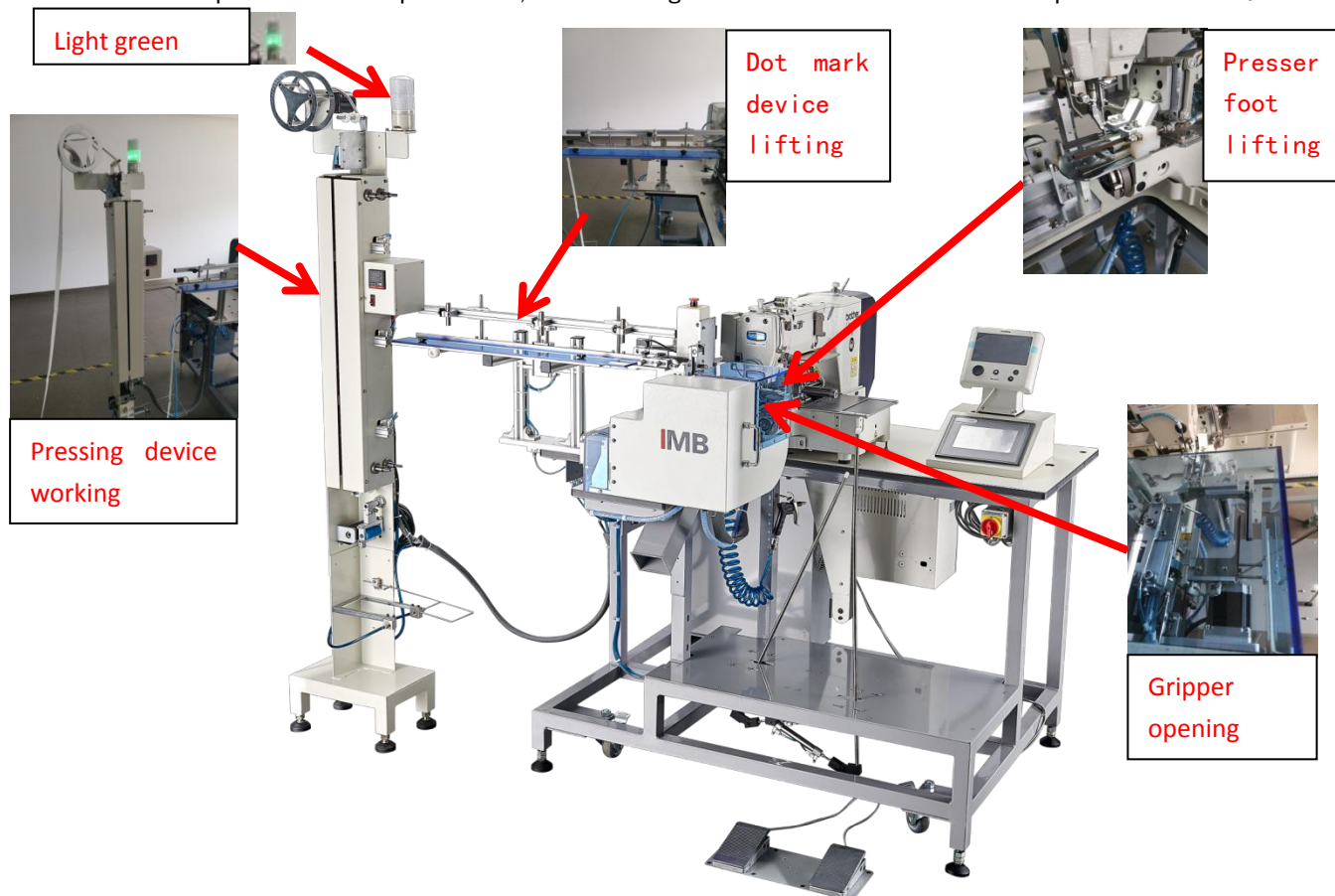
- a. Turn the power switch 4.1 (3) to the on position at 90 ° and power on the equipment.



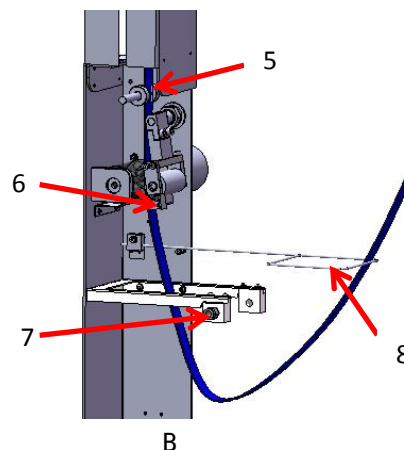
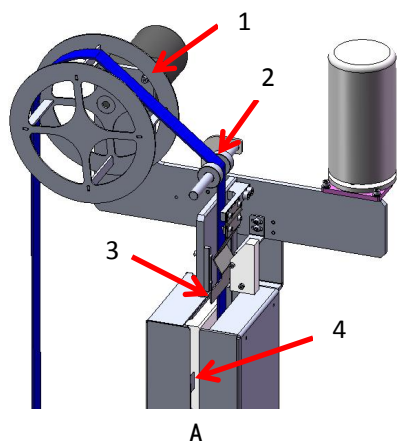
- b. Turn on the pressing switch as required 4.1 (1) . Rubber band with crease can open pressing device, no crease can close pressing device.

5.2.2 Reset operation

Start up and reset as per 4.2.1, and the figure below shows the reset completion status.

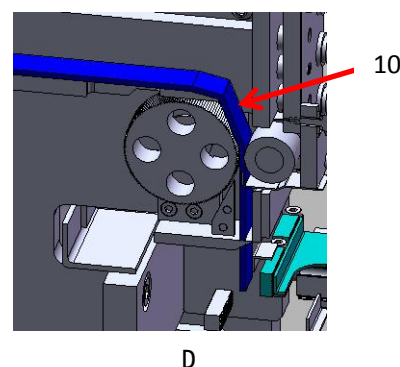
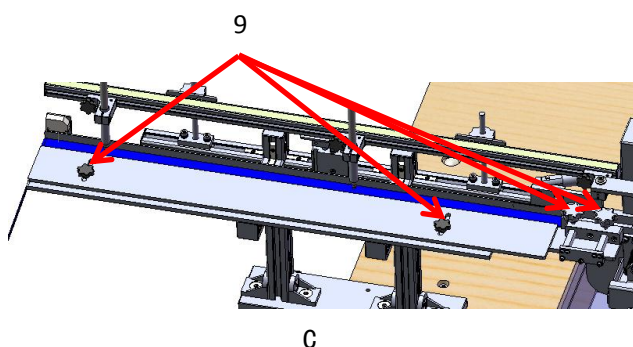


5.2.3 Rubber band threading



a. Pass the rubber bar around the 1 rotary table, clamp the rubber bar by adjusting the limit roller at the 2 position, push the trigger plate at the 3 position and let the rubber bar fall into the 4 pressing plate, as shown in Figure a.

b. Clamp the rubber bar by adjusting the limit roller at position 5, push the paddle at position 6, thread in the 8 paddle, pull in the rubber bar to make the rubber bar fall under the 7 sensor, as shown in Figure B.



c. Place the rubber bar on the feeding plate, adjust the front and back position of the baffle plate by 9 hand screws, so as to keep the rubber bar properly pressed during feeding, as shown in Figure C. .

d. Press the 4.1 (6) – B monitoring interface after the rubber bar passes through the pressing wheel and exceeds the position of the cutter 手动切刀, After cutting the surplus material, the threading is completed, as shown in Figure D.

5.2.4 Set rubber length

(1) Press in 4.1 (6) – B monitoring interface 无LOGO设置, Open the following interface

无LOGO参数设置

A橡筋长度:	0mm	A橡筋数量:	0		补偿长度
B橡筋长度:	0mm	B橡筋数量:	0		0mm

↩

(2) Rubber length and quantity setting

Two kinds of rubber bars with different specifications can be set, and the production quantity of rubber bars with different specifications can be set, That is to say, after the production of a rubber bar is completed according to the quantity, the warning device will flash red light to prompt, the interface will prompt that the sewing is completed (see the figure below), and press "continue



sewing" , The warning light turns green. At the same time, the equipment carries out production according to the setting parameters of B rubber bar, and converts the receiving rod to receive materials, and circulates in turn.

***1. If the number of rubber bars of two receiving rods has not been taken out in accordance with the parameter setting, the warning light flashes red light to prompt, and the equipment stops running.**

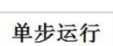
2. In the process of rubber band sewing, the single or several rubber bands have sewing problems due to faults. It is necessary to manually increase or decrease the number of rubber bands, , Press 4.1 (6) -b 的“分段计数” increase  、 decrease  the adjusted count quantity (see the figure below)..



(3) Length adjustment

For rubber bars of different specifications, because of material, elasticity and other factors, the actual length of rubber bars does not conform to the set length. According to the actual situation, the allowance can be compensated by length adjustment. The compensation value can be set to a negative number.

5.2.5 Sewing

Press 4.1 (6) -b Monitoring interface  Jog the test machine to make sure it is running correctly and the product size is correct. Press  or  to Production.

5.2.6 Shutdown

After operation, turn the power switch 90 ° to the off position, turn off the equipment, and press the pressing switch to turn off the pressing mechanism.

*** Foot pedal function: the machine head can be sewn independently, the left foot is used to lift the presser foot, and the right foot is used to sew the machine head, which can be used to handle some broken materials manually.**

6、Debugging method

6.1. Rubber changing operation

6.1.1 Program number selection:

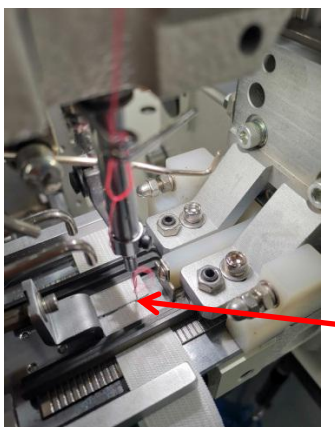
Select the corresponding program number in the head touch screen 6.1 (5) according to the

rubber band width and the required sewing parameters . See table below. :

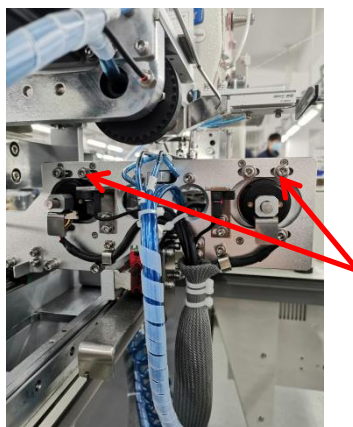
Program number	Stitch number	Length	Width
110	107	8	10
120	167	8	20
130	227	8	30
140	287	8	40
150	347	8	50
210	84	8	10
220	125	8	20
230	173	8	30
240	287	8	40
250	263	8	50
310	71	8	10
320	113	8	20
330	149	8	30
340	185	8	40
350	221	8	50
410	53	8	10
420	77	8	20
430	108	8	30
440	132	8	40
450	162	8	50
510	42	8	10
520	66	8	20
530	85	8	30
540	102	8	40
550	126	8	50

6.1.2 Rubber adjustment:

- ⑤ Replace the belt according to the steps of "rubber band threading" in 5.2.3.

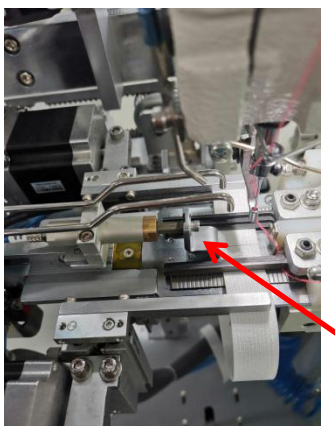


E



F

- ⑥ After adjustment, press 单步运行 of B monitoring interface continuously , When running to the step to be sewn as shown in Figure e, check whether the needle is aligned with the spliced interface. If the needle is not in the interface position, adjust the mounting screw of the motor to make it meet.。



I



J

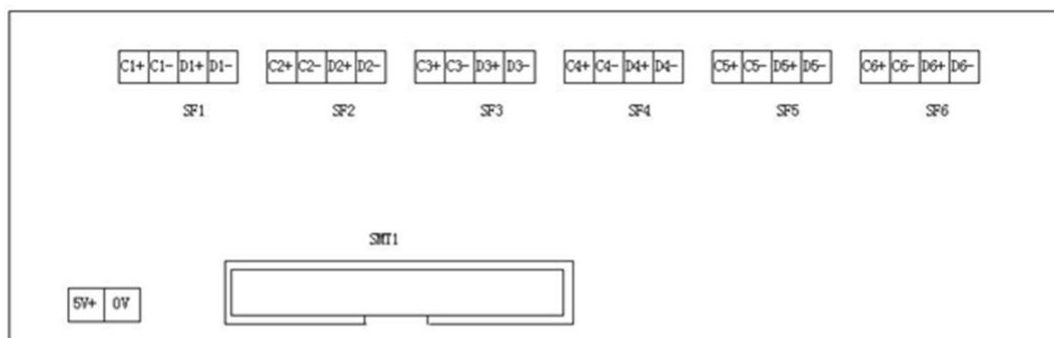
- ⑦ Adjust the front and rear positions of the material blocking slide plate through (Fig. J) so that the front limit (Fig. I) is close to the edge of both ends of the rubber rib.



- ⑧ Adjust the front and back position and air pressure of the air blowing pipe, so that the air blowing pipe can blow tight the rubber band.

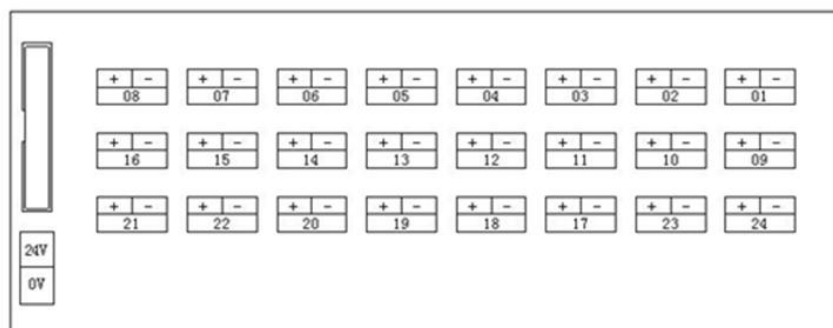
7、Electrical wiring

7.1. Motor board:



No.	PORT	NAME
1	SF1	Wheel motor
2	SF2	Feeding motor
3	SF3	90° left motor
4	SF4	90° right motor
5	SF5	90° right motor
6	SF6	
7	24V	Power

7.2. Output board:



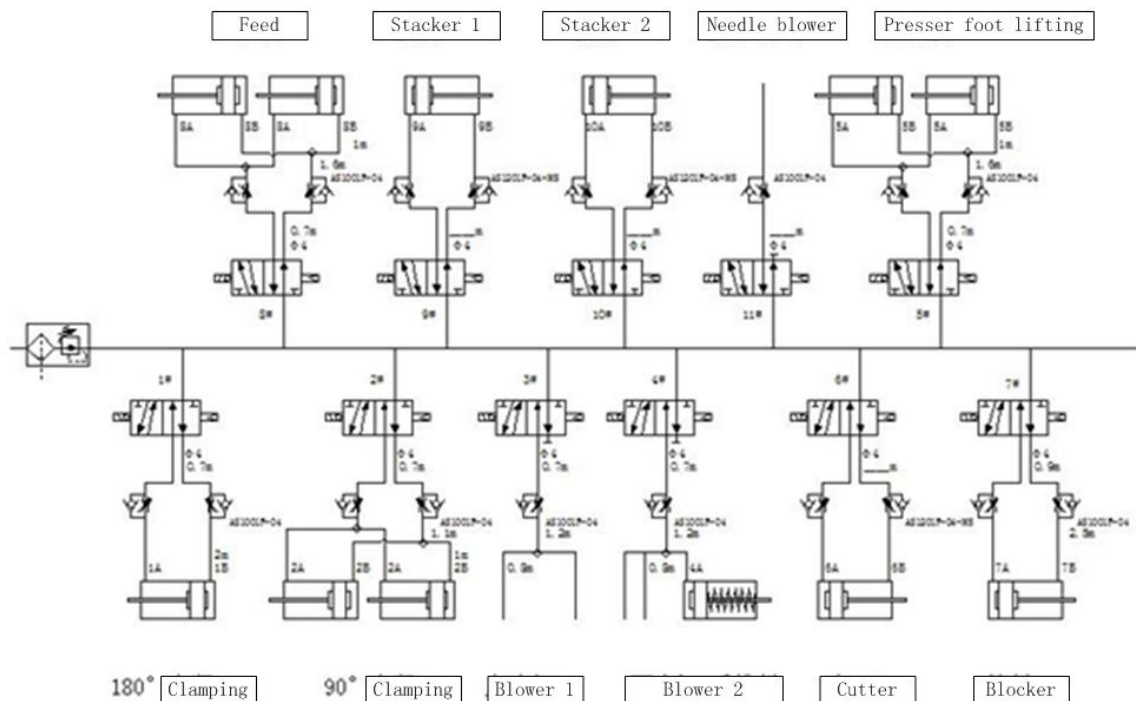
序号	地址	名称
1	01	180° Rotating Cylinder
2	02	90° Rotating Cylinder
3	03	Tube 1
4	04	Tube 2
5	05	/
6	06	Cutter cylinder
7	07	Block cylinder
8	08	Feeding cylinder
9	09	Stacker Cylinder 1
10	10	Stacker Cylinder 2
11	11	Needle cooler
12	12	/
13	13	/
14	14	/
15	15	/
16	16	/
17	17	Left Pedal

序号	地址	名称
18	18	Right Pedal
19	19	/
20	20	/
21	21	/
22	22	/
23	23	Feed Motor
24	24	prefeed Motor 2
25	24V	DC 24V Power

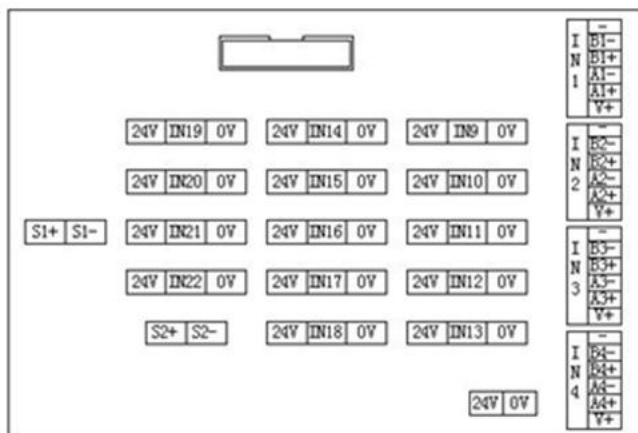
P35-1
P35-11

Presser foot

7.3. Air control chart:



7.4. Input board:



序号	地址	名称
1	IN9	Feed Motor
2	IN10	90 Left motor 1.2
3	IN11	180 rotating motor
4	IN12	90 right motor 1.2
5	IN13	Thread breaking encoder
6	IN14	Rubber detector 1
7	IN15	Prefeed detector
8	IN16	Alarm
9	IN17	Switch 1
10	IN18	/
11	IN19	Switch 2
12	IN20	Switch 3
13	IN21	Emergency stop button
14	IN22	/
15	S1	/
16	S2	/

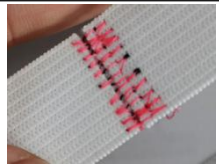
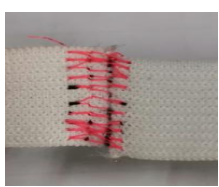
8、Accessories box details

NO	ITEM		QTY
1	《Instruction manual》		1
2	《Parts Manual》		1
3	《Touch screen interface operation instructions》		1
4	Slotted screwdriver	5*300mm	1
5	Wrench	1.5—6mm	1

9、Common problems and Solutions

10.1. See the table below for common problems and Solutions

10.2. More questions, See 《MB1008A- Touch screen interface operation instructions》

Fault phenomenon	Image	Cause Analysis	Solutions
Joint stacking		The pre feeding length of rubber wheel motor is too long	Reduce prefeed length
Joint clearance		Short pre feeding length of rubber wheel motor	Increase prefeed length
Joint dislocation		Caster deflection or 180 ° cylinder deflection	View and adjust caster and cylinder installation
Rubber band wrinkle		1. Press not on; 2. Low press temperature;	1、Turn on the press。 2、Adjust the high-pressure ironing temperature。
The blowing air pipe cannot blow the rubber band tightly on the plane		Insufficient blowing pressure	Increase the flow of the blowing pipe
The material is not broken.		Blunt cutter or loose cutter installation	View and adjust cutter installation

10、Daily maintenance requirements

11.1. See the following table for the list and requirements of equipment maintenance

11.2. Please refer to the machine head manual for other maintenance requirements

NO	Project	Frequency				Requirement
		Daily	Weekly	Monthly	Half year	
1	Clean up the dust	√				Remove dust from equipment surface and parts
2	Cleaning up oil pollution		√			Clean the greasy dirt on the table , needle plate and bobbin
3	Air tube interface			√		The air tube interface is tight without air leakage
4	Oil			√		Oil volume not lower than warning line
5	Bobbin			√		Check if the bobbin is scratched
6	Sensor				√	Check if the sensitivity is accurate and if the position changes
7	Slider				√	Check slide lubrication and add lubricant if necessary
8	Electric control box				√	Cooling fan runs normally, clean up the dust in time
9	Press	√				Check the pressing machine to ensure that there is no foreign matter between the pressing plates
10	Cutting edge		√			Check the cutting edge to ensure there is no gap and wear

11、 Knowledge product protection statement

MB1008A Elastic Jointer was designed by Changzhou wisdom & valley Electric Technology Co., Ltd. 。 The intellectual property rights of this achievement belong to Changzhou wisdom & valley Electric Technology Co., Ltd. and are protected by national intellectual property laws and regulations. Without the written permission of the right holder, the patented technology of the achievement shall not be implemented, and the information related to the achievement shall not be copied, sold or disseminated through the network. For any illegal infringement, Changzhou wisdom & valley Electric Technology Co., Ltd. will pursue its legal responsibility according to law.