

卷边机

Pocket hemmer

(MB2001D-W3522P-04BX264)

(MB2001D-31016-264/364)

(MB2001D-NL5803GPXP 1/4. 3)

(MB2001D-MH380FU-AC)

(MB2001D-T-8720C)

使用说明书

Instruction Manual

常州智谷机电科技有限公司

IMB AUTOMATION 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

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.

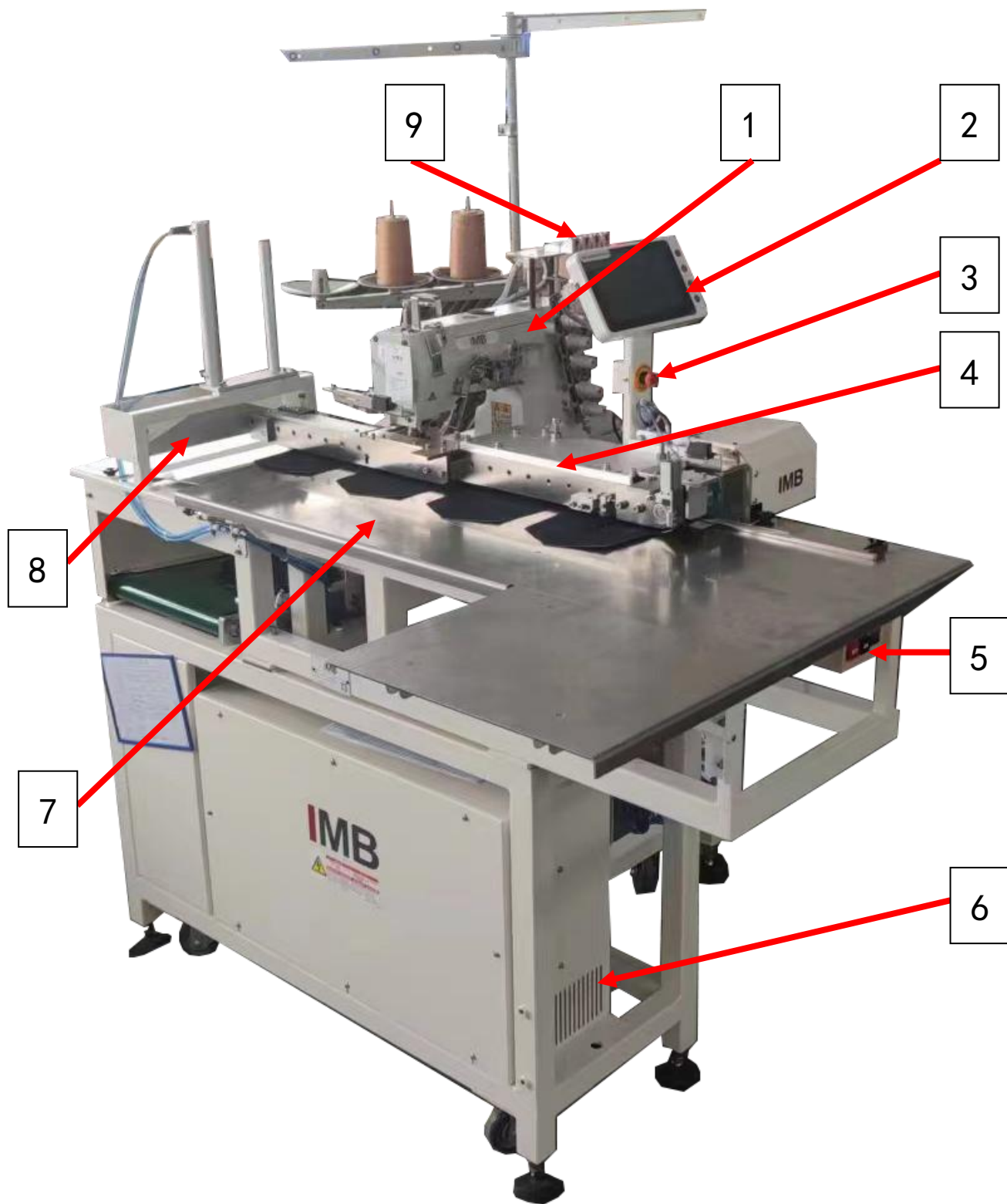
我们将欣然接受各位提出的改进此说明书的任何建议和指示

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《MB2001D-使用说明书》、《MB2001D-零件手册》《MB2001D -直驱单头卷袋口说明书》。

The introduction of this machine is divided into three parts. For details, please refer to 《MB2001D Operation manual》 and 《MB2001D Parts Manual》《MB2001D Touch screen interface operation instructions》.

1、 Basic equipment information





1: Head; 2: Panel; 3: Emergency stop button; 4: Feeding roller; 5: Power switch; 6: Control box; 7: Table; 8: Stacker; 9: Thread break detection

2、Parameter

MB2001D Pocket hemmer		
1	Machine head	Pegasus: W3522P-04BX264 (Maximum speed: 4000rpm)
		IMB: 31016-264/364 (Maximum speed: 4000rpm)
		Kansai: NL5803GPXP 1/4. 3 (Maximum speed: 4000rpm)
		Juki: MH380FU-AC (Maximum speed: 5000rpm)
		Brother: T-8720C (Maximum speed: 3000rpm)
2	Hemming width/mm	7-25
3	Voltage/V	AC220
4	Air pressure/Mpa	0.5
5	Main shaft	AC Servo motor
6	Stitch length/mm	2-5
7	Size/mm	1350L × 1300W × 1300H
8	Weight/kg	330

3、SAFETY PRECAUTIONS

Precautions 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 motor electrical box or touch the parts in the electrical box when the power is turned on.</p>
 注意	<p>1. In order to prevent personal injury, please do not operate the machine with the belt guard, finger protector and other safety devices removed</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>7. When the sewing machine is running, please do not cut off the power or air supply.</p> <p>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.</p> <p>9. In order to prevent accidents caused by electric shock, please do not operate the sewing machine when the power ground wire is removed.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>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.</p> <p>16. After the power switch is turned off in the presser foot action, the presser foot action,</p>

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、 Key Function Description



(1) : Power switch

Press "ON" to turn on and ventilate the device.

Press "OFF" to shut down the power and gas of the equipment.

(2) Emergency stop switch

Press the emergency stop button and the equipment will stop instantly.

Turn the right emergency stop button to cancel the emergency stop.

(3) : Panel

Refer to the control manual

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 fabric in the stacker box has been emptied

5.2. Operation process description

5.2.1 start equipment

Press "ON" to power on the machine.



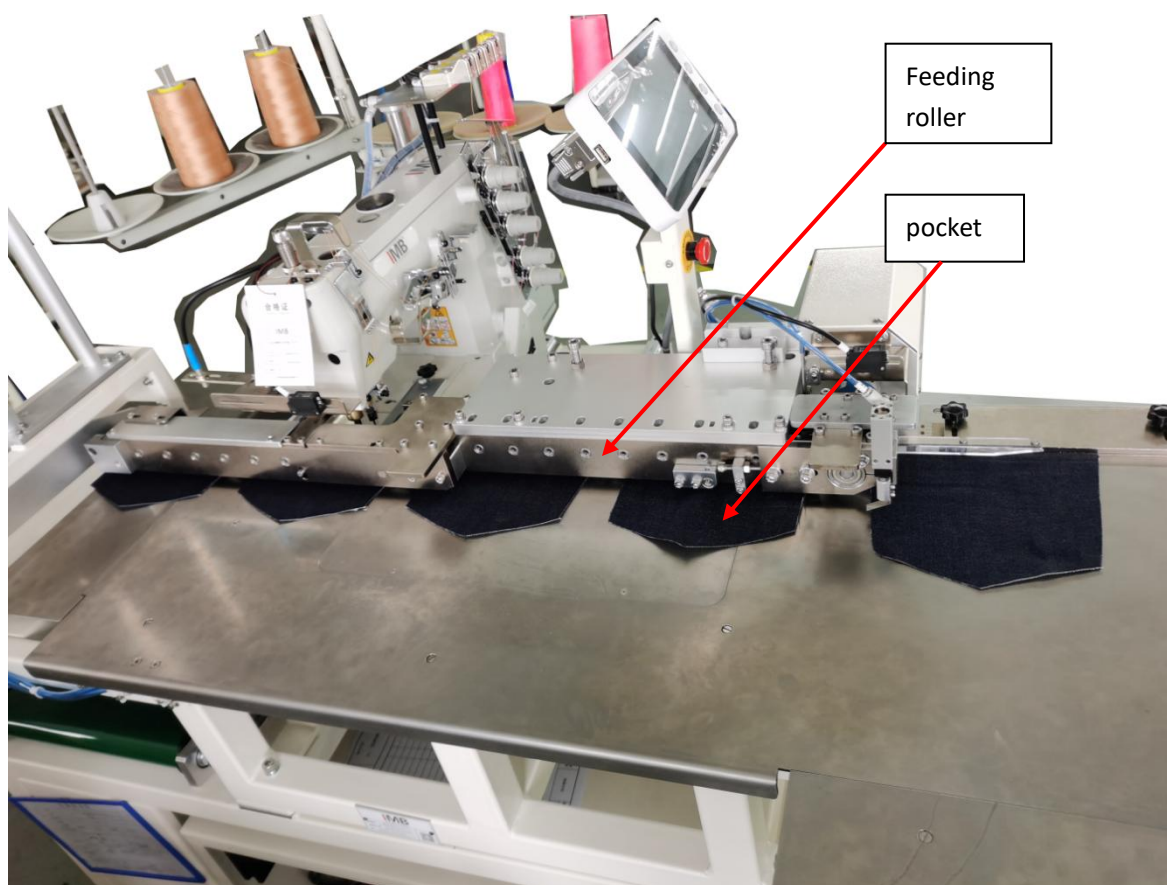
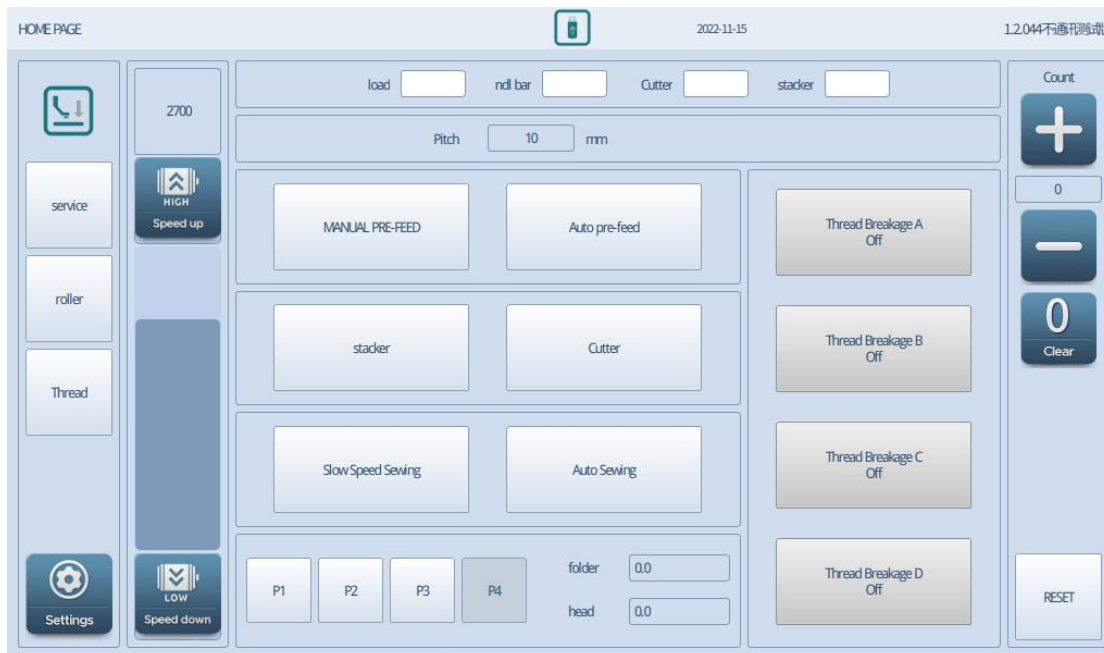
5.2.2 Boot screen

This interface can be operated in either Chinese or English



5.2.3 Operation interface

Click "English" to enter the operation interface, as shown in the following figure:

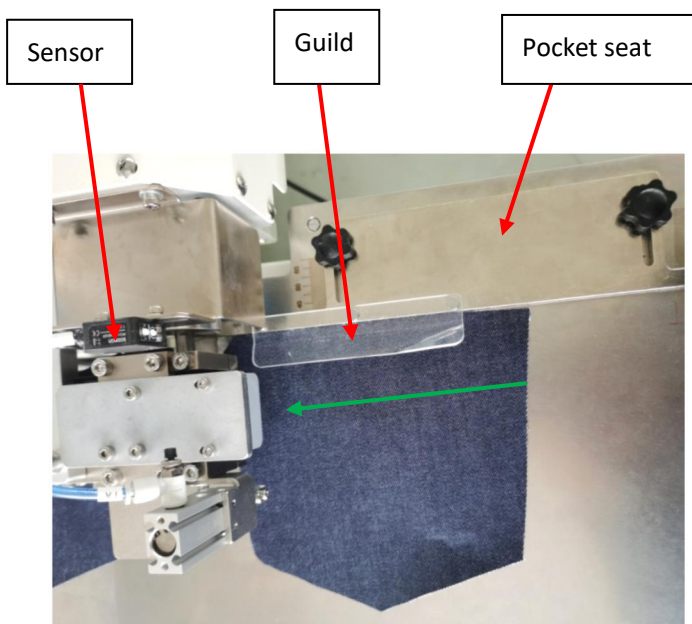


Step 1: Press "Reset"

Step 2: If the pockets are not fully filled under the feeding group, press "Manual Pre feeding"

If the feeding group has already filled the pockets, press "auto sewing"

5.2.4 Fabric placement



- 1、 Place the pocket on the table, with the side that needs to be rolled parallel to the pocket seat
- 2、 Move the pocket towards the seat, ensuring that it is under the guide plate and naturally snugly against the seat
- 3、 Push the pocket in the direction of the green arrow and still ensure that the pocket is naturally snug against the seat during this process
- 4、 When the senses detect the pocket, the feeding mechanism will start working and feed the pocket forward
- 5、 Repeat actions 1 to 4

5.2.5 Shutdown



After completing the operation, press "OFF" to shut down the device.

6、Commissioning method

6.1 Air pressure debugging



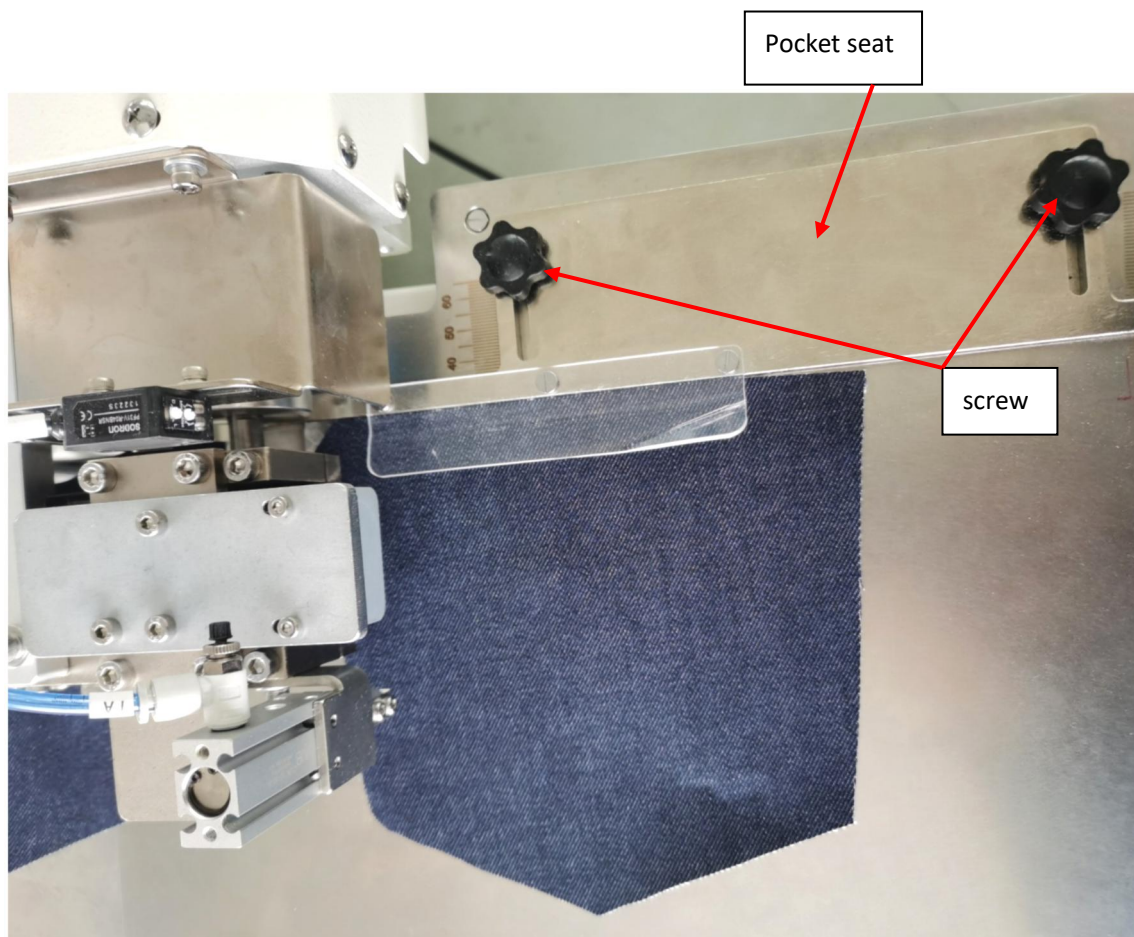
The valve is used to control the feeding group, with a factory setting of 0.05MPa



The remaining pneumatic control components are controlled by this pressure gauge, with a factory setting of 0.5 MPa

6.2 Pocket positioning adjustment

- 1: Open the trial pocket and check if it is OK. If there is any deviation, calculate the deviation value.
- 2: Loosen the hand screw
- 3: Adjust the pocket positioning according to the reference line and deviation value
- 4: Tighten the hand screws

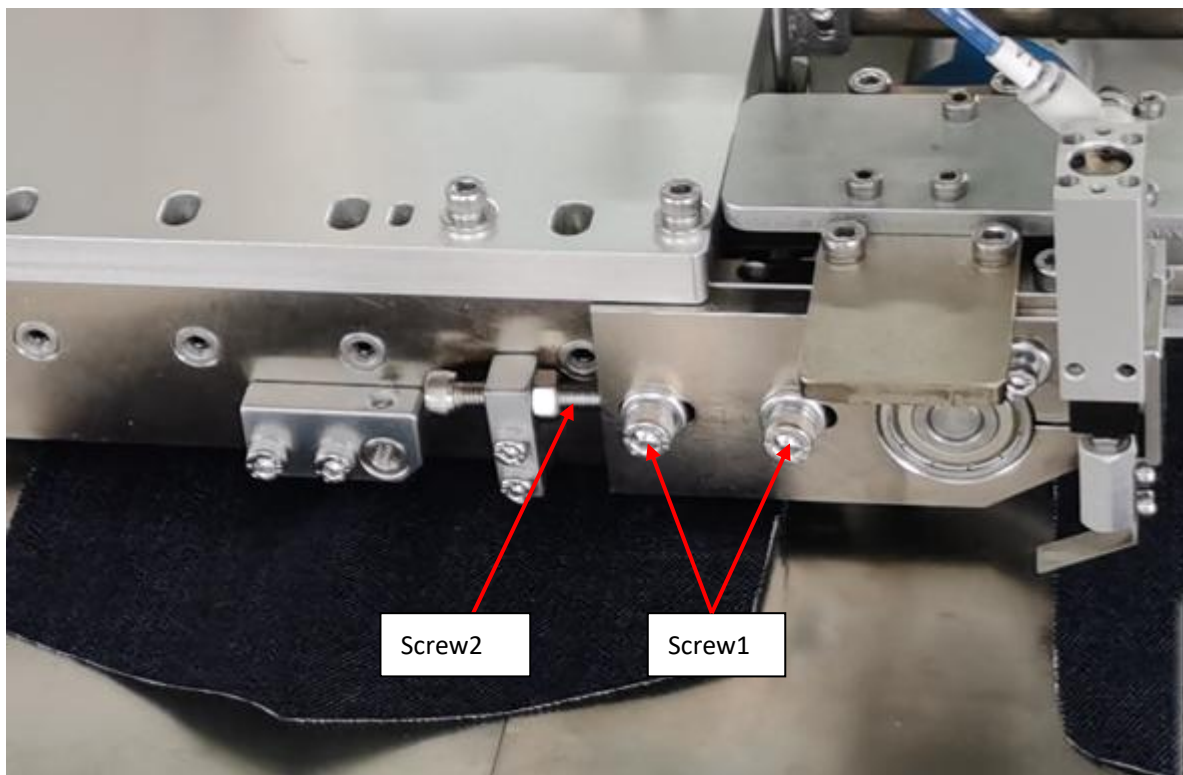


6.3 Tensioning of the feeding group 1

Step 1: Loosen the screw 1

Step 2: Tighten the screws 2

Step 3: Tighten the screws 1



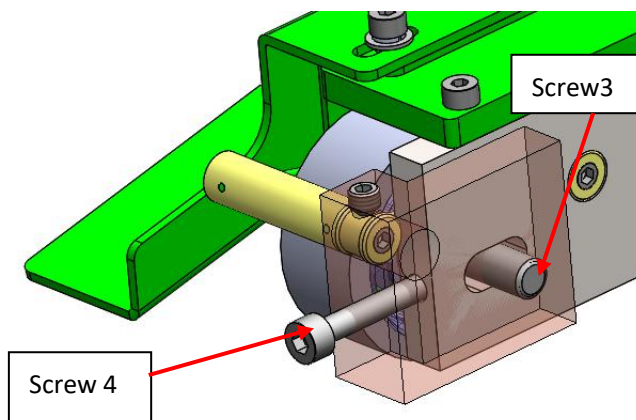
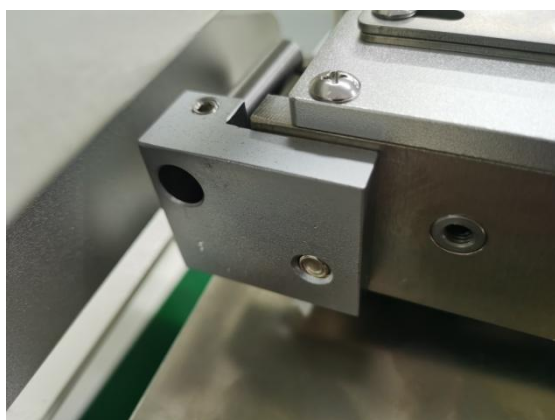
6.4 Tensioning of the feeding group 2

Step 1: Loosen the screw 3

Step 2: Retrieve M5 × Use one set of 30 screws as a screw 4 and tighten the screw 4

Step 3: Tighten the screws 3

Step 4: Remove the screws 4

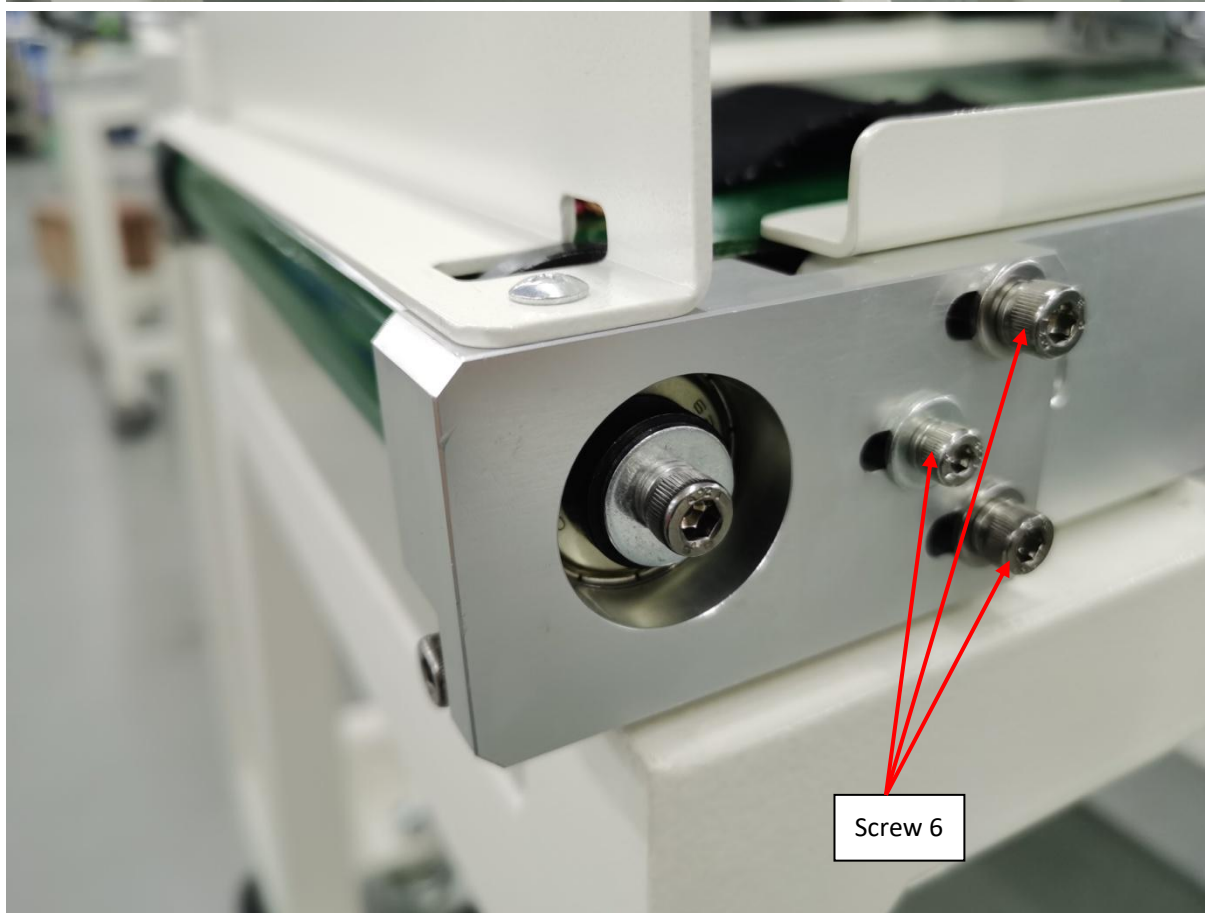
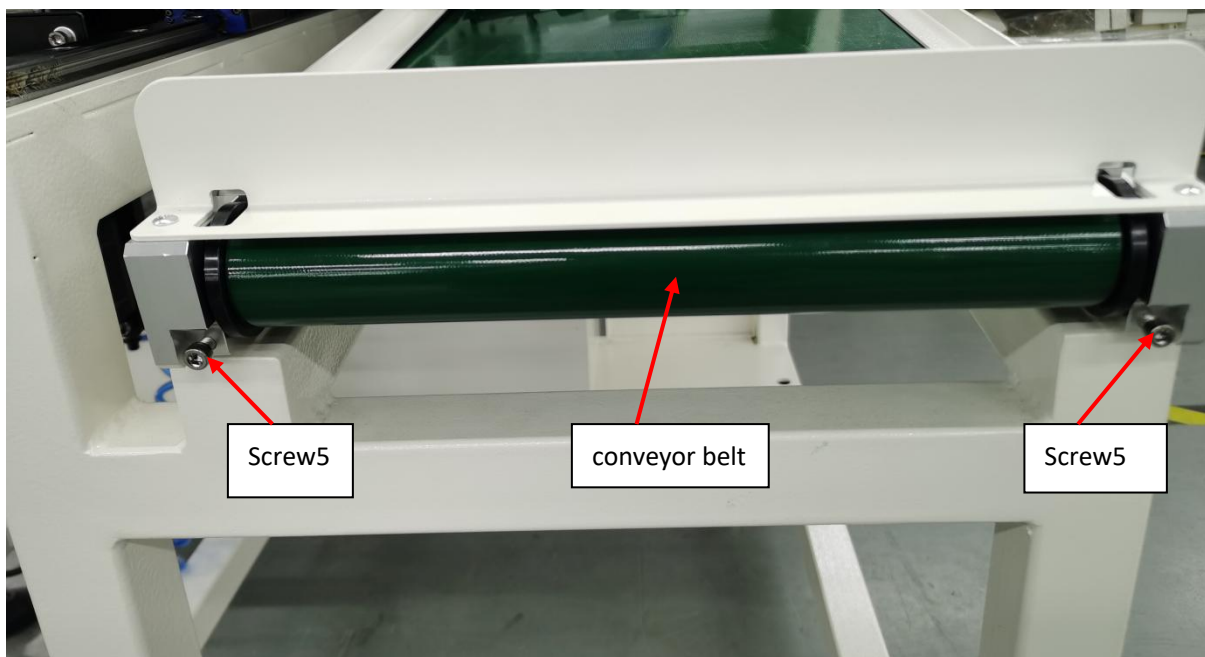


6.5 Tensioning of stacker

Step 1: Loosen the screws 6 (six in total on the left and right)

Step 2: Tighten the screws 5 (two left and two right)

Step 3: Tighten the screws 6

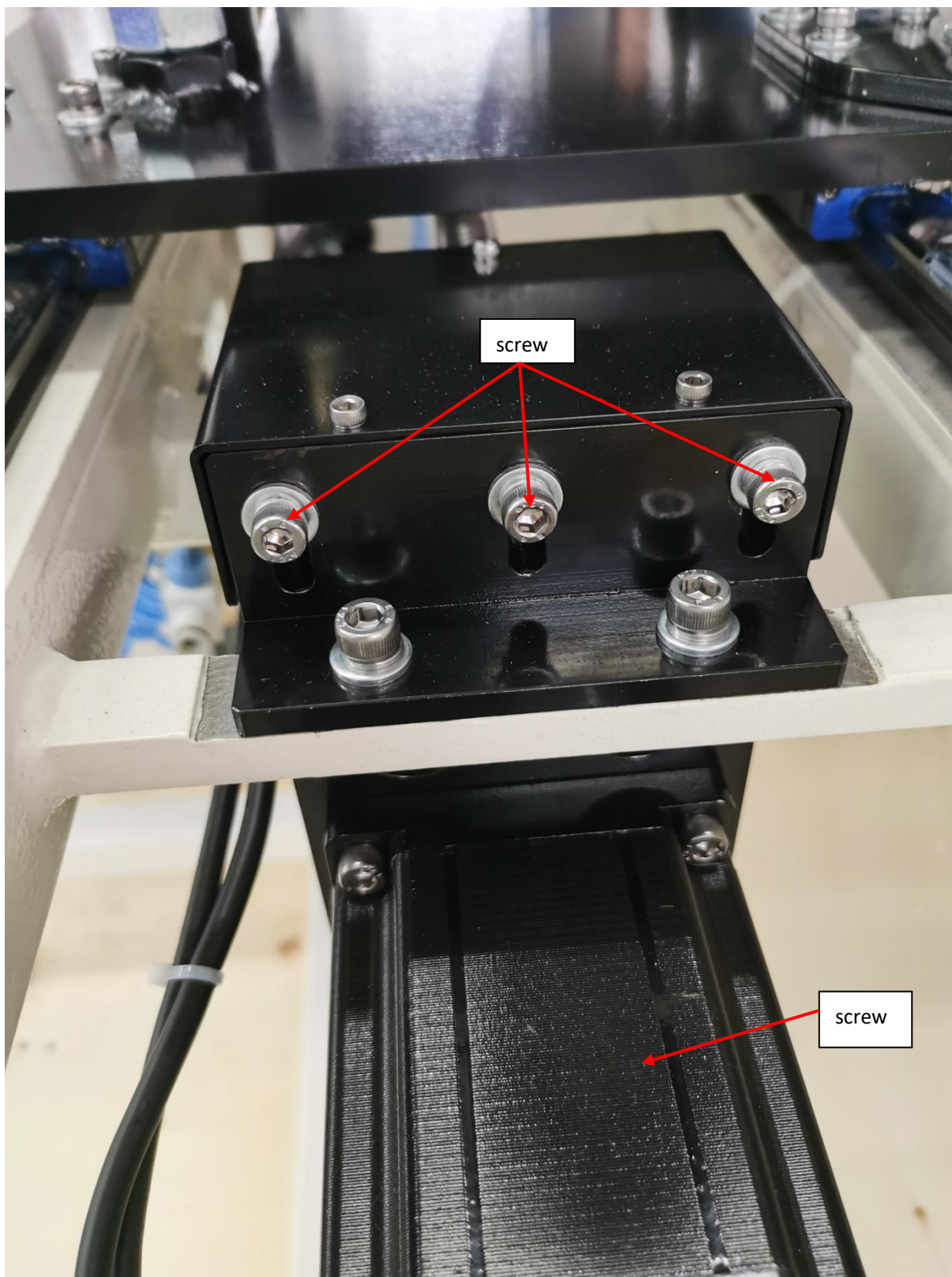


6.6 Head movement group motor tension

Step 1: Loosen the locking screws (three in total)

Step 2: Use the motor's own weight to tension downwards

Step 3: Tighten the locking screws



7、Common problems and solutions

7.1.Common problems and solutions in sewing technology

Phenomenon	Cause Analysis	Solution
Thread breakage/jumper	<ol style="list-style-type: none"> 1. The pressure on the presser foot is too low; 2. Needle damage; 3. The position of the bending needle and the machine needle is incorrect. 	<ol style="list-style-type: none"> 1. Adjust the pressure of the presser foot; 2. Replace the needle; 3. Adjust the position of the bending needle and the machine needle.
Trimming issue	knife wear	<ol style="list-style-type: none"> 1. Grinding and fixing the knife 2. Replace the fixed knife/moving knife
Stitches issue	Folder not in position	Adjust folder position

8、Daily maintenance requirements

8.1. The equipment maintenance checklist and requirements are detailed in the table below

8.2. For more maintenance requirements on the machine head, please refer to the machine head manual

NO.	Item	Frequency				Description
		Daily	Weekly	Monthly	Half year	
1	Cleaning dust	√				Remove dust from equipment surfaces and components
2	Clean oil		√			Clean the oil stains on the table, needle plate, and shuttle core
3	Clean the dust collection bag	√				Clean up the garbage in the dust collection bag
4	Air hose connector			√		connector is tight and does not leak air
5	Oil			√		The oil shall not be lower than the warning line
6	Control box				√	The cooling fan is running normally and should be cleaned of dust in a timely manner

10. KNOWLEDGE PRODUCT PROTECTION STATEMENT

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