

Ultrasonic lace machine (double motor) (MB9018B)


Explanation of Adjustments

Adjustments made on the digital display

As soon as the power button  is turned on you will see the display below.



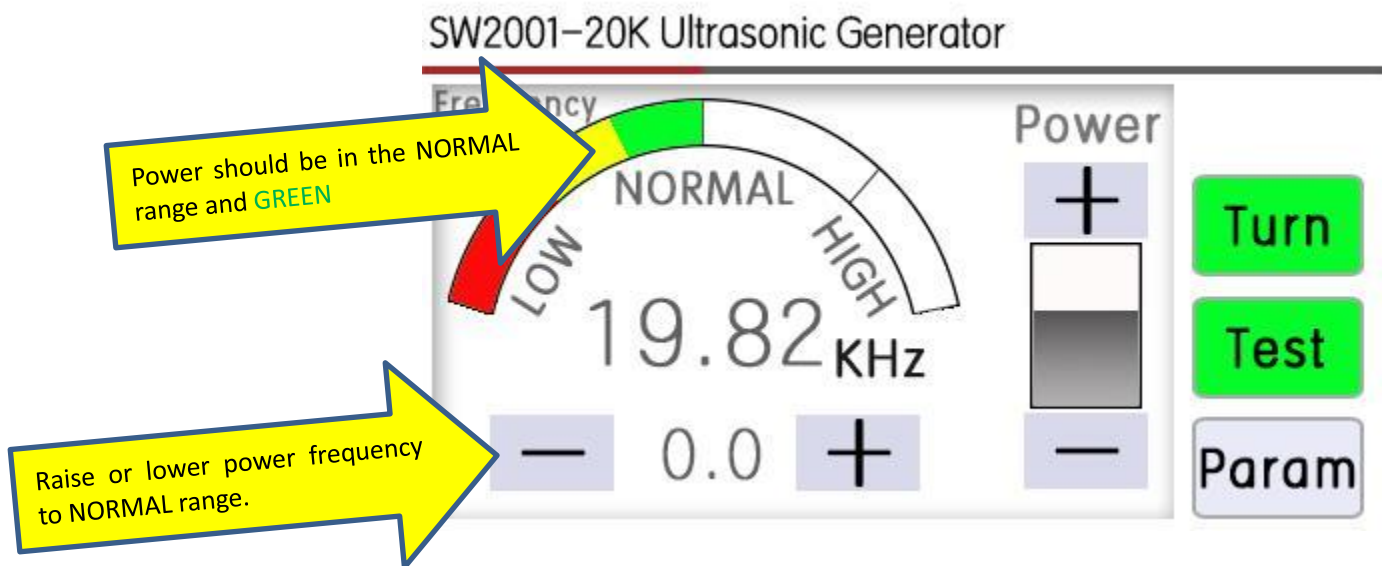
If you haven't done it already, press the button for **English**. This will set the display for English permanently until you wish to change it using the same method.

You should see the display below on the control box. Push . This runs both top and bottom motors to show they are both engaged and running. However, ultrasonic vibration is not engaged.

Press . This shows the power frequency. The power frequency should be in the

NORMAL range which is the **GREEN** area. Even though this is a 20 KHz machine, the power level will typically run just below that at around 19.80. Use the horizontal **- 0.0 +** buttons directly under the KHz display to bring the power frequency within the **GREEN** area or NORMAL zone. Never run the machine in the Low or High range.

The vertical "Power" adjustment to the right of the KHz display should remain at factory settings. No adjustment needed.

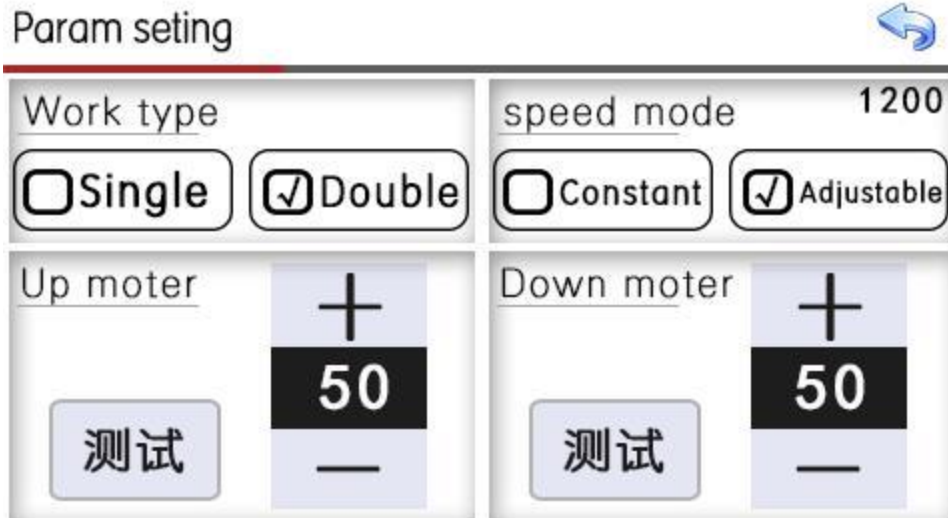


For the most part there is very little you can do to make significant adjustment on the touch screen display.

However, if you press the **Param** button you can adjust

- Turn the bottom or horn motor off, however this is not suggested
- Adjust the speed of the wheel and horn motors
- Make the operation of the wheel continuous (one speed when the foot pedal is depressed) or variable (speed controlled by pedal, more resembling a sewing machine)

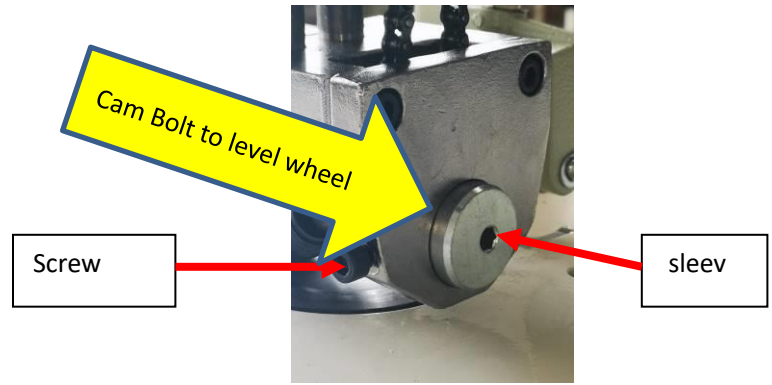
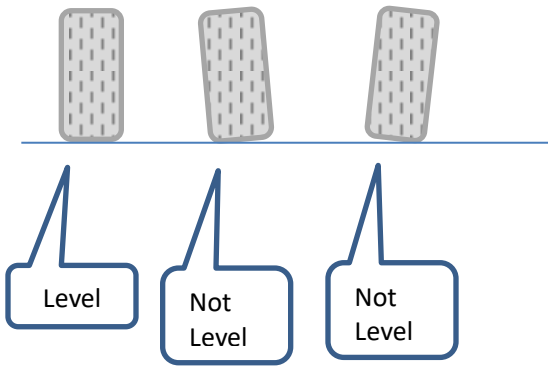
Once the **Param** button is depressed you will see the adjustments available on display.



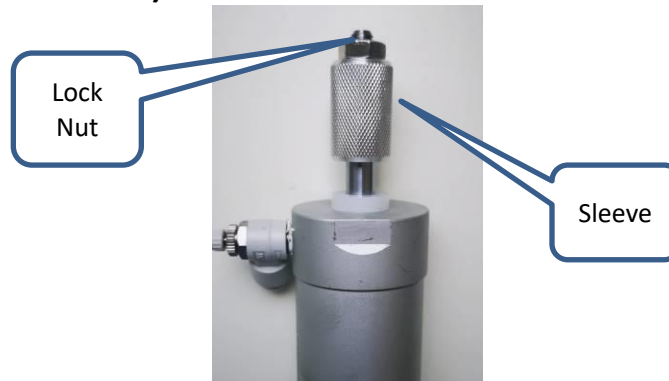
- Under the “Work type” display, if the “Single” button (not recommended) is pushed only the top motor will engage. This could possibly be used for tacking but in most cases is not recommended. When the bottom motor or the Horn motor is not running handling of the material is more difficult. The “Double” button should always be on in order to give the operator full control.
- Under the “speed mode” display, the “Adjustable” should usually be used. This allows the operator to control the speed with the foot pedal. The “Constant” button takes the speed control or variable speed away from the pedal/operator.
- To increase or decrease the speed of the motors push the “+” for increased speed and “-” for decreased speed. The speed for the “Up moter” and for the “Down moter” should be the same for normal welding conditions.

Mechanical Adjustments

This adjustment is for the leveling of the wheel. After loosening the set screw the sleeve (cam bolt) can be moved up and down in order to level the wheel.



To adjust the depth (up and down) of the wheel or how close it is to the horn or sonotrode.

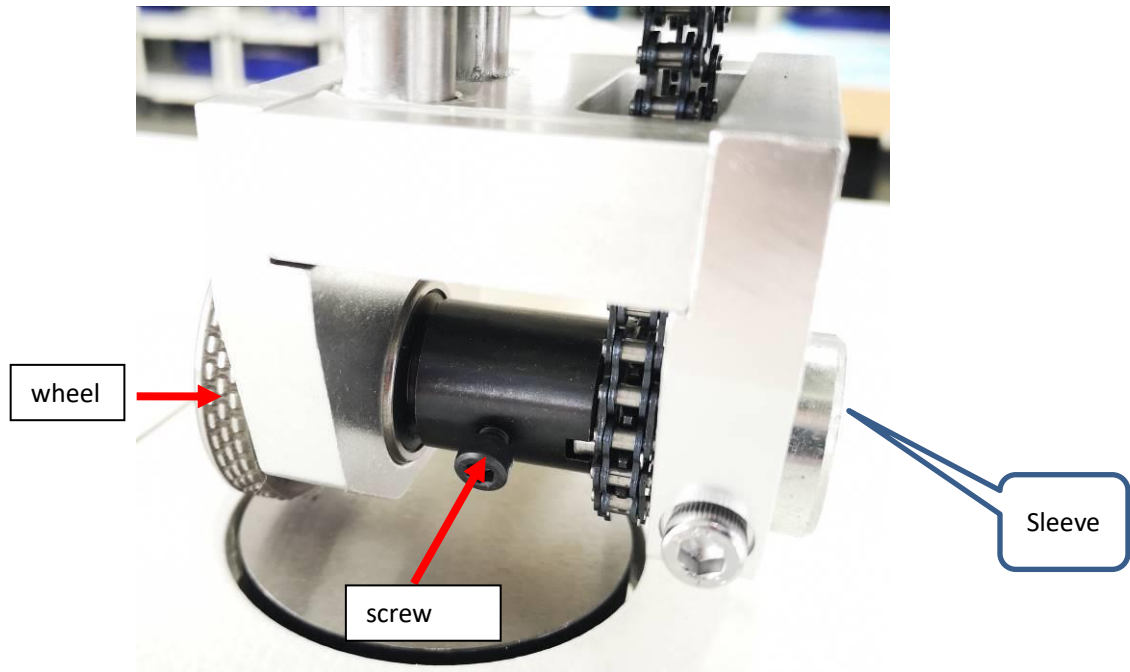


Loosen the Lock Nut, adjust the sleeve and position the wheel where you want it then re-tighten the Lock Nut.

A suggested method of adjusting the height of the wheel in relation to the horn:

- Place a single layer of the film or fabric you will be welding under the wheel between the wheel and the horn and machine bed.
- Adjust the wheel so that it lightly touches the single ply of fabric. It should be loosely held in place.
- Adjust the sleeve and tighten the lock nut. Ensure the wheel is not touching the horn.
- Test weld two plies of fabric.

Replacing the Wheel



Loosen the screw and remove the wheel. Some people have had trouble removing the wheel because the chain is too tight. You may need to loosen the level adjustment wheel (Sleeve) insert the wheel then re-adjust the level of the wheel.

Please let me know if any of this is explanation needs improvement or you have additional tricks or some improved methods of adjustments that might help.

Regards,

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