

超声波缝合机

Ultrasonic lace machine(single motor)

(MB9018A)

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

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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.

本机介绍说明分为两部分，具体请参照《MB 9018A 超声波缝合机-使用说明书》、《MB9018A 超声波缝合机-零件手册》。

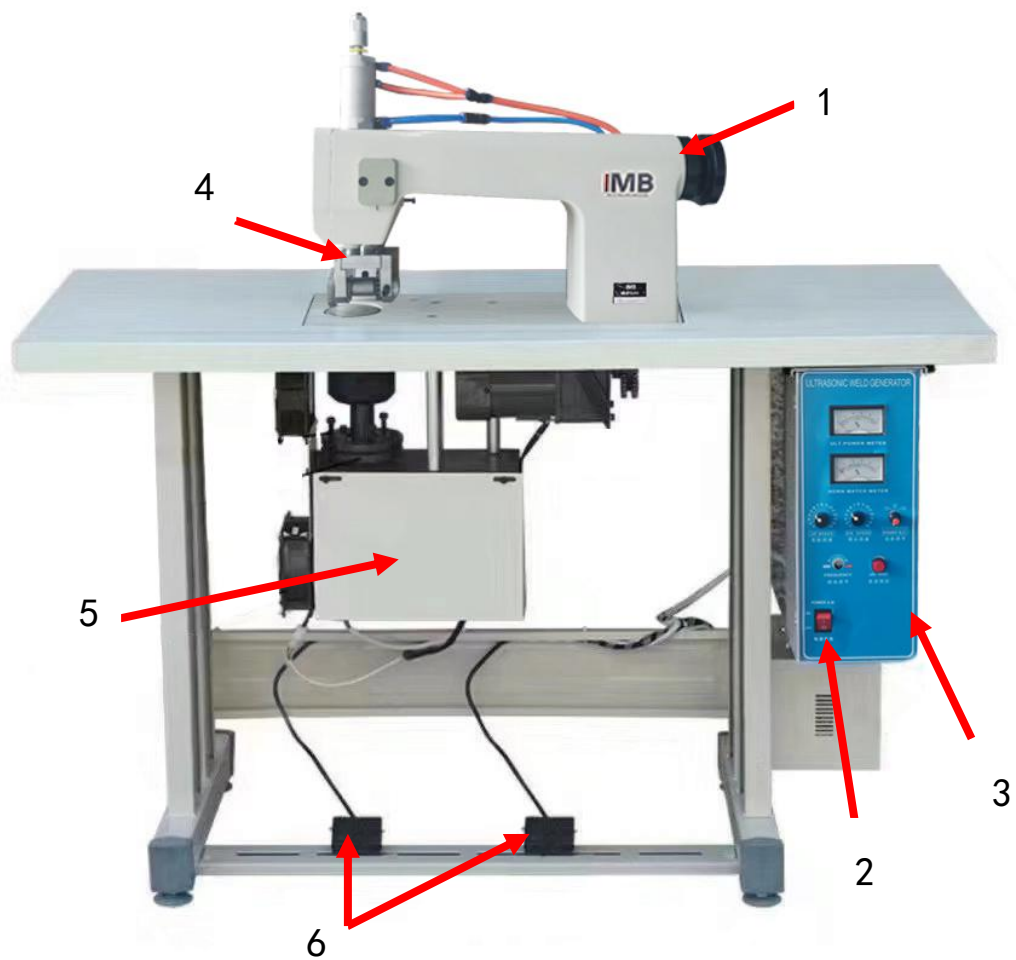
The introduction of this machine is divided into two parts. For details, please refer to 《MB9018A Operation manual》 and 《MB9018A Parts Manual》

ENGLISH

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1、 Basic information of the equipment



1: Machine head;
4: Wheel;

2: Power switch;
5: Ultrasonic components;



3: Control box;
6: Pedal;

2、 Technical parameters of the equipment

MB9018A Ultrasonic lace machine(single motor)		
1	Machine head	IMB
2	Voltage	0-2000V AC
3	Power	0-2000W (adjustable)
4	Frequency	20KHz
5	Power Supply	AC220V 50Hz
6	Pressure	0.3MPa
7	Frequency tracking	± 0.5 Hz
8	Speed	0-16m/min
9	Temperature	+5°C~+50°C
10	Size	1200mmX500mmX1150mm
11	Weight	90KG

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.

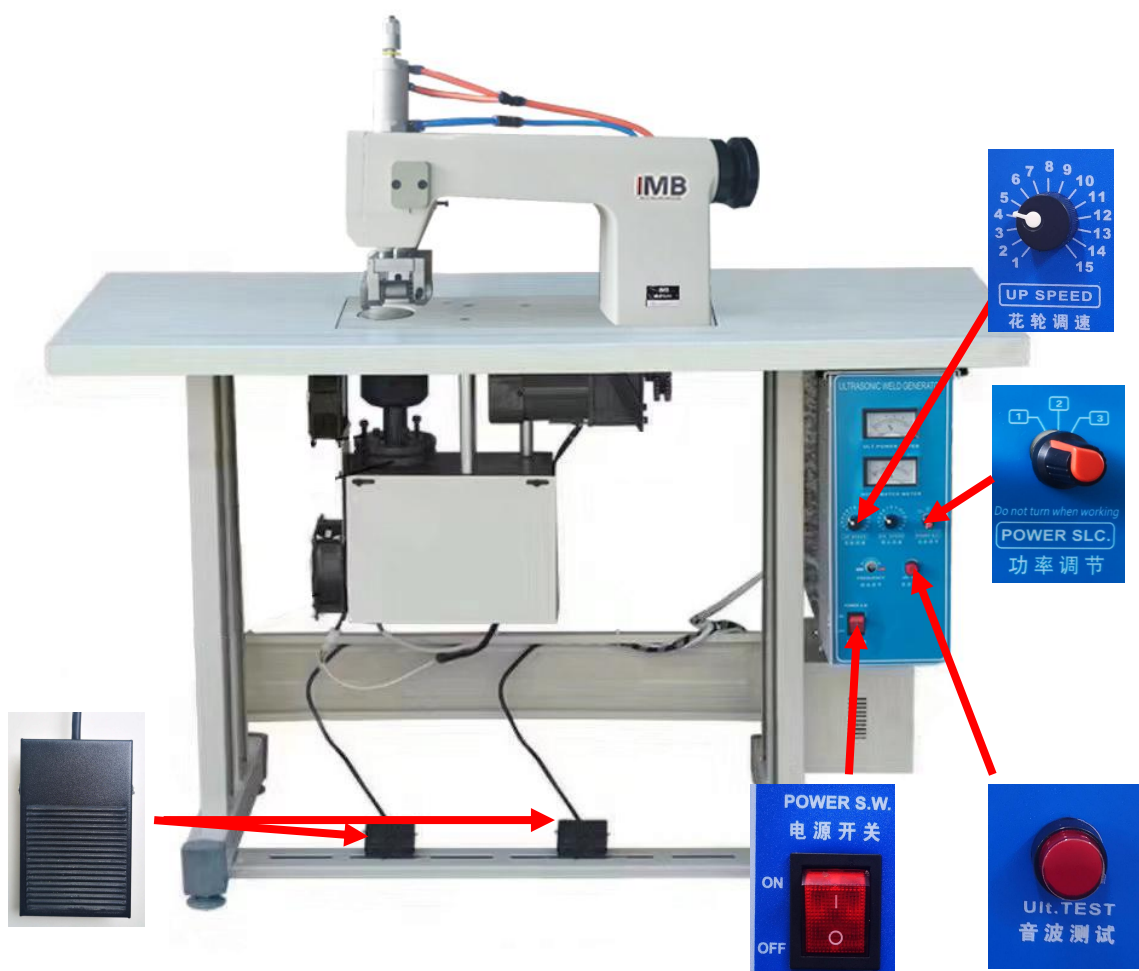
17. During folding operation, please be careful not to clip the cylinder to your finger when putting your finger into the folding machine.

*** 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 .Function description of the button



(1) : Power switch: press the power switch to on, and the equipment is powered on and ventilated.

(2) : Pedal:the left foot pedal controls the lifting of the pressing wheel and the flower wheel, and the right foot pedal controls the rotation of the flower wheel and the welding head.

(3) : Flower wheel speed control knob: rotate the flower wheel speed control knob left and right to adjust the rotation speed of the flower wheel

(4) : Sound wave test button – switch between ultrasonic short wave and long wave modes.

(5) : Power adjustment knob – adjust the power of ultrasonic.

5、 Operating instructions

5.1. Preparation before operation

- ✓ The machine head shall be in the stop state when the operator checks it
- ✓ 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

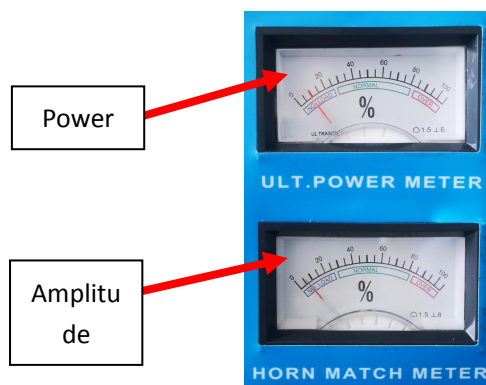
5.2. Operation process description

5.2.1 Boot device



Press 4.1-(1) power switch to ON, Power on the device.

5.2.2 Ultrasonic testing



step on Four point one -(2) The left foot pedal in the middle raises the flower wheel, press the sound wave test button under no-load state, the amplitude is within 10%, the power is within 15%, and the machine is normal,

5.2.3 Sewing

Place the cloth piece in the sewing area and press Four point one -(2) The right foot pedal in, the machine starts to sew, release the foot pedal and the machine stops.

5.2.4 Shutdown

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

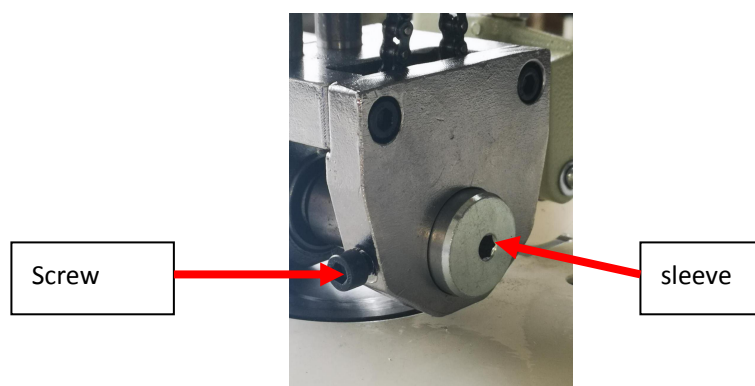
6、 Debugging method

6.1. Wheel speed adjustment



Turn the left wheel speed control knob to reduce the rotation speed of the wheel, and turn the right wheel speed control knob to increase the rotation speed of the wheel.

6.2. Flower wheel angle adjustment



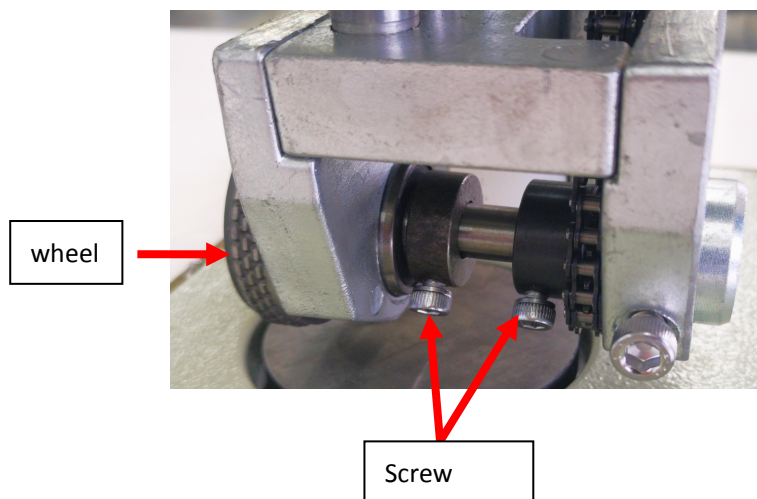
Loosen the fixing screw and rotate the eccentric sleeve to adjust the angle between the flower wheel and the welding head, so as to ensure that the thickness of each pressing edge of the flower wheel is equal.

6.3. Adjustment of depth of flower wheel indentation



Loosen the fixing nut, rotate the limit sleeve, adjust the stroke of the cylinder, and change the indentation depth of the flower wheel.

6.4. Mold replacement



- 1) Remove the two fixing screws and take out the flower wheel;
- 2) Insert the new flower wheel to be replaced into the bearing and tighten the two fixing screws;
- 3) According to Six point two Step to adjust the angle of the flower wheel and complete the mold replacement.

6.5. Ultrasonic adjustment

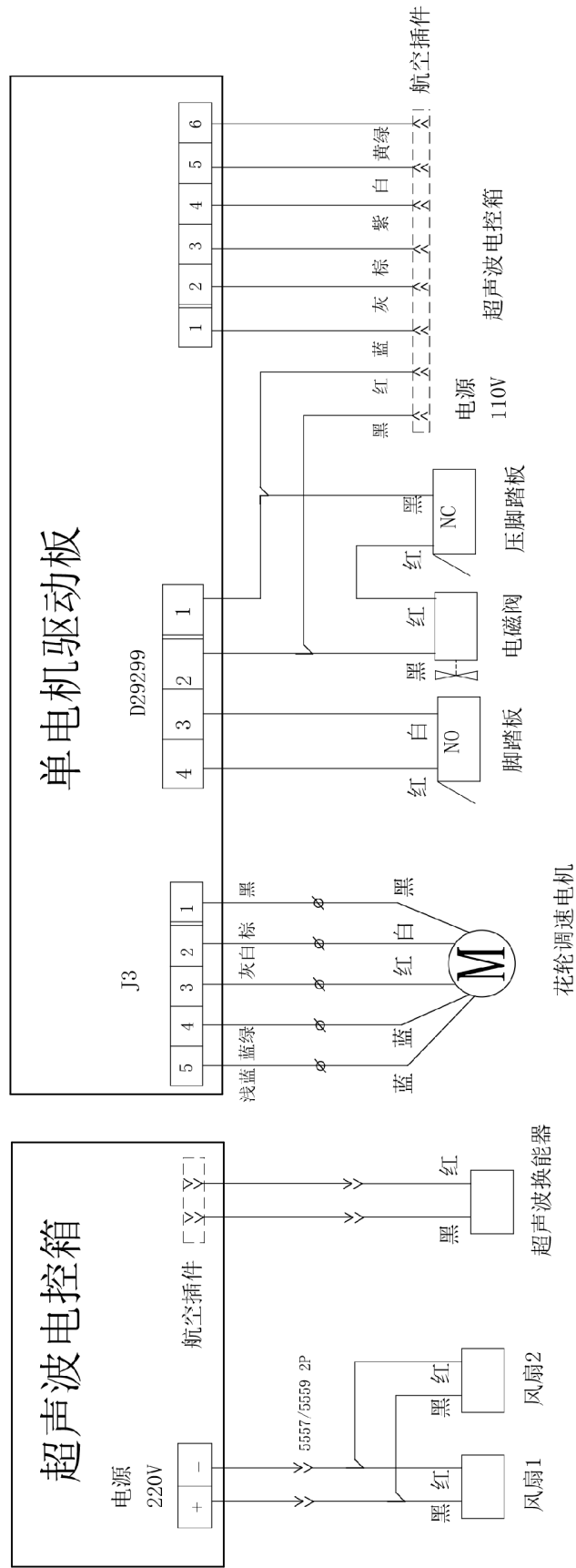


When the amplitude is greater than 10%, turn the frequency adjusting knob with a cross



screwdriver, There is no fixed direction. It needs to rotate left and right to find the center point. Adjust the amplitude to less than 10% and the power to less than 15%

7、Electrical wiring



8、 Optional device

Support customization of flower wheel and pattern

10、 Common problems and Solutions

10.1. See the table below for common problems and Solutions

Phenomenon	Cause analysis	Solutions
Uneven left and right edge pressing of flower wheel	The flower wheel is not vertical to the welding head	according to Six point two Step to adjust the flower wheel angle
Shallow or deep impression of flower wheel	Small or large cylinder stroke	according to Six point three Step adjust cylinder stroke

11、 Daily maintenance requirements

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

NO	Project	Frequency				Requirement
		Daily	Weekly	Monthly	Half year	
1	Dust removal	√				Remove dust from equipment surface and parts
2	Clean up oil		√			Clean the oil stain on the platform
8	Air pipe interface			√		The air pipe interface is tight without air leakage
13	Slide				√	Check the lubrication of sliding parts and add lubricant if necessary
14	Electric control box				√	Cooling fan operates normally, clean dust in time

12、 Knowledge product protection statement

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