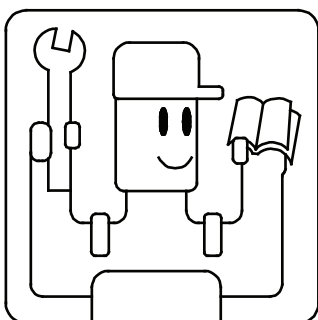


MCA 20Z-19

電子送帶機安裝手冊

THE INSTALLATION GUIDE BOOK



- 安裝前，請詳細閱讀安裝說明書
- PLEASE READ INSTRUCTIONS & ASSOCIATED DRAWINGS BEFORE INSTALLATION

目錄

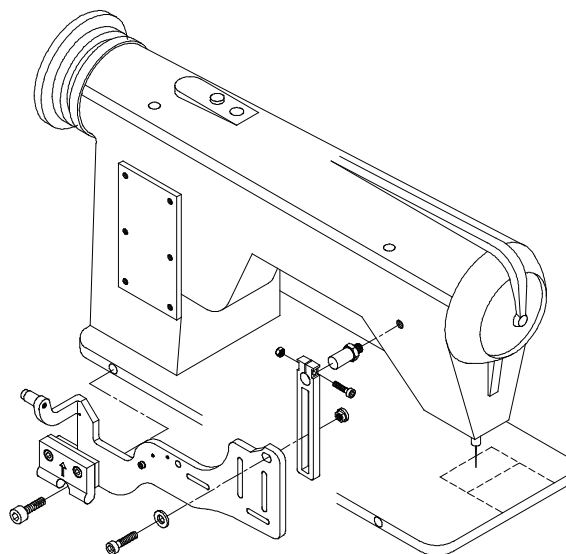
Index

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組合圖 Assembly Combination	2-3
接線圖 Wiring Diagram	4-5
管路圖 Air Hose Diagram	6
零件圖 Parts List	7-8
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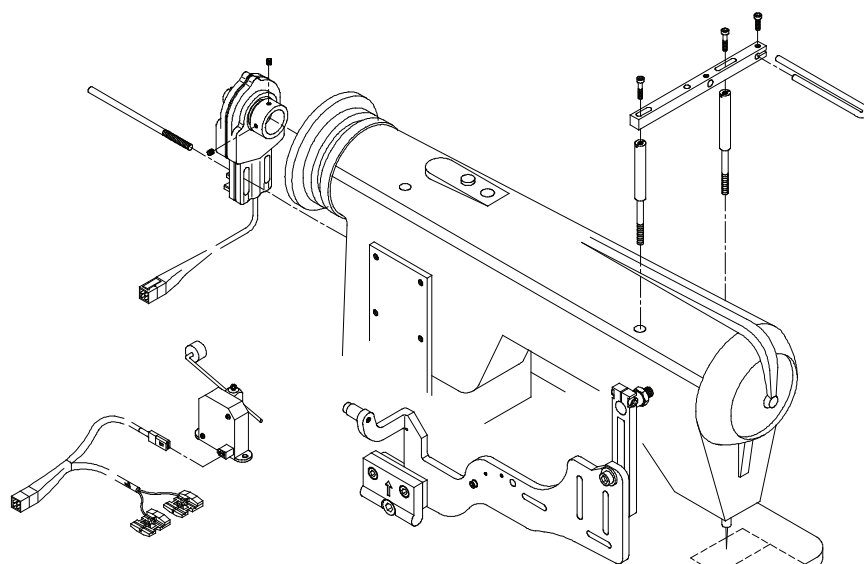
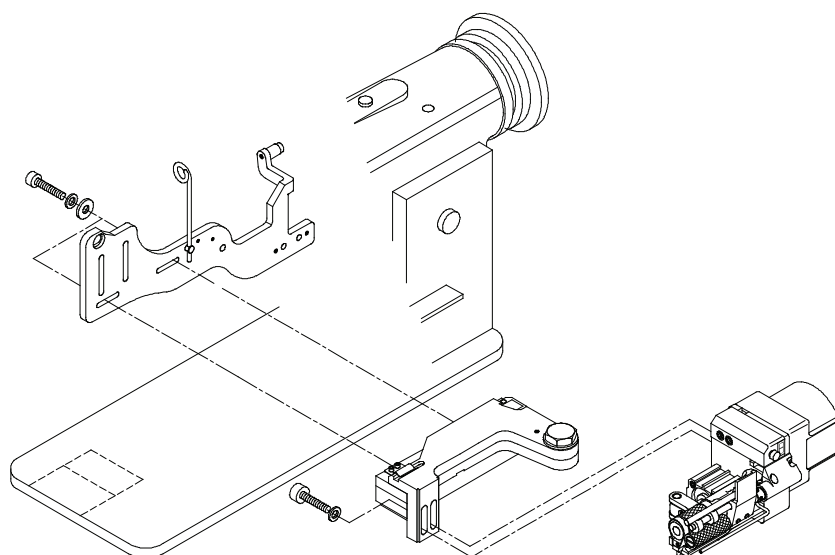
MCA20Z 組合圖

MCA 20Z Assembly Combination

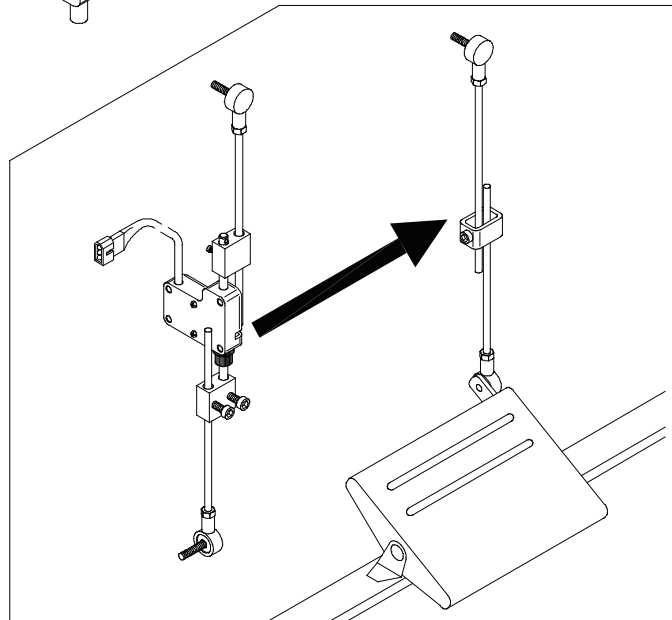
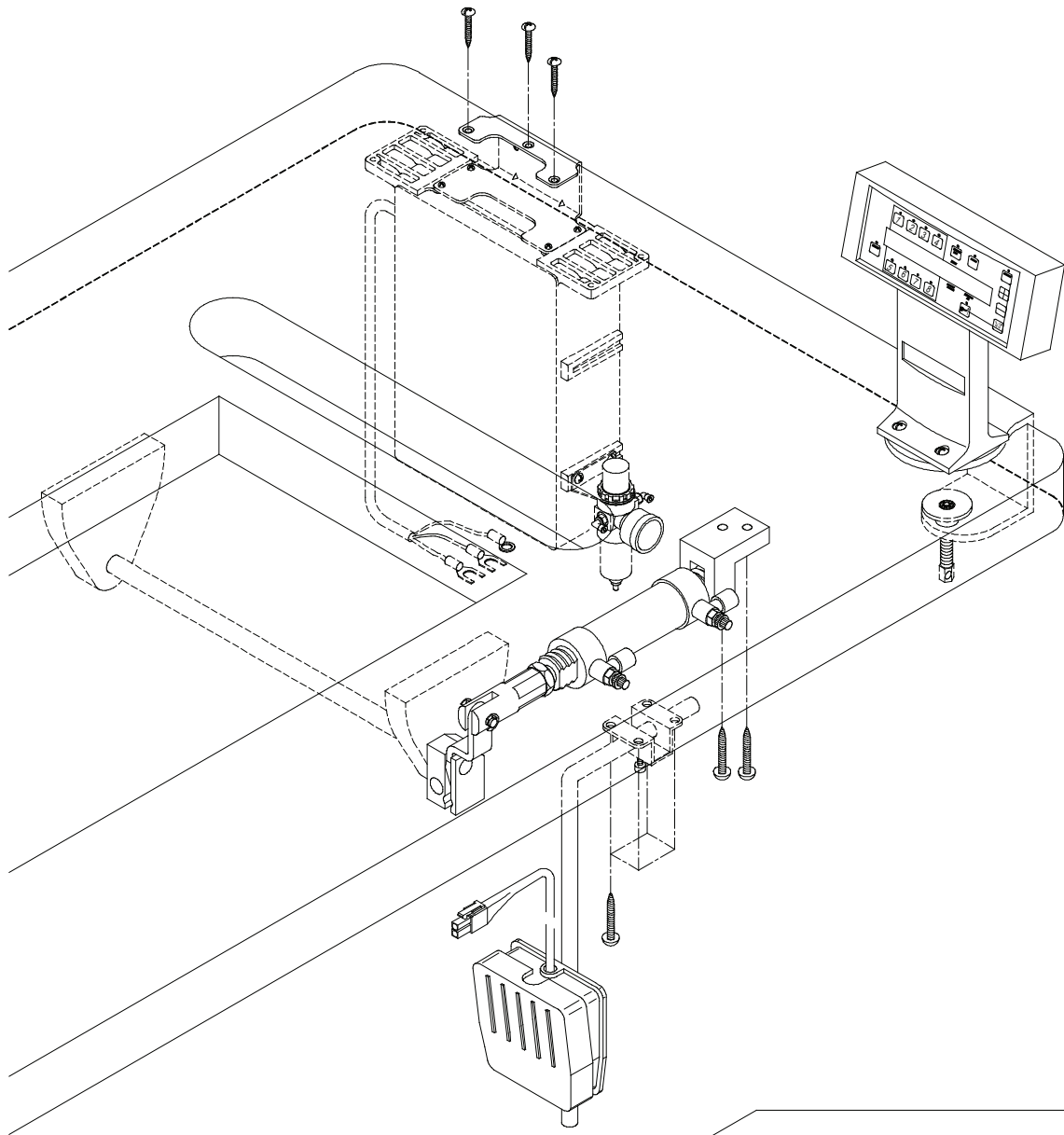
A: 支架
A: BRACKET



B: 主機組
B: MAIN MECHANISM

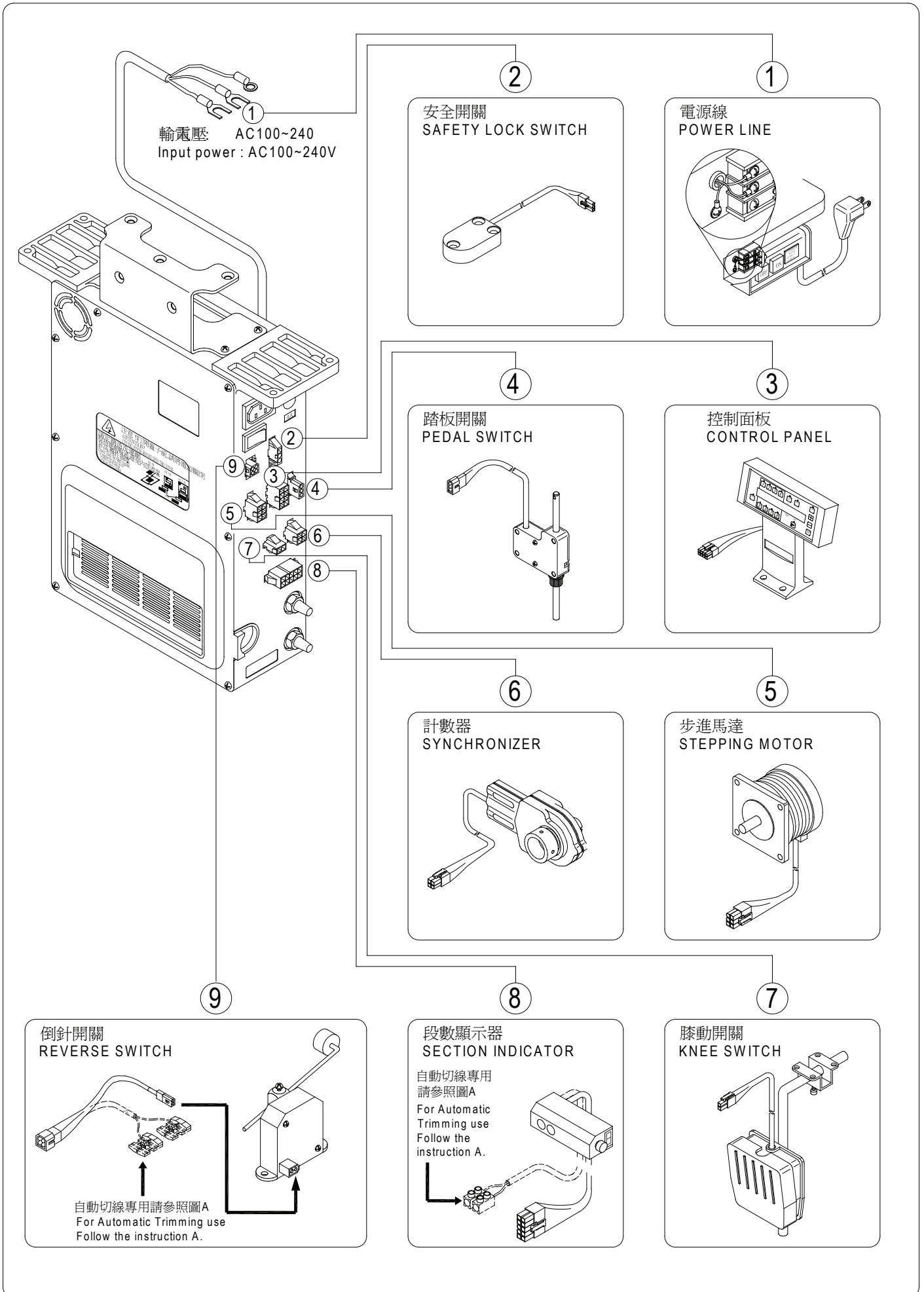


MCA20Z 組合圖
MCA 20Z Assembly Combination



MCA20Z 接線圖

MCA 20Z Wiring Diagram

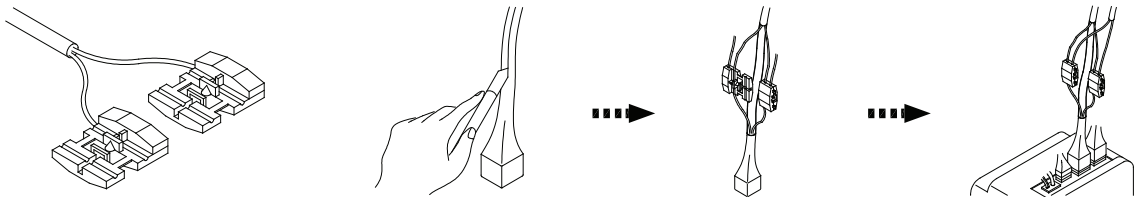


MCA20Z 接線圖
MCA 20Z Wiring Diagram

自動切線專用
Instruction A automatic-trimming

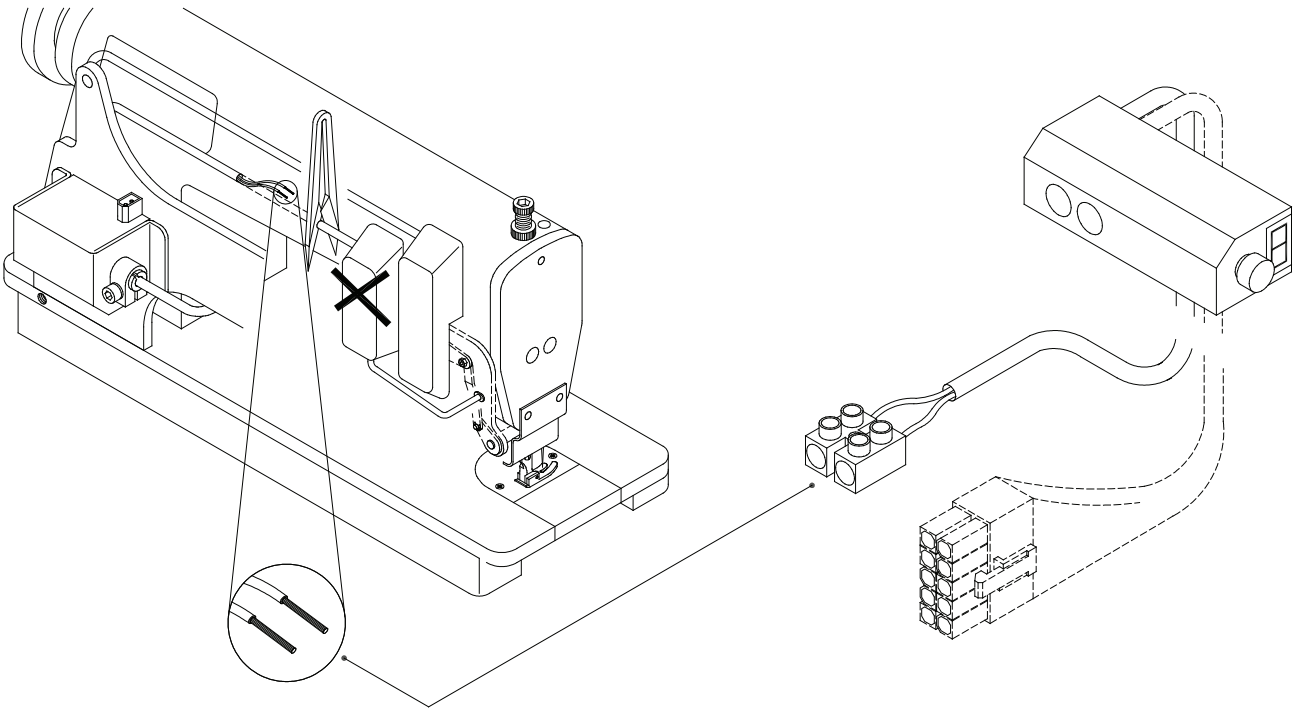
接於自動切線針車倒針用電磁電源上 (DC24 ~ 48V)
Finding and connecting the power cords of auto-reverse solenoid (DC24 ~ 48V)

無自動切線之針車此線無需使用並將蓋子蓋上
For nonautomatic-trimming machine, keep this wire connector.



插頭形狀 Pin alignment	針車廠牌 Machine brand	適用機型 Applicable Models	使用番號 Auto-reverse cord no.
	JUKI	DDL-555-4	A 3 4
		DDL-555-5 DDL-5550-6	B 7 8
		DDL-5550-7 DDL-9000	C 6 13
	BROTHER	BROTHER SERIES	B 10 11
		BROTHER S-7200	C 5 12
	SINGER	SINGER SERIES	A 1 2
	TOYOTA	LS2-AD158	A 3 4
	MITSUBISHI	DA-1200 SERIES	B 1 4
		LS2-180 DB189 LS2-190	B 11 12

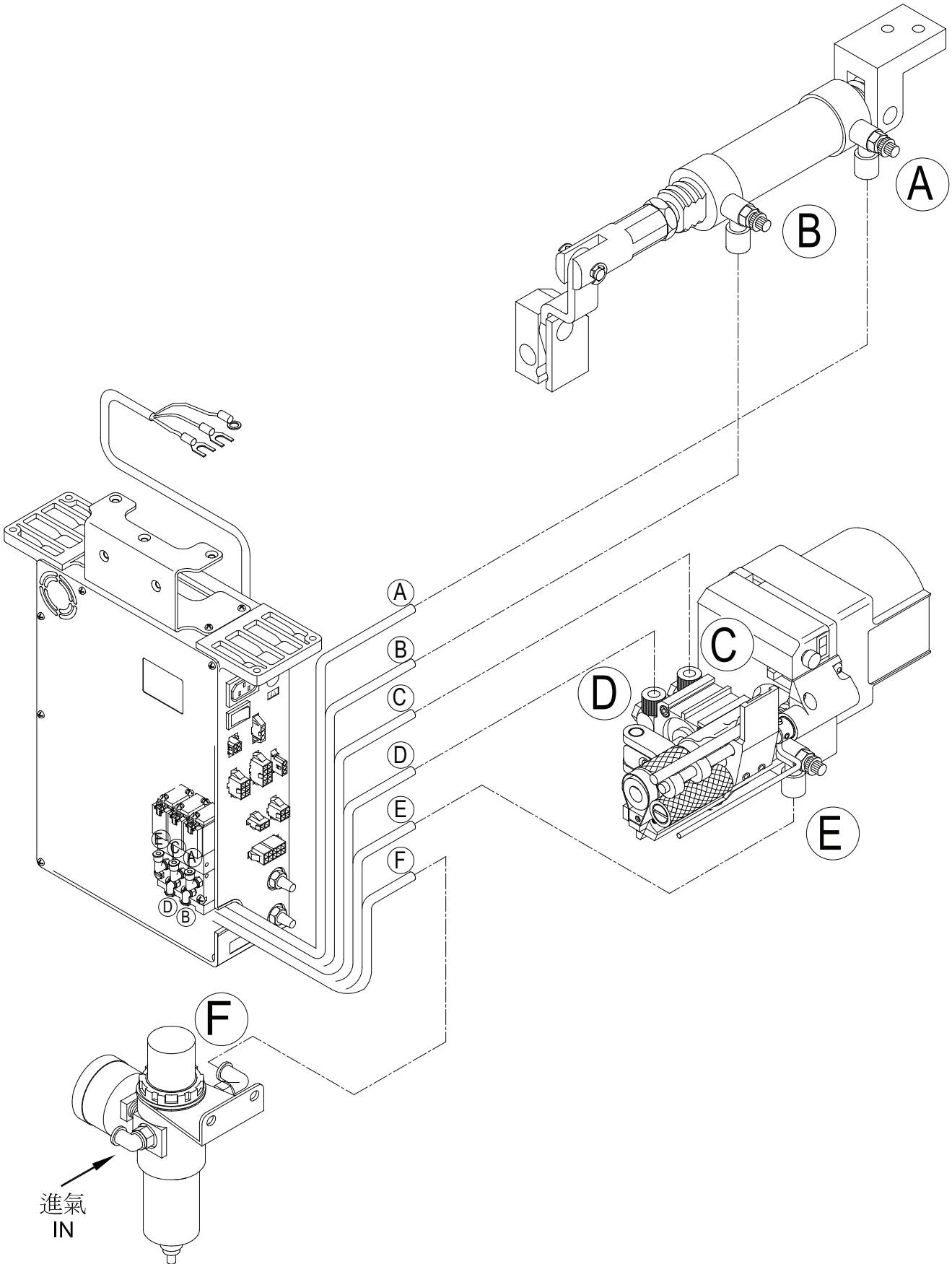
觸摸式倒針開關盒移位接線圖
The instruction of the relocation assembly tooch-back box.



MCA20Z 管路圖

MCA 20Z Air Hose Diagram

空壓壓力：最小 4 kgf / cm²
 Pressure Air : Min. 4 kgf / cm²



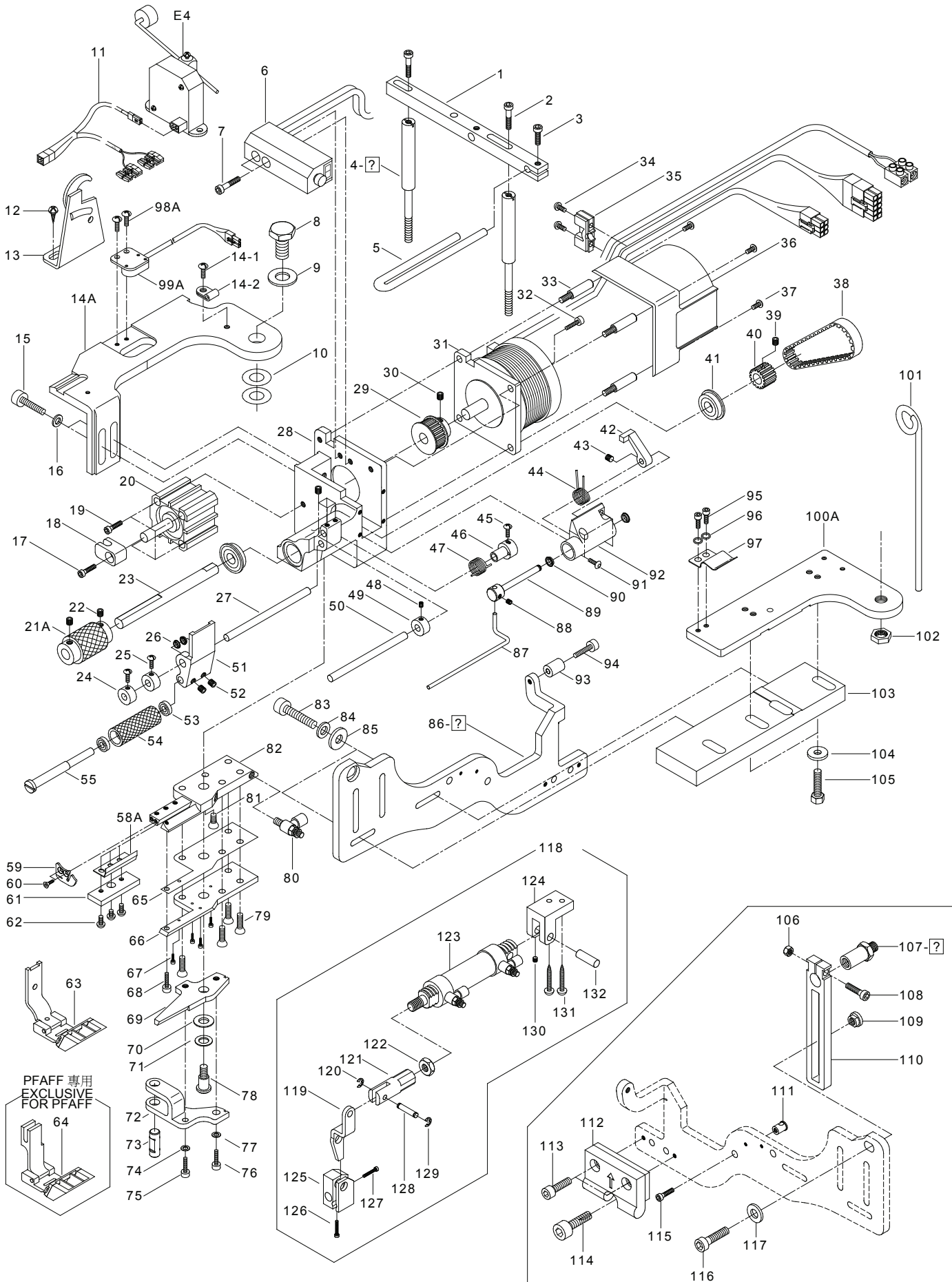
MCA20Z 零件圖

MCA 20Z Parts List

記號說明：

Mark description :

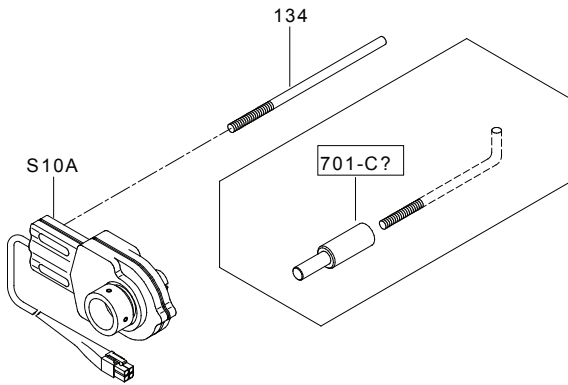
 選擇性配件
Optional parts

 選擇性配件,請告知針車廠牌機型
Optional parts, please indicate sewing machine model no.


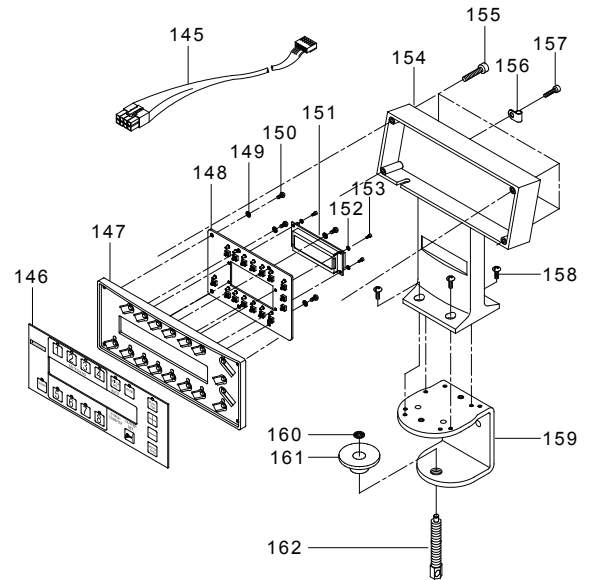
MCA20Z 零件圖

MCA 20Z Parts List

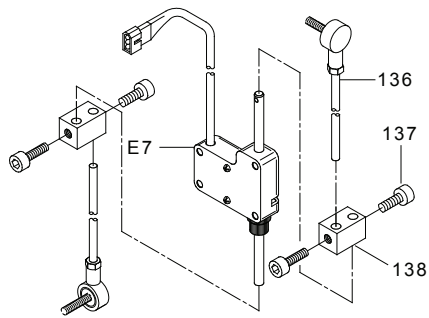
133



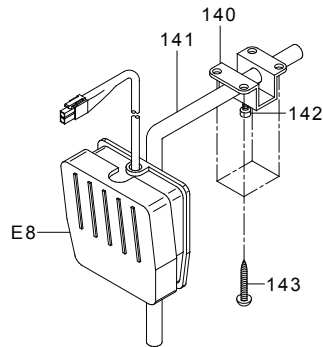
144



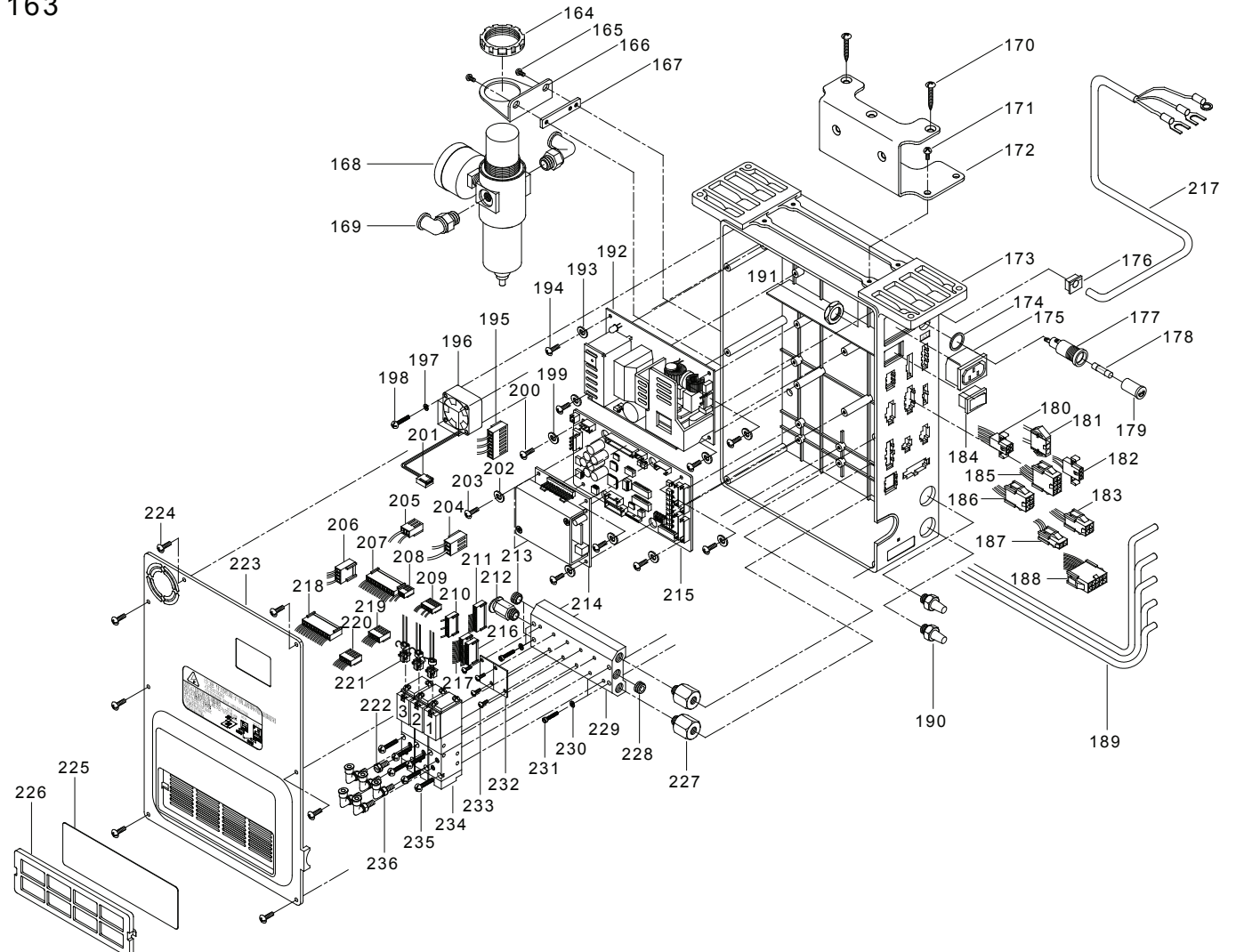
135



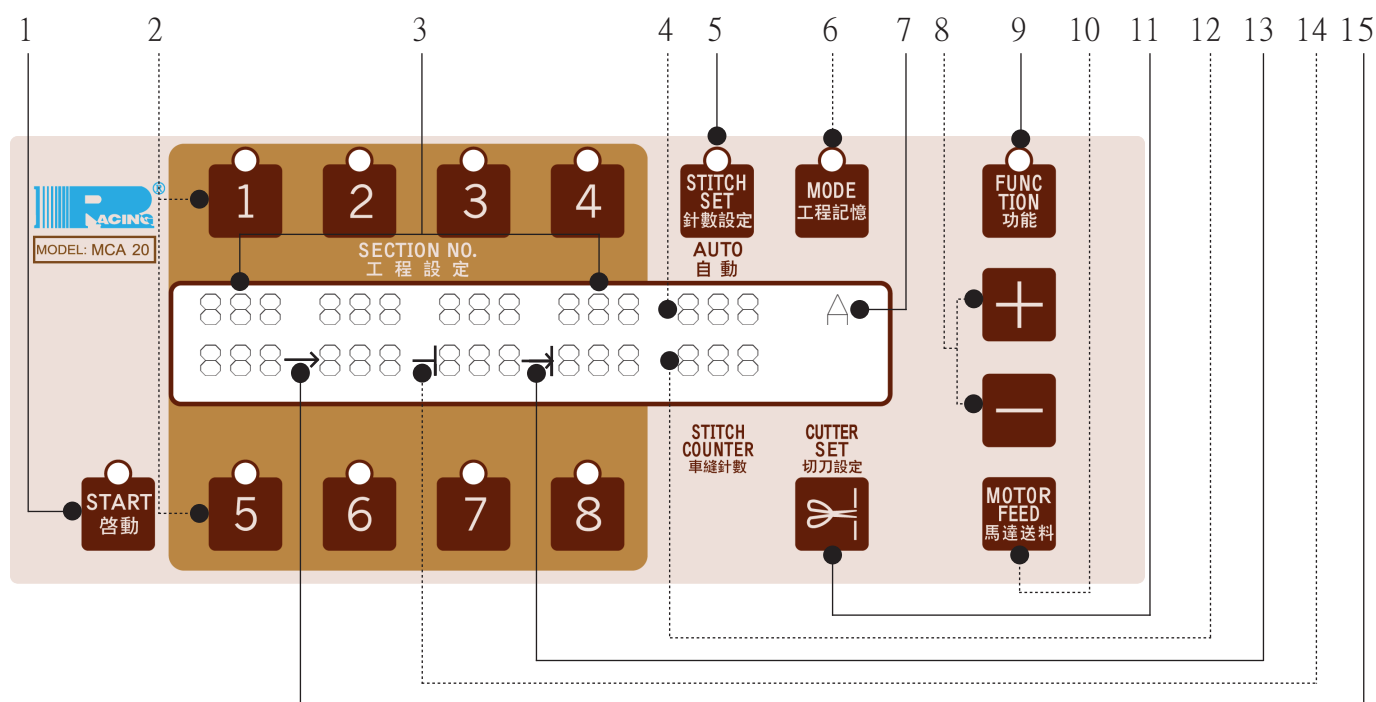
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操控說明 OPERATION GUIDE



視窗及按鍵說明：

- | | |
|---------------|------------------------------------|
| 1. 啟動鍵： | 進入車縫模式用。 |
| 2. 工程設定選擇鍵： | 共有八段工程可供設定鬆緊度。 |
| 3. 送料值顯示窗： | 顯示各段工程鬆緊度之設定值，一共有八段，每段設定值均可從1~999。 |
| 4. 針數設定顯示窗： | 顯示針數設定數值，空白或1~999。 |
| 5. 針數設定鍵： | 於自動換段車縫時設定使用。（參照第14~16頁） |
| 6. 工程記憶鍵： | 可儲存26組(A~Z)不同工程內容的資料。（參照第16頁） |
| 7. 工程記憶顯示窗： | 顯示工程記憶之設定值(A~Z)。 |
| 8. +，- 鍵： | 使用+，- 鍵來更改各項功能的設定數值。 |
| 9. 功能設定鍵： | 特殊功能設定。（參照第10頁） |
| 10. 馬達送料鍵： | 按此鍵時馬達運轉，送入鬆緊帶。 |
| 11. 切刀設定鍵： | 設定段落切帶。（請參照第15~16頁） |
| 12. 針數顯示窗： | 顯示車縫時的針數，最多針數999針。 |
| 13. 段落自動切帶符號： | → 顯示段落自動切帶。 |
| 14. 段落切帶符號： | — 顯示段落手動切帶。 |
| 15. 自動換段符號： | → 顯示自動換段。 |

Control Panel Instructions:

- | | |
|-------------------------------|--|
| 1. START : | Press Start to normal sewing operation. |
| 2. SECTION TENSION : | To set each Sections' tension, Up to 8 different Sections per program. |
| 3. SECTION PANEL : | Displays all the Sections' status from 1~999. |
| 4. STITCH DISPLAY : | Indicate the number of stitches to be sewn from 1~999 for Auto section change. |
| 5. STITCH SET : | Stitch count setting. (page14~16) |
| 6. MODE : | Use this key to memorise up to 26 different programs from A~Z. (Page16) |
| 7. MODE DISPLAY : | Indicates the Mode which you have set (A~Z). |
| 8. + , - KEY : | Use the + , - key to Adhust all settings. |
| 9. FUNCTION SETTING KEY: | Press this key to activate for setting the SPECIAL functions. (Page 10) |
| 10. MOTOR FEED : | Press this key to set the elastic tape. |
| 11. CUTTER SET : | To cut the elastic tape between sections.(Page15~16) |
| 12. COUNTER DISPLAY: | Indicate the number of stitches sewn up to 999. |
| 13. AUTO CUT SIGN: | → Indicate To cut the elastic tape between sections by Stitch Cunter. |
| 14. CUT SIGN: | — Indicate To cut the elastic tape between sections. |
| 15. Auto Section Change Sign: | → Indicate Auto change to the next section. |

操控說明 OPERATION GUIDE

功能: FUNCTION:

01. 進帶長度 (00= 35mm 每增加1=1mm, 99=134mm)
Length of Inserting Tape (000=0mm, Every 1 unit=1mm, 99=134mm)
02. 進帶速度 (00=50mm/秒 每增加1=1.9mm/秒. 99=238.1mm/秒)
Speed of Inserting Tape
(00=50mm/Sec., Every 1 unit=1.9mm/Sec., 99=238.1mm/Sec.)
03. 始縫時鬆緊帶回拉 (00=0mm 每增加1=0.35mm, 99=34mm)
Pull back tape at beginning sewing
(00=0mm, Every 1 unit=0.35mm, 99 = 34mm)
04. 切刀吻合時間 (000= 0.01秒 每增加1=0.01秒, 99=1秒)
Cutter Timer (00=0.01Sec. Every 1 unit=0.01Sec. 99=1Sec.)
05. 切刀後,車縫針數. TR與真空吸風裝置會啓動 (TR專用)
(00=0針 每增加1=1針, 99=99針)
Stitch after Cut to Active TR and Vacuum device (For TR deviceOnly)
(00=0 stitch, Every 1 unit=1 stitch, 99=99 stitch)
06. ON:車縫完成停止後押腳自動提昇進帶
ON: Pressure Foot lifted up and Insert the Tape after completely operation.
07. 始縫時,真空吸風裝置動作針數 (TR專用)
(00= 0針 每增加1=1針, 99=99針, ON=連續吸風)
Vacuum Activates stitch at beginning sewing (For TR device Only)
(00=0 stitch, Every 1 unit=1 stitch, 99=99 stitch, ON=Non-stop)
08. 開始送帶針數 (00=0 針 每增加1=1針, 99=99針)
Stitch for Start Feed Tape (00=0 stitch, Every 1 unit=1 stitch, 99=99 stitch)
09. 切刀後送帶長度
(00= 0mm 每增加1=0.35mm, 99=34mm)
Feed Tape after Cut
(00=0mm, Every 1 unit=0.35mm, 99=34mm)
10. 切刀後張力控制器 (RTA專用)
(OFF=關, 01=1針 每增加1=1針, 99=99針)
Ending Tape tesnion after Cut (For RTA device Only)
(OFF= No function, 01=1stitch, Every 1 unit=1stitch, 99=99stitch)

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
01	INSER	TAPE	LENGTH		20
5	6	7	8	STITCH COUNTER 車縫針數	
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
02	INSER	TAPE	SPEED		50
5	6	7	8	STITCH COUNTER 車縫針數	
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
03	INSER	TAPE	TENSION		00
5	6	7	8	STITCH COUNTER 車縫針數	
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
04	CUTTER	TIMER			30
5	6	7	8	STITCH COUNTER 車縫針數	
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
05	END	V-ON	STITCH		15
5	6	7	8	STITCH COUNTER 車縫針數	
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
06	AUTO	FOOT	UP		OFF
5	6	7	8	STITCH COUNTER 車縫針數	
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
07	START	V-OFF	STITCH		10
5	6	7	8	STITCH COUNTER 車縫針數	
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
08	START	TENSION	STITCH		03
5	6	7	8	STITCH COUNTER 車縫針數	
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
09	FEED	TAPE	AFTER CUT		00
5	6	7	8	STITCH COUNTER 車縫針數	
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
10	TAPE	ENDING	TENSION		OFF
5	6	7	8	STITCH COUNTER 車縫針數	

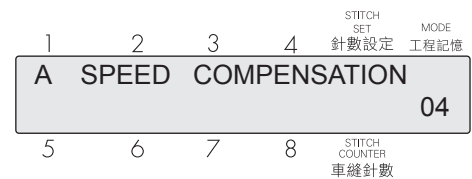
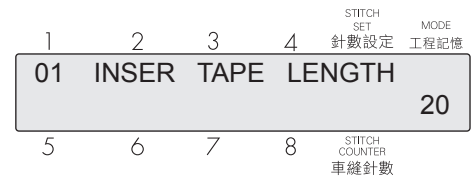
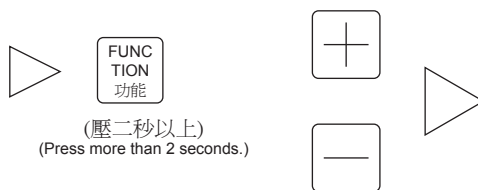
操控說明 OPERATION GUIDE

專業功能: ADVANCE FUNCTION:

- A. 速度補償: 依車縫速度越, 補償送料值.
A. Speed Compensation: Compensation Feed by different sewing speed.



操作說明:
Operation Guide:

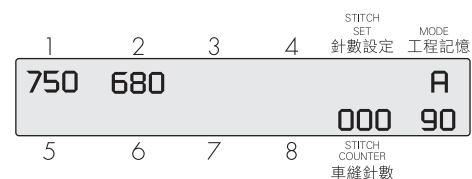
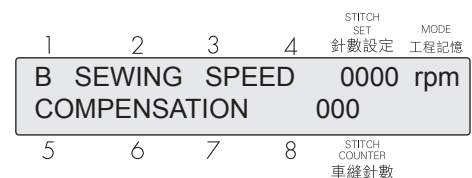


補償表
Setting List

* 出廠設定
Default

設定值 SETTING 車速 R.P.M.	0	1	2	3	*4	5	6	7	8	9
3000	000	000	000	000	000	000	010	010	010	010
4000	000	000	000	010	010	010	020	030	040	040
5000	000	010	010	010	010	020	030	050	070	080
6000	000	010	010	010	020	020	040	070	100	110

- 車縫狀態檢視: 可檢視車縫速度與補償值.
Sewing Statue Check: It can show the sewing machine Speed and Compensation Value.



操控說明 OPERATION GUIDE

符號說明：

Description for Special Figures Used In This Manual :



數值閃爍時,表示可修改.
Value can be adjusted when it is flashing.



表示自動換段.
Auto Sections Change by Stitch Counter-SY.



切刀後,前往下段工程.
Continue to next Section after Cut.



自動切刀後,前往下段工程.
Continue to next section after Auto Cut.

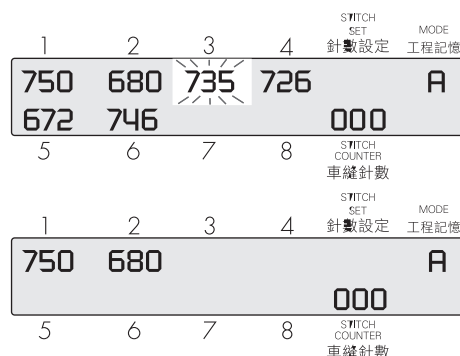
連續按兩下段數之數字鍵,可以刪除多餘的段數.
Push the section button twice to erase the extra sections.



操作說明:
Operation Guide:



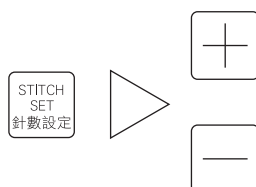
START
啟動



如需設定第一段之自動換段針數,按下”1”號鍵後按壓“針數設定”鍵,進入針數設定,以+ - 鍵來調整針數.
Press Section 1 key and then press Stitch Set button. You can adjust the stitch for Auto section change by press + - key.



操作說明:
Operation Guide:



START
啟動



連續按兩下針數設定鍵,可以解除自動換段功能.
Press the Stitch Set button twice to disable Auto function.



操作說明:
Operation Guide:



START
啟動



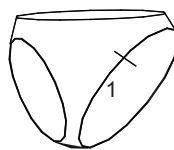
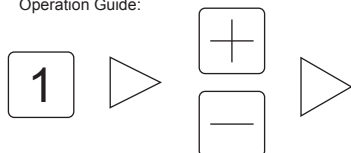
操控說明 OPERATION GUIDE

使用說明: Operation Guide:

例 一: 單一工程 Example 1: Single Section



操作說明:
Operation Guide:



工程 SECTION	送料 FEED	針數 STITCH
1	500	

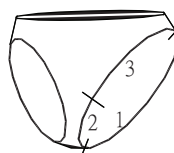
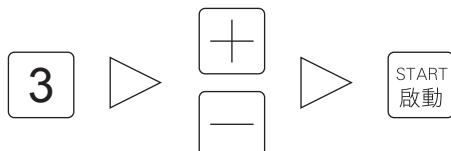
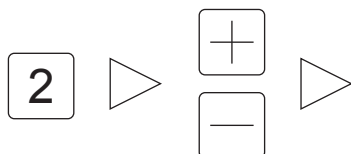
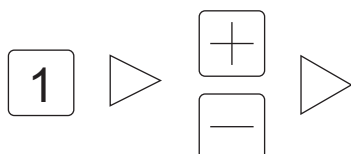
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
500	680				A
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
500					A
5	6	7	8	STITCH COUNTER 車縫針數	000

例 二: 三段手動換段工程 Example 2: 3 Sections by Manual



操作說明:
Operation Guide:



工程 SECTION	送料 FEED	針數 STITCH
1	700	
2	300	
3	700	

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
700					A
5	6	7	8	STITCH COUNTER 車縫針數	000

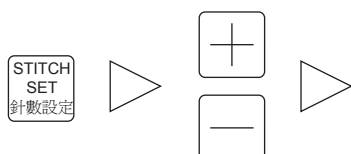
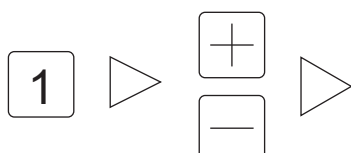
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
700	500				A
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
700	500	700			A
5	6	7	8	STITCH COUNTER 車縫針數	000

例 三: 一段工程 自動切刀 Example 3: 1 Section with Auto Cut



操作說明:
Operation Guide:



工程 SECTION	送料 FEED	針數 STITCH
1	500	165

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
500					A
5	6	7	8	STITCH COUNTER 車縫針數	000

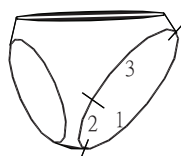
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
500 →				165	A
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
500 →				165	A
5	6	7	8	STITCH COUNTER 車縫針數	000

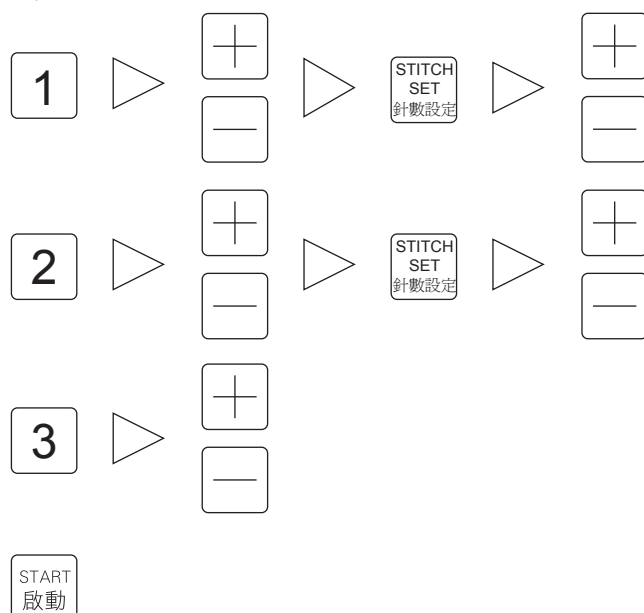
操控說明 OPERATION GUIDE

例 四: 三段工程. 一、二段自動換段,
三為手動切刀

Example 4: 3 sections, Section1 & 2 are Auto
Section 3 is Manual.



操作說明:
Operation Guide:

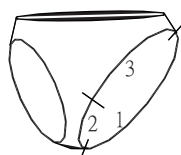


工程 SECTION	送料 FEED	針數 STITCH
1	700	150
2	300	75
3	700	

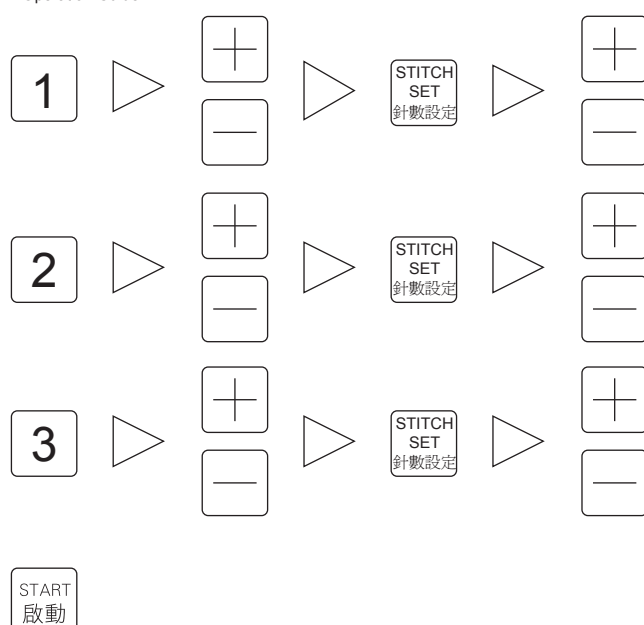


例 五: 三段工程. 一、二段自動換段,
三段為自動切刀

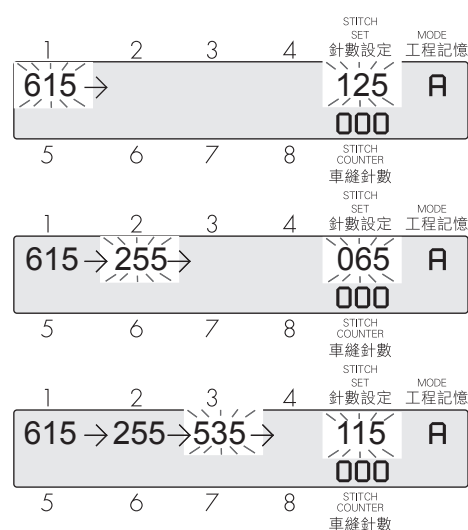
Example 5: 3 sections, Section1 & 2 are Auto
Section 3 is Auto cut.



操作說明:
Operation Guide:



工程 SECTION	送料 FEED	針數 STITCH
1	615	125
2	255	65
3	535	115



操控說明 OPERATION GUIDE

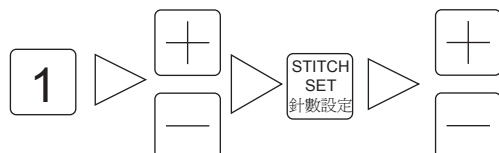
例 六: 褲腳左右兩邊車縫
左右兩邊褲腳各只有一段工程
鬆緊帶以針數自動切刀
啓縫時鬆緊回拉約1公分



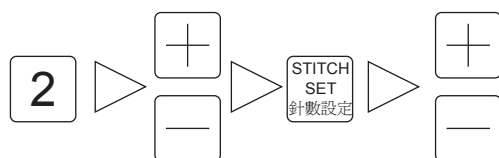
Example 6: Two leg openings of slaps
Each slip is with 1 section.
Tape Cut by Auto Stitch Counter
With about 1cm tape Pull Back function at beginning.



操作說明:
Operation Guide:



注意: 此符號意思為切刀後 會繼續下一段未完成的工程
Noticed: This sign is mean the section is not finish yet after section cut.

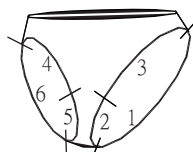


按功能鍵3次,進入
04 INSEr TAPE TENSION
Push Function Key to enter
03 INSEr TAPE TENSION



START
啟動

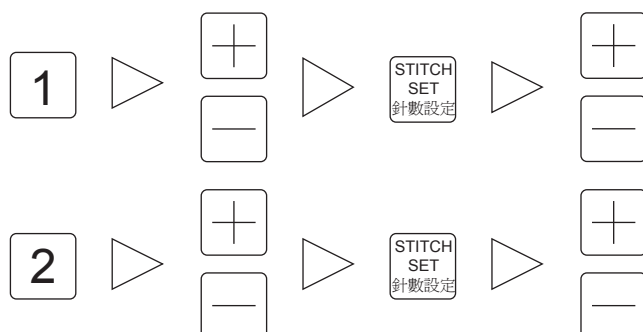
例 七: 褲腳左右兩邊車縫
左右兩邊褲腳各有三段工程
設定工程自動換段,手動切刀



Example 7: Two leg opening of slaps
Each slip is with 3 sections.
Section change by Auto, Cut by Manual



操作說明:
Operation Guide:



工程 SECTION	送料 FEED	針數 STITCH
1	355	215
2	366	223

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→			215	A
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→			215	A
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→	366	→	223	A
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
03	INSEr	TAPE	TENSION		30
5	6	7	8	STITCH COUNTER 車縫針數	

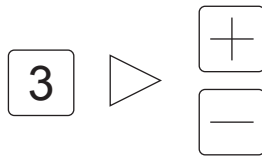
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→	366	→	215	A
5	6	7	8	STITCH COUNTER 車縫針數	000

工程 SECTION	送料 FEED	針數 STITCH
1	355	110
2	211	75
3	321	
4	315	105
5	208	68
6	334	

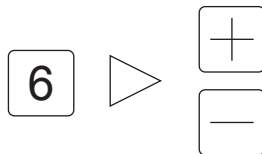
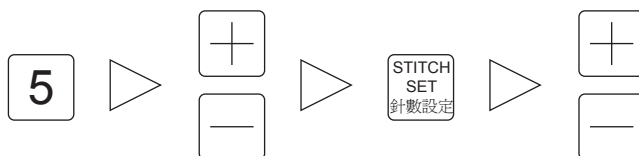
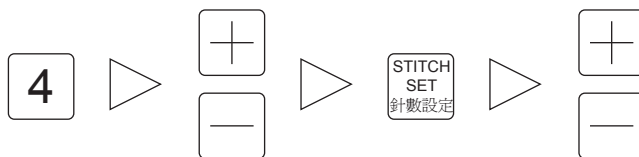
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→			110	A
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→	211	→	075	A
5	6	7	8	STITCH COUNTER 車縫針數	000

操控說明 OPERATION GUIDE



注意: 此符號意思為切刀後 仍有未完成的工程需進行
Noticed: This sign is mean the section is not finish yet after section cut.



1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→	211	→	321	A
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→	211	→	321	A
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→	211	→	321	A
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→	211	→	321	A
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→	211	→	321	A
5	6	7	8	STITCH COUNTER 車縫針數	000

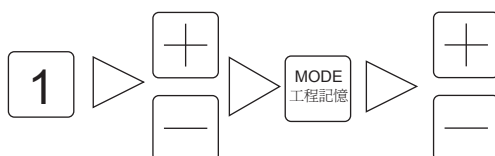
1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
355	→	211	→	321	A
5	6	7	8	STITCH COUNTER 車縫針數	000

例 八: 更換模式,由模式A換到模式B.

Example 8: Switch MODE form Mode A to Mode B



操作說明:
Operation Guide:



1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
841	851	861	871		B
5	6	7	8	STITCH COUNTER 車縫針數	000

1	2	3	4	STITCH SET 針數設定	MODE 工程記憶
841	851	861	871		B
5	6	7	8	STITCH COUNTER 車縫針數	000

故障排除

SOLUTION FOR ERROR FUNCTION

現 像	原 因	解 決 方 法
送帶機異常振動	1.送帶機與縫紉機銜接的螺絲鬆弛	1.參照第 2 頁重新固定
送帶機無動作	1.電源未接妥善 2.線路系統斷路 3.控制系統故障	1.參照第 4 頁設定 2.參照第 4 頁檢查各線路插座與插頭接腳是否鬆脫 3.通知維修人員進行更換維修
螢幕不顯示	1.面板故障	1.通知維修人員進行更換維修
模式數值無法記憶	1.記憶體故障	1.通知維修人員進行更換維修
送帶不順	1.送帶位置或裝置不當 2.吹氣孔氣量不足或位置不當	1.參照第 02 頁重新固定 2.參照第 02 頁固定調整

保固期限：壹年，日期如無法查證時以出廠日期起18個月為準確（不含時規皮帶）

Situation	Reason	Solution
Vibration	1. Fixed screw loosen.	1. Refer to the page 2
No signal	1. Power is not connecting properly. 2. Connecting wire is break. 3. Electronic control system error.	1. Refer to the page 4 2. Refer to the page 4, please check the pin of connecting plug or socket are not loose. 3. Please call the technician to maintain
Blank panel	1. Panel out of order.	1. Please call the technician to maintain
Cannot memory the Mode	1. Memory out of order.	1. Please call the technician to maintain
Inserting tape difficulty	1. Wrong position for the tape or the main device. 2. The air jet hole is in the wrong position or too less jet air.	1. Refer to the page 02 2. Refer to the page 02

Warranty: One year, or 18 months after manufactured date. (Timing belt is not under warranty)