

超声波缝合机

Ultrasonic lace machine(double motor)

(MB9018B)

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

2020.06

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 9018B 超声波缝合机-使用说明书》、《MB9018B 超声波缝合机-零件手册》。

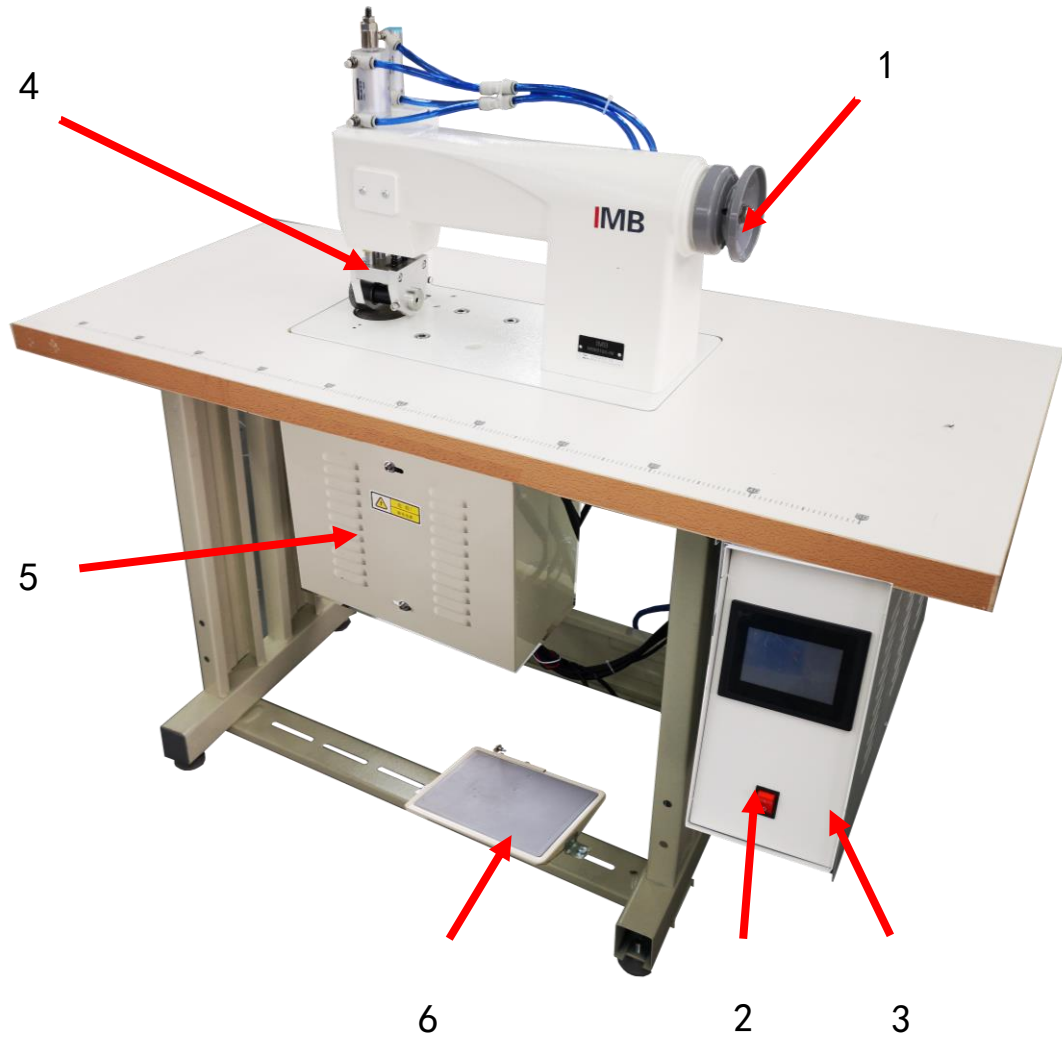
The introduction of this machine is divided into two parts. For details, please refer to 《MB9018B Operation manual》 and 《MB9018B Parts Manual》

ENGLISH

Catalog

1、 Basic information of equipment	错误!未定义书签。
2、 Technical parameters of the equipment	错误!未定义书签。
3、 Safety precautions	错误!未定义书签。
4、 Key function description	错误!未定义书签。
4.1 . Function description of the button	错误!未定义书签。
5、 Operating instructions	错误!未定义书签。
5.1. Preparation before operation	错误!未定义书签。
5.2. Operation process description	错误!未定义书签。
5.2.1 Boot device	错误!未定义书签。
5.2.2 Sewing	错误!未定义书签。
5.2.3 Shutdown	错误!未定义书签。
5.2.4 Power OFF	错误!未定义书签。
6、 Debugging method	错误!未定义书签。
6.1. Wheel speed adjustment	错误!未定义书签。
6.2. Flower wheel angle adjustment	错误!未定义书签。
6.3. Adjustment of depth of flower wheel indentatio	错误!未定义书签。
6.4. Change mold	错误!未定义书签。
6.5. Mould change	错误!未定义书签。
6. 6. Ultrasonic setting	错误!未定义书签。
7、 Electrical wiring	错误!未定义书签。
8、 Optional device	错误!未定义书签。
9、 Accessories box details	错误!未定义书签。
10、 Common problems and solutions	错误!未定义书签。
11、 Daily maintenance requirements	错误!未定义书签。
12、 Knowledge product protection declaration	错误!未定义书签。

1. Basic information of equipment



1: Machine head;

2: Power switch;

3 Control box;

4: Pattern wheel components;

5: Ultrasonic components;



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 be careful not to pinch your fingers.</p>

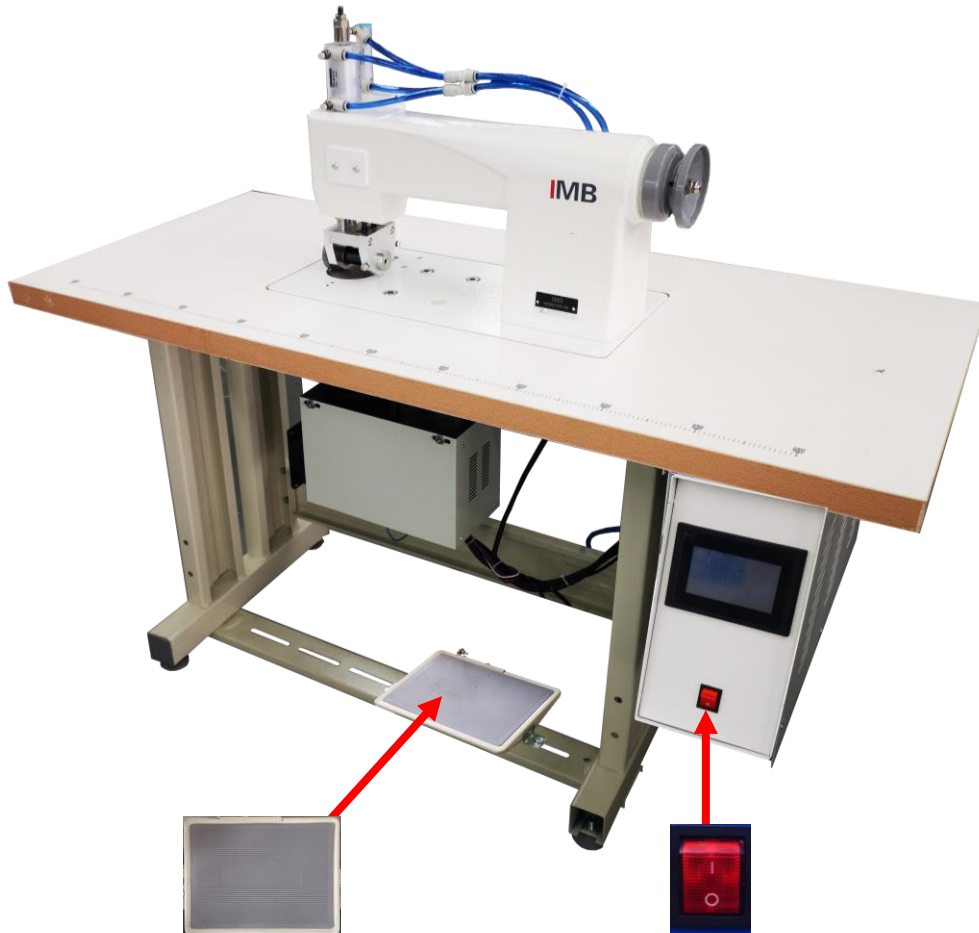
	<p>17. During folding operation, please be careful not to clip the cylinder to your finger when putting your finger into the folding machine.</p>
--	---------------------------------------------------------------------------------------------------------------------------------------------------

*** 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 front foot pedal controls the sewing of the machine, and the rear foot pedal controls the lifting of the pressing wheel and the flower wheel.

(3) : Touch screen

a. Power on interface:

IMB 智谷机电

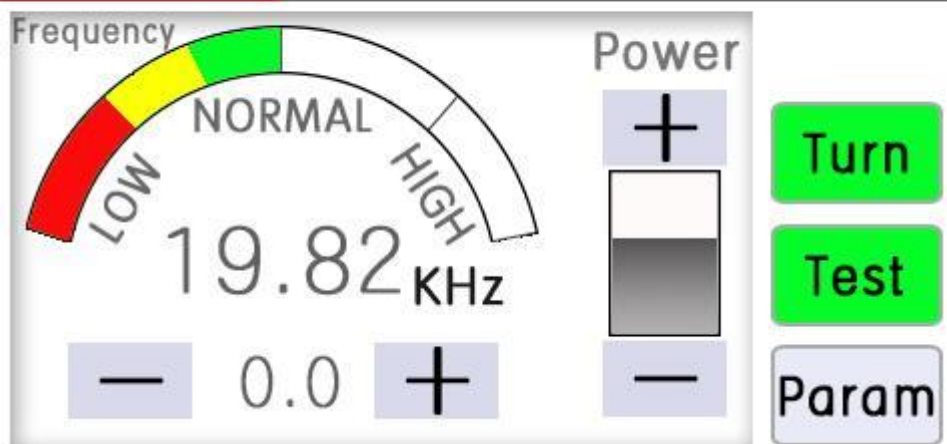
SW2001-20K

中文

English

b. Monitoring interface:

SW2001-20K Ultrasonic Generator



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

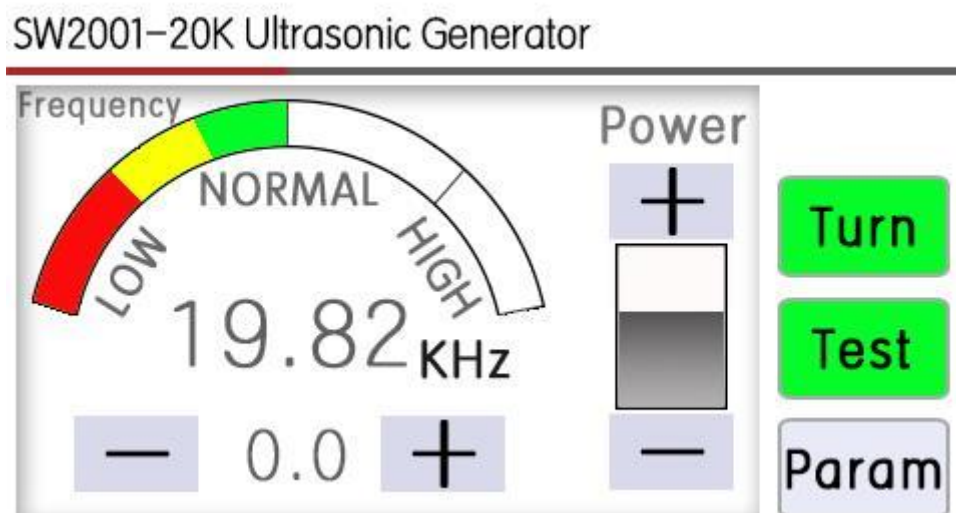
5.2.1 Boot device


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

5.2.2 Motor detection

Click  4.1 - (3) - B touch screen monitoring interface button, The upper and lower motors rotate at the same time, and the machine is normal。

5.2.3 Ultrasonic testing



Click  4.1 - (3) - B touch screen monitoring interface, The frequency is within the normal range, the machine is normal,

5.2.4 Sewing

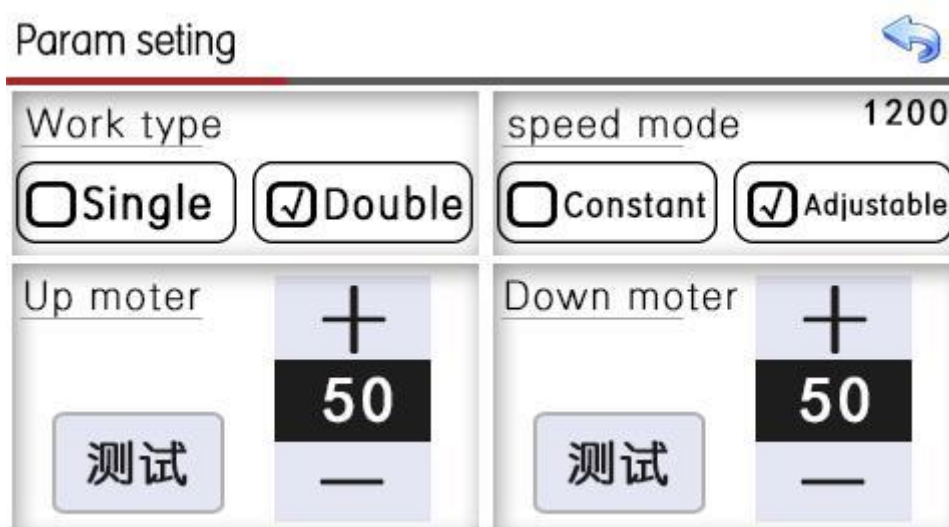
Place the cloth piece in the sewing area and press Four point one -(2) The right foot pedal in, the machine starts to sew, release the foot pedal and the machine stops.


5.2.5 Shutdown

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

6、 Debugging method

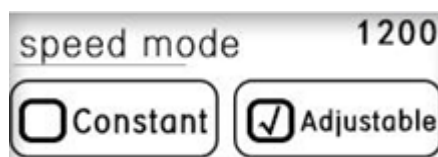
6.1. Model selection



Click  the button of 4.1 - (3) - B touch screen monitoring interface, Pop up the interface shown in the figure above, and select dual motor



6.2. Speed regulation mode



Select constant speed sewing or adjustable speed sewing in parameter setting interface

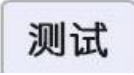
Constant: Front pedal motor rotates at a fixed speed;

Adjustable: The rotation speed of motor increases with the increase of pedal force.

6.3. Wheel speed adjustment



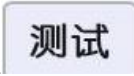
Click on the parameter setting interface, Push button

to adjust the speed of upper motor, Speed range 10% - 100%, Click  Button speed measurement.

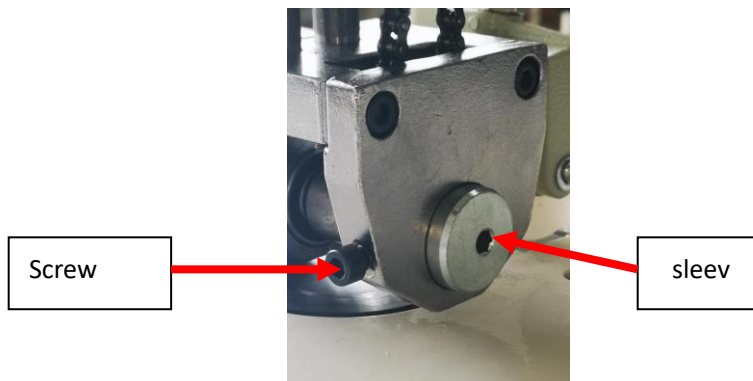
6.4. Speed adjustment of welding head



Click on the parameter setting interface, Motor speed

under button adjustment, speed range 10% - 100%, Click  Button speed measurement.

6.5. Wheel angle adjustment



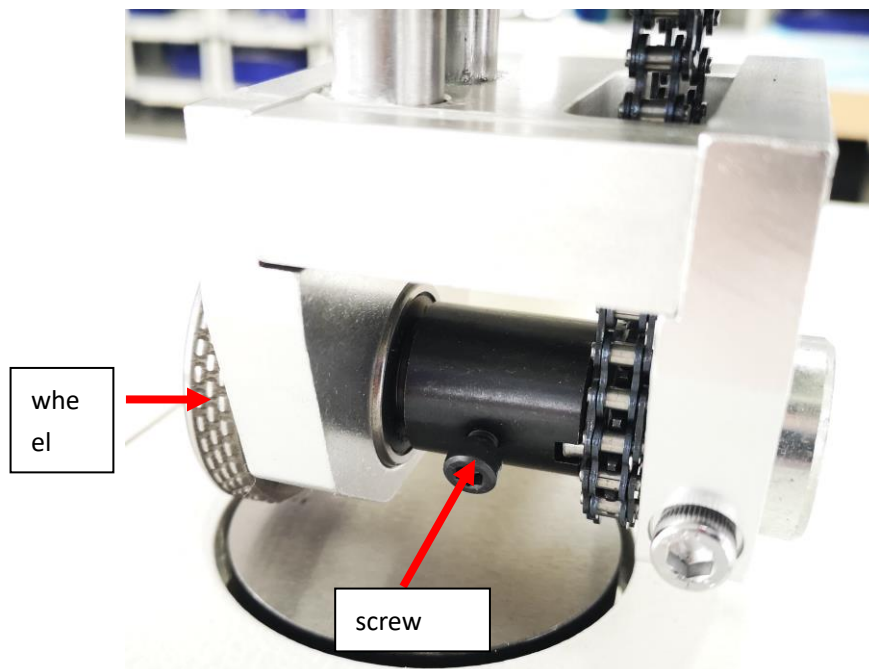
Loosen the fixing screw and rotate the eccentric sleeve to adjust the angle between the flower wheel and the welding head, so as to ensure that the thickness of each pressing edge of the flower wheel is equal.

6.6. Adjustment of depth of wheel



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

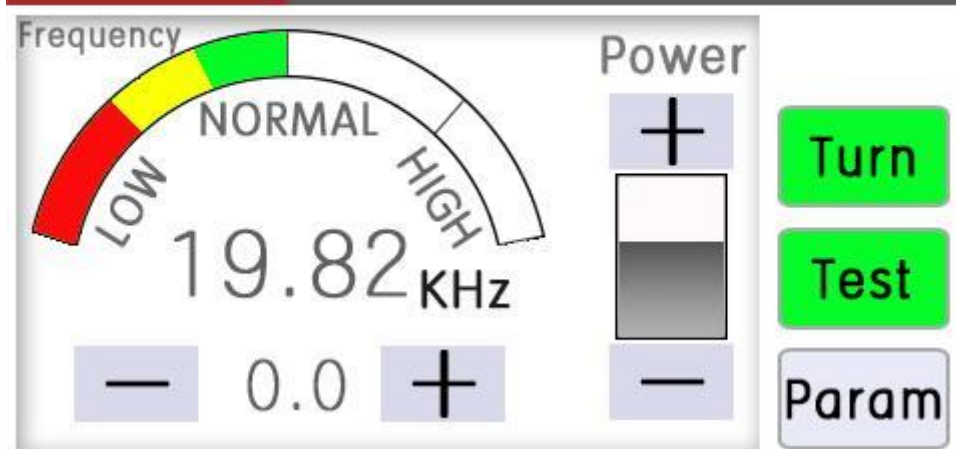
6.7. Wheel replacement



- 1) Remove the fixing screw and take out the wheel;
- 2) Insert the new wheel to be replaced into the bearing and tighten the fixing screw;
- 3) Adjust the angle of the wheel according to step 6.5, and the mold replacement is completed.

6.8. Ultrasonic adjustment

SW2001-20K Ultrasonic Generator



High or low frequency, Click  0.0 , Adjust frequency,

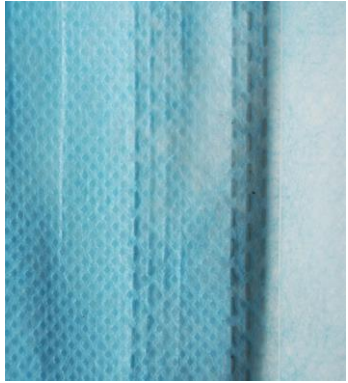

Power



High or low power, Click , Regulated power.

9、 Common problems and Solutions

9.1. See the table below for common problems and Solutions

Phenomenon		Cause analysis	Solutions
<p>Uneven left and right edge pressing of wheel</p>		<p>The wheel is not vertical to the welding head</p>	<p>according to 6.5 Step to adjust the flower wheel angle</p>
<p>Shallow or deep impression of wheel</p>		<p>mall or large cylinder stroke</p>	<p>according to 6.6 Step adjust cylinder stroke</p>

10、 Daily maintenance requirements

10.1. 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

11、 Knowledge product protection statement

MB9018B Ultrasonic lace machine (double motor) 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.