

全自动钉扣机

Button sewing indexer

(MB6006A)

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.

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No part of this manual may be copied or transcribed without requesting prior authorization from IMB

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《MB6006A-使用说明书》、《MB6006A-零件手册》、《MB6006A-触摸屏界面操作说明》。

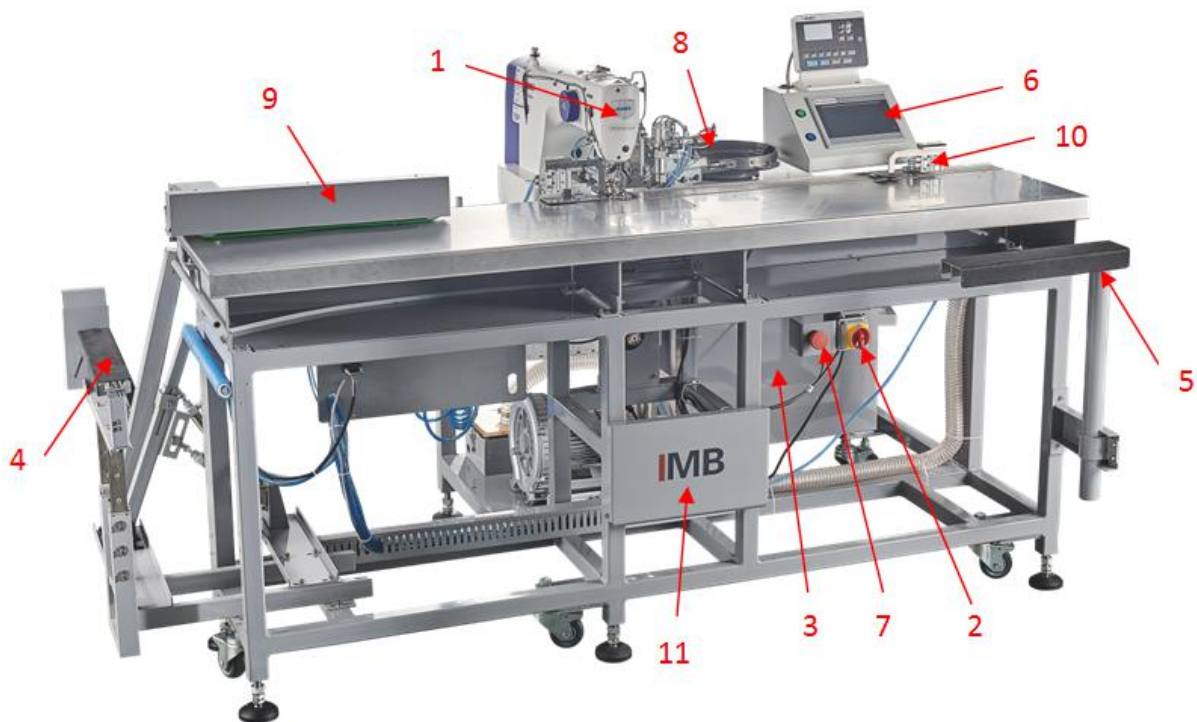
The introduction of this machine is divided into three parts. For details, please refer to 《MB6006A Operation manual》 and 《MB6006A Parts Manual》《MB6006A Touch screen interface operation instructions》

ENGLISH

Catalog

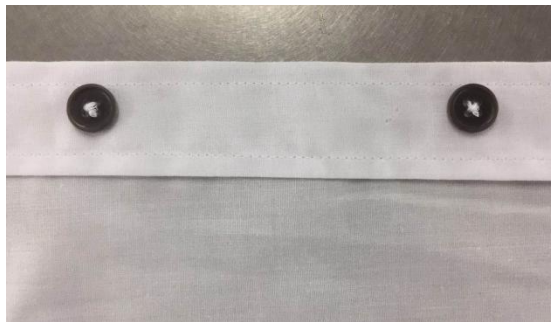
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1、 Basic information of the equipment





- 1: Machine head; 2: power switch; 3: Electric control panel; 4: Stacker; 5: Loader;
6: Touch screen; 7: Emergency stop button; 8: Button feeder; 9: Drag mechanism 10: Clamp;
11. Knee switch

2、Technical parameters of the equipment

MB6006A Button sewing indexer		
1	Machine head	JUKI LK-1903BN
		Brother BE-438HS
2	Maximum/rpm	2700
3	Button spacing /mm	maximum ≤ 650
4	Edge distance/mm	10~20
5	Presser foot height /mm	≤ 13
6	Needle/mm	DP×17 11J~14J
7	Sewing number	50 ↑
8	Conveying distance/mm	≤ 650
9	working voltage /V	220
10	Working pressure /Mpa	0.5
11	Sewing pattern	
12	Size/mm (L*W*H)	2300*1420*1500
13	Weight/kg	322

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 be careful not to pinch your fingers.</p>
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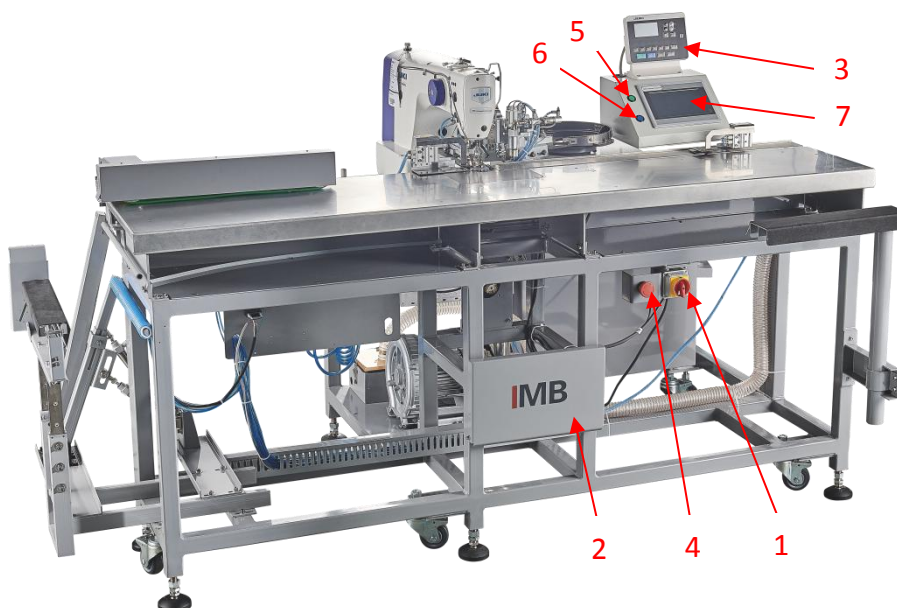
	<p>17. During folding operation, please be careful not to clip the cylinder to your finger when putting your finger into the folding machine.</p>
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*** important safety information:**

- ✓ 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) : Power switch -- rotate the power switch to ON by -90° to energize and ventilate the equipment.

(2) : Knee switch: in normal sewing, the knee is up, not released, start suction, adjust the fabric position; release the knee, start automatic sewing.

(3) : Head operation panel: adjust head related parameters.

(4) : Emergency stop button: in case of emergency, press the button to stop the machine.

(5) : Green button: press the button, and the buckle feeding device will make up the buckle.

(6) : Blue button: press the button to reset the button feeding device separately.

(7) : Touch screen---refer to 《MB6006A Interface description》。

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

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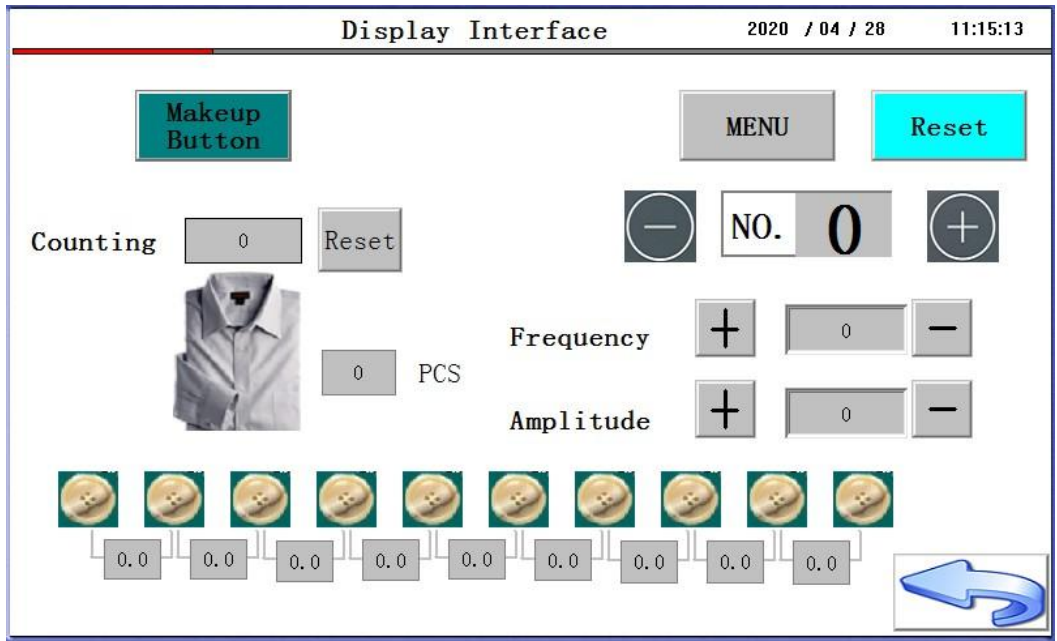
MB6006A全自动钉扣机

MB6006A Automatic button sewer

中文

English

b: Monitoring interface: display the current sewing model number and related dimension modification bar, as well as the menu button.



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 cloth on the receiving plate has been emptied

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.




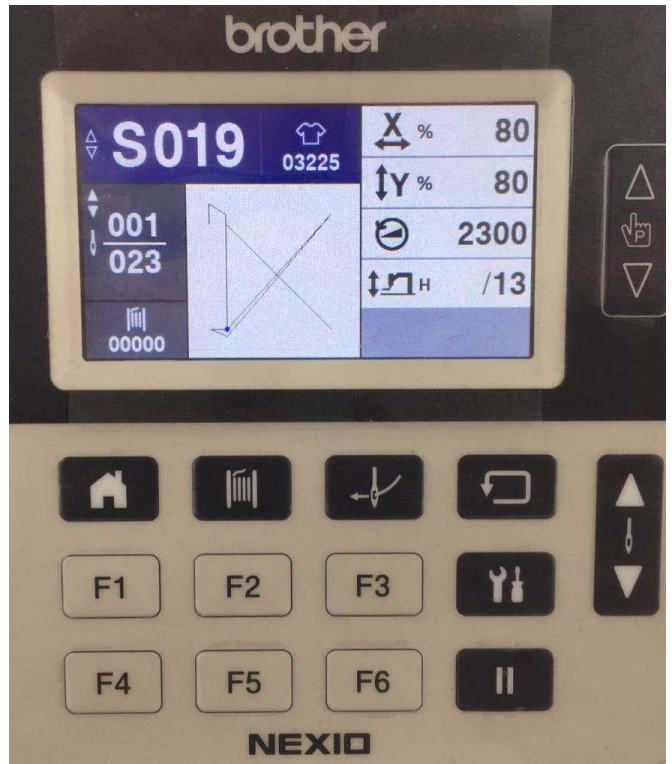
5.2.2. Reset operation

Reset operation of JUKI head and device: Press the head operation screen button ,

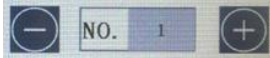
The relevant reset action can be completed.



Reset operation of Brother head and device: Press the head operation screen button ,
The relevant reset action can be completed.

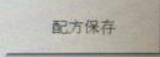



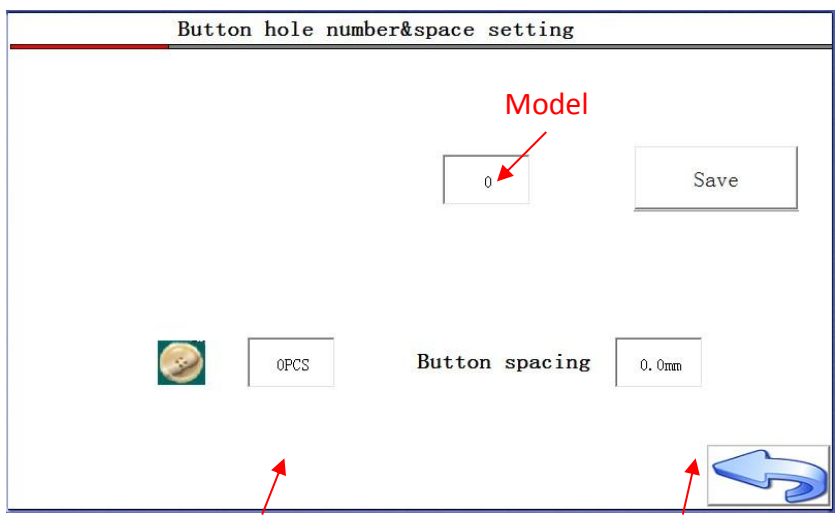
5.2.3. Program confirmation and program selection

1) 、 No. selection: As shown in the figure 4.1. (7) . b,  This icon is displayed for item No, That is, the current number is: NO.1。 To change the style, click the plus and minus symbols on the screen.

2) 、 Formula setting: To modify the parameter of item No, Click on the icon in screen

4.1. (7). B , Enter "formula setting" interface, See the figure below, After modification,

Click "save"  then press :

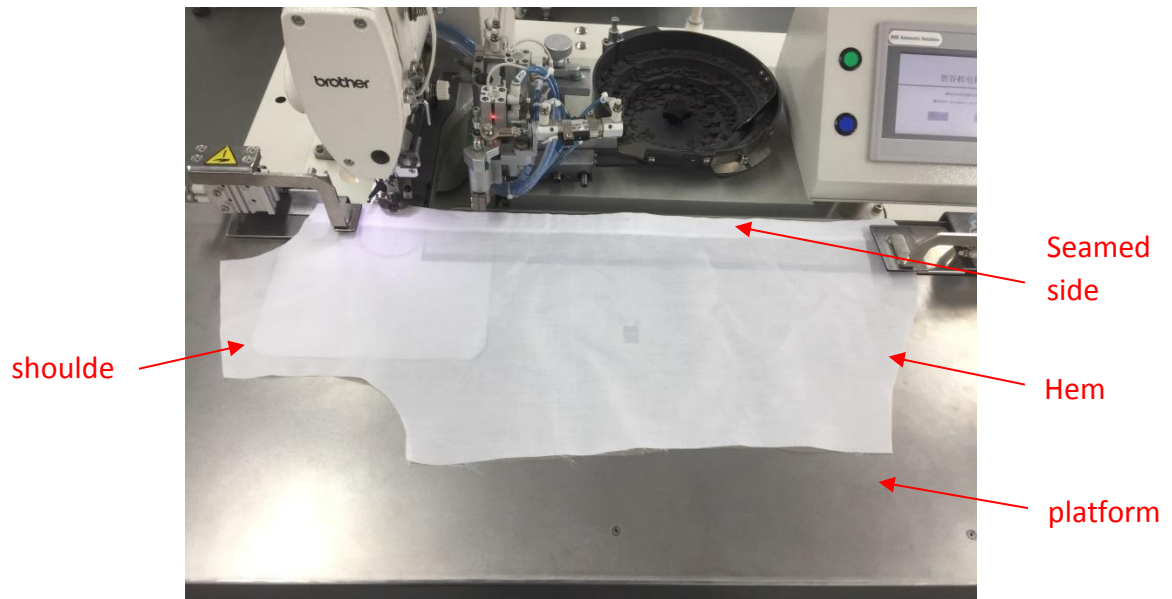


Button number

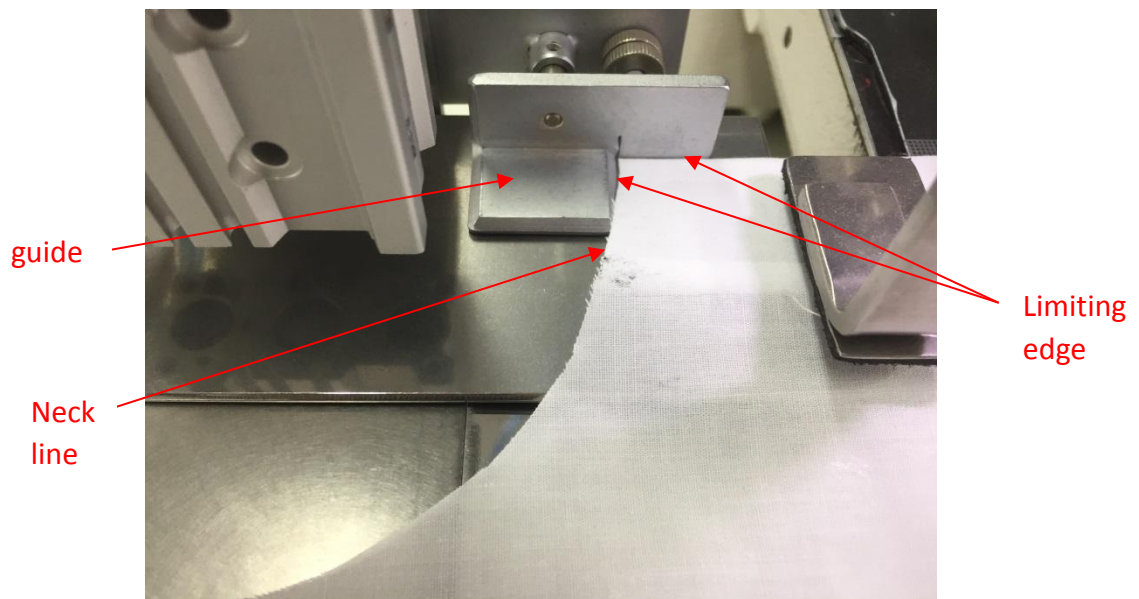
Button spacing

5.2.4. Fabric placement

1)、Cloth placement: spread the fabric horizontally on the placement plate, with the shoulder facing left, as shown in the following figure:



2)、Neckline alignment: align the neckline with the limit edge of the side position, as shown in the figure below:



3)、Garment piece alignment: the side of the sewing button is close to the cloth piece, as shown in the figure below:



5.2.5. Start air suction to adjust fabric automatic sewing

1) 、 Suction adjustment: Use your knees to rest on the knee switch panel, Do not loosen. At this time, the panel will open to absorb the fabric.

At the same time, the operator needs to adjust the position of the fabric to the best position, without wrinkles and skewness.

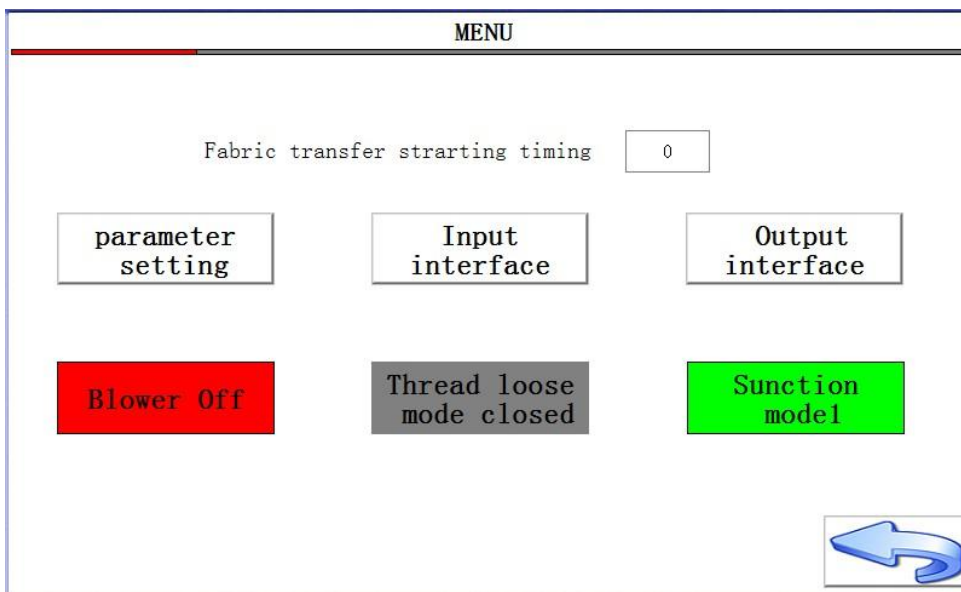
2) 、 Automatic sewing: after the fabric is adjusted, release the knee rest switch, and the program will perform automatic sewing.

3) 、 Automatic stacker: stacker after sewing

When the cloth clamping device is returned, the fabric can be placed again and repeated in turn.

5.2.6. Introduction to common parameter settings of menu interface

Click the menu in 4.1. (7). B to enter the "menu" interface below:



1) 、 Delay of drag motor: this parameter is used to adjust the action time of mop device, so as to match the receiving time, so as to achieve the best receiving effect.

2) 、 Parameter setting, output interface and input interface: these three options can only be accessed by providing a password, which is used to modify related parameters.

3) 、 Fan: this option is used to turn on and off the fan.

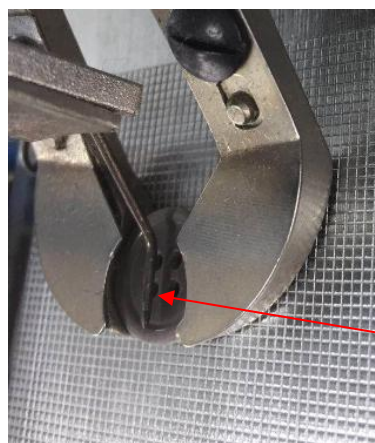
4) 、 Selection and function of suction mode: click "suction mode 1" on the screen to realize the conversion of "suction mode 1" and "suction mode 2".

Suction mode 1: in the process of sewing buttons and moving fabrics, the suction is always on until all buttons are sewn and the suction is off.

Suction mode 2: suction is turned on during button sewing and off during fabric moving.

*** The above two modes are adjusted for different fabrics, and the best mode can be selected according to the sewing effect.**

5) 、 Thread loosening mode off: this parameter is used to select whether the suture needs to be loosened or normal tightness. (when this function is turned on, the steel wire stretches out and the suture loosens; when this function is turned off, the steel wire retracts and the suture is of normal tightness)




steel wire

5.2.7. Make up operation

Status: when the button at a certain position on the cloth is not nailed; when the effect of the button nail is not good, it needs to be nailed again.

Operation steps: manually send the cloth under the needle, align it with the position to

be nailed, click 4.1. (7). B, and then click "make up" on the touch screen" ,


Machine completes sewing operation.

5.2.8. Thread break operation



In case of thread breakage during sewing, the machine will stop automatically and thread can be threaded at this time.

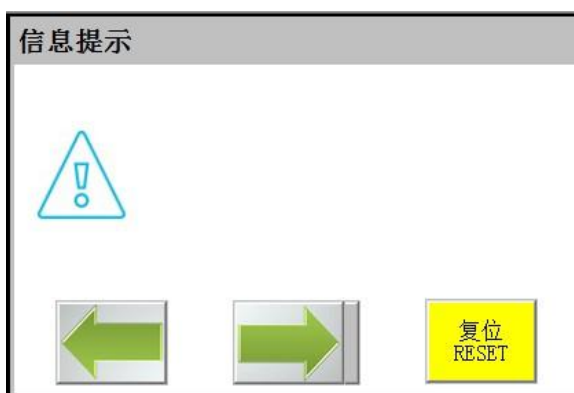
After threading, there are two situations:

1) 、 When the operator does not want to continue to sew the cloth:

At this time, you need to click the , The cloth piece returns to the initial position, the cloth clamping device is loosened, and the operator can take away the cloth piece;;

2) 、 When the operator wants to continue to sew the cloth:

Click the Green left and right arrows on the touch screen , , Select the position to start sewing, The knee lean up knee lean switch is released, and the machine continues to complete the unfinished nailing operation, as shown in the figure below:



5.2.9. Shutdown

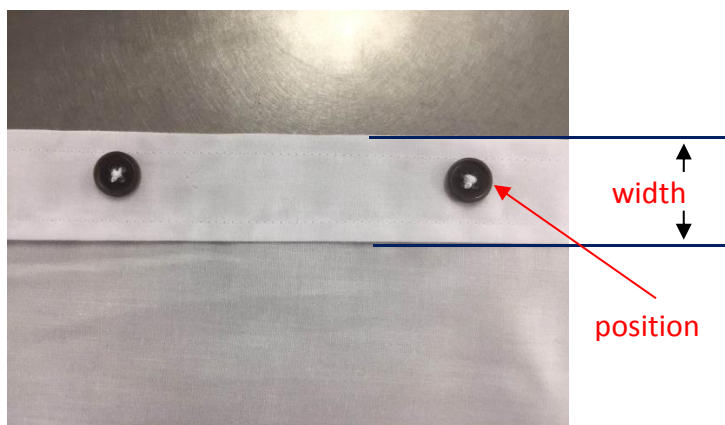
After operation, turn the power switch 90 ° to the off position, and the equipment will be shut down.

6、 Adjustment instructions of relevant parts

6.1. Adjustment of position

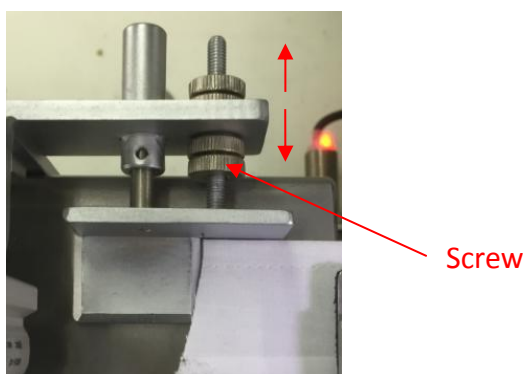
6.1.1.Button sewing description

When sewing the corresponding cloth for the first time, the position of the nail buckle may be deviated. At this time, the position of the cloth against the mountain needs to be adjusted. The figure below is the schematic description of the nail buckle position:

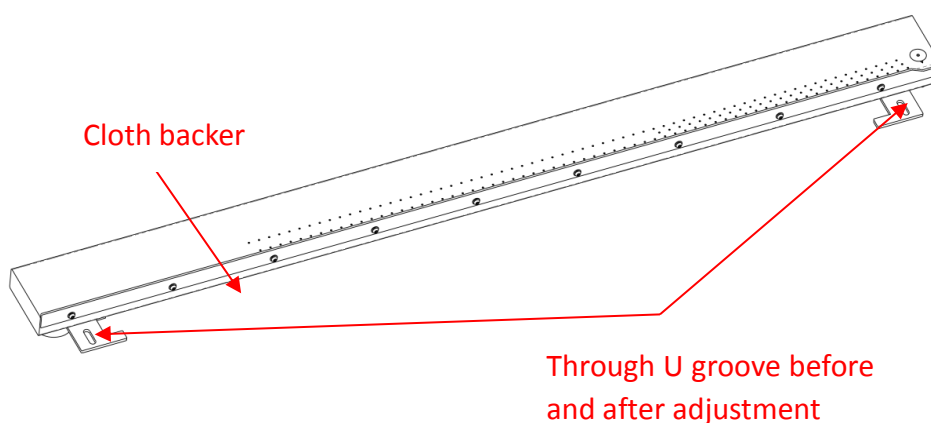


6.1.2. Adjustment method

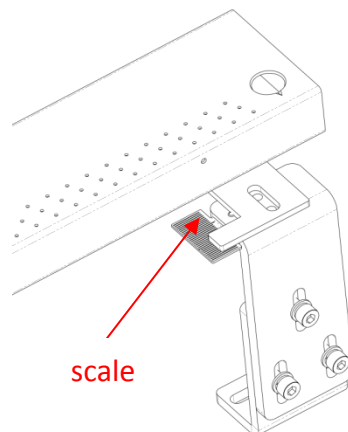
1) 、 Adjustment before and after parting:



2) 、 The front and back of the cloth is adjusted. :



3) 、 Refer to the scale beside for adjustment, as shown in the figure below:

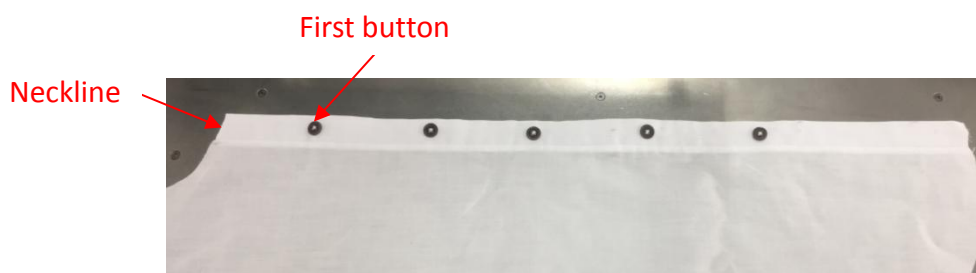


6.2. Adjustment of cloth clamping device

6.2.1. Description of adjustment

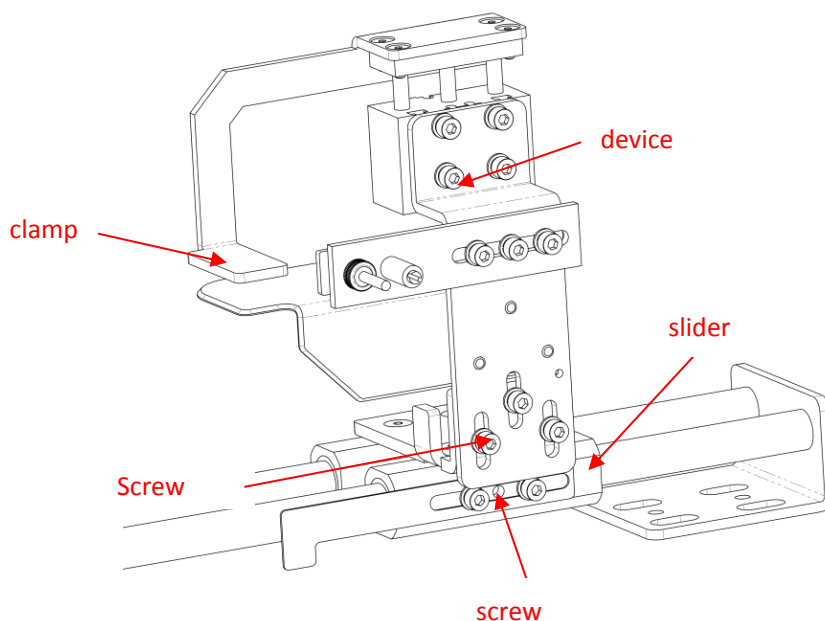
When sewing the corresponding cloth sheet for the first time, it is necessary to adjust the left and right positions of the left and right cloth clamping devices;

- 1) 、 Adjust the left cloth clamping device to determine the position of the first button to the neckline;
- 2) 、 Adjust the right cloth clamping device to match the length of the cloth, so that the clamp can clamp the cloth, as shown in the following figure:

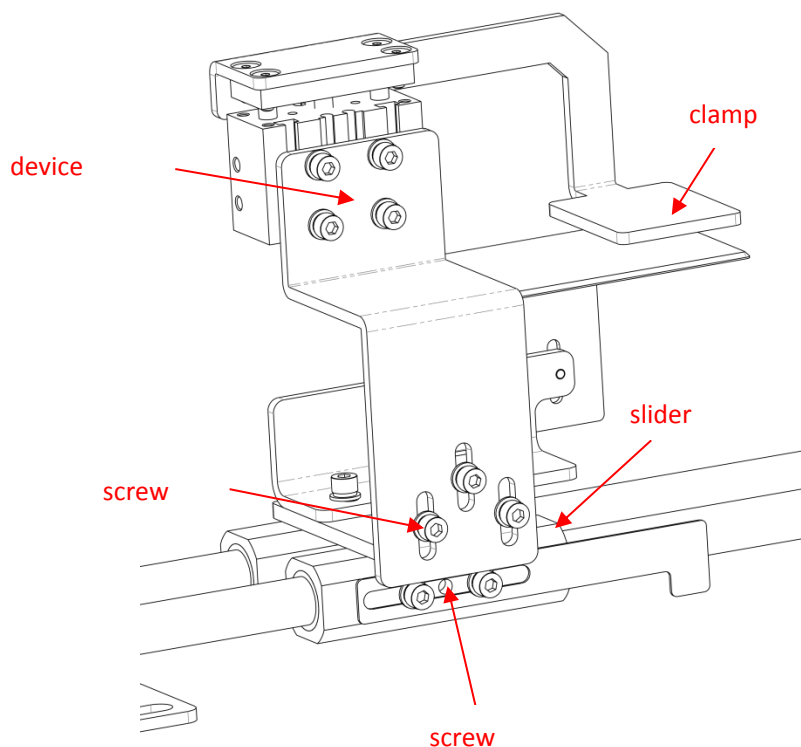


6.2.2. Adjustment method

- 1) 、 Left cloth clamping device: after unscrewing the set screw (1 place) in the middle of the slider, you can adjust the position left and right, as shown in the figure below:



2) 、 Right cloth clamping device: after unscrewing the set screw (1 place) in the middle of the slider, you can adjust the position left and right, as shown in the figure below:

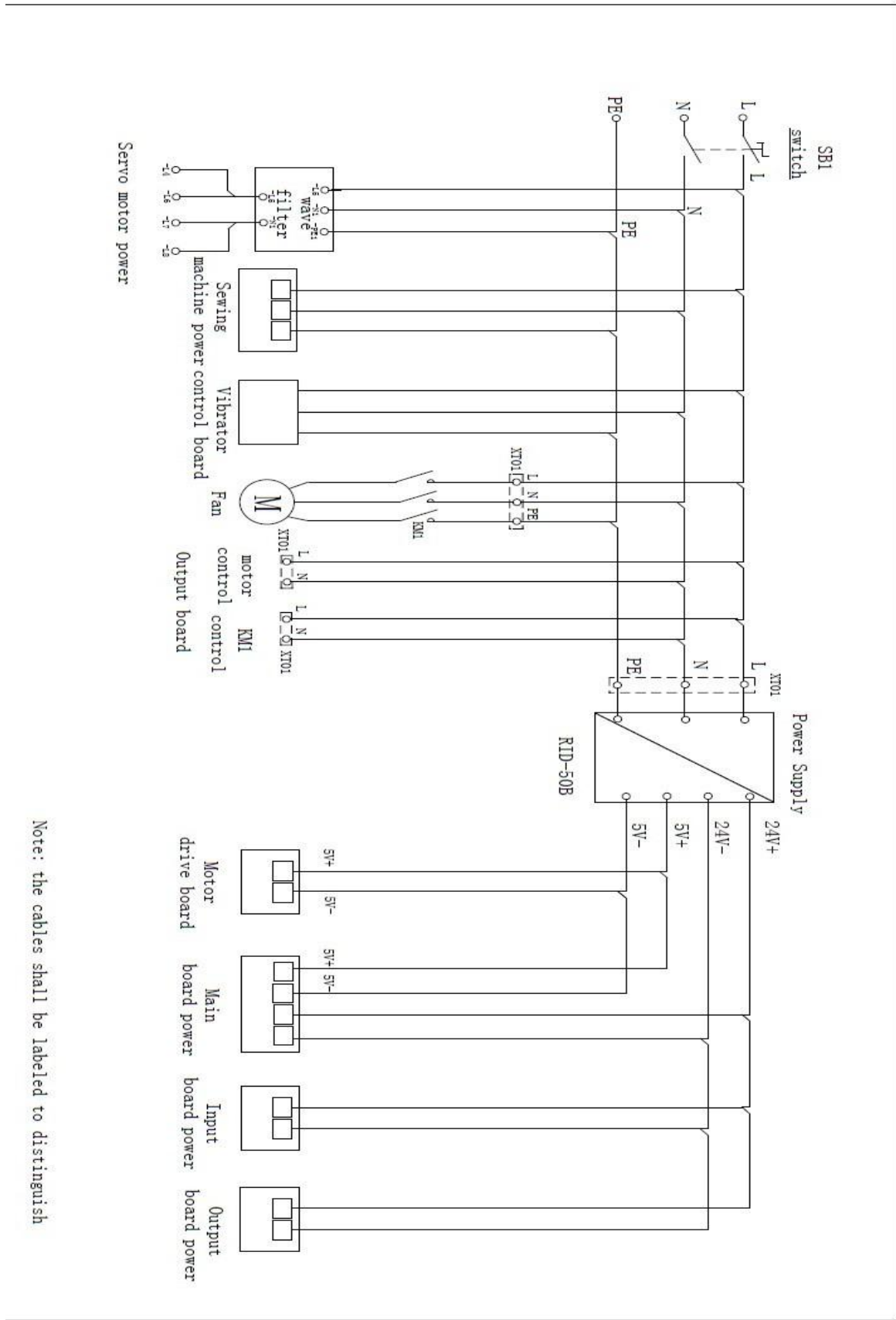


6.3. adjustment of cloth clamping device

When different kinds of cloth are replaced, the thickness of cloth is different, At this time, if the clamping effect of the clip is not good, it is necessary to loosen the adjusting screw to adjust the upper and lower positions of the clip, as shown in Fig. 6.2.2.1) and Fig. 6.2.2.2) :

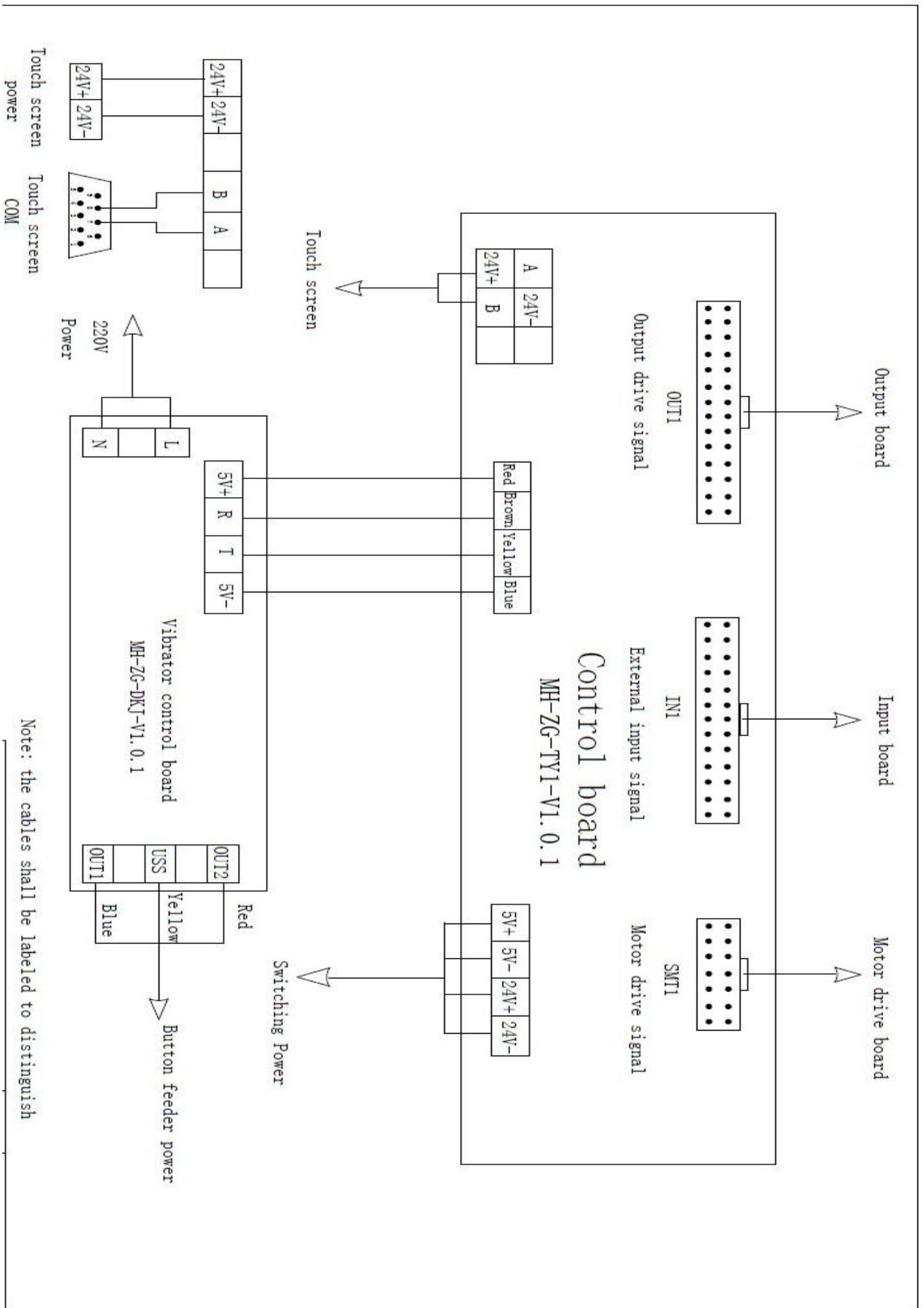
7、Electrical wiring

Main circuit diagram

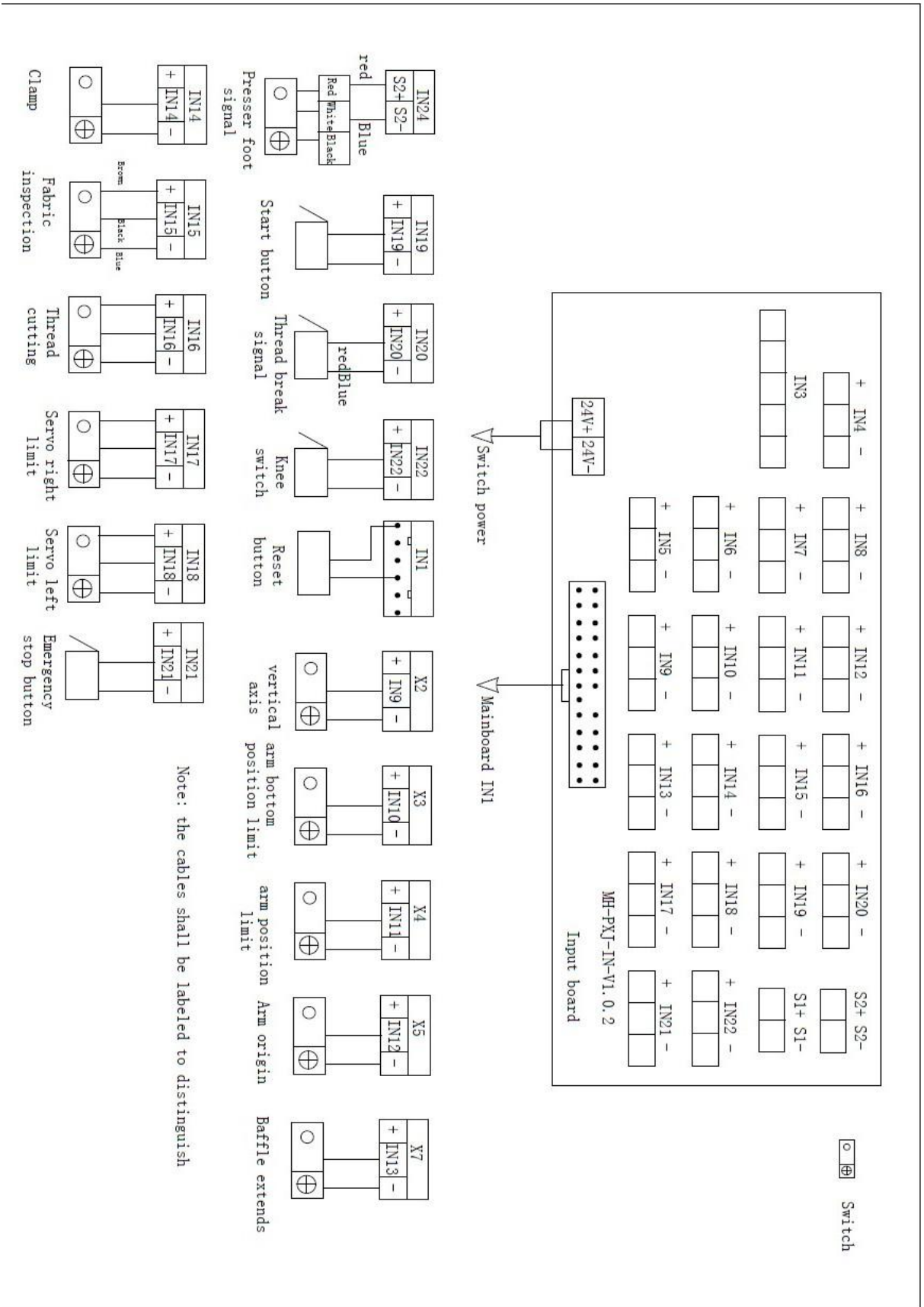


Note: the cables shall be labeled to distinguish

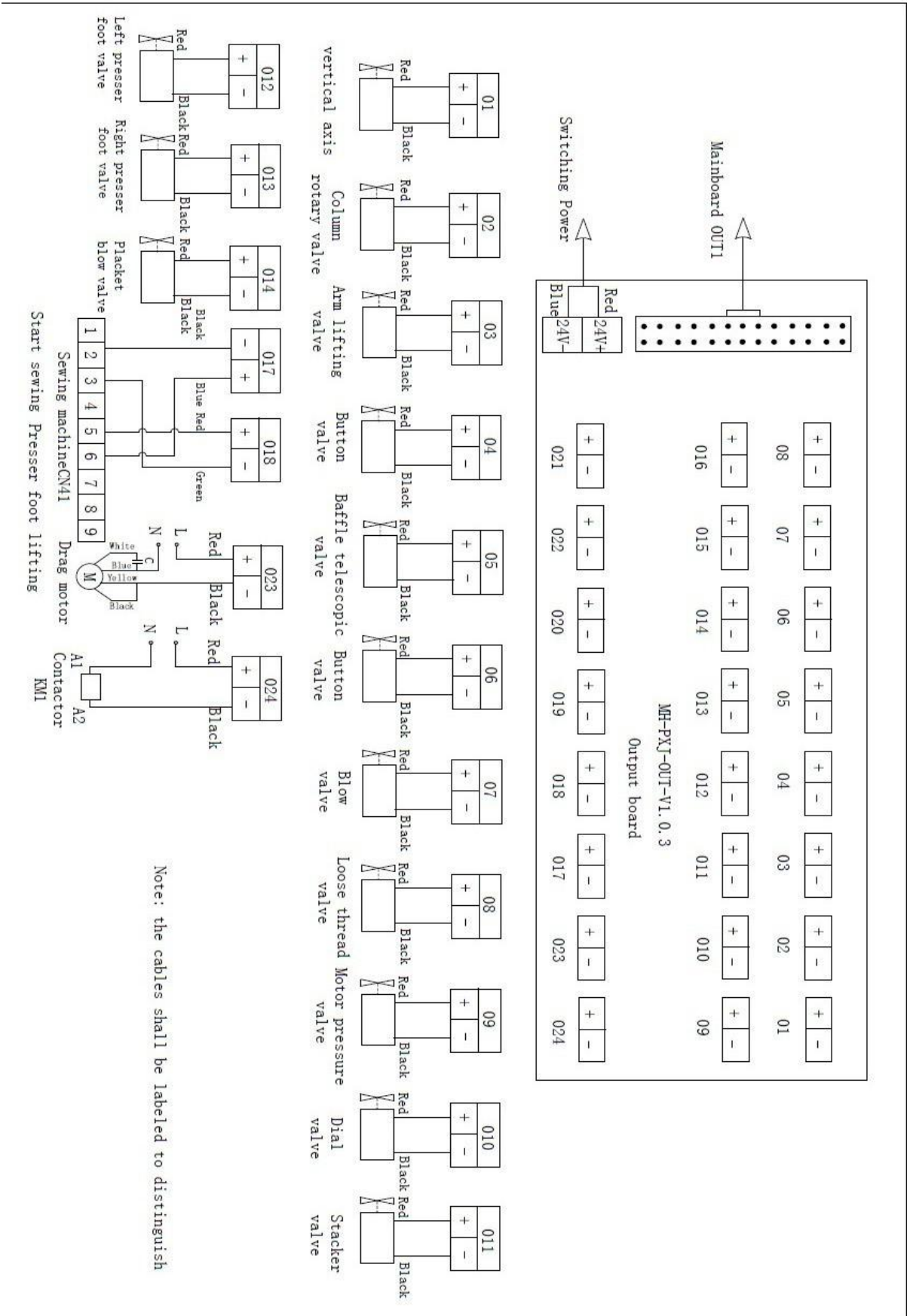
main control panel wiring



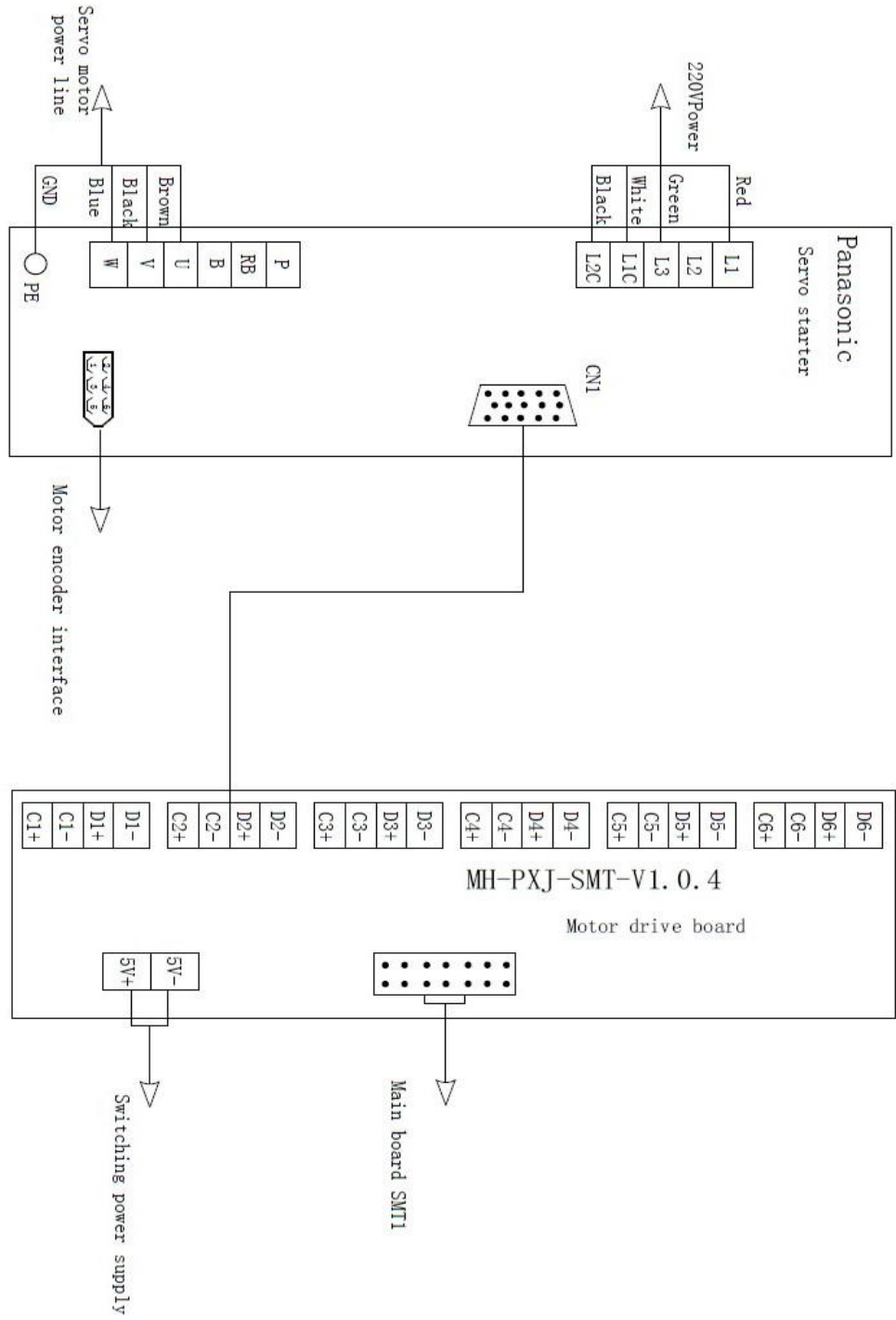
Input board



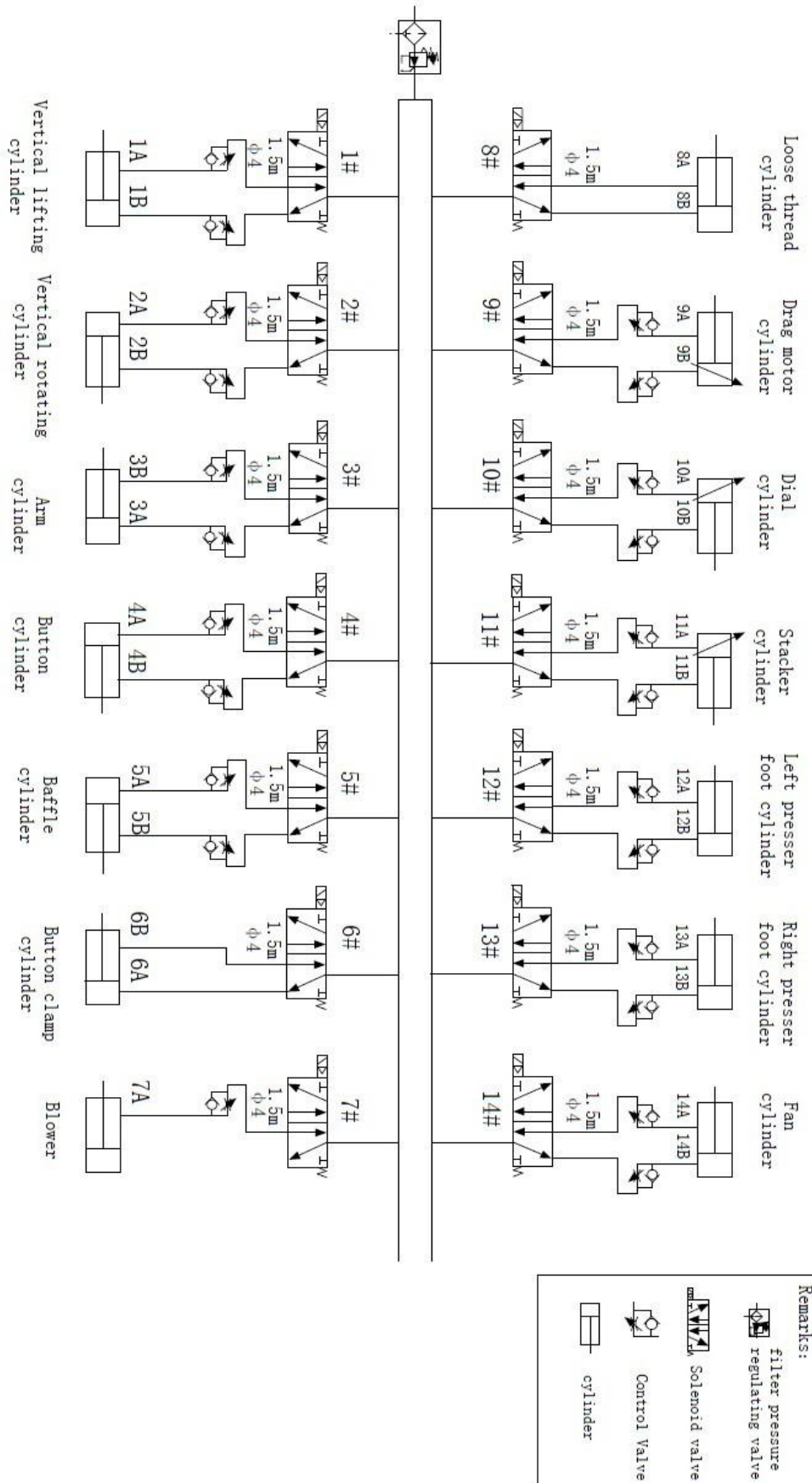
Output board



Driver board



Note: the cables shall be labeled to distinguish



8、Accessories box details

NO	ITEM		QTY
1	《Instruction manual》		1
2	《Parts Manual》		1
3	《Touch screen interface operation instructions》		1
4	Thread stand	Original accessories	1
5	Eye protector	Original accessories	1
6	Oil	Original accessories	1
7	Machine head cover	Original accessories	1
8	Accessory package	Original accessories	1
9	Manual (QR code)	Original accessories	1
10	Bushing		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	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

10、 Knowledge product protection statement

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