

送衬机

Linning Feeding Machine

(MB8002A)

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转录的。说明书的内容可能被修改，而不需预先通知。

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.

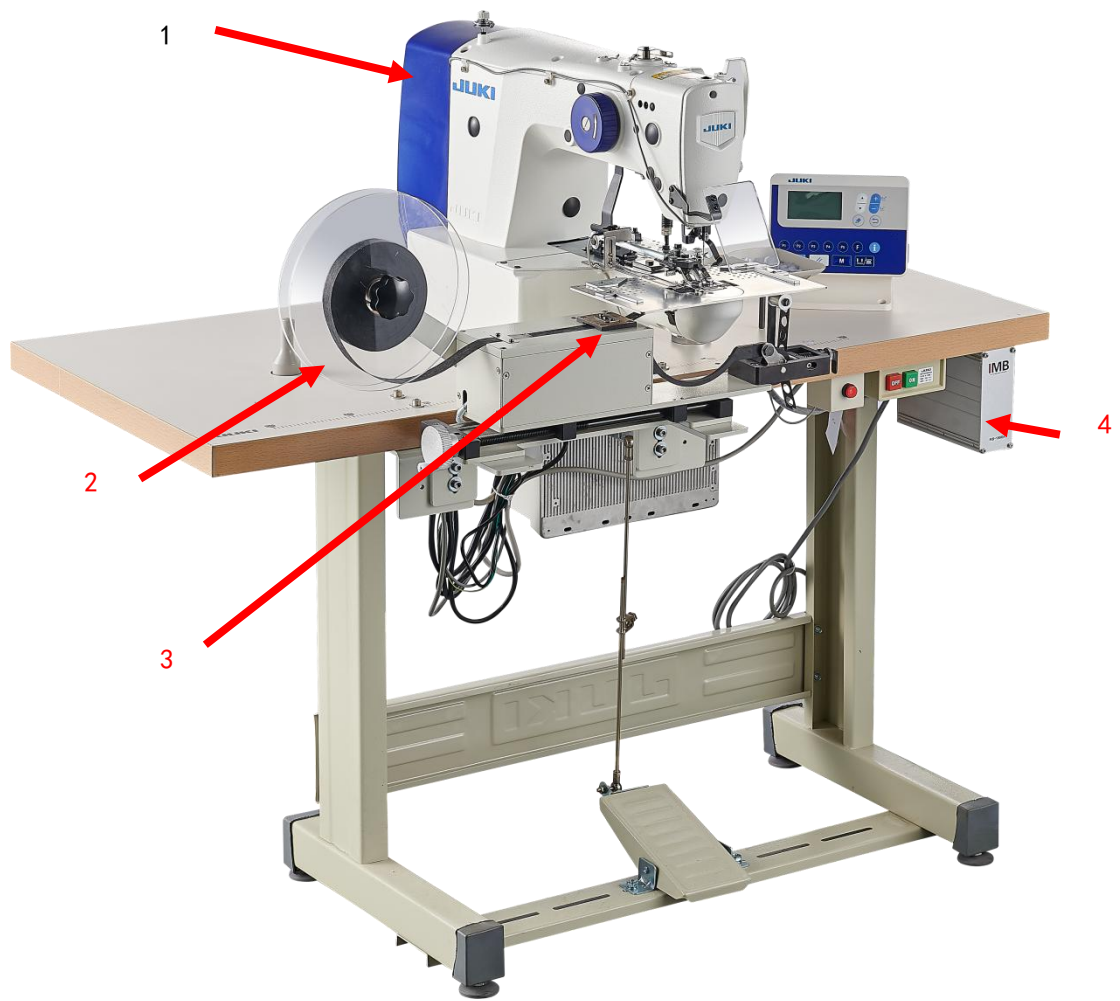
本机介绍说明分为二部分，具体请参照《MB8002A 送衬机-使用说明书》、《MB8002A 送衬机-零件手册》。

The introduction of this machine is divided into two parts. For details, please refer to 《mb8002a operation manual》 and 《mb8002a Parts Manual》

CONTENT

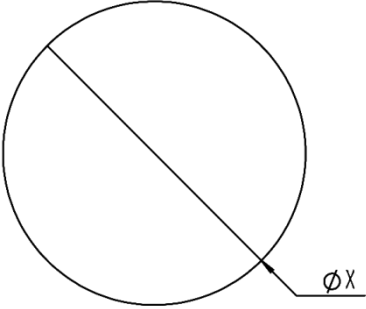
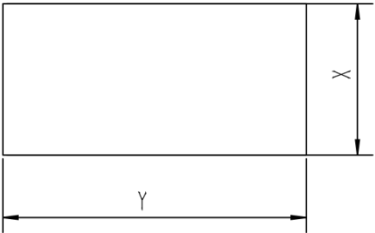
| | |
|---|----|
| 1、 ESSENTIAL INFORMATION..... | 1 |
| 2、 SPECIFICATIONS..... | 2 |
| 3、 SAFETY PRECAUTIONS..... | 3 |
| 4、 BUTTON FUNCTION DESCRIPTION..... | 5 |
| 4. 1. BUTTON FUNCTION DESCRIPTION..... | 5 |
| 5、 OPERATING INSTRUCTIONS..... | 6 |
| 5. 1. PREPARATION BEFORE OPERATION..... | 6 |
| 5. 2. OPERATION PROCESS DESCRIPTION..... | 6 |
| 6、 CHANGEOVER OPERATION..... | 7 |
| 6. 1. STEPS OF ADJUSTING THE FEED RATE OF MOVING KNIFE..... | 7 |
| 6. 2 Replacement steps of moving knife and solid knife..... | 7 |
| 6. 3 Mould replacement..... | 9 |
| 7、 ELECTRICAL WIRING..... | 11 |
| 7. 1. MAIN BOARD..... | 11 |
| 8、 OPTIONAL DEVICE..... | 12 |
| 8. 1. TABLE+STAND..... | 12 |
| 8. 2. SUPPORTING PLATE..... | 12 |
| 8. 3 KNIFE DIFFERENCE PARTS..... | 12 |
| 9、 COMMON PROBLEMS AND SOLUTIONS..... | 13 |
| 10、 DAILY MAINTENANCE REQUIREMENTS..... | 14 |
| 11、 KNOWLEDEG PRODUCT PROTECTION STATEMENT..... | 15 |

1、 ESSENTIAL INFORMATION





1: Machine head; 2: Loader; 3: Knife; 4: Control box;

2、SPECIFICATIONS

| MB8002A Lining feeding device | | |
|-------------------------------|--|---|
| 1 | Machine head | Button sewing/Bar tack machine |
| 2 | Working Voltage/V | 220 |
| 3 | Shape | Size |
| |  | Diameter ϕ 10-15 Thickness δ 0.2-1 |
| |  | X: 5-10 Y: 10-20: δ : 0.2-1 |
| | Other shapes can be customized | Pad $\delta \leq 1$ |

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): Manual button--Press the button manually, the device cuts a piece of lining.

(2): Pedal -- After pressing the foot pedal to finish sewing, the device automatically cuts a piece of lining and sends it under the needle to wait for the next sewing.

5、 OPERATING INSTRUCTIONS

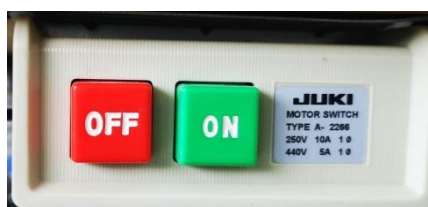
5.1. PREPARATION BEFORE OPERATION

- ✓ 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 whether the eye guard has been installed correctly

5.2. OPERATION PROCESS DESCRIPTION

1 BOOT DEVICE

Press the green button to turn on the device.



2 SEWING

Place the fabric manually in the work area, press the foot pedal, and the machine will sew automatically

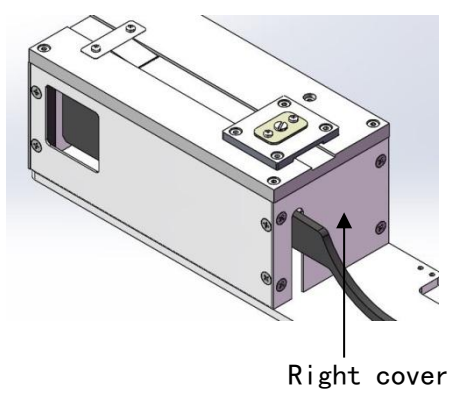
3 SHUTDOWN

After the operation is completed, press the red button to turn off the device.

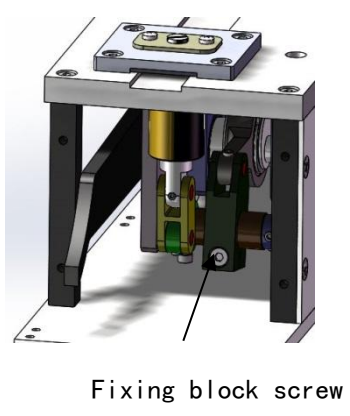
6、CHANGEOVER OPERATION

6.1. STEPS OF ADJUSTING THE FEED RATE OF MOVING KNIFE

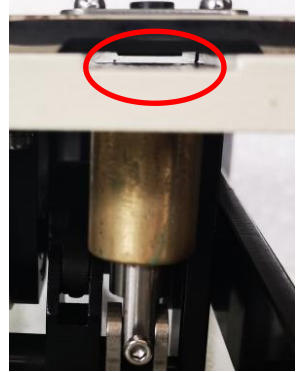
1. Remove the right cover fixing screw and remove the right cover



2. Loosen the fixing block screws



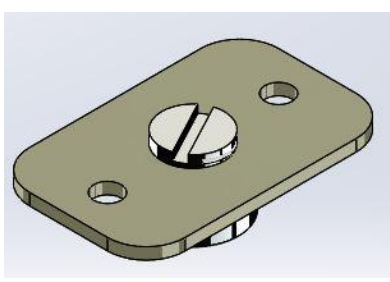
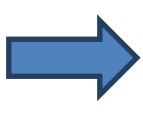
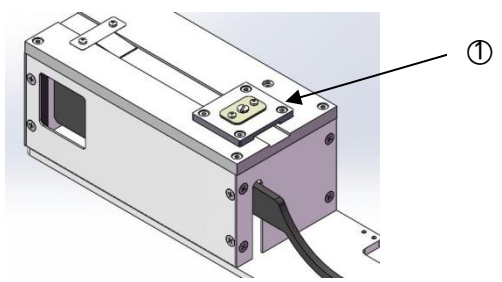
3. Move the knife up manually, about 1.5mm away from the fixed knife (through the lining clearance), and tighten the fixing block screws.



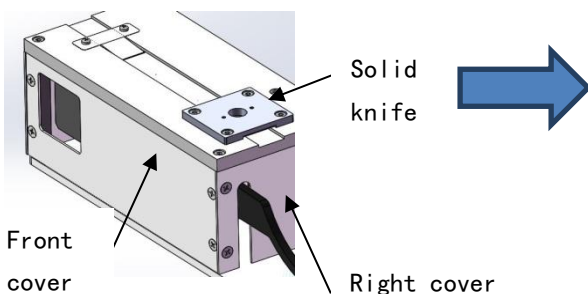
4. Assemble the cover disassembled in step 1 and adjust the knife.

6.2 Replacement steps of moving knife and solid knife

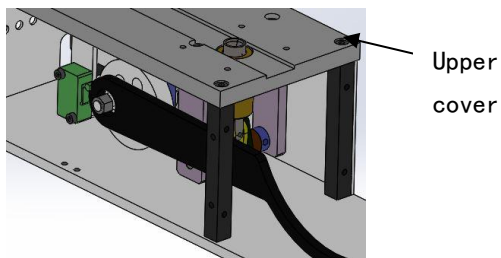
1. Remove the knife cover fixing screw and remove the knife cover assembly



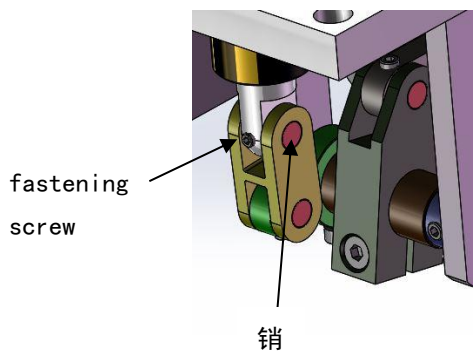
2. Remove the solid knife and front cover fixing screws, and remove the fixed knife, front cover, and right cover.



3. Remove the upper cover fixing screws.



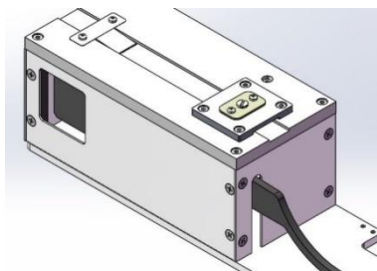
4. Lift the upper cover assembly, remove the moving knife fastening screw, knock out the pin on the moving knife, pull out the moving knife manually, and replace the new moving knife. knife.



5. Manually rotate the eccentric wheel to move the moving knife up, and the knife edge is higher than the upper cover.

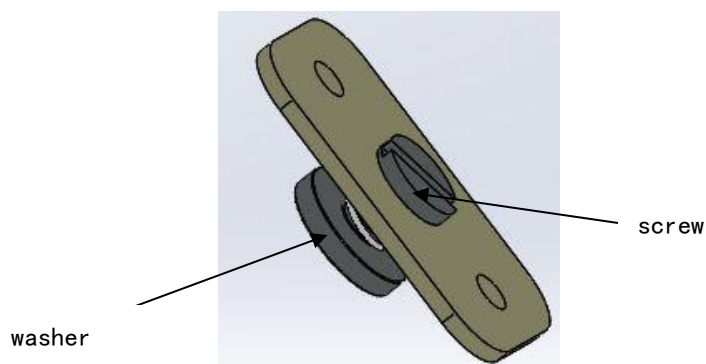


6. Align the new solid knife edge with the moving knife edge, press it on the upper cover plate, reassemble according to the above disassembly steps, The moving and fixed knife replacement is completed.

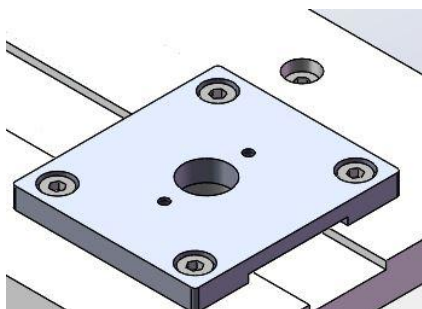


6.3 Mould replacement

1. Remove the knife cover assembly, fixed knife and front cover plate according to steps 1 and 2 of 6.2.
- 2 Remove the screws and replace the washers.



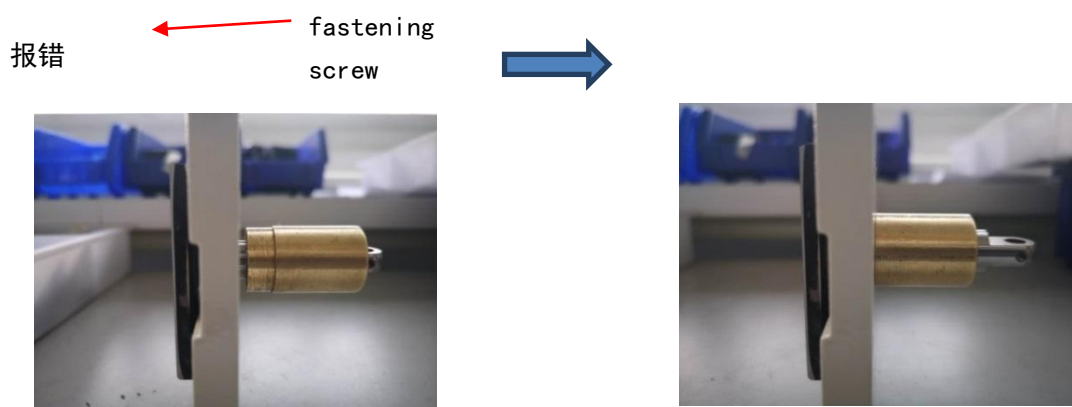
3. Remove the upper cover plate, the right cover plate and the moving knife according to step 2.3.4 of 6.2.
4. The copper sleeve is fixed by gluing. It is recommended to preheat it with a baking gun and knock out the copper sleeve.
5. Fix the fixed knife on the upper cover plate, the screw cannot be tightened, and the

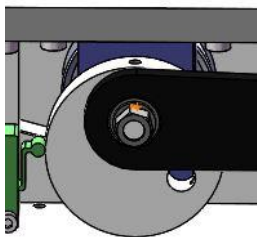


fixed knife can be moved.

6. Brush glue on the new copper sleeve to cover the copper sleeve on the moving knife, then insert the moving knife into the fixed knife edge, and insert the copper sleeve into the upper cover plate to ensure that the moving knife and the fixed knife are vertical. Tighten the fixed knife fixing screws until the glue solidifies.

7. Remove the fastening screw of the pin as shown in the figure, and adjust the hole position of the pin



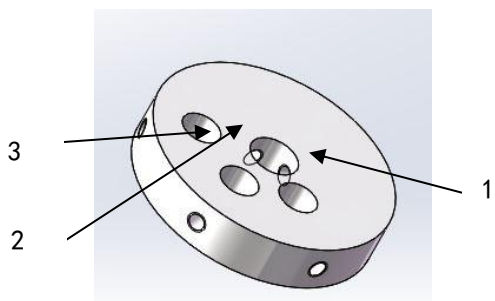


As the shape and size of the lining vary, the distance of feeding the lining also needs to be adjusted:

02800210102800 long rod with round 12mm lining is assembled in hole 1 (See parts manual for details of parts assembly);

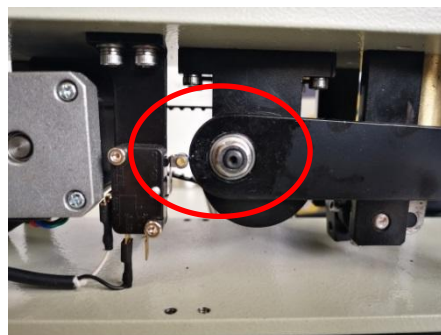
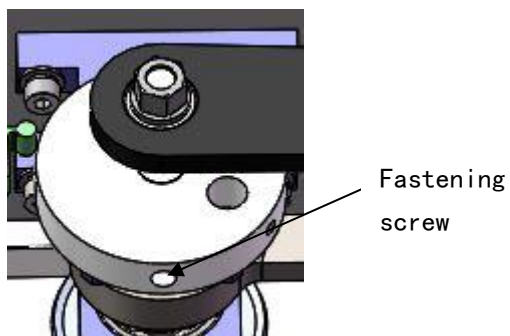
02800210102800 long rod with round 15mm lining is assembled in hole 2;

02800210102800 long rod with square 10 * 20MM lining is assembled in hole 3



8 Install the moving knife according to step 4 of 6.2.

9 Loosen the two set screws of the eccentric (left in the figure below), turn the eccentric



manually to the position as shown in the figure (right in the figure below), and tighten the screws.

10 Adjust the feed rate of moving knife according to 6.1.

11 Reassemble according to the above disassembly steps and complete the mould change.

7、ELECTRICAL WIRING

7.1. MAIN BOARD

| 8002A | | PORT | RESET STATUS |
|----------------|----|------|--------------|
| Presser switch | 2P | IN1 | 关 |
| Motor switch | 2P | IN2 | 关 |
| Button | 2P | IN3 | 关 |

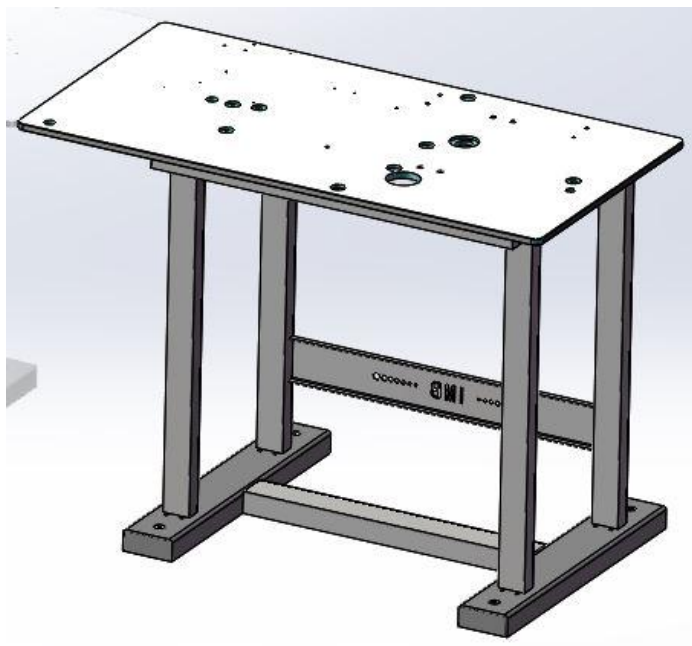
8、OPTIONAL DEVICE

8.1. TABLE+STAND

1、SIMPLE STAND+WOODEN TABLE



2、WELDING STAND+REINFORCEMENT TABLE



8.2. SUPPORTING PLATE

The support plate is divided into two types, BROTHER and JUKI. See details of different parts and assembly methods 《MB8002A Lining feeding machine-parts manual》

8.3 KNIFE DIFFERENCE PARTS

see 《MB8002A Lining feeding machine-parts manual》

9、COMMON PROBLEMS AND SOLUTIONS

| Fault phenomenon | Cause analysis | Solutions |
|--|---|--|
| <p>The cut interlining has silk adhesion besides the notch</p> | <ol style="list-style-type: none"> 1. The moving knife is not installed properly; 2. Normal working wear. | <p>Cause 1 adjust the feed rate of the moving knife according to the operation steps in 6.1.</p> <p>Cause 2 replace the moving knife and solid knife according to step 6.2.</p> |
| <p>Stitched lining not centered</p> | <ol style="list-style-type: none"> 1. Device position movement; 2. Bartack length adjustment. | <p>Adjust the guide mechanism: 050200913002 embossing hand wheel controls the left and right directions, two 050200904003 plum handle screws control the front and rear directions, and the specific adjustment direction is adjusted according to the actual direction of the lining deviation.</p> |

10、 DAILY MAINTENANCE REQUIREMENTS

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

11.2. Please refer to brother-bas-311hn for other maintenance requirements

| NO. | ITEM | 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 | Oil | | | √ | | Oil volume not lower than warning line |
| 4 | Bobbin | | | √ | | Check if the bobbin is scratched |
| 5 | Sensor | | | | √ | Check if the sensitivity is accurate and if the position changes |
| 6 | Slider | | | | √ | Check slide lubrication and add lubricant if necessary |
| 7 | Electric control box | | | | √ | Cooling fan runs normally, clean up the dust in time |

11、KNOWLEDEG PRODUCT PROTECTION STATEMENT

MB1002F 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.