

全自动热转移印标机

Automatic heat transfer marking machine

(MB4006A)

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

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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.

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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.

本机介绍说明分为二部分，具体请参照《MB4006A 全自动热转移印标机-使用说明书》、《MB4006A 全自动热转移印标机-零件手册》、《MB4006A 全自动热转移印标机-触摸屏操作说明》。

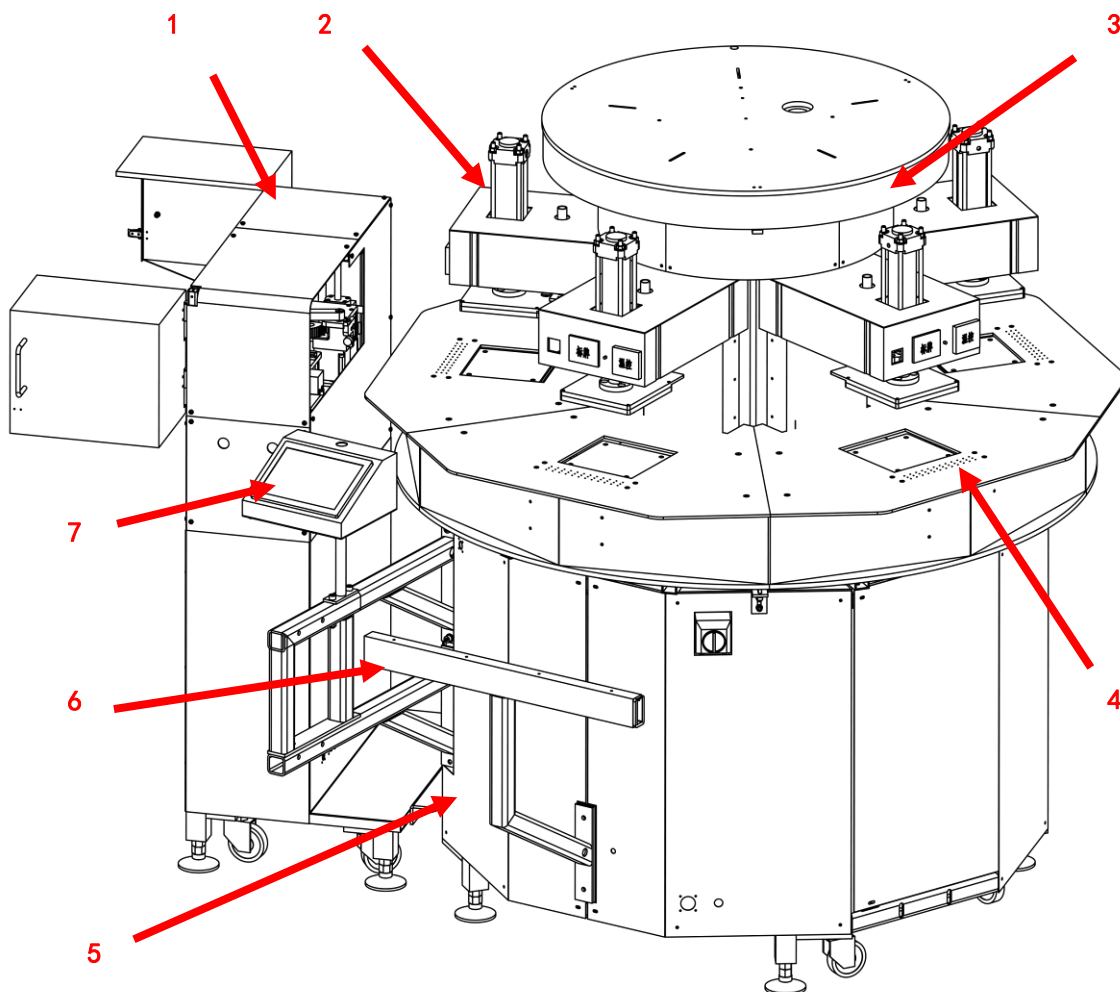
The introduction of this machine is divided into three parts. For details, please refer to 《MB4006A Operation manual》 and 《MB4006A Parts Manual》《MB4006A Touch screen interface operation instructions》

ENGLISH

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1、 Basic information of equipment



1: Label absorbing mechanism;

2: Heating unit;

3: Light; 4: Worktable;

5: rotating stand;

6: Loader



7: Touch screen

2、 Technical parameters of equipment

MB4006A Heating device		
1	Heater	HP-16P-XT
2	Size/mm	Maximum160*160
3	Working voltage/V	220
4	Working pressure/Mpa	0.3-0.6
5	Power/kw	Machine power: 1.8
		Heater power:1.1
6	Temperature/°C	0-195
7	Noise/ dB	<80
8	Protection level	IP44
9	Size/mm	2500L×1850W×1650H

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>

16. When the power switch is turned off during the foot press action, please be careful not to pinch your fingers.

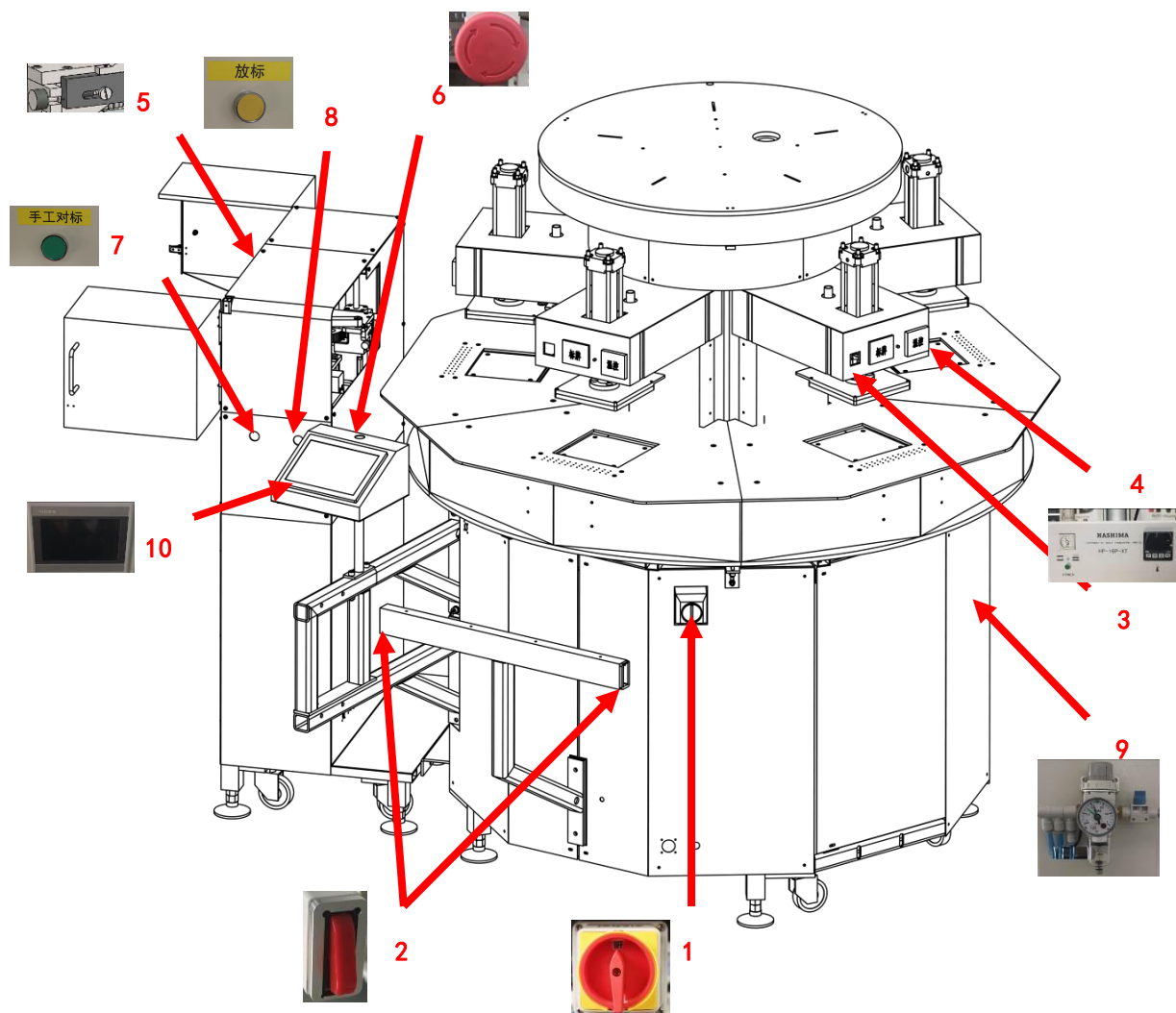
17. During folding operation, please be careful not to clip the cylinder to your finger when putting your finger into the folding machine.

**** 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

4.1 Button function description



(1): Power switch -- turn the power switch to on at 90 ° to power and ventilate the equipment.

(2): Manual switch - press left and right at the same time, the machine runs a station.

(3): Pressure reducing valve --- adjust the cylinder pressure of heating unit.

(4): Temperature control panel --- adjust the temperature of heating unit

(5): Sensor adjustment knob --- fine adjustment of suction cup origin position

(6): Emergency stop switch - emergency stop machine operation

(7): Manual benchmarking: the machine absorbs the label paper and transfers it to the bottom

of the ironing machine, which is the same as the touch screen button 手工对标

(8): Marking --- move the marking paper under the ironing machine down to the working surface,

the same as the touch screen button 放标

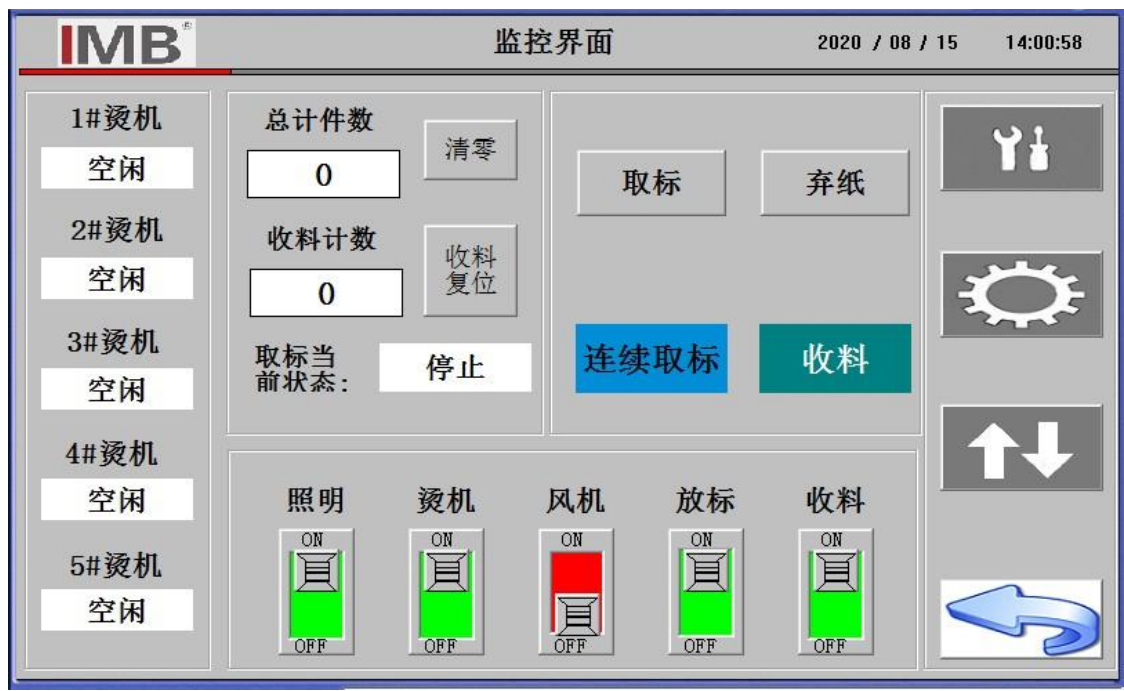
(9): Low pressure protection: when the air pressure is lower than the set pressure, the machine will stop automatically

(10): Touch screen

a. Boot interface



b. Main interface



5、Operating instructions


5.1 Preparation before operation

- ✓ When the operator checks, the machine head should be in the stop state
- ✓ Check whether the sewing thread is properly put on
- ✓ Check whether the needle has been installed
- ✓ Clean up the debris on the machine table to ensure that there will be no debris obstructing the operation of the machine
- ✓ Check that the eye guard is properly installed

5.2 Operation process description

5.2.1 Boot device


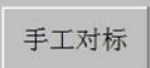



Turn the power switch to on  at 90 ° to power on the device. Select the language in the boot interface to enter the main interface.

5.2. 2 Matching



Manually put the label paper into the label setting table, and click B in the main

interface , Enter the benchmarking interface and click , The machine will automatically draw a piece of label paper, move it to the lower part of the heating unit, and click the marking button , If there is any deviation, fine tune the position of the label according to step 6.1.

5.2.3 Pressing

- a) Process parameter setting: set pressing parameters in 5.2.2 benchmarking interface(see mb4006a automatic heat transfer marking machine – touch screen operation instructions for details)



- b) Turn on the function according to the demand
 c) Set the temperature according to step 6.4 and wait for heating.
 d) According to the stacking form of marking paper, select the marking form

There is no interlayer between the label papers

连续取标

There are partitions between the label sheets

间隔取标

- e) When the ironing machine meets the temperature requirements, manually place the fabric to the specified area, press the manual button with both hands at the same time, move the fabric to the marking position, the label suction mechanism starts to place the label, and place the second fabric at the same time, and so on.

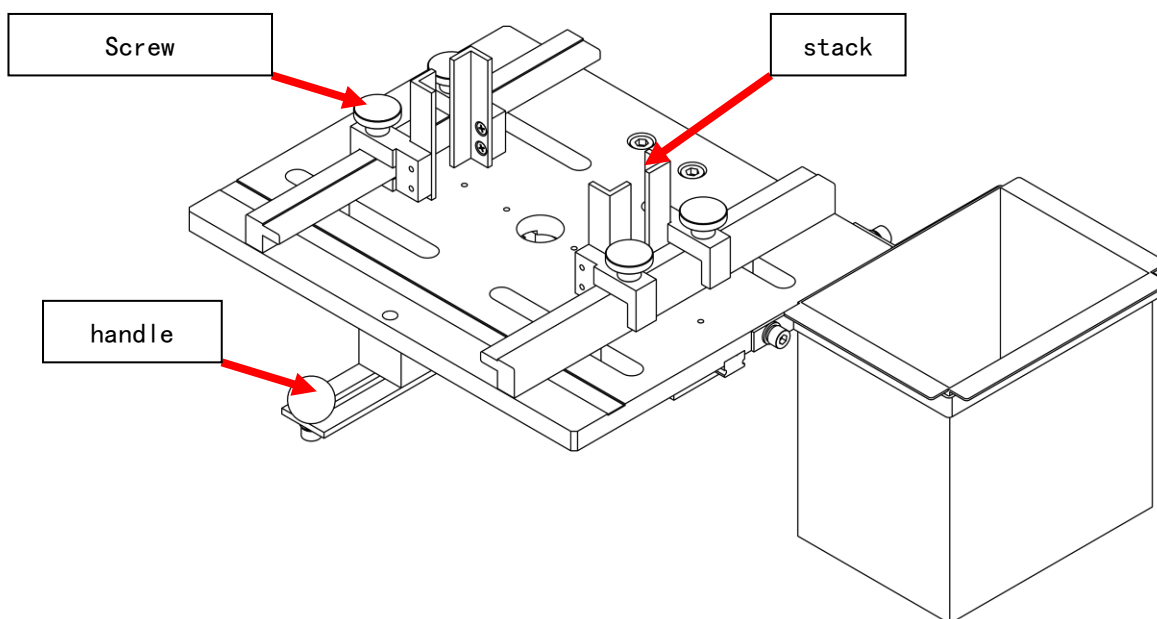
5.2.3 Shutdown



Turn the power switch to off at 90 ° to shut down the equipment

6、debugging

6.1 Label paper placement

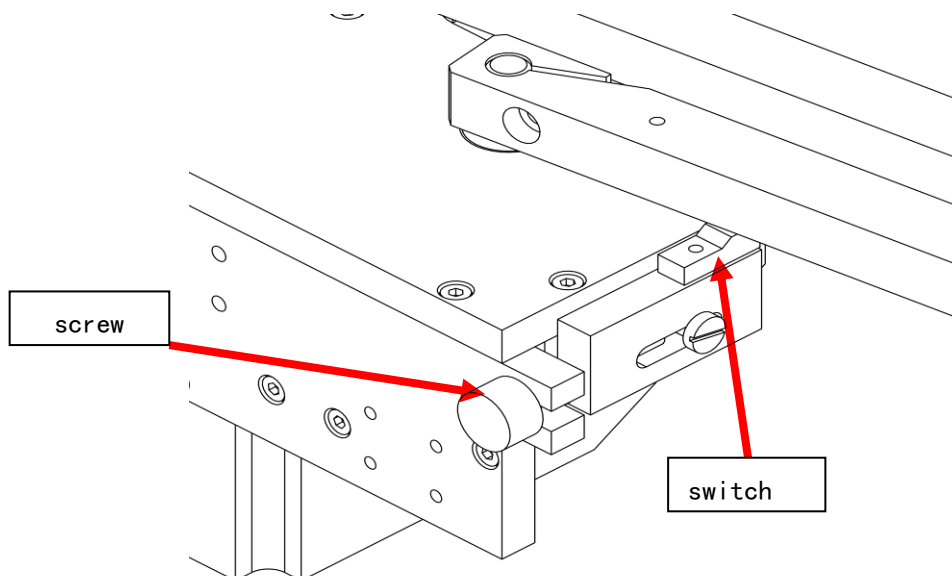


Horizontal dimension adjustment: manually move the spherical handle forward to increase the left and right spacing, and move the spherical handle backward to reduce the left and right spacing

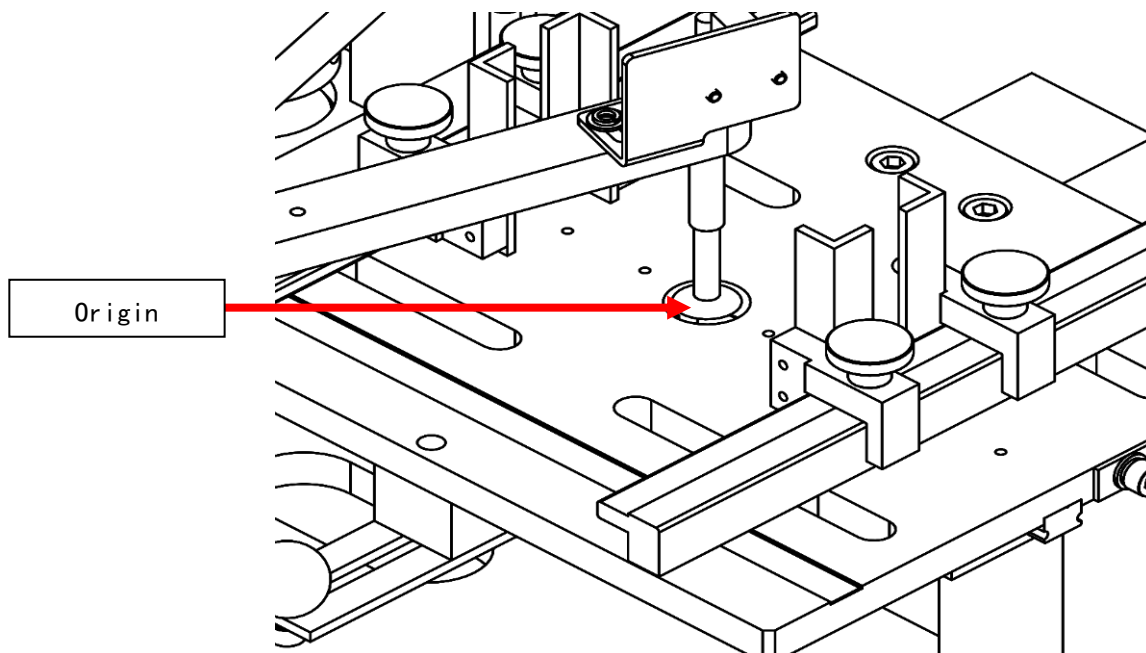
Longitudinal dimension adjustment: manually loosen the embossing hand screw to move the stack position forward and backward.

First, adjust the horizontal dimension to the size of the standard paper, manually loosen the four embossing hand screws, and adjust the stack spacing to be larger than the size of the standard paper, then place the standard paper on the platform, pay attention to align the center origin, stick the stack close to the standard paper, and tighten the embossing hand screw.

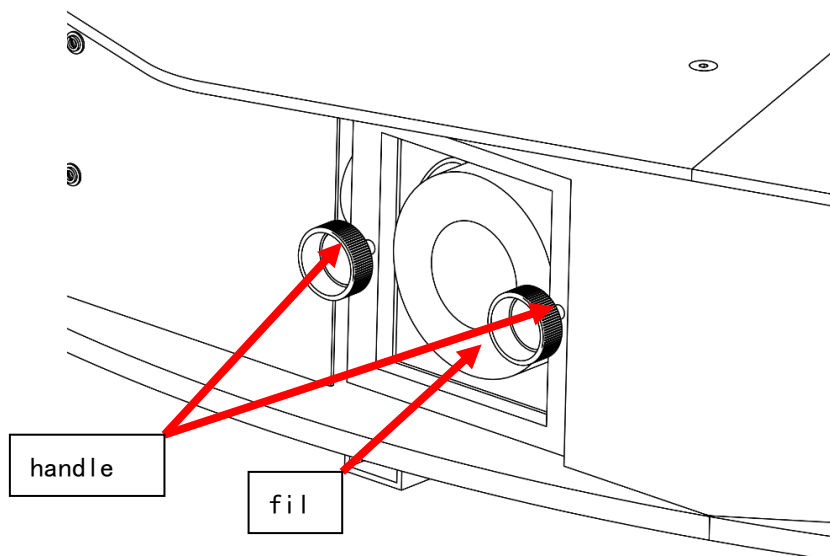
6.2 Origin adjustment



Manually rotate the adjusting screw clockwise to move the proximity switch to the left, and rotate the adjusting screw counterclockwise to move the proximity switch to the right. After each adjustment, you need to click the button in the benchmarking interface to make the connecting rod swing once 手工对标, The final debugging result is shown in the figure below

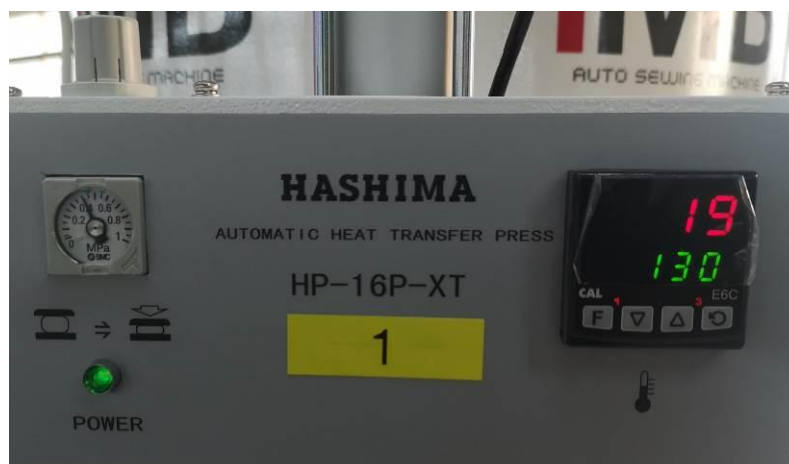



6.3 Cleaning of fan filter element





When the fan is overheated or cleaned according to the specified cycle:
 Manually remove the two plum handle, take out the filter element, clean it up, and then reassemble. If there is overheating protection, you need to wait for the fan temperature to decrease before the machine can operate normally.

6.4 Temperature control setting of heating unit

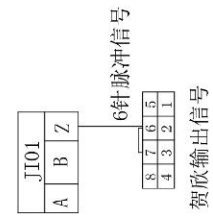
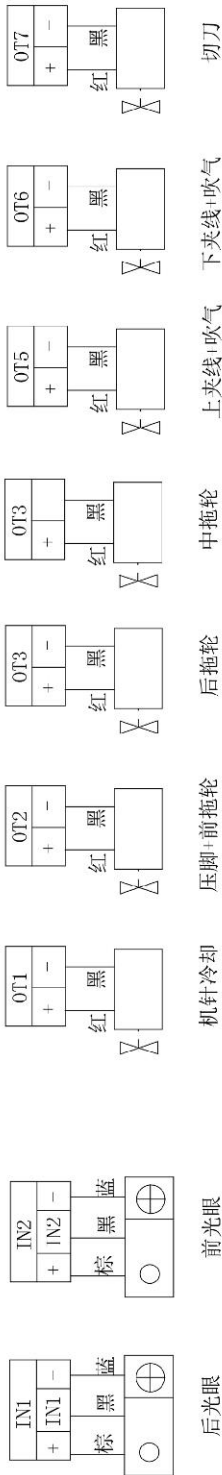
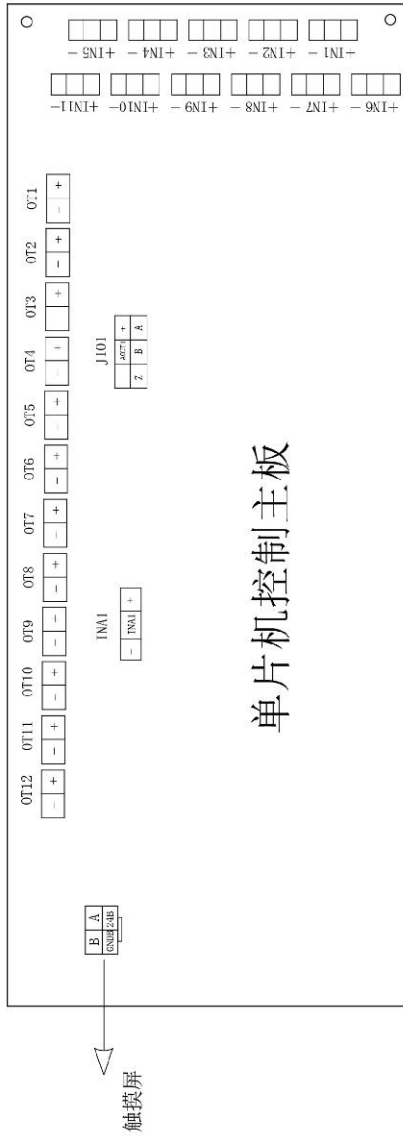


Press , Turn on the ironing machine, the green number is the set temperature, and the red number is the real-time temperature,

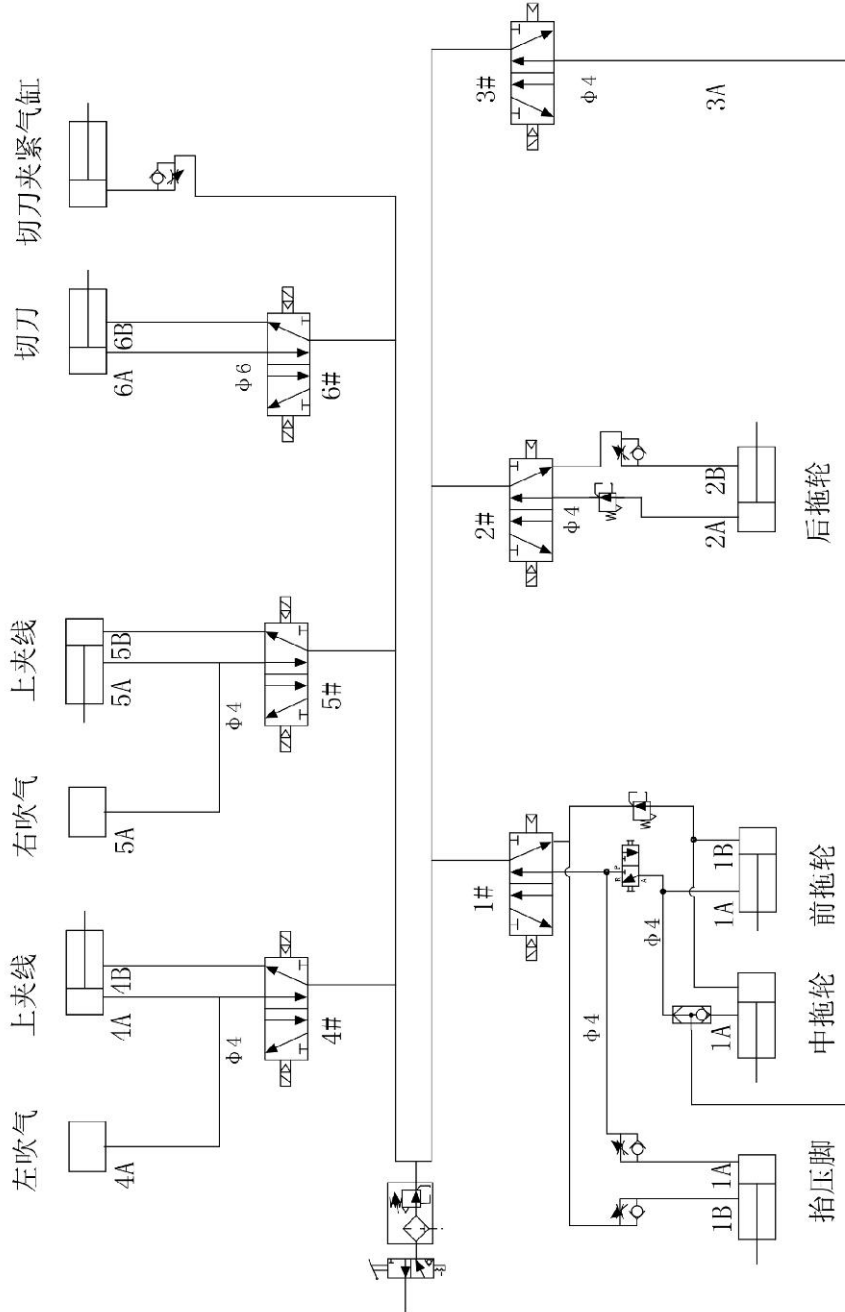
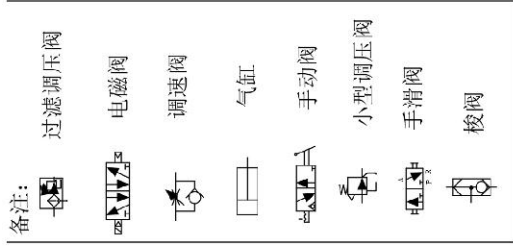
Setting temperature regulation: in the temperature control panel, press , Decrease the set temperature, press  Increase set temperature.

7、Electrical wiring

7.1 Electronic control



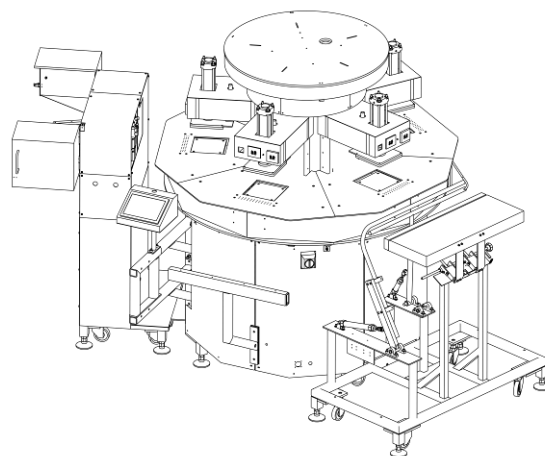
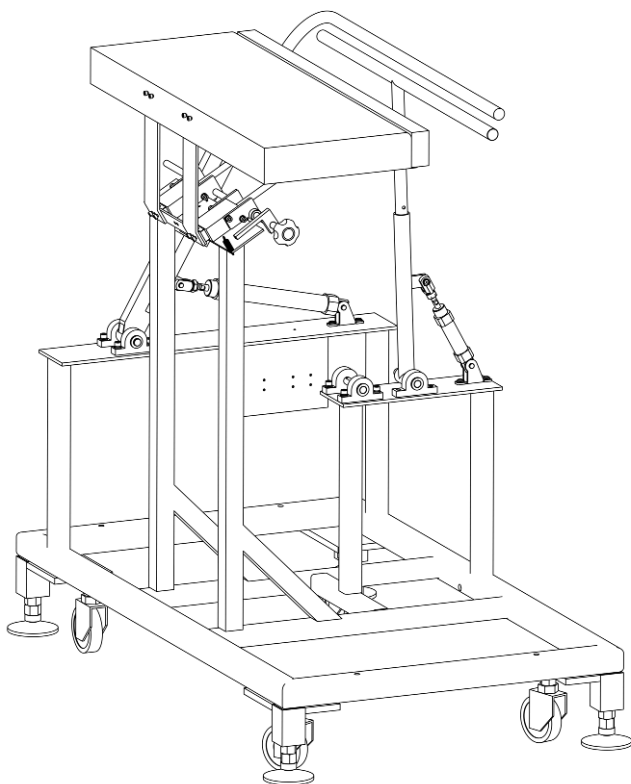
7.2 Air control



备注：各气路布放时要做好标签，以示区分。

8、 optional devices

8.1 stacker (large)



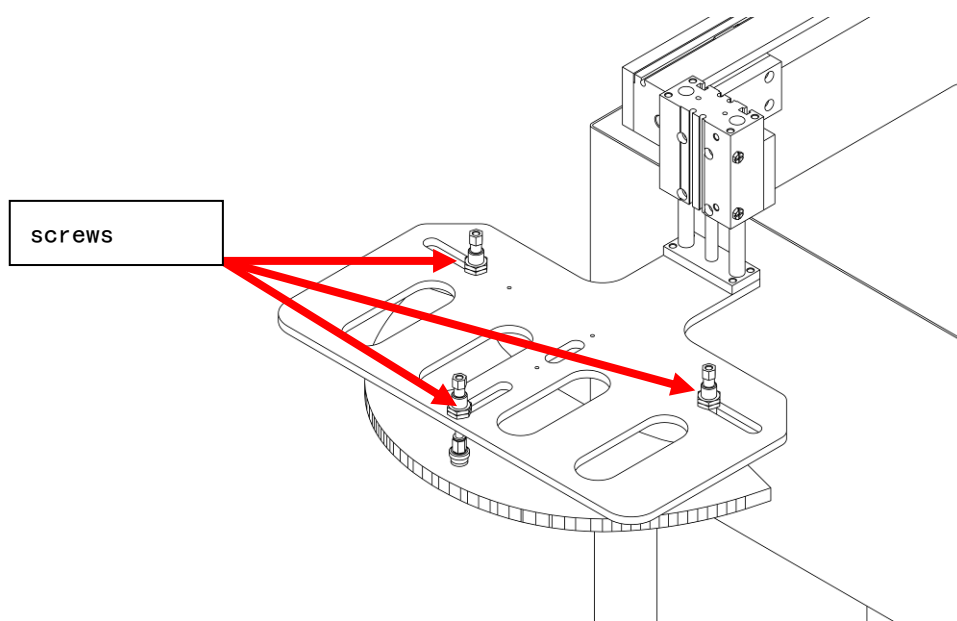
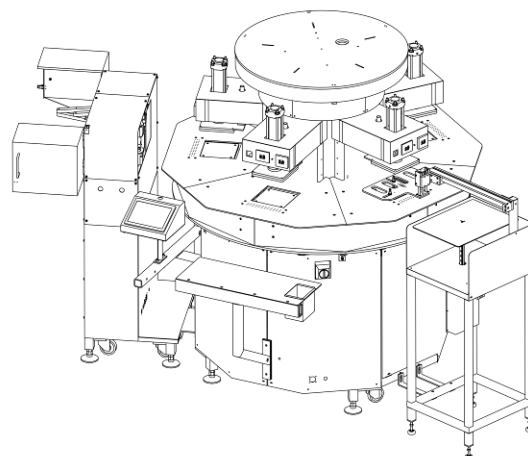
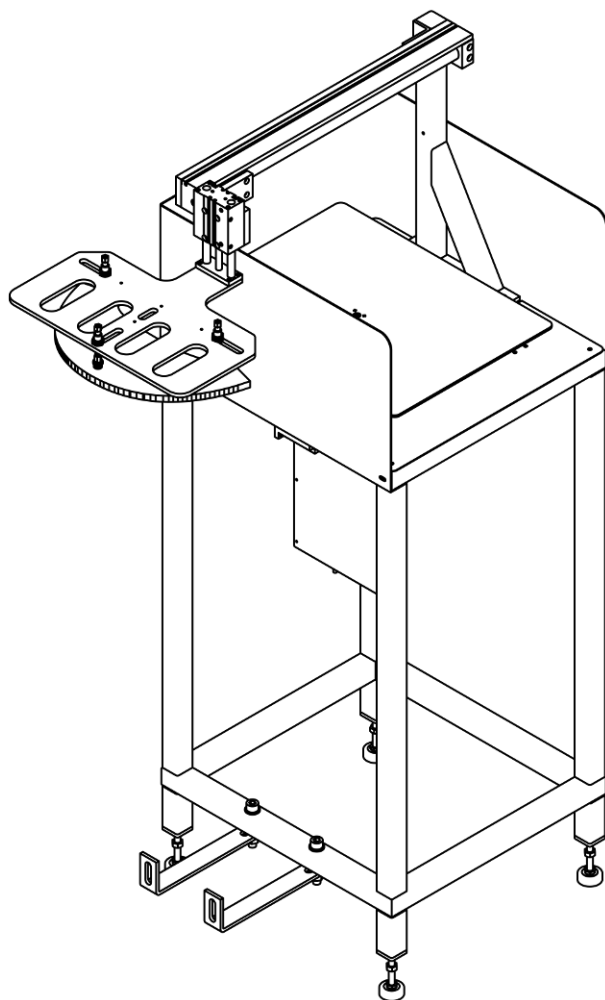
The stacker has its own descending function. After automatically collecting a certain amount of fabric, it needs to collect them manually. After receiving, it needs to manually rotate the plum blossom handle clockwise to reset the stacker.



← stacker

← handle

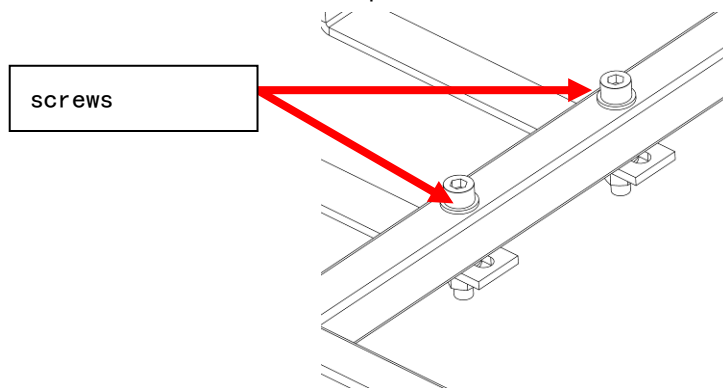
8.2 stacker (small I)



According to the different size of the fabrics, the position of the collecting suction cup is set to be adjustable :

Loosen the three fixed nuts of the suction cup, move the position of the suction cup in the waist groove to make the three suction cups fall on the cutting piece, and then tighten

the fixed nuts of the suction cup.



Adjustment of the position of the receiving frame relative to the ironing machine:
 When there is a deviation between the overall position of the suction cup and the cutting position, loosen the two fixed screws of the receiving frame to adjust the distance between the receiving frame and the main body.

9、 Common problems and Solutions

Phenomenon	Analysis	Solution
Machine overheating protection	Fan blocked	Clean the fan filter element according to 6.3
Low voltage protection of the machine	The air pressure is lower than the set pressure	Make up pressure
Failure of label absorption	The exhaust speed is slow or the makeup pressure is insufficient	<ol style="list-style-type: none"> 1. Check the quick release 2. Check the vacuum generator 3. Check the undervoltage protection and set the parameters according to the manual

10、 Daily maintenance requirements

10.1. The equipment maintenance list and requirements are shown in the table below

No.	Project	Frequency				Description
		Daily	Weekly	Monthly	Half year	
1	Dust removal	√				Remove dust from equipment surface and parts
2	Clean up the oil		√			Clean up the oil stains on the table board, needle board and shuttle core
3	filter element			√		Regular replacement
4	sensor				√	Check whether the sensitivity is accurate and whether the position changes
5	Slide parts				√	Check the lubrication of sliding parts and add lubricant if necessary
6	Control box				√	The cooling fan operates normally, and clean the dust in time

11、 Knowledge product protection statemen

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