

拼橡筋机

Elastic Jointer

(MB1008A-BR-BAS311HN-03A)

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

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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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《MB1008A-使用说明书》、《MB1008A-零件手册》、《MB1008A-触摸屏界面操作说明》。

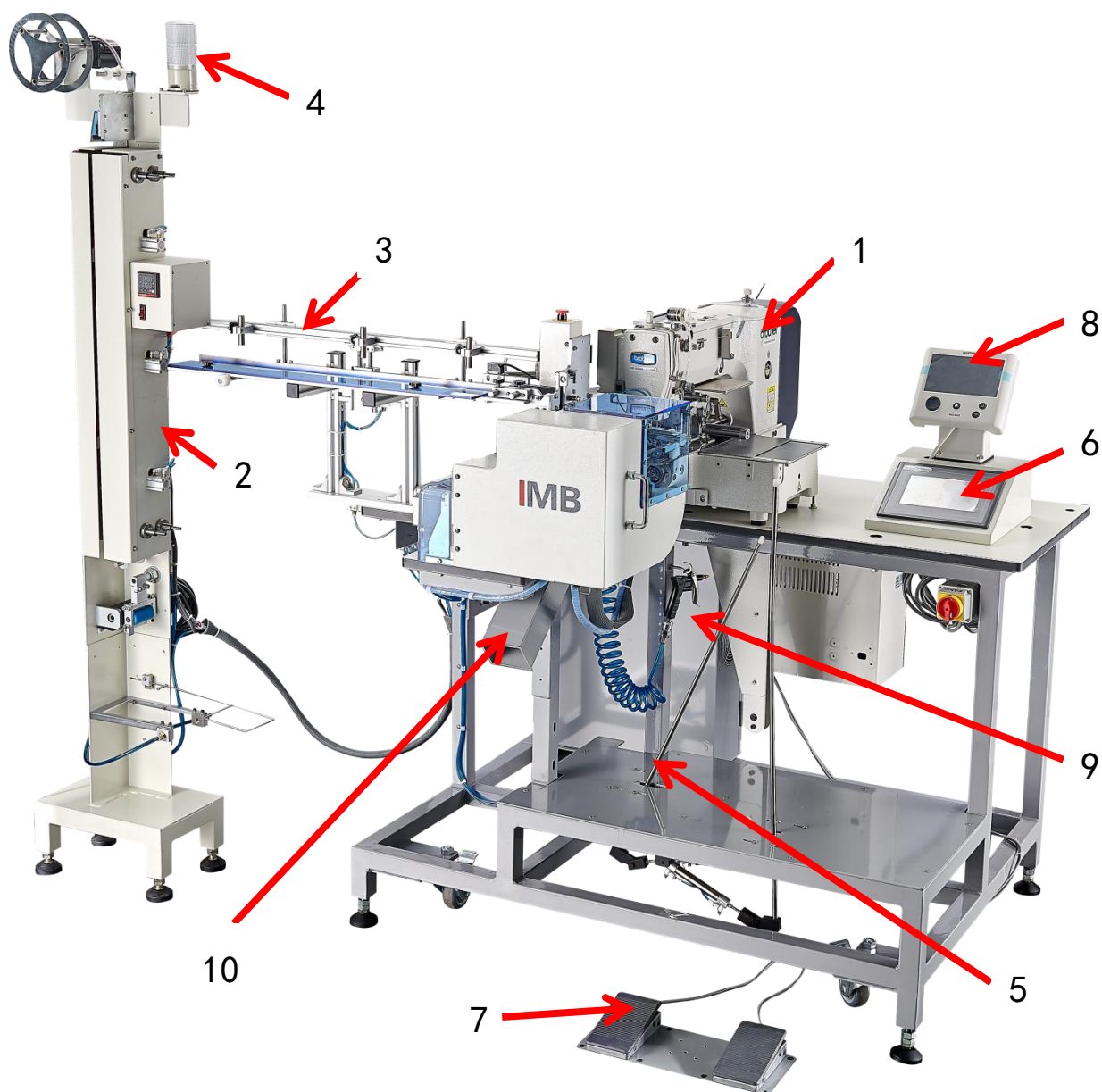
The introduction of this machine is divided into three parts. For details, please refer to 《MB1008A Operation manual》 and 《MB1008A Parts Manual》《MB1008A Touch screen interface operation instructions》

ENGLISH

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1、Basic information of the equipment





- | | | | |
|-------------------------------|------------------------|--------------------|------------|
| 1: BR-BAS-311HN Machine head; | 2: Pressing mechanism; | 3: Dot mark; | 4: Warning |
| Light | 5: Stacker; | 6: Touch screen; | 7: Pedal; |
| 8: Machine head touch screen; | 9: Control box; | 10: Waste passage; | |

2、Technical parameters of the equipment

MB1008A Elastic jointer		
1	Machine head	brother-BAS-311HN
2	Maximum sewing speed /rpm	2800
3	Working voltage /V	AC220
4	Working pressure /Mpa	0.5
5	Stitch length /mm	0.05--12.7
6	GST	Width:15mm, length:370mm, Stitches number:60, sewing speed 2200r / min
7	Working efficiency	857 PCS/H
8	Minimum rubber length /mm	300
9	Minimum rubber width /mm	10
10	Maximum rubber width /mm	50
11	Size/mm	1750L×1500W×1450H
12	Weight/kg	287

3、Safety precautions

Considerations 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 electrical box of the motor or touch the parts in the electrical box when the power is connected.
 注意	<ol style="list-style-type: none"> 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. 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. 3. To prevent personal injury, please do not put your finger near the needle when turning on the power or running the machine. 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. 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. 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. 7. Please do not cut off the power or air supply while the machine is running. 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. 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. 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. 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. 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. 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>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> <ol style="list-style-type: none"> 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. 16. When the power switch is turned off during the foot press action, please

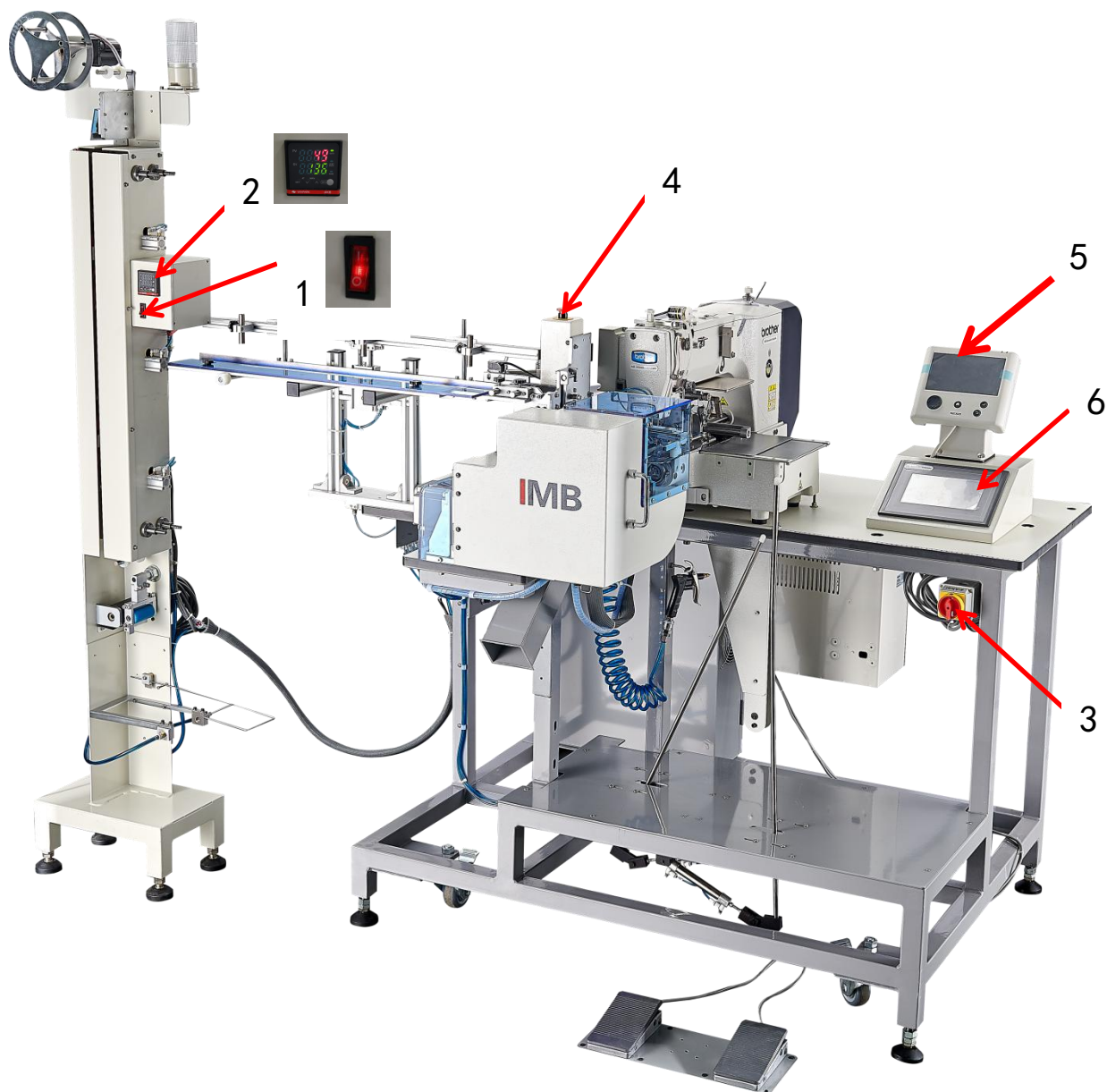
	<p>be careful not to pinch your fingers.</p> <p>17. During folding operation, please be careful not to clip the cylinder to your finger when putting your finger into the folding machine.</p>
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*** important safety information:**

- ✓ 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

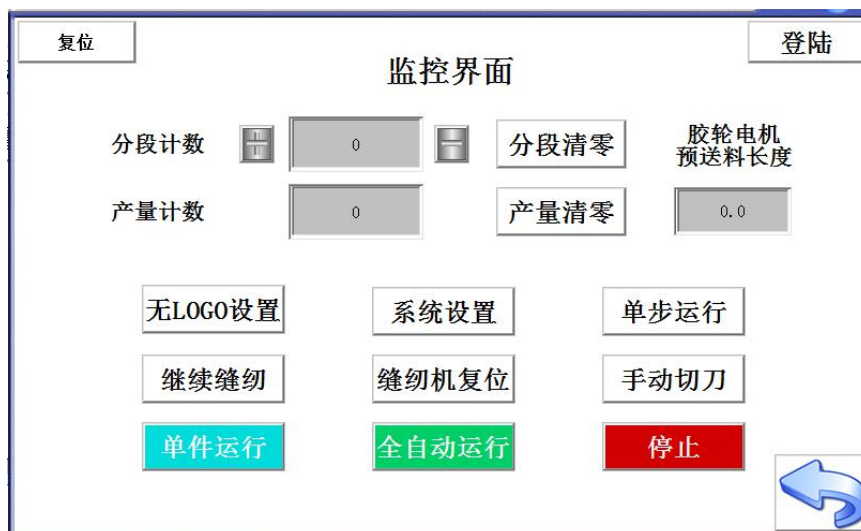


- (1) : Pressing mechanism power switch – the mechanism starts to heat up.
- (2) : Temperature control meter – control and display heating temperature.
- (3) : Main switch: ventilate and power on the equipment after rotating 90 ° 。
- (4) : Emergency stop switch – press this switch in case of emergency to stop the mechanical operation.
- (5) : Head touch screen – see the head operation manual for details.
- (6) : Equipment touch screen--see 《MB1008A interface description》 。

a: Boot interface



b: Monitoring interface



4.2.Reset operation instructions

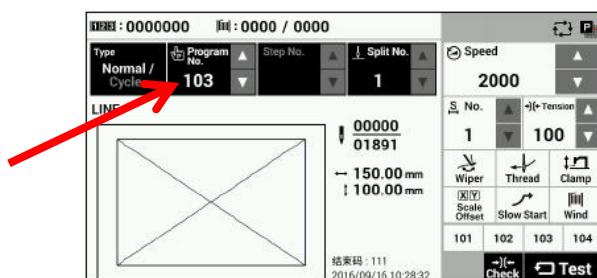
4.2.1 Boot reset operation

a. Turn on the 4.1 (3) main switch, and the head and device will reset automatically at the same time;

b. Check whether the program number on the touch screen of 4.1 (5) head flashes (see the figure below):

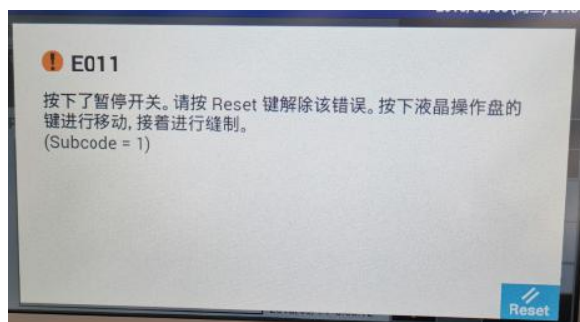
No flashing: that is, the power on reset is completed, the touch screen of the device enters the power on interface 4.1 (6) – A, and the language is selected to enter the 4.1 (6) B monitoring interface;

Flashing: Select language in 4.1 (6) – a of the device touch screen boot interface to enter 4.1 (6) B monitoring interface, Press **缝纫机复位**, Power on reset operation completed.



4.2.2 Emergency stop reset operation

Status: head touch screen alarm, as shown in figure (1); See figure (2) below for equipment touch screen alarm; warning light flashes red.



(1)



(2)

Operation:

- ① Turn the emergency stop switch clockwise to the normal position;
- ② Press **Reset** on the pop-up window of the head touch screen to release the head alarm;
- ③ Press **复位** on the pop-up window of the touch screen of the device to reset the device.

Note: only when the sewing of the machine head is interrupted, the touch screen of the machine head will prompt whether to continue sewing after ② operation is completed:

At this time, press yes, and then press continue sewing on the touch screen of the device, and the device will continue to finish sewing.

At this time, press no to reset the sewing machine. Press reset on the device

screen to reset the device.

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

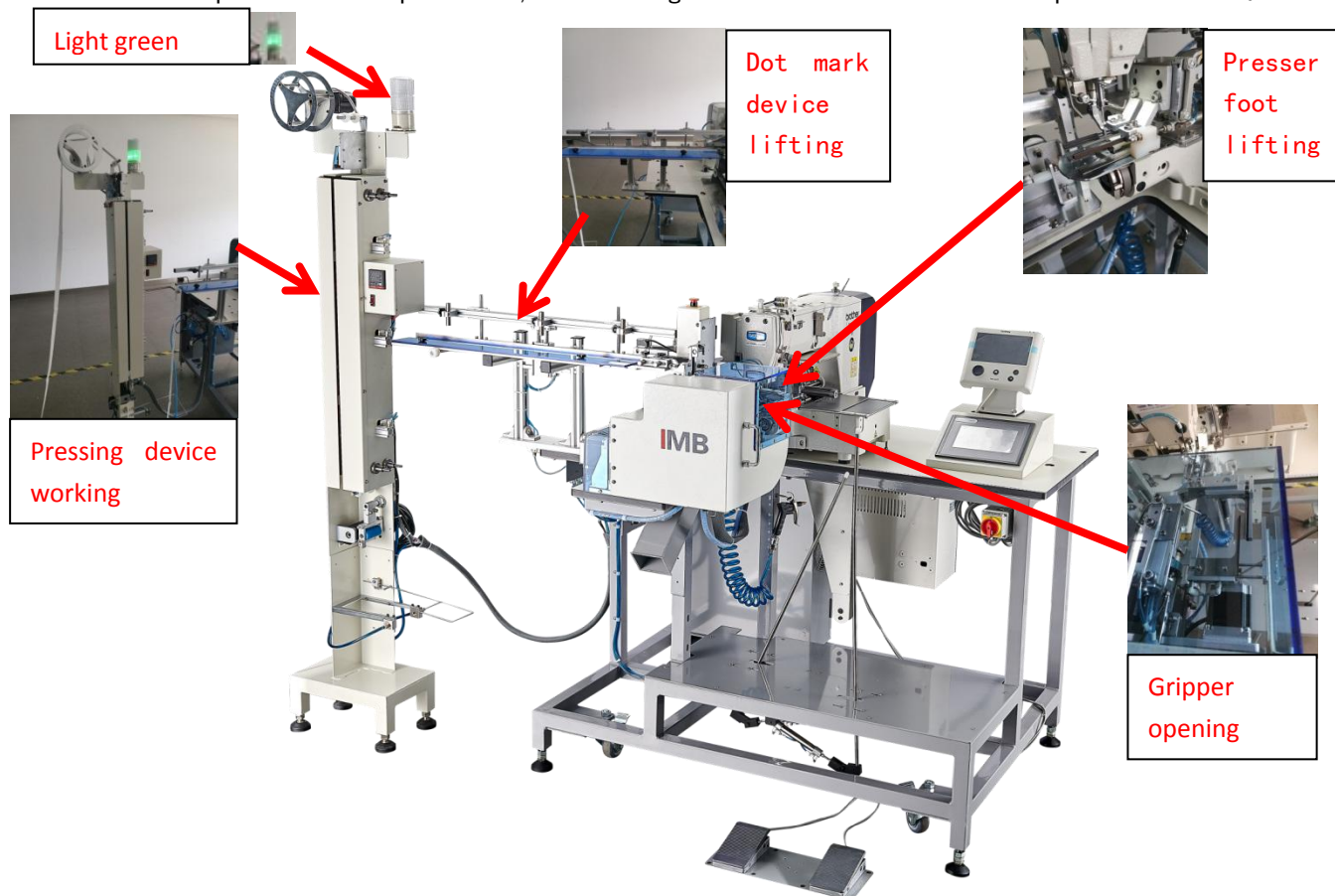
- a. Turn the power switch 4.1 (3) to the on position at 90 ° and power on the equipment.



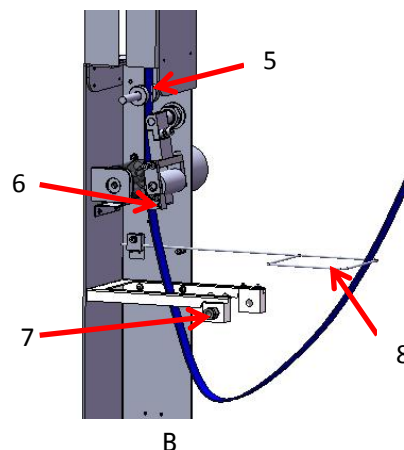
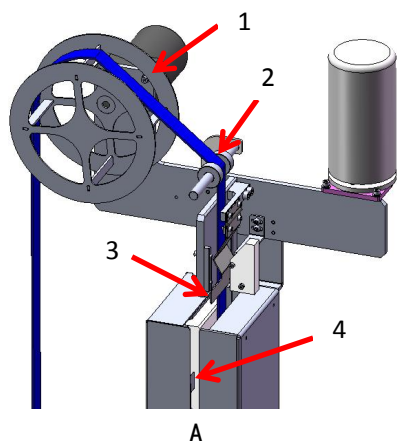
- b. Turn on the pressing switch as required 4.1 (1) . Rubber band with crease can open pressing device, no crease can close pressing device.

5.2.2 Reset operation

Start up and reset as per 4.2.1, and the figure below shows the reset completion status.

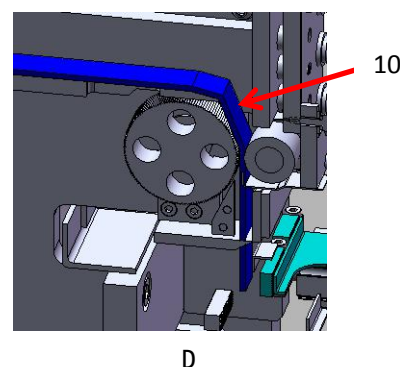
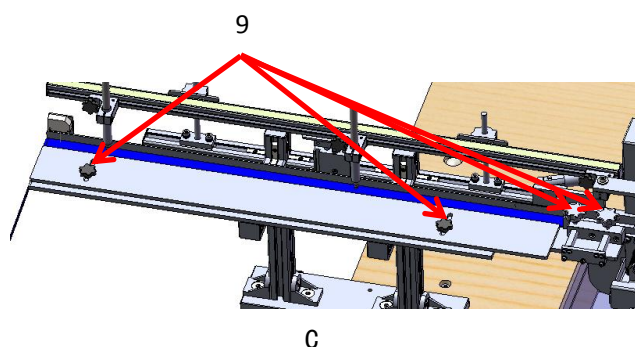


5.2.3 Rubber band threading



a. Pass the rubber bar around the 1 rotary table, clamp the rubber bar by adjusting the limit roller at the 2 position, push the trigger plate at the 3 position and let the rubber bar fall into the 4 pressing plate, as shown in Figure a.

b. Clamp the rubber bar by adjusting the limit roller at position 5, push the paddle at position 6, thread in the 8 paddle, pull in the rubber bar to make the rubber bar fall under the 7 sensor, as shown in Figure B.



c. Place the rubber bar on the feeding plate, adjust the front and back position of the baffle plate by 9 hand screws, so as to keep the rubber bar properly pressed during feeding, as shown in Figure C. .

d. Press the 4.1 (6) – B monitoring interface after the rubber bar passes through the pressing wheel and exceeds the position of the cutter 手动切刀, After cutting the surplus material, the threading is completed, as shown in Figure D.

5.2.4 Set rubber length

(1) Press in 4.1 (6) – B monitoring interface 无LOGO设置, Open the following interface

无LOGO参数设置

A橡筋长度:	<input type="text" value="0mm"/>	A橡筋数量:	<input type="text" value="0"/>		补偿长度
B橡筋长度:	<input type="text" value="0mm"/>	B橡筋数量:	<input type="text" value="0"/>		<input type="text" value="0mm"/>

↩



(2) Rubber length and quantity setting

Two kinds of rubber bars with different specifications can be set, and the production quantity of rubber bars with different specifications can be set. That is to say, after the production of a rubber bar is completed according to the quantity, the warning device will flash red light to prompt, the interface will prompt that the sewing is completed (see the figure below), and press "continue



sewing", The warning light turns green. At the same time, the equipment carries out production according to the setting parameters of B rubber bar, and converts the receiving rod to receive materials, and circulates in turn.

***1. If the number of rubber bars of two receiving rods has not been taken out in accordance with the parameter setting, the warning light flashes red light to prompt, and the equipment stops running.**




2. In the process of rubber band sewing, the single or several rubber bands have sewing problems due to faults. It is necessary to manually increase or decrease the number of rubber bands, , Press 4.1 (6) -b 的“分段计数” increase  、 decrease  the adjusted count quantity (see the figure below)..



(3) Length adjustment

For rubber bars of different specifications, because of material, elasticity and other factors, the actual length of rubber bars does not conform to the set length. According to the actual situation, the allowance can be compensated by length adjustment. The compensation value can be set to a negative number.

5.2.5 Sewing

Press 4.1 (6) -b Monitoring interface  Jog the test machine to make sure it is running correctly and the product size is correct. Press  or  to Production.

5.2.6 Shutdown

After operation, turn the power switch 90 ° to the off position, turn off the equipment, and press the pressing switch to turn off the pressing mechanism.


*** Foot pedal function: the machine head can be sewn independently, the left foot is used to lift the presser foot, and the right foot is used to sew the machine head, which can be used to handle some broken materials manually.**

6、Debugging method

6.1. Rubber changing operation

6.1.1 Program number selection:

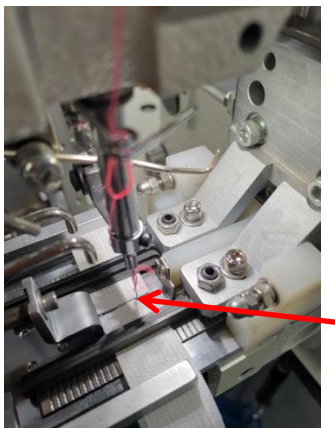
Select the corresponding program number in the head touch screen 6.1 (5) according to the

rubber band width and the required sewing parameters . See table below. :

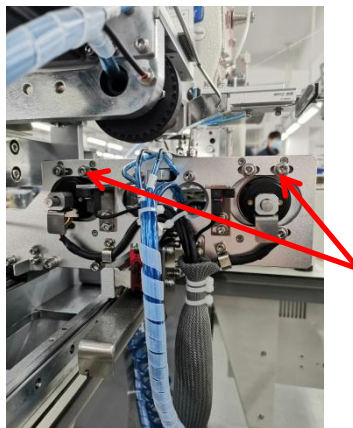
Program number	Stitch number	Length	Width
110	107	8	10
120	167	8	20
130	227	8	30
140	287	8	40
150	347	8	50
210	84	8	10
220	125	8	20
230	173	8	30
240	287	8	40
250	263	8	50
310	71	8	10
320	113	8	20
330	149	8	30
340	185	8	40
350	221	8	50
410	53	8	10
420	77	8	20
430	108	8	30
440	132	8	40
450	162	8	50
510	42	8	10
520	66	8	20
530	85	8	30
540	102	8	40
550	126	8	50

6.1.2 Rubber adjustment:

- ① Replace the belt according to the steps of "rubber band threading" in 5.2.3.



E



F

- ② After adjustment, press 单步运行 of B monitoring interface continuously , When running to the step to be sewn as shown in Figure e, check whether the needle is aligned with the spliced interface. If the needle is not in the interface position, adjust the mounting screw of the motor to make it meet.。



I



J

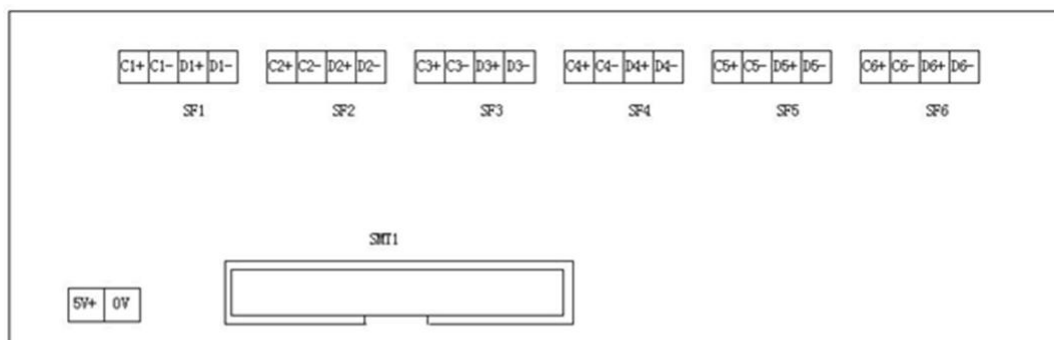
- ③ Adjust the front and rear positions of the material blocking slide plate through (Fig. J) so that the front limit (Fig. I) is close to the edge of both ends of the rubber rib.



- ④ Adjust the front and back position and air pressure of the air blowing pipe, so that the air blowing pipe can blow tight the rubber band.

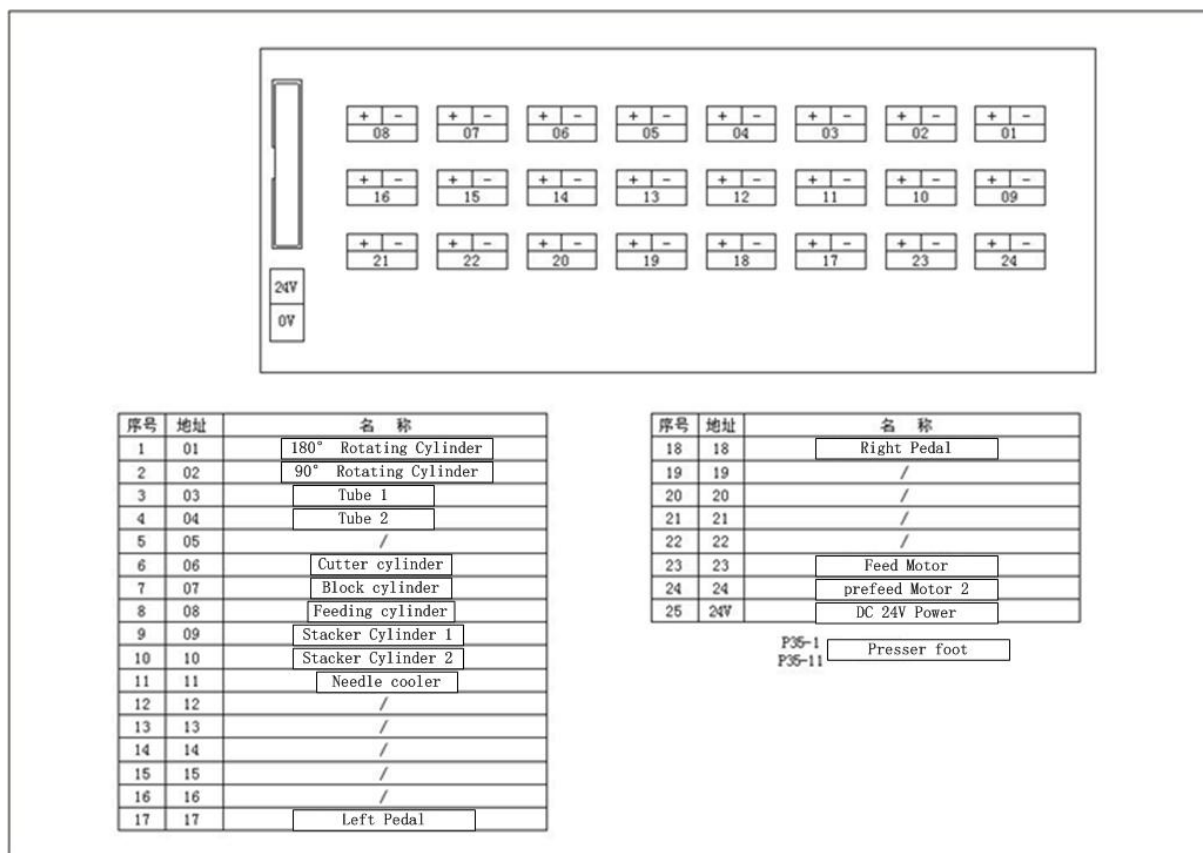
7、Electrical wiring

7.1. Motor board:

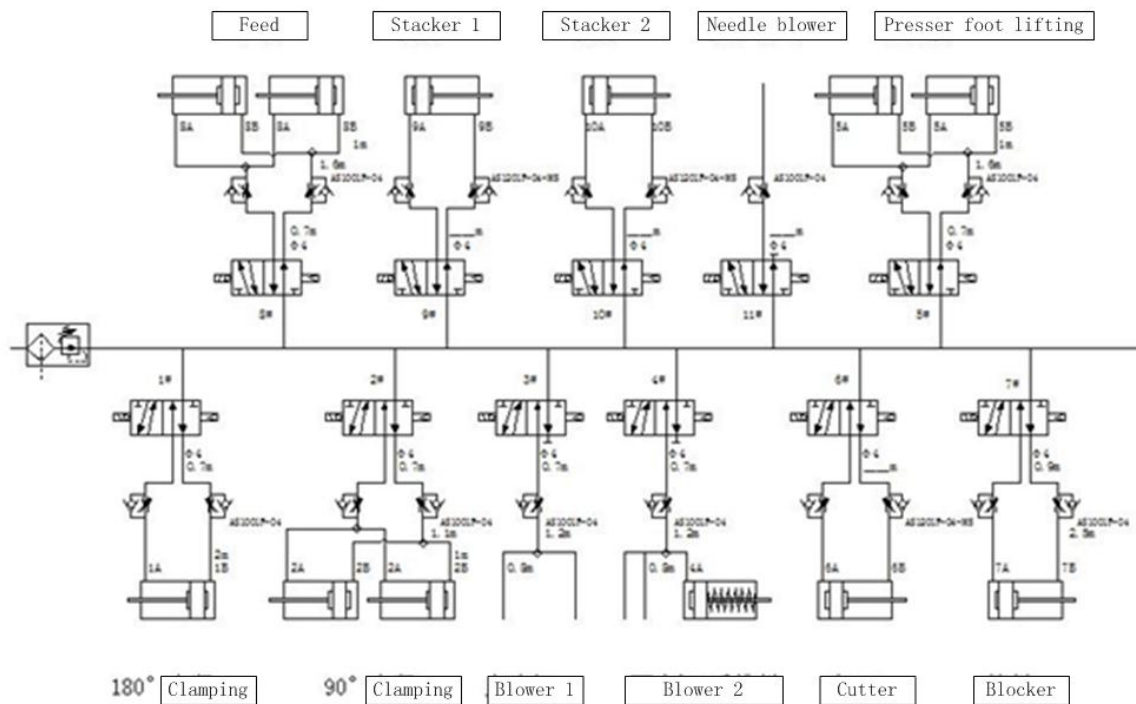


No.	PORT	NAME
1	SF1	Wheel motor
2	SF2	Feeding motor
3	SF3	90° left motor
4	SF4	90° right motor
5	SF5	90° right motor
6	SF6	
7	24V	Power

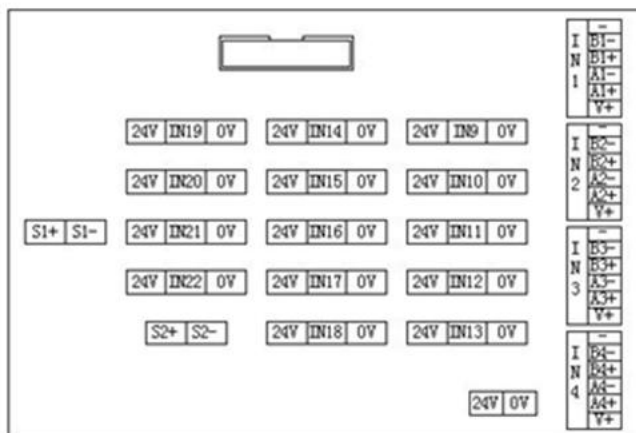
7.2. Output board:



7.3. Air control chart:



7.4. Input board:



序号	地址	名称
1	IN9	Feed Motor
2	IN10	90 Left motor 1.2
3	IN11	180 rotating motor
4	IN12	90 right motor 1.2
5	IN13	Thread breaking encoder
6	IN14	Rubber dector 1
7	IN15	Prefeed dector
8	IN16	Alarm
9	IN17	Switch 1
10	IN18	/
11	IN19	Switch 2
12	IN20	Switch 3
13	IN21	Emergency stop button
14	IN22	/
15	S1	/
16	S2	/


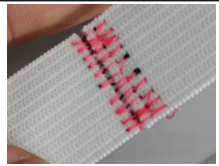
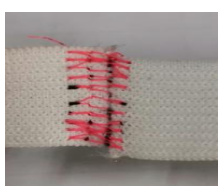
8、Accessories box details

NO	ITEM		QTY
1	《Instruction manual》		1
2	《Parts Manual》		1
3	《Touch screen interface operation instructions》		1
4	Slotted screwdriver	5*300mm	1
5	Wrench	1.5—6mm	1

9、Common problems and Solutions

10.1. See the table below for common problems and Solutions

10.2. More questions, See 《MB1008A- Touch screen interface operation instructions》

Fault phenomenon	Image	Cause Analysis	Solutions
Joint stacking		The pre feeding length of rubber wheel motor is too long	Reduce prefeed length
Joint clearance		Short pre feeding length of rubber wheel motor	Increase prefeed length
Joint dislocation		Caster deflection or 180 ° cylinder deflection	View and adjust caster and cylinder installation
Rubber band wrinkle		1. Press not on; 2. Low press temperature;	1、Turn on the press。 2、Adjust the high-pressure ironing temperature。
The blowing air pipe cannot blow the rubber band tightly on the plane		Insufficient blowing pressure	Increase the flow of the blowing pipe
The material is not broken.		Blunt cutter or loose cutter installation	View and adjust cutter installation

10、Daily maintenance requirements

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

11.2. 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	Press	√				Check the pressing machine to ensure that there is no foreign matter between the pressing plates
10	Cutting edge		√			Check the cutting edge to ensure there is no gap and wear

11、 Knowledge product protection statement

MB1008A Elastic Jointer 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.