



電子送帶機

COMPUTERIZED METERING DEVICE

使用說明書
OPERATION MANUAL



MODEL : MC1 SERIES



中文版

ENGLISH

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EC - Manufacturer Declaration

EC Declaration of Conformity

We declare herewith that the following equipment :
NEEDLE POSITIONER

DEVICE---MK SERIES

. is designed to be a driver of a sewing unit or system and must not be put into commission until the sewing unit or system has been declared in conformity with the provision of the EC Machinery Directives.

. complies with the following relevant provisions:

- EC Low Voltage Directive (2014/35/EU)
- EC Electromagnetic Compatibility Directive (2014/30/EU)
- EC Machinery Directive (2006/42/EC)

Applied harmonized standards, especially :

- | | |
|-------------|---|
| EN 60204-31 | Electrical equipment of industrial machines. Particular requirements for sewing machines, sewing units and sewing system. |
| EN 12100 | Safety of machines. |

EG Konformitätserklärung

Hiermit erklären wir, dass die Bauart des Nähmaschinenantriebes :
MOTOR TYP

DEVICE---MK SERIES

. zum Einbau in eine Näheinheit oder Nähanlage sind und dass Inbetriebnahme so lange untersagt ist, bis festgestellt wurde, dass die Näheinheit oder Nählag, in die dieser Nähmaschinenantrieb eingebaut werden soll, den Bestimmungen der EG-Maschinenrichtlinie entspricht.

. folgenden einschlägigen Bestimmungen entspricht :

- EG Niederspannungsrichtlinie (2014/35/EU)
- EG EMV Richtlinie (2014/30/EU)
- EG Maschinenrichtlinie (2006/42/EWG)

Angewendete harmonisierte Normen, insbesondere :

- | | |
|-------------|--|
| EN 60204-31 | Elektrische Ausrüstung von Industriemaschinen. Besondere Anforderungen für Nähmaschinen, Nähheiten und Nähanlagen. |
| EN 12100 | Sicherheit von Maschinen, Grundsätzliche Terminologie und Methodik. |

Dichiarazione CE di conformità

Con la presente dichiariamo che la costruzione del motore per macchine per cucire :
TIPO DI MOTORE

DEVICE---MK SERIES

. è destinata per essere incorporata in una unità di cucitura oppure in un impianto di cucitura.

E vietata la sua messa in servizio prima che l'unità o l'impianto di cucitura in cui sarà incorporata sia stato dichiarato conforme alle disposizioni della direttiva CE per macchinari.

. è conforme alle seguenti disposizioni pertinenti :

- Direttiva CE per bassa tensione (2014/35/EU)
- Direttiva CE per compatibilità elettromagnetica (2014/30/EU)
- Direttiva CE per macchinari (2006/42/CE)

Norme armonizzate utilizzate, in particolare :

- | | |
|-------------|--|
| EN 60204-31 | Equipaggiamento elettrico di macchine industriali. Esigenze speciali per macchine per cucire, unità ed impianti di cucitura. |
| EN 12100 | Sicurezza di macchinari, terminologia di base e metodica. |

Déclaration CE de conformité

Par la présente, nous déclarons que le type de fabrication du moteur pour machines à coudre :
TYPE DE MOTEUR

DEVICE---MK SERIES

. est destiné à être intégré à une unité ou un système de couture et que sa mise en service est interdite tant que l'unité ou le système de couture auquel il sera intégré n'ait été déclaré conforme aux dispositions de la directive CE sur les machines.

. répond aux suivantes dispositions pertinentes :

- Directive CE sur la basse tension (2014/35/EU)
- Directive CE sur la compatibilité électromagnétique (2014/30/EU)
- Directive CE sur les machines (2006/42/CE)

Normes appliquées après harmonisation, en particulier :

- | | |
|-------------|--|
| EN 60204-31 | Équipement électrique des machines industrielles. Règles particulières pour machines à coudre, unités et systèmes couture. |
| EN 12100 | Sécurité des machines, terminologie de base, méthodologie. |

Declaração CE de Conformidade

Declaramos, pelo presente instrumento, que a construção do motor da máquina de costura :
TIPO DO MOTOR

DEVICE---MK SERIES

. está destinada a ser incorporada numa unidade ou instalação de costura. Nunca colocar em serviço antes de a unidade de costura ou a instalação de costura em que este motor vai ser incorporado ser declarada em conformidade com o disposto na diretiva da CE sobre máquinas.

. corresponde às seguintes normas pertinentes :

- Directiva CE sobre baixa tensão (2014/35/EU)
- Directiva CE sobre compatibilidade electromagnética (2014/30/EU)
- Directiva da CE sobre máquinas (2006/42/CE)

Normas harmonizadas aplicadas, em particular :

- | | |
|-------------|---|
| EN 60204-31 | Equipamento eléctrico de máquinas industriais. Requisitos especiais para máquinas de costura, Unidades de costura e instalações de costura. |
| EN 12100 | Segurança das máquinas, terminologia básica, metodologia. |

EC Declaración de Conformidad

Declaramos junto con esto que el siguiente equipo :
MOTOR SINCRONIZADOR

DEVICE---MK SERIES

. está diseñado para ser un controlador de una unidad de costura o sistema y no hay que ser puesto en servicio activo hasta que la unidad de costura o sistema se ha declarado conforme a la provisión de EC Directivas Maquinarias.

. Se conforma con las siguientes provisiones pertinentes :

- EC Directiva Voltaje Bajo (2014/35/EU)
- EC Directiva Compatibilidad Electromagnética (2014/30/EU)
- EC Directiva Maquinaria (2006/42/EC)

Aplicado normas armonizadas, especialmente :

- | | |
|-------------|---|
| EN 60204-31 | Equipo electrico de máquinas industriales. Requisito particular para máquinas de coser. Unidades de costura y sistema de costura. |
| EN 12100 | Seguridad de máquinas. |

H. S. Machinery. Co., Ltd

Mr. C. C. Lee Plant Manager

有毒物質限量指令自我宣告書

Declaration of Conformity for Concentration Limits for Certain Hazardous Substances

本公司所生產之伺服馬達產品系列如下所列：

We declare herewith that the following AC servo motor series products list below：

AC 伺服馬達--- i 系列/ G 系列/ GD 系列/ MD 系列

AC Servo Motor --- i Series / G Series / GD Series / MD Series

Devrice---TK Series / TC Series / MK Series

皆符合以下指令及要求：

Are complies with the following directives and requirements：

1. 歐盟 RoHS 指令 (2002/95/EC) 及有毒物質的限量要求 (2005/618/EC)
2. 中華人民共和國電子行業標準：電子信息產品中有毒有害物質的限量要求 (SJ/T 11363-2006)

1. European Union RoHS Directive (2002/95/EC) and the concentration limits for certain hazardous substances (2005/618/EC)

2. People's Republic of China Electronic Business Standard : Requirements for concentration limits for certain hazardous substances in electronic information products (SJ/T 11363-2006)

本公司產品本身(馬達,控制箱)或其包裝材料及附件(紙箱,螺絲配件包,說明書,貼紙,標籤,印刷品...等等)或其元件與原材料供應商皆依照歐盟 RoHS 指令及中華人民共和國電子行業標準的限量規定而符合以下所列之六種有毒物質的限量要求：

Our product itself (motor, control box) or its packing materials and accessories (box, screws package, user manual, sticker, label, print...etc.) or the suppliers of parts and raw materials are all in conformity with the provision of the European Union RoHS Directive and People's Republic of China Electronic Business Standard to conform the following concentration limits for the six hazardous substances：

有毒物質 / Hazardous Substance	限量要求 / Permissible Values
鉛 Lead (Pb)	低於 1000 ppm / Less than 1000 ppm
汞 Mercury (Hg)	低於 1000 ppm / Less than 1000 ppm
鎘 Cadmium (Cd)	低於 100 ppm / Less than 100 ppm
六價鉻 Hexavalent chromium (Cr VI)	低於 1000 ppm / Less than 1000 ppm
多溴聯苯 Polybrominated Biphenyl (PBB)	低於 1000 ppm / Less than 1000 ppm
多溴二苯醚 Polybrominated Diphenyl ether (PBDE)	低於 1000 ppm / Less than 1000 ppm
鄰苯二甲酸二酯 Di(2-ethylhexyl)phthalate (DEHP)	低於 1000 ppm / Less than 1000 ppm
鄰苯二甲酸丁酯苯甲酯 Butyl Benzyl Phthalate (BBP)	低於 1000 ppm / Less than 1000 ppm
鄰苯二甲酸二丁酯 Dibutyl phthalate (DBP)	低於 1000 ppm / Less than 1000 ppm
鄰苯二甲酸二異丁酯 Diisobutyl phthalate (DIBP)	低於 1000 ppm / Less than 1000 ppm

* 基板的無鉛製程：總鉛含有濃度基準量 800 ppm 以下。

* The concentration of lead in the lead-free process for PCB shall be less than 800 ppm.

* 包裝材料：Pb+Hg+Cd+Cr VI 含有濃度基準總共合計 80 ppm 以下。

* For packing materials shipped with our products or parts, the hazardous substances shall be 80 ppm or less in sum of Pb+Hg+Cd+Cr VI.

H. S. Machinery. Co., Ltd



Mr. C. C. Lee Plant Manager

目錄

I. 安全上的注意事項.....	1
II. 接線與接地.....	3
III. 控制箱安裝.....	4
IV. 縫製畫面功能說明.....	22
V. 編輯畫面功能說明.....	24
VI. 參數設定畫面功能說明.....	27
VII. 測試畫面功能說明.....	31
VIII. 操作說明.....	32
IX. 提示代碼和錯誤代碼.....	36

I. 安全上的注意事項

使用前請詳細閱讀本技術資料與所搭配的縫製機械說明書，配合正確使用，並須由接受過正確訓練的人員來安裝或操作。

在使用或安裝 MC 控制箱驅動裝置時，請注意下列事項。
本驅動裝置僅適用於指定範圍的縫紉機械，請勿移做其他用途。

1 作業環境的安全：

(1). 電源電壓：

電源電壓請遵照控制箱銘牌所標示之規格 $\pm 10\%$ 範圍內操作。

(2). 電磁波干擾：

請遠離高週磁波機器或電波發射器等，以免所產生的電磁波干擾本驅動裝置因而發生錯誤動作。

(3). 溫濕度 /：

- a. 請不要在室溫 45°C 以上或 5°C 以下的場所操作。
- b. 請不要在日光直接照射的場所或室外運作。
- c. 請不要在暖氣 (電熱器) 旁運作。
- d. 請不要在相對濕度 30% 以下或 95% 以上或有露水的場所運作。

(4). 空氣：

- a. 請不要在多灰塵或具有腐蝕性物質的場所操作。
- b. 請不要在有揮發性氣體的場所操作。

2 安裝的安全：

(1). 控制箱：請遵照說明書正確裝好。

(2). 附屬品：如要裝配其它選購配件或附屬品時，請先關閉電源並拔掉電源線插頭。

(3). 電源線：

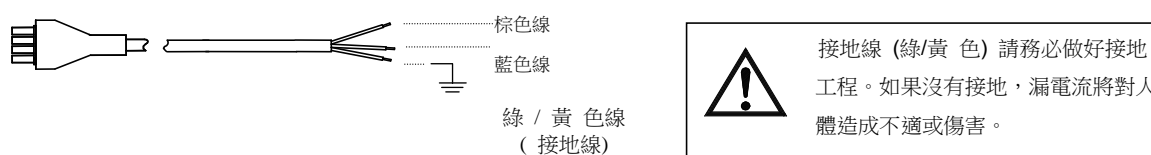
- a. 請注意不要被外物壓住或過度扭曲電源線。
- b. 裝釘電源線時請不要靠近會轉動的皮帶輪及三角皮帶，最少要離開 3 公分以上。
- c. 當連接電源線到電源插座時，應確定此供應電壓必須符合標示在控制箱銘牌上的指定電壓 $\pm 10\%$ 內。

※注意：控制箱電源系統為 **AC 220V** 時，請勿插接到 **AC 380V** 的電源插座上，此時請立即關閉電源開關，重新檢查電源。持續供應 **380V** 超過五分鐘以上，將會燒毀基板而危及人身安全。



(4).接地：

a. 為防止雜訊干擾或漏電事故，請做好接地工程。(包括縫紉機、馬達、控制箱、定位器)



b. 電源線的接地線須以適當大小的導線和接頭連接到生產工廠的系統地線，此連接必須被永久固定。

3 操作中的安全：

- (1). 在第一次開電後，請先以低速操作送料機並檢查送料方向是否正確。
- (2). 送料機運轉時，請不要去觸摸送料機構等會作動的部位。
- (3). 所有可作動的部份，必須以所提供的防護裝置加以隔離，防止身體接觸並請勿在裝置內塞入其他物品。

4 保養維修的安全：

在操作以下動作前，請先關閉電源：

- (1). 要拆卸控制箱時，或在控制箱上插或拔任何連接插頭時。
- (2). 控制箱裡面有危險高壓電，所以關閉電源後要等 10 分鐘以上方可打開控制箱蓋。
- (3). 修理或作任何機械上的調整時翻抬車頭時。
- (4). 機器休息不用時。

5 保養維修的規定：

- (1). 修理及保養的作業，要請經過訓練的技術人員執行。
- (2). 請不要以不適當物體，如木槌、鐵槌等敲擊本產品裝置。
- (3). 所有維修用的零件，須由本公司提供或認可，方可使用。

6 危險標示、注意標示：



這個標示符號表示機器安裝時，如有錯誤恐會傷害到人體或機器會受到損壞，所以機器方面有危險性的地方會有此標示。



這個標示符號表示有高壓電，電氣方面有危險性的地方會有此標示。

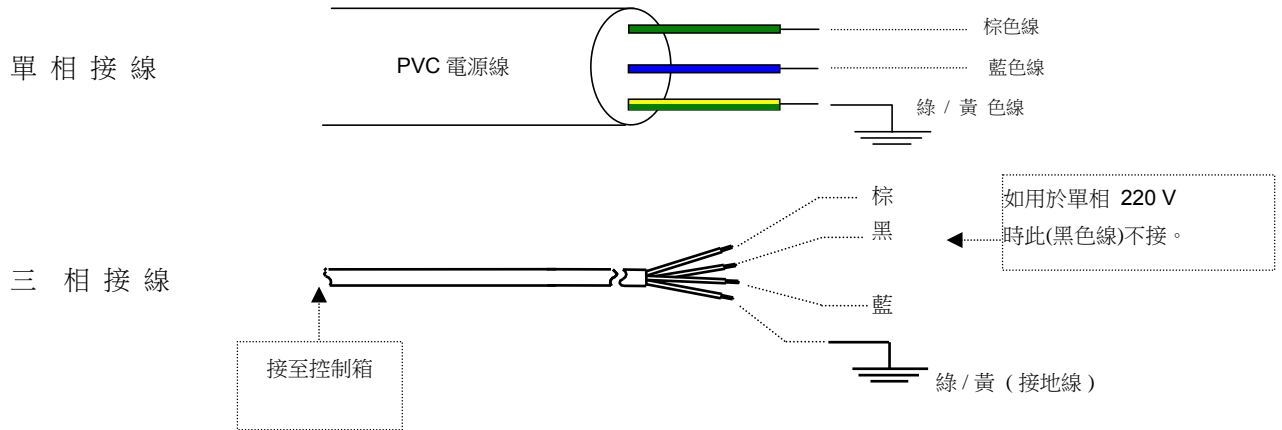
7 保固期限規定：

本裝置保證在正常工作情況且無人為失誤的操作下，保證出廠 18 個月內，無償的為客戶維修使能正常操作。

II. 接線與接地

(1). 單相與三相電源線的接法：

綠/黃色電線為接地線。

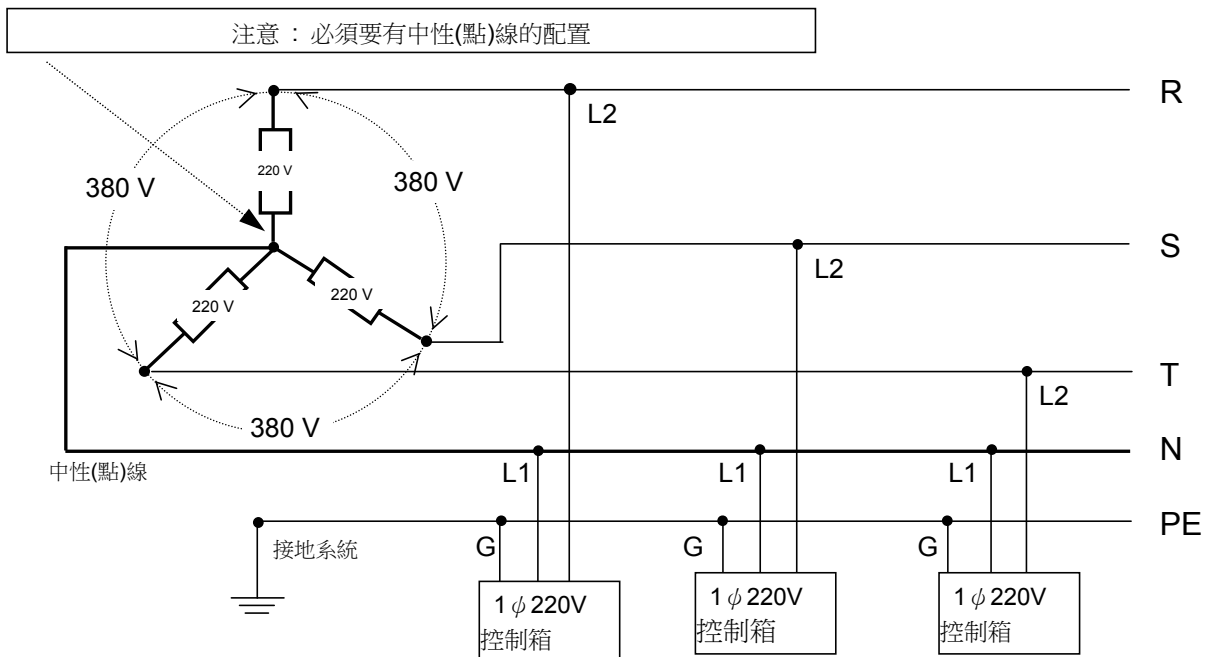


1. 當控制箱如要接於單相 200 ~ 240 V 的電壓使用時，只要接 棕色線 和 藍色線 即可，但黑色線請用絕緣膠帶確實包好，以免產生漏電現象。
2. 綠/黃色電線為接地線，一定要做好系統的接地工程。

(2). 當電源系統配置為三相四線式 380V 時，欲使用單相 220 V 供應本電機的接線方式：



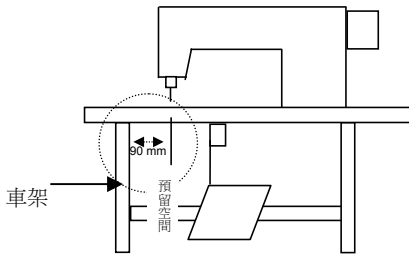
注意：如果此配置系統沒有【中性(點)線】時，則控制箱不適合在此場所使用。



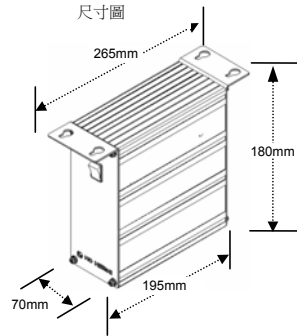
(3). 當控制箱欲使用在三相 220V 的電壓時，須注意配置使用上的負載平衡。

III. 控制箱安裝

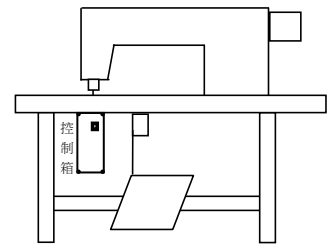
a). 車板左側車架面須預留 90 mm 以上空間



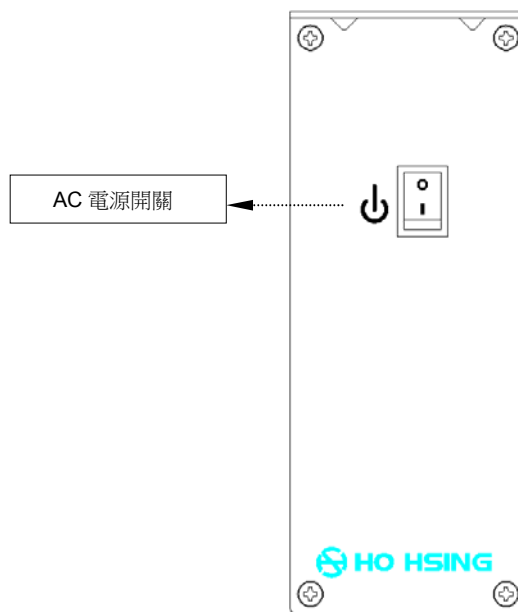
b). 將 MC 控制箱鎖裝於車板下方



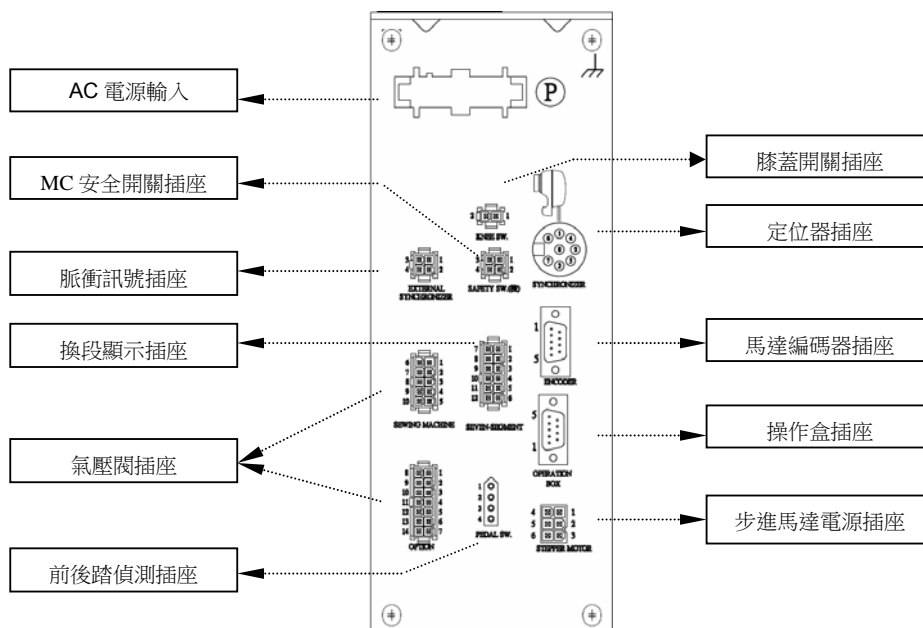
c). 安裝後示意圖



控制箱正面：



控制箱背面 端子座面板：



端子座 Pin 功能配置圖：

SYNCHRONIZER	
1	---
2	+5V
3	PULSE IN
4	0V
5	NO SYNC.
6	---
7	UP
8	---
9	---

EXTERNAL SYNCHRONIZER		
1	+5V	+5V
2	US	EXTERNAL US
3	---	---
4	0V	0V

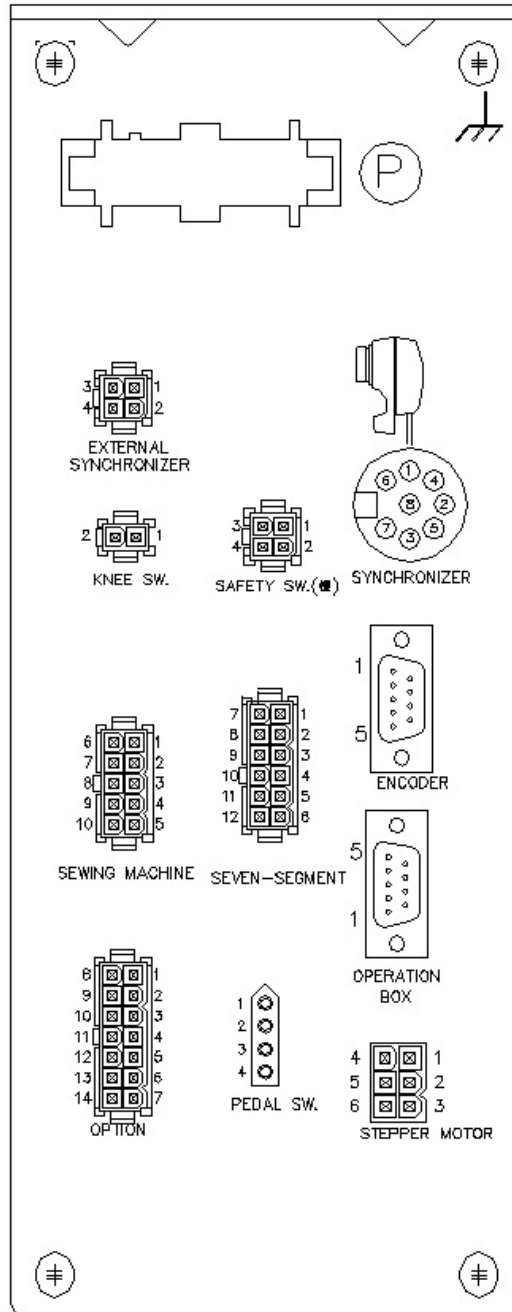
SAFETY SW.		
1	+12V	+12V
2	INL	SAFETY SW.
3	+5V	+5V
4	0V	0V

KNEE SW.		
1	INK	KNEE SW.
2	0V	0V

OPTION		
1	06	■01
8	E+	E+
2	07	■02
9	E+	E+
3	OP SW.	OP SW.
10	0V	0V
4	INB	PSD
7	+12V	+12V
11	0V	0V
5	REV.SW	REV.SW
12	0V	0V
6	HP SW.	HP SW.
13	0V	0V
14	+5V	+5V

SEWING MACHINE		
1	OA	MT
2	OB	MW
3	OC	MR
4	OD	ML
5	OF	MP
6	+24V	+24V
7	+24V	+24V
8	+24V	+24V
9	+24V	+24V
10	+24V	+24V

PEDAL SW.		
1	+5V	+5V
2	FORWARD	FORWARD SW.
3	BACK	BACK SW.
4	0V	0V



OPERATION BOX	
1	+12VF
2	---
3	T1fn
4	R1fn
5	---
6	---
7	---
8	---
9	0V

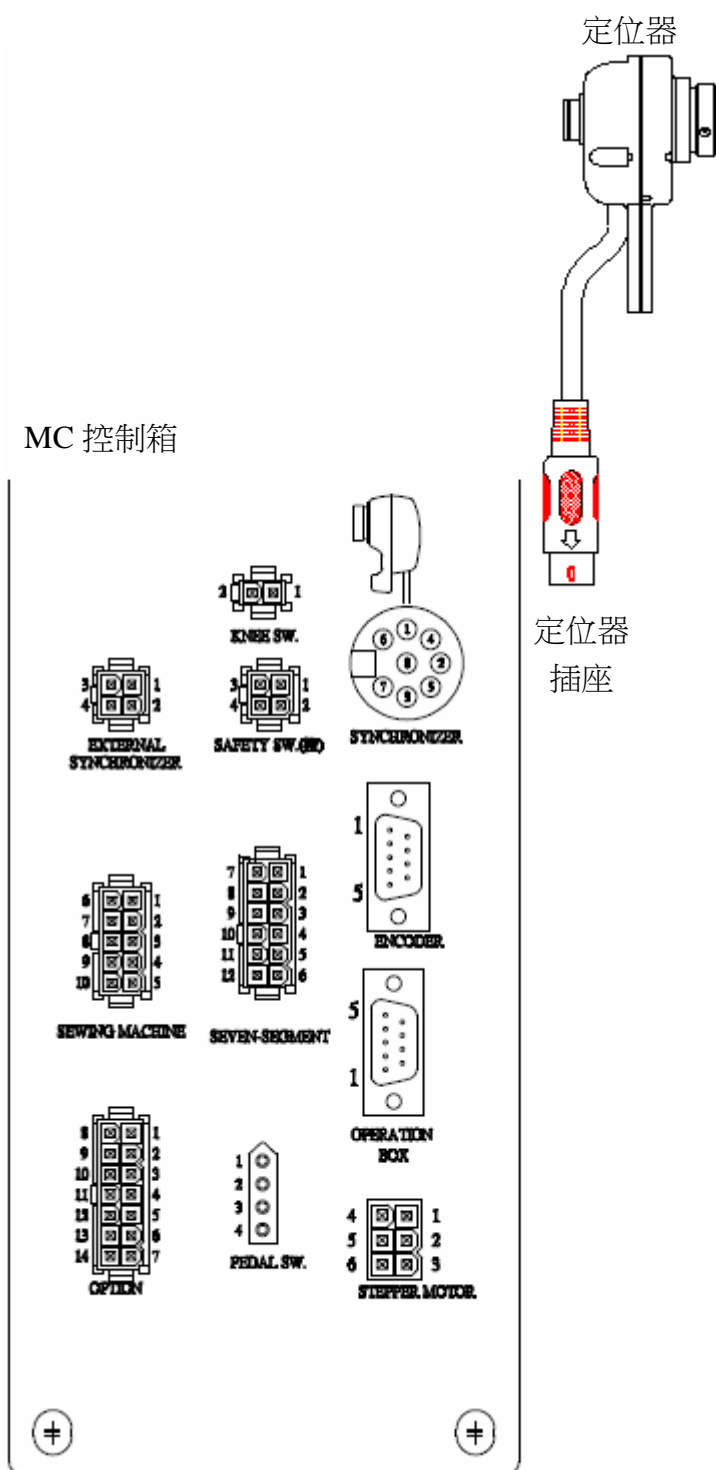
ENCODER	
1	+5V
2	UP
3	---
4	A PHASE
5	---
6	---
7	---
8	---
9	0V

SEVEN-SEGMENT	
1	OUT0
2	OUT1
3	OUT2
4	OUT3
5	OUT4
6	OUT5
7	OUT6
8	OUT7
9	+5V
10	U SW.
11	0V
12	0V

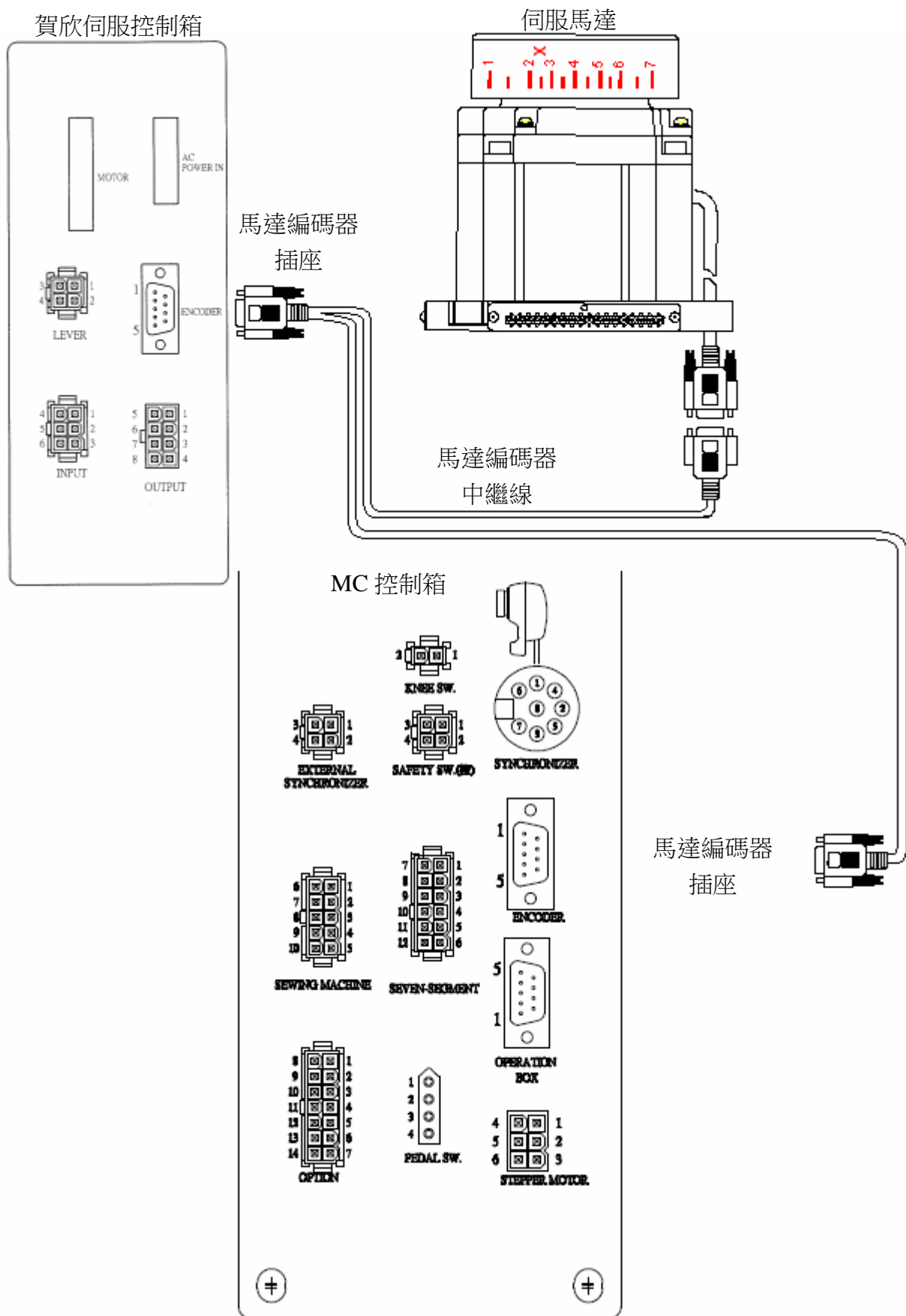
STEPPER MOTOR	
1	A
2	B
3	C
4	D
5	E
6	---

搭配說明示意圖：

1. 一般安裝



2. 賀欣直驅式伺服電機

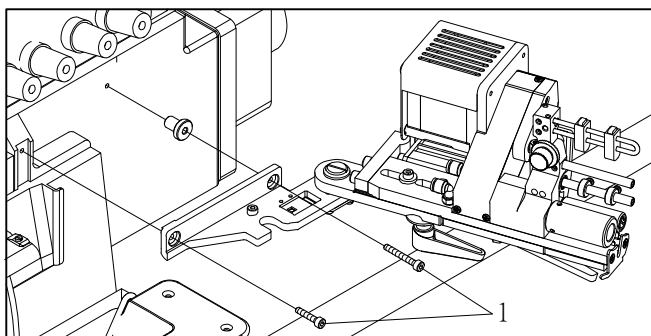


各部件的安裝

MC裝置的安裝

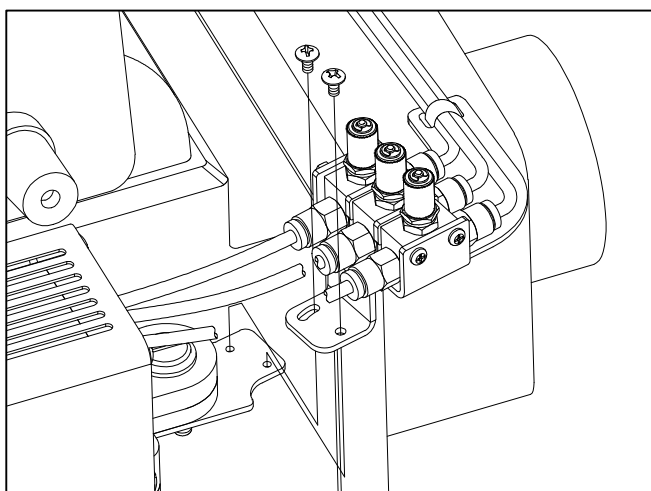
⚠ 在安裝MC裝置時，請務必關閉電源，並將插座上的電源插頭拔下，然後請專門的技術人員進行操作。

請參照右圖，將帶有MC裝置的托架，用螺絲 1 安裝到縫紉機車頭上。



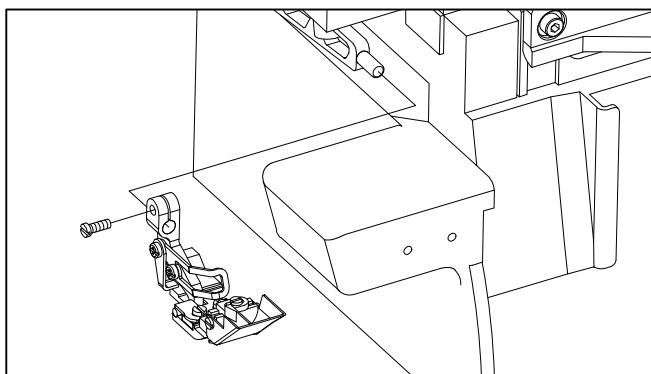
流量調節閥的安裝

⚠ 在安裝流量調節閥時，務必將電源開關及空氣壓縮機所供給的壓縮空氣切斷之後，然後請專門的技術人員進行操作。



壓布腳的安裝

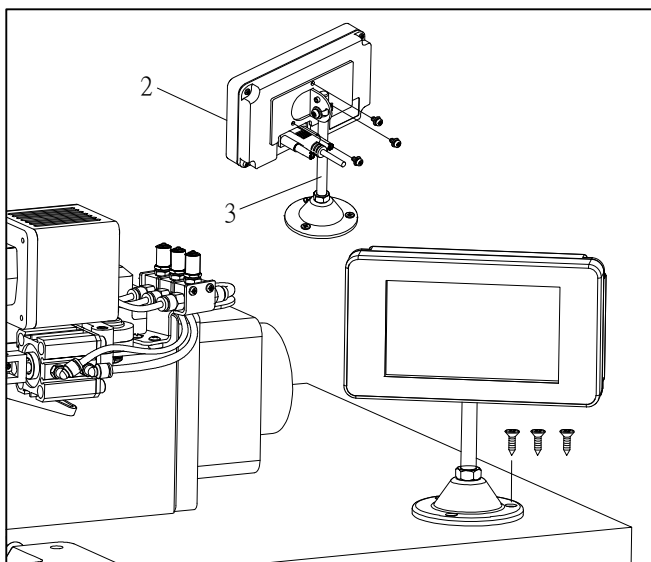
⚠ 在安裝壓布腳時，請務必關閉電源，並將插座上的電源插頭拔下，然後請專門的技術人員進行操作。



操作盒的安裝

⚠ 在安裝操作盒時，請務必關閉電源，並將插座上的電源插頭拔下，然後請專門的技術人員進行操作。

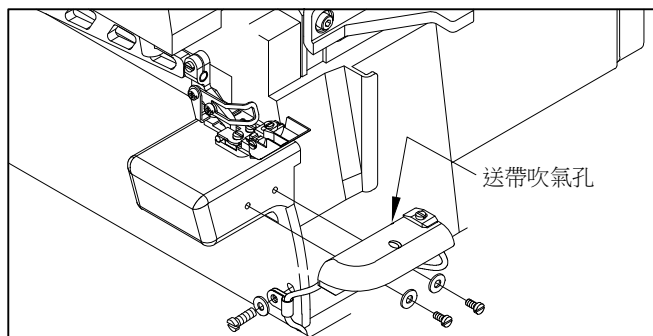
1. 請將操作面板 2 安裝到托架 3 上。
2. 再請將操作面板 2 和托架 3 安裝到車板上。



各部件的安裝

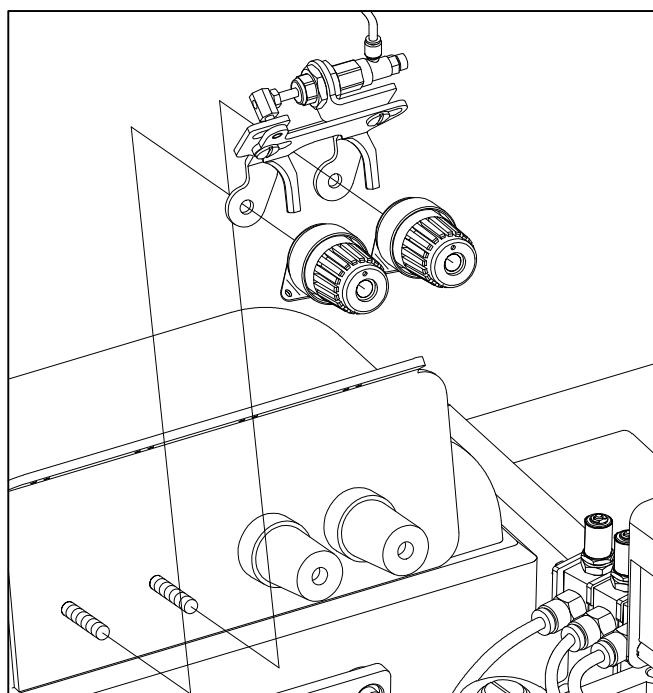
下吹風裝置的安裝

⚠ 在安裝下吹風裝置時，務必將電源開關及空氣壓縮機所供給的壓縮空氣切斷之後，然後請專門的技術人員進行操作。



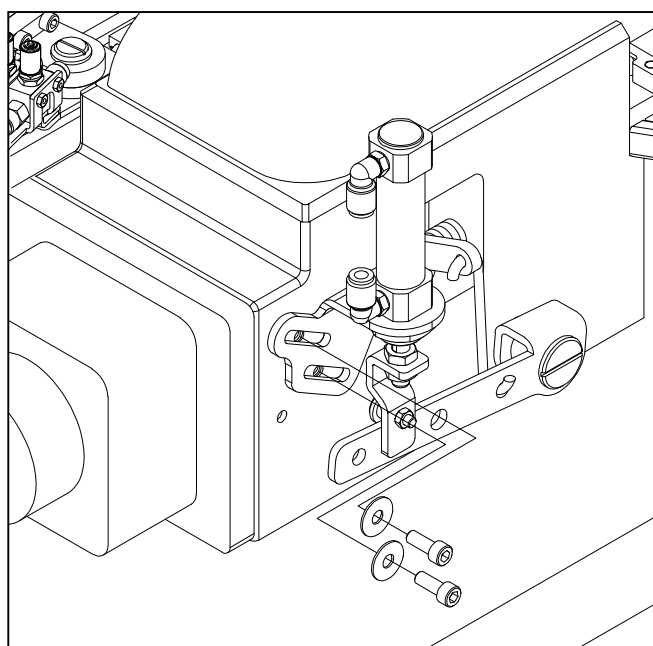
鬆線裝置的安裝

⚠ 在安裝鬆線裝置時，請務必關閉電源，並將插座上的電源插頭拔下，然後請專門的技術人員進行操作。



抬壓腳氣缸裝置的安裝

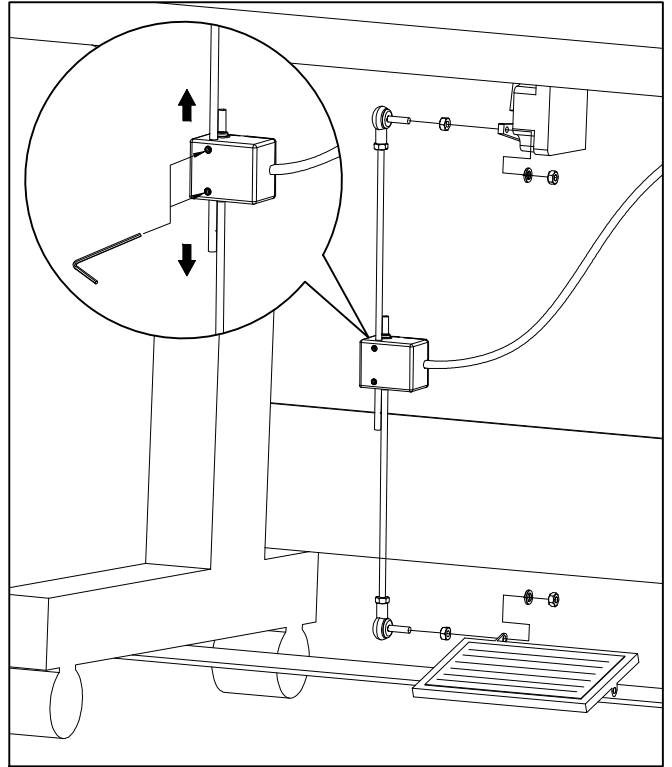
⚠ 在安裝抬壓腳氣缸裝置時，務必將電源開關及空氣壓縮機所供給的壓縮空氣切斷之後，然後請專門的技術人員進行操作。



各部件的安裝

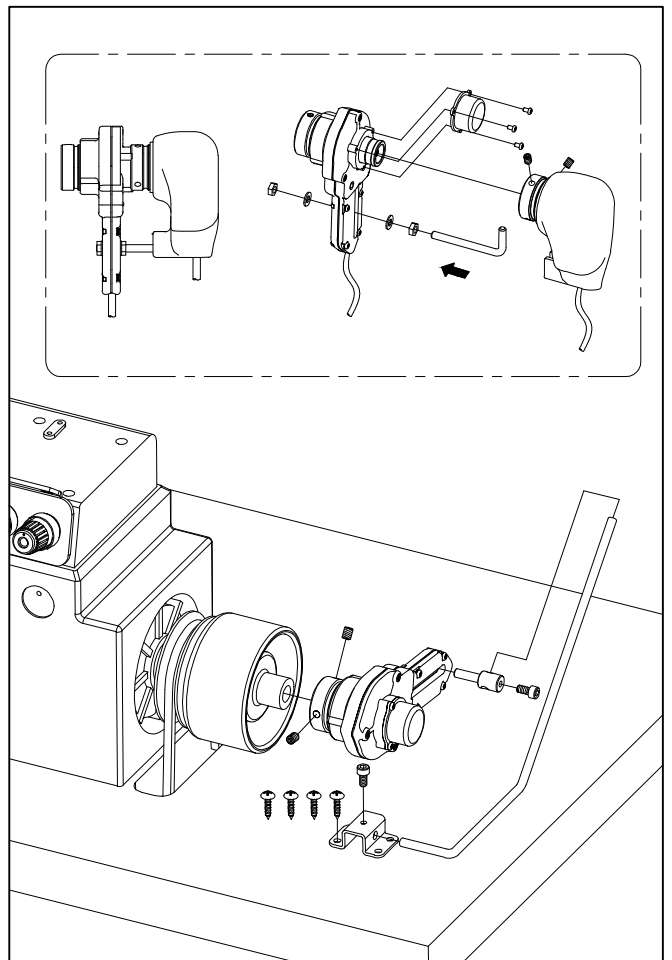
前後踏偵測裝置的安裝

⚠ 在安裝鬆線裝置時，請務必關閉電源，並將插座上的電源插頭拔下，然後請專門的技術人員進行操作。



定位器的安裝

⚠ 在安裝定位器時，請務必關閉電源，並將插座上的電源插頭拔下，然後請專門的技術人員進行操作。



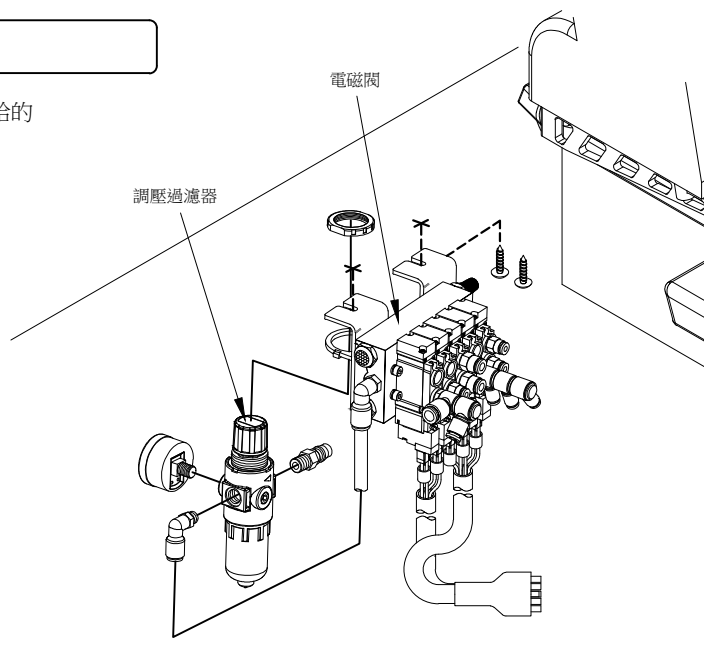
各部件的安裝

電磁閥與調壓過濾器的安裝

⚠ 在安裝電磁閥與調壓過濾器時，務必將電源開關及空氣壓縮機所供給的壓縮空氣切斷之後，然後請專門的技術人員進行操作。

⚠ 壓縮空氣的供給一定要在風壓管線確實接好後進行。

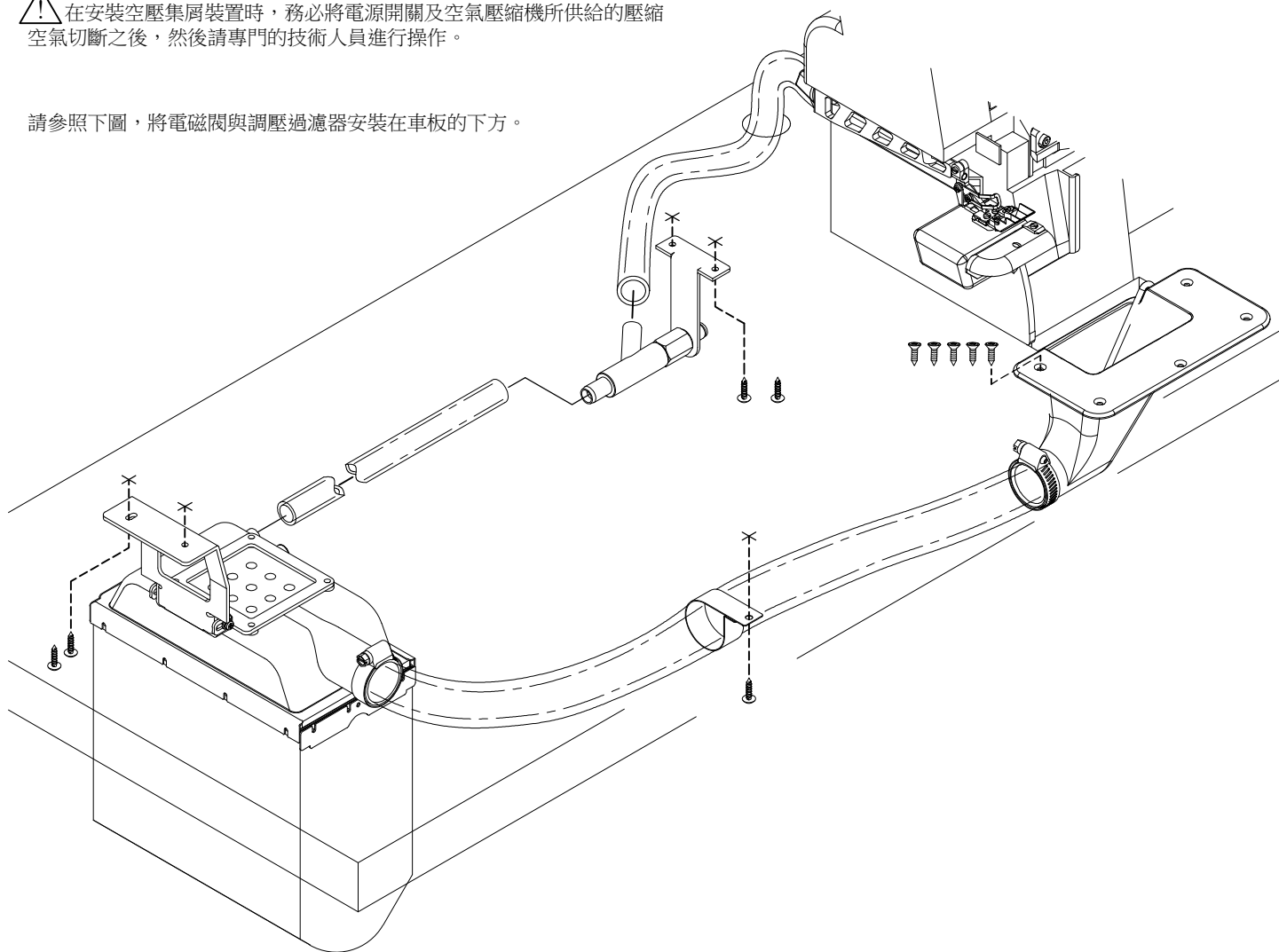
請參照右圖，將電磁閥與調壓過濾器安裝在車板的下方。



空壓集屑裝置的安裝

⚠ 在安裝空壓集屑裝置時，務必將電源開關及空氣壓縮機所供給的壓縮空氣切斷之後，然後請專門的技術人員進行操作。

請參照下圖，將電磁閥與調壓過濾器安裝在車板的下方。



風壓管的連接

⚠ 注意

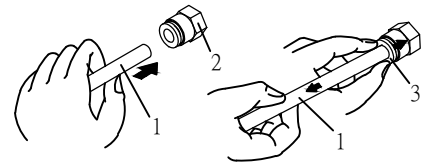
⚠ 在連接風壓管管線時，務必將電源開關及空氣壓縮機所供給的壓縮空氣切斷之後，請專門的技術人員進行操作。

⚠ 壓縮空氣的供給一定要在風壓管線確實接好後進行。

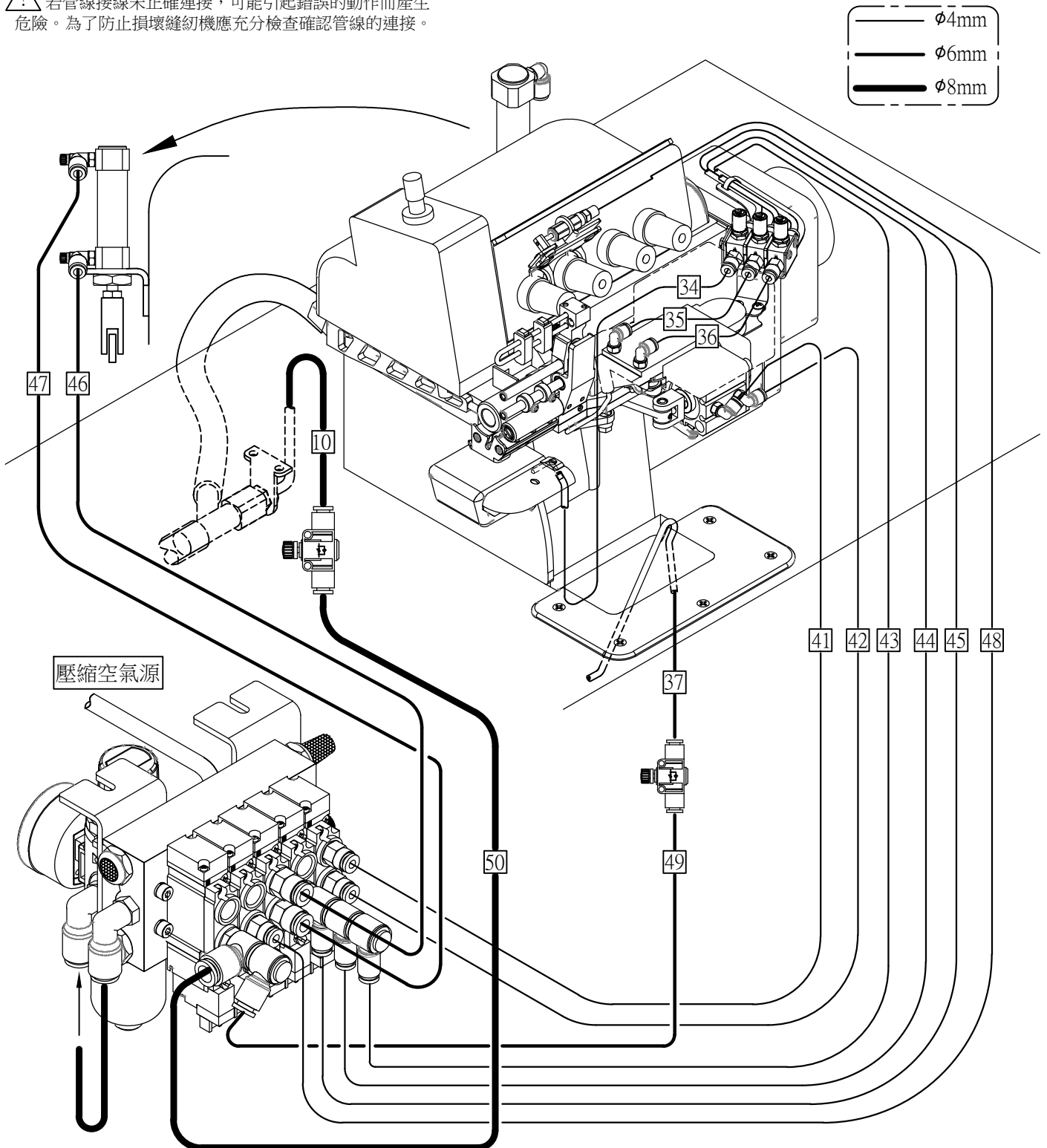
⚠ 若管線接線未正確連接，可能引起錯誤的動作而產生危險。為了防止損壞縫紉機應充分檢查確認管線的連接。

● To connect air tube 1 to joint 2, insert the tube completely to the inlet depth and make sure the tube can not be disconnected by pulling it.

● To disconnect air tube 1, press release ring 3 toward the arrow and pull it out.



請參照下圖，進行風壓管管線得連接。



調壓過濾器的調節

(1) 空氣壓力的調節

向上拉動調壓過濾器的旋鈕 1，則會聽到『喀嚓』一聲，旋鈕稍微向上彈起。這時請轉動旋鈕 1，將空氣壓力調節到 0.5Mpa (5kgf/cm²)。

- 向(+)方向旋轉，壓力增加。
- 向(-)方向旋轉，壓力增加。

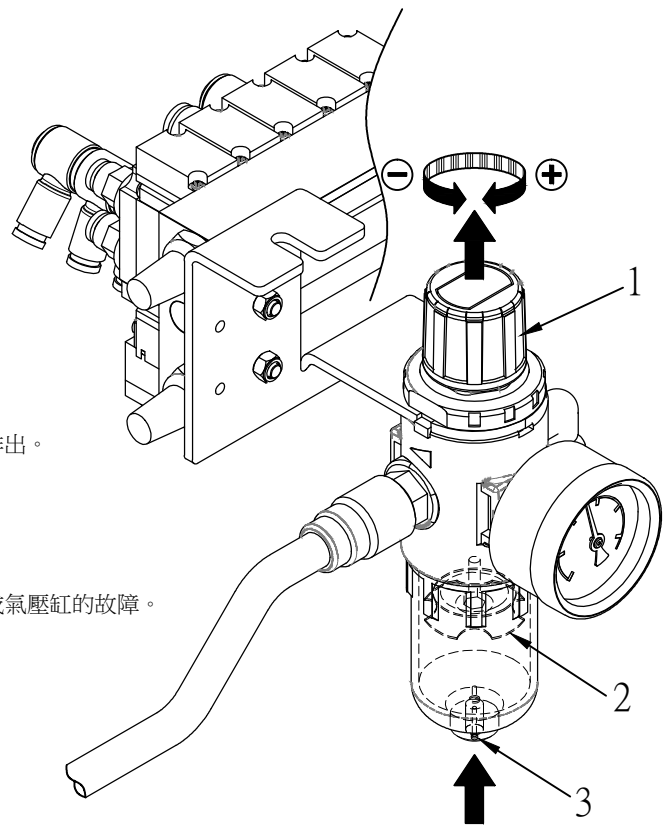
(2) 積水的排出

當積水深度到達擋蓋 2 的位置之前，請按壓排水按鈕 3 將積水排出。

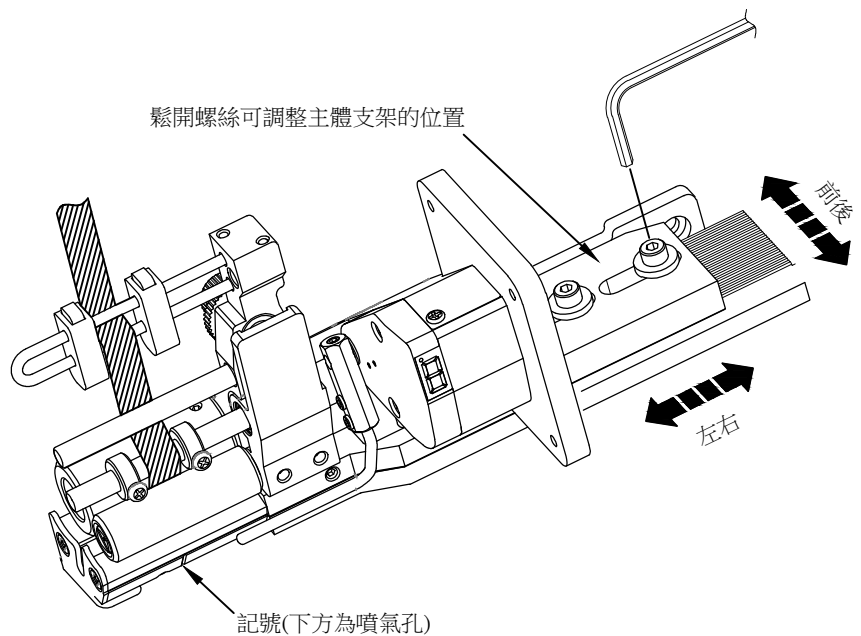
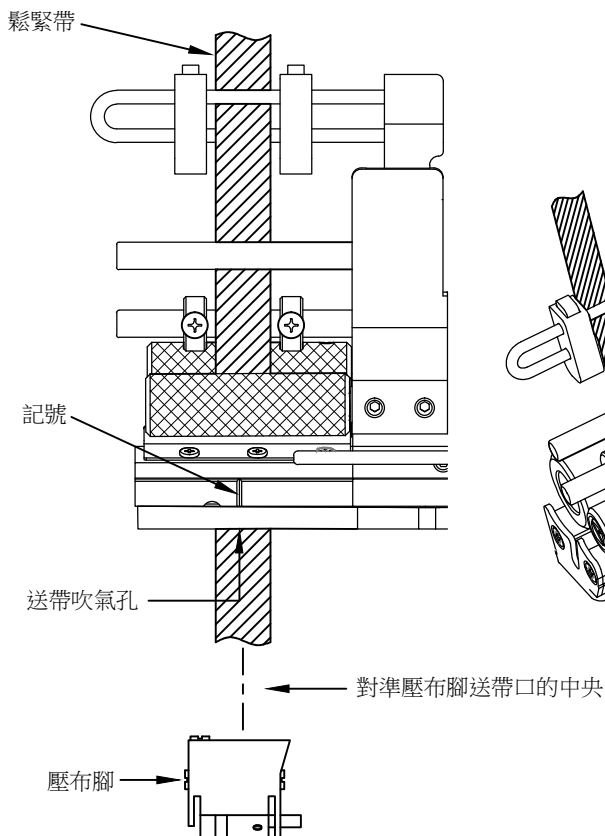
⚠ 注意

調壓過濾器的清掃以及積水的排除應定期進行。積水過多會造成氣壓缸的故障。

排水時積水與壓縮空氣會一起向外沖出，排水時請格外注意。





放入鬆緊帶的正確位置

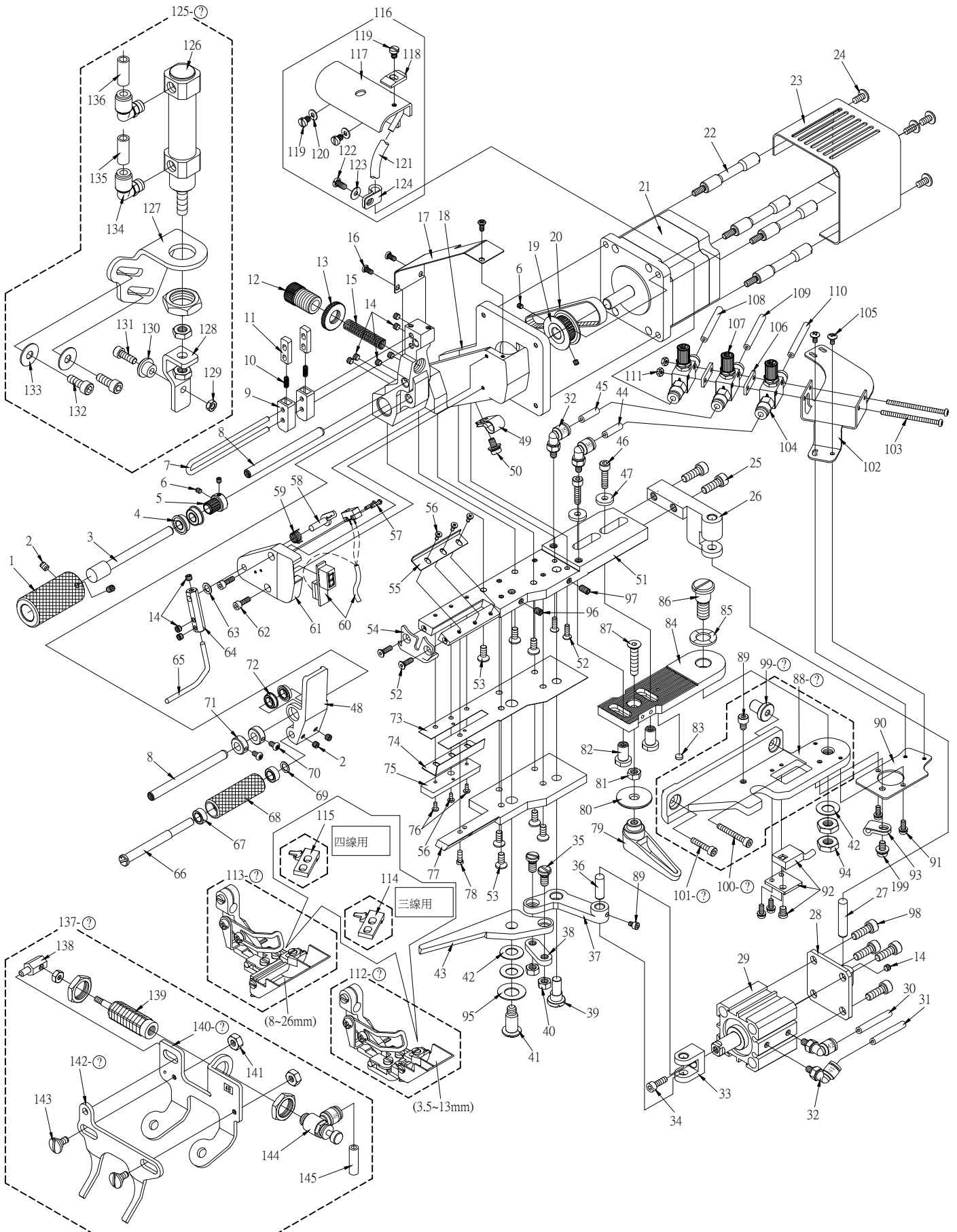


主機的記號必需調整對準壓步腳送帶口的中央。
(送帶用噴氣孔是在記號的下方)



MC1-38 送料機零件圖

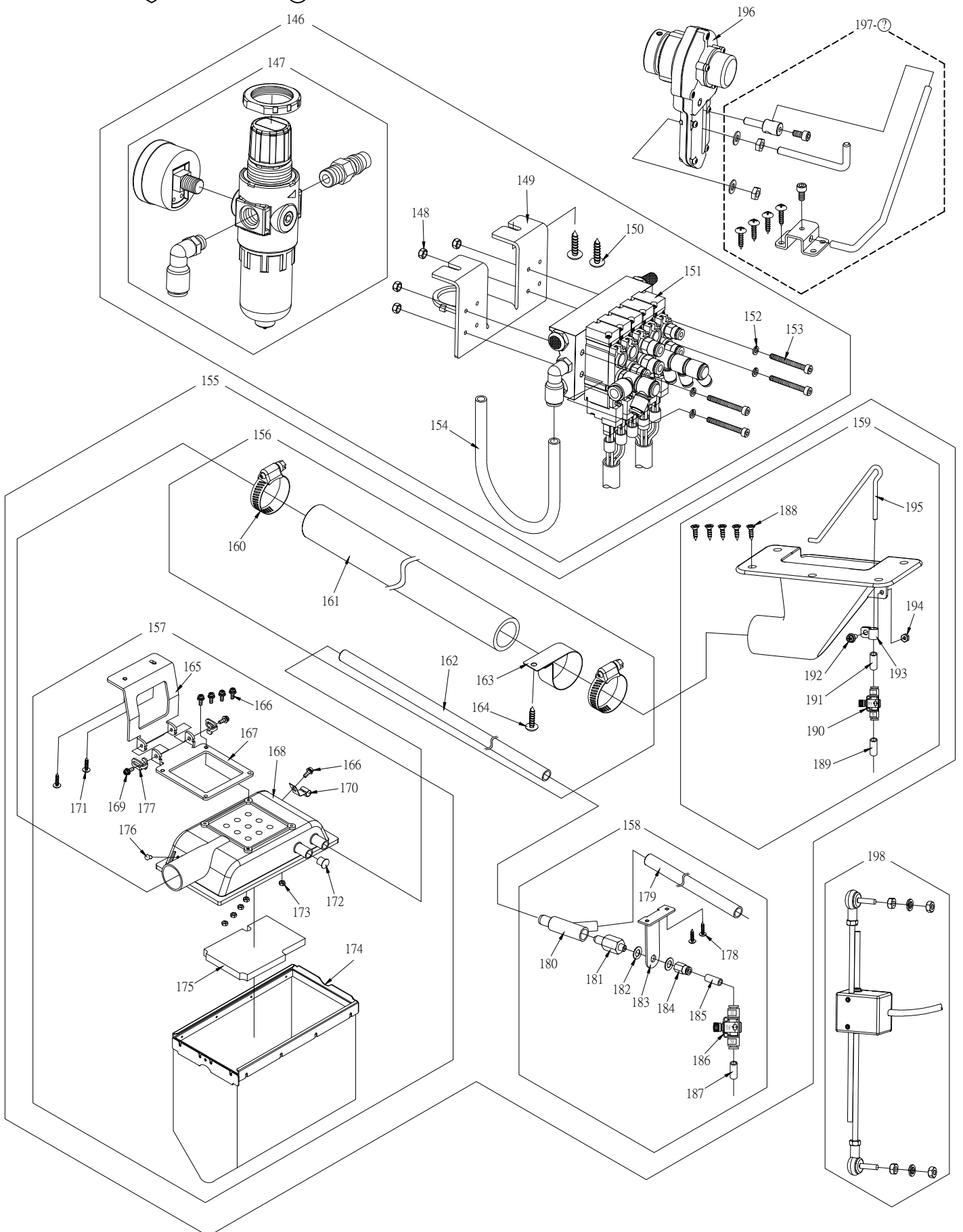
記號說明：  選擇性配件

 選擇性配件請告知針車廠牌型號



MC1-38 送料機零件圖

記號說明：  選擇性配件  選擇性配件請告知針車廠牌型號



MC1-38 送料機零件圖

NO.	訂購碼	用量	說明
1	313PY8031	1	
2	331SS1180	4	M4*0.7P*5L (染黑)
3	313FDDF50	1	
4	313BR4090	2	
5	312PY1061	1	
6	331SS1200	4	M3*0.5P*3L (染黑)
7	313FDD201	1	
8	313FDD261	2	
9	315FDD180	2	
10	33BLS2017	2	
11	315FDD190	2	
12	313FDD310	1	
13	313FDD300	1	
14	331SS1320	5	M4*0.7P*3L (染黑)
15	33BMPC120	1	
16	331SP5160	3	M3*0.5P*6L (鍍銀)
17	313FDDF60	1	
18	312FDD190	1	
19	312PY1051	1	
20	316BT1051	1	(B89MXL) 89齒
21	2MCD3ZSMB09001	1	
22	331SC1340	4	φ8*50L*M4*0.7t*10L
23	313FDDD11	1	
24	331SP1B90	2	M4*0.7P*8L (鍍銀)
25	331HC1270	2	M5*0.8P*20L (染黑)
26	313FDDF70	1	
27	313FDDF80	1	φ6*29L
28	313FDD211	1	
29	33DCLD220	1	ID 25*15
30	2MCD58PLF09005	1	配管標誌 # 42 : # 42
31	2MCD58PLF09004	1	配管標誌 # 41 : # 41
32	33DSPL090	4	φ4 : M5*0.8P外牙
33	313FDDG00	1	
34	331HC1100	1	M5*0.8P*10L (染黑)
35	331SP5091	2	
36	313FDDF81	1	φ6*18L
37	313FDDG10	1	
38	313FDD181	1	
39	313FDDF90	1	
40	332NO5010	2	M5*0.8P*5t (染黑)
41	331SP5101	1	
42	33BWA1190	3	φ16*φ8.2*0.6t (染黑)
43	313FDD431	1	
44	2MCD58PLF09015	1	配管標誌 # 36 : # 36
45	2MCD58PLF09014	1	配管標誌 # 35 : # 35
46	331HC1720	2	M4*0.7P*16L (鍍銀)
47	333WP1500	2	φ12*φ4.35*2t (鍍銀)
48	313FDD251	1	
49	33CHB1030	1	
50	331SP1130	1	M4*0.7P*8L (鍍銀)
51	313FDD421	1	
52	331SN1190	4	M3*0.5P*10L (鍍銀)
53	331SN1140	7	M4*0.7P*10L (鍍銀)
54	313FDD191	1	
55	313FDDG20	1	
56	331SP5170	4	M2*0.4P*5L (鍍銀)
57	331SP2330	2	M2*0.4P*8L (染黑)
58	313FDD171	1	
59	33BLS4020	1	
60	2MCDSPW0021	1	
61	312FDD200	1	
62	331HC1660	2	M3*0.5P*10L (鍍銀)


NO.	訂購碼	用量	說明
63	333WP1060	1	φ8*φ4.8*1t, 橘紅色
64	313FDD401	1	
65	313FDD281	1	
66	313FDD251	1	
67	313BR4080	2	
68	313PY8041	1	
69	333WP1640	1	φ8*φ5.2*0.5t (鍍銀)
70	331SP1530	2	M3*0.5P*4L (鍍銀)
71	313FDD290	2	
72	313BR4020	2	
73	333PK1130	1	
74	313FDDG30	1	
75	313FDDG40	1	
76	331SP5180	2	M2*0.4P*9L (鍍銀)
77	313FDD441	1	
78	331SP5190	1	M3*0.5P*8L (鍍銀)
79	33ZFDD080	1	
80	313FDDG50	1	
81	332NO1400	1	M5*0.8P*4t (染黑)
82	313FDD321	2	
83	324MGU010	1	φ5*1.5t
84	313FDD371	1	
85	33BWA1020	1	φ14.5*φ10.5*2H*0.3t
86	331SP5081	1	
87	331SN1180	1	M5*0.8P*25L (染黑)
88	313FDD24*	1	依不同廠牌型號選用
89	331HC1760	2	M4*0.7P*6L (鍍銀)
90	313FDDG60	1	
91	331SP1930	4	M3*0.5P*8L (鍍銀)
92	2MCD5W030	1	
93	33CHB1050	1	
94	332NO1390	2	M8*1.25P*4.5t (鍍銀)
95	333WP1150	1	φ15*φ8*1t (鍍銀)
96	331SS1370	1	M4*0.7P*6L (染黑)
97	331SS1380	1	M4*0.7P*8L (染黑)
98	331HC1640	4	M6*1.0P*15L (染黑)
99	313FDDG9*	1	依不同廠牌型號選用
100	331HC****	1	依不同廠牌型號選用
101	331HC****	1	依不同廠牌型號選用
102	313FDDG70	1	
103	331SP1980	2	M3*0.5P*45L (鍍銀)
104	33DCUF190	6	
105	331SP1C60	2	M3*0.5P*4L (鍍銀)
106	313FDDG80	2	
107	33DJVA040	3	
108	2MCD58PLF09018	1	配管標誌 # 45 : # 45
109	2MCD58PLF09017	1	配管標誌 # 44 : # 44
110	2MCD58PLF09016	1	配管標誌 # 43 : # 43
111	332NO1340	2	M3*0.5P*2.3t (鍍銀)
112	2MCDPF201*	1	依不同廠牌型號選用
113	2MCDPF202*	1	依不同廠牌型號選用
114	43ZFDD051	2	三線使用
115	43ZFDD050	2	四線使用
116	2MCDTR021	1	
117	313FDDDD60	1	
118	313FDDE10	1	
119	331SP5130	3	M3*0.5P*5L (染黑)
120	333WP1570	2	φ6*φ3.2*0.5t (鍍銀)
121	2MCD58PLF09013	1	配管標誌 # 34 : # 34
122	331SP5120	1	M3*0.5P*8L (染黑)
123	333WP1600	1	φ8*φ4*1t (染黑)
124	33CHB1050	1	


MC1-38 送料機零件圖

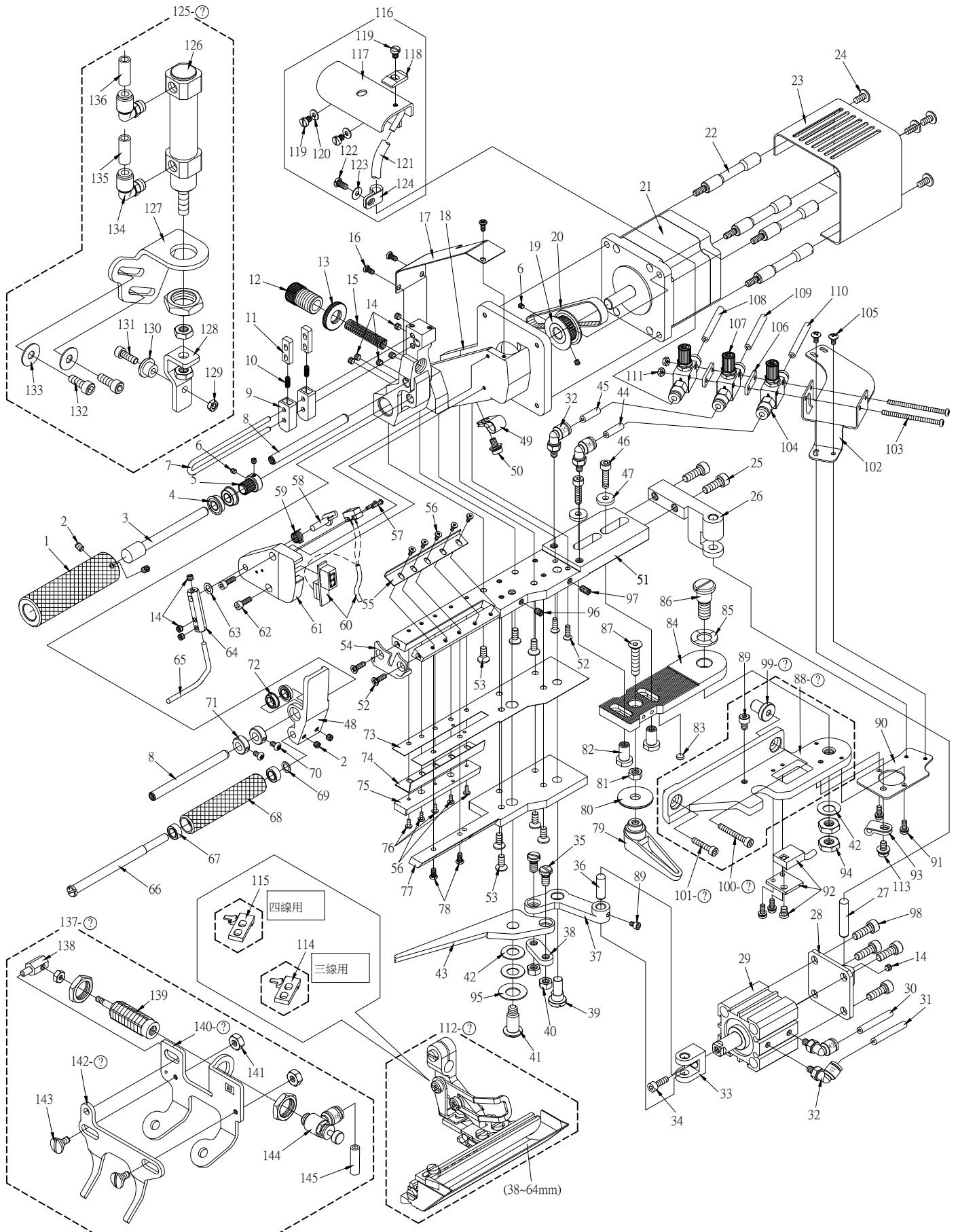
NO.	訂購碼	用量	說明
125	2MCDPF10**	1	依不同廠牌型號選用
126	33DCLD120	1	
127	313SMM260	1	
128	313SMM170	1	
129	332NO5010	1	M5*0.8P*5t (染黑)
130	313SMM190	1	
131	331HC1230	1	M5*0.8P*15L (染黑)
132	331HC1090	2	M6*1.0P*16L (染黑)
133	333WP1130	2	φ19*φ6.7*1t (染黑)
134	33DSPL010	2	
135	2MCD58PLF08012	1	配管標誌 # 46 : # 46
136	2MCD58PLF08013	1	配管標誌 # 47 : # 47
137	2MCDTSY0***	1	依不同廠牌型號選用
138	313FDD140	1	
139	33DCUF180	1	
140	313FDDE3*	1	依不同廠牌型號選用
141	332NO1300	2	M3*0.5P*2.6t (染黑)
142	313FDDE2*	1	依不同廠牌型號選用
143	331SP5110	2	M3*0.5P*8.6L (染黑)
144	33DJSC040	1	
145	2MCD58PLF09009	1	配管標誌 # 48 : # 48
146	2MCD3DAL5S1011A	1	
147	2VDAR04	1	
148	332NO1060	4	M4*0.7P (鍍鋅)
149	313IRF140	1	
150	331ST1100	2	φ4.7*19L (鍍鋅)
151	2MCD3DAL5S1001A	1	
152	334WS1020	4	φ7.1*φ4.1*1t (鍍鋅)
153	331HC1460	4	M4*0.7P*35L (染黑)
154	2MCD58PLF07001	1	
155	2MCDVD7050P02A	1	
156	2MCDACC001	1	
157	2MCDFBA01	1	
158	2MCDVEN002A	1	
159	2MCDFUN002A	1	
160	339HSE030	2	
161	316PT6040	1	L=800mm
162	315PT1020	1	L=800mm
163	339CB1060	1	
164	331ST1100	1	
165	313SMM520	1	
166	331SP1160	5	
167	313SMM530	1	
168	315VDR040	1	
169	331SP1830	2	
170	313SMM155	1	
171	331ST1100	2	
172	33CHY2090	1	
173	332NO1050	5	M4*0.7P*3.2t (鍍鋅)
174	33ZSMD04A	1	
175	35ZSMR230	1	
176	33ZSMN220	1	
177	313SMM540	2	
178	331ST1100	2	
179	315PT1020	1	L=250mm
180	33DALS031	1	
181	33DALS020	1	
182	333WP1180	2	
183	313IRF060	1	
184	33DSQG010	1	
185	2MCD58PLF07005	1	配管標誌 # 10 : # 10
186	33DJVA030	1	配管標誌 # 50 : # 10

NO.	訂購碼	用量	說明
187	2MCD58PLF07006	1	配管標誌 # 50 : # 50
188	331ST1070	5	
189	2MCD58PLF08014	1	配管標誌 # 49 : # 49
190	33DJVA010	1	配管標誌 # 49 : # 37
191	2MCD58PLF08011	1	配管標誌 # 37 : # 37
192	331SP1160	1	
193	33CHB1050	1	
194	332NO1050	1	M4*0.7P*3.2t (鍍鋅)
195	315VDR050	1	
196	2VP11AD00101	1	
197	2VP122009*	1	依不同廠牌型號選用
198	2TCSW020	1	
199	331SP1160	1	M4*0.7P*12L (鍍鋅)



MC1-64 送料機零件圖

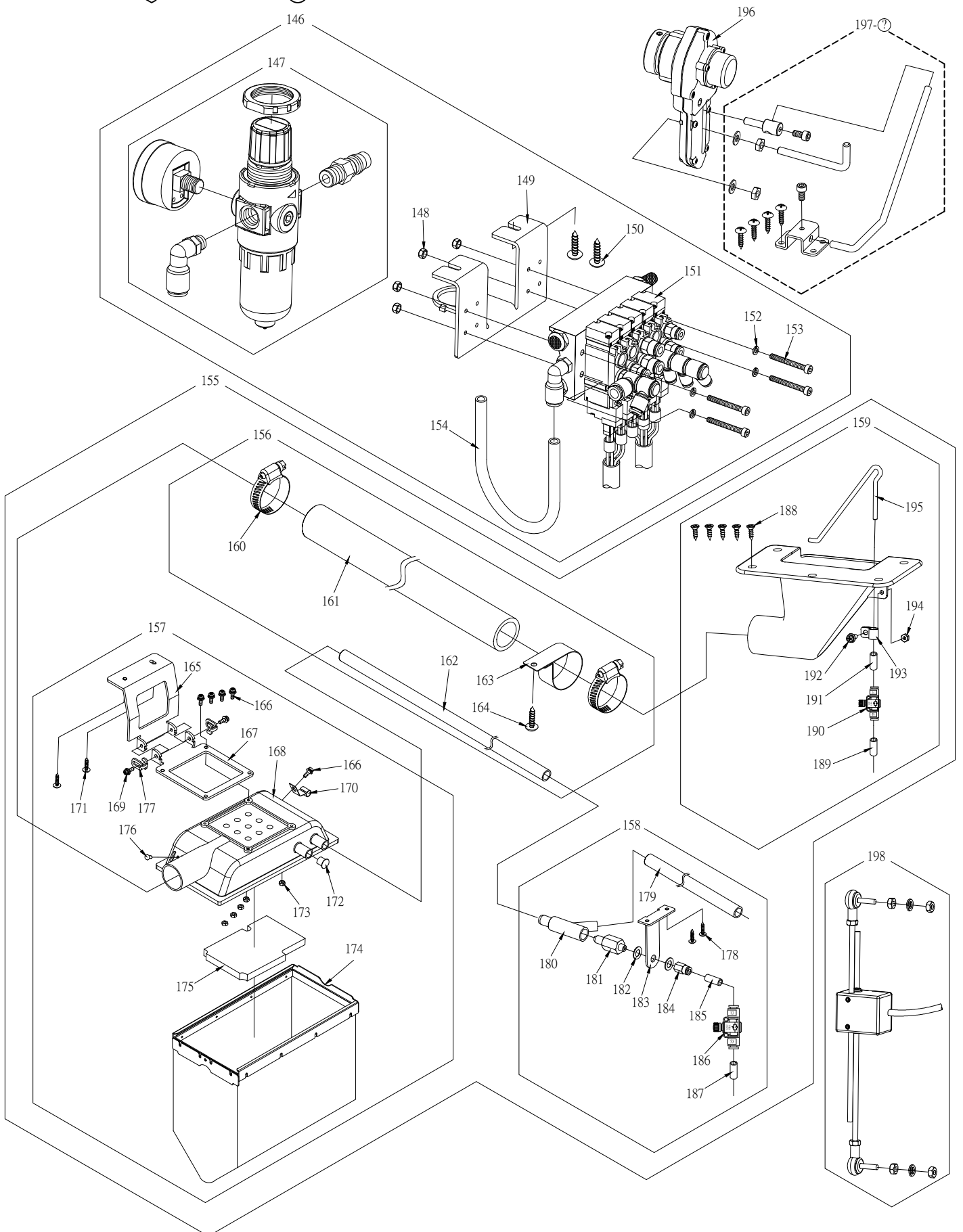
記號說明：  選擇性配件

 選擇性配件請告知針車廠牌型號



MC1-64 送料機零件圖

記號說明：  選擇性配件  選擇性配件請告知針車廠牌型號



MC1-64 送料機零件圖

NO.	訂購碼	用量	說明
1	313PY8032	1	
2	331SS1180	4	M4*0.7P*5L (染黑)
3	313FDDF50	1	
4	313BR4090	2	
5	312PY1061	1	
6	331SS1200	4	M3*0.5P*3L (染黑)
7	313FDD203	1	
8	313FDD262	2	
9	315FDD180	2	
10	33BLS2017	2	
11	315FDD190	2	
12	313FDD310	1	
13	313FDD300	1	
14	331SS1320	5	M4*0.7P*3L (染黑)
15	33BMPC120	1	
16	331SP5160	3	M3*0.5P*6L (鍍銀)
17	313FDDF60	1	
18	312FDD190	1	
19	312PY1051	1	
20	316BT1051	1	(B89MXL) 89齒
21	2MCD3ZSMB09001	1	
22	331SC1340	4	φ8*50L*M4*0.7t*10L
23	313FDDD11	1	
24	331SP1B90	2	M4*0.7P*8L (鍍銀)
25	331HC1270	2	M5*0.8P*20L (染黑)
26	313FDDF70	1	
27	313FDDF80	1	φ6*29L
28	313FDD211	1	
29	33DCLD220	1	ID 25*15
30	2MCD58PLF09005	1	配管標誌 # 42 : # 42
31	2MCD58PLF09004	1	配管標誌 # 41 : # 41
32	33DSPL090	4	φ4 : M5*0.8P外牙
33	313FDDG00	1	
34	331HC1100	1	M5*0.8P*10L (染黑)
35	331SP5091	2	
36	313FDDF81	1	φ6*18L
37	313FDDG10	1	
38	313FDD181	1	
39	313FDDF90	1	
40	332NO5010	2	M5*0.8P*5t (染黑)
41	331SP5101	1	
42	33BWA1190	3	φ16*φ8.2*0.6t (染黑)
43	313FDD432	1	
44	2MCD58PLF09015	1	配管標誌 # 36 : # 36
45	2MCD58PLF09014	1	配管標誌 # 35 : # 35
46	331HC1720	2	M4*0.7P*16L (鍍銀)
47	333WP1500	2	φ12*φ4.35*2t (鍍銀)
48	313FDD251	1	
49	33CHB1030	1	
50	331SP1130	1	M4*0.7P*8L (鍍銀)
51	313FDD422	1	
52	331SN1190	4	M3*0.5P*10L (鍍銀)
53	331SN1140	7	M4*0.7P*10L (鍍銀)
54	313FDD191	1	
55	313FDDG21	1	
56	331SP5170	7	M2*0.4P*5L (鍍銀)
57	331SP2330	2	M2*0.4P*8L (染黑)
58	313FDD171	1	
59	33BLS4020	1	
60	2MCDSPW0021	1	
61	312FDD200	1	
62	331HC1660	2	M3*0.5P*10L (鍍銀)

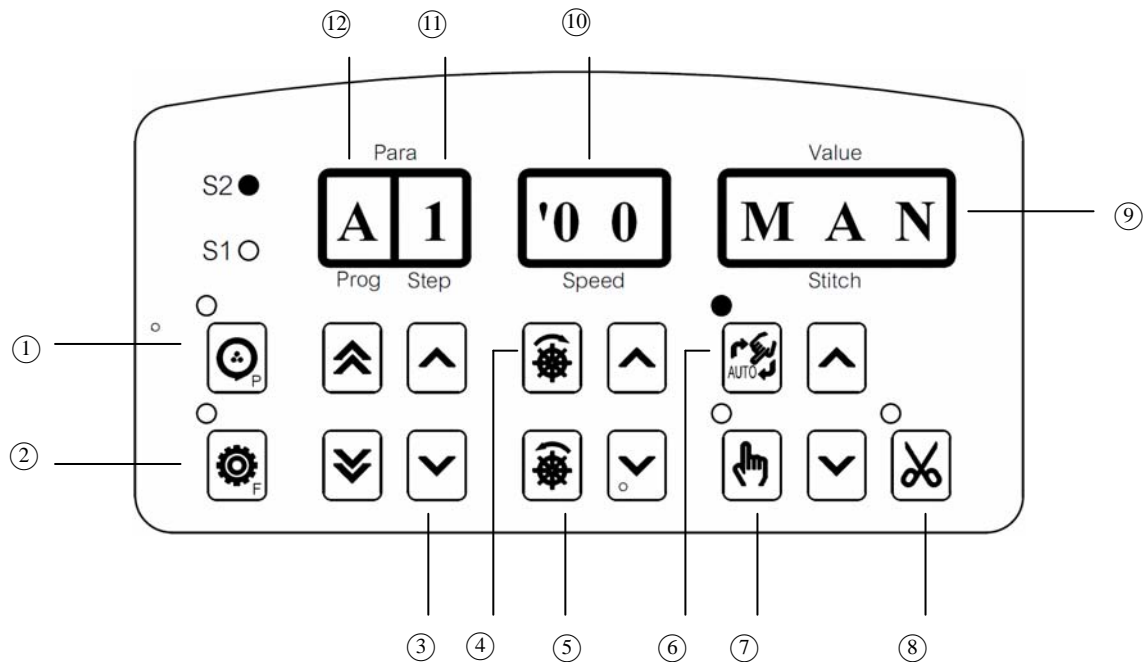
NO.	訂購碼	用量	說明
63	333WP1060	1	φ8*φ4.8*1t, 橘紅色
64	313FDD401	1	
65	313FDD281	1	
66	313FDD252	1	
67	313BR4080	2	
68	313PY8042	1	
69	333WP1640	1	φ8*φ5.2*0.5t (鍍銀)
70	331SP1530	2	M3*0.5P*4L (鍍銀)
71	313FDD290	2	
72	313BR4020	2	
73	333PK1131	1	
74	313FDDG31	1	
75	313FDDG41	1	
76	331SP5180	3	M2*0.4P*9L (鍍銀)
77	313FDD442	1	
78	331SP5190	2	M3*0.5P*8L (鍍銀)
79	33ZFDD080	1	
80	313FDDG50	1	
81	332NO1400	1	M5*0.8P*4t (染黑)
82	313FDD321	2	
83	324MGU010	1	φ5*1.5t
84	313FDD371	1	
85	33BWA1020	1	φ14.5*φ10.5*2H*0.3t
86	331SP5081	1	
87	331SN1180	1	M5*0.8P*25L (染黑)
88	313FDD24*	1	依不同廠牌型號選用
89	331HC1760	2	M4*0.7P*6L (鍍銀)
90	313FDDG60	1	
91	331SP1930	4	M3*0.5P*8L (鍍銀)
92	2MCD5W030	1	
93	33CHB1050	1	
94	332NO1390	2	M8*1.25P*4.5t (鍍銀)
95	333WP1150	1	φ15*φ8*1t (鍍銀)
96	331SS1370	1	M4*0.7P*6L (染黑)
97	331SS1380	1	M4*0.7P*8L (染黑)
98	331HC1640	4	M6*1.0P*15L (染黑)
99	313FDDG9*	1	依不同廠牌型號選用
100	331HC****	1	依不同廠牌型號選用
101	331HC****	1	依不同廠牌型號選用
102	313FDDG70	1	
103	331SP1980	2	M3*0.5P*45L (鍍銀)
104	33DCUF190	6	
105	331SP1C60	2	M3*0.5P*4L (鍍銀)
106	313FDDG80	2	
107	33DJVA040	3	
108	2MCD58PLF09018	1	配管標誌 # 45 : # 45
109	2MCD58PLF09017	1	配管標誌 # 44 : # 44
110	2MCD58PLF09016	1	配管標誌 # 43 : # 43
111	332NO1340	2	M3*0.5P*2.3t (鍍銀)
112	2MCDPF204*	1	依不同廠牌型號選用
113	331SP1160	1	M4*0.7P*12L (鍍銀)
114	43ZFDD051	2	三線使用
115	43ZFDD050	2	四線使用
116	2MCDTR021	1	
117	313FDDD60	1	
118	313FDDE10	1	
119	331SP5130	3	M3*0.5P*5L (染黑)
120	333WP1570	2	φ6*φ3.2*0.5t (鍍銀)
121	2MCD58PLF09013	1	配管標誌 # 34 : # 34
122	331SP5120	1	M3*0.5P*8L (染黑)
123	333WP1600	1	φ8*φ4*1t (染黑)
124	33CHB1050	1	


MC1-64 送料機零件圖

NO.	訂購碼	用量	說明
125	2MCDPF10**	1	依不同廠牌型號選用
126	33DCLD120	1	
127	313SMM260	1	
128	313SMM170	1	
129	332NO5010	1	M5*0.8P*5t (染黑)
130	313SMM190	1	
131	331HC1230	1	M5*0.8P*15L (染黑)
132	331HC1090	2	M6*1.0P*16L (染黑)
133	333WP1130	2	φ19*φ6.7*1t (染黑)
134	33DSPL010	2	
135	2MCD58PLF08012	1	配管標誌 # 46 : # 46
136	2MCD58PLF08013	1	配管標誌 # 47 : # 47
137	2MCDTSY0***	1	依不同廠牌型號選用
138	313FDD140	1	
139	33DCUF180	1	
140	313FDDE3*	1	依不同廠牌型號選用
141	332NO1300	2	M3*0.5P*2.6t (染黑)
142	313FDDE2*	1	依不同廠牌型號選用
143	331SP5110	2	M3*0.5P*8.6L (染黑)
144	33DJSC040	1	
145	2MCD58PLF09009	1	配管標誌 # 48 : # 48
146	2MCD3DAL5S1011A	1	
147	2VDAR04	1	
148	332NO1060	4	M4*0.7P (鍍鋅)
149	313IRF140	1	
150	331ST1100	2	φ4.7*19L (鍍鋅)
151	2MCD3DAL5S1001A	1	
152	334WS1020	4	φ7.1*φ4.1*1t (鍍鋅)
153	331HC1460	4	M4*0.7P*35L (染黑)
154	2MCD58PLF07001	1	
155	2MCDVD7050P02A	1	
156	2MCDACC001	1	
157	2MCDFBA01	1	
158	2MCDVEN002A	1	
159	2MCDFUN002A	1	
160	339HSE030	2	
161	316PT6040	1	L=800mm
162	315PT1020	1	L=800mm
163	339CB1060	1	
164	331ST1100	1	
165	313SMM520	1	
166	331SP1160	5	
167	313SMM530	1	
168	315VDR040	1	
169	331SP1830	2	
170	313SMM155	1	
171	331ST1100	2	
172	33CHY2090	1	
173	332NO1050	5	M4*0.7P*3.2t (鍍鋅)
174	33ZSMD04A	1	
175	35ZSMR230	1	
176	33ZSMN220	1	
177	313SMM540	2	
178	331ST1100	2	
179	315PT1020	1	L=250mm
180	33DALS031	1	
181	33DALS020	1	
182	333WP1180	2	
183	313IRF060	1	
184	33DSQG010	1	
185	2MCD58PLF07005	1	配管標誌 # 10 : # 10
186	33DJVA030	1	配管標誌 # 50 : # 10


NO.	訂購碼	用量	說明
187	2MCD58PLF07006	1	配管標誌 # 50 : # 50
188	331ST1070	5	
189	2MCD58PLF08014	1	配管標誌 # 49 : # 49
190	33DJVA010	1	配管標誌 # 49 : # 37
191	2MCD58PLF08011	1	配管標誌 # 37 : # 37
192	331SP1160	1	
193	33CHB1050	1	
194	332NO1050	1	M4*0.7P*3.2t (鍍鋅)
195	315VDR050	1	
196	2VP11AD00101	1	
197	2VP122009*	1	依不同廠牌型號選用
198	2TCSW020	1	

IV. 縫製畫面功能說明



- ①  進入到編輯畫面鍵

說明：按此鍵，會切換到編輯畫面，進入後則可依實際需求進行相關設定

- ②  進入到參數設定畫面鍵

說明：按此鍵，會切換到參數設定畫面，進入後則可依實際需求進行相關設定

- ③  工程段數切換按鍵


說明：切換工程段數用，工程段數最多可設定 19 段

- ④  送料鍵


說明：按此鍵不放開，正轉送料用步進馬達運轉，按鍵離開後步進馬達停止運轉。

- ⑤  退料鍵

說明：按此鍵不放開，反轉送料用步進馬達運轉，按鍵離開後步進馬達停止運轉。


- ⑥  顯示該工程段數為自動車縫模式或手動車縫模式 /

說明：


-  LED ON 為自動，LED OFF 為手動

自動:設定針數累計到達時依序進入下一工程段數


“MAN”(手動):用手動開關進入下一工程段數

- ⑦  針數/換段修正切換鍵

說明：切換每一 Step 之設定針數/換段修正值。


-  LED ON 顯示目前車縫針數，LED OFF 顯示設定針數/換段修正值
- 換段修正：補償換段時鬆緊帶產生緩衝段的誤差
- 當 Stitch 欄顯示“XXX.”時，XXX 值為換段修正值，範圍為 0~99

- ⑧  切線顯示

說明： LED ON 此段結束時有切線動作，LED OFF 此段結束時無切線動作

- ⑨  針數/換段修正值顯示器


說明：顯示每一 Step 之換段修正值/設定針數。

- ⑩  送料速度(送布量)表示

說明：顯示每針的送料速度，送料速度範圍為 0~180

- ⑪  縫製段數表示

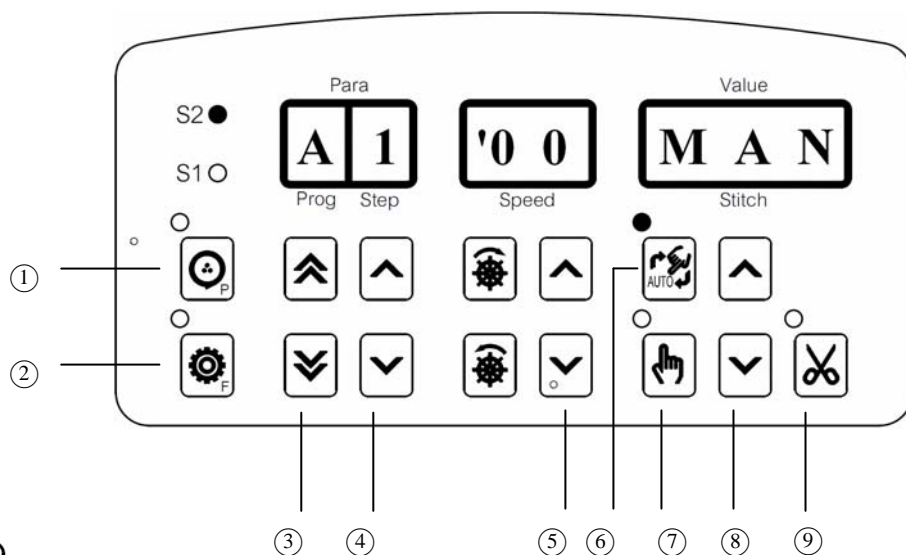
說明：每個工程模式各有 19 個工程段數可供設定

- ⑫  縫製資料區表示

說明：顯示目前選用的工程模式,最多可儲存 23 組(A~)不同工程內容的資料

V. 編輯畫面功能說明

◎縫製畫面下按  鍵 LED 亮進入編輯畫面



①  返回鍵

說明：返回縫製畫面

②  設定工程結束

說明：可設定兩種工程結束的模式,如下:

End: 工程結束時自動切線

Cont: 工程結束時不切線,並自動返回 Step01.

③  工程模式切換按鍵

說明：工程模式存放區共 23 組(A ~ Z)，依實際需求選擇適當之存放區

④  工程段數切換按鍵

說明：切換工程段數用，工程段數最多可設定 19 段


⑤   設定送料速度

說明：

每針送料長度的設定，以下是送料量的對照表。

MC 專用

速度	送料長度(mm)	速度	送料長度(mm)
0	0.00	100	2.33
10	0.23	110	2.57
20	0.47	120	2.80
30	0.70	130	3.03
40	0.93	140	3.27
50	1.17	150	3.50
60	1.40	160	3.73
70	1.63	170	3.97
80	1.87	180	4.2
90	2.10		

⑥  設定該工程段數為自動車縫模式或手動車縫模式 /

說明：


○



LED ON 為自動，LED OFF 為手動

自動:設定針數累計到達時依序進入下一工程段數

“MAN”(手動):用手動開關進入下一工程段數

⑦  針數/換段修正切換/載入針數鍵

說明：切換每一 Step 之設定針數/換段修正值/載入針數。

○



LED ON 載入針數，LED OFF 設定針數/換段修正值

⑧   設定車縫針數/換段修正值/載入針數

說明：依需求設定針數/換段修正值/載入針數

當  LED ON :

在試縫完成後可將針數作為該工程的針數設定(注意!原針數會被覆蓋掉):

當  LED OFF :

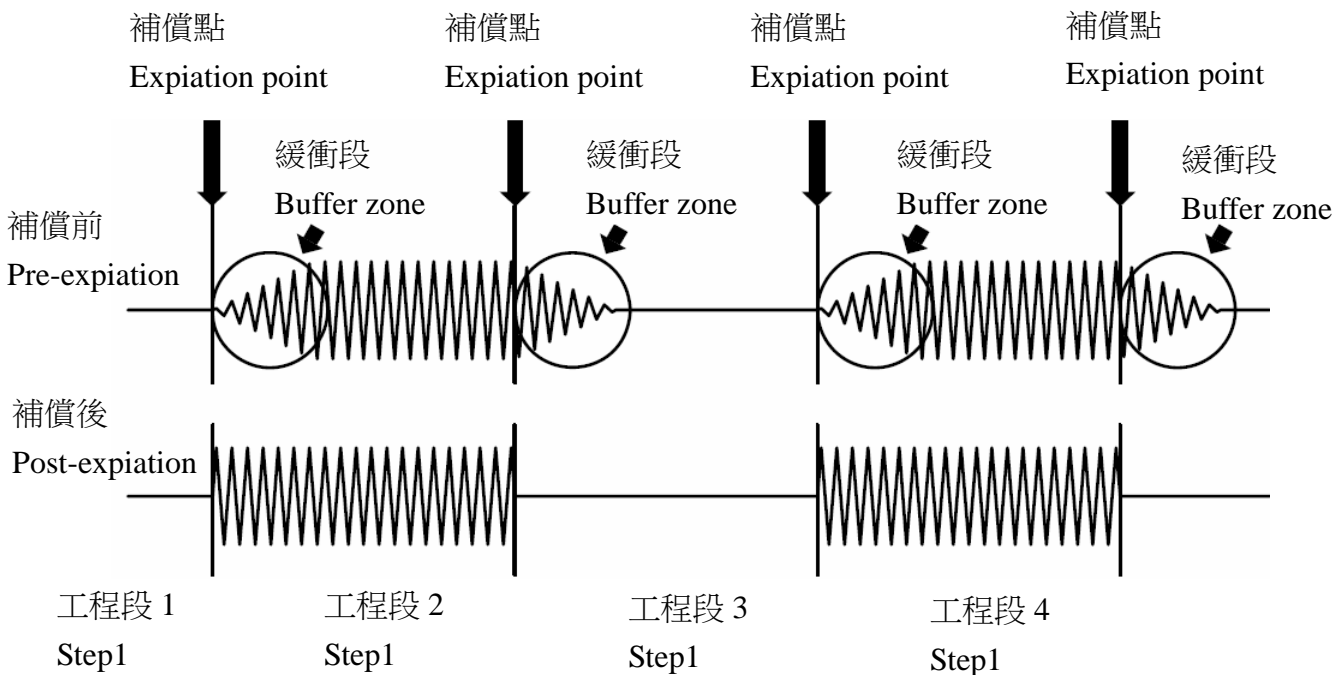
Stitch 欄顯示“XXX”時，XXX 值為設定的每段針數。

Stitch 欄顯示“XXX.”時，XXX 值為設定的換段修正值，為解決在多段車縫過程中，變換不同工程段落時，鬆緊帶將會產生緩衝段的誤差，可借由此功能來回拉或補償緩衝段的誤差。

修正方式

- A. 工程段 1 換到工程段 2 時由工程段 1 修正。
- B. 工程段 2 換到工程段 3 時由工程段 2 修正。
- C. 工程段到最後一段返回工程 1 時由最後一段修正。

註:鬆緊帶修正值 0=0mm，每增加 1 為 0.35mm。(回拉或補償自動判斷)

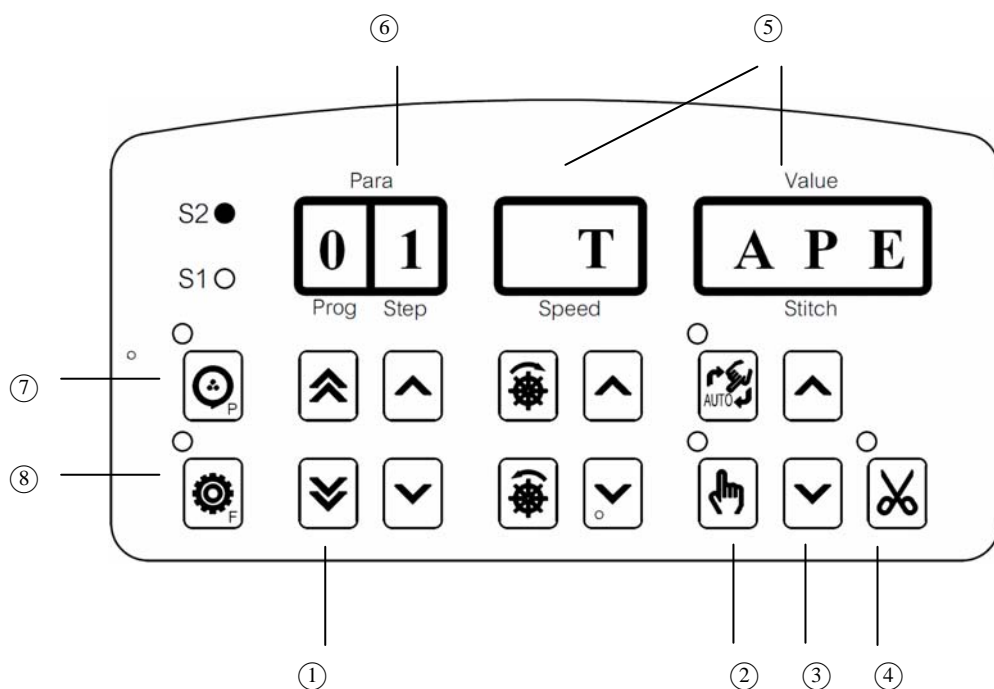




⑨  設定切線模式

說明：按下此鍵後，此鍵的 LED ON，表示此工程段縫製結束後會自動做切線動作。


VI. 參數設定畫面功能說明

◎縫製畫面下按  鍵 LED 亮進入參數設定畫面



①   參數資料 "上 / 下" 按鍵

說明：每按一次，"上 / 下"移動一筆參數

②  參數資料值顯示鍵 /

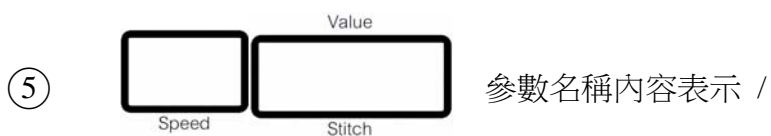
說明：按住可顯示該參數資料值


③   設定參數值


說明：設定參數值用

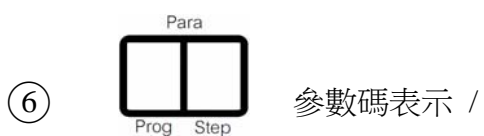
④  參數名稱顯示鍵 /

說明：在參數資料值設定完，按下後返回上一層顯示參數名稱



說明：按住  時，顯示該參數的內容

按下  時，顯示該參數的內容，並進入參數內容值調整



說明：參數共有 64 個



說明：在顯示參數名稱的情況下，按下後返回縫製畫面



說明：按第一次進參數設定畫面，在參數設定畫面再按一次為進入參數內容值調整

參數內容 1/2

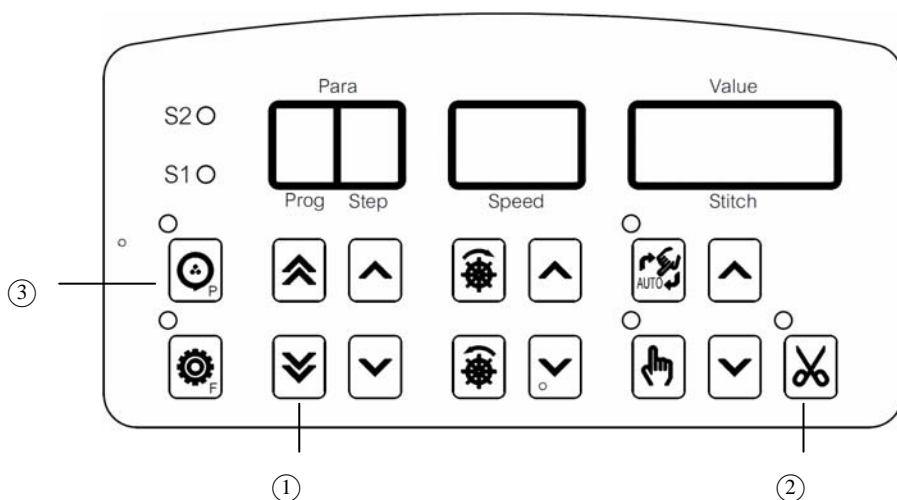
參數編號	參數名稱	參數值	範圍	參數說明																																																																		
01	tape	10	0~99	送帶長度 00=35mm, increases 1=1mm,99=134mm																																																																		
02	sp	50	0~99	送帶速度設定 00=50mm,increase =1.9mm,99=238.1mm																																																																		
03	in_tr	0	0~99	送料後回拉長度設定 00=0mm,每增加 1=0.35mm,99=34mm																																																																		
04	cut_t	15	0~99	切刀時間設定 00=0.1 秒,每增加 1=0.005 秒,99=0.6 秒																																																																		
05	cut_s	15	0~99	切刀後繼續車縫的針數																																																																		
06	foot	0	1 / 0	縫製完畢後壓腳自動提升或不自動提升的選擇 on - 1 / off - 0																																																																		
07	v_off	10	0~99	始縫時停止吸線頭的針數																																																																		
12	Sp_co	0	0~9	<p>送料補償:因車速不同所造成的送帶誤差(車速愈快針目會愈大)</p> <table border="1"> <thead> <tr> <th>轉速 rpm \ 補償值 value</th> <th>300</th> <th>400</th> <th>500</th> <th>600</th> <th>7000</th> </tr> </thead> <tbody> <tr> <td>*0</td> <td>00</td> <td>00</td> <td>00</td> <td>00</td> <td>00</td> </tr> <tr> <td>1</td> <td>00</td> <td>00</td> <td>02</td> <td>02</td> <td>02</td> </tr> <tr> <td>2</td> <td>00</td> <td>00</td> <td>02</td> <td>02</td> <td>03</td> </tr> <tr> <td>3</td> <td>00</td> <td>02</td> <td>02</td> <td>02</td> <td>03</td> </tr> <tr> <td>4</td> <td>00</td> <td>02</td> <td>02</td> <td>03</td> <td>03</td> </tr> <tr> <td>5</td> <td>00</td> <td>02</td> <td>03</td> <td>03</td> <td>04</td> </tr> <tr> <td>6</td> <td>02</td> <td>03</td> <td>04</td> <td>05</td> <td>07</td> </tr> <tr> <td>7</td> <td>02</td> <td>04</td> <td>07</td> <td>09</td> <td>12</td> </tr> <tr> <td>8</td> <td>02</td> <td>05</td> <td>09</td> <td>13</td> <td>17</td> </tr> <tr> <td>9</td> <td>02</td> <td>05</td> <td>10</td> <td>14</td> <td>17</td> </tr> </tbody> </table>	轉速 rpm \ 補償值 value	300	400	500	600	7000	*0	00	00	00	00	00	1	00	00	02	02	02	2	00	00	02	02	03	3	00	02	02	02	03	4	00	02	02	03	03	5	00	02	03	03	04	6	02	03	04	05	07	7	02	04	07	09	12	8	02	05	09	13	17	9	02	05	10	14	17
轉速 rpm \ 補償值 value	300	400	500	600	7000																																																																	
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1	00	00	02	02	02																																																																	
2	00	00	02	02	03																																																																	
3	00	02	02	02	03																																																																	
4	00	02	02	03	03																																																																	
5	00	02	03	03	04																																																																	
6	02	03	04	05	07																																																																	
7	02	04	07	09	12																																																																	
8	02	05	09	13	17																																																																	
9	02	05	10	14	17																																																																	



參數內容 2/2

參數編號	參數名稱	參數值	範圍	參數說明
17	sf_sw	3	0/1/2/3	安全開關型態: 0:常開式 1:常閉式 2:常閉式,但安全開關打開時可當一般拷克車使用 3:禁用安全開關
18	rest	0	1/0	參數切換到 run 時可回復出廠設定值 (需重新開機) no - 0 / run - 0
30	knee	1	0/1/2/3/4	膝蓋開關功能切換: 0: 無效 1: 控制 MC 切刀 2: 控制 ME 切刀 3: 切換工程段數 4: 抬壓腳
31	ext	3	0/1/2/3/4	外部開關功能切換: 0: 無效 1: 控制 MC 切刀 2: 控制 ME 切刀 3: 切換工程段數 4: 抬壓腳
34	psd	0	0/2/3	車頭型態: 0: MC 拷克車用 2: ME 用,啟縫時不偵測布 3: ME 用,啟縫時不偵測布;使用'A'自動模式前必須先安裝光檢知器
35	psd_t	0	0 / 1	切換不同型態感測器: 0:感測器型號 a 1:感測器型號 b
39	MC_ra	1	0 / 1	MC Device 齒輪比
40	PI_mo	0	0 / 1	壓腳抬起時的吹帶功能開關 0:啟動 1:關閉
41	smdir	0	0 / 1	切換送料馬達正反轉(cw - 0 / ccw - 1)
42	smcw	3	0~3	馬達送料速度
43	smccw	3	0~3	馬達退料速度
44	zig	0	-100%~100%	回縫時，步進馬達逆送量的比例
45	s_con	0	0 ~ 9999	縫製計數器

VII. 測試畫面功能說明

◎在縫製畫面下依序按  →  →  →  →  後將會進入測試畫面：




①   測試參數資料 "上 / 下 " 按鍵 /

說明：選擇要測試的項目

②  測試鍵

說明：按此鍵，執行所選擇的測試項目

③  返回鍵

說明：返回縫製畫面

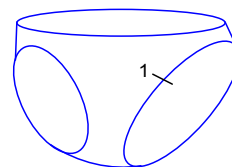
測試參數內容


參數名稱	參數說明
Foot	押腳功能測試
Cut1	MC 剪線功能測試鍵
Tension	鬆線功能測試
Vacuu	後吸功能測試鍵
Blow	前吸功能測試鍵
Buzzer	鳴器測試鍵
Cut2	ME 剪線功能測試鍵
Stm	步進馬達功能測試鍵
Aotorun	步進馬達自動運轉測試 - 長時間
Aototur	步進馬達自動運轉測試 - 圈數運轉

VIII. 操作說明


◎MC(送料裝置+拷克車)操作前請先確認參數 34(psd on-off)必須設定為 off,以確保裝置能正常運作
MC 範例 1.單一工程段數車縫內衣的單一開口,手動切線,送料速度 55

Step	Speed	Stitch
01	55	MAN



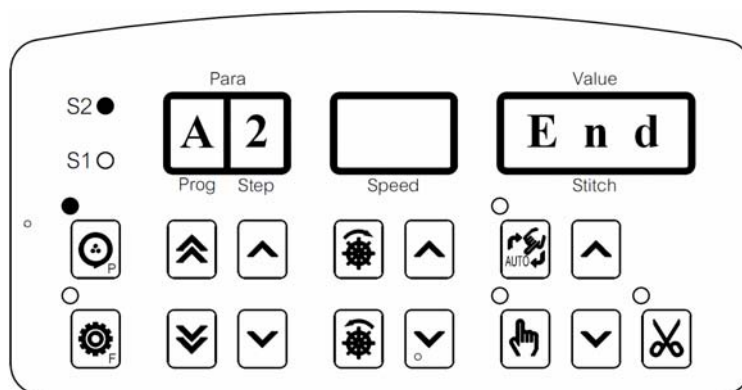
步驟 1.在縫製畫面按下  進入到編輯畫面


步驟 2. 將 Step 1 的 Speed 欄設定為 55

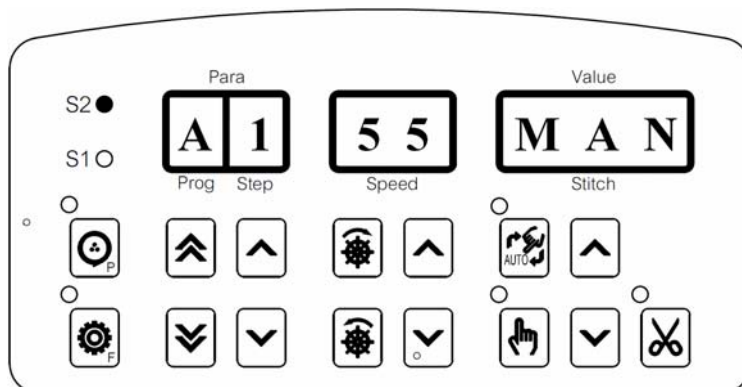
步驟 3. 按  鍵 LED OFF，Step 1 的 Stitch 欄設定為”MAN”

步驟 4. 確認 Step 2 的 Speed 欄設定為空白 Stitch 欄為”end”,若 Step 2 的 Stitch 欄不是”end”,則

跳至 Step 2,再按  鍵設定 Stitch 欄為”end”,如下圖:

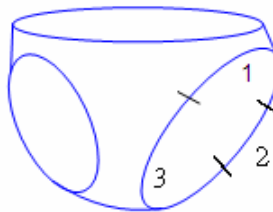


步驟 5.按返回鍵  回縫製畫面即可,設定完成後畫面如下:



MC 範例 2. 車縫內衣的單一開口,設定 3 個工程段數,1,2 段為自動模式,第 3 段手動模式

Step	Speed	Stitch	Correction
01	80	125	50.
02	30	55	20.
03	50	MAN	0



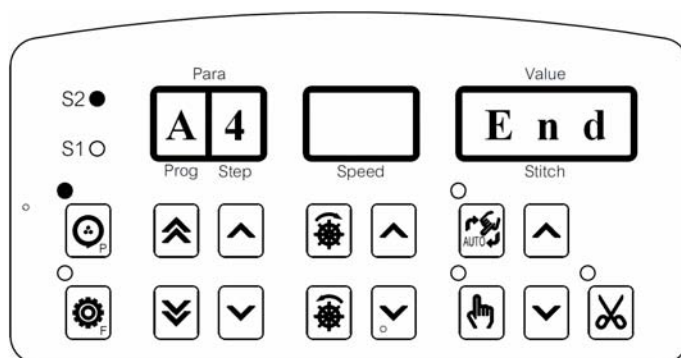
步驟 1. 在縫製畫面按下  進入到編輯畫面


步驟 2. 將 Step 1 的 Speed 欄設為 80, Stitch 欄設為 125, 按下  LED OFF 且 Stitch 欄個位數出現 ., 將 Stitch 欄設為 50.

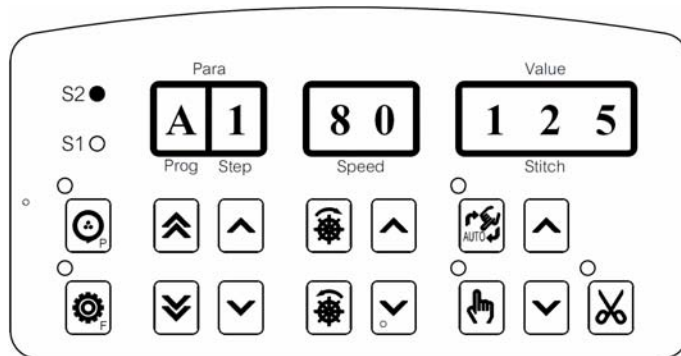
步驟 3. 將 Step 2 的 Speed 欄設為 30, Stitch 欄設為 20., 按下  LED OFF 且 Stitch 欄個位數無 ., Stitch 欄設為 55

步驟 4. 將 Step 3 的 Speed 欄設為 50, 按  鍵 LED OFF 將 Step 03 的 Stitch 欄設為”MAN”.

步驟 5. 確認 Step 4 的 Stitch 欄設定為”end”, 若 Step 4 的 Speed 欄不是”end”, 再按  鍵設定 Stitch 欄為”end”, 如下圖:

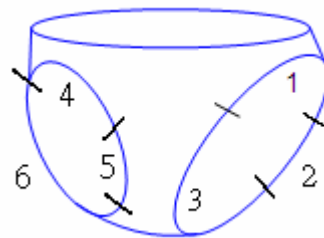


步驟 6. 按返回鍵  回縫製畫面即可, 設定完成後畫面如下:




MC 範例 3.車縫兩個開口的內衣,設定 6 個工程段數,1,2 段為自動模式,第 3 段手動切線,第 4,5 段為自動模式,第 6 段為手動切線

Step	Speed	Stitch	Correction
01	80	125	50.
02	30	55	20.
03	50	MAN	20.
04	70	50	40.
05	30	75	40.
06	70	MAN	



步驟 1.在縫製畫面按下  進入到編輯畫面

步驟 2. 將 Step 1 的 Speed 欄設為 80, Stitch 欄設為 125, 按下  LED OFF 且 Stitch 欄個位數出現 .,將 Stitch 欄設為 50.

步驟 3. 將 Step 2 的 Speed 欄設為 30, Stitch 欄設為 20., 按下  LED OFF 且 Stitch 欄個位數無 ., Stitch 欄設為 55


步驟 4. 將 Step 3 的 Speed 欄設定為 50,按  LED OFF,將 Step 3 的 Stitch 欄設定為”MAN”,
並且按  LED ON,設定為切線模式, 按下  LED OFF 且 Stitch 欄個位數出現 ., 將 Stitch 欄設為 20.

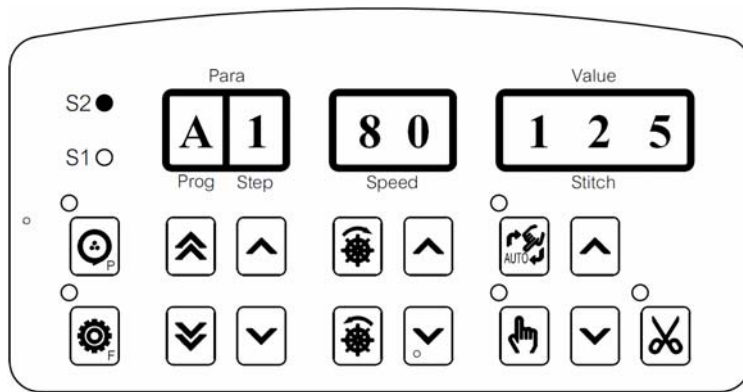
步驟 5. 將 Step 4 的 Speed 欄設為 70, Stitch 欄設為 40., 按下  LED OFF 且 Stitch 欄個位數無 ., Stitch 欄設為 50

步驟 6. 將 Step 5 的 Speed 欄設為 30, Stitch 欄設為 75, 按下  LED OFF 且 Stitch 欄個位數出現 .,將 Stitch 欄設為 40.

步驟 7. 將 Step 6 的 Speed 欄設為 70, 按  LED OFF,將 Step 6 的 Stitch 欄設為”MAN”

步驟 8. 確認 Step 7 的 Stitch 欄設定為”end”,若 Step 7 的 Speed 欄不是”end”,再按  鍵設定 Stitch 欄為”end”.

步驟 9. 按返回鍵  回縫製畫面即可,設定完成後畫面如下:



IX. 提示代碼和錯誤代碼

操作盒用:

提示代碼	訊息	說明
E098	successfully saved	出廠參數值儲存成功
E099	please reboot	已回復出廠參數值,請重啟電源

操作盒用:

錯誤代碼	訊息	說明
E000	SAFETY LOCK-ON	安全開關安裝錯誤,請檢查安全開關或參數 17
E100	No response from front panel	操作盒和控制箱無法互相通信,請檢查操作盒的連接線是否插好或插錯接口。

控制箱用:

錯誤代碼	故障原因	說明
ER0.9	<ol style="list-style-type: none">1. 車頭線圈(或氣壓閥)短路時。2. 驅動車頭氣壓閥之功率電晶體迴路有故障。	<p>車頭出力與操作盒之定針式樣縫製功能將全部關閉對無效。</p> <p>請檢查氣壓閥之迴路是否短路。</p> <p>請檢查主基板組之各功率驅動電晶體是否故障。</p>

Content

I. Safety Precaution	1
II. Power Connection and Grounding.....	3
III. Control Box Installation.....	4
IV. Function for sewing	22
V. Editing.....	24
VI. Parameter setting mode.....	27
VII. Function test mode.....	31
VIII.Operation.....	32
IX. Tip Code list and Error Code list	35

I. Safety Precaution

Please read this manual carefully , also with related manual for the machine head before use. For perfect operation and safety, installing and operating this product by trained personnel is required.

When install and operate MC control box, precaution must be taken as the following.

This product is designed for specify sewing machines and must not be used for other purposes.

1.1 Work Environment :

(1). Power voltage:

Only use Power Voltage indicated on the name plate of the Feeder in $\pm 10\%$ ranges.

(2). Electromagnetic pulse interference:

To avoid the false operate, please keep the product away from the high electromagnetic machinery or electro pulse generator.

(3). Temperature:

a. Please don't operate in room temperature is above 45°C or under 5°C

b. Avoid operating in direct sun light or outdoors area.

c. Avoid operating near the heater.

d. Avoid operating in the area which humidity is 30% or less and 95% or more, also keep away dew area.

(4). Atmosphere:

a. Avoid operating in dusty area, and stay away from corrosive material.

b. Avoid operating in evaporate or combustible gas area.

1.2 Safety In Installation :

(1). Control box: Follow the instruction in this manual for correct installation.

(2). Accessories: Turn off the power and unplug the cord before mounting any accessories.

(3). Power cord:

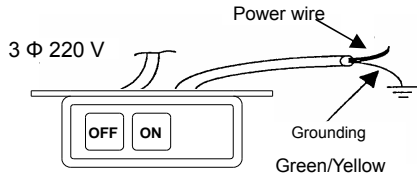
a. Avoid power cord being applied by heavy objects or excessive force, or over bend.


b. Power cord must not set to be near the V-belt and the pulley, keep 3 cm space or above.

c. Check the outlet voltage before plugging the cord, make sure it match the voltage shown on the name plate of the Feeder in $\pm 10\%$ ranges.

※ Attention : If the control box is AC 220V system, please don't connect to the AC 380V power outlet. If that happened, please turn off the power switch immediately and check the power voltage. Continue supply the 380V power over 5 minutes might damage the fuses (F1,F2) and burst the electrolytic capacitors (C3,C4) of the main board and even might endanger the person safety.







Ground Wire (Green/Yellow) must be grounding.
 Properly current leakage cause uncomfortable
 Even hurt the body if not grounding

(4). Grounding:

- a. To avoid the static interference and current leakage, all grounding must be done.
- b. Use the correct connector and extension wire when connecting ground wire to Earth and secure it tightly.

1.3 Safety In Operating :

- (1). When turn on the machine in the first time, use low speed to operate and check the correct rotation direction.
- (2). During machine operation, don't touch any moving parts.
- (3). All moving parts must use the protective device to avoid the body contact and objects insertion.

1.4 Safety in Maintenance and Repairs :

Power must be turned off first, when:

- (1).Uninstall the motor or the control box, or plug and unplug any connector.
- (2).Turn off the power and wait 10 minutes before opening box cover.
- (3).Repairing or doing any mechanical adjustment.
- (4).Machines rest.

1.5 Regulation in Maintenance and Repairs :

- (1).Maintenance and Repairs must be done by specially trained personnel.
- (2).Don't use any objects or force to hit or ram the product.
- (3).All spare parts for repair must be approved or supplied by the manufacturer.

1.6 Danger and Caution Signs :



Risks that may cause personal injury or risk to the machine are marked with this symbol in the instruction manual.



This symbol indicates electrical risks and warnings.

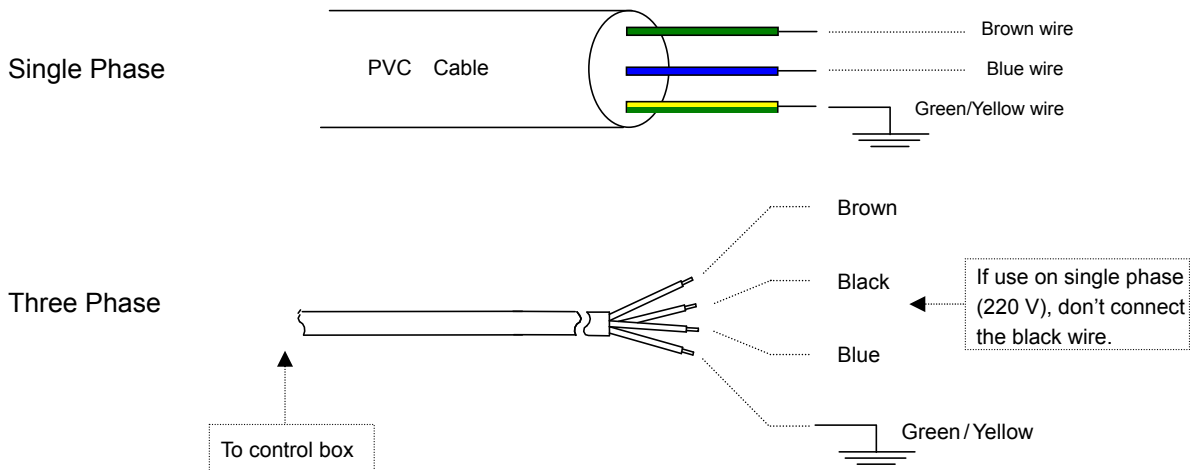
1.7 Warranty Information :

Manufacturer provide a warranty in respect of the products covered for a period of 1 year use or 1 year and 6 months after the shipping date of the products for any defects arising in the normal course of use of the products by customers.

II. Power Connection and Grounding

(1). Single phase and three phase connection:

Green/yellow wire is the ground wire.



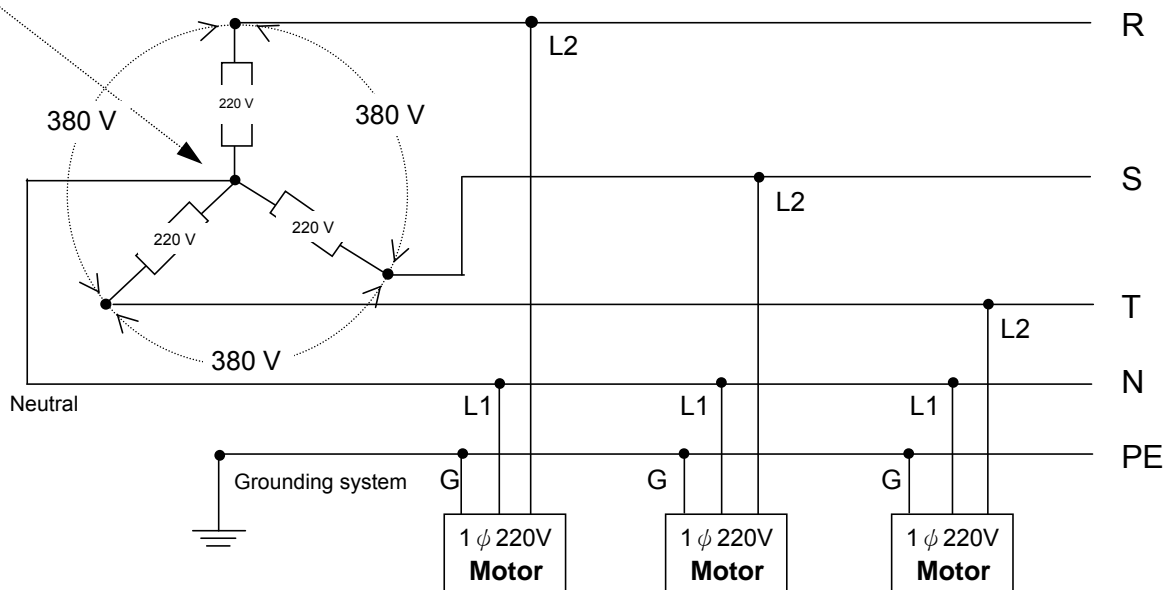
1. When a control box used on single phase 200 ~ 240 V power, only connect brown and blue wires. Use insulating tape to wrap up the black wire, in order to prevent the current leakage.
2. Green / Yellow wire must do the grounding.

(2). How to connect a 1 Φ / 220 V power from a 3 Φ / 380 V power source



Caution : If the power source does not have the neutral point, then this control box is not suitable for this connection.

Caution: Must have a Neutral point

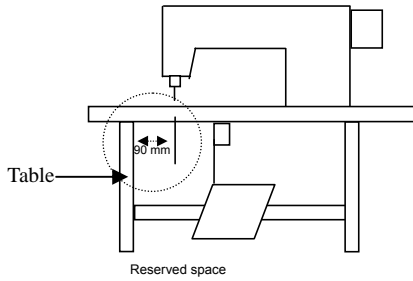


(3). The load balance when use a control box on a 3 Φ / 220 V power source.

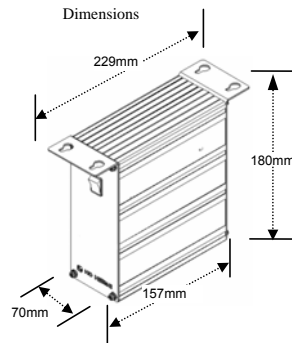
Please consider R.S.T balance when connecting to several sewing machine

III. Control Box Installation

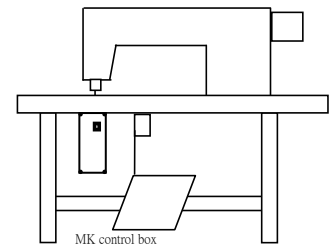
a).Reserved 90mm space (or above) on leftside of table



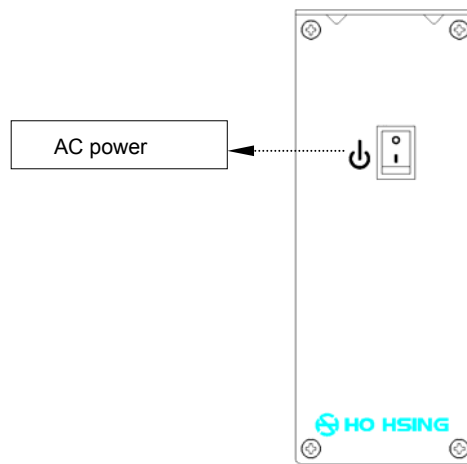
b)Installs MC control box under the table



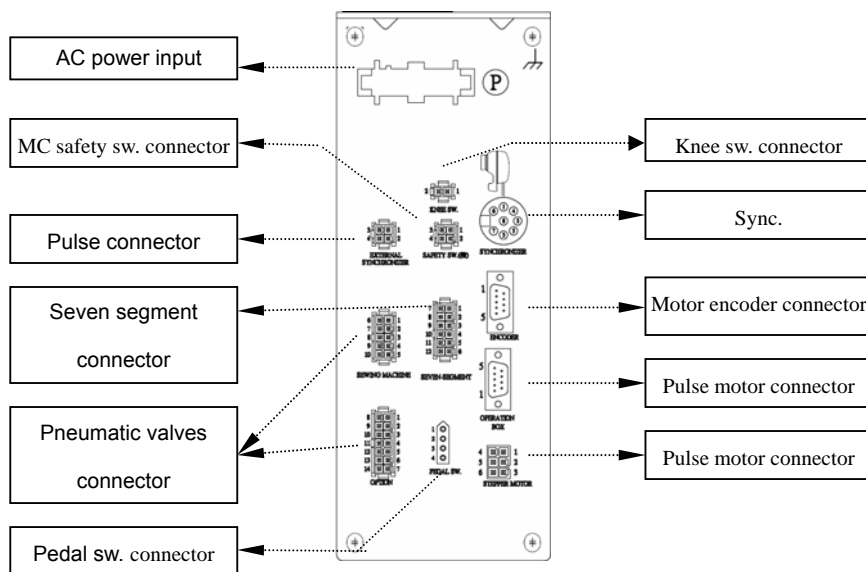
c).Illustration after installation



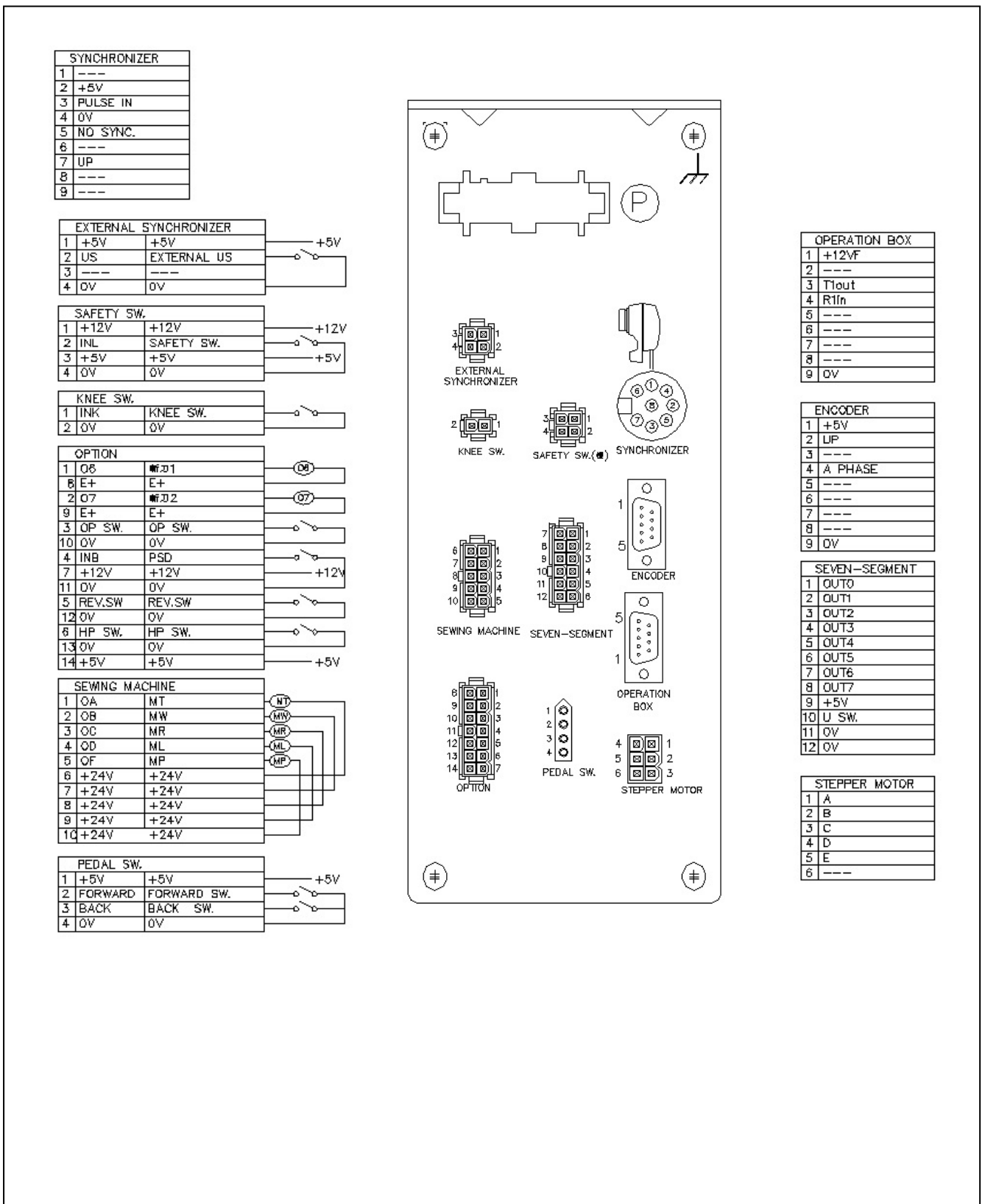
Front side :



Rear side:

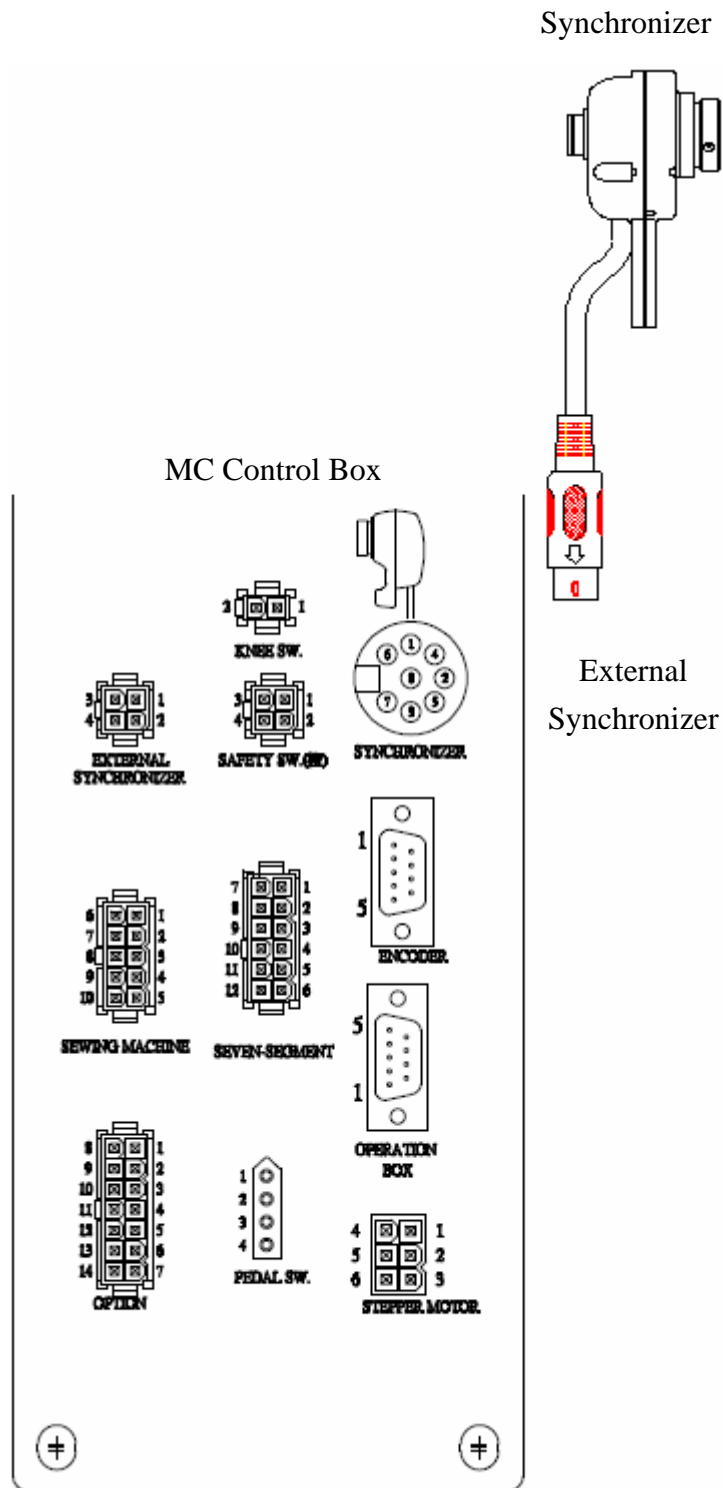


Pin assignment :

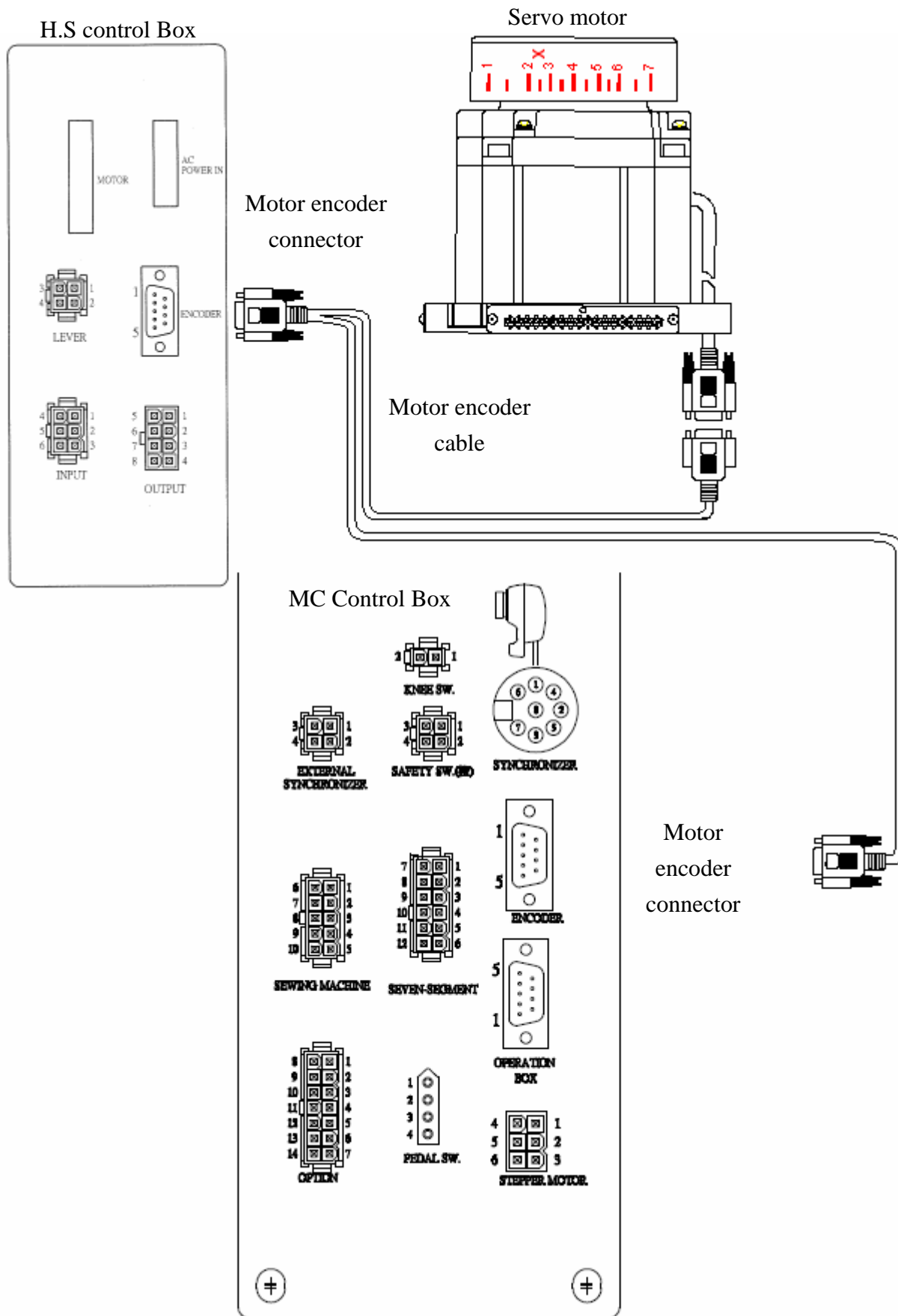


Connection for diagram illustrating :

1. General Installation



2. D.D. Servo motor

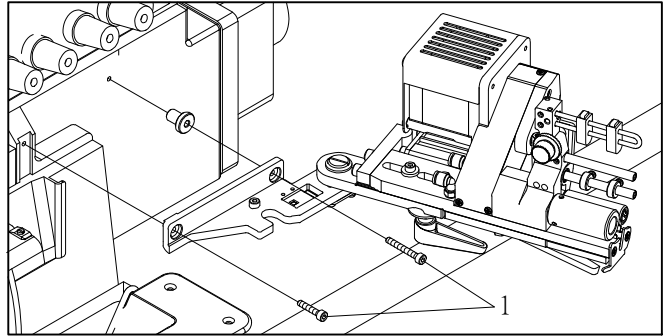


Installing each component

Installing the MC device

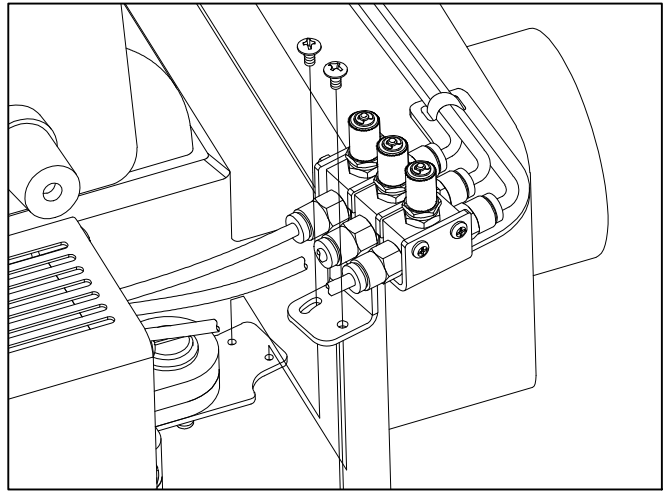
⚠ Always turn off the power,unplug the machine from the outlet and then only well-qualified technicians should install the MC device.

Install the bracket with the MC device on the machine head with screws 1 as shown in the illustration.



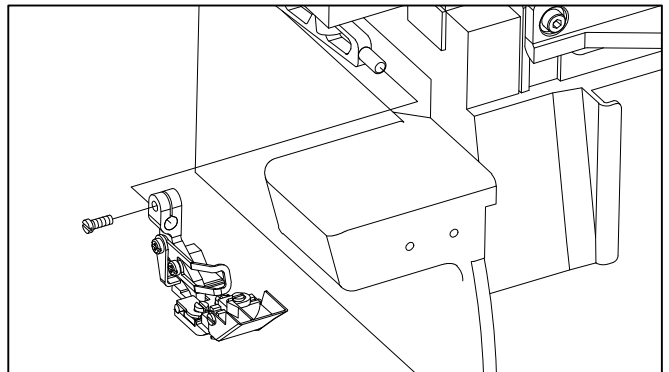
Installing the flow control valve device

⚠ Always turn off the power and air compressor first and then only well-qualified technicians should installing the flow control valve device.



Installing the press foot

⚠ Always turn off the power,unplug the machine from the outlet and then only well-qualified technicians should install the press foot.

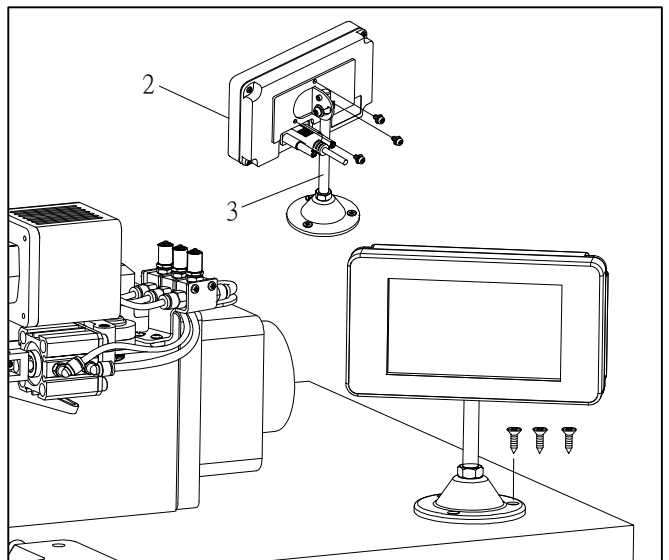


Installing the operation panel

⚠ Always turn off the power,unplug the machine from the outlet and then only well-qualified technicians should install the operation panel.

1. Install the operation panel 2 on bracket 3.

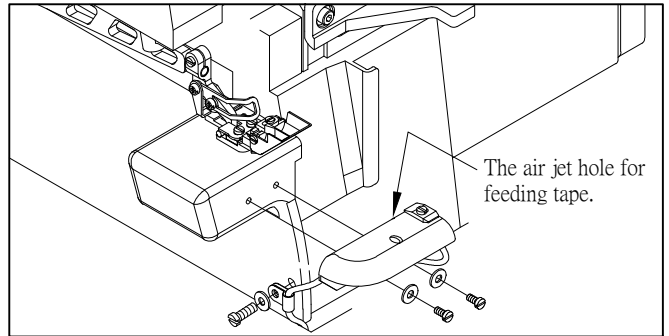
2. Mount the operation panel 2 and bracket 3 on the machine table.



Installing each component

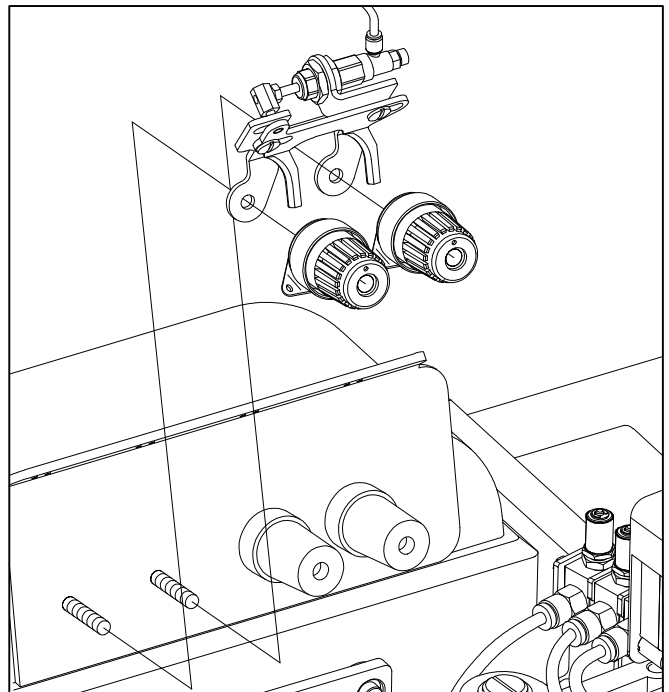
Installing the under air jet hole device

⚠ Always turn off the power and air compressor first and then only well-qualified technicians should installing the under air jet hole device.



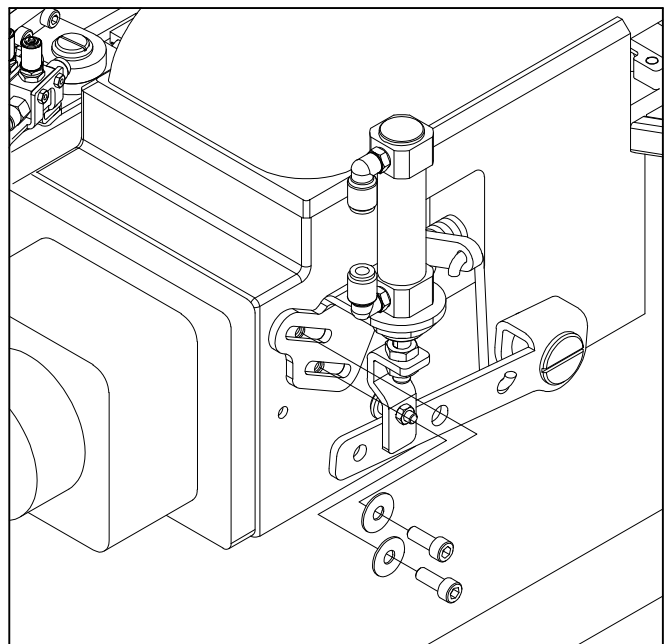
Installing the thread release device

⚠ Always turn off the power,unplug the machine from the outlet and then only well-qualified technicians should install the thread release device.



Installing the PL device

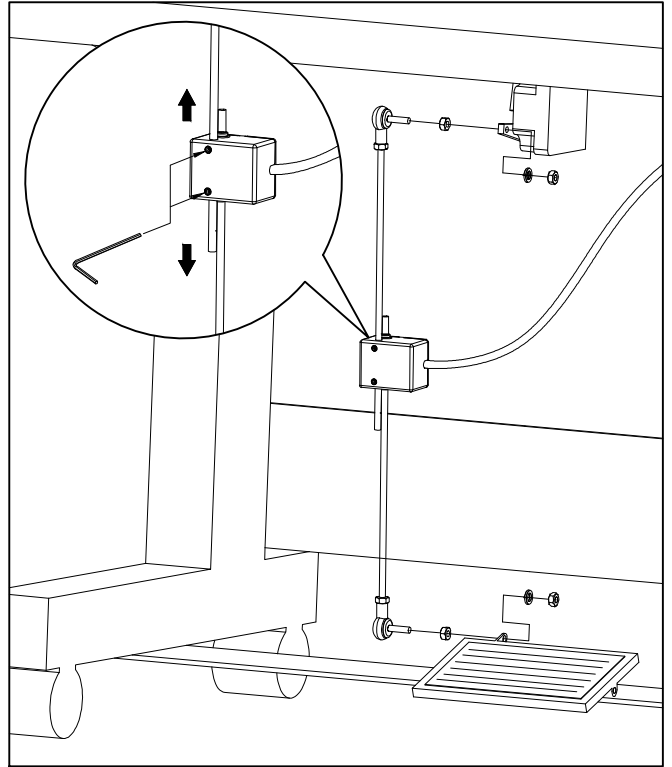
⚠ Always turn off the power and air compressor first and then only well-qualified technicians should installing the PL device.



Installing each component

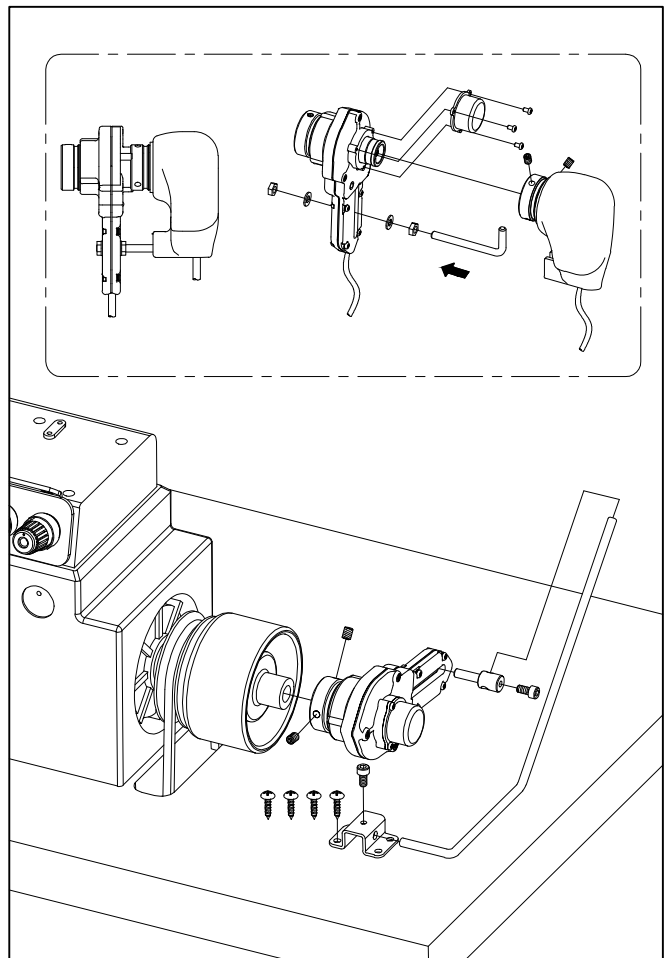
Installing the pedal switch

⚠ Always turn off the power,unplug the machine from the outlet and then only well-qualified technicians should install the pedal switch.



Installing the synchronizer

⚠ Always turn off the power,unplug the machine from the outlet and then only well-qualified technicians should install the pedal switch.



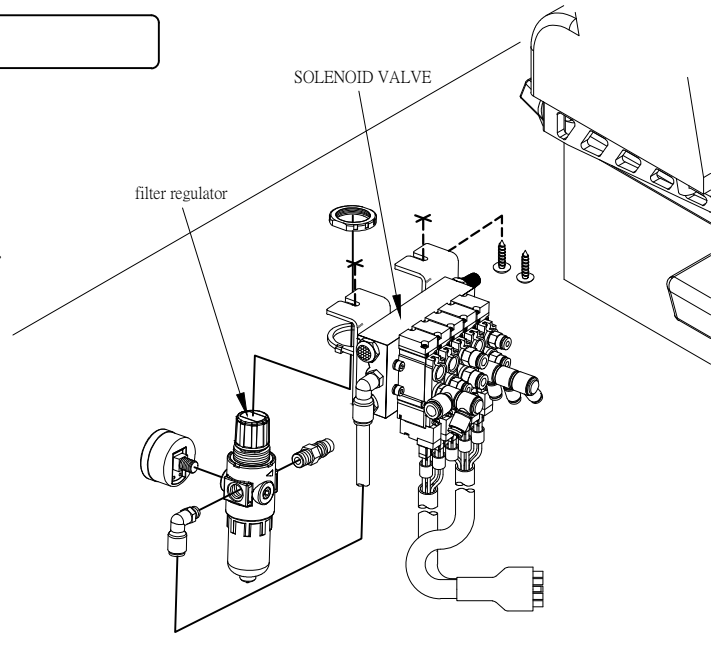
Installing each component

Installing the solenoid valve / filter regulator

⚠ Always turn off the power and air compressor first and then only well-qualified technicians should installing the solenoid valve / filter regulator.

⚠ Connect other lines first before connecting to the air source (air compressor).

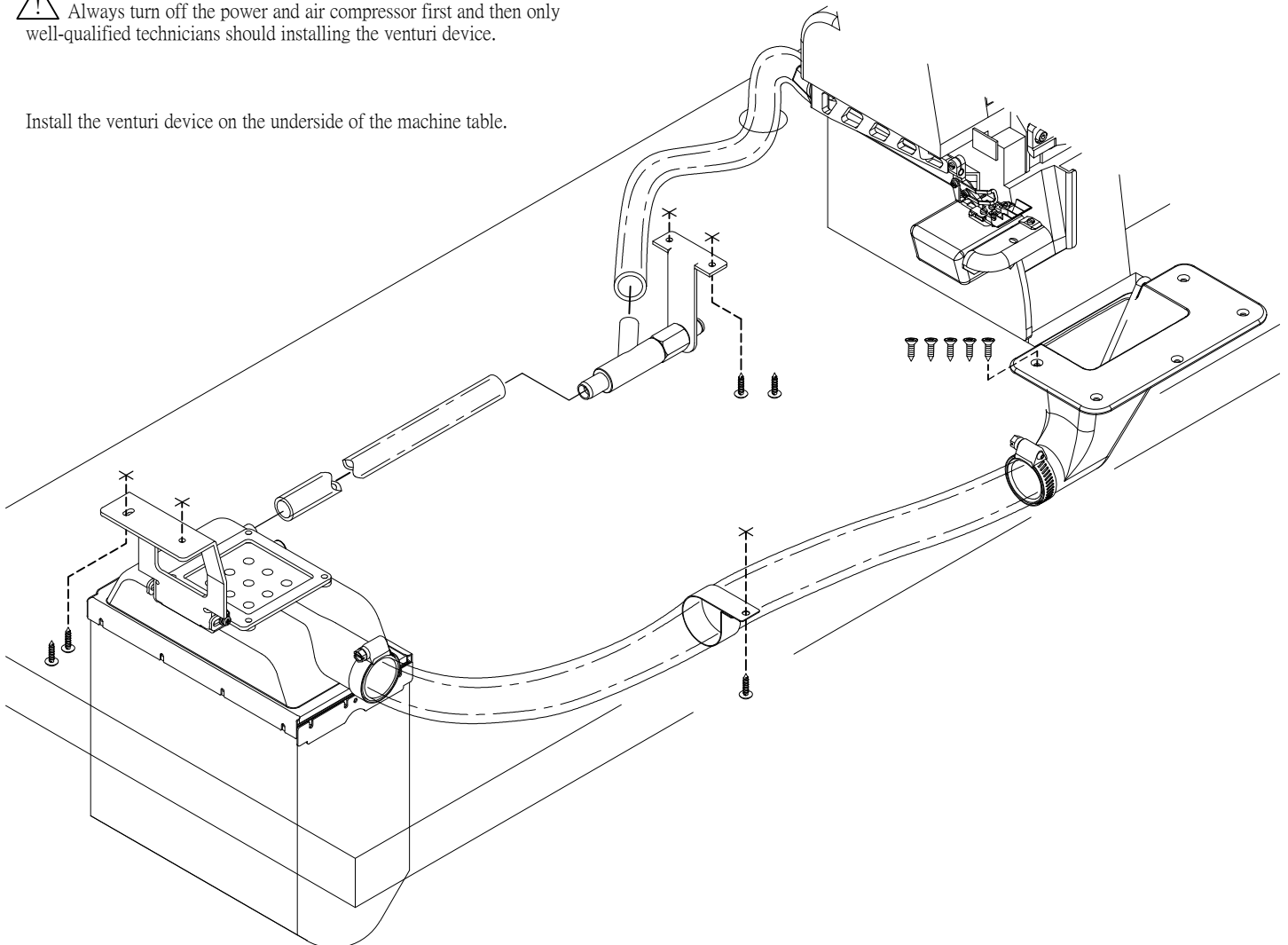
Install the solenoid valve / filter regulator on the underside of the machine table.



Installing the venturi device

⚠ Always turn off the power and air compressor first and then only well-qualified technicians should installing the venturi device.

Install the venturi device on the underside of the machine table.



Connecting air lines

⚠ CAUTION

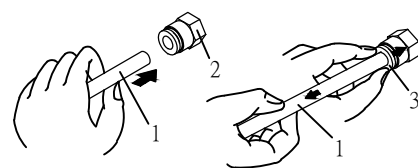
⚠ Always turn off the power and air compressor first and then only well-qualified technicians should connect the air lines.

⚠ Connect other lines first before connecting to the air source (air compressor).

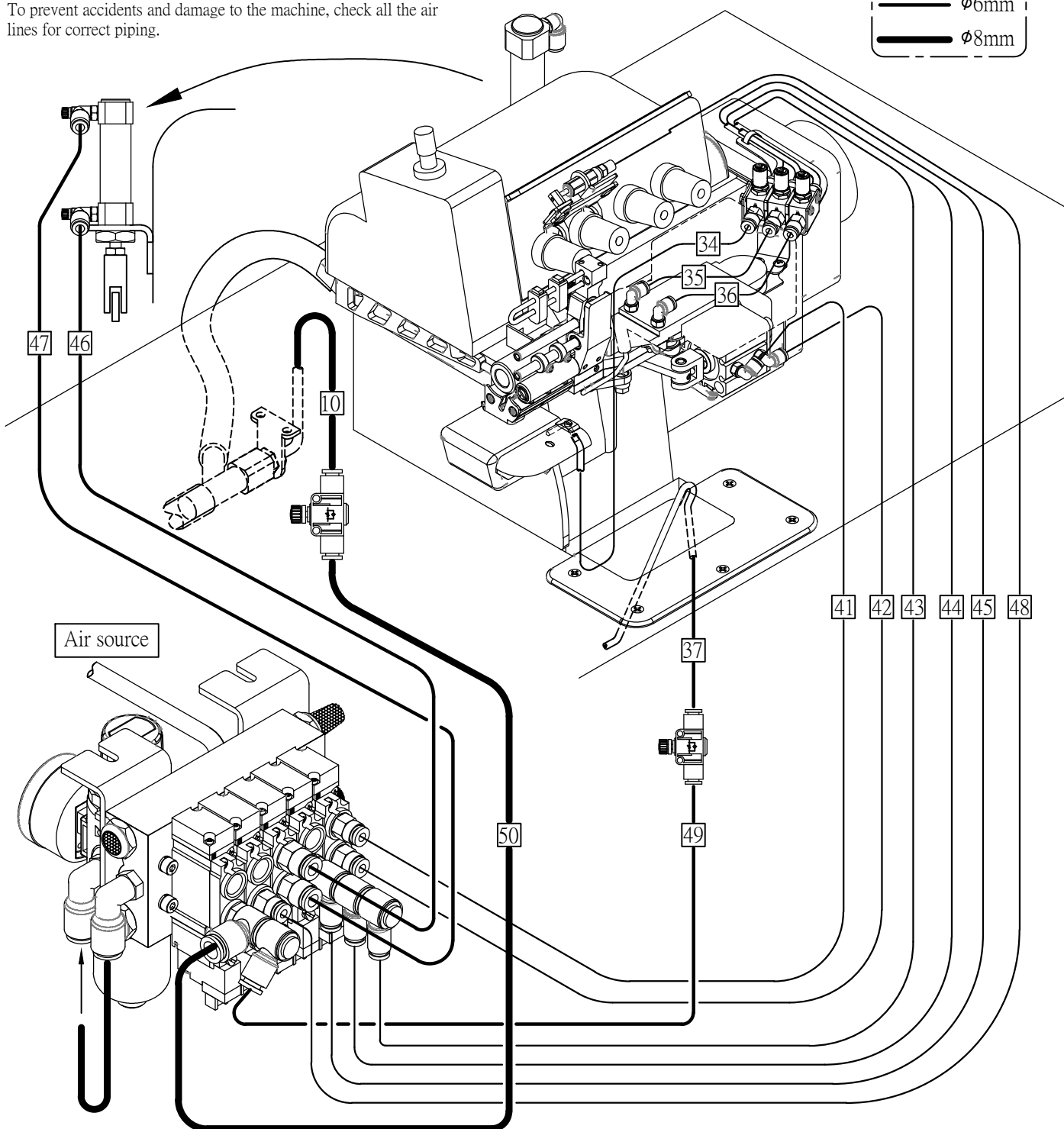
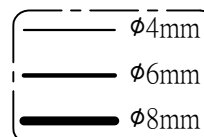
⚠ Failure to connect air lines properly may cause hazardous faulty operations.

To prevent accidents and damage to the machine, check all the air lines for correct piping.

- To connect air tube 1 to joint 2, insert the tube completely to the inlet depth and make sure the tube can not be disconnected by pulling it.
- To disconnect air tube 1, press release ring 3 toward the arrow and pull it out.



Connect the lines by referring to the illustration.



Adjusting the filter regulator

(1) Adjusting air pressure

Pull up knob 1 on filter regulator unit it clicks.
Then set the air pressure at 0.5Mpa (5kgf/cm²).

- Turning 1 in the (+) direction increases the air pressure.
- Turning 1 in the (-) direction decreases the air pressure.

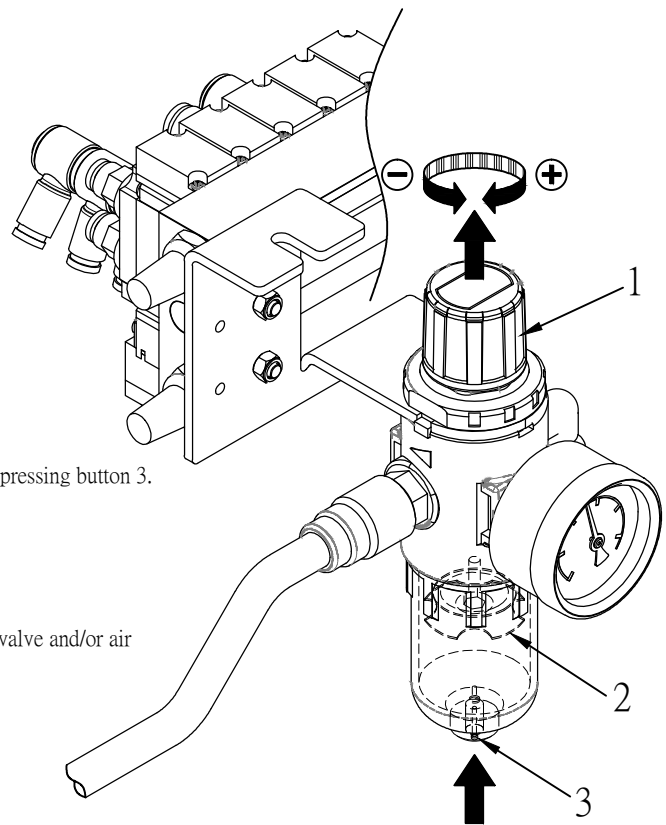
(2) Draining the filter regulator

Drain the filter regulator before collected drainage reaches the level 2 by pressing button 3.

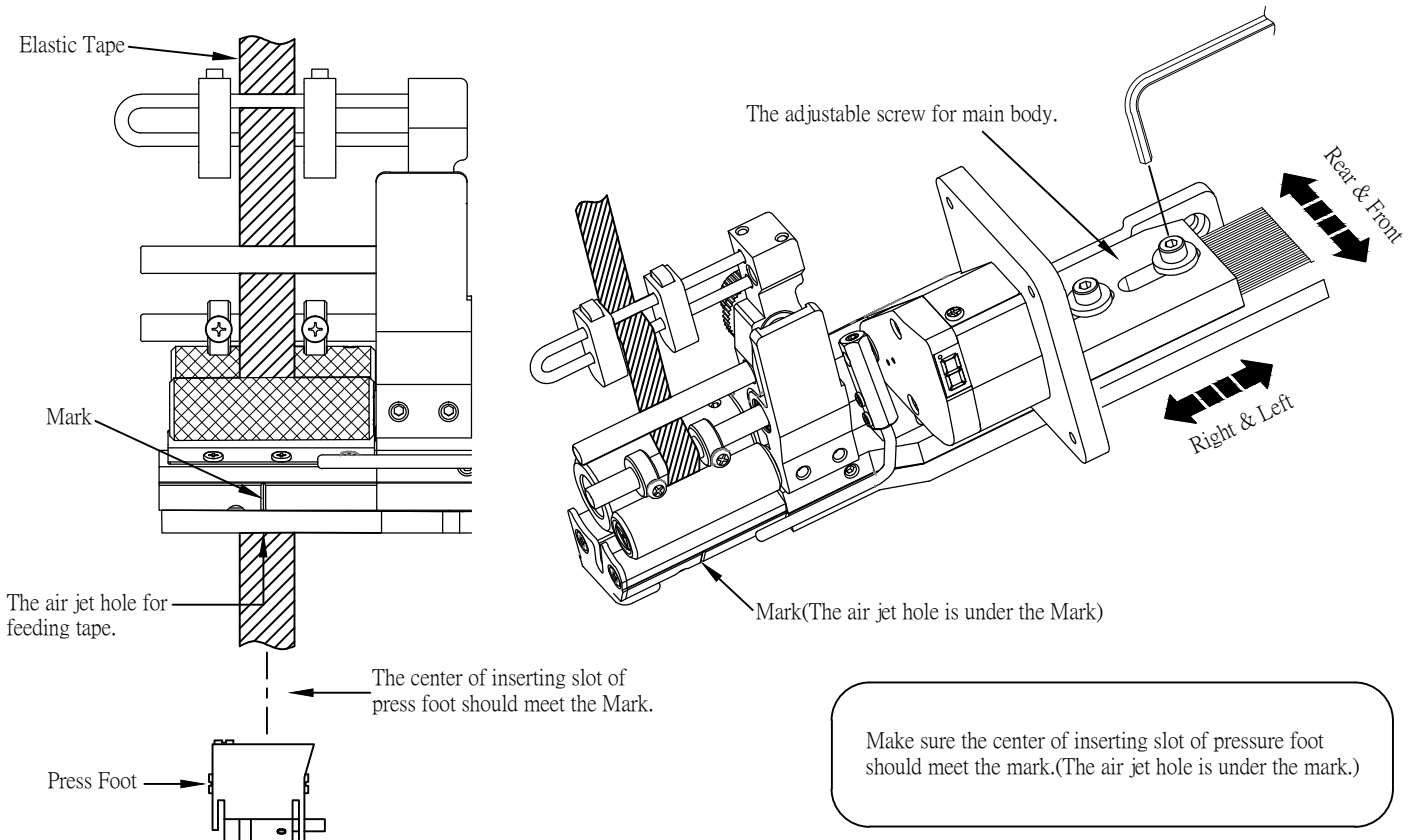
⚠ CAUTION

Be sure to drain periodically. Otherwise, drainage will flow into solenoid valve and/or air cylinder, causing trouble.


Note that drainage and air spout out downward.



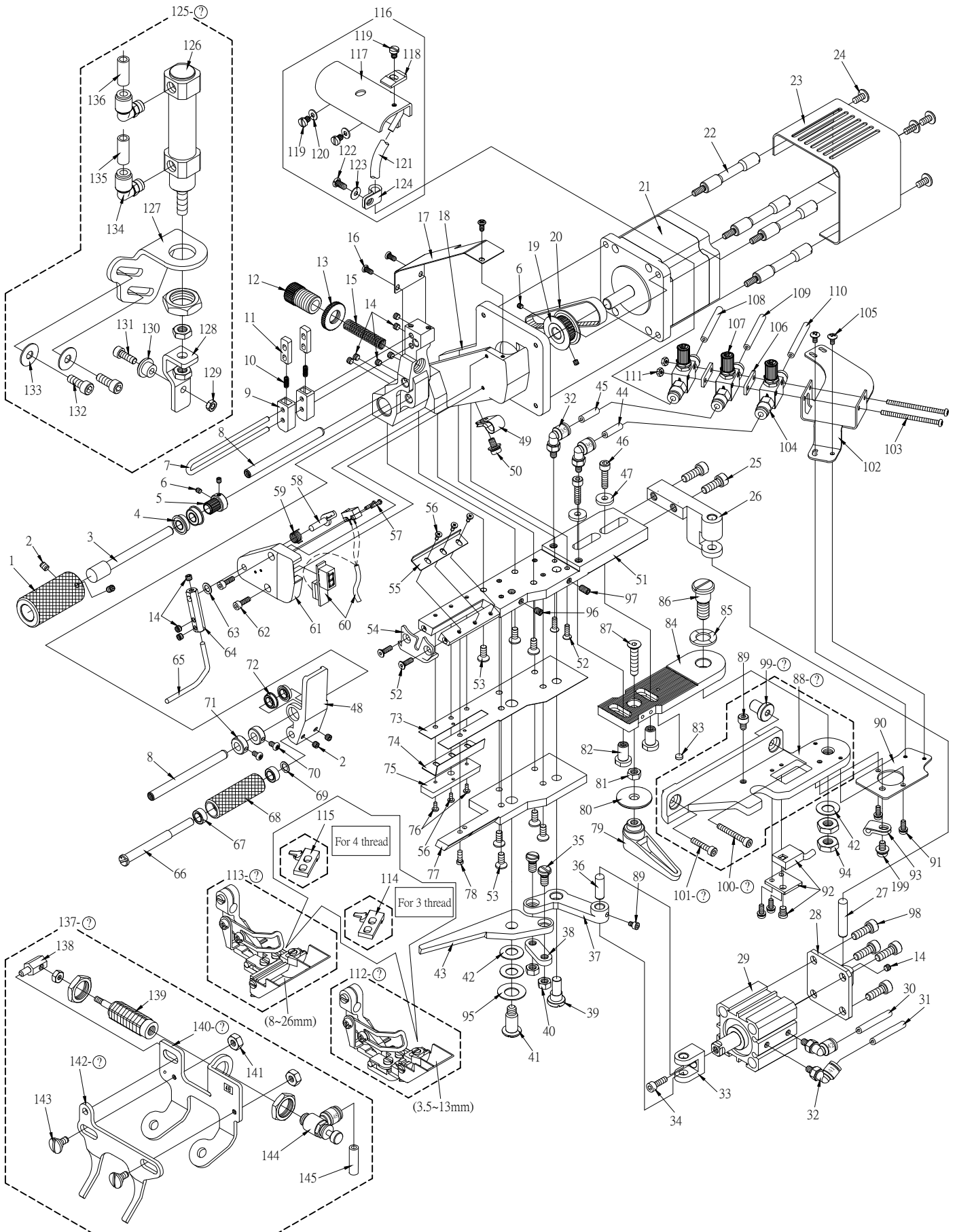
The right position for inserting elastic tape




MC1-38 Device part list


Mark description :  Option parts

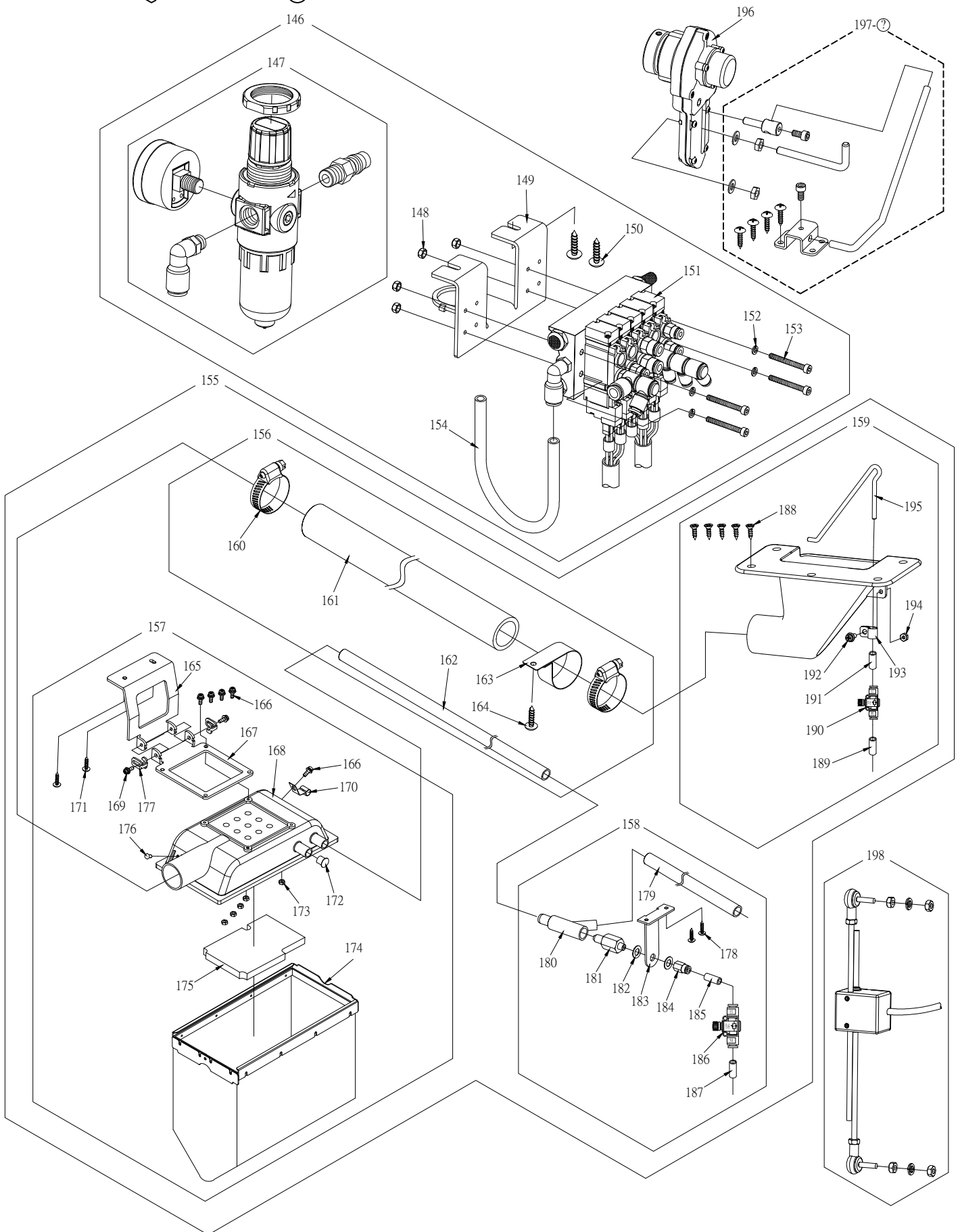
 Option parts, please indicate sewing machine model NO.



MC1-38 Device part list

Mark description :  Option parts

 Option parts, please indicate sewing machine model NO.



MC1-38 Device part list

NO.	Order Coder	Qty.	Description
1	313PY8031	1	
2	331SS1180	4	M4*0.7P*5L
3	313FDDF50	1	
4	313BR4090	2	
5	312PY1061	1	
6	331SS1200	4	M3*0.5P*3L
7	313FDD201	1	
8	313FDD261	2	
9	315FDD180	2	
10	33BLS2017	2	
11	315FDD190	2	
12	313FDD310	1	
13	313FDD300	1	
14	331SS1320	5	M4*0.7P*3L
15	33BMPC120	1	
16	331SP5160	3	M3*0.5P*6L
17	313FDDF60	1	
18	312FDD190	1	
19	312PY1051	1	
20	316BT1051	1	(B89MXL)
21	2MCD3ZSMB09001	1	
22	331SC1340	4	φ8*50L*M4*0.7t*10L
23	313FDDD11	1	
24	331SP1B90	2	M4*0.7P*8L
25	331HC1270	2	M5*0.8P*20L
26	313FDDF70	1	
27	313FDDF80	1	φ6*29L
28	313FDD211	1	
29	33DCLD220	1	ID 25*15
30	2MCD58PLF09005	1	# 42 : # 42
31	2MCD58PLF09004	1	# 41 : # 41
32	33DSPL090	4	φ4 : M5*0.8P
33	313FDDG00	1	
34	331HC1100	1	M5*0.8P*10L
35	331SP5091	2	
36	313FDDF81	1	φ6*18L
37	313FDDG10	1	
38	313FDD181	1	
39	313FDDF90	1	
40	332NO5010	2	M5*0.8P*5t
41	331SP5101	1	
42	33BWA1190	3	φ16*φ8.2*0.6t
43	313FDD431	1	
44	2MCD58PLF09015	1	# 36 : # 36
45	2MCD58PLF09014	1	# 35 : # 35
46	331HC1720	2	M4*0.7P*16L
47	333WP1500	2	φ12*φ4.35*2t
48	313FDD251	1	
49	33CHB1030	1	
50	331SP1130	1	M4*0.7P*8L
51	313FDD421	1	
52	331SN1190	4	M3*0.5P*10L
53	331SN1140	7	M4*0.7P*10L
54	313FDD191	1	
55	313FDDG20	1	
56	331SP5170	4	M2*0.4P*5L
57	331SP2330	2	M2*0.4P*8L
58	313FDD171	1	
59	33BLS4020	1	
60	2MCDSPW0021	1	
61	312FDD200	1	
62	331HC1660	2	M3*0.5P*10L


NO.	Order Coder	Qty.	Description
63	333WP1060	1	φ8*φ4.8*1t
64	313FDD401	1	
65	313FDD281	1	
66	313FDD251	1	
67	313BR4080	2	
68	313PY8041	1	
69	333WP1640	1	φ8*φ5.2*0.5t
70	331SP1530	2	M3*0.5P*4L
71	313FDD290	2	
72	313BR4020	2	
73	333PK1130	1	
74	313FDDG30	1	
75	313FDDG40	1	
76	331SP5180	2	M2*0.4P*9L
77	313FDD441	1	
78	331SP5190	1	M3*0.5P*8L
79	33ZFDD080	1	
80	313FDDG50	1	
81	332NO1400	1	M5*0.8P*4t
82	313FDD321	2	
83	324MGU010	1	φ5*1.5t
84	313FDD371	1	
85	33BWA1020	1	φ14.5*φ10.5*2H*0.3t
86	331SP5081	1	
87	331SN1180	1	M5*0.8P*25L
88	313FDD24*	1	According to different brand models selected
89	331HC1760	2	M4*0.7P*6L
90	313FDDG60	1	
91	331SP1930	4	M3*0.5P*8L
92	2MCD58PLF09005	1	
93	33CHB1050	1	
94	332NO1390	2	M8*1.25P*4.5t
95	333WP1150	1	φ15*φ8*1t
96	331SS1370	1	M4*0.7P*6L
97	331SS1380	1	M4*0.7P*8L
98	331HC1640	4	M6*1.0P*15L
99	313FDDG9*	1	According to different brand models selected
100	331HC****	1	According to different brand models selected
101	331HC****	1	According to different brand models selected
102	313FDDG70	1	
103	331SP1980	2	M3*0.5P*45L
104	33DCUF190	6	
105	331SP1C60	2	M3*0.5P*4L
106	313FDDG80	2	
107	33DJVA040	3	
108	2MCD58PLF09018	1	# 45 : # 45
109	2MCD58PLF09017	1	# 44 : # 44
110	2MCD58PLF09016	1	# 43 : # 43
111	332NO1340	2	M3*0.5P*2.3t
112	2MCDPF201*	1	According to different brand models selected
113	2MCDPF202*	1	According to different brand models selected
114	43ZFDD051	2	For 3 thread
115	43ZFDD050	2	For 4 thread
116	2MCDTR021	1	
117	313FDDD60	1	
118	313FDDE10	1	
119	331SP5130	3	M3*0.5P*5L
120	333WP1570	2	φ6*φ3.2*0.5t
121	2MCD58PLF09013	1	# 34 : # 34
122	331SP5120	1	M3*0.5P*8L
123	333WP1600	1	φ8*φ4*1t
124	33CHB1050	1	


MC1-38 Device part list

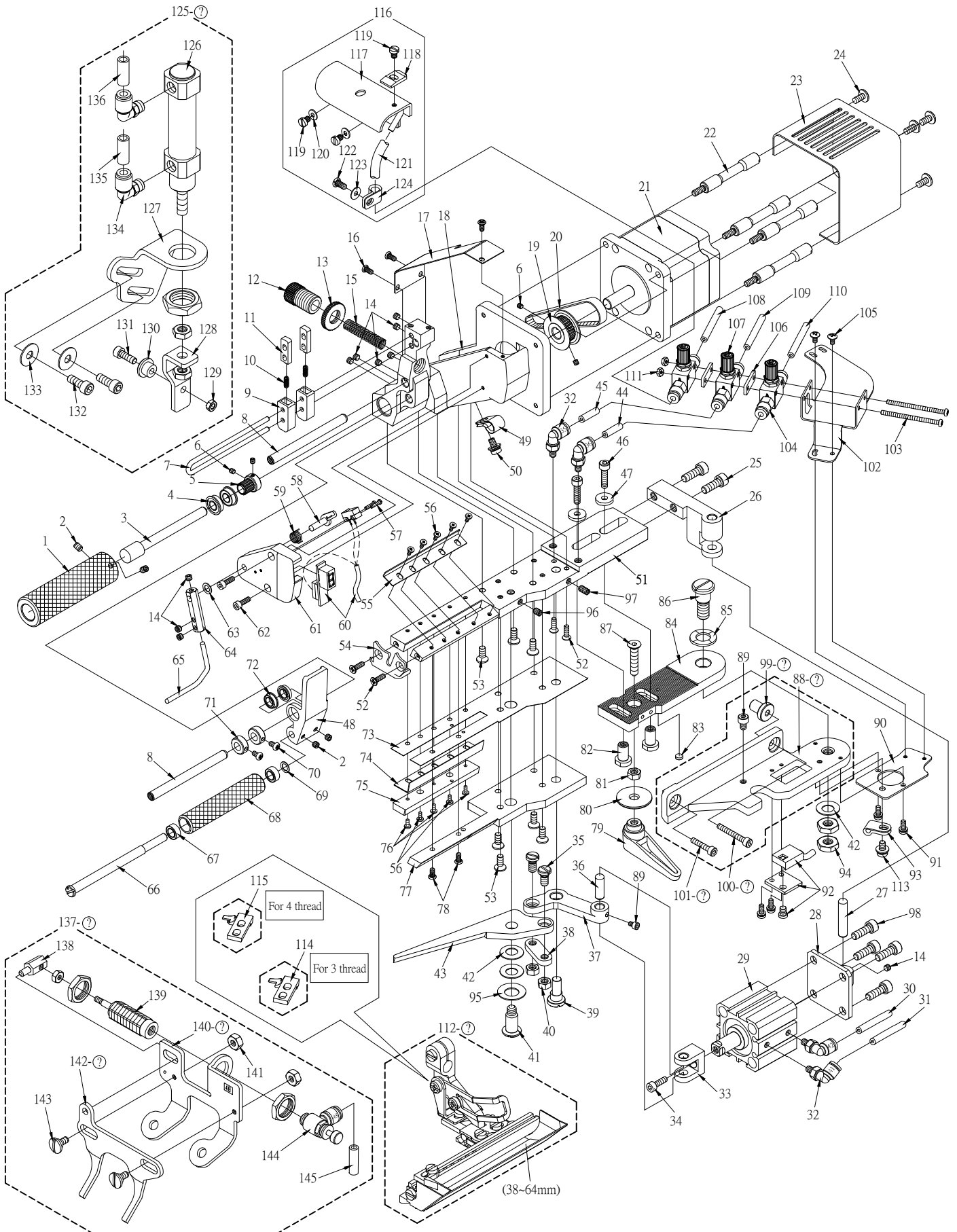
NO.	Order Coder	Qty.	Description
125	2MCDPF10**	1	According to different brand models selected
126	33DCLD120	1	
127	313SMM260	1	
128	313SMM170	1	
129	332NO5010	1	M5*0.8P*5t
130	313SMM190	1	
131	331HC1230	1	M5*0.8P*15L
132	331HC1090	2	M6*1.0P*16L
133	333WP1130	2	φ19*φ6.7*1t
134	33DSPL010	2	
135	2MCD58PLF08012	1	# 46 : # 46
136	2MCD58PLF08013	1	# 47 : # 47
137	2MCDTSY0***	1	According to different brand models selected
138	313FDD140	1	
139	33DCUF180	1	
140	313FDDE3*	1	According to different brand models selected
141	332NO1300	2	M3*0.5P*2.6t
142	313FDDE2*	1	According to different brand models selected
143	331SP5110	2	M3*0.5P*8.6L
144	33DJSC040	1	
145	2MCD58PLF09009	1	# 48 : # 48
146	2MCD3DALSS51011A	1	
147	2VDAR04	1	
148	332NO1060	4	M4*0.7P
149	313IRF140	1	
150	331ST1100	2	φ4.7*19L
151	2MCD3DALSS51001A	1	
152	334WS1020	4	φ7.1*φ4.1*1t
153	331HC1460	4	M4*0.7P*35L
154	2MCD58PLF07001	1	
155	2MCDVD7050P02A	1	
156	2MCDACC001	1	
157	2MCDFBA01	1	
158	2MCDVEN002A	1	
159	2MCDFUN002A	1	
160	339HSE030	2	
161	316PT6040	1	L=800mm
162	315PT1020	1	L=800mm
163	339CB1060	1	
164	331ST1100	1	
165	313SMM520	1	
166	331SP1160	5	
167	313SMM530	1	
168	315VDR040	1	
169	331SP1830	2	
170	313SMM155	1	
171	331ST1100	2	
172	33CHY2090	1	
173	332NO1050	5	M4*0.7P*3.2t
174	33ZSMD04A	1	
175	35ZSMR230	1	
176	33ZSMN220	1	
177	313SMM540	2	
178	331ST1100	2	
179	315PT1020	1	L=250mm
180	33DALS031	1	
181	33DALS020	1	
182	333WP1180	2	
183	313IRF060	1	
184	33DSQG010	1	
185	2MCD58PLF07005	1	# 10 : # 10
186	33DJVA030	1	# 50 : # 10

NO.	Order Coder	Qty.	Description
187	2MCD58PLF07006	1	# 50 : # 50
188	331ST1070	5	
189	2MCD58PLF08014	1	# 49 : # 49
190	33DJVA010	1	# 49 : # 37
191	2MCD58PLF08011	1	# 37 : # 37
192	331SP1160	1	
193	33CHB1050	1	
194	332NO1050	1	M4*0.7P*3.2t
195	315VDR050	1	
196	2VP11AD00101	1	
197	2VP122009*	1	According to different brand models selected
198	2TCSW020	1	
199	331SP1160	1	M4*0.7P*12L


MC1-64 Device part list


Mark description :  Option parts

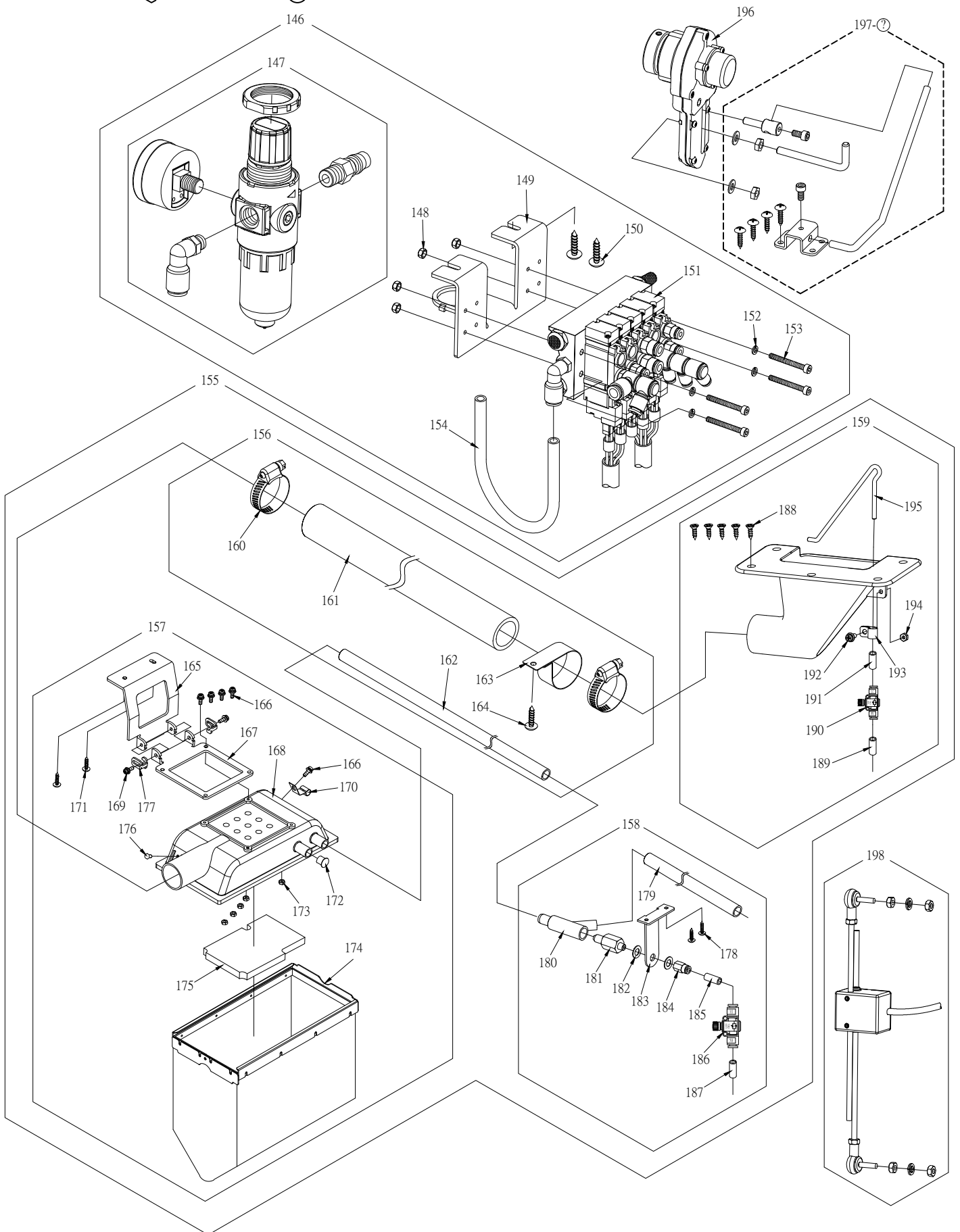
 Option parts, please indicate sewing machine model NO.



MC1-64 Device part list

Mark description :  Option parts

 Option parts, please indicate sewing machine model NO.



MC1-38 Device part list

NO.	Order Coder	Qty.	Description
1	313PY8032	1	
2	331SS1180	4	M4*0.7P*5L
3	313FDDF50	1	
4	313BR4090	2	
5	312PY1061	1	
6	331SS1200	4	M3*0.5P*3L
7	313FDD203	1	
8	313FDD262	2	
9	315FDD180	2	
10	33BLS2017	2	
11	315FDD190	2	
12	313FDD310	1	
13	313FDD300	1	
14	331SS1320	5	M4*0.7P*3L
15	33BMPC120	1	
16	331SP5160	3	M3*0.5P*6L
17	313FDDF60	1	
18	312FDD190	1	
19	312PY1051	1	
20	316BT1051	1	(B89MXL)
21	2MCD3ZSMB09001	1	
22	331SC1340	4	φ8*50L*M4*0.7t*10L
23	313FDDD11	1	
24	331SP1B90	2	M4*0.7P*8L
25	331HC1270	2	M5*0.8P*20L
26	313FDDF70	1	
27	313FDDF80	1	φ6*29L
28	313FDD211	1	
29	33DCLD220	1	ID 25*15
30	2MCD58PLF09005	1	# 42 : # 42
31	2MCD58PLF09004	1	# 41 : # 41
32	33DSPL090	4	φ4 : M5*0.8P
33	313FDDG00	1	
34	331HC1100	1	M5*0.8P*10L
35	331SP5091	2	
36	313FDDF81	1	φ6*18L
37	313FDDG10	1	
38	313FDD181	1	
39	313FDDF90	1	
40	332NO5010	2	M5*0.8P*5t
41	331SP5101	1	
42	33BWA1190	3	φ16*φ8.2*0.6t
43	313FDD432	1	
44	2MCD58PLF09015	1	# 36 : # 36
45	2MCD58PLF09014	1	# 35 : # 35
46	331HC1720	2	M4*0.7P*16L
47	333WP1500	2	φ12*φ4.35*2t
48	313FDD251	1	
49	33CHB1030	1	
50	331SP1130	1	M4*0.7P*8L
51	313FDD422	1	
52	331SN1190	4	M3*0.5P*10L
53	331SN1140	7	M4*0.7P*10L
54	313FDD191	1	
55	313FDDG21	1	
56	331SP5170	7	M2*0.4P*5L
57	331SP2330	2	M2*0.4P*8L
58	313FDD171	1	
59	33BLS4020	1	
60	2MCDSPW0021	1	
61	312FDD200	1	
62	331HC1660	2	M3*0.5P*10L

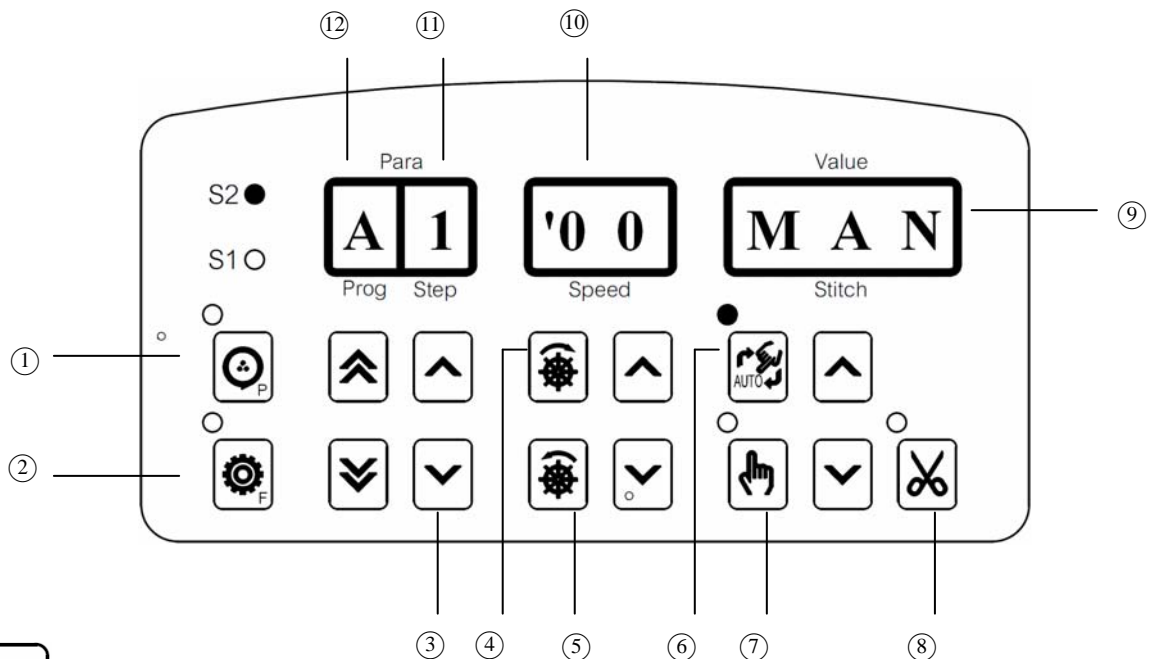
NO.	Order Coder	Qty.	Description
63	333WP1060	1	φ8*φ4.8*1t
64	313FDD401	1	
65	313FDD281	1	
66	313FDD252	1	
67	313BR4080	2	
68	313PY8042	1	
69	333WP1640	1	φ8*φ5.2*0.5t
70	331SP1530	2	M3*0.5P*4L
71	313FDD290	2	
72	313BR4020	2	
73	333PK1131	1	
74	313FDDG31	1	
75	313FDDG41	1	
76	331SP5180	3	M2*0.4P*9L
77	313FDD442	1	
78	331SP5190	2	M3*0.5P*8L
79	33ZFDD080	1	
80	313FDDG50	1	
81	332NO1400	1	M5*0.8P*4t
82	313FDD321	2	
83	324MGU010	1	φ5*1.5t
84	313FDD371	1	
85	33BWA1020	1	φ14.5*φ10.5*2H*0.3t
86	331SP5081	1	
87	331SN1180	1	M5*0.8P*25L
88	313FDD24*	1	According to different brand models selected
89	331HC1760	2	M4*0.7P*6L
90	313FDDG60	1	
91	331SP1930	4	M3*0.5P*8L
92	2MCD58PLF09005	1	
93	33CHB1050	1	
94	332NO1390	2	M8*1.25P*4.5t
95	333WP1150	1	φ15*φ8*1t
96	331SS1370	1	M4*0.7P*6L
97	331SS1380	1	M4*0.7P*8L
98	331HC1640	4	M6*1.0P*15L
99	313FDDG9*	1	According to different brand models selected
100	331HC****	1	According to different brand models selected
101	331HC****	1	According to different brand models selected
102	313FDDG70	1	
103	331SP1980	2	M3*0.5P*45L
104	33DCUF190	6	
105	331SP1C60	2	M3*0.5P*4L
106	313FDDG80	2	
107	33DJVA040	3	
108	2MCD58PLF09018	1	# 45 : # 45
109	2MCD58PLF09017	1	# 44 : # 44
110	2MCD58PLF09016	1	# 43 : # 43
111	332NO1340	2	M3*0.5P*2.3t
112	2MCDPF204*	1	According to different brand models selected
113	331SP1160	1	M4*0.7P*12L
114	43ZFDD051	2	For 3 thread
115	43ZFDD050	2	For 4 thread
116	2MCDTR021	1	
117	313FDDD60	1	
118	313FDDE10	1	
119	331SP5130	3	M3*0.5P*5L
120	333WP1570	2	φ6*φ3.2*0.5t
121	2MCD58PLF09013	1	# 34 : # 34
122	331SP5120	1	M3*0.5P*8L
123	333WP1600	1	φ8*φ4*1t
124	33CHB1050	1	

MC1-38 Device part list

NO.	Order Coder	Qty.	Description
125	2MCDPF10**	1	According to different brand models selected
126	33DCLD120	1	
127	313SMM260	1	
128	313SMM170	1	
129	332NO5010	1	M5*0.8P*5t
130	313SMM190	1	
131	331HC1230	1	M5*0.8P*15L
132	331HC1090	2	M6*1.0P*16L
133	333WP1130	2	φ19*φ6.7*1t
134	33DSPL010	2	
135	2MCD58PLF08012	1	# 46 : # 46
136	2MCD58PLF08013	1	# 47 : # 47
137	2MCDTSY0***	1	According to different brand models selected
138	313FDD140	1	
139	33DCUF180	1	
140	313FDDE3*	1	According to different brand models selected
141	332NO1300	2	M3*0.5P*2.6t
142	313FDDE2*	1	According to different brand models selected
143	331SP5110	2	M3*0.5P*8.6L
144	33DJSC040	1	
145	2MCD58PLF09009	1	# 48 : # 48
146	2MCD3DAL5S1011A	1	
147	2VDAR04	1	
148	332NO1060	4	M4*0.7P
149	313IRF140	1	
150	331ST1100	2	φ4.7*19L
151	2MCD3DAL5S1001A	1	
152	334WS1020	4	φ7.1*φ4.1*1t
153	331HC1460	4	M4*0.7P*35L
154	2MCD58PLF07001	1	
155	2MCDVD7050P02A	1	
156	2MCDACC001	1	
157	2MCDFBA01	1	
158	2MCDVEN002A	1	
159	2MCDFUN002A	1	
160	339HSE030	2	
161	316PT6040	1	L=800mm
162	315PT1020	1	L=800mm
163	339CB1060	1	
164	331ST1100	1	
165	313SMM520	1	
166	331SP1160	5	
167	313SMM530	1	
168	315VDR040	1	
169	331SP1830	2	
170	313SMM155	1	
171	331ST1100	2	
172	33CHY2090	1	
173	332NO1050	5	M4*0.7P*3.2t
174	33ZSMD04A	1	
175	35ZSMR230	1	
176	33ZSMN220	1	
177	313SMM540	2	
178	331ST1100	2	
179	315PT1020	1	L=250mm
180	33DALS031	1	
181	33DALS020	1	
182	333WP1180	2	
183	313IRF060	1	
184	33DSQG010	1	
185	2MCD58PLF07005	1	# 10 : # 10
186	33DJVA030	1	# 50 : # 10


NO.	Order Coder	Qty.	Description
187	2MCD58PLF07006	1	# 50 : # 50
188	331ST1070	5	
189	2MCD58PLF08014	1	# 49 : # 49
190	33DJVA010	1	# 49 : # 37
191	2MCD58PLF08011	1	# 37 : # 37
192	331SP1160	1	
193	33CHB1050	1	
194	332NO1050	1	M4*0.7P*3.2t
195	315VDR050	1	
196	2VP11AD00101	1	
197	2VP122009*	1	According to different brand models selected
198	2TCSW020	1	

IV. Function for sewing



- ①  Enter editing

Description: Enter editing when press this key, process related setting after entered.

- ②  Enter parameter setting

Description: Press the key to enter parameter setting, process related setting after entered.

- ③  Shift up/downward


Description: Moves one step when press shift up/downward key.

- ④  Forward

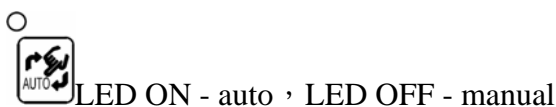
Description: Press the key to forward the tape.

- ⑤  Reserve

Description: Press the key to reverse the tape.


- ⑥  Set auto or manual in programming segment

Description:

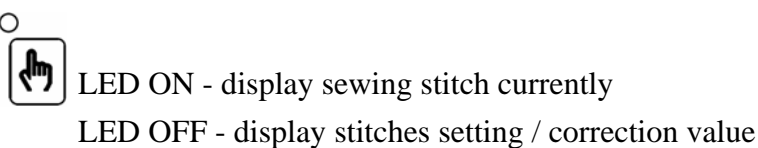


(Auto): enter to next segment automatically while the set stitch achieved.

“MAN” (Manual):enter to next segment manually.

- ⑦  Switch key for stitch /correction value of section changed


Description: Switch stitches be setted / correction value of each step.



Section correction : correct the deviation on buffer tape

The xxx value is correction value of section changed , while stitch column display xxx. , the range is 0 – 99.

- ⑧  Trimming

Description :  LED ON - trimming automatically after finished the programming segment.

- ⑨  Stitch / correction value


Description: Display the set stitches / correction value in every programming segment.

- ⑩  Metering of feeding

Description: Display the meter of every stitch, the range of meter is 0 ~ 180.

- ⑪  Programming segments

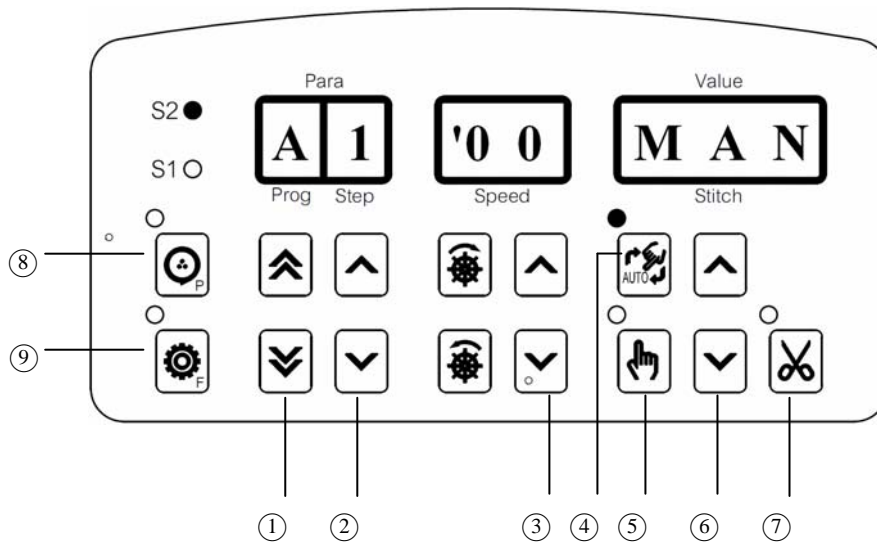
Description: 19 programming segments in each programming mode.

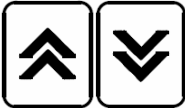
- ⑫  Programming mode

Description: Display the model is processing, maximum 23 modes (A~).


V. Editing

press  key to enter editing



①  Programming mode switch key

Description: Total 23 zones(A ~) in programming mode, select the mode you need to store data.

②  Programming segment switch key


Description: For switch programming segment, maximum 19 segments.

③  Meter feeding setting

Description: Set the feeding meter of every stitch, list below is the reference table.

For MC


Speed	feeding meter (mm)	Speed	feeding meter (mm)
0	0.00	100	2.33
10	0.23	110	2.57
20	0.47	120	2.80
30	0.70	130	3.03
40	0.93	140	3.27
50	1.17	150	3.50
60	1.40	160	3.73
70	1.63	170	3.97
80	1.87	180	4.2
90	2.10		

- ④  Set auto or manual in programming segment

Description:

“A”(Auto):enter to next segment automatically while the set stitch achieved.

“M”(Manual):enter to next segment manually.



- ⑤  Switch key for stitches / correction of section changed / stitches number be loaded

Description: Switch stitches be setted / correction value of section changed / stitches number be loaded



LED ON : stitches number be loaded

LED OFF : stitches be setted / correction value of section changed

- ⑥   Setting for stitches number / correction value of section changed / stitches number be loaded

Description: set the stitch / correction value needed, press “+” increment, “-“ decrement .



LED ON : The number of stitch after sewing finished can be download to stitch column new stitch setting (warning! The original number of stitch will be over written.)



LED OFF :

The xxx value is stitches value of section , while stitch column display xxx

The xxx value is correction value of section changed , while stitch column display xxx., To

eliminate the difference at multi-step stitching while elastic band yields carved in and out, this function serves as a reparation and/or offsetting difference by pull and push back and forth.

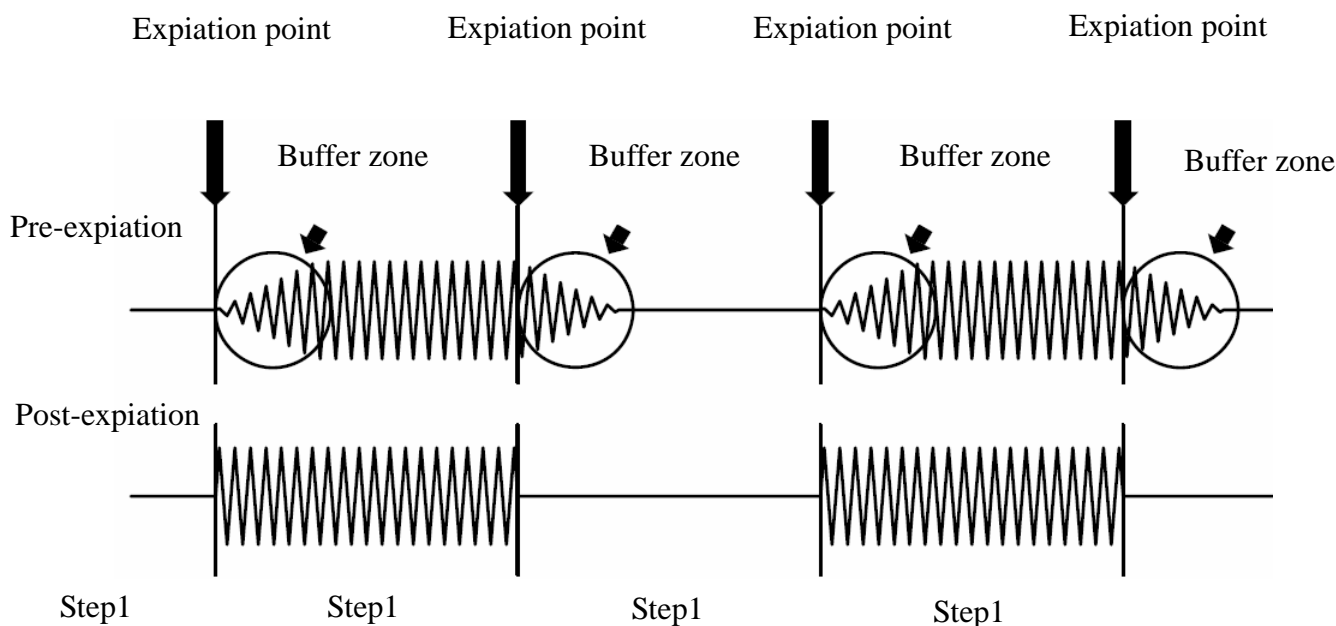
Correction Module:

A. Transit from 1st step to 2nd step: adjust from step one.

B. Transit from 2st step to 3nd step: adjust from step two.

C. Rationalize above operation until it goes back to step one: adjust from the last step.

Note: Elastic band correction value: 0=0mm , every extend one depicts 0.35mm.(Automatic judgment for pull or push compensation)




⑦  Trimming mode setting

Description: Press the key to show scissors mark in mode, it process trimming after sewing finished.

⑧  Return

Description: Return to sewing mode.

⑨  Programming ending setting


Description: Two modes been selected:

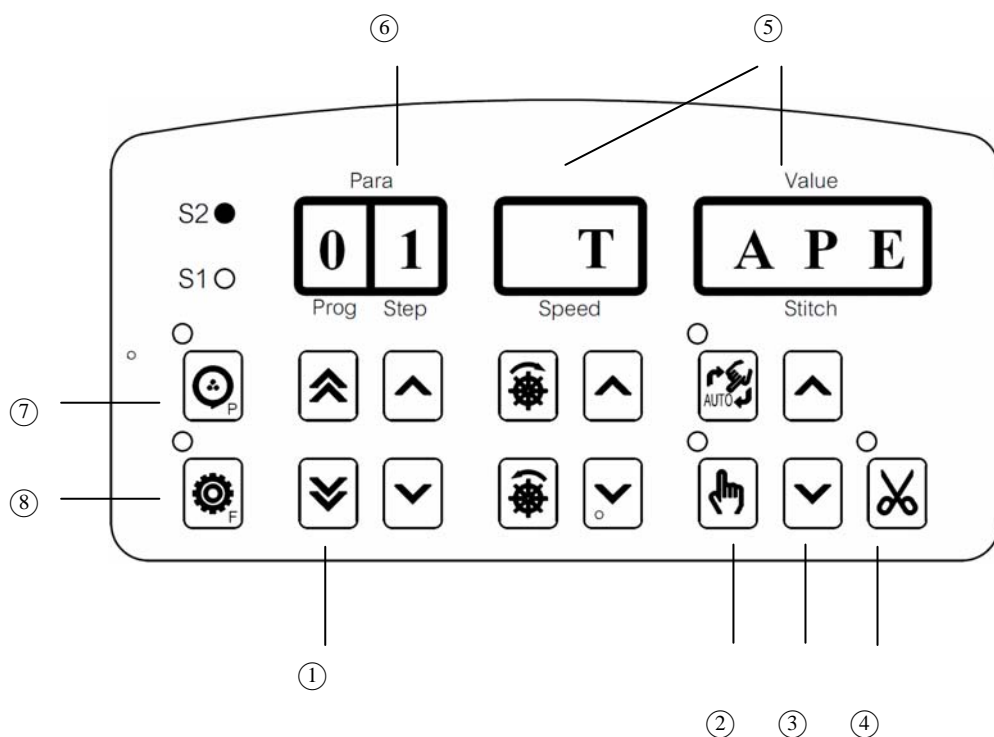
End: Trimming after the ending of programming.



End2: No trimming after the ending of programming (ME dedicated).

Cont: No trimming after the ending of programming, and automatically return Step01.

VI. Parameter setting mode

① press  key to enter parameter setting




①   Previous/next parameter data


Description: Press one time to move one parameter data.

②  Parameter value display key

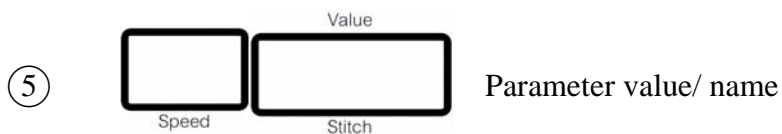
Description: Press the key to display parameter value



③   Parameter value setting

Description: To set the value of parameter.

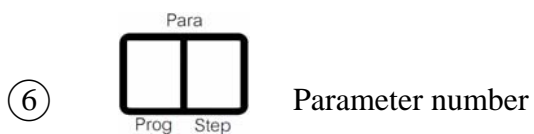
④  Name of parameter display key

Description: One parameter name in the parameter data value setting finished, return to the post-press



Description :  LED ON or press  , display parameter value

 LED ON , display name of parameter



Description: Total 64 parameter



Description: In the case of the parameter name is displayed , return to sewing mode.



Description: Press the first time into the parameter setting screen, parameter setting screen press to enter the parameter content value adjustment

Content of parameter 1/2

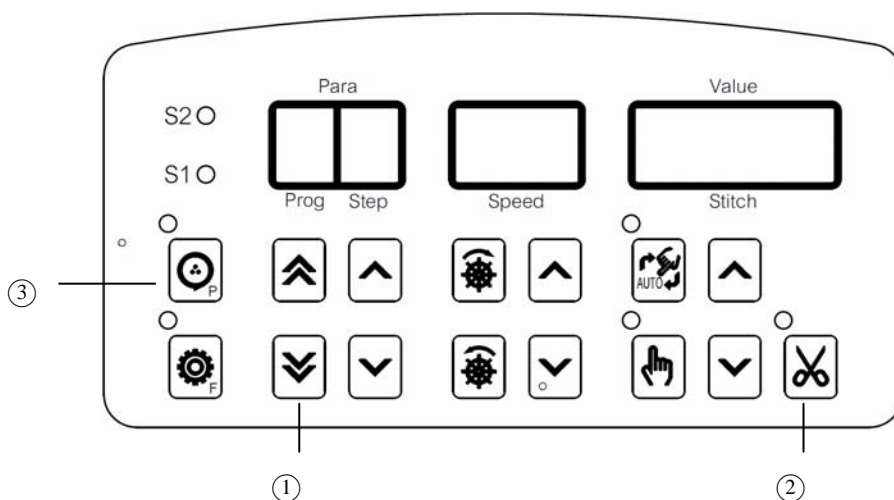
NO.	Name of parameter	Value	Range	Description																																																																		
01	tape	10	0~99	Meter of feeding, 00=35mm, increases 1=1mm,99=134mm																																																																		
02	sp	50	0~99	Feeding speed , 00=50mm,increase =1.9mm,99=238.1mm																																																																		
03	in_tr	0	0~99	Meter of pull back after fed, 00=0mm, increase 1=0.35mm,99=34mm																																																																		
04	cut_t	15	0~99	Cutter timing , 00=0.1s, increase 1=0.005s,99=0.6s																																																																		
05	cut_s	15	0~99	Stitch after cut off																																																																		
06	foot	0	1/ 0	on - 1 / off - 0 To select presser foot lift automatically or not																																																																		
07	v_off	10	0~99	Sewing stitch after thread suction stop																																																																		
12	Sp_co	0	0~9	<p>Compensation: Tape feeding may be uneven caused by different sewing speed.(More speed may cause bigger stitch)</p> <table border="1"> <thead> <tr> <th>rpm \ value</th> <th>300</th> <th>400</th> <th>500</th> <th>600</th> <th>7000</th> </tr> </thead> <tbody> <tr> <td>*0</td> <td>00</td> <td>00</td> <td>00</td> <td>00</td> <td>00</td> </tr> <tr> <td>1</td> <td>00</td> <td>00</td> <td>02</td> <td>02</td> <td>02</td> </tr> <tr> <td>2</td> <td>00</td> <td>00</td> <td>02</td> <td>02</td> <td>03</td> </tr> <tr> <td>3</td> <td>00</td> <td>02</td> <td>02</td> <td>02</td> <td>03</td> </tr> <tr> <td>4</td> <td>00</td> <td>02</td> <td>02</td> <td>03</td> <td>03</td> </tr> <tr> <td>5</td> <td>00</td> <td>02</td> <td>03</td> <td>03</td> <td>04</td> </tr> <tr> <td>6</td> <td>02</td> <td>03</td> <td>04</td> <td>05</td> <td>07</td> </tr> <tr> <td>7</td> <td>02</td> <td>04</td> <td>07</td> <td>09</td> <td>12</td> </tr> <tr> <td>8</td> <td>02</td> <td>05</td> <td>09</td> <td>13</td> <td>17</td> </tr> <tr> <td>9</td> <td>02</td> <td>05</td> <td>10</td> <td>14</td> <td>17</td> </tr> </tbody> </table>	rpm \ value	300	400	500	600	7000	*0	00	00	00	00	00	1	00	00	02	02	02	2	00	00	02	02	03	3	00	02	02	02	03	4	00	02	02	03	03	5	00	02	03	03	04	6	02	03	04	05	07	7	02	04	07	09	12	8	02	05	09	13	17	9	02	05	10	14	17
rpm \ value	300	400	500	600	7000																																																																	
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7	02	04	07	09	12																																																																	
8	02	05	09	13	17																																																																	
9	02	05	10	14	17																																																																	
17	sf_sw	3	0/1/2/3	<p>Mode of safety switch</p> <p>0: Normally open</p> <p>1: Normally close</p> <p>2: Permanently close, it run as overlock when the safety switch be open</p> <p>3: Disable safety switch</p>																																																																		
18	rest	0	1/ 0	no - 0 / run - 1 Return to factory preset value when parameter switch to run (need power on again)																																																																		

Content of parameter 2/2

NO.	Name of parameter	Value	Range	Description
30	knee	2	0/1/2/3/4	Function of knee switch 0: Invalid 1: Control MC cutter 2: Control ME cutter 3: Change program segment 4: Presser foot lift
31	ext	3	0/1/2/3/4	External key function 0: Invalid 1: Control MC cutter 2: Control ME cutter 3: Change program segment 4: Presser foot lift
34	psd	2	0/2/3	Code of sewing machine 0: For MC overlock 2: For ME, sew without fabric been detected 3: For ME, sew without fabric been detected; Sensor must be installed before using the Auto Mode('A')
35	psd_t	0	0 / 1	Sensor selection 0: Type a 1: Type b
39	MC_ra	1	0 / 1	MC Device gear ratio
40	PI_mo	0	0 / 1	When the presser foot is lifted, the blow function switch 0: Enable 1: Disable
41	smdir	0	0 / 1	cw – 0 / ccw – 1 clockwise/ counter clockwise for feeding motor
42	smcw	3	0~3	Feeding speed
43	smccw	3	0~3	The speed of the return
44	zig	0	-100%~100%	The scale of stepping motor moving back while process back tacking
45	s_con	0	0 ~ 9999	Sewing counter

VII. Function test mode

©In sewing mode, press  →  →  →  →  sequentially to enter function test mode:



①   Test parameter switch key

Description: Select the item to be tested.

②  Test key

Description: Executing the selected test function

③  Return

Description: Return to sewing mode

Content of parameter

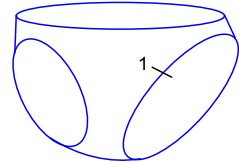
Name of parameter	Description
Foot	Presser foot test
Cut1	ME cutter test
Tension	Tension test
Vacuu	Rear suction test
Blow	Front suction test
Buzzer	Buzzer test
Cut2	MC cutter test
Stm	Stepping motor test
Aotorun	Stepping motor auto run test – long period
Aototur	Stepping motor auto run test – turn running

VIII. Operation

©MC(feeding device + over lock)pleases check parameter 34 must set at off before operation.


MC example 1. Sewing one single opening of underwear in single program step, cut manually , feed speed 55

Step	Speed	Stitch
01	55	MAN




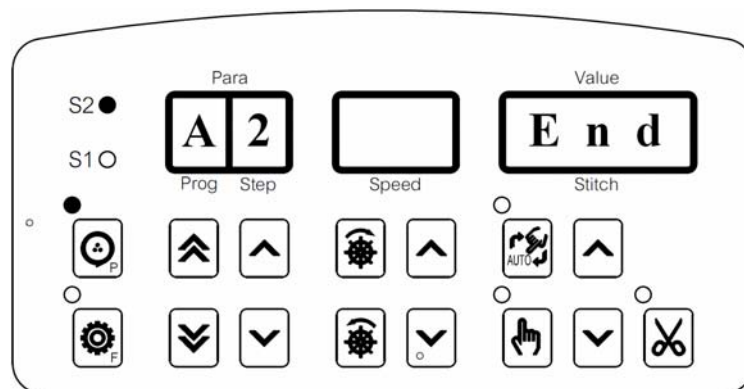
Procedure 1. In sewing mode, press  key to enter editing mode


Procedure 2. Set 55 at speed column in step 01

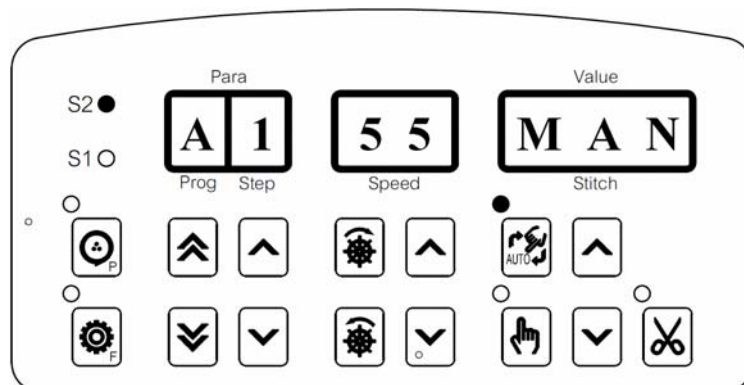
Procedure 3. Press  key LED OFF to set “MAN” at mode column in step 01

Procedure 4. Pleases check the speed column at step 02 must set “end” , if not pleases move to step

02 and press  key to set “end”. Illustration as below:

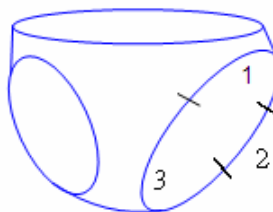


Procedure 5. Press  key to return to sewing mode , illustrated below if setting completed





MC example 2. Sewing single opening of underwear , set three program steps , step 01 & step 02 are auto mode , step 03 is manual


Step	Speed	Stitch	Correction
01	80	125	50
02	30	55	20
03	50	MAN	0




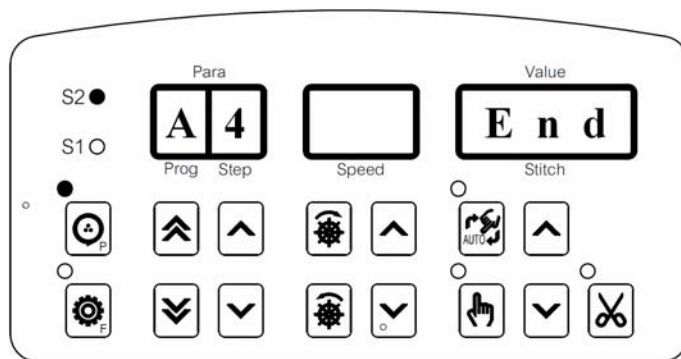
Procedure 1. In sewing mode , press  key to enter editing mode


Procedure 2. Set speed:80, stitch:125 in step 1 , press  LED OFF , changes stitches to 50

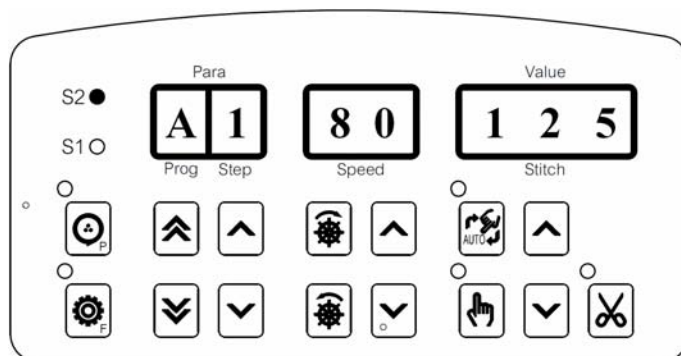
Procedure 3. Set speed:30, stitch:20 in step 2 , press  LED OFF, changes stitches to 55

Procedure 4. Set 50 at speed column in step 03 , set 'MAN' at mode column in step 03 while press  key LED OFF

Procedure 5. Please check the speed column at step 04 must set "end" , if not please move to step 04 and press  key to set "end" . Illustration as below:

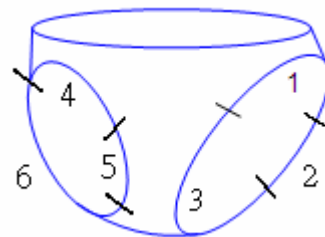


Procedure 6. Press  key to return to sewing mode, illustrated below if setting completed:





MC Example 3. sewing two opening of underwear at 6 program steps, set step 01 & step 02 auto mode, step 03 manual , step 04 & step 05 auto mode , step 06 manual



Step	Speed	Stitch	Correction
01	80	125	50
02	30	55	20
03	50	MAN	20
04	70	50	40
05	30	75	40
06	70	MAN	





Procedure 1. In sewing mode , press  key to enter editing mode


Procedure 2. Set speed:80, stitch:125 at step 1 , press  LED OFF , changes stitches to 50.


Procedure 3. Set speed:30, stitch:20. at step 2 , press  LED OFF , changes stitches to 55


Procedure 4. Set speed:50, at step 3 , press  key LED OFF to set “MAN”at mode column n step 03 , press  key to set trimming mode at same time

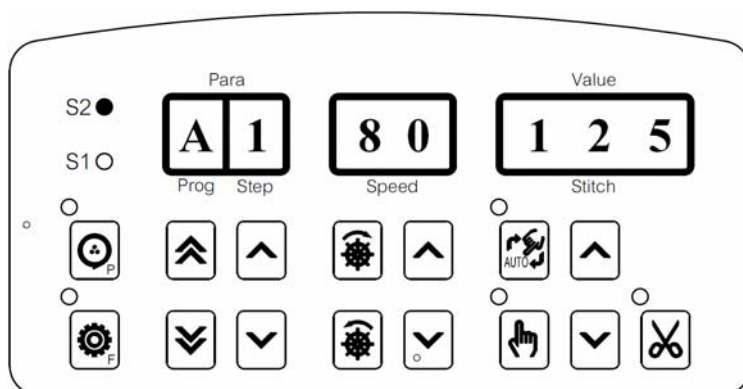
Procedure 5. Set speed:70, stitch:40. at step 4 , press  LED OFF , changes stitches to 50

Procedure 6. Set speed:30, stitch:75 at step 5 , press  LED OFF , changes stitches to 40.

Procedure 7. Set 70 at speed column in step 06 , press  key LED OFF to set ‘MAN’ at mode column in step 06

Procedure 8. Pleases check speed column in step 07 must set “end” , in case the speed column is not set at “end” pleases move to step 07 and press  key to set “end” at speed column.

Procedure 9. Press  key to return back to sewing mode , illustrated as below:



IX. Tip Code list and Error Code list

For operation box:

Tip Code	Message	Comment
E098	successfully saved	factory preset value saved successfully
E099	please reboot	Has returned to factory preset value, please restart the power

For operation box:

Error Code	Message	Comment
E000	SAFETY LOCK-ON	Safety switch installation errors, check the safety switch or parameter 17
E100	No response from front panel	Operation box can not communicate to control box, please check the operation box cable is plugged in or plugged into the wrong connector.

For control box:

Error Code	Cause of the problem	Comment
ER0.9	<ol style="list-style-type: none"> 1. Machine solenoid shorted. 2. Main board's power transistor is faulty. 	<p>All output signals and Operation box's pattern Sewing function will be invalid.</p> <p>Please check machine's solenoids.</p> <p>Please check all the power transistors which related To solenoid.</p>

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