

口袋卷边机

Pocket Hemming Machine

(MB2001B)

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 reference

版本信息/ Version

2022.04.03

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《MB2001B-使用说明书》、《MB2001B-零件手册》、《MB2001B-触摸屏界面操作说明》。

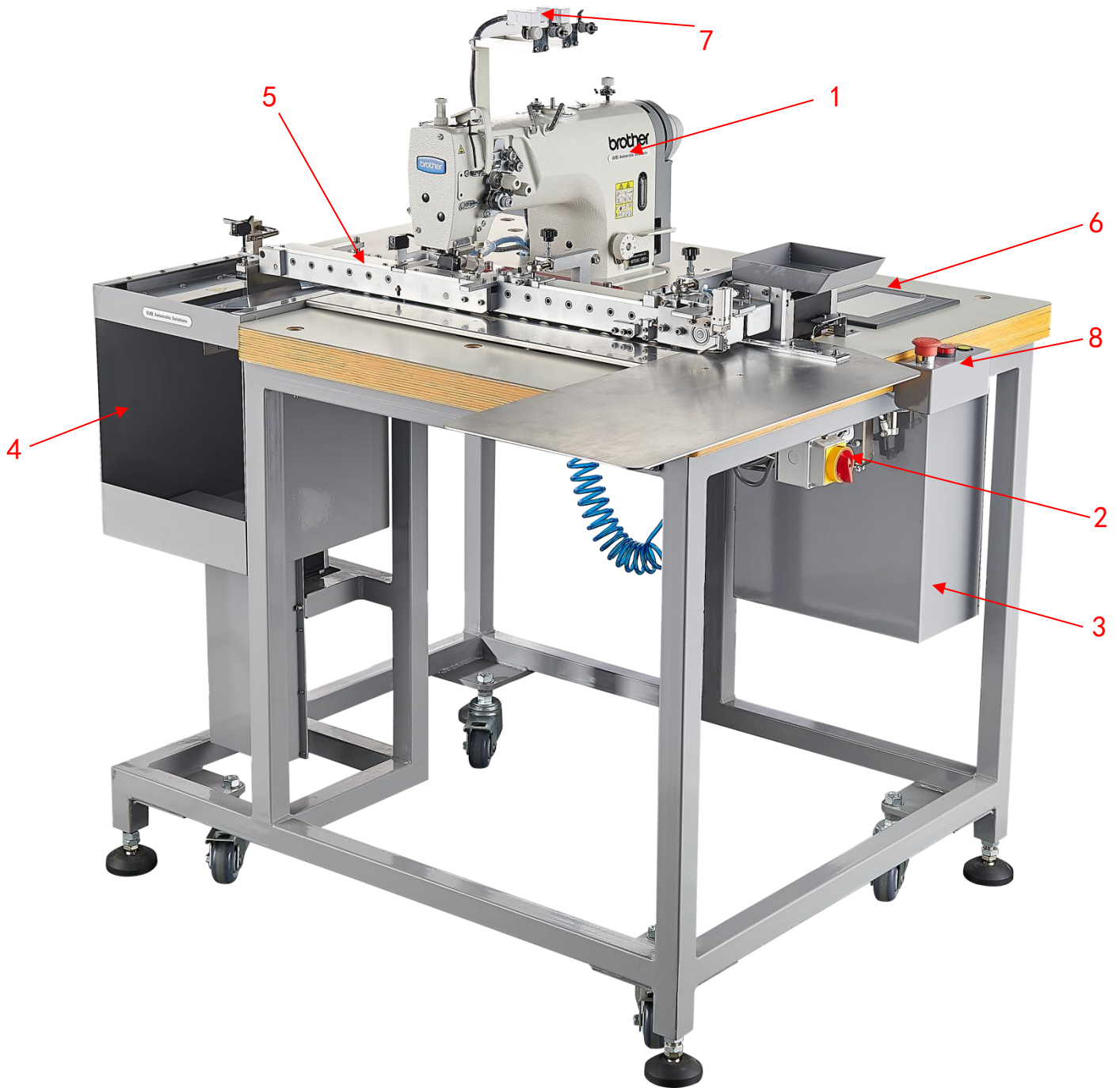
The introduction of this machine is divided into three parts. For details, please refer to 《MB2001B Operation manual》 and 《MB2001B Parts Manual》《MB2001B Touch screen interface operation instructions》

ENGLISH

Content



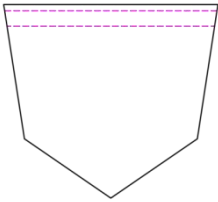
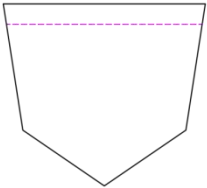
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1、 ESSENTIAL INFORMATION





1: Machine head; 2: switch; 3: control box; 4: stacker; 5: loader; 6: touch screen;
7: thread break device; 8: button;

2、SPECIFICATIONS

MB2001B Pocket hemming machine		
1	Machine head	Brother T-8720C (Lock)
		JUKI MH380 (Chain)
		JUKI LH-3578A (Lock)
2	Maximum speed /rpm	Lock 3000
		Chain 3500
3	Working voltage /V	220
4	Working pressure /Mpa	0.5
5	Sample	Lock stitch 
		Chain stitch 
6	Hemming width/mm	8~12
7	Working efficiency	2s/pc
8	Size/mm	1300L×1100W×1470H
9	Weight/kg	170
10	Twin thread 	
	Single thread 	

3、SAFETY PRECAUTIONS

Precautions for safe use of automata

 危険	<ol style="list-style-type: none"> 1. In order to prevent accidents caused by electric shock, please do not open the cover of the motor electrical box or touch the parts in the electrical box when the power is turned on.
 注意	<ol style="list-style-type: none"> 1. In order to prevent personal injury, please do not operate the machine with the belt guard, finger protector and other safety devices removed 2. In order to prevent personal accidents involving the machine, please keep fingers, hair and clothes away from the belt pulley, V-belt and motor during the operation of the sewing machine, and do not put objects on it. 3. In order to prevent personal injury, please do not put your finger near the needle when turning on the power or when the sewing machine is running. 4. In order to prevent personal injury, please do not put your fingers in the thread take-up rod cover when the sewing machine is running. 5. When the sewing machine is running, it turns at a high speed. In order to prevent injury to your hands, please never let your hands near the cloth cutter during operation. In addition, please turn off the power supply when changing the cable. 6. In order to prevent personal injury, please take care not to pinch your fingers when the sewing machine moves up and down or returns to its original position. 7. When the sewing machine is running, please do not cut off the power or air supply. 8. In order to prevent accidents caused by sudden start-up, when the preparatory work is finished and the sewing can be carried out, please remove the cloth guide. 9. In order to prevent accidents caused by electric shock, please do not operate the sewing machine when the power ground wire is removed. 10. In order to prevent accidents caused by electric shock and damage of electrical parts, please turn off the power switch before plugging in and out the power plug. 11. In order to prevent accidents caused by damage of electrical parts, please stop the operation and unplug the power plug for safety during thunder. 12. In order to prevent accidents caused by damage to electrical parts, condensation will occur when moving from cold places to warm places, etc., so please turn on the power after the water drops are completely dry. 13. Because this product is a precision machine, please pay full attention to the operation, do not splash water and oil on the machine, and do not let the machine drop to impact the machine. 14. This machine is a class A industrial machine. If this machine is used in

the home environment, the phenomenon of radio interference may occur. At this time, please take appropriate measures to solve the problem of radio interference.

15. After the power switch is turned off when the stacker acts, the stacker bar acts, so please take care not to pinch fingers, etc.

16. After the power switch is turned off in the presser foot action, the presser foot action, so please pay attention not to pinch fingers, etc.

17. During the folding operation, please be careful not to let the air cylinder clamp the finger when putting the finger in the folding machine.

***WARNING:**

√ Improper operation of the machine may cause personal injury. Please read this instruction carefully and operate it correctly before operation.

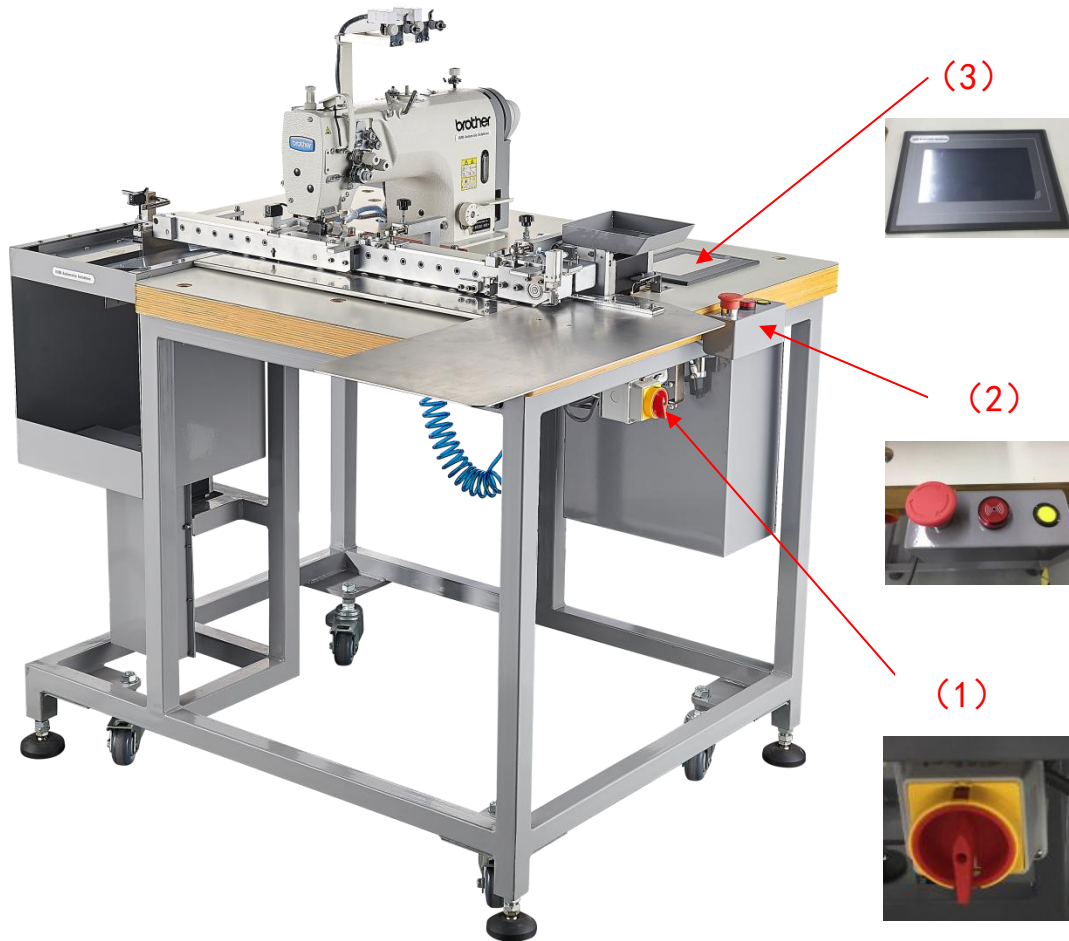
√ Please ventilate the machine before power on.

√ It is strictly prohibited to open the electric cabinet or the internal parts of the touch screen when it is powered on.

√ This machine needs to be used after being trained or under the guidance of a special person to ensure the personal safety of the user.

4、BUTTON FUNCTION DESCRIPTION

4.1.BUTTON FUNCTION DESCRIPTION



(1) : Power switch – turn the power switch 90 ° to on, and the device is powered on, ventilated and the touch screen is turned on.



(2) : From left to right:

Emergency stop button (left) --- all actions stop after pressing, and the emergency stop will be released when the button is screwed back;

Buzzer (medium) - alarm prompt after the stacker is full;

Reset button (right) --- press it and the receiving plate will rise and reset;

(3) : Touch screen--- For details, please refer to 《mb2001b pocket hemming machine interface description》 .

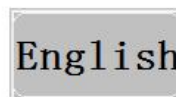
a: Power on main interface: used for the selection of Chinese or English operation interface.



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IMB2001B-IM Auto Hemmer For Jeans



b: Main menu interface: select relevant sub interfaces to enter.

M E N U

Working Mode



Parameters Setting



Maintenance Test



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
- ✓ Check whether the fabric in the stacker box has been emptied

5.2. OPERATION PROCESS DESCRIPTION

5.2.1 BOOT DEVICE

Turn the power switch 90 ° to the on position, and the equipment is powered on.

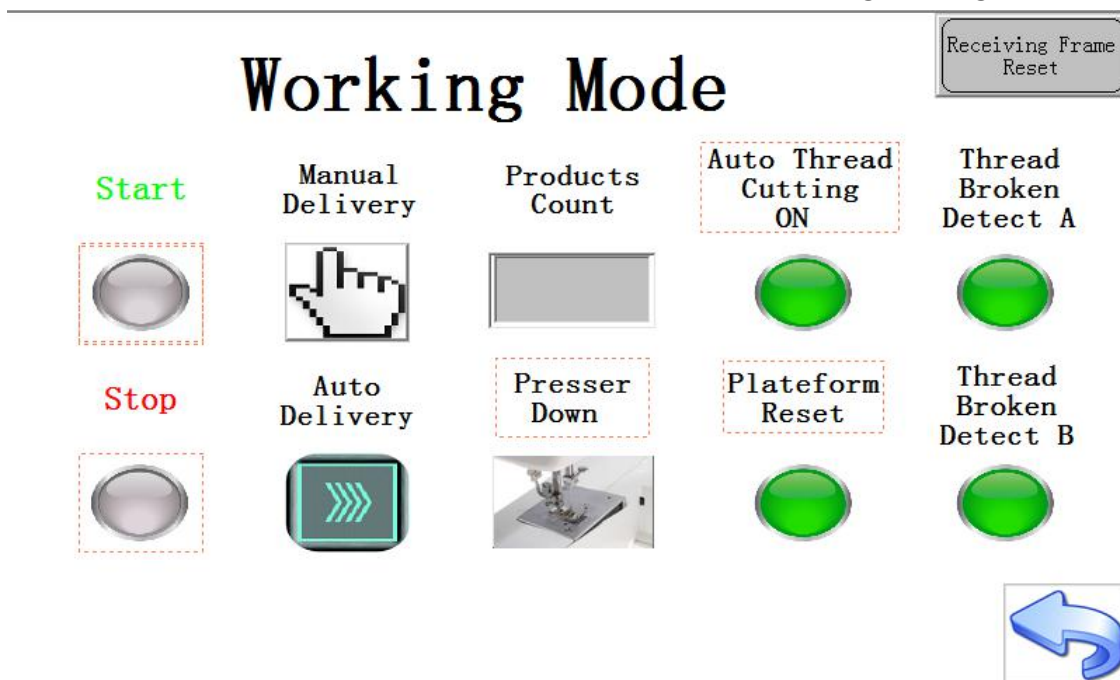


Stacker reset button

5.2.2 Pre feeding operation

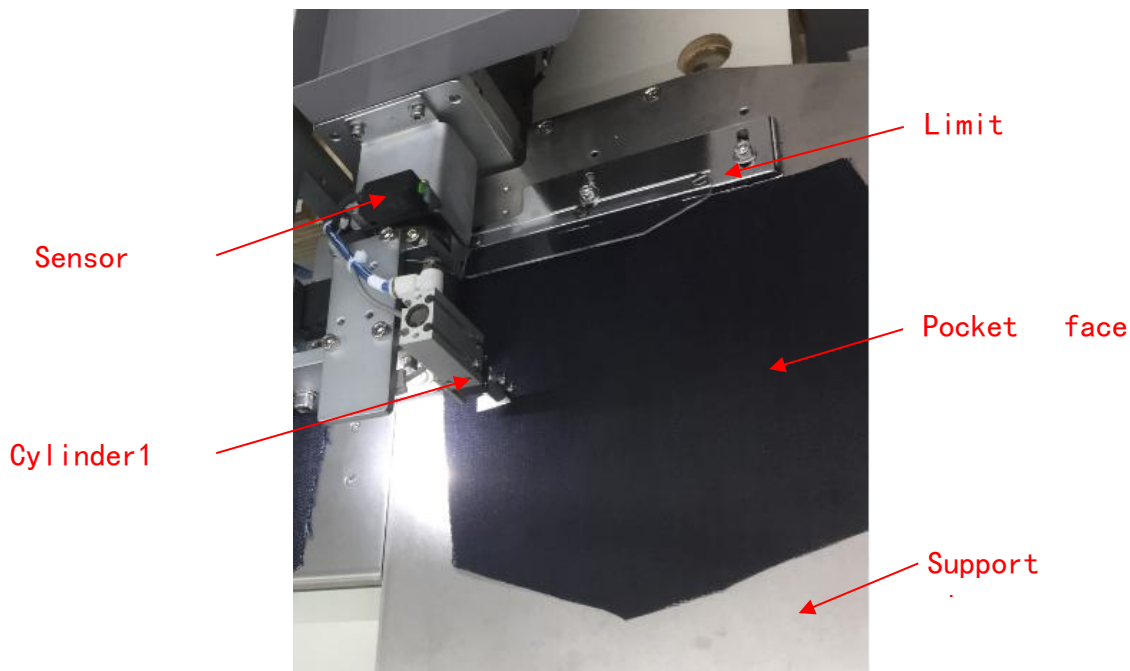
5.2.2.1 Interface operation:

Select the language "English" in the main interface of 4.1 (3) a → the "working mode" in the main menu interface of 4.1 (3) B to enter the following working mode interface.



5. 2. 2. 2 FABRIC PLACEMENT:



Put the pocket face up, the upper side of the pocket against the limit block on the cloth feeding support plate, manually send it under the sensor, and put the pocket in place.

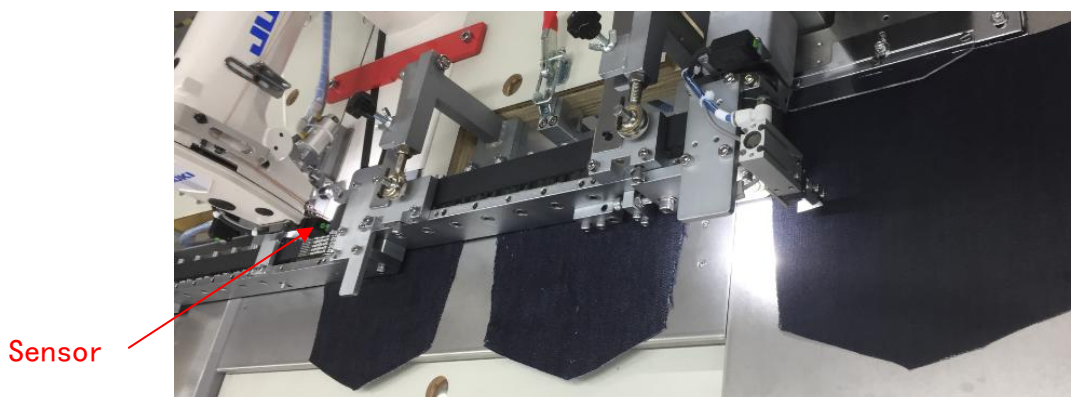


5. 2. 2. 3 Prefeed mode:


a. Manual pre feed:

When the pocket is in place, press "manual pre feeding" in "working mode interface"

5. 2. 2. 1 all the time , At this time, press down the cylinder1, hold the pocket, and at the same time, the cloth feeding tug starts to automatically feed until the pocket is all sent under the tug, release the "manual pre feeding" , Stop the feeding, raise the cylinder1, and perform the operation of placing the fabric again in 5. 2. 2. 2, Repeat the above actions until the first pocket is under the sensor in the feeding process, and the manual pre feeding process is finished.




a. Automatic pre feeding:

Enter "working mode interface" 5.2.2.1, click "automatic pre feeding"  When the pocket is placed in place, the feeding tug automatically starts feeding, and the cylinder presses down to realize the automatic feeding process. Repeat this up action until the pocket is under the sensor for sewing in the feeding process, and the automatic pre feeding process is finished.

**It is recommended that the operator select automatic pre feeding mode 5.2.2.3-b operation*

5.2.3 Start sewing

Click "start" in "working mode interface" 5.2.2.1 , Turn on the sewing mode. Repeat the action in 5.2.2.2, place the pocket continuously and sew continuously.

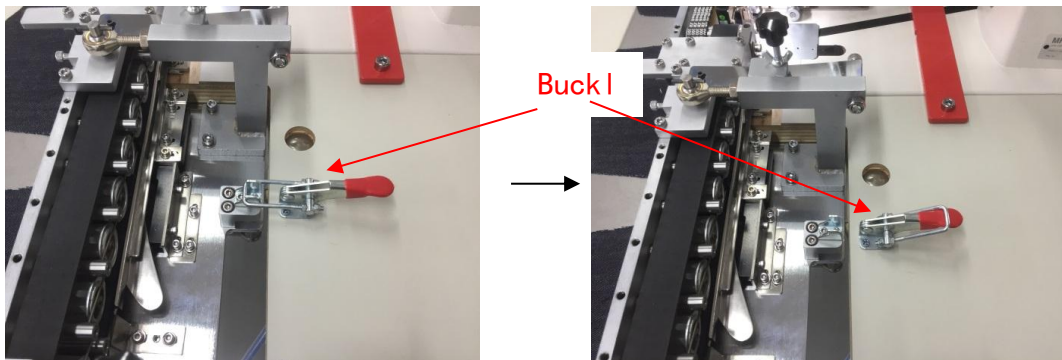
5.2.4 Stacker reset operation


When the pocket in stacker reaches the set height, the "buzzer" 4.1 (2) (middle) will give an alarm. At this time, the operator is required to take off the cloth in the stacker, press the "stacker reset button" 4.1 (2) (right), the material receiving lifting plate rises, and the material receiving reset is completed.

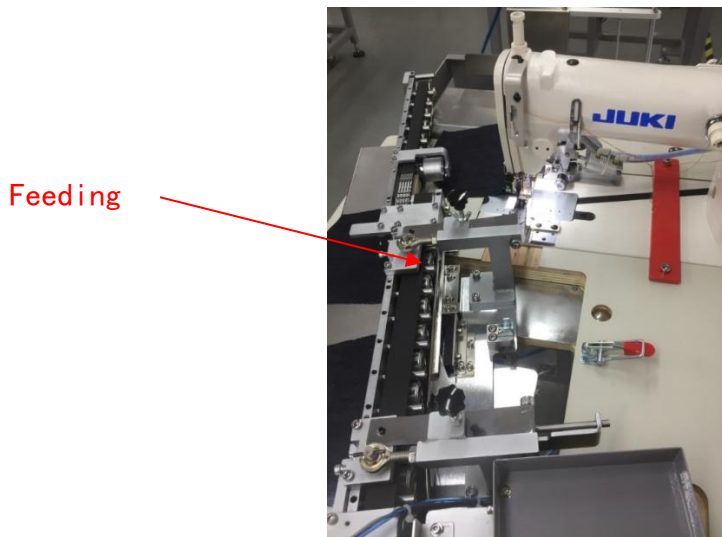


5.2.5 Thread operation

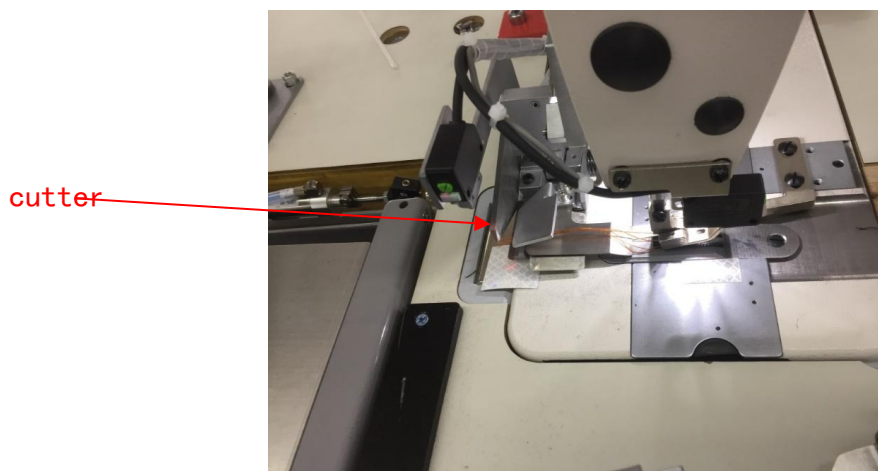
a. When it is necessary to thread, first loosen the buckle on the platen;






b. Click "feeding platform reset" in "working mode interface" 5.2.2.1 , The feeding part is rotated and opened, at this time, the threading operation can be performed (see the figure below).



c. After threading, pull the topstitching thread and innerstitching thread to the bottom of the cutter, as shown in the following figure:



d. Click "feeding platform reset" in "working mode interface" 5.2.2.1 again , Rotate the feeding platform into place and lock the buckle.

e. Enter "working mode interface" 5.2.2.1 and click "low speed sewing" , After several stitches of slow sewing, click "start"  to start normal sewing.

5.2.6 Shutdown

During shutdown, there are two situations:

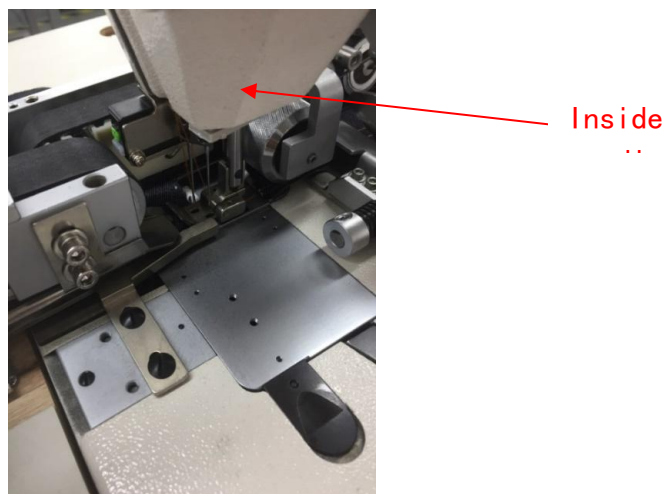
- a. a. It is necessary to sew all the pockets under the cloth feeding tug. The next time the machine is started, it is necessary to carry out the operation of automatic pre loading again. In this case, the operator needs to manually block the sensor and let the machine continue to sew until all sewing is completed.
- b. There is no need to sew all the remaining pockets. The next time the machine is turned on, the sewing can be started directly without automatic pre placing.

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

6、 Adjustment instructions of relevant parts

6.1. Adjustment of single and double needle

If it is necessary to sew a single line, remove the inside needle indicated by the arrow.

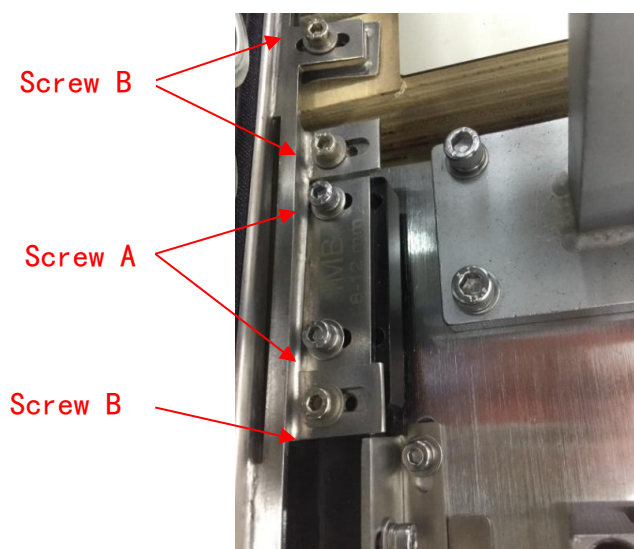


6.2. Adjustment of puller

a. Adjustment purpose: Adjust the width of pocket hemming M; adjust the width of seam to edge N.



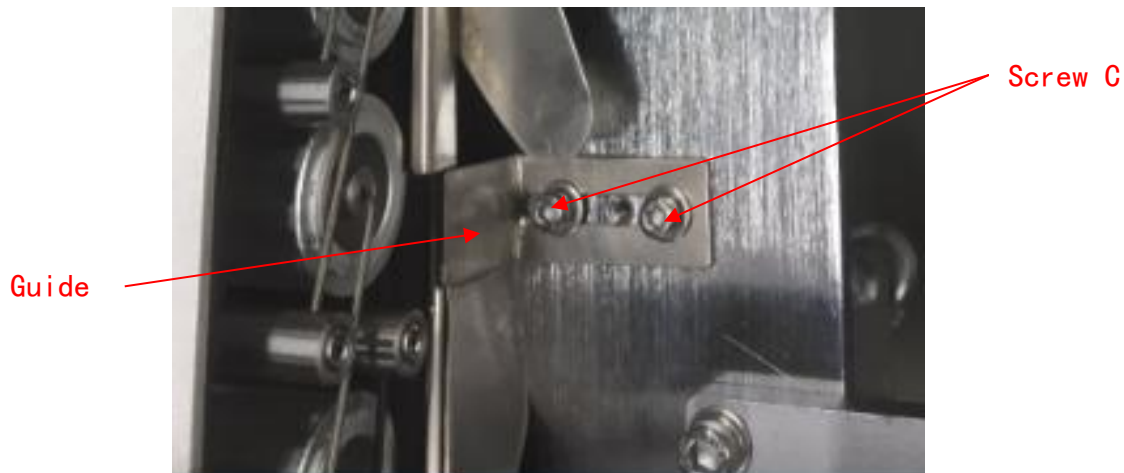
b. Change the puller and change the curling width dimension M: Remove two screws a to replace the folder as a whole (see the figure below). The dimension of the factory folder is 8-12mm. If it exceeds the dimension, the folder shall be customized and replaced.



c. Adjust the position of the folder, and change the width from the suture to the edge
N:


c.1 Loosen two screws B to adjust the left and right position of the folder, so as to adjust the distance from the suture to the edge;

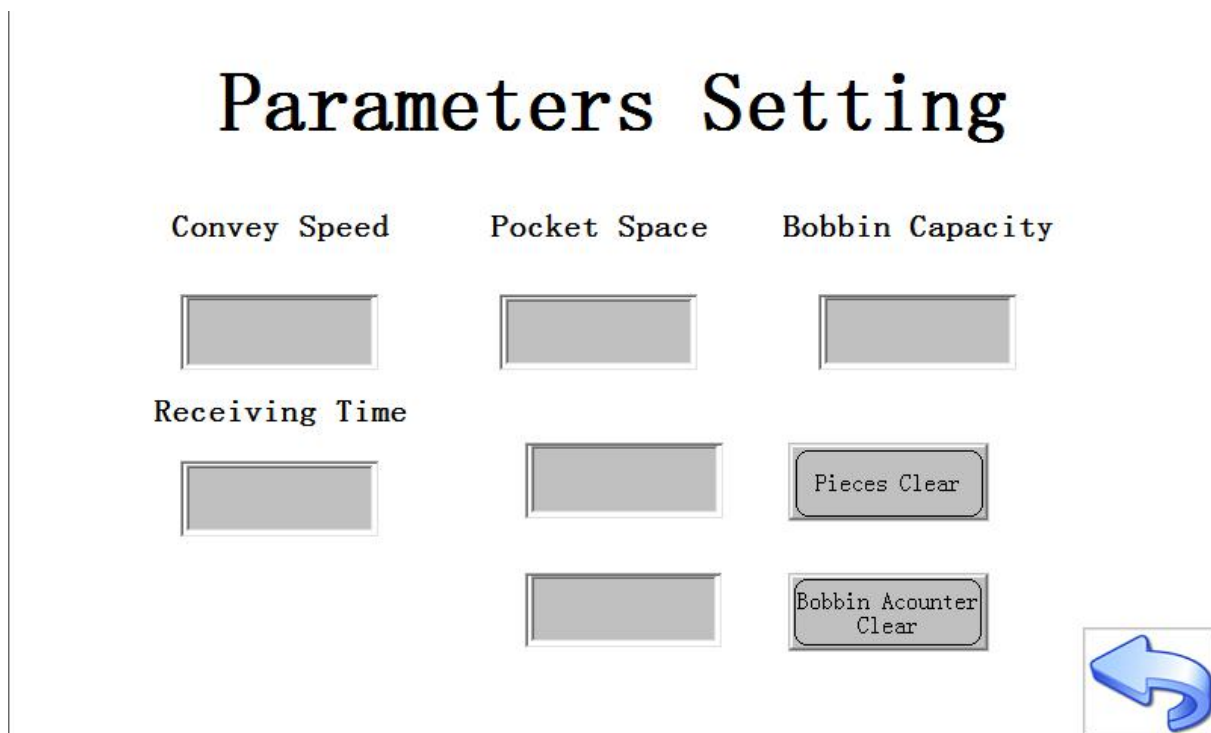
c.2 Loosen two screws C to adjust the left and right position of the guide. The position of the guide changes with the position of the folder (the guide is next to the puller).



6.3. Stitch adjustment

6.3.1 Interface operation:

Select "English" in the main interface of 4.1 (3) a → "parameter setting" in the main menu interface of 4.1 (3) B , Enter the following working mode interface.



6.3.1 Stitch adjustment:

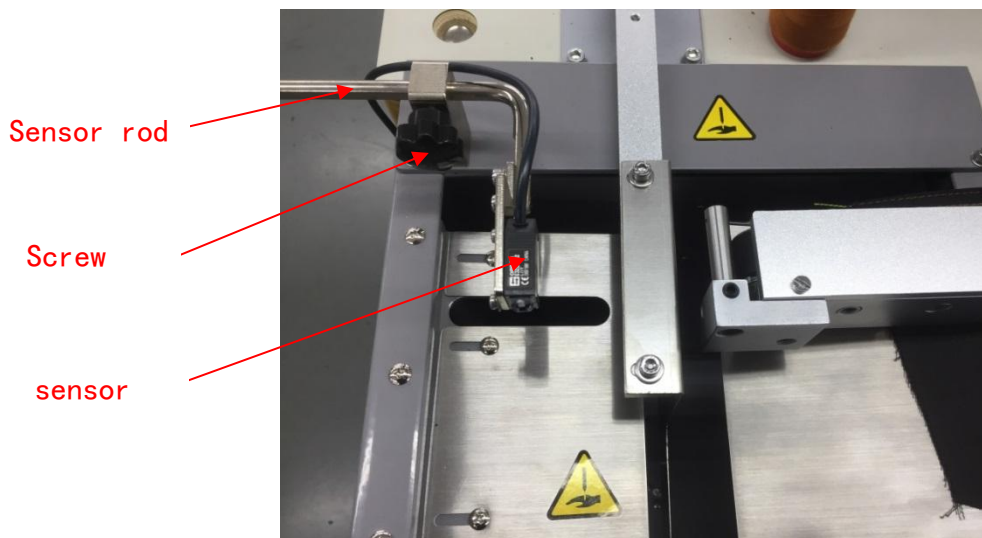
Convey Speed

By adjusting the "convey speed" in the parameter setting And adjust the needle dial (see the figure below), so that the teeth and feeding speed are synchronized. (it can be judged whether to reduce or increase the feeding speed by observing the sewing effect)



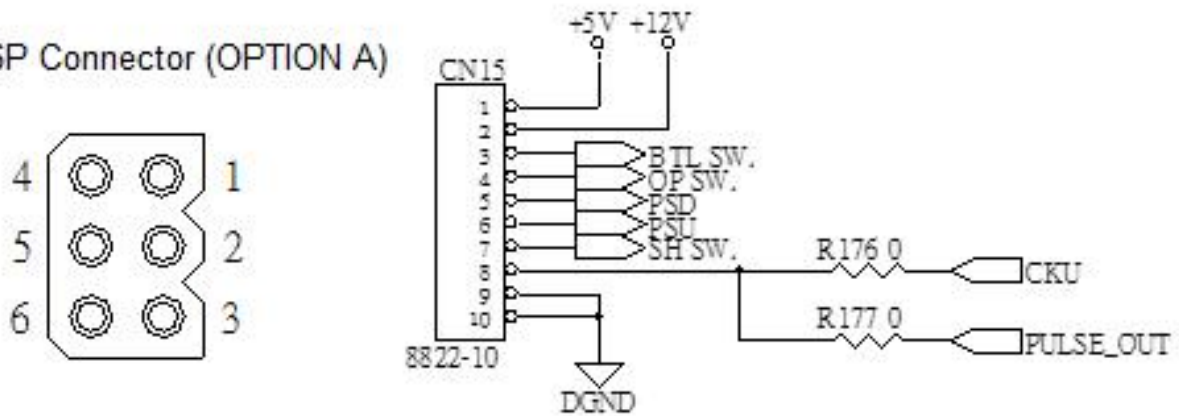
6.4. Sensor adjustment

Loosen the screw, adjust the sensor rod left and right, so as to adjust the left and right position of the sensor, so as to meet the induction recognition of different width pockets.



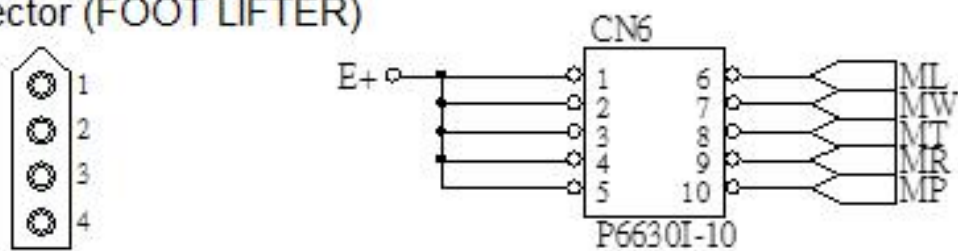
7、ELECTRIC WIRING

6P Connector (OPTION A)



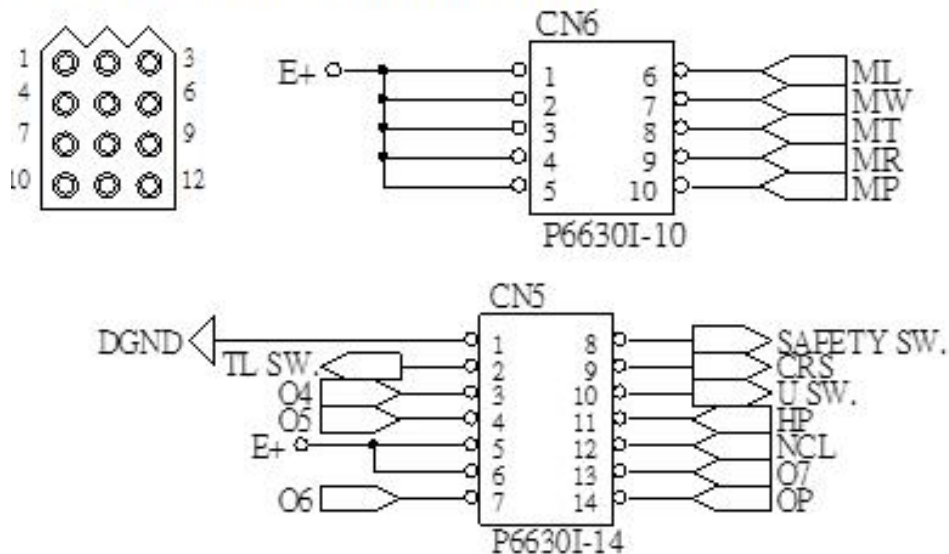
OPTION A		装置	CN15	
4	12V	送布電眼	2	12V
6	0V		10	0V
1	147. INA=IO2		6	147. INA=IO2
4	12V	針棒電眼	2	12V
6	0V		10	0V
2	220. INB=IO2		5	220. INB=IO2
4	12V	切刀電眼	2	12V
6	0V		10	0V
3	144. IN1=IO1		4	144. IN1=IO1

4P Connector (FOOT LIFTER)



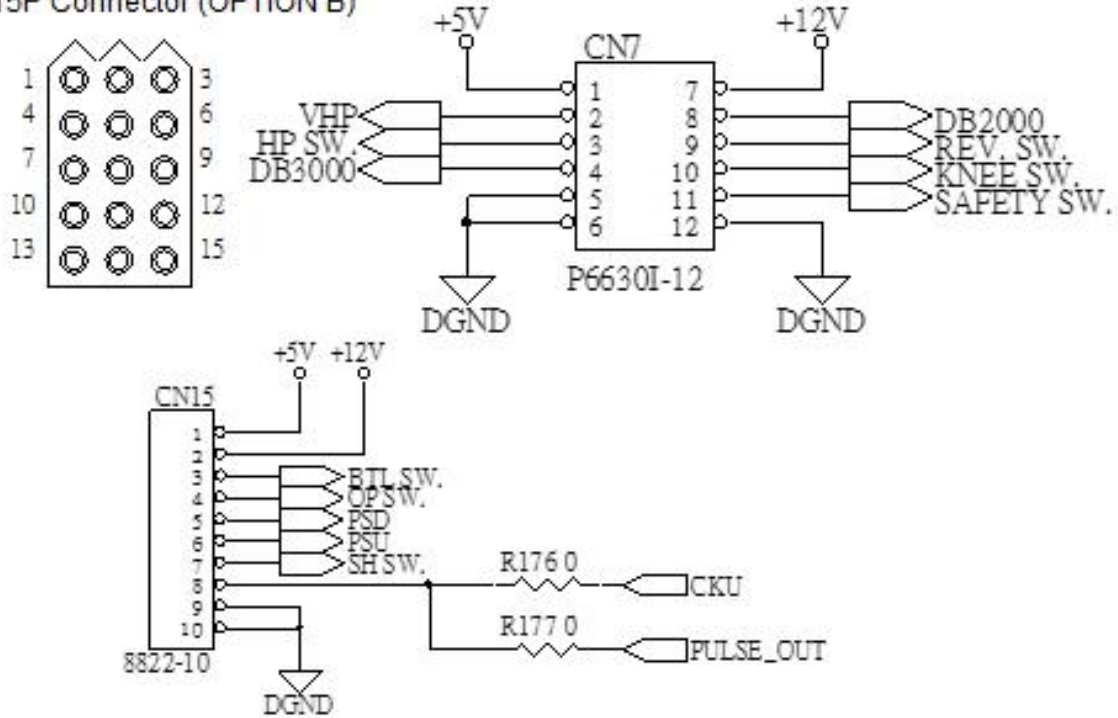
FOOT LIFTER		装置	CN6	
1	—	—	—	—
2	—		—	—
3	24V	押脚	5	24V
4	OF		10	OF

12P Connector (SEWING MACHINE)



SEWING MACHINE		装置			
2	155.OB=KS2	押布	7	155.OB=KS2	CN6
5	24V		2	24V	
3	157.O1=KS1	斬刀	14	157.O1=KS1	CN5
5	24V		6	24V	
7	156.OD=KS2	上頂	6	156.OD=KS2	CN6
8	24V		1	24V	
9	158.O3=KS2	外推	11	158.O3=KS2	CN5
8	24V		5	24V	
10	159.O4=KS2	收料	3	159.O4=KS2	CN5
11	24V		5	24V	
6	240.O2=KS2	吹風	12	240.O2=KS2	CN5
11	24V		6	24V	

15P Connector (OPTION B)



OPTION B (中繼線)		裝置			
2	0V	平台開關	12	0V	CN7
3	INL		11	INL	
1	0V	斷線檢測A-1	9	0V	CN15
9	221. INJ=PSU		3	221. INJ=PSU	
5	12V	斷線檢測B-1	2	12V	CN7
15	153. INK=PSU		5	0V	
5	12V	收料復位	3	153. INK=PSU	CN7
10	0V		7	12V	
14	150. INE=IO4	緊急停止	5	0V	CN15
8	12V		9	150. INE=IO4	
10	0V	斷線檢測A-2	7	12V	CN7
6	148. INC=STOP		5	0V	
13脚为24V		斷線檢測B-2	8	200. IN4=PSU	CN7
			7	12V	
			5	0V	CN7
			4	219. IN5=PSU	
			7	12V	

8、ACCESSORIES BOX DETAILS

	ITEM		QTY
1	《instruction manual》		1
2	《Parts Manual》		1
3	《Touch screen interface operation instructions》		1
4	Thread stand	Head original	1
5	thread clamp spring	Head original	2
6	Oil	Head original	1
7	Plug as-ground	Head original	1
8	CD	Head original	1
9	Cover	Head original	1
10	Bobbin	Head original	2
11	Instructions	Head original	1
12	Thread stand instructions	Head original	1

9、 DAILY MAINTENANCE REQUIREMENTS

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

9.2. Please refer to BROTHER and JUKI for other maintenance requirements

NO	ITEM	Frequency				REQUIRMENT
		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

10、 KNOWLEDGE PRODUCT PROTECTION STATEMENT

MB2001B denim pocket setter 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.