

双层自动合缝机

Double Layer Side Seamer

(MB3005B-PS-EXT3216H)

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

2020.04

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.

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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《MB3005B 双层自动合缝机-使用说明书》、《MB3005B 双层自动合缝机-零件手册》。

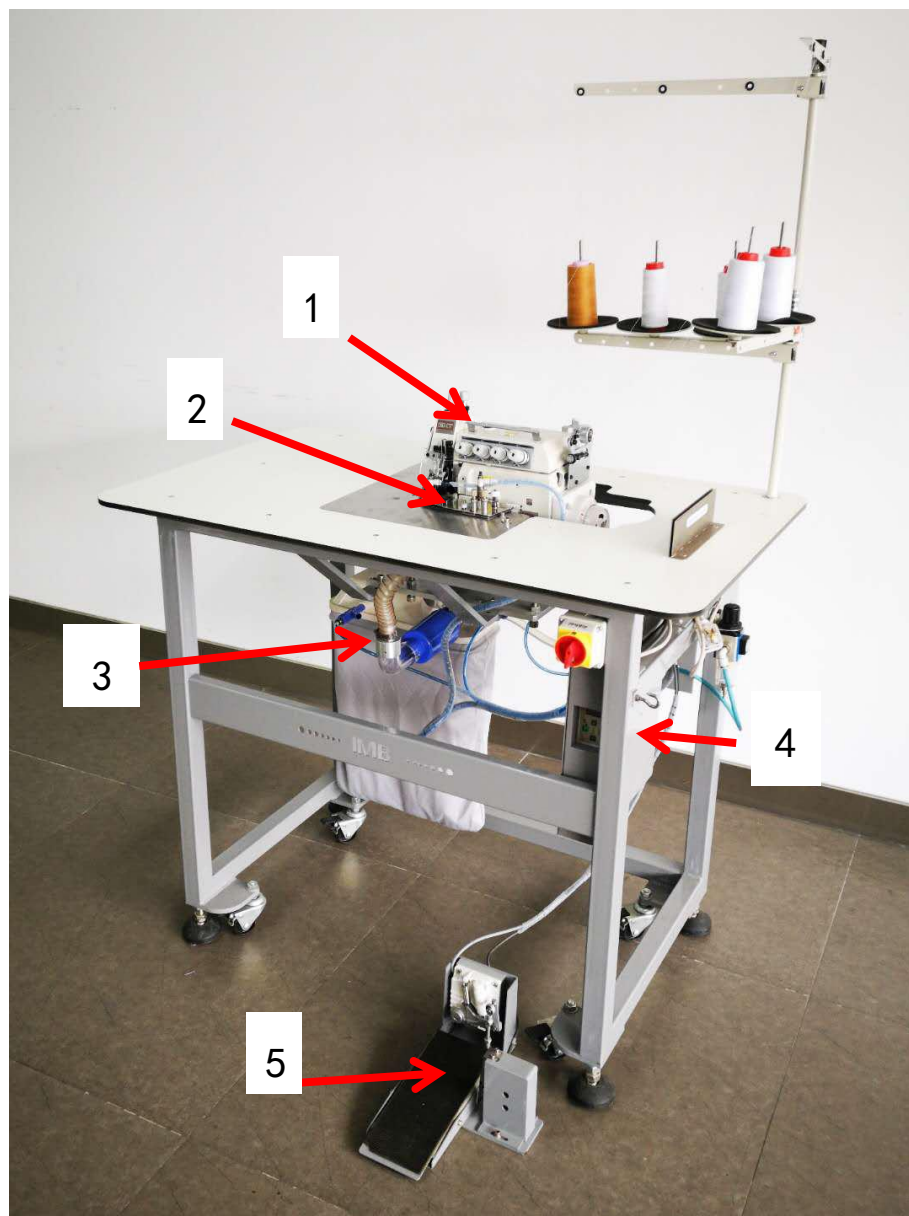
The introduction of this machine is divided into three parts. For details, please refer to 《MB3005B Operation manual》 and 《MB3005B Parts Manual》《MB3005B Touch screen interface operation instructions》

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一、设备基本信息





- 1: PS-EXT3216H 缝纫机头; 2: 合缝机构; 3: 集尘装置; 4: 电控箱;
5: 脚踏板组件;

二、设备技术参数

MB3005B 双层自动合缝机		
1	机头配置	PS-EXT3216H
2	最快缝纫速度/rpm	5000
3	工作电压/V	AC220
4	工作气压/Mpa	0.5
5	缝制针距长度/mm	0-5
6	设备尺寸/mm	1270L×890W×1270H
7	设备重量/kg	95

三、安全注意事项

为了安全地使用自动机的注意事项

 危险	<ol style="list-style-type: none"> 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	<ol style="list-style-type: none"> 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，请使用人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) : 电源开关——旋转 90° 后设备通气，通电。
- (2) : 脚踏板——前踩缝制，后踩压脚抬起。
- (3) : 微动开关——触碰后 1.1-2 合缝机构左移或右移。

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

90° 旋转电源开关 4.1 (1) 至 ON 位置，设备通电开机。

5.2.2 操作过程

a. 裤脚缝至裤腰

- 1) 向后踩 4.1 (2) 脚踏板抬起压脚，将布料放至工作区域，向前踩脚踏板缝至下图所示位置后停止，用脚触碰 4.1 (3) 微动开关，合缝机构向左移动(如下图)；



- 2) 前踩脚踏板缝至下图所示位置后停止，用脚触碰 4.1 (3) 微动开关，合缝机构向右移动；



- 3) 前踩脚踏板缝至下图所示位置后，缝制完成。（注意：因剪线位于送布牙后方，所以裁片需要送至剪线吸风后方，以便于剪线）



b. 裤腰缝至裤脚

- 1) 向后踩 4.1 (2) 脚踏板抬起压脚，将布料放至工作区域，向前踩脚踏板缝至下图所示位置后停止，用脚触碰 4.1 (3) 微动开关，合缝机构向左移动(如下图)；



- 2) 前踩脚踏板缝至下图所示位置后停止，用脚触碰 4.1 (3) 微动开关，合缝机构向右移动，缝制完成。

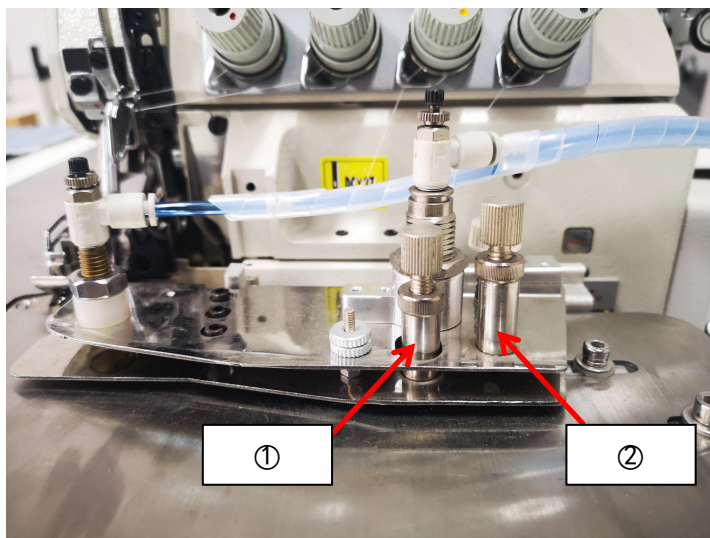


5.2.3 关机

操作完毕，90° 旋转电源开关至 OFF 位置，设备关机。

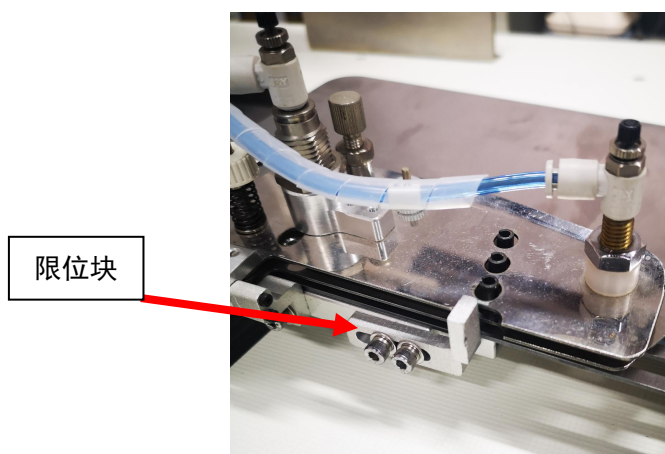
六、调试方法

6.1. 合缝机构上下层间隙



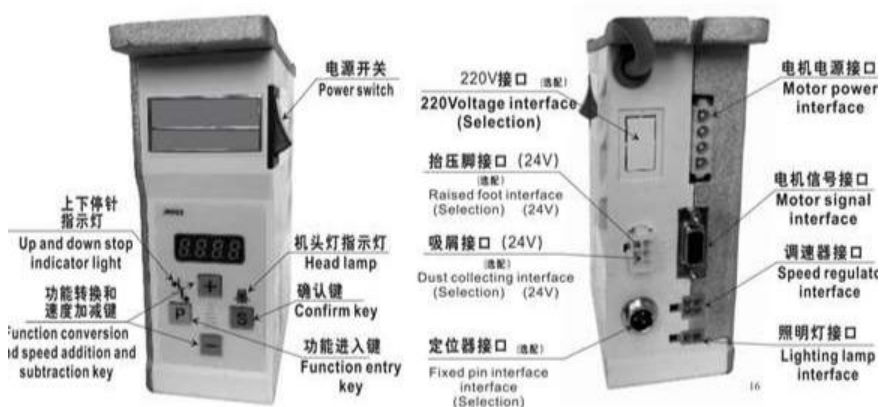
手动旋转滚花手拧螺丝①, 调节下层板与拖布板的间隙, 间隙大小根据底层裁片厚度调节
 手动旋转滚花手拧螺丝②, 调节上层板与下层板的间隙, 间隙大小根据上层裁片厚度调节

6.2. 靠位



根据包边尺寸大小调整限位块左右位置。

6.3. 主轴电机参数调试



1. 各按键的用途: Each key purpose:

1) “P” 键的用途:

- 第一: “P” 键为上、下停针键, 按下“P” 键, 上灯孔亮, 为上针停; 下灯孔亮, 为下针停, 两灯都不亮, 为自由停针;
- 第二: 功能进入键 (见进入参数的操作方法)。

2) “S” 键的用途:

- 第一: “S” 键为机头灯开关键, 按下“S” 键, 当“S” 键上的小灯亮为打开机头灯, 灭为关掉机头灯;
- 第二: 功能参数 (确认) 键 (见进入参数的操作方法)。

3) “+” “-” 键的用途:

此两个键用于转速调整和参数调整。

2. 进入参数的操作方法

例: 怎样把电机的顺时针转调到逆时针转。

第一步: 打开电源;

第二步: 先按“P” 键不放, 同时按“+” 号键, 此时画面会显示 P-00;

第三步: 按“+” 号键, 把 P-00 调至 P-02, (P-02) 就是点击正反转参数 (常用参数表上有标明);

第四步: 按下“P” 键画面会显示 1;

第五步: 按下“-” 号键把“1” 调到“0” (“1” 为顺时针转, “0” 为逆时针转, 常用参数表上有标明);

第六步: 按下“S” 键确定参数调整完成。

3. 恢复出厂设置

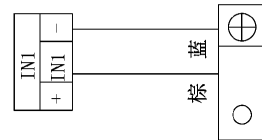
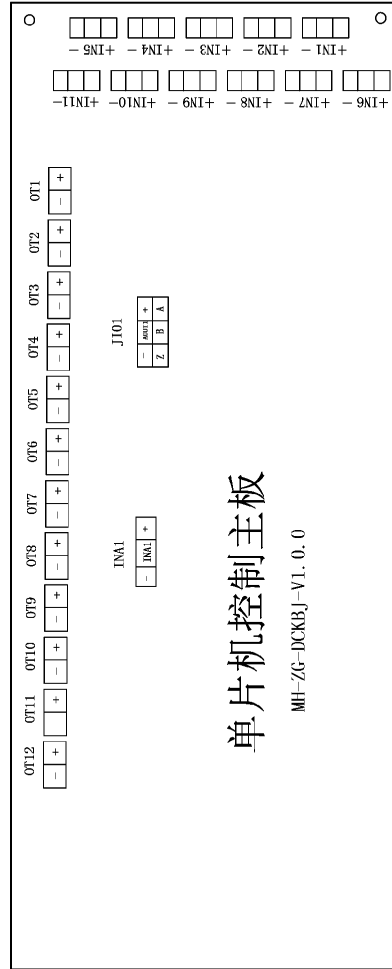
恢复出厂设置方法: 先按“P” 键不放, 同时按“+” 号键, 此时画面会显示 P-00, 再长按“S” 键约 3 秒即可。

4. 电机常用参数设置

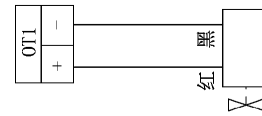
序号 The serial number	参数编号 Parameters name	参数名称 The Parameters name	参数范围 Adjusting rang	出厂设置 The factory reset settings	备注 Remark
1	P-01	最大速度锁定 Maximum Speed lock	200-6500RPM	4500 转	
2	P-02	电机方向 Direction of rotation	0 是逆时针 0 is reverse turn needle 1 是顺时针 1 is clockwise turn	1	
3	P-04	起缝速度 Start sewing speed	200-800 转	250 转	
4	P-05	加速快慢 Speed up And slow	2000-4000 转	3000 转	
5	P-06	定针缝 Set the seam	0-999 针	0	
6	P-10	自动间隙运行 (跑和) Automatic clearance run(run)	把 0 改成 1 再按 S 键 Press the S key change 0 to 1	0	
7	P-11	抬压脚启动时间 Presser foot ascend starting time	0-2000ms	0	
8	P-12	抬压脚保持时间 Ascension presser foot keeptime	1-120s	5s	
9	P-14	最大电流限制 Maximum current limiting	50-450	300	
10	P-15	是否检测上针位 The location of the needle	1: 检测针位, 0: 不检测 1: detecting needle 0: no detection	1	

七、电气配线

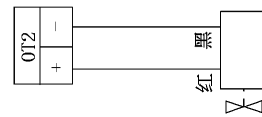
7.1. 电控板:



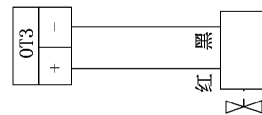
踏板微动开关



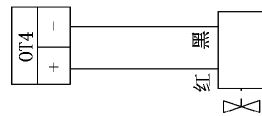
压板阀



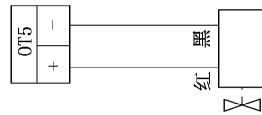
吹气阀



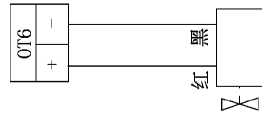
压板移动阀



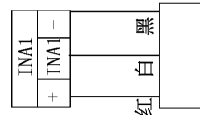
收尘阀



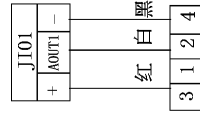
压脚阀



小收尘阀

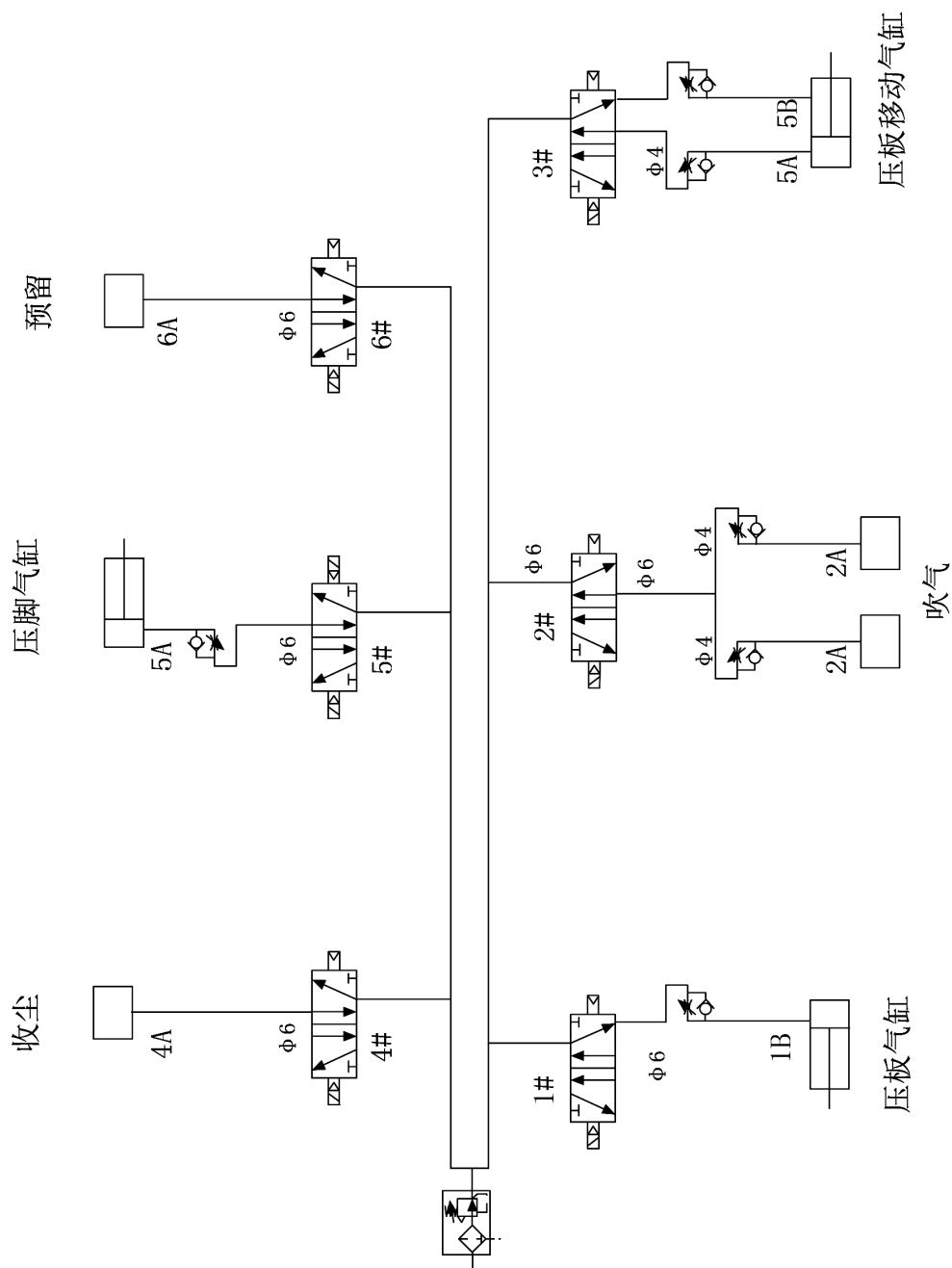
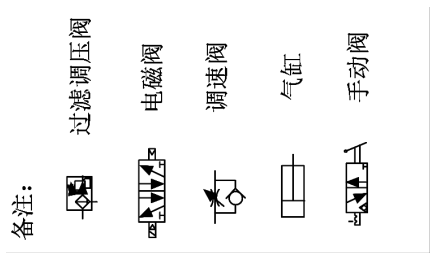


脚踏板



速普电控插头

7.2. 气控图:



八、附件箱明细


序号	附件名称	规格	数量
1	《MB3005B 双层自动合缝机 -使用说明书》		1
2	《MB3005B 双层自动合缝机 -零件手册》		1
3	机头附件箱		1

九、常见问题及解决方法

9.1. 一般故障处理

序号	错误代码	错误内容	错误问题的多种可能
1	Er01	找不到停针位	<ol style="list-style-type: none"> 1. 手轮靠的不够进间隙在 2.5mm 内 2. 九针插头接触不良 3. 电机霍尔坏, 要更换电机 4. 手轮的磁铁掉落
2	Er02	开机没有检测到调速器	<ol style="list-style-type: none"> 1. 调速器插头没有插 2. 调速器线断了或没有插
3	Er03	电机霍尔或相位线错误	<ol style="list-style-type: none"> 1. 九针插头接触不良 2. 机电没有安装好 3. 霍尔坏
4	Er04	堵转保护	<ol style="list-style-type: none"> 1. 电机过载 2. 电机与电控箱连接的四心线接触不好 3. 电机断线或坏了
5	Er05	硬件过流保护	<ol style="list-style-type: none"> 1. 电机过载 2. 信号线接触不好或断了 3. 主板坏了
6	Er07	串口通信超时错误	显示屏至主板信号线不良或主板坏
7		显示屏无电 开关有电	<ol style="list-style-type: none"> 1. 主板坏 2. 显示屏与主板连接线接触不良

9.2. 常见问题及解决方法详见下表

现象	图片	原因分析	解决措施
包边过空		限位块位置偏左	根据步骤 6.2 调整限位块位置

十、日常保养要求

10.1. 设备保养清单及要求详见下表

10.2. 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	切刀韧口		√			检查切刀韧口，保证无缺口和磨损

十一、知识产品保护声明

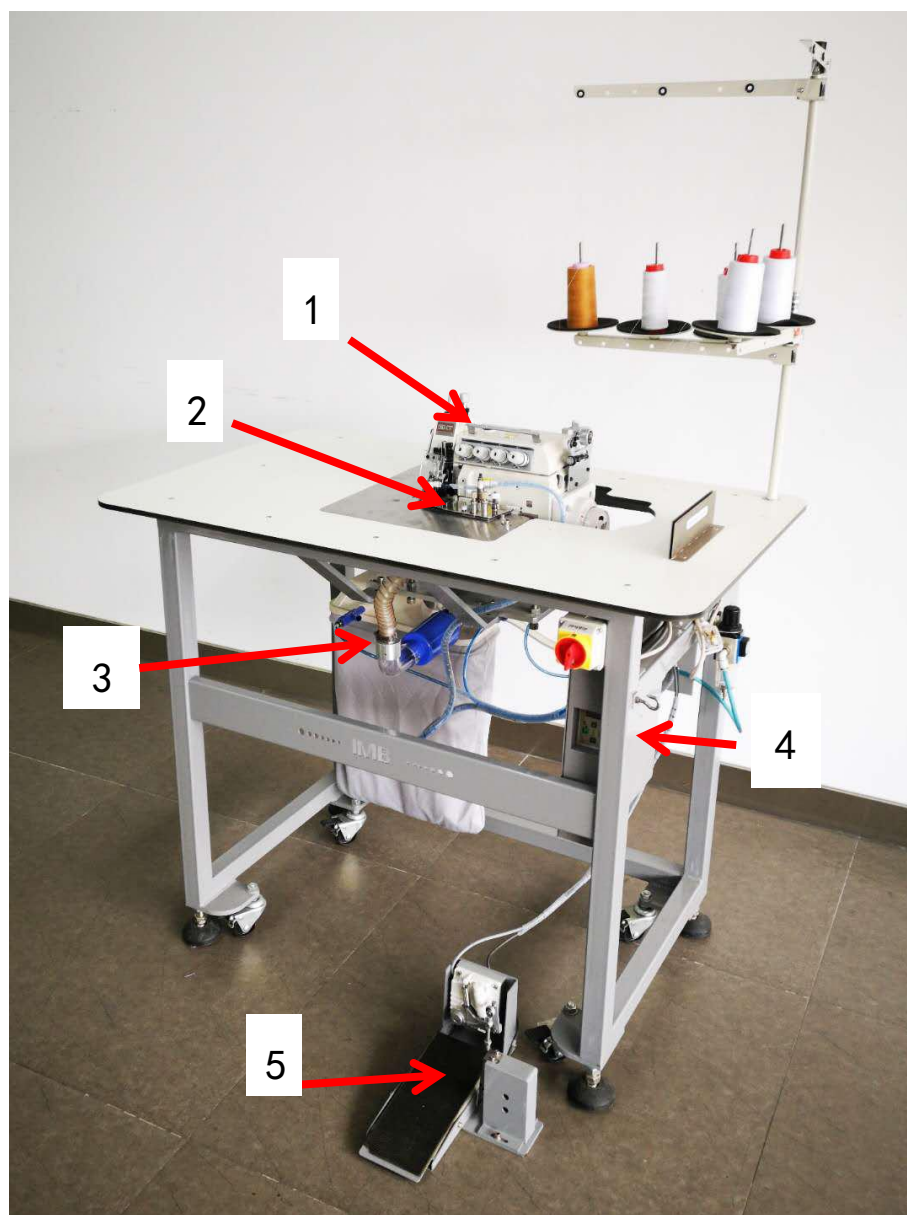
MB3005B 双层自动合缝机是常州智谷机电科技有限公司独立自主完成的设计成果。该成果知识产权属于常州智谷机电科技有限公司，受国家知识产权相关法律法规的保护。未经权利人书面许可，不得实施该成果的专利技术，不得复制、销售或通过信息网络传播和该成果有关的信息。任何违法行为，常州智谷机电科技有限公司将依法追究其法律责任。

ENGLISH

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1、 Basic information of the equipment



1: PS-EXT3216H Machine head;
Control box;

2: Seamer device;

3: Dust collecting device;

4:



5: Pedal;

2、Technical parameters of equipment

MB3005B Side seamer		
1	Machine head	PS-EXT3216H
2	Maximum sewing speed/rpm	5000
3	Voltage/V	AC220
4	Working pressure/Mpa	0.5
5	Stitch length/mm	0-5
6	Size/mm	1270L×890W×1270H
7	Weight/kg	95

3、Safety precautions

Considerations for safe use of automata

 危険	<p>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.</p>
 注意	<p>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.</p> <p>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.</p> <p>3. To prevent personal injury, please do not put your finger near the needle when turning on the power or running the machine.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>7. Please do not cut off the power or air supply while the machine is running.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>16. When the power switch is turned off during the foot press action, please</p>

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. Button function description



- (1) : Power switch: ventilate and power on the equipment after 90 ° rotation.
- (2) : Pedal: sewing in front and lifting in back.
- (3) : Microswitch: 1.1-2 sewing mechanism moves left or right after touching.

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

Rotate the power switch at 90° to the ON position, and the equipment will be powered ON. 。

5.2.2 Operation process

a. Hem to waist

- 4) Press 4.1 (2) pedal backward to lift the presser foot, Place the cloth in the work area, Press the pedal forward to the position shown in the figure below and then stop, Touch the 4.1 (3) microswitch with your foot, and the sewing mechanism moves to the left (as shown in the figure below);

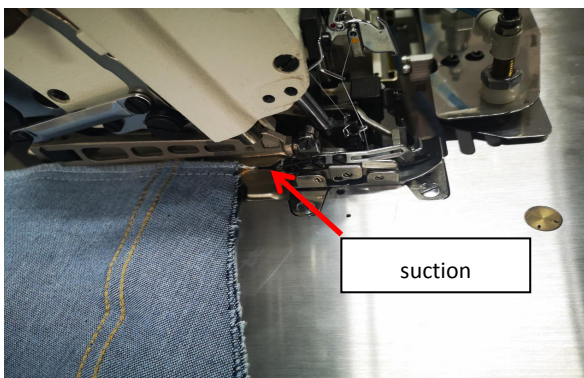


- 5) Press the foot pedal forward to the position shown in the figure below and then



stop, Touch the microswitch 4.1 (3) with your foot, and the sewing mechanism moves to the right;

- 6) Press the foot pedal forward to sew to the position shown in the figure below, and the sewing is completed. (Note: because the thread cutting is located behind the cloth



feeding teeth, Therefore, the cutting piece needs to be sent to the rear of the thread cutting and suction to facilitate the thread cutting)

b. Waistband to hem

- 3) Press 4.1 (2) pedal backward to lift the presser foot, Place the cloth in the work area, Press the pedal forward to the position shown in the figure below and then stop, Touch the 4.1 (3) microswitch with your foot, The sewing mechanism moves to the left (as shown in the figure below);



- 4) Press the foot pedal forward to the position shown in the figure below and then stop, Touch the 4.1 (3) microswitch with your foot, The sewing mechanism moves to the right and the sewing is completed.

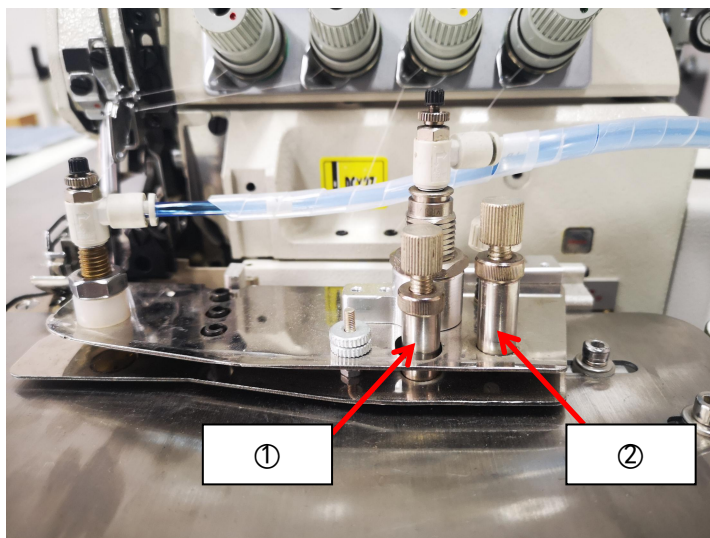


5.2.3 Shutdown

After operation, turn the power switch 90 ° to the off position, and the equipment will be shut down.

6、 Debugging method

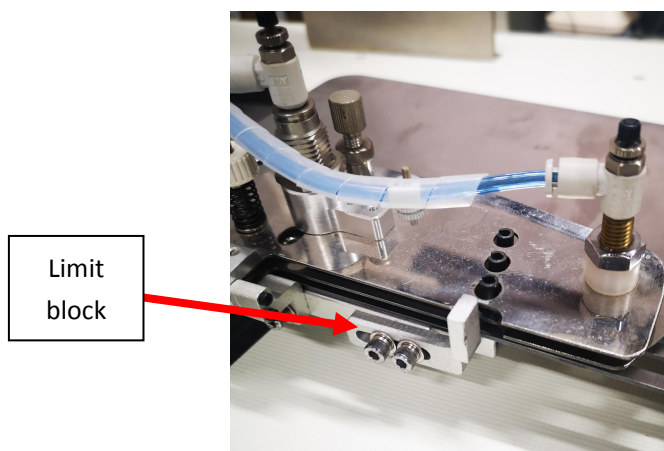
6. 1. Gap adjustment



Manually rotate screw ①, Adjust the gap between the lower plate and the mop plate, The gap size shall be adjusted according to the thickness of the bottom cutting piece

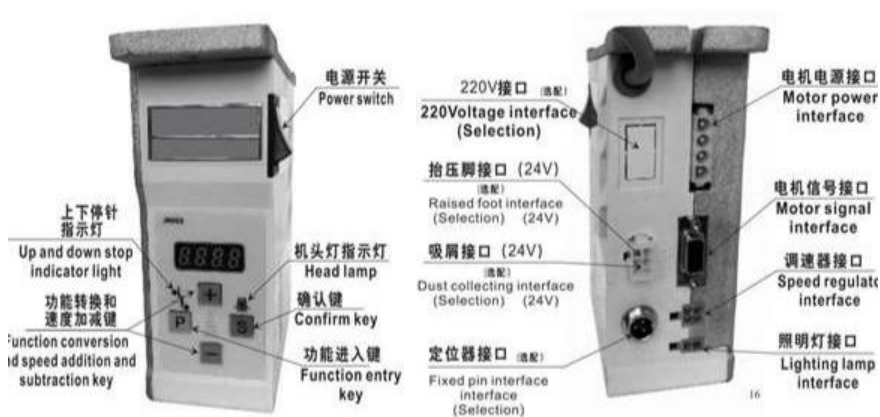
Manually rotate screw ②, Adjust the gap between the upper plate and the lower plate, The gap size is adjusted according to the thickness of the upper cutting plate

6. 2. Adjustment



Adjust the left and right position of the limit block according to the size of the binding.

6.3. Parameter debugging



1: Each key purpose:

4) Use of "P" key:

The first: "P" key is the up and down needle stop key, Press the "P" key, the upper light hole is on, which means the upper needle stops; the lower light hole is on, which means the lower needle stops, which means the two hole lights are not on, which means the free needle stops;
Second: function access key (see operation method of access parameter) 。

5) Use of "s" key:

First: "s" key is the key to turn on the headlight, press "s" key, when the small light on "s" key is on, turn off the headlight when it is off;
Second: function parameter (confirm) key (see operation method of entering parameter) 。

6) Purpose of "+" - "key:

These two keys are used for speed adjustment and parameter adjustment.

2: Operation method of entering parameters

example: How to turn the motor clockwise to anticlockwise。

Step 1: turn on the power;

Step 2: press the "P" key first, and press the "+" key at the same time, the screen will display p-00;

Step 3: press the "+" key to adjust the p-00 to P-02, which is to click the forward and reverse parameters (indicated on the common parameter table) ;

Step 4: press "P" key and the screen will display 1,;

Step 5: press "-" key to adjust "1" to "0" ("1" is clockwise, and "0" is counter clockwise, which is indicated on the common parameter table) ;

Step 6: press the "s" key to confirm that the parameter adjustment is completed.

3: Restore factory settings

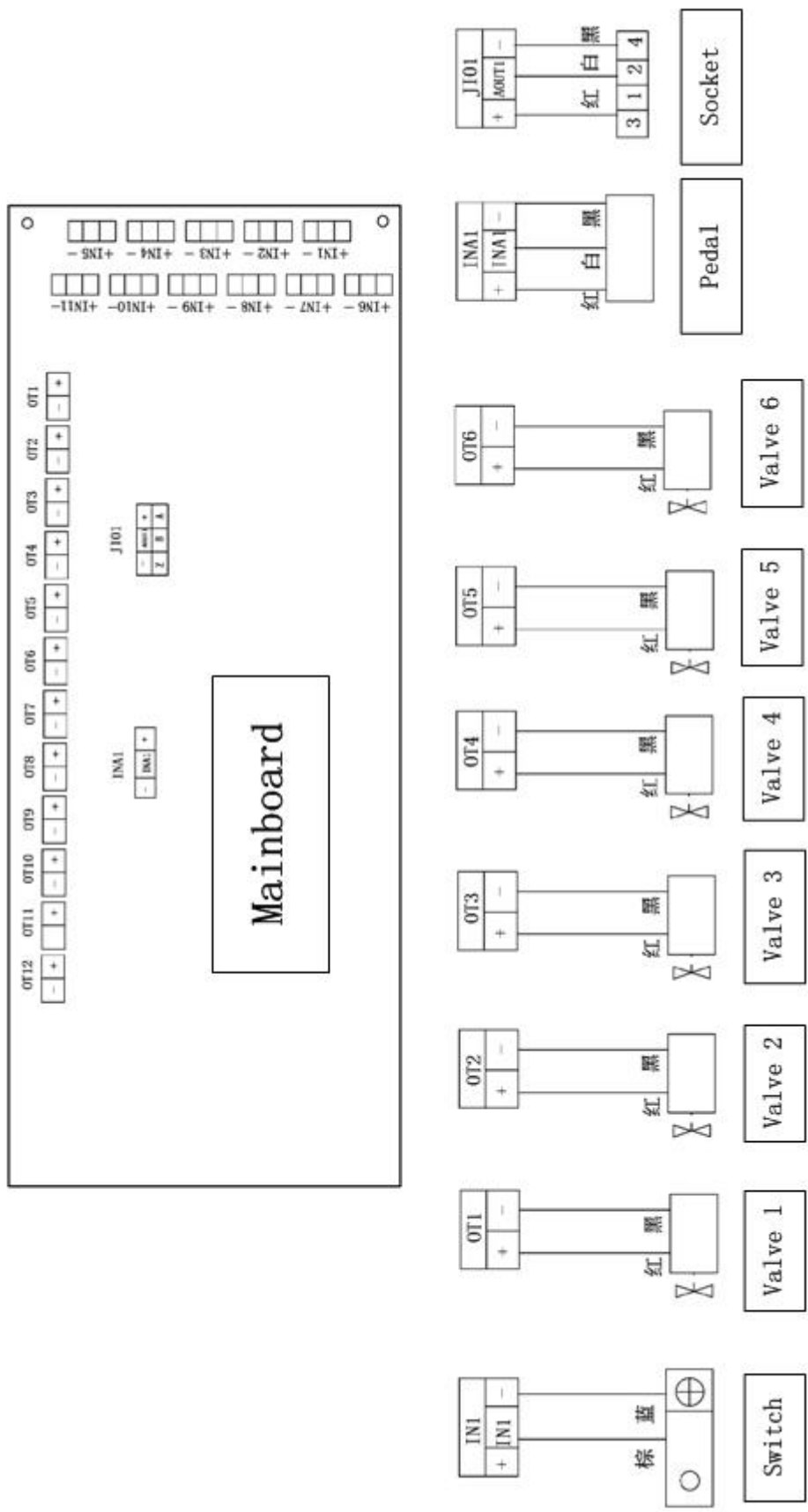
Factory reset method : Press the "P" key first, press the "+" key at the same time, the screen will display p-00, and then press the "s" key for about 3 seconds.

4: Common parameter setting of motor

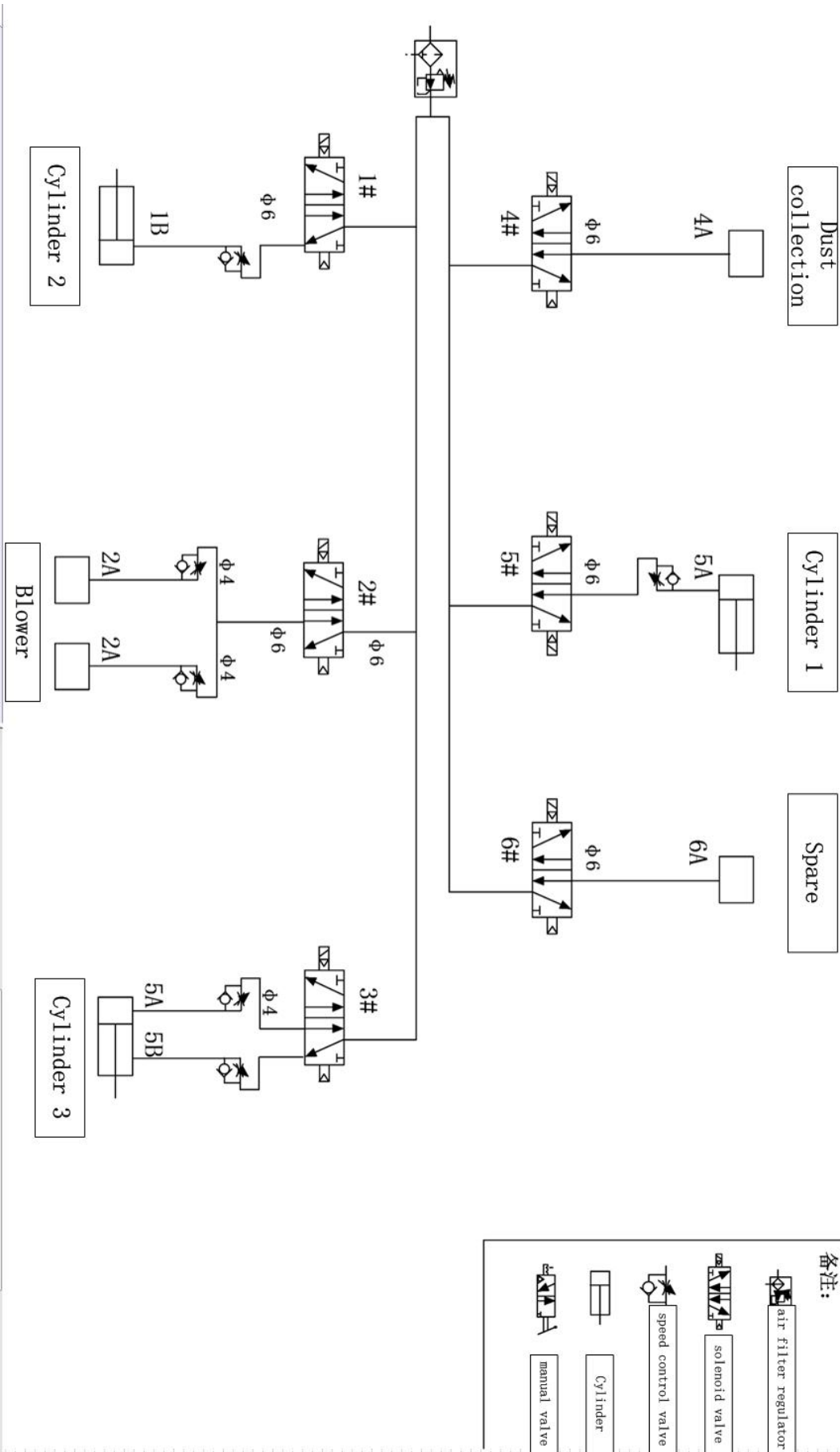
The serial number	Parameters name	The Parameters name	Adjusting rang		The factory reset settings	Remark
1	P-01	Maximum Speed lock	200-6500RPM		4500rpm	
2	P-02	Direction of rotation	0 is reverse turn needle	1 is clockwise turn	1	
3	P-04	Start sewing speed	200-800rpm		250rpm	
4	P-05	Speed up And slow	2000-4000rpm		3000rpm	
5	P-06	Set the seam	0-999		0	
6	P-10	Automatic clearance run(run)	Press the S key change 0 to 1		0	
7	P-11	Presser foot ascend starting time	0-2000ms		0	
8	P-12	Ascension presser foot keep time	1-120s		5s	
9	P-14	Maximum current limiting	50-450		300	
10	P-15	The location of the needle	1:detecting needle 0:no detection		1	

7、Electrical wiring

7.1. Electronic control panel:



7.2. Air control chart:



8、Accessories box details

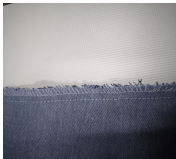
NO	ITEM		QTY
1	《MB3005B Instruction manual》		1
2	《MB3005B Parts Manual》		1
3	Head accessory box		1

9、Common problems and Solutions

9.1. General troubleshooting

The serial number	Error code	Error content	Several possible error problem
1	Er01	Can' t find the needle position	<ol style="list-style-type: none"> 1. The hand wheel is not close . clearance within 2.5mm 2. Nine plug contact undesirable 3. Motor holzer bad.to replace the motor 4. The hand wheel magnet in the loss
2	Er02	Not detected boot speed regulator	<ol style="list-style-type: none"> 1. Speed control device without plug 2. Speed wire is broken or contact undesirable
3	Er03	Motor holzer or phase error	<ol style="list-style-type: none"> 1. Nine hole plug contact undesirable 2. The motor doesn' t pack good 3. Holzer is bad
4	Er04	Locked-rotor protection	<ol style="list-style-type: none"> 1. The motor overload 2. The motor and the controller connected four hole line contact is not good 3. Motor is bad
5	Er05	Hardware over-current protection	<ol style="list-style-type: none"> 1. The motor overload 2. Line contact is bad or broken 3. Main board is bad
6	Er07	Serial port communication time out error	Display to the system board signal is bad or board is bad
7		screen without electricity Switch with electricity	<ol style="list-style-type: none"> 1. Main board is bad 2. The display screen and the main board connection line contact is bad

9.2. See the table below for common problems and Solutions

Phenomenon	Image	Cause Analysis	Solutions
Over bound		The position of limit block is to the left	Adjust the stop position according to step 6.2

10、 Daily maintenance requirements

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

10.2. 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	Cutter tough		√			Check cutter toughness to ensure no gaps and wear

11、 Knowledge product protection statement

MB3005B Side seamer 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.。