C

全自动免烫贴袋机

Automatic Pocket Setter

（VI-168）

使用说明书

Instruction Manual

在使用本设备之前请先阅读本使用说明书
Please read the operation manual of the touch screen interface before using the device

请将本使用说明书放在便于查阅的地方保管
Please keep this operation manual of touch screen interface in convenient place for reference

版 本 信 息 /
Version

2022.08

感谢购买工业用缝纫机。
在使用此机器之前，请仔细阅读以下的说明，这样可以更好地帮到您了解此机器的相关 操作。
这些说明是根据现行的条例明确阐述了正确的工作方法。
Thank you for purchasing this industrial sewing machine

Before using this automatic unit, please read the following instructions, which will help you to understand how the machine operates.

These instructions illustrate the correct working methods to comply with current regulations.

我们将欣然接受各位提出的改进此说明书的任何建议和指示
We are happy to receive suggestions and/or indications on ways we could improve this manual.

中文

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一、设备基本信息

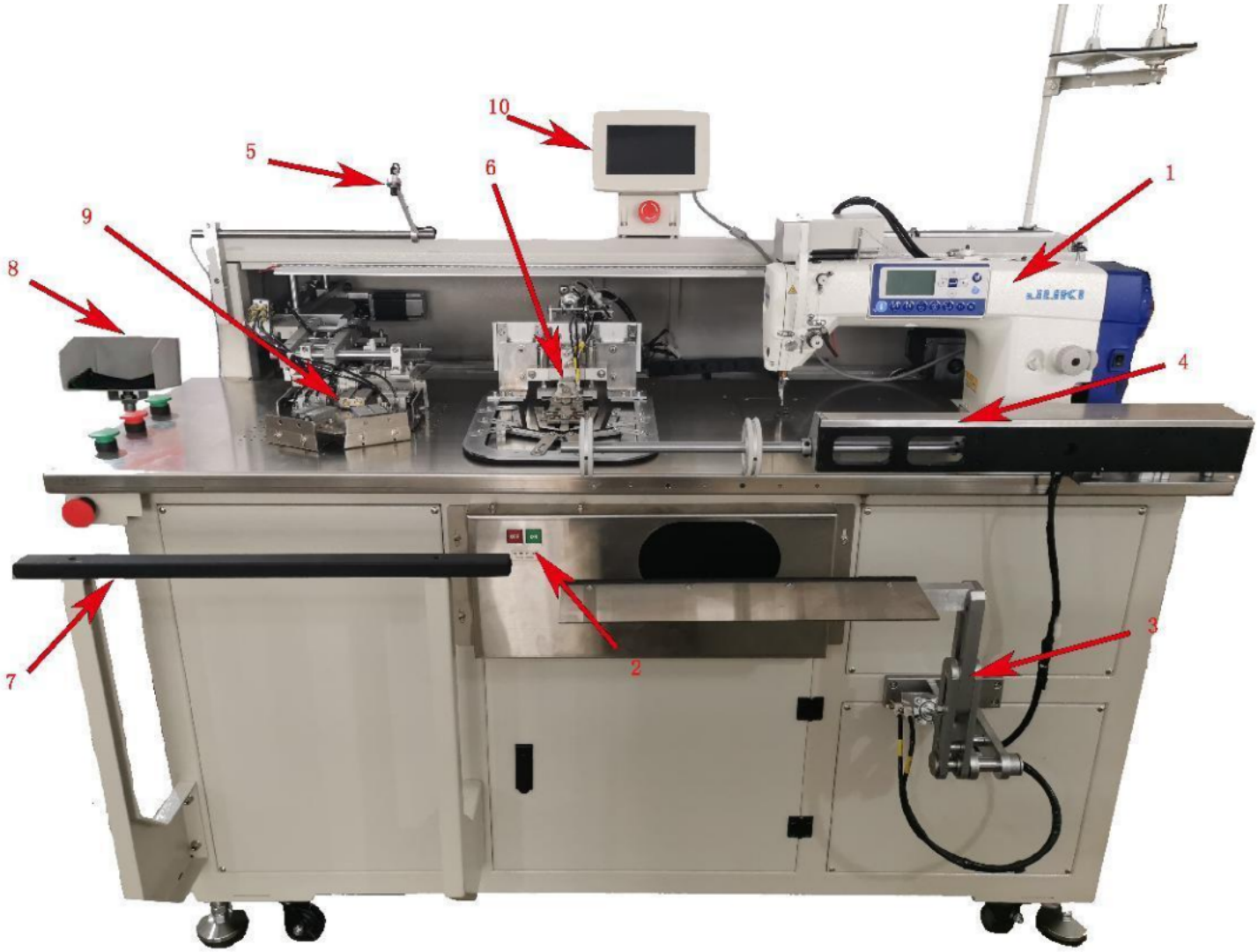


图1

1：机头；　　2：电源开关；　　3：收料装置；　　4：滚轮装置；　　5：红外定位装置；
6：伸缩模板结构；　　7：衣片放料架；　　8：口袋放料盒；　　9：折边器；　　10：触摸屏；

二、设备技术参数

VI-168贴袋机		
1	机头配置	默认JUKI8000A（可选配）
2	最快缝纫速度/rpm	3200
3	台板	不锈钢台板
4	工作电压/V	220
5	工作气压/MPA	0.6
6	主轴、X/Y 控制	步进马达
7	缝制针距长度/mm	1--5
8	工作效率	6个/min（按面料实际情况有所增减）
9	换模方式	快速整体换模
10	设备尺寸/mm	1600*900*1200
11	设备重量/kg	450
12	机针型号	DB*1/11-18
13	制作尺寸长宽（单位：mm）	210*200（超出该尺寸需特别定制） 定制极限尺寸230*260

三、安全注意事项

为了安全地使用自动机的注意事项

 危险	1. 为了防止因触电造成的事故，在接通了电源的状态下，请不要打开马达电气箱的盖子，也不要触摸电气箱内的零件。
 注意	1. 为了防止对人身的伤害，请不要在卸下了皮带护罩、手指防护器等安全装置的状态下运转机器。 2. 为了防止被卷入机器的人身事故，缝纫机运转中，请不要让手指、头发、衣服靠近皮带轮、V 型皮带、马达附近，也不要把物品放到上面。 3. 为了防止对人身的伤害，打开电源时或缝纫机运转中，请不要把手指放到机针附近。 4. 为了防止对人身的伤害，缝纫机运转中，请不要把手指放到挑线杆护罩内。 5. 缝纫机运转时，是以高速转动。为了防止伤害到手，运转中请绝对不要让手靠近切布刀。另外，更换机线时，请一定关闭电源。 6. 为了防止对人身的伤害，缝纫机上下动作时或返回原来位置时，请一定注意不要夹到手指。 7. 缝纫机运转中，请不要切断电源或切断空气供给源。 8. 为了防止突然的起动造成的事故，当准备工作完了，达到可以进行缝制的状态时，请卸下布料导向器。 9. 为了防止因触电造成的事故，在卸下电源地线的状态下，请不要运转缝纫机。 10. 为了防止因触电和电气零件损坏造成的事故，插拔电源插头时，请一定先关掉电源开关。 11. 为了防止因电气零件损坏造成的事故，打雷时，为了安全请停止作业，并拔掉电源插头。 12. 为了防止因电气零件损坏造成的事故，从寒冷的地方立即移动到温暖的地方等时会发生结露现象，因此请待水滴万全干燥之后再接通电源。 13. 因为本产品属于精密机器，所以操作时请充分注意，不要把水、油溅到机器上面，也不要让机器掉落给与机器冲击。 14. 本机器是 A 级工业用机器。在家庭环境下使用此机器的话，有可能发生电波干扰的现象。此时，请使用人采取适当的措施解决电波干扰问题。 15. 堆积器动作时关闭了电源开关之后，堆积杆动作，因此请注意不要夹到手指等。 16. 布压脚动作中关闭了电源开关之后，布压脚动作，因此请注意不要夹到手指等。 17. 折边机动作中，把手指放到折边机内时，请注意不要让气缸夹到手指。

*重要安全信息：

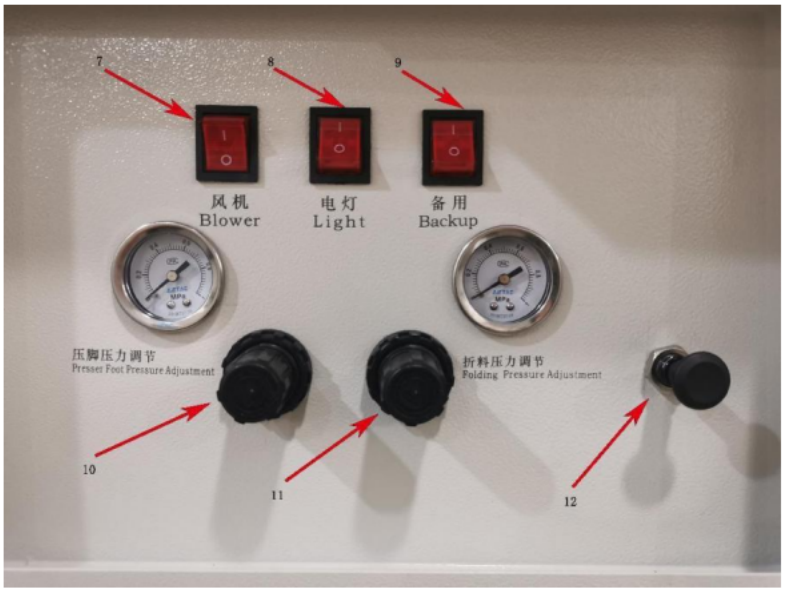
√对机器操作不当可能会导致人身伤害，请在操作前仔细阅读本说明并正确操作。
√机器正式运行通电前，请先通气。
√严禁在通电状态下打开电控箱或触摸屏内部零件。
√本机器需要在接受培训后或专人指导下使用，以确保使用者的人身安全。

四、按键功能说明

4. 1按键名称

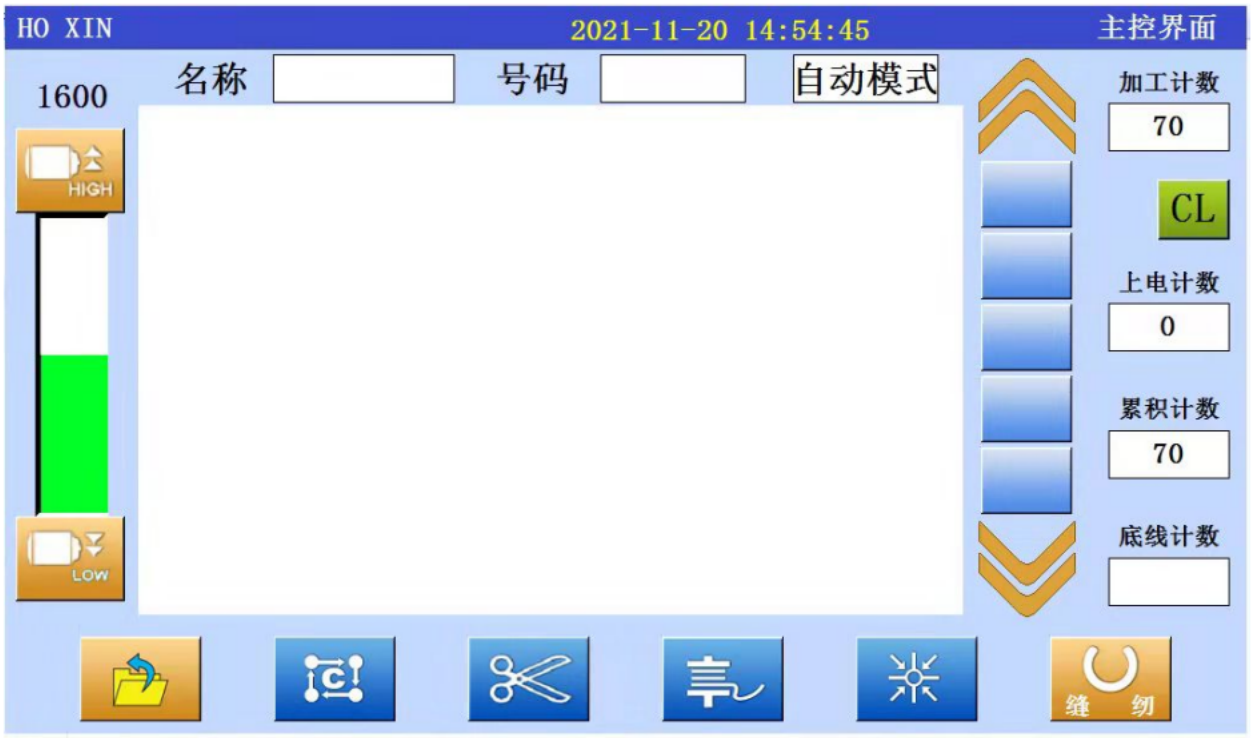
图2

1. 折料取消按钮---当折料装置折料不能达到预期，可按下此按钮及时调整。
2. 电源开关---控制设备电源按钮
3. 启动开关---正确放置袋片后，按下此按钮自动开始贴袋操作。
4. 对格开关---在贴袋前使用此开关可降下袋型版，用于对齐布料图样。
5. 无料启动---在贴袋前使用此开关可在断线情况下完成缝纫动作。
6. 急停开关---按下后设备即停止缝制动作。折料压力调节按钮---折料装置气管内压力调节。



7. 风机按钮---台板吸料风机开关按钮。
8. 电灯--- 设备灯光。
9. 备用（选配）--- 一般为后期升级功能预留按钮，也可作为红外激光定位开关。
10. 压脚压力调节按钮---压脚装置气管内压力调节。
11. 折料压力调节按钮---折料装置气管内压力调节。
12. 快速整体换模开关---开启后，模具可直接拔出更换。

a：主界面


HO XIN
2021-11-20 14:54:45
主控界面
1600
名称
号码
自动模式
HIGH
LOW
加工计数
70
CL
上电计数
0
累积计数
70
底线计数
缝 纫

b：缝制界面


HO XIN
2021-11-20 14:54:01
缝制加工
1600
名称
号码
自动模式
HIGH
LOW
加工计数
70
CL
上电计数
0
累积计数
70
底线计数
大压板
小压板
手动缝
花样修改
退 出

4.2. 复位操作说明

4.2.1 开机复位操作

步骤	说明	按键方法
1	开机	4.1（2）
2	复位	缝制界面 
3	切换缝纫模式	主界面

4.2.2 急停复位操作

按下急停后，复位的步骤：急停开关顺时针旋转复位，面料重新摆放。

五、操作说明

5.1 操作前准备工作

√ 操作人员检查时机头需处于停止状态
√ 检查压板海绵是否完好无损
√ 检查车缝线是否已经正确穿好
√ 检查机针是否已经安装完成
√ 清理机器台面上的杂物，确保机器运行过程中不会有杂物阻碍运行
√ 检查气压表压力，使其符合机器使用要求
√ 检查护眼板是否已经正确安装完成

5.2 操作过程说明

5.2.1 启动设备

按动电源开关 ON，设备通电开机。

图3

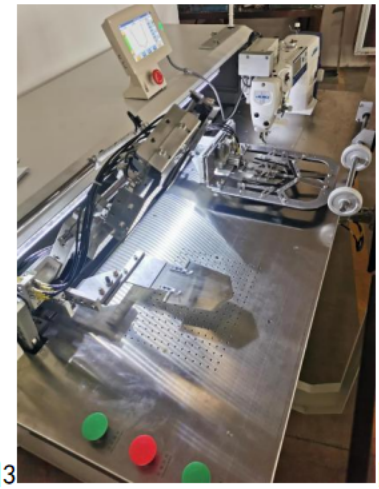


图4

5.2.2 复位操作

执行机器开机复位操作。请参考：4.2.1　开机复位操作后按下4.1.（7）风机开启键，吸风打开。图4为复位完成后的设备状态。

5.2.3 裁片摆放位置

按下4.1.（9）备用按键打开镭射灯准确对位，将大身摆放于如图5所示。

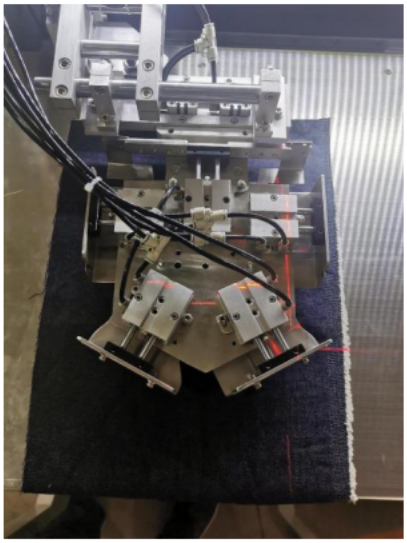


图5


图6

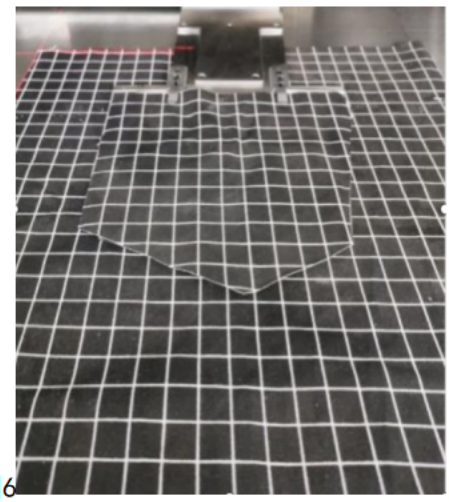


图7

5.2.4 口袋摆放

口袋裁片摆放如图6所示。

***放置口袋时如需要进行对格对条：按下4.1.（4）对格开关按钮，袋模板下降至台面，进行对格对条，如图7所示。**

5.2.5 自动折料启缝

1. 按下 4.1（3）启动开关，折边器压下后自动折边（见图8）
2. 送布板左移至袋模板上方后，下压压住口袋，袋模板向后撤出，送布板右移开始缝制如下图9
3. 缝纫完成自动收料，送布板回至原点。

送布板右移缝制区域，左侧可继续放置裁片，依次循环操作。


图8

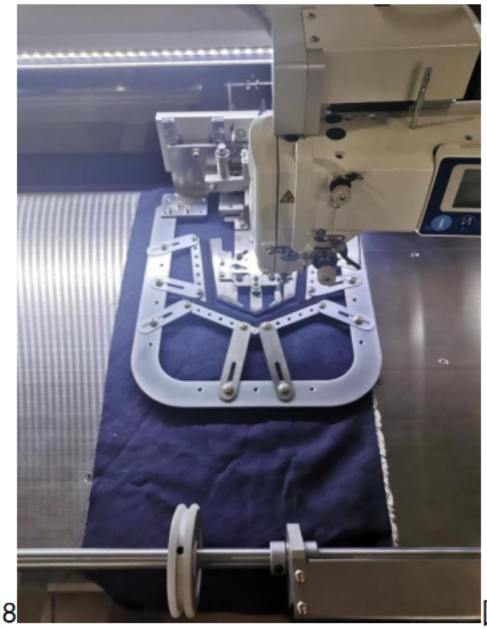


图9

5.2.6 关机

操作完毕，按动电源开关 OFF，设备关机。

六、调试方法

6.1 模具位置

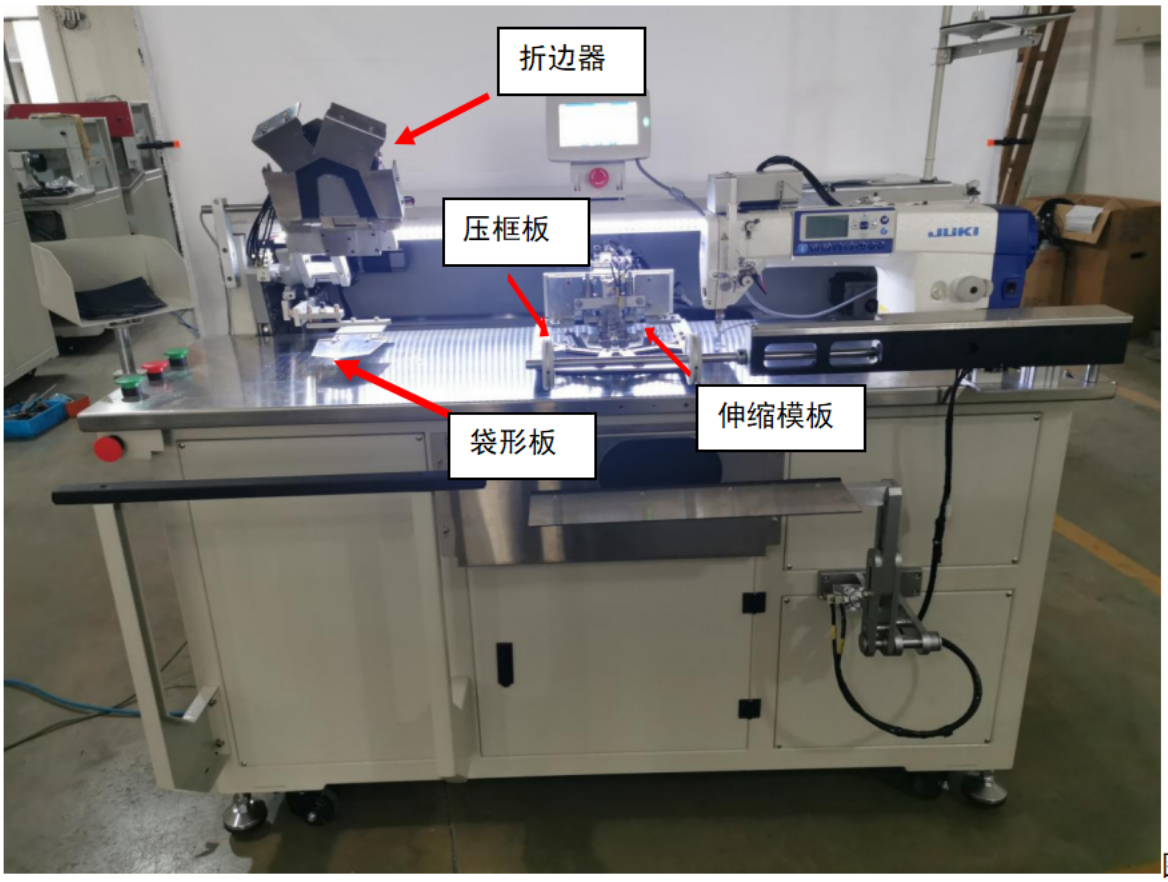


图10

6.2 换模步骤

6.2.1 拆装模具

拆装模具需按以下步骤进行：

1. 袋型板换装步骤：在设备复位后关闭电源4.1.（2）保持气阀气压，松开袋形板螺丝（图11），换上新的袋型板，并拧紧螺丝后检查是否牢固。

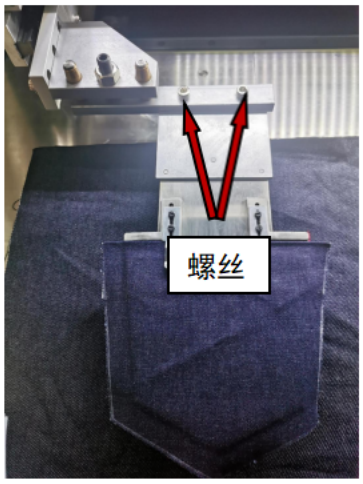


图11

图12


图13

2. 折边器换装步骤：保持设备有足够的气阀气压及关机状态，拉出折边器，折料压力调节归零后拔出六根气

管（图13），拨动换模开关4.1.（12），拔出整个折边器，更换折边器并按照对应位置接好气管后，关闭换模开关锁住折边器，恢复折料压力调节工作压力测试是否漏气。

3. 伸缩模板换装步骤： 保持设备有足够的气阀气压及关机状态，如图14：

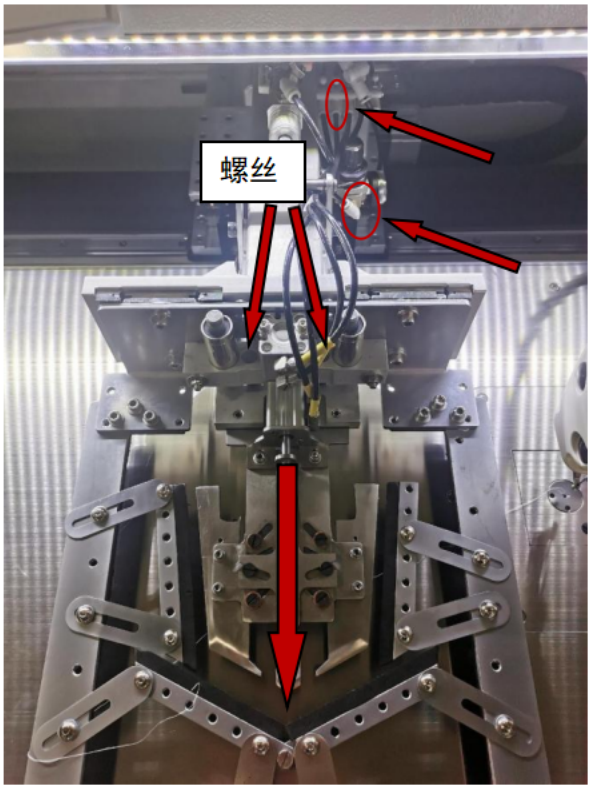


图14

此时松开上图螺丝并拔出两根气管（图14），即可将伸缩模板拆下，把新伸缩模板安装到位后拧紧螺丝并插上对应气管后测试是否漏气。

*注意模具更换完成后，保持气阀工作压力并开机，一定要先进行复位。有正常使用记录的模具更换后注意保持模具状态，再次更换此模具就无需进行细节调试，基本可上机即用。

6.2.2 模板坐标校正

设备调试需按以下步骤进行：

触摸屏主界面 中“  ”进入如下界面：

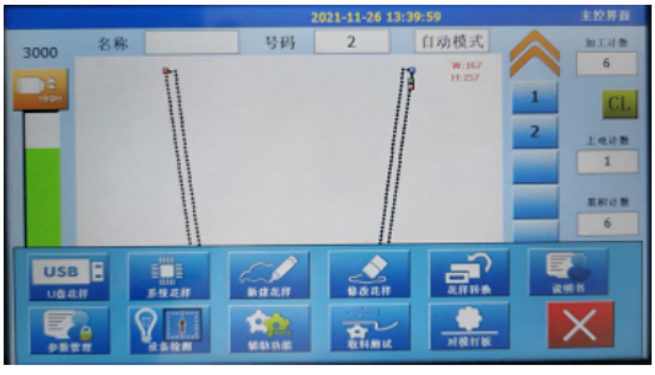


图15

点击界面中“  ”如图16：进入单步动作测试界面并点击“  ”，

图16

在该界面下检查袋型板起针点是否与缝纫位置齐平（图17），点击“  ”至第19步（图19）并点击“  ”压板压下后是否如图20一般对称，如需调整进入第18步点击“取料校正”进入图18点击“  ”调整。

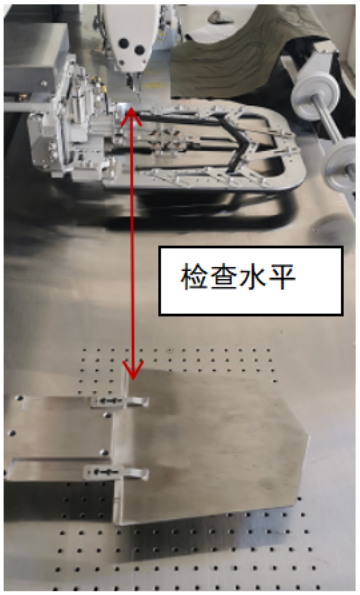


图17

图18

图19

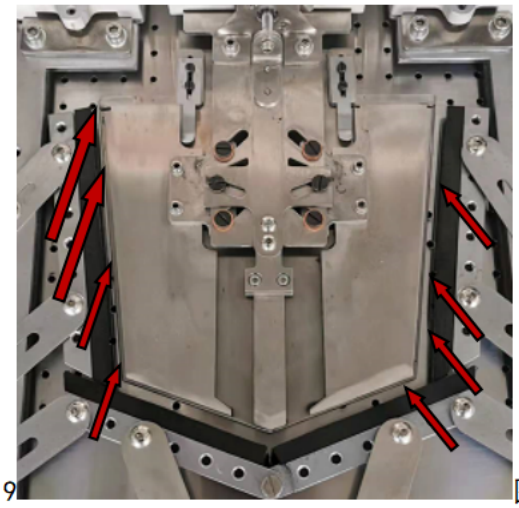


图20

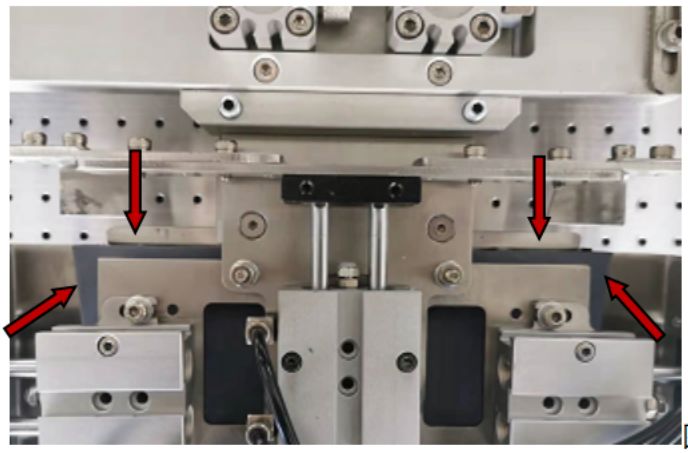


图21

进入动作测试第5步检查图21是否对称。如需调整，进入单步测试第3步后点“取料校正”进入图18界面点击“  ”调整。

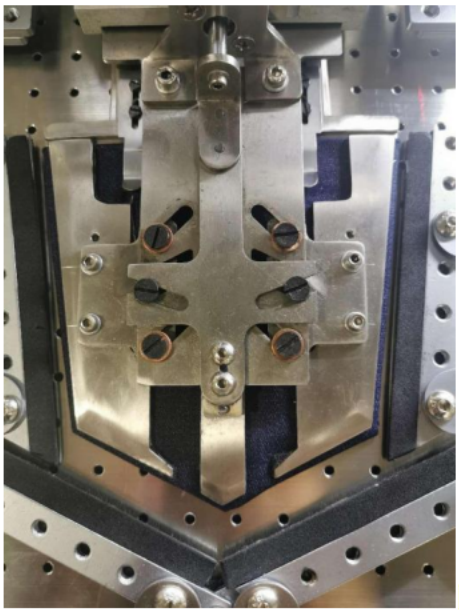


图22

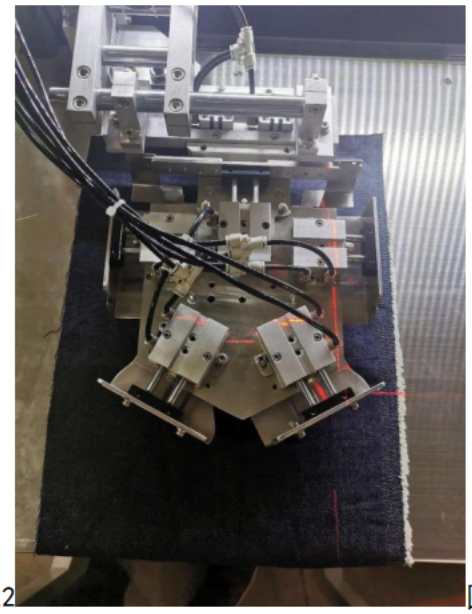


图23

最后的调整效果应保证压板与袋型板契合，折料器与袋型板契合。（图22、23）

七、基础绘图

在完成以上调试后设备带布料由图17点击界面中“  ”，进入动作测试界面并点击“  ”进入第23步后点击“  ”进入图24。

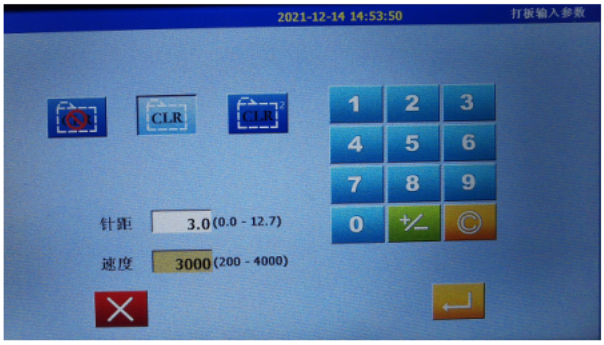


图24

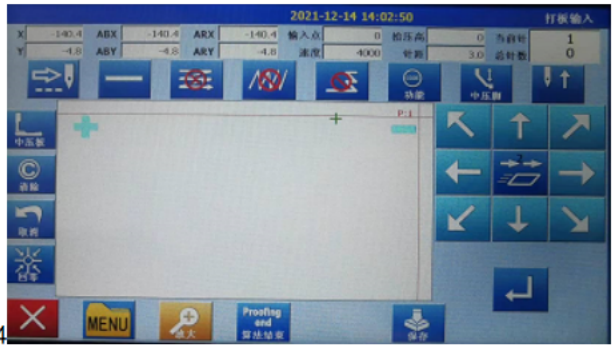


图25

设定好针距和速度后其他保持默认设置点击“  ”进入图25。

7.1 双线模具绘图

由图25点击“  ”进入图26

图26

图27

图26点击“  ”和“  ”后点击“  ”进入图27，在图27根据实际双线间距修改“距离”，其他默认选项后点击“  ”回到图26再点击“  ”形成图28。点击“  ”移动模板至起针点后点击“ 

”测试是否碰板（再次移动模板前需抬起中压脚）

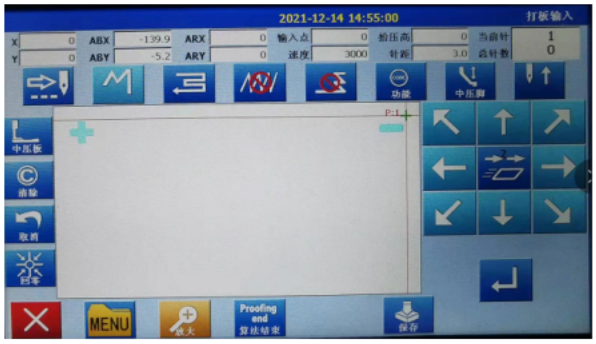


图28

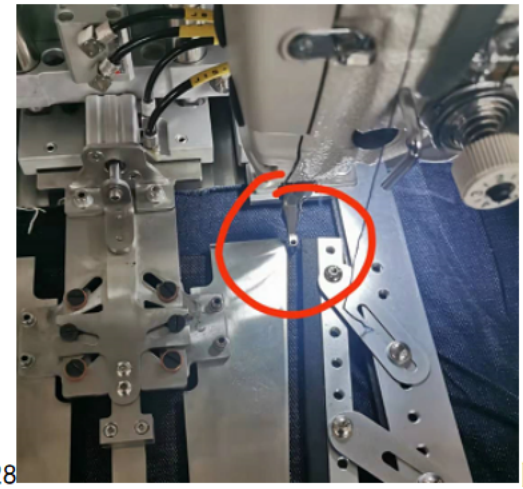


图29

确认起针位置后在图28点击“  ”后根据模板样式画图，在图30中点击“  ”形成图31。

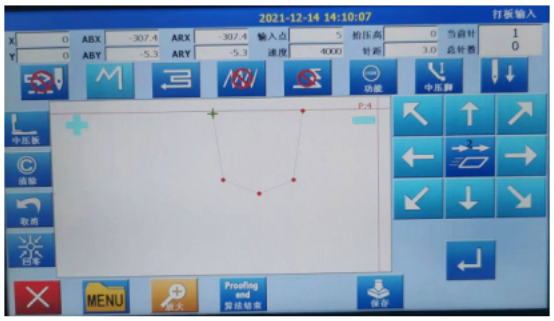


图30

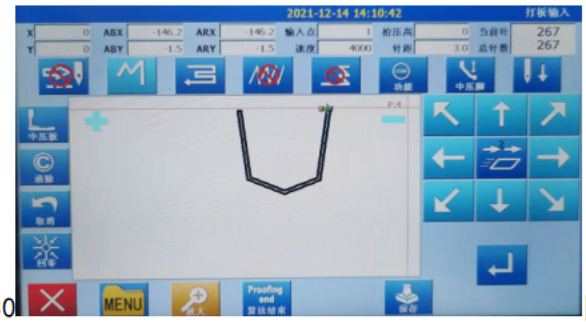


图31

图31中点击“  ”放大线迹后点击“  ”在图26选中“  ”及“  ”后点击“  ”

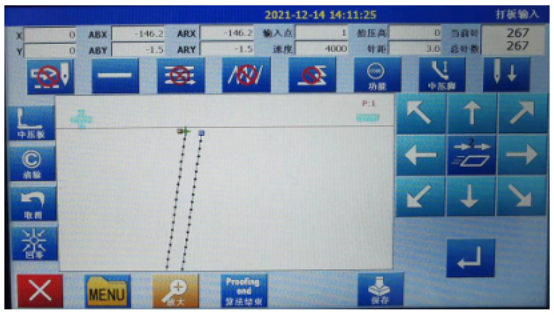


图32

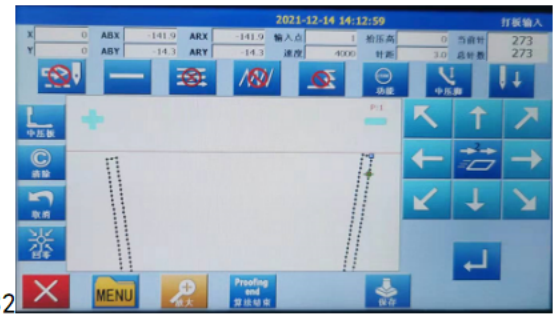


图33

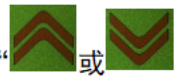
连接图32起针点和结束点两端并沿着起针点再打3-4个点位后如图33所示。在图33点击“  ”在图37中点击剪线，保存图样并设置图样名称后返回图34点击“  ”后点击“  ”检查是否撞针。

图34

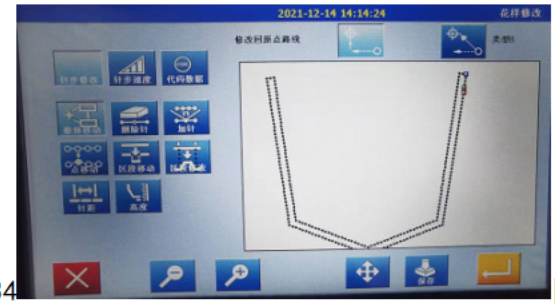
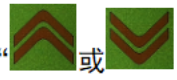


图35

无论有无撞针问题都需要点击“  ”进入图35，如有撞针问题通过图35进行微调，如无撞针问题点击“  ”进入图36通过点击“  ”选择需要退板的点位（一般为左上角）后点击“  ”进入图37点击退板后点击“  ”保存并覆盖原图样。为保证设备人员安全，每次保存图样后都需要检查是否撞针。

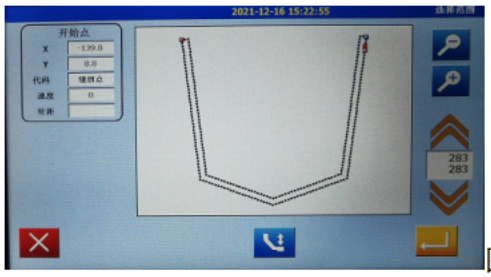


图36

图37

7.2 单线模具绘图

由图25直接通过“  ”绘图**并设置剪线后**（方法参照双线模具）。为避免图39中机针回位时由于布料过厚，抬高伸缩模板导致撞针，需进行空送回针设置。


图38

图39

在图38状态下点击“  ”后通过“  ”下移，避开图39伸缩模板高处，点击“  ”后仍需点击“  ”再通过“  ”，把压框板移出机针位置点击“  ”后保存图样。移出后的位置如图40所示，移除后的画图情况如图41所示。

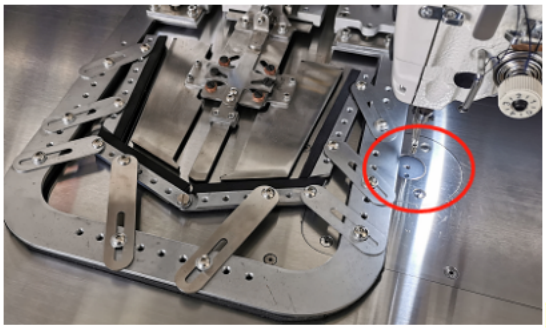


图40

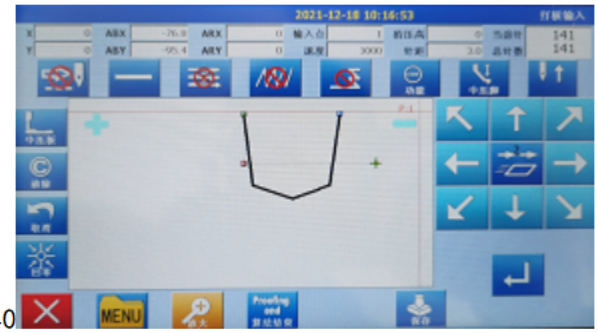



图41

保存图样后仍需通过缝纫界面点击“ 

”后点击“  或  ”检查是否撞针。

八、附件箱明细

序号 Serial Number	物料名称 Name	数量 Number	备注 Remarks
1	线架	1	机头原配件
2	机头罩	1	机头原配件
3	锁芯	1	机头原配件
4	工具包	1	个
5	螺丝刀	2	把
6	六角扳手	4	2.5/3/4/5
7	气管接头	4	个
8	模板压布片	8	个
9	机针	1	包
10	口袋放料盒	1	个

九、日常保养要求

设备保养清单及要求详见下表

序号	项目	时间				要点描述
		每天	每周	每月	半年	
1	清理灰尘	√				清除设备表面及零部件灰尘
2	清理油污		√			清理台板、针板、梭芯油污
3	风机滤芯		√			清理风机滤芯灰尘
4	压板海绵		√			检测海绵是否磨损变形，有损需更换
5	折边器			√		保持水平，并检查螺钉紧固
6	袋模板			√		保持水平，并检查螺钉紧固
7	送布板			√		保持水平，并检查螺钉紧固
8	伸缩模板			√		保持水平，并检查螺钉紧固
9	气管接口			√		气管接口紧密，不漏气
10	机头油量			√		机头油量不低于警戒线
11	梭芯			√		检查机头梭芯是否刮花
12	感应器				√	检查灵敏度是否准确，位置是否变化
13	滑动件				√	检查滑动件润滑，如有需要则添加润滑剂
14	电控箱				√	散热风扇运转正常，及时清理灰尘


ENGLISH

Catalog

1、Basic information of the equipment

FIG. 1

1:Machine head；2:Power switch; 3:Stacker; 4:Rolling Device; 5:Infrared positioning；
6:Activity template organization ; 7:Loader; 8:Pocket loader; 9:Folding group;
10:Touchscreen；

2、Technical parameters of the equipment

168 Automatic Pocket Setter		
1	Machine head	JUKI-8000A
2	Maximum sewing speed /rpm	3200
3	Table	Stainless steel
4	Working voltage /V	220
5	Working pressure /Mpa	0.6
6	Spindle, X/Y control	Stepping motor
7	Stitch length /mm	1--5
8	Working efficiency	6 PCs/min
9	Way of the mould	Fast changing whole mould
10	Size/mm	1700*1220*1370
11	Weight/kg	450
12	Needle type	DP*5/DP*17
13	Shape (Size:mm)	210*200(Special customization is required beyond this size, max:230*260)

3、Safety precautions

Considerations for safe use of automatic pocket setter

 危险	1. In order to prevent accidents caused by electric shock, please do not openthe cover of the electrical box of the motor or touch the parts in the electrical box when the power is connected.
 注意	1. In order to prevent personal injury, please do not operate the machine inthe stateofremovingthebeltguard,fingerprotectorandothersafetydevices. 2. In order to avoid being involved in the machine's personal accident, please do not let your fingers, hair, clothes near the pulley, v-belt, motor, and do not put items on it during the operation of the sewing machine. 3. To prevent personal injury, please do not put your finger near the needle when turning on the power or running the machine. 4. In order to prevent personal injury, please do not put your fingers in the wire pole guard during the operation of the sewing machine. 5. When the machine is running, it turns at a high speed. To prevent damageto the hand, never let the hand near the cutter during operation. In addition, when changing the cable, please be sure to turn off the power. 6. In order to prevent personal injury, please be careful not to pinch your fingers when the machine moves up and down or when you return to the original position. 7. Please do not cut off the power or air supply while the machine is running. 8. In order to prevent accidents caused by sudden starting, please remove the cloth guide when the preparation work is finished and the sewing state is reached. 9. In order to prevent accidents caused by electric shock, please do not operate the sewing machine when the ground wire of the power supply is removed. 10. In order to prevent accidents caused by electric shock and damage to electrical parts, be sure to turn off the power switch before inserting or unplugging the power plug. 11. In order to prevent accidents caused by damage of electrical parts, pleasestop the operation for safety when it thunders and pull the power plug. 12. In order to prevent accidents caused by damage to electrical parts, condensation will occur when moving from a cold place to a warm place immediately, so please wait until the water drops dry before switching on the power. 13. As this product is a precision machine, please pay full attention to itduring operation, do not splash water or oil on the machine, and do not letthe machine fall and give the machine impact. This machine is A class A industrial machine. The use of this machine in the home environment may cause the phenomenon of radio interference. At this point, please take appropriate measures to solve the problem of radio interference. 15. After the power switch is turned off when the accumulator moves, the

	accumulator lever moves, so please be careful not to clip your finger, etc. **16. When the power switch is turned off during the foot press action, pleasebe careful not to pinch your fingers.** **17. During folding operation, please be careful not to clip the cylinder toyour finger when putting your finger into the folding machine.**

*** Important safety information:**

- ✓ Improper operation of the machine may cause machine damage or personal injury. Please read this instruction carefully and operate correctly before operation.
- ✓ Please ventilate the machine before it is officially powered on.
- ✓ Do not turn on the internal parts of the electric cabinet or touch screenwhile the power is on.
- ✓ This machine should be used after receiving training or under special instruction to ensure the safety of the user.

4、key function description

4.1. Function description of the button

FIG. 2

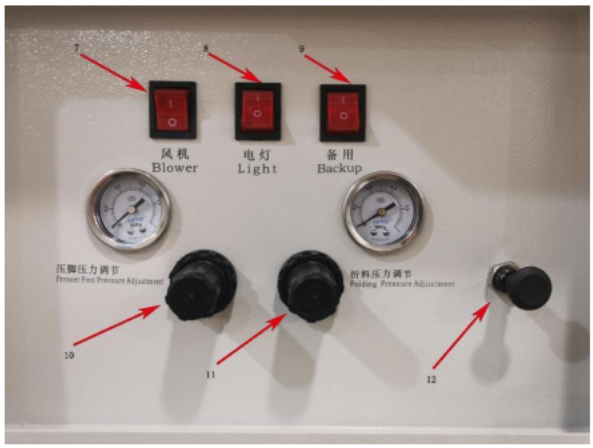
1、Folding cancel button --- Press the button to stop the folding group.

2、Power switch -- Press to start / close the machine.

3、Start switch --- Press the button to start sew.

4、Grid switch --- This is used to align the cloth pattern.

5、Start without material --- Use this button to complete the sewing action without material.



6、Sewing emergency stop button - press to stop sewing.

7、Suction fan button - Switch button of suction fan.

8、Lighting switch - Lighting.

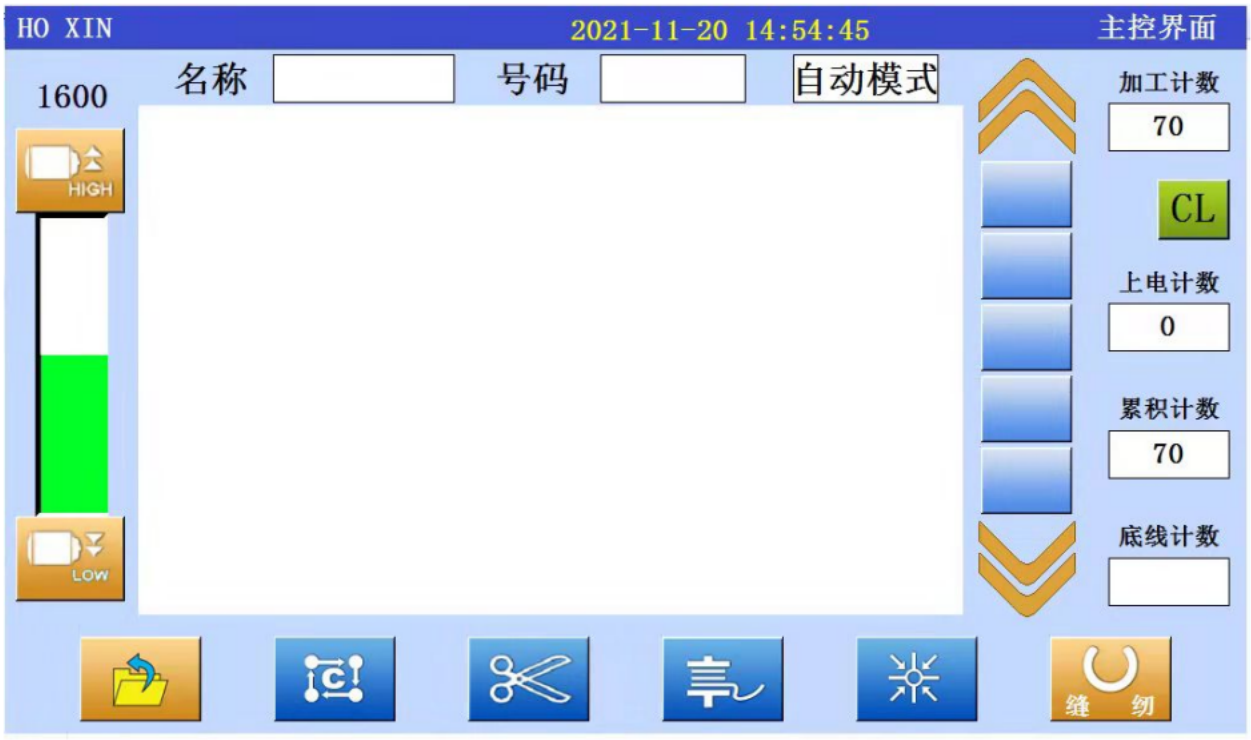
9、Standby (optional) - the button is generally reserved for later upgrade function, and can also be used as infrared laser positioning switch.

10、Presser foot pressure adjustment button - Pressure adjustment for presser foot device.

11、Folding pressure adjustment button - Pressure adjustment for folding device.

12、Quick overall mold change switch --- After opening, the mold can be directly pulled out for replacement.

a：Main interface



b：Sewing interface

4.2. Reset operation instructions

4.2.1 Boot reset operation

Steps	Instructions	The key way to
1	Boot	4.1（2）
2	Reset	Sewing interface 
3	Switch sewing mode	Main interface

4.2.2 Emergency stop reset operation

Turn off the emergency stop switch to reset, and place the fabric again.

5、Operating instructions

5. 1. Preparation before operation

- ✓ The machine head shall be in the stop state when the operator checks it
- ✓ Check whether the pressing plate sponge is intact
- ✓ Check whether the sewing thread has been put on correctly
- ✓ Check whether the needle has been installed
- ✓ Clean the sundries on the machine table to ensure that there are no sundries hindering the operation of the machine
- ✓ Check the pressure of the air pressure gauge to make it meet the use requirements of the machine
- ✓ Check whether the eye guard has been installed correctly

5. 2. Operation process description

5.2.1 Boot device

The equipment will be powered on after press ON..

FIG. 3

FIG. 4

5.2.2 Reset operation

Perform the machine power on reset operation. Please refer to: 4.2.1. Key function description -- 4.1 power on reset operation. Then switch on 4.1.(7) to open the suction fan. The following figure shows the status ofthe device after the reset.

5.2.3 Fabric placement

Press 4.1.(9), align accurately according to the laser spotlight, and place the back parts as shown in the FIG.5 below.

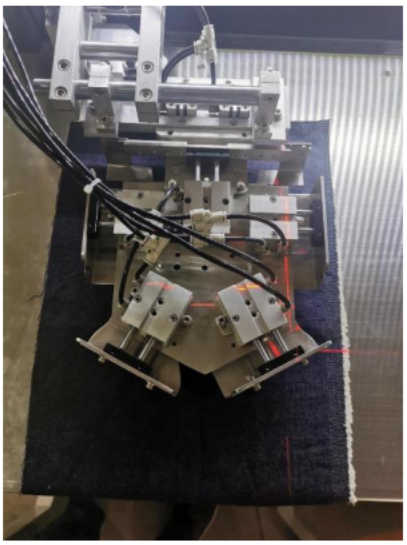


FIG. 5

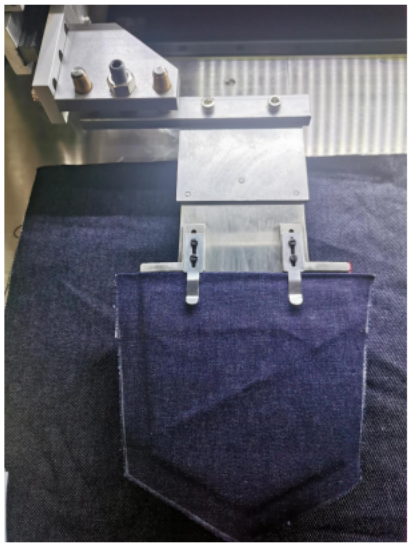


FIG. 6

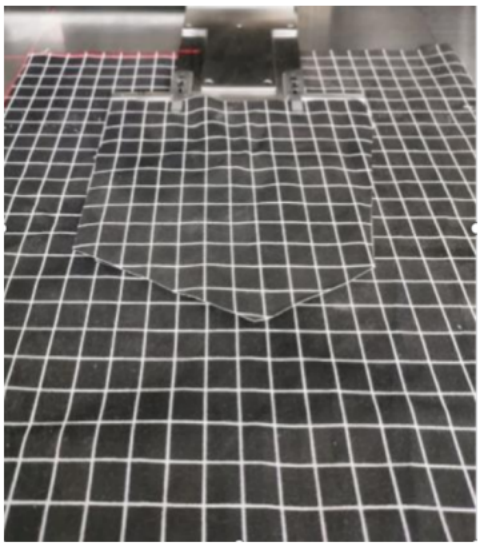


FIG. 7

5.2.4 Pocket placement

Pocket placement is shown in FIG. 6.

***When placing the pocket, check the strip if necessary: press grid switch 4.1.(4) , the pocket template will descend to the table top, and check the strip, as shown in FIG.7.**

5.2.5 Automatic folding and sewing

1. Press the 4.1 (3) sewing switch, and the folding group will slide out and folding automatically; see FIG.8.

2. After the cloth feeding plate is moved to the left over the center blade, it is pressed down to press the pocket, and the center blade is withdrawn backward, and the cloth feeding plate is moved to the right to start sewing, as shown in FIG.9 below.

3. After sewing, the material will be automatically received, and the cloth feeding plate will return to the original point.

*** Move the cloth feeding plate to the right of the sewing area, and continue to place the fabric on the left side, and operate in turn.**

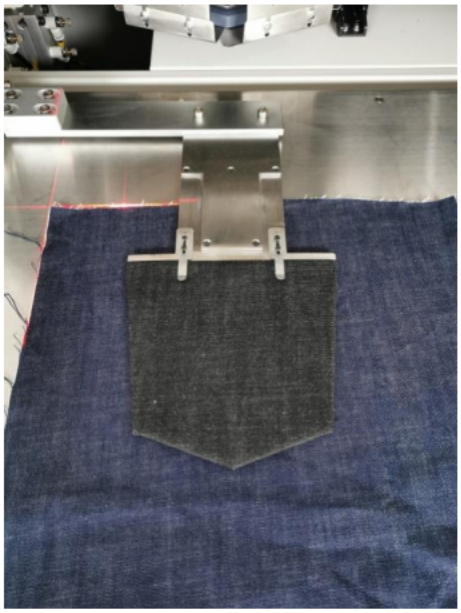


FIG.8

FIG. 9

5.2.6 Shutdown

After operation, press off, and the equipment will be shut down.

6、Debugging method

6.1 Jig position

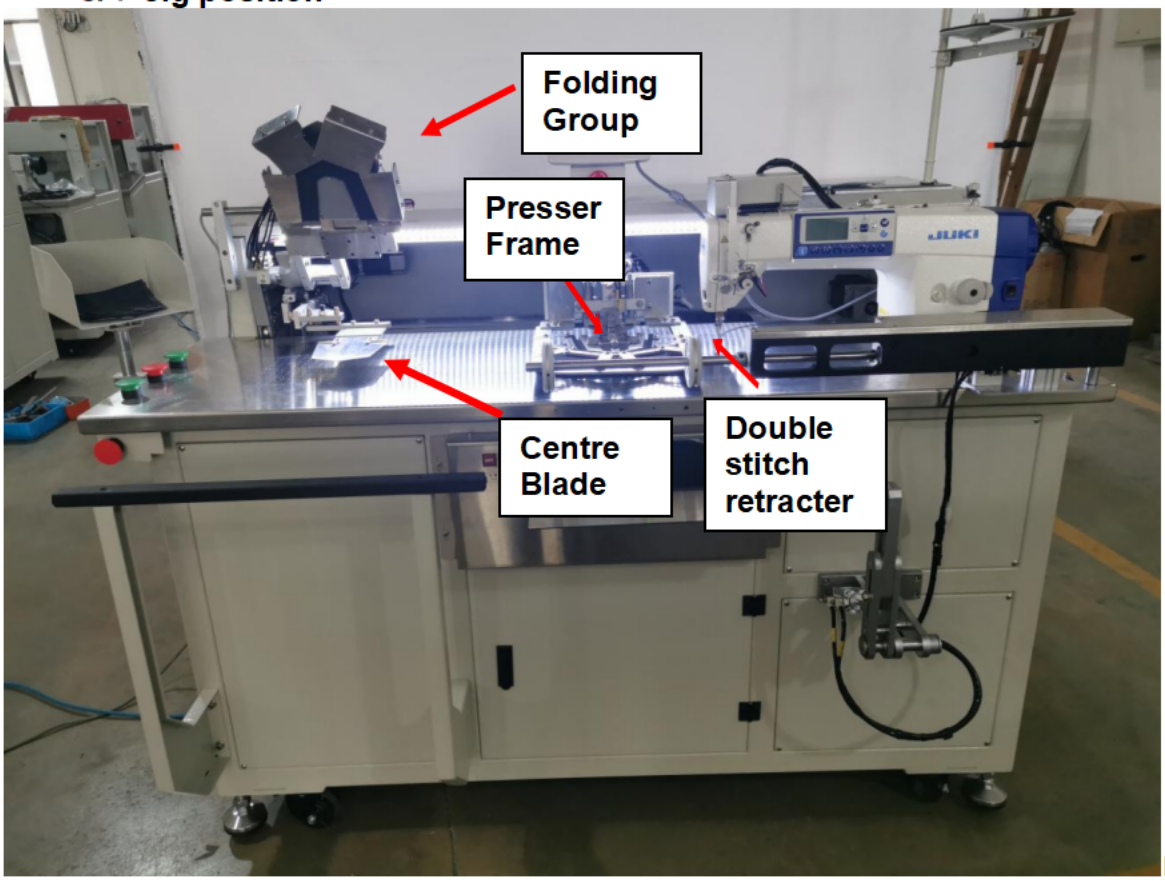


FIG. 10

6.2 Jig changing procedure

6.2.1 Disassembly and assembly of the mould

1. Replacement of centre blade: turn off the power after the equipment return to the start 4.1 (5). Maintain the air pressure of the air valve, loosen the screws of the centre blade (FIG. 13), replace it with a new centre blade, and check whether it is firm after tightening the screws.

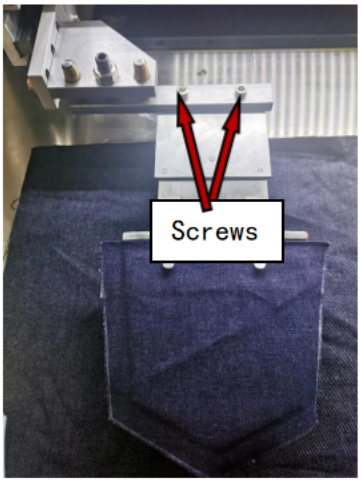


FIG. 11

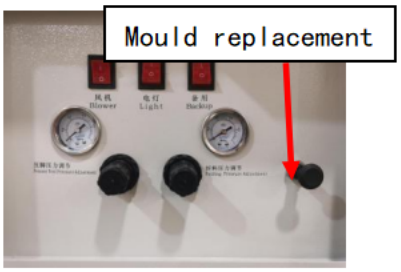


FIG. 12

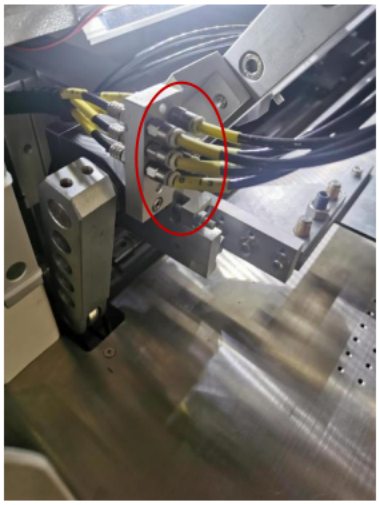


FIG. 13

2. Disassembly and assembly of folding group： keep the equipment in sufficient air pressure and shutdown, pull out the folding group, and adjust the folding pressure after zeroing, pull out the six air pipes (FIG.13) and turn the mould replacement switch(FIG.12) , pull out the whole folding device, replace the folding device and connect the air pipe according to the corresponding position, close the mould replacement switch to lock the folding device, restore the folding pressure, adjust working pressure switch, and test to make sure there is no air leakage.

3. Replacement of double stitch re-tractor plate:keep the equipment in sufficient air pressure and shutdown, as shown in FIG.14:

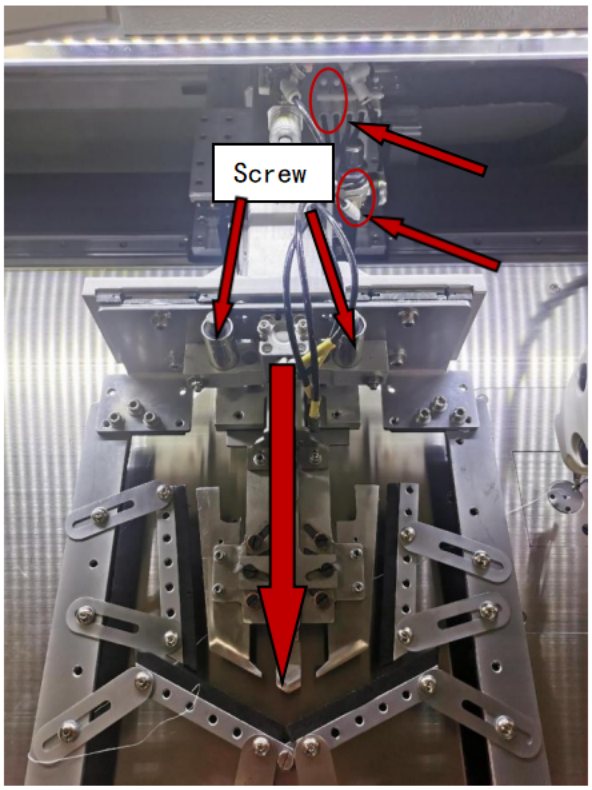


FIG. 14

Then loosen the screw in the figure above and pull out the two air pipes (FIG.14), remove the re-tractor plate and install the new re-tractor plate in place, tighten the screw and insert the corresponding air pipe to make sure there is no air leakage

*Note that machine needs to be zeroing after the replacement of the mould. there is no need for detailed debugging if mould has previously adjusted and used.

6.2.2 Equipment debugging and parameter setting

Press  in main interface, to enter the following interface

FIG. 15

Click  on above, enter single step action test and click  , as showing below

FIG. 16

In this interface, check whether the starting point of the pocket plate is flush with the sewing position (FIG. 17),

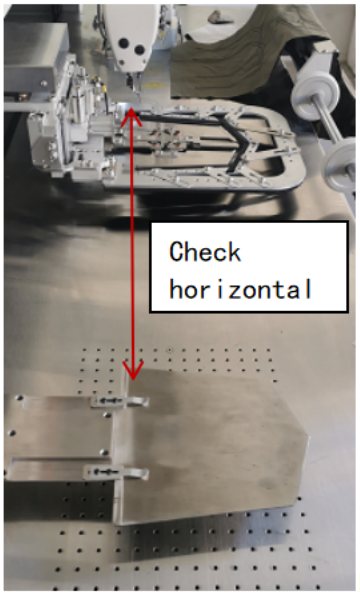


FIG. 17

FIG. 18

click  to enter 19 Step shown in FIG.19, and check if related sides are symmetrical on FIG.20.

FIG. 19

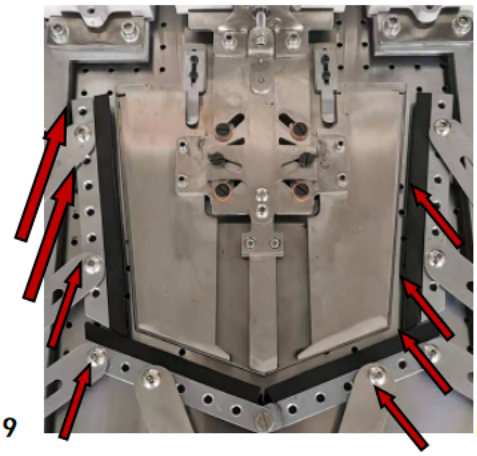


FIG. 20

If adjustment is required,click  after STEP 18 in single step action test, entering interface shows in FIG.18,and click  to adjust symmetry。

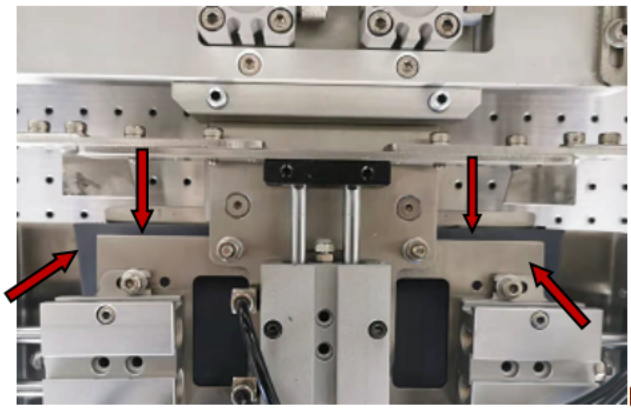


FIG. 21

Also entering STEP 5 in single step action test,and check symmetry for the parts shown in FIG.21, if adjustment is needed， click  after entering STEP 3 in single step action test, click  for adjustment as shown in FIG.18.

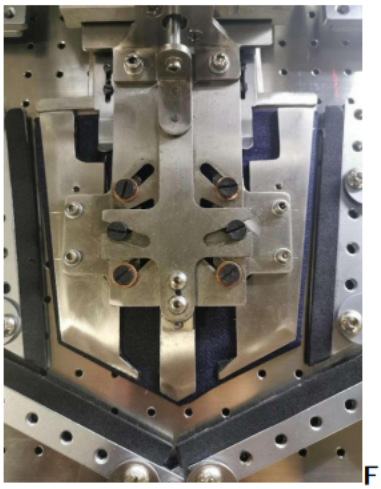


FIG. 22

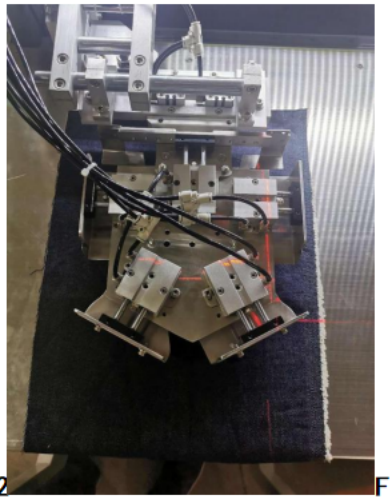


FIG. 23

Please ensure the presser frame and centre blade are fit with each other after adjustment, same as to the folding group and center blade.

7、Basic Drawing

After adjustment of mould, click  in FIG.17， entering action test interface and click  until STEP 23, and then click  entering the interface as shown in FIG.24。

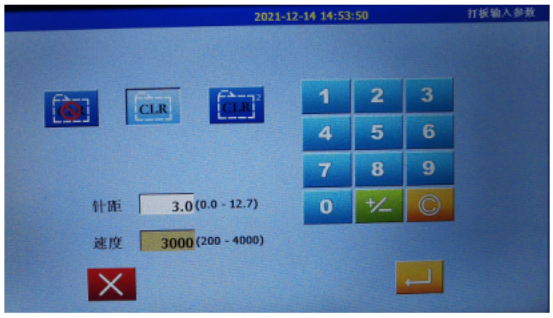


FIG. 24

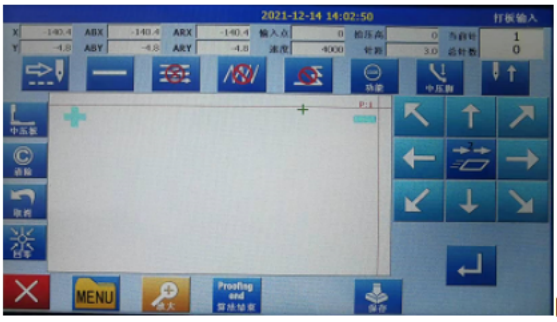


FIG. 25

After setting the stitch length and speed, click “  ” to enter FIG.25.

7.1 Drawings for double stitch

Entering FIG.26 by clicking  in FIG.25

FIG. 26

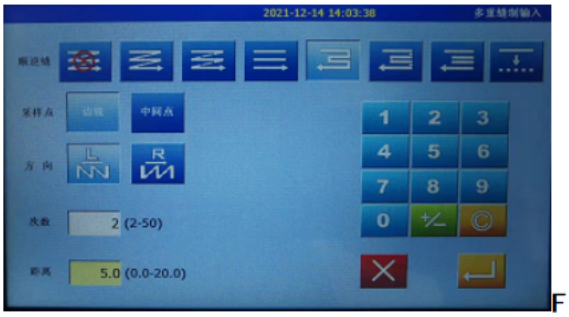


FIG. 27

In FIG.26,click  and  ,then click  to enter FIG.27, modify double stitch distance based on actual requirement， keep other option default and click  to back to FIG.26,click  in FIG.26 for entering FIG.28. Click  to move the mould to the starting point and then click  to test whether it touches the plate(lift the middle presser foot before moving the mould again)

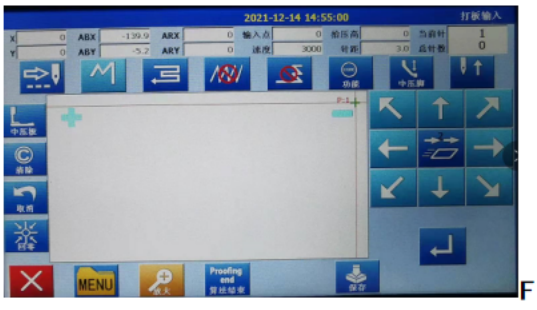


FIG. 28

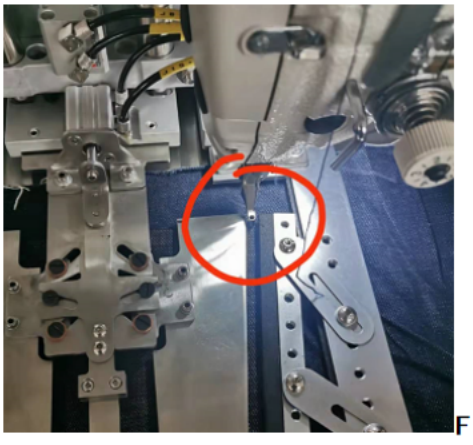


FIG. 29

After confirming the sewing starting point, click  in FIG.28,and draw according to the mould style (example shows in FIG.30), and click 

to form FIG.31.

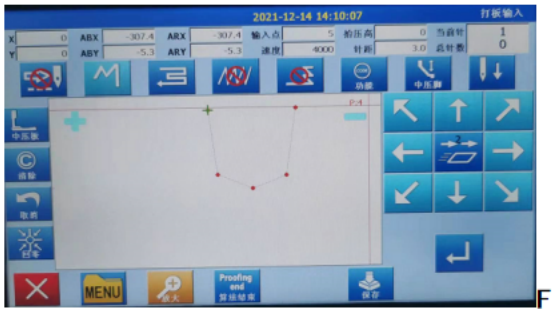


FIG. 30

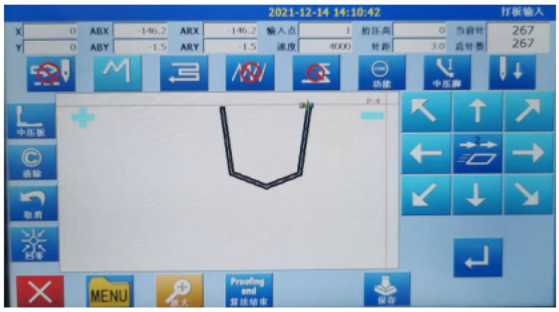


FIG. 31

Click  to enlarge the stitch in FIG.31, then click  in FIG.26,after choose  and  , than click  to confirm.

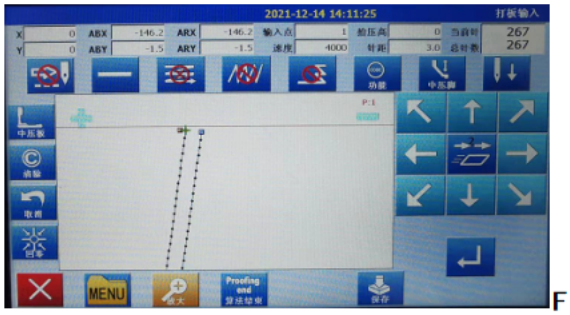


FIG. 32

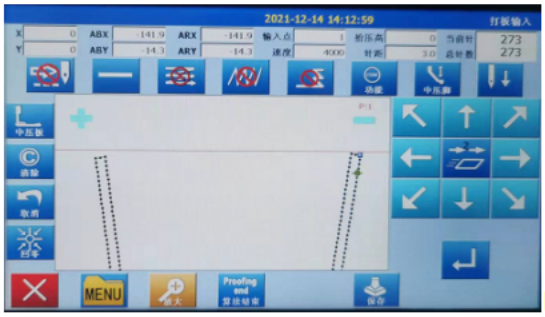


FIG. 33

Connect starting point and ending point as shown in FIG.32, then mark 3-4 points along the starting point (shown in FIG.33). Click  in FIG.33, entering FIG.37, click  for thread trimming, save the drawing and set name, then return to FIG.34, click  , then click  or  to check whether there is needle hit.

FIG. 34

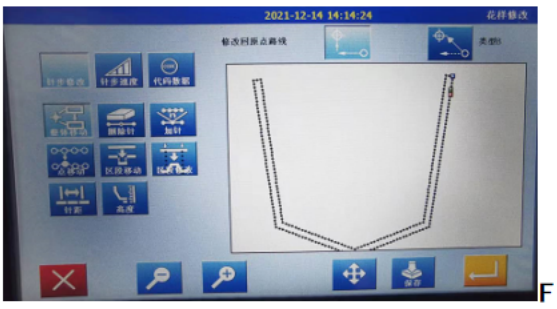


FIG. 35

Click  to enter FIG.35, if there is collision problem, adjust in FIG.35 ， if not, click  entering FIG.36, click  or  to select the point where the retract-er plate needs to be withdrawn (usually the upper left corner. Then click  entering interface as shown in FIG.37, click  ,then click  to save and overwrite the original drawing. For safety user instruction, it is necessary to check whether there is collision problem after saving the drawing every time.

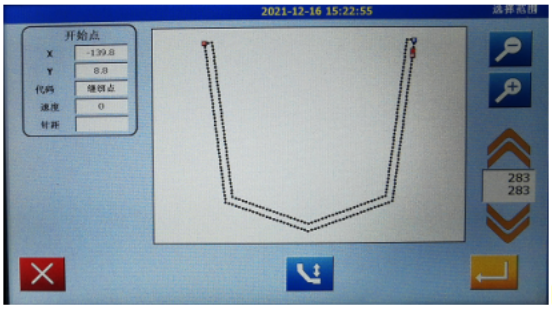

2021-12-16 15:22:55
开始点
X
-139.8
Y
8.8
代码
缝初点
速度
0
针距
283
283

FIG. 36

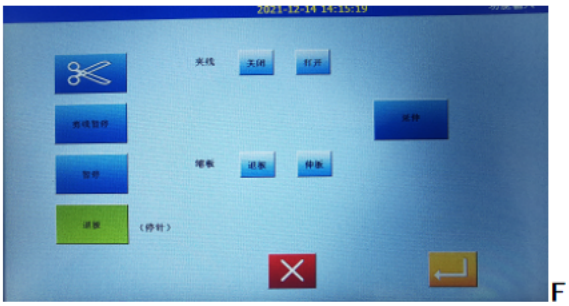

2021-12-14 14:15:19
夹线
关闭
打开
退板
排废
（停针）

FIG. 37

7.2 Drawings for single stitch

Draw directly through "  " as shown in Figure 25 and set the thread trimming (refer to the double stitch mould for the method).

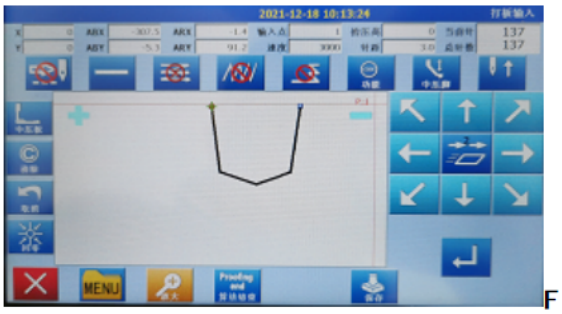


FIG. 38


FIG. 39

To avoid the needle collision problem in Figure 39,click  in FIG.38, move down through  ,avoid the high position of the retracter plate as shown in Figure 39， click  for confirmation. Repeat above steps if there is still needle collision. Move the pressure frame out of the needle position and click  to save drawing。The position after removal is shown in Figure 40, and the drawing after removal is shown in Figure 41.

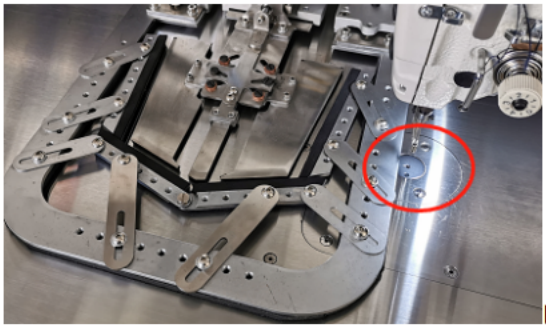


FIG. 40

FIG. 41

After drawing is saved, click 

in FIG.34, then click  or  to check whether there is needle collision issue.

8、Accessories box details

序号 NO.	物料名称 Name	数量 Number	备注 Remarks
1	Thread stand	1	-
2	Head Cover	1	-
3	Bobbin	1	-
4	Screwdriver	2	-
5	Hex Wrench	4	2.5/3/4/5
6	Air pipe connector	4	-
7	Needle	1	-
8	Pocket storage box	1	-

9、Daily maintenance requirements

See the following table for the list and requirements of equipment maintenance

Please refer to brother s7300a for other maintenance requirements

NO	Project	Frequency				Requirement
		Daily	weekly	Monthly	Half year	
1	Clean up the dust	√				Remove dust from equipment surface and parts
2	Cleaning up oil pollution		√			Clean the greasy dirt on the table , needle plate and bobbin
3	Fan filter		√			Clean the fan filter dust
4	Clamp sponge		√			Check whether the sponge is worn and deformed and needs to be replaced if damaged
5	Folding group			√		Keep level and check screw tightening
6	Center blade			√		Keep level and check screw tightening
7	Cloth feeding board			√		Keep level and check screw tightening
8	Re-tracter plate			√		Keep level and check screw tightening
9	Air tube connector			√		The air tube interface is tight without air leakage
10	Bobbin			√		Check if the bobbin is scratched
11	Sensor				√	Check if the sensitivity is accurate and if the position changes
12	Guide				√	Check slide lubrication and add lubricant if necessary
13	Electric control box				√	Cooling fan runs normally, clean up the dust in time