

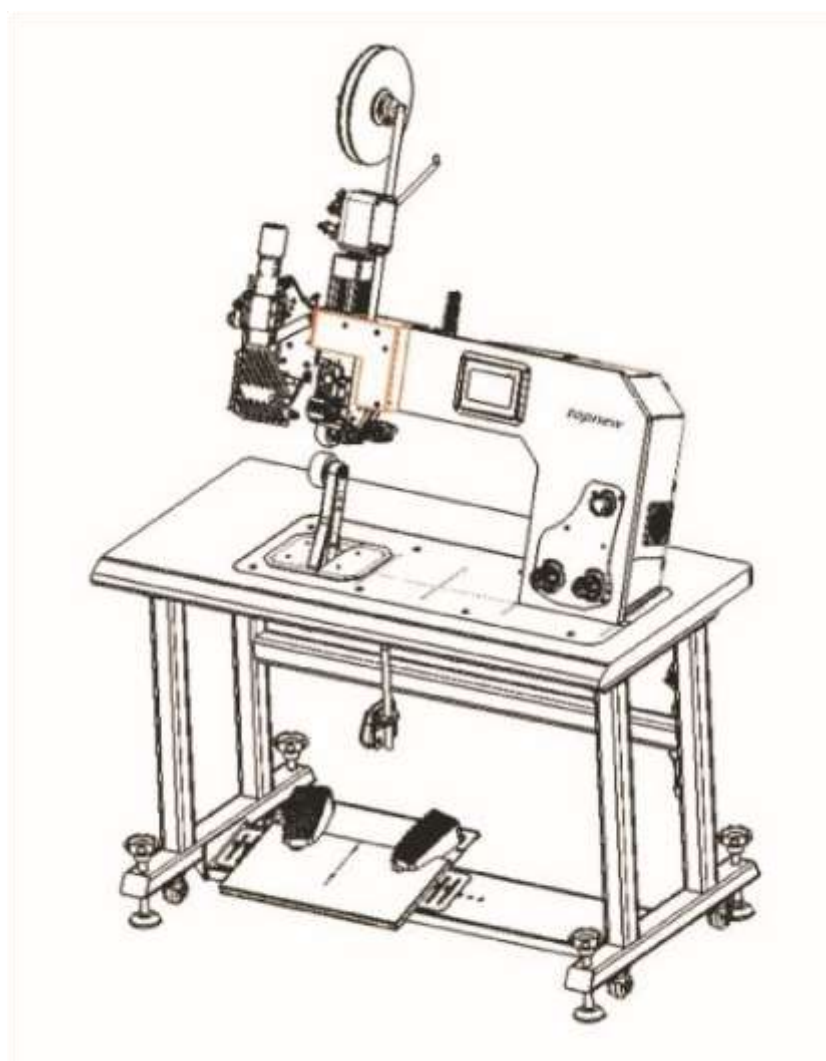


# MB9028 热风机

## MB9028 HOT AIR BLOWER

### 使用说明书

### USER'S GUIDE



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请遵守以下安全守则，以便能在一个安全的工作环境下提高工作效率，防止伤害事故发生。若能严格遵守本手册指引，使用多年后，本设备仍然性能良好。

Please abide by the following safety rules in order to improve work efficiency in a safe working environment and prevent injuries. If we can strictly follow Following the guidelines of this manual, the device still performs well after many years of use.



小心触电

Caution Electricity



紧急停止按钮

Emergency stop button



夹手 危险！请勿靠近

Hand pinched Danger! Keep away



危险！小心触电

Danger! Caution Electricity



危险！高温，请勿触摸

Danger! High temperature,  
please do not touch

## > 产品简介 > Product Introduction

本手册所描述的热风机是迄今为止市场上最好用的机型。MB9028 为专业用户而设，以全数码化平台为基础，融合众多崭新特性，令接缝密封比以往更加容易。使用前，用户需具备基本密封操作知识及技术。

The hot air blower described in this manual is by far the best model on the market. MB9028 is designed for professional users, based on a fully digital platform, incorporating many new features to make seam sealing easier than ever. Before use, users need to have basic sealing operation knowledge and technology.

为了能够正确操作本设备，避免机器损坏和人员伤害，请仔细阅读本手册并保留以作将来参考之用。

In order to operate this equipment correctly and avoid machine damage and personal injury, please read this manual carefully and keep it for future reference.

## > 产品规格 > Product specifications

型号	:	<b>MB9028</b>
Model	:	<b>MB9028</b>
电压	:	AC 220 伏/单相
Voltage	:	AC 220V/single phase
功率	:	50/60 赫兹
Power	:	50/60 Hz
功率消耗	:	3600 瓦（最大），1500 瓦（标准）
Power Consumption	:	3600 watts (maximum), 1500 watts (standard )
压缩空气	:	0.4-0.6 兆帕
Compressed Air	:	0.4-0.6 MPa
空气消耗	:	100 升/分钟 最大
Air Consumption	:	100 l/min max
密封速度	:	1-60 英尺/分钟
Sealing Speed	:	1-60 feet/minute
风嘴温度	:	50-800 C
Nozzle Temperature	:	50-800 C
风嘴宽度	:	22.0 毫米 标准，其他可选
Nozzle Width	:	22.0 mm standard, other optional
上压辘宽度	:	25.4 毫米-31.0 毫米（其它可选）
Upper Pressure Reel Width	:	25.4 mm-31.0mm (other optional )
下压辘宽度	:	31.0 毫米
Width Of Down Roll	:	31.0 mm
总体体积	:	长 1.2X 宽 0.7X 高 1.8
Overall Volume	:	Length 1.2X width 0.7X height 1.8
总体重量	:	150 千克
Total Weight	:	150 kg

注意：由于不断改进，规格如有变更，恕不另行通知

Note: Due to continuous improvement, specifications are subject to change without notice

＞ 主要特性      > Main features

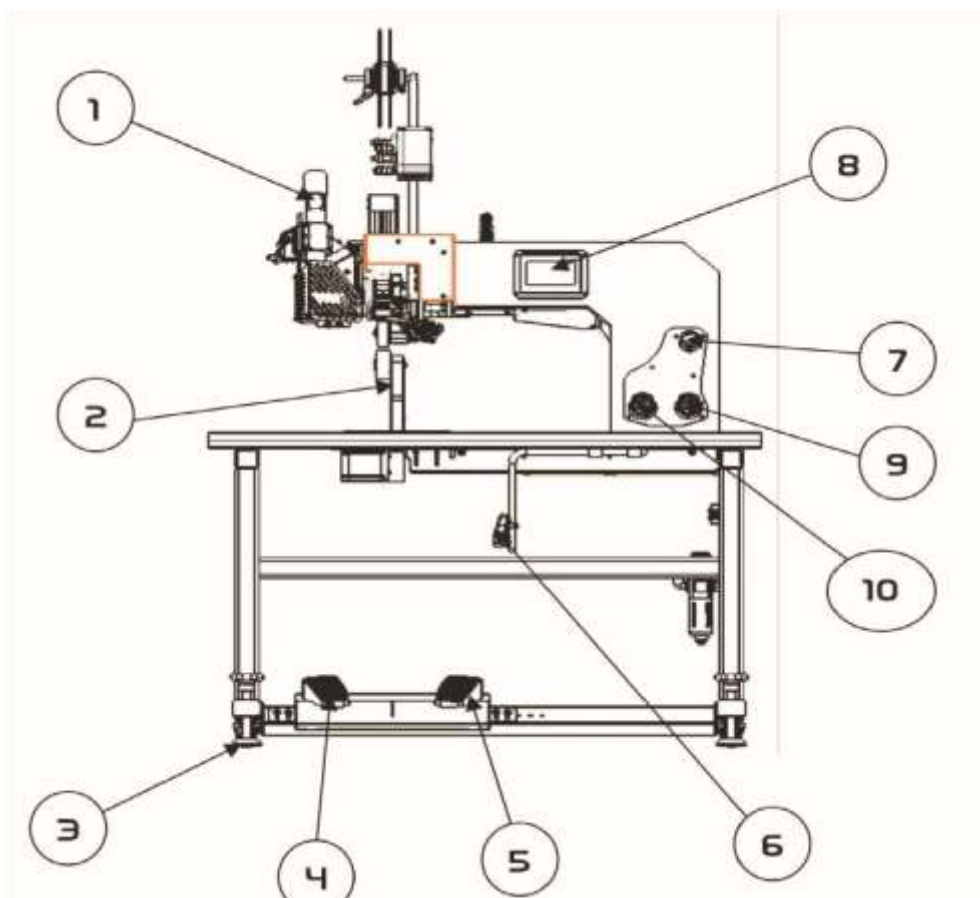
- ※ 上下压辊差速度运行，是减少弹性织物起褶皱或被拉伸的理想选择  
The upper and lower pressure rollers run at different speeds, which is an ideal choice for reducing wrinkles or stretching of elastic fabrics
- ※ 数码松带器稳定运行  
Digital tape loosener runs stably
- ※ PLC 程序集于一体快速排除故障  
The PLC program is integrated to quickly troubleshoot
- ※ 独立版面故障报警显示  
Independent layout fault alarm display
- ※ 多功能彩色数据储存显示屏  
Multifunctional color data storage display
- ※ 密码锁数据功能  
Password lock data function
- ※ 下轮组件多样选配  
Various options for lower wheel components

> 组件识别

> Component identification

>> 正视图

>> Front view



1. 加热器

1. Heater

2. 下轮组

2. Next round

3. 可调校地座

3. Adjustable base

4. 左脚踏

4. Left foot pedal

5. 右脚踏

5. Right foot pedal

6. 膝开关

6. Knee switch

7. 电源开关 紧急停止按钮

7. Power switch, emergency stop button

8. 触屏式控制面板

8. Touch screen control panel

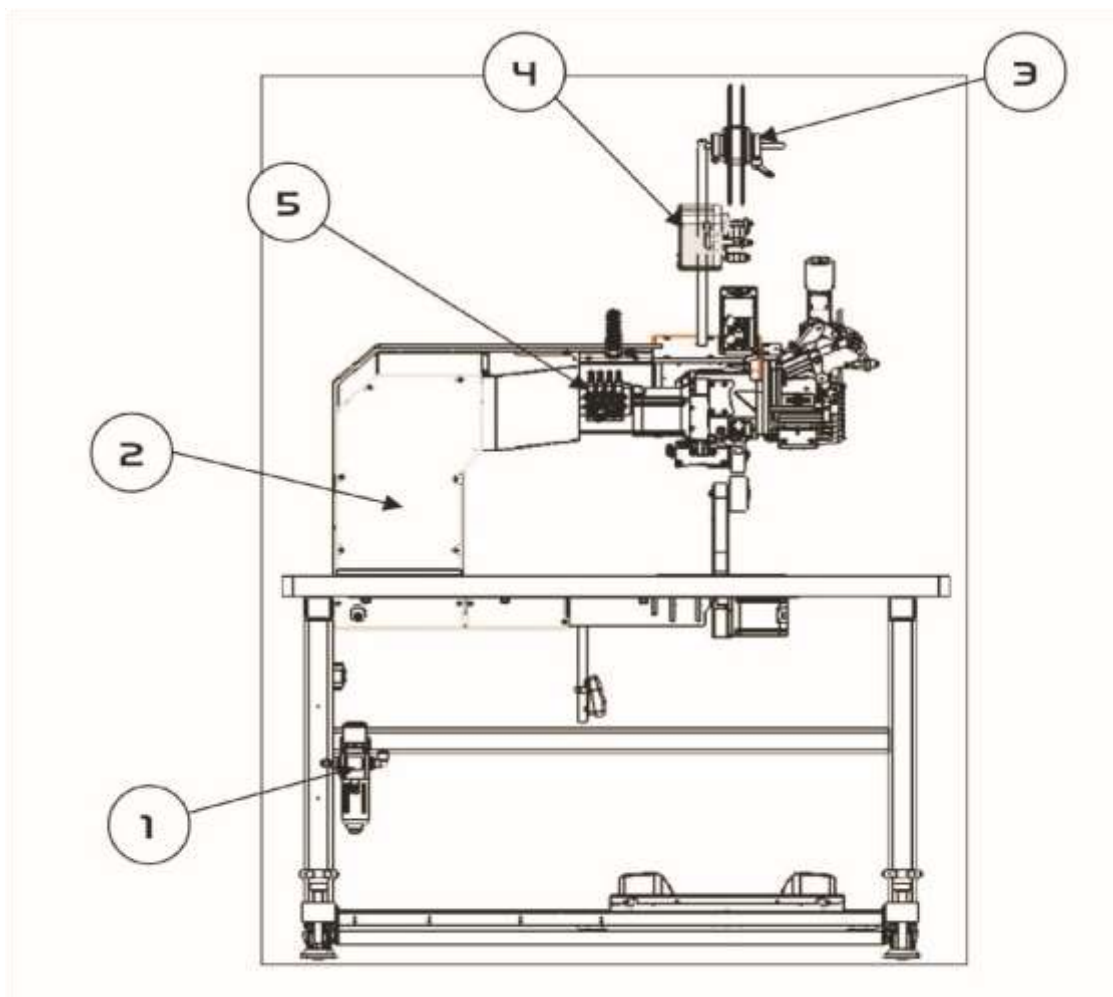
9. 风嘴压力调节器

9. Air nozzle pressure regulator

10. 压轮压力调节器

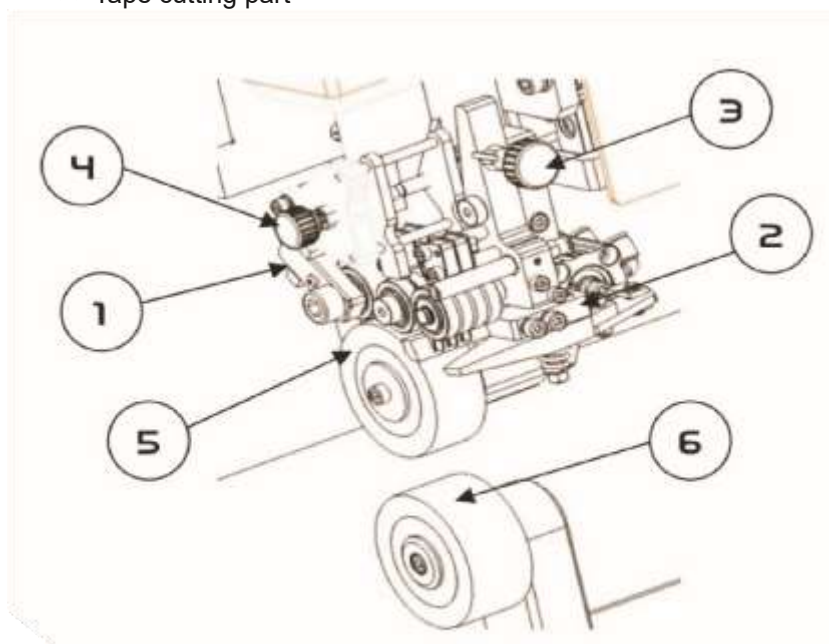
10. Pressure roller pressure regulator

>> 后视图 >> Back view

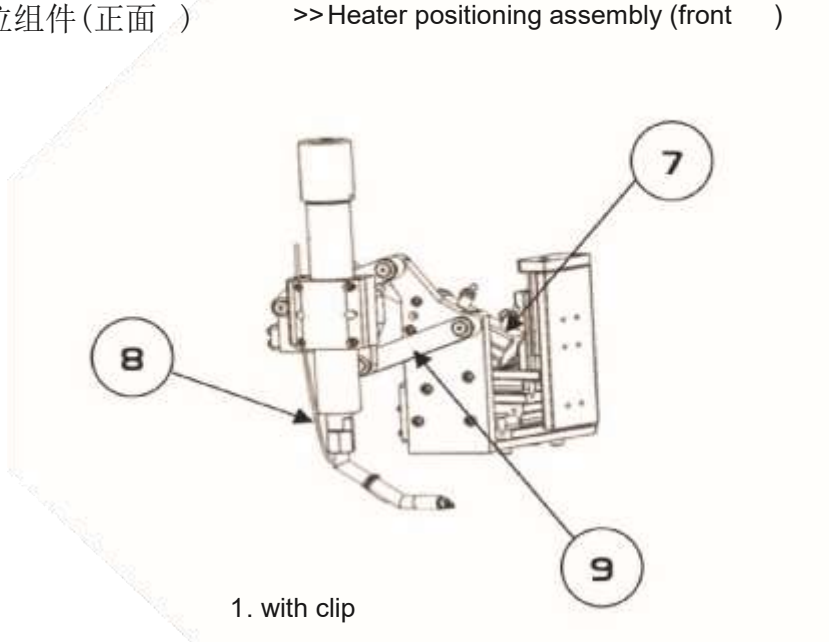


- 1. 过滤器组合
- 1. Filter combination
- 2. 配电箱
- 2. Distribution box
- 3. 带盘
- 3. With reel
- 4. 胶带张紧装置
- 4. Tape tensioning device
- 5. 电磁阀
- 5. Solenoid valve

>> 剪带部分 >> Tape cutting part



>> 加热器定位组件(正面) >> Heater positioning assembly (front)

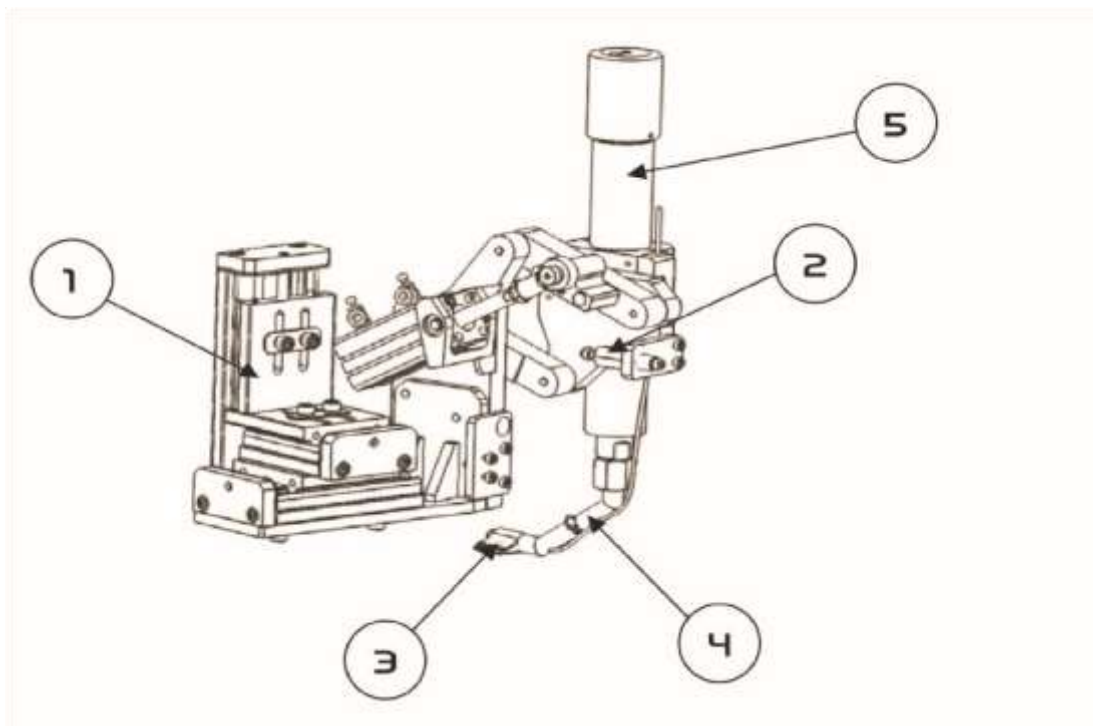


- |             |   |
|-------------|---|
| 1. 带夹       | 1. with clip                              |
| 2. 剪刀       | 2. Scissors                               |
| 3. 送带压力调节旋钮 | 3. Supplied with pressure adjustment knob |
| 4. 胶带宽度调节旋钮 | 4. Tape width adjustment knob             |
| 5. 上压辊      | 5. Upper pressure reel                    |
| 6. 下压辊      | 6. Press down the reel                    |
| 7. 主摆动气缸    | 7. Main swing cylinder                    |
| 8. 温度传感器    | 8. Temperature sensor                     |
| 9. 加热器摆动手臂  | 9. Heater swing arm                       |

> 组件识别 (续) > Component identification (Continued )

>> 加热器定位组件 (背面)

>> Heater positioning assembly (rear )



1 风嘴 3 轴（上下、左右、前后）调节装置

1 Air nozzle 3-axis (up and down, left and right, front and rear) adjustment device

2 摆抢缓冲装置

2 Swing grab buffer device

3 风嘴

3 nozzle

4 风嘴柄

4 Nozzle handle

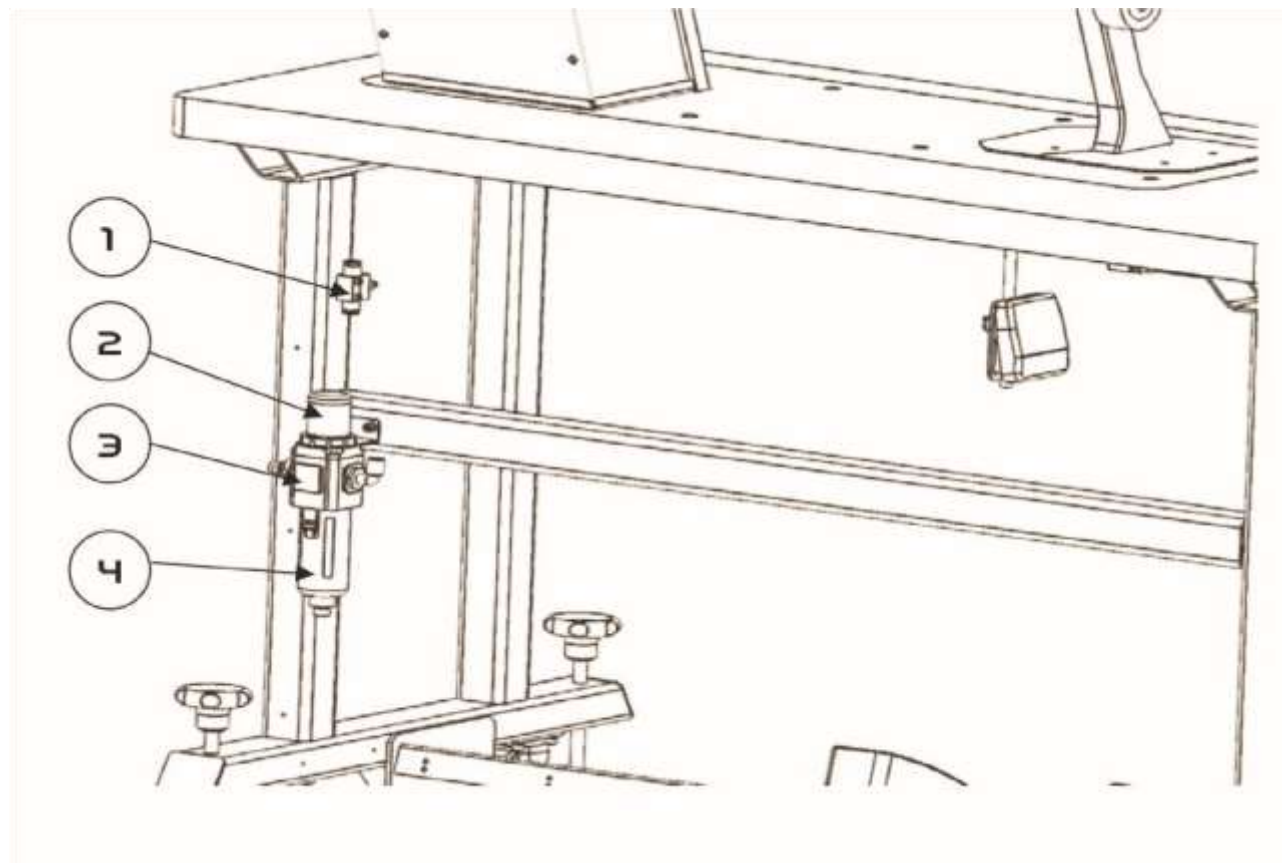
5 加热器

5 heater

> 组件识别 (续) > Component identification (Continued)

>> 压缩空气开关按钮及主空气过滤器组件

>> Compressed air switch close button and main air filter assembly



- 1 压缩空气开关按钮
- 1 Compressed air switch button
- 2 主压缩空气压力调整器
- 2 Main compressed air pressure regulator
- 3 主压缩空气压力表
- 3 Main compressed air pressure gauge
- 4 水隔
- 4 Water barrier

加热密封胶带后，胶带上的黏合剂粘性将会变得活跃，再将其加压黏贴于防水涂层或织物封口迭层上。胶

带冷却后，胶带与封口便可紧密地黏合。封口的黏合强度能够阻挡加压水渗入接缝。防水缝口便制成。

“KT-100 热风机”能准确控制所产生的热风温度，并直接加热密封胶带的黏合剂。织物及加热后的胶带会送入两个相对位置，称为压辊的旋转滚轴上。压辊的线性速度称之为密封速度。

在密封过程中，热风从风嘴喷出。因为实际到达胶带表面的热风嘴是风嘴所喷出的热空气及周围空气的混合气体，故气体到达胶带的实际温度低于风嘴的温度。风嘴与胶带之间的距离越远，热风中所混合的周围空气比例越高。另一方面，提高热风的流量可减少周围空气的比率，从而提高接触胶带的热风温度。故此风嘴位置及热气流量都是非常重要的因素。

因此，影响缝口密封的主要因素包括：

- 热风温度
- 密封速度
- 风嘴气压
- 空气流量
- 风嘴位置

因上述因素会互相联系，直接影响密封的准确度，若要生产具有一致性的产品，需准确设置以上所有因素。

After heating the sealing tape, the adhesive viscosity on the tape will become active, and then press it and stick it on the waterproof coating or fabric sealing laminate. glueAfter the belt is cooled, the tape and the seal can be tightly bonded. The adhesive strength of the seal can prevent pressurized water from penetrating into the joint. The waterproof seam is made.

"KT-100 hot air blower" can accurately control the temperature of the hot air generated and directly heat the adhesive of the sealing tape. The fabric and the heated tape will It is sent to two relative positions on the rotating roller called the reel. The linear speed of the reel is called the sealing speed.

During the sealing process, hot air is ejected from the nozzle. Because the hot air nozzle that actually reaches the surface of the tape is a mixture of the hot air sprayed from the air nozzle and the surrounding air Gas, so the actual temperature of the gas reaching the tape is lower than the temperature of the tuyere. The farther the distance between the nozzle and the tape, the air around the mixed The higher the gas ratio. On the other hand, increasing the flow of hot air can reduce the ratio of surrounding air, thereby increasing the temperature of the hot air contacting the tape. So wind The position of the mouth and the flow of hot air are very important factors.

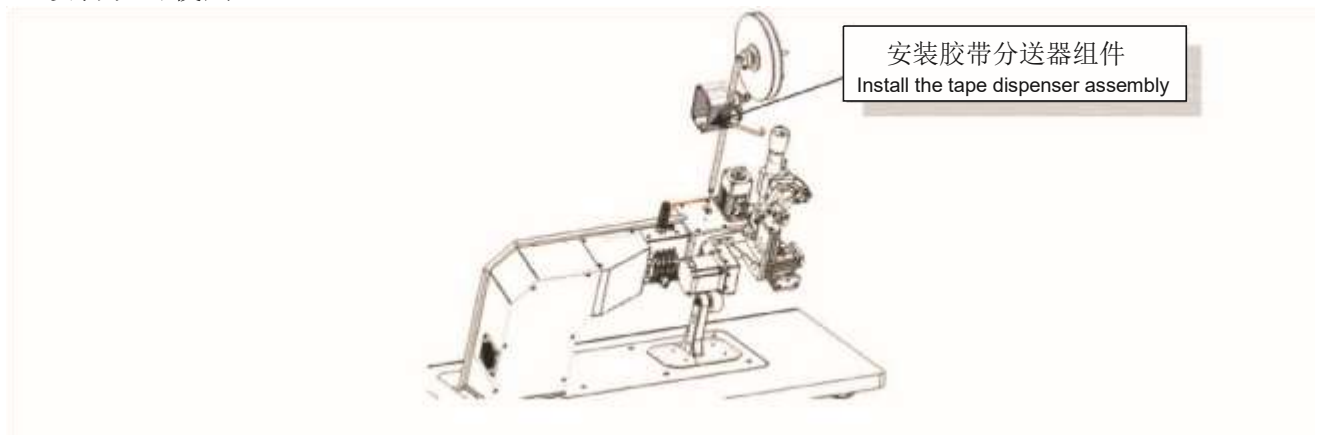
Therefore, the main factors affecting the seam seal include:

- Hot air temperature
- Sealing speed
- Air nozzle pressure
- Air flow
- Nozzle position

Because the above factors are interrelated and directly affect the accuracy of the seal, if you want to produce a consistent product, you need to set all the above factors accurately.

安装必须由专业人员执行并遵循以下步骤：

1. 将机器置于一个平整的表面上并且两边（包括背面）各留下至少 50cm 的空隙，这对于热风导向装置的正常运作及为基本维修服务预留充足空间，是极为重要的。
2. 调较机脚以至机身水平。
3. 松开包装束带及包装材料，以便解开器材配件。
4. 将电源插头插入合适的电容量至少为 15 安的插座。
5. 将本设备所配置的送风管找出，将其一端连接至设备背面的滤水器，另一端与压缩空气供给装置如空气压缩机或中央送风装置连接。必须确保压缩空气的压力强度至少为 0.6 兆帕（6 巴）及流量不少于 100 升/分钟。
6. 将胶带分送器安置于设备顶部，并调教带盘与设备的所在平面成 90° 角。（参看下图）
7. 旋转一卷密封胶带于带盘上，带有粘性的一面朝向操作人员（请查阅装带部分）。
8. 设备现可使用。



The installation must be performed by a professional and follow the steps below:

1. Place the machine on a flat surface and leave a gap of at least 50cm on both sides (including the back).  
This is for the hot air guide device. It is extremely important for the normal operation of the system and reserve sufficient space for basic maintenance services.
2. Adjust the feet of the machine so that the machine is level.
3. Loosen the packaging straps and packaging materials in order to untie the equipment accessories.
4. Insert the power plug into a suitable socket with a capacity of at least 15A.
5. Locate the air supply pipe configured with this equipment, and connect one end to the water filter on the back of the equipment, and the other end to the compressed air supply device. Air compressor or central air supply device connection. It must be ensured that the pressure strength of the compressed air is at least 0.6 MPa (6 bar) and the flow rate is not less than 100 liters/minute.
6. Place the tape dispenser on the top of the device, and adjust the tape reel to make an angle of 90° with the plane of the device. (See the picture below)
7. Rotate a roll of sealing tape on the reel, with the sticky side facing the operator (please refer to the tape loading section).
8. The equipment is now ready for use.

## > 操控方法 > Control method

### >> 触屏式控制面板

透过触屏式控制面板，用指尖触碰屏幕上的参数进行调整，几乎所有的设置及机械定时控制参数均可输入，亦可转换页面更改其它参数（请参阅控制菜单导航部分）。屏幕表面有一层保护膜可以防止表层刮损，但使用时仍需避免过度用力触摸屏幕。

警告：绝对禁止使用剪刀，锥子，针等尖锐物品去触碰膜屏，会对触摸屏造成不可修复的损伤。

### >> 脚踏开关

本机器有 2 个脚踏开关和 1 个膝开关。可以在控制界面上选择不同的工厂模式实现不同的功能，以适应不同操作习惯的操作员。本机的脚踏开关只须由操作员的脚部进行操作，既可单独使用也可同时使用。因此，操作员的手部可自由控制加工的织物。

### >> Touch screen control panel

Through the touch screen control panel, touch the parameters on the screen with your fingertips to adjust, almost all settings and mechanical timing control parameters can be input. You can also switch the page to change other parameters (please refer to the control menu navigation section). There is a protective film on the surface of the screen to prevent the surface from scratching. However, you still need to avoid excessively touching the screen when using it. Warning: It is absolutely forbidden to use scissors, awl, needles and other sharp objects to touch the film screen, which will cause irreparable damage to the touch screen.

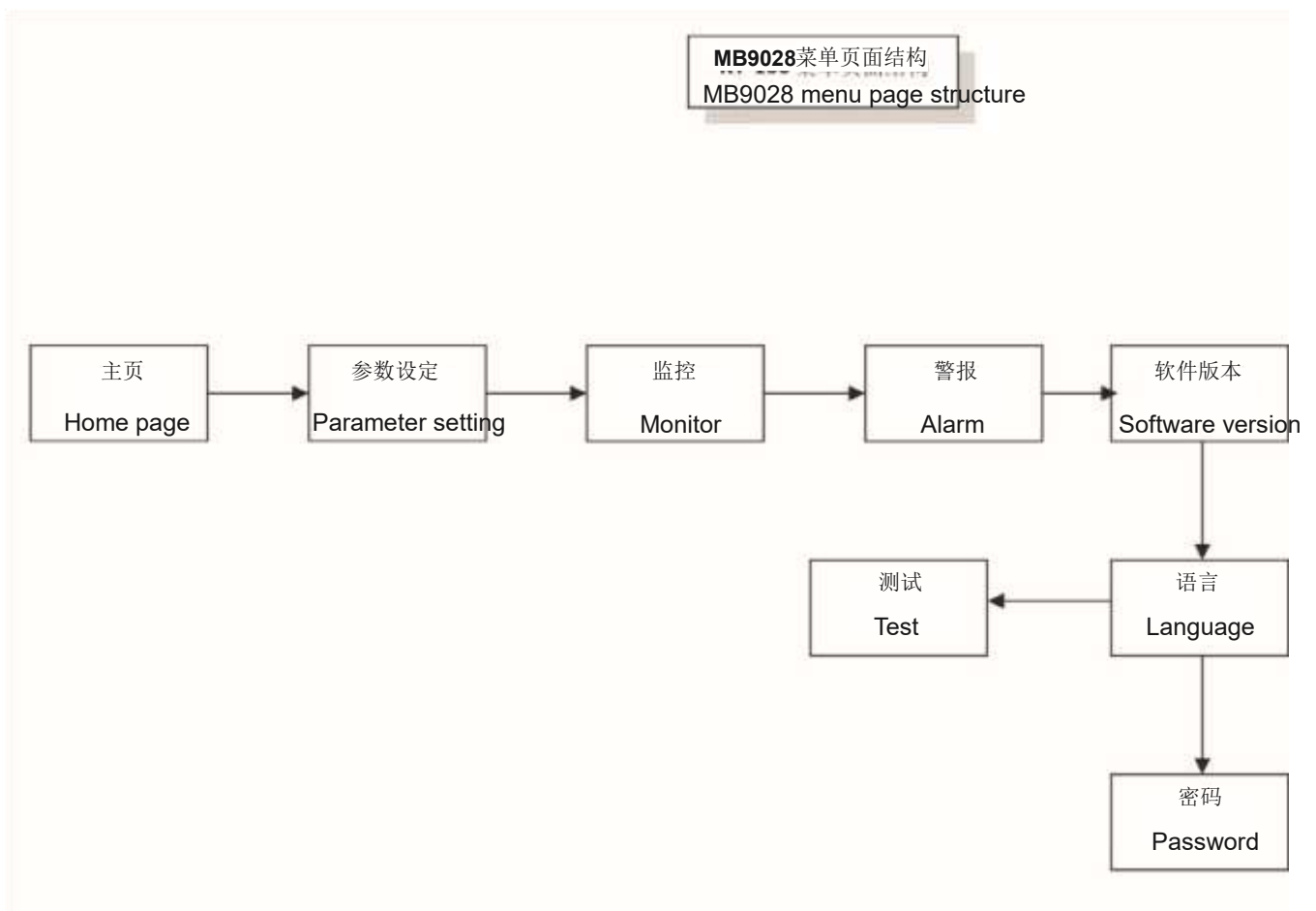
### >> Foot switch

This machine has 2 foot switches and 1 knee switch. Different factory modes can be selected on the control interface to achieve different functions to suit Operators with different operating habits. The foot switch of this machine only needs to be operated by the operator's foot, and it can be used alone or at the same time. Therefore, the operator's hand can freely control the processed fabric.

>> 控制菜单导航 >> Control menu navigation

**MB 9028**热风机具备多种参数，方便用户根据操作情况进行调整。根据其功能性而设，触屏式控制面板的不同菜单页面编排有不同的参数。菜单页面的编排结构如下图表所示。

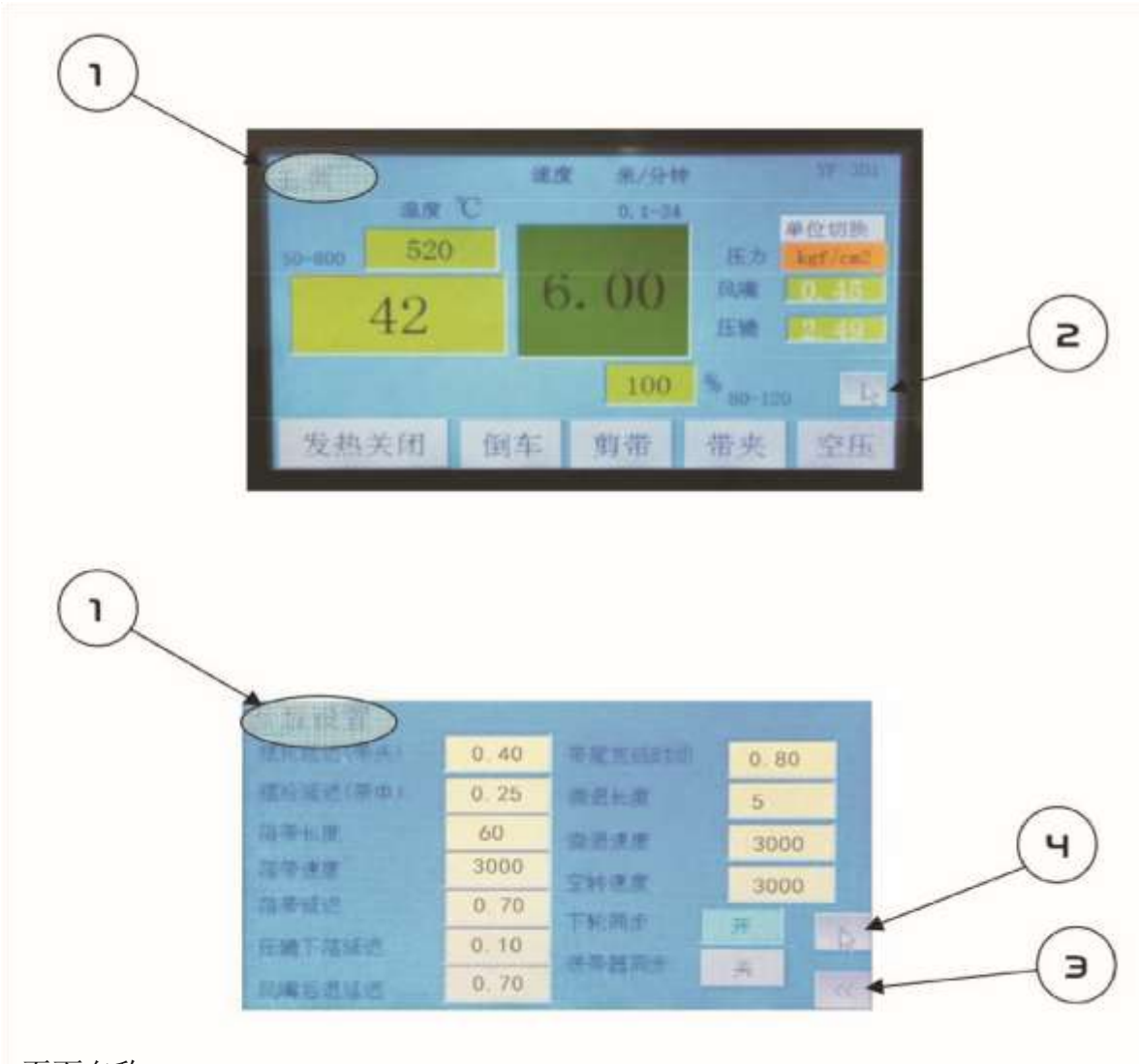
MB9028 hot air blower has a variety of parameters, which is convenient for users to adjust according to operating conditions. According to its functionality, the touch screen control panel Different menu page layouts have different parameters. The layout structure of the menu page is shown in the figure below.



>> 控制菜单导航 (续) >> Control menu navigation (Continued)

以下是典型的功能页面，其左上角均有名称以便确认。标有指向右面箭头的按钮是作为操作功能组的导航。标有指向下方箭头的按钮是支援功能组的导航。请注意主页为功能网络的核心，故只有该页面同时具有操作功能组及支援功能组的按钮。

The following is a typical function page, with names in the upper left corner for confirmation. The button marked with an arrow pointing to the right is used as an operation function group navigation. The button with an arrow pointing down is to support the navigation of the function group. Please note that the homepage is the core of the functional network, so only this pagelt also has buttons for operating the function group and supporting the function group.



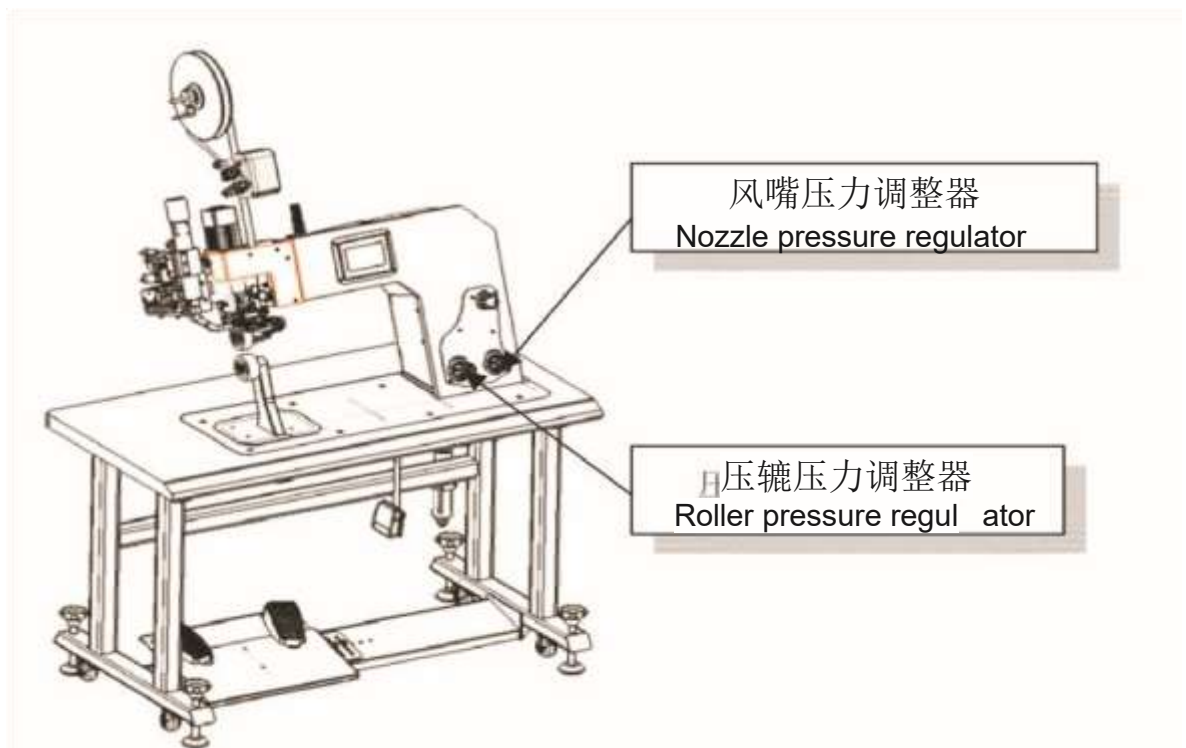
- 1 页面名称  
Page name
- 2 下一个操作页面  
Next operation page
- 3 返回主页功能热键  
Return to homepage function hotkey
- 4 下一个支援功能页面  
Next support function page

> 操控方法（续） > Control method (Continued )

>> 压力调整 >> Pressure adjustment

拉出压力调整旋钮之后，按顺时针或逆时针旋转便可按需要增加或减少压力。操作完成后，需将压力调整旋钮推向调整器方可锁住调整器的压力。

After pulling out the pressure adjusting knob, turn it clockwise or counterclockwise to increase or decrease the pressure as needed. After the operation is completed, the pressure needs to be adjusted Push the knob toward the regulator to lock the pressure of the regulator.



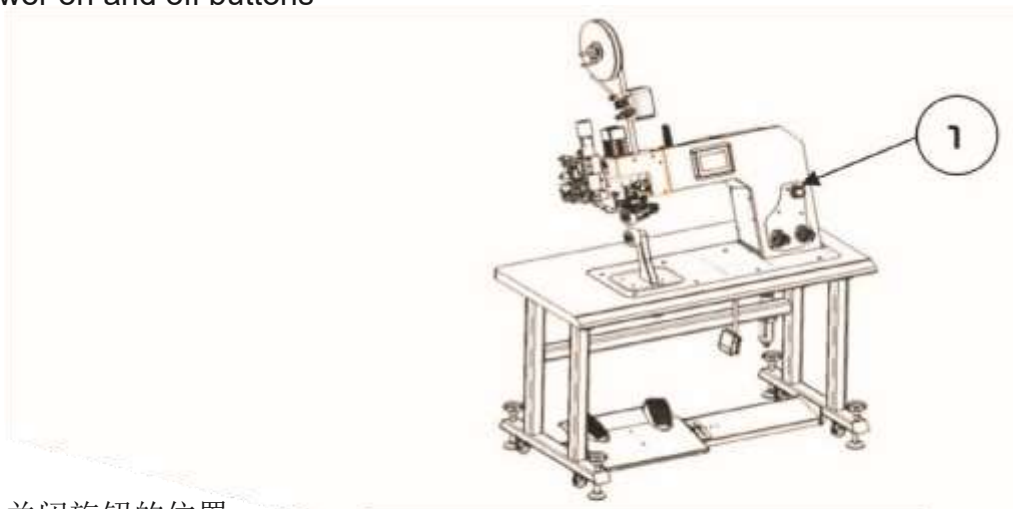
## >启动及关闭步骤      >Start-up and shutdown steps

正确地启动及关闭本机，对于保持其良好性能极为重要，所以请按以下所述步骤执行。

Starting and shutting down the machine correctly is extremely important to maintain its good performance, so please follow the steps described below

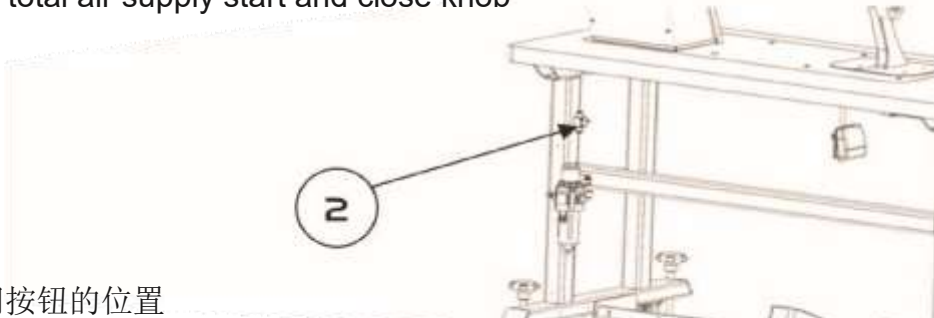
电源启动及关闭按钮的位置

Location of the power on and off buttons



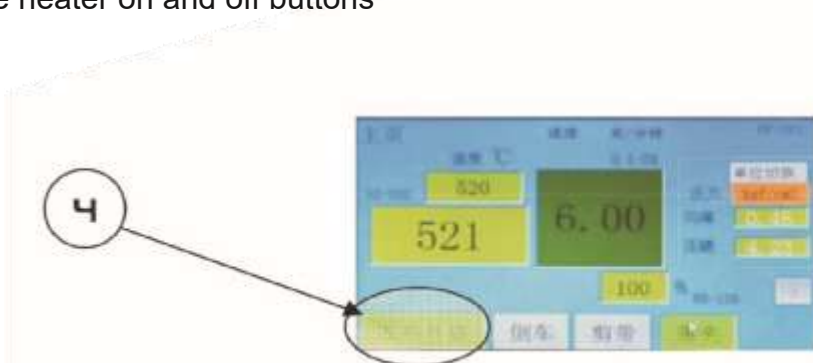
总空气供应启动及关闭旋钮的位置

The position of the total air supply start and close knob



加热器启动及关闭按钮的位置

The position of the heater on and off buttons



- 1 电源关闭按钮  
Power off button
- 2 电源启动按钮  
Power start button
- 3 总空气供应启动及关闭旋钮  
Total air supply start and close knob
- 4 加热器启动及关闭按钮  
Heater start and stop button

## > 启动及关闭步骤（续） > Start-up and shutdown steps (continued)

### >> 启动步骤 >> Start steps

- 1 逆时针旋转电源启动按钮，启动设备。
  - 2 转动总空气启动/关闭旋钮，启动压缩空气供应系统。
  - 3 按下「发热关闭」按钮，启动加热功能。（字体由灰色背景变为绿色背景，对应文字显示为加热开启，即表示开始加热）
- 1 Turn the power start button counterclockwise to start the device.
  - 2 Turn the total air start/stop knob to start the compressed air supply system.
  - 3 Press the heating off button to start the heating function. (The font changes from a gray background to a green background, and the corresponding text is displayed as heating on Kai, it means heating starts)



### >> 关闭步骤 >> Close steps

#### 警告！

请严格遵从以下关闭步骤以避免对加热器造成损害。必须待加热器冷却后方能关闭压缩空气供应装置。

#### caveat!

Please strictly follow the shutdown steps below to avoid damage to the heater. The compressed air supply device can only be turned off after the heater has cooled down.

- 1 若机器处于加热状态时，再次按下发热按钮，字体由绿色背景变为灰色背景，对应文字显示为加热关闭时，即已经关闭热器。
  - 2 留意风嘴的温度，其温度会逐渐下降。
  - 3 请等待风嘴的温度降至 60℃ 以下，因之前的温度及周围的环境而异，整个过程可能需时 5-10 分钟。
  - 4 在确定风嘴温度低于 60℃ 后，按下红色电源关闭按钮，关闭设备。
  - 5 随后转动总空气供应启动及关闭按钮以停止压缩空气供给。
- 1 If the machine is in the heating state, press the heating button again, the font changes from a green background to a gray background, and the corresponding text is displayed as heating When it is turned off, the heater is already turned off.
  - 2 Pay attention to the temperature of the nozzle, its temperature will gradually drop.
  - 3 Please wait for the temperature of the tuyere to drop below 60° C. Depending on the previous temperature and surrounding environment, the whole process may take 5-10 minutes.
  - 4 After confirming that the air nozzle temperature is lower than 60° C, press the red power off button to turn off the device.
  - 5 Then turn the total air supply start and stop button to stop the compressed air supply.

> 基本操作 > Basic operation

>> 温度，密封速度和压力调整

>> Temperature, sealing speed and pressure adjustment

操作前，请注意你需要设置的基本参数所在位置。详细解释请参考相应部分。

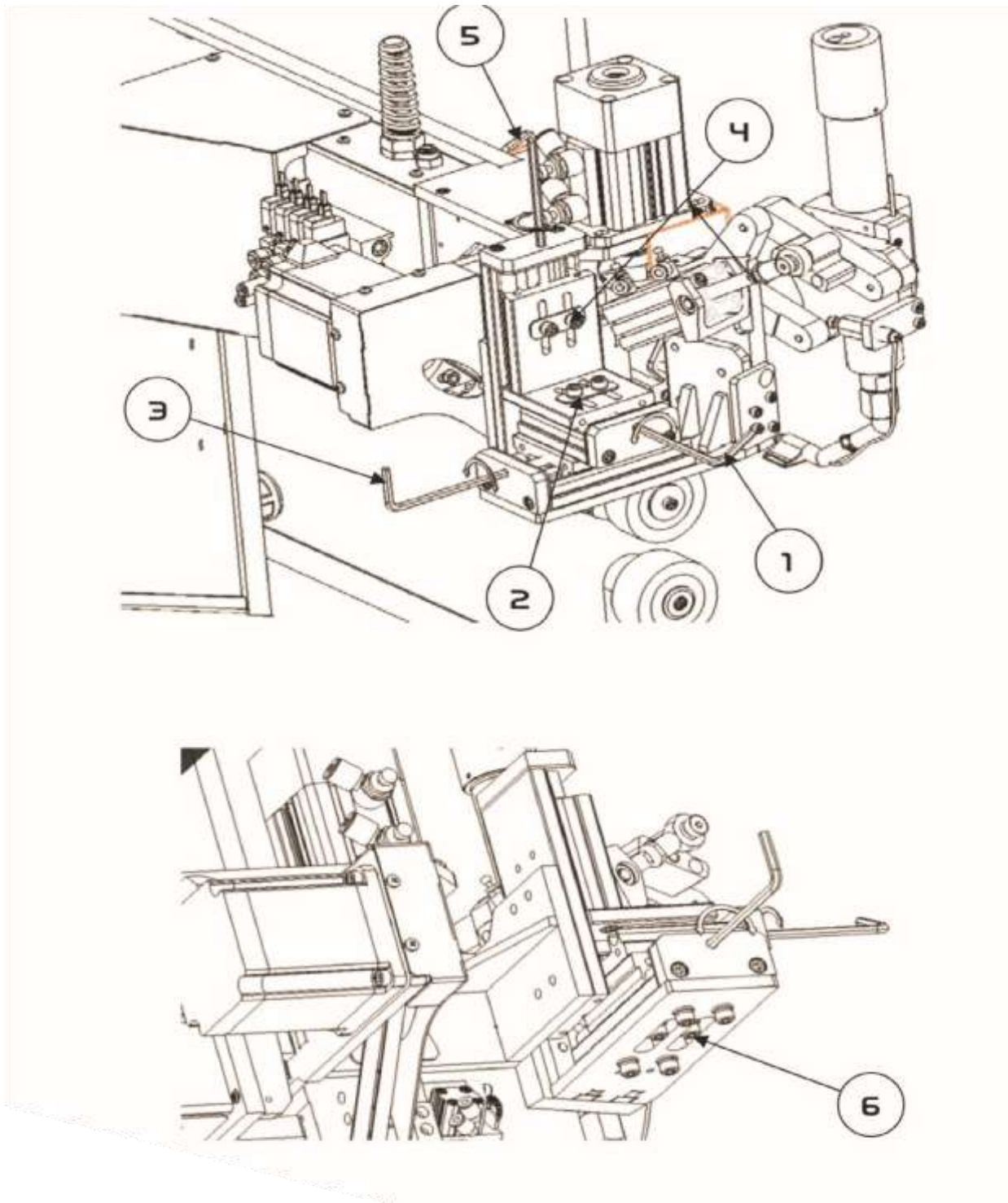
Before operation, please pay attention to the location of the basic parameters you need to set. For detailed explanation, please refer to the corresponding section.



- |        |                                |
|--------|--------------------------------|
| 1 设定温度 | 1 Set temperature              |
| 2 密封速度 | 2 Sealing speed                |
| 3 风嘴压力 | 3 nozzle pressure              |
| 4 压辊气压 | 4 Pressure roller air pressure |

> 基本操作(续) > Basic operation (continued)

> > 风嘴位置调整 >> Air nozzle position adjustment



1 风嘴位置（左-右调整）

2 风嘴左-右调整锁定螺丝

3 风嘴位置（远-近调整）

4 风嘴远-近调整锁定螺丝

5 风嘴位置（上-下调整）

6 风嘴上-下调整锁定螺丝

1 Air nozzle position (left-right adjustment )

2 Air nozzle left-right adjustment locking screw

3 Air nozzle position (far-near adjustment )

4 Air nozzle far-near adjustment locking screw

5 Air nozzle position (up-down adjustment )

6 Air nozzle up-down adjustment locking screw

## >基本操作（续） > Basic operation(continued)

### >> 密封步骤 >> Sealing step

将加热器温度，风嘴压力及密封速度设置到所需值。刚启动时，请将加热器温度，风嘴压力及密封速度分别设置为 400℃，0.1 兆帕及 12 英尺/分钟。以上设置为第一次启动时的适宜设定，但是其它的设置可根据实际情况进行设定。

实时启动运转先踏下左脚踏（压辊下压），在左脚踏仍踏下时，再踩右脚踏，风枪摆入，检查风嘴位置并适当地调整。

将密封胶带放入胶带稳定器和白色胶带压辊中，先踏下左脚踏（压辊下压），在左脚踏仍踏下时，再轻踩一下右脚踏，以便将胶带延伸入压辊中，胶带必须放置于中间位置并且具粘性的一面朝向操作员。调整密封胶带的张力及转动位置（请参阅装带部分）。

用双手将缝口聚合至于指可以触碰到起点的位置。将前臂置于桌面上，再用手指使缝口平滑。

启动运转踏板（右脚），热风嘴开始运行，压辊也会开始转动并将压辊之间的胶带及缝口卷入。松开缝口同时将其置于下压辊中间。

快到胶带尾端时，在左、右脚踏仍踏下时，先松开左脚踏，便可将胶带剪断。上压辊抬起后，新胶带便会自动送下。第一次缝口密封时，重复上述步骤进行下次的密封。

Set the heater temperature, nozzle pressure and sealing speed to the required values. Just start, please adjust the heater temperature, nozzle pressure and seal The speeds were set to 400° C, 0.1 MPa and 12 ft/min. The above settings are suitable for the first startup, but other settingsThe setting can be set according to the actual situation.

Start the operation in real time, first step on the left pedal (press the roller down), and when the left pedal is still depressed, step on the right pedal again, swing in the air gun, and check the air nozzle Position and adjust appropriately.

Put the sealing tape into the tape stabilizer and the white tape press roller, first step on the left pedal (press the roller down), and when the left pedal is still stepping down, Step on the right pedal again to extend the tape into the press roller. The tape must be placed in the middle with the sticky side facing the operator.

Adjust the tension and rotation position of the sealing tape (please refer to the section on tape loading). Use both hands to gather the seam so that your fingers can touch the starting point. Place your forearm on the table and smooth the seam with your fingers.

Start the running pedal (right foot), the hot air nozzle starts to operate, the pressure roller will also start to rotate and the tape and seam between the pressure roller will be drawn in. Loosen the seam Put it in the middle of the lower pressure reel at the same time.

When approaching the end of the tape, while the left and right pedals are still being stepped on, release the left pedal first to cut the tape. After the upper pressure reel is lifted, the new tape will be It will be sent automatically.

When the seam is sealed for the first time, repeat the above steps for the next sealing.

### >> 剪带 >> Cut tape

密封时-左、右脚踏处于前进密封位置时，松开左脚踏便可剪断胶带。

闲置时-手动按下触摸屏上的 剪带 按钮，便可剪断胶带。闲置时-左、右脚踏处于回转位置时，松开左脚踏便可剪断胶带。

When sealing-when the left and right pedals are in the forward sealing position, release the left pedal to cut the tape.

When not in use-manually press the cut tape button on the touch screen to cut the tape.

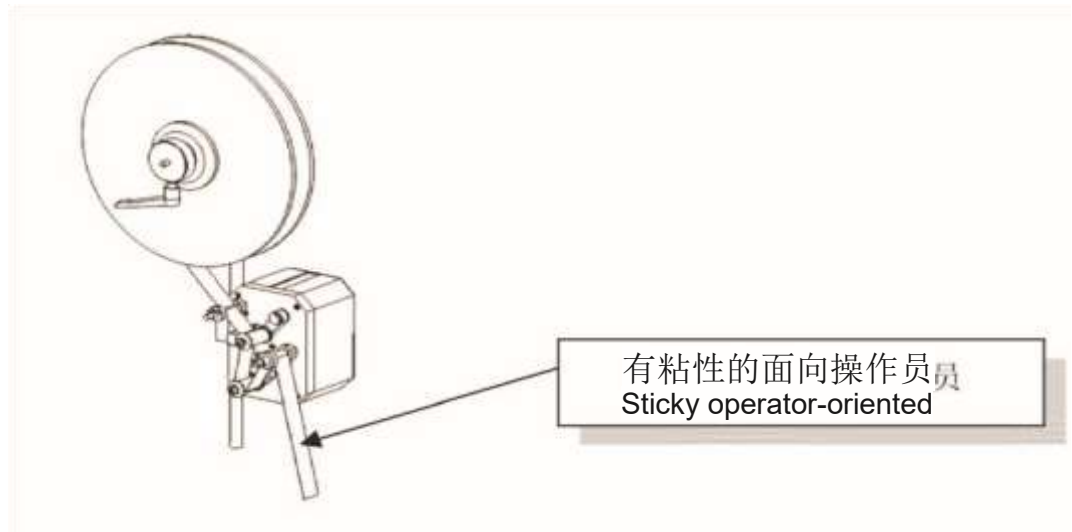
When idle-when the left and right pedals are in the rotating position, release the left pedal to cut the tape.

>基本操作（续） > Basic operation（continued）

>> 落带 >> Drop zone

将胶带装入带盘上，按既定路线将胶带穿过松带器，如下图所示。安放胶带时，须确保具粘性的一面要面向操作员。

Put the tape on the reel, and pass the tape through the loosener according to the established route, as shown in the figure below. When placing the tape, make sure that the sticky side is For the operator.



下一步：将胶带导出各种路径，如下图所示：将胶带从带盘按顺序导入到带夹，穿过带夹置于上压辊的中心位置。

警告：不正确的导带方式，可能会导致在密封时偏带，及松带器故障等情形。

Next step: Export the tape to various paths, as shown in the figure below: Import the tape from the tape reel to the belt clip in order, pass through the belt clip and place it on the upper rollerCentral location.

Warning: Improper way of guiding the tape may cause the tape deviation during sealing and the failure of the tape loosener.

过往，热风机的生产技术大致相同，在日常生产中，质量与效率之间的矛盾成为密封的主要问题，令制造商在炎苦恼。

而MB9028 热风机的设计令密封大大简化，控制更为精确。独一无二的新特特性让用户能在目前水平上，根据微调密封所需条件，解决传统热风机在密封时所存在的一些问题。

### **MB9028** 热风机的特性举例如下：

压力数字化显示，可实现压力单位切换  
自动报警，故障排除功能  
上下轮差速运行  
自动测试及工厂模式选择  
参数化设置带 头/中/尾端  
数码松带器  
参数密码锁定

In the past, the production technology of hot air blowers was roughly the same. In daily production, the contradiction between quality and efficiency became the main problem of sealing, making manufacturing Shang is in distress.

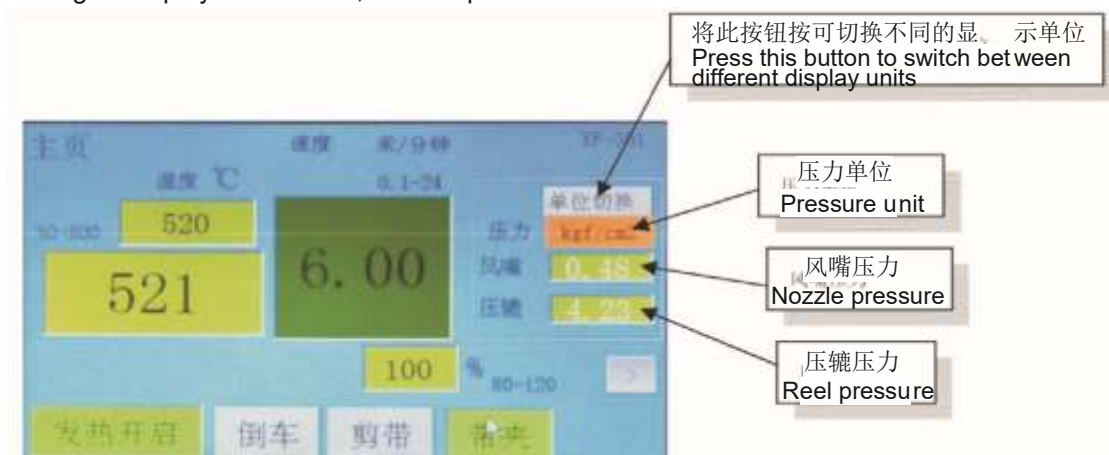
The design of the MB9028 hot air blower greatly simplifies the sealing and more precise control. Unique new features allow users to be based on the current level According to the conditions required for fine-tuning the sealing, some problems existing in the sealing of the traditional hot air blower are solved.

The characteristics of MB9028 hot air blower are as follows:

Pressure digital display, can realize pressure unit switch  
Automatic alarm, troubleshooting function  
Differential running of upper and lower wheels  
Automatic test and factory mode selection  
Parameterized setting lead/middle/end  
Digital release  
Parameter password lock

>>压力数字化显示同，可实现压力单位切换

>> The pressure digital display is the same, and the pressure unit can be switched



下单位切换按钮，可切换不同压力单位（kgf/cm<sup>2</sup>、Mpa、PSI、bar）。

Press the unit switch button to switch between different pressure units (kgf/cm<sup>2</sup>, Mpa, PSI, bar).

>>自动报警，故障快速排除功能

该功能用于机器发生故障时便于开始排除，以缩短停机时间。

若机器显示警报时，侧会显示下图标志，按下警报按钮后，侧进入警报界面，可以查看警报信息是，可以根据信息排除故障

>> Automatic alarm, quick troubleshooting function

This function is used to facilitate troubleshooting when the machine fails to shorten the downtime.

If the machine displays an alarm, the side will display the following logo, after pressing the alarm button, the side will enter the alarm interface, you can view the alarm information Troubleshoot based on information

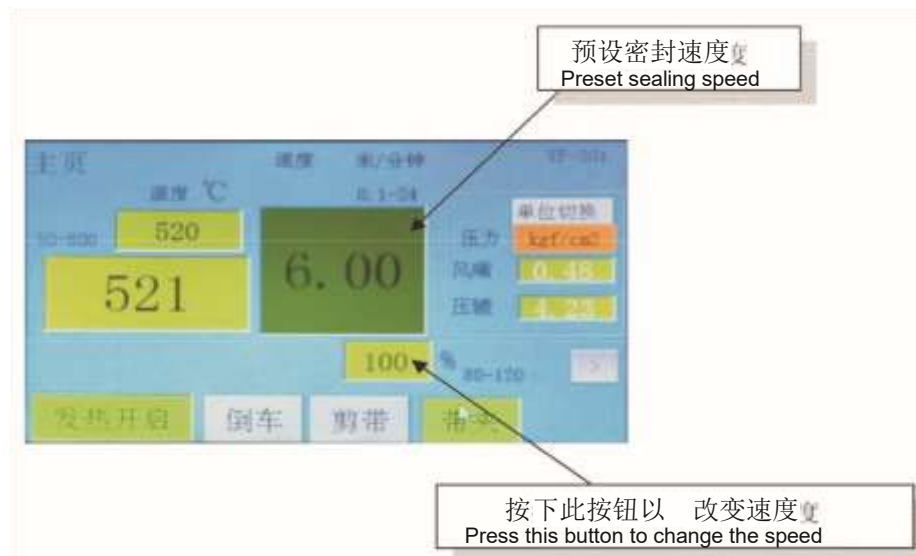


>高级操作（续） >Advanced Operations(Continued )

>差速 >Differential

在该功能下，操作员可以将上下压辊设定为不同的速度。

Under this function, the operator can set the up and down rollers to different speeds.



上压辊以预设速度运行时，下压辊将会以%的设定速度动行。

下压辊的速度=预设速度 x%设定。

若差速设定=100%，下压辊的滚动速度与上压辊的滚动速度一样。

若差速设定>100%，下压辊的滚动速度大于上压辊的滚动速度。

若差速设定<100%，下压辊的滚动速度小于上压辊的滚动速度。

设定百分比的范围是 80-120%。

**警告！**

差速较大时（<90%或>110%）压辊之间一定要放置一块织物，否则，会导致传输系统压力过大而损坏机器部件。

**用途：**

减少因弹性织物拉伸而产生的焊缝皱纹。

减少因上下压辊磨损变得不均匀而造成的焊缝争纹。

改善某些织物会出现的“竹壳”现象。

When the upper pressing reel runs at the preset speed, the non-pressing reel will move at the% set speed.

The speed of pressing the reel = preset speed x% setting.

If the differential speed setting=100%, the rolling speed of the lower pressure reel is the same as that of the upper pressure reel.

If the differential speed setting is >100%, the rolling speed of the lower pressure reel is greater than that of the upper pressure reel.

If the differential speed is set to <100%, the rolling speed of the lower pressure reel is less than that of the upper pressure reel.

The range of setting percentage is 80-120%.

**caveat!**

When the differential speed is large (<90% or >110%), a piece of fabric must be placed between the rollers, otherwise, it will cause excessive pressure in the transmission system

And damage the machine parts.

**Use:**

Reduce weld wrinkles caused by stretched elastic fabric.

Reduce the weld seam contention caused by uneven wear of the upper and lower rollers.

Improve the "bamboo shell" phenomenon that occurs in some fabrics.

>高级操作（续） >Advanced Operations(Continued )

>>自动测试及工厂模式选择

在语言界面有隐藏进入自动测试界面按钮，只需要先点击左上角，然后快速点击右下角，侧可以进入到测试界面，在测试界面中可以选不同的工厂模式，以及打开自动测试功能

>>Automatic test and factory mode selection

There is a hidden button to enter the automatic test interface in the language interface, just click the upper left corner, and then quickly click the lower right corner to enter the test world In the test interface, you can select different factory modes and turn on the automatic test function

工厂模式选择  
Factory mode selection

>>参数化设置

MB9028 热风机能识别机器所处的密封阶段。根据密封进程的独立程序可改变机械的运作。改变该页面参数可实现对不同材料与不同胶带。

>>Parameterization

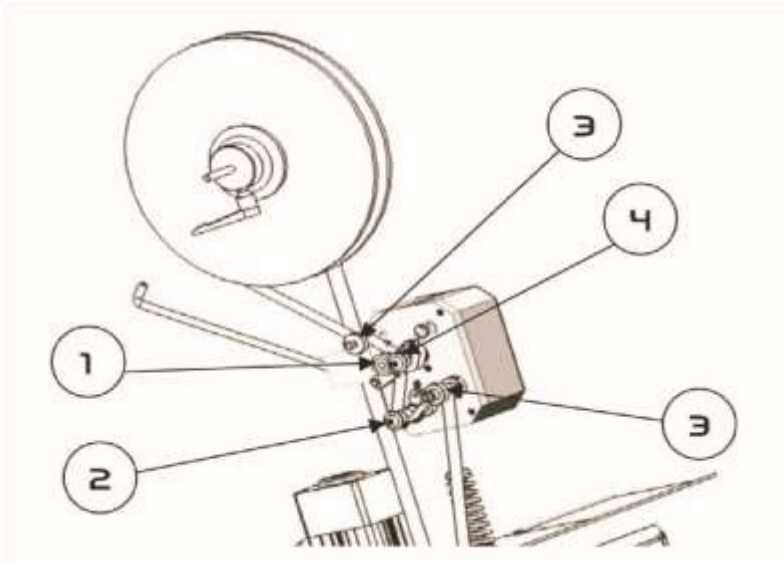
MB9028 hot air blower can identify the sealing stage of the machine. The operation of the machine can be changed according to an independent program of the sealing process. Change this page Parameters can be realized for different materials and different tapes.



>>数码松带器 >>Digital loosener

密封期间，密封胶带对密封区域的持续供应非常重要，而 MB9028 热风机配备一个内置数码松带器，可确保胶带的供应，请按照以下示图正确将胶带穿过密封区域。

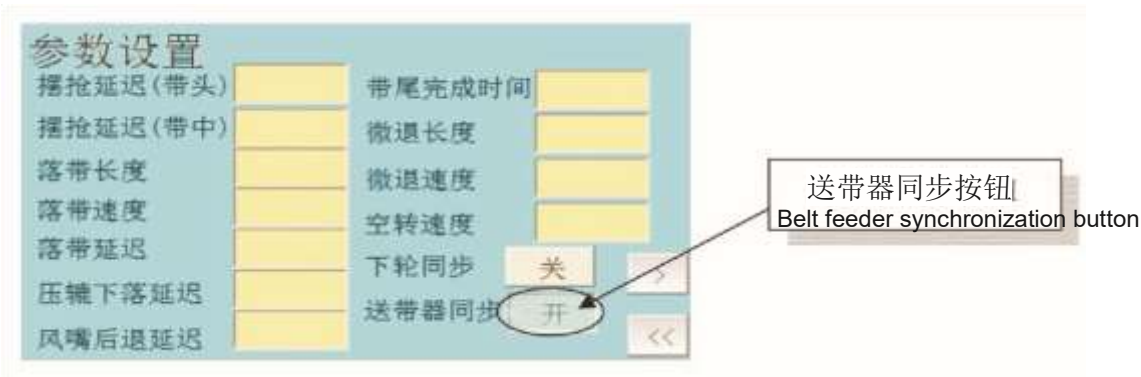
During the sealing period, the sealing tape is very important for the continuous supply of the sealed area, and The MB9028 hot air blower is equipped with a built-in digital tape loosener, which can To ensure the supply of tape, please correctly pass the tape through the sealing area as shown in the figure below.



- |   |        |   |                  |
|---|--------|---|------------------|
| 1 | 主动轮    | 1 | Driving wheel    |
| 2 | 摆动式传感器 | 2 | Swing sensor     |
| 3 | 胶带挡规   | 3 | Tape stop gauge  |
| 4 | 松带器压辊  | 4 | Belt looser reel |

机器运行时会默认运行松带器与送带轮同步，如果不需要同步功能，可以在参数设置界面的将其关闭。

When the machine is running, the belt releaser and the belt pulley will be synchronized by default. If the ynchronization function is not required, you can set the parameter Set the interface to close it.

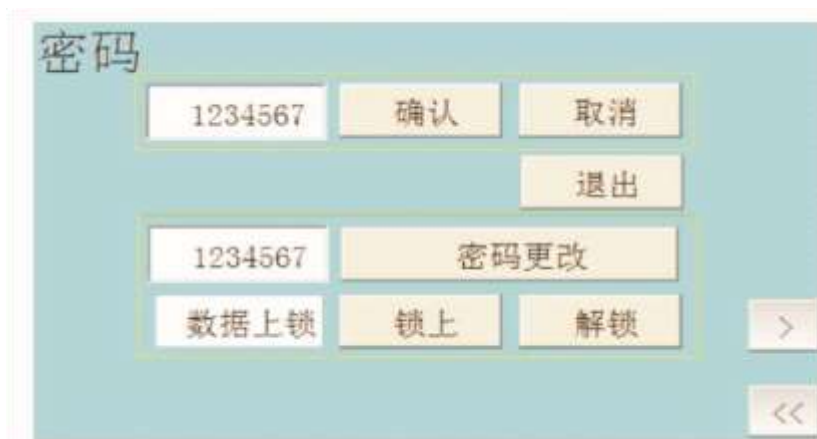


高级操作（续） >Advanced Operations(Continued )

>>参数锁定 >>Parameter lock

本机设置具有参数锁定功能，可以免受参数突然改变泽机器造成的损害。进入到密码界面后，初始密码是 22222，进入界面后可以修改密码以及给数据上锁。锁定后按退出按钮即可

The machine setting has a parameter lock function, which can avoid the damage caused by the sudden change of the parameter. After entering the password interface, the initial password The code is 22222, you can change the password and lock the data after entering the interface. Press the exit button after locking

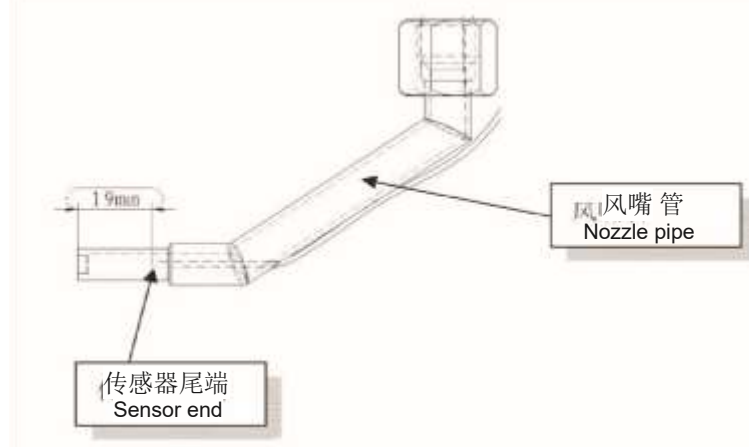


>> 更换零件程序  
温度传感器

替换热电偶时，其尾端位置非常重要，必须与下图所示位置一样。请检测以确保热电偶尾端位于导管中央，不要接触到金属体部分。上述操作对传感器能否正确测量热风温度非常重要。

>> Replace parts program  
Temperature Sensor

When replacing the thermocouple, its end position is very important and must be the same as the position shown in the figure below. Please check to make sure that the thermocouple Do not touch the metal part in the center of the tube. The above operations are very important for the sensor to correctly measure the temperature of the hot air.

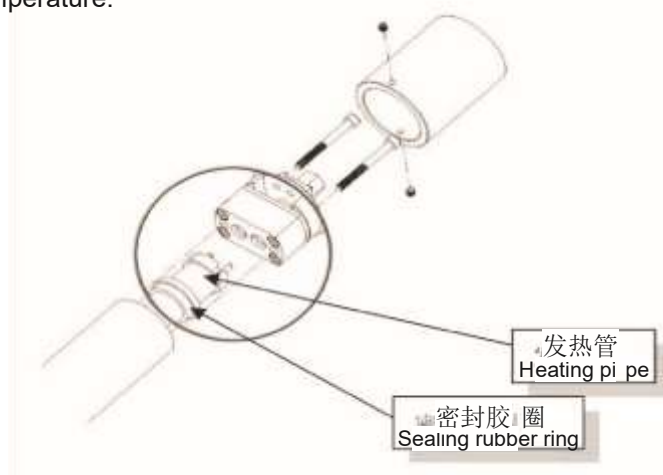


发热管

移出加热器的顶罩及安全网以安装发热管。请小心地将发热管从连接插拉出，更换破损的组件，同时必须确保红色密封胶圈已被正确装上。更换后的安装过程刚刚相反，更换新的发热管后，以 300℃ 的温度运行机器最少 10 分钟，令新的组件与加热器互相适应后，才能以更高的温度操作。

Heating pipe

Remove the top cover and safety net of the heater to install the heating pipe. Please carefully pull out the heating tube from the connector, replace the damaged component, and It must be ensured that the red sealing rubber ring has been installed correctly. The installation process after replacement is just the opposite. After replacing the new heating tube, Run the machine at a higher temperature for at least 10 minutes. After the new components and the heater are adapted to each other, they can operate at a higher temperature.



## >维护(续) >Maintenance (continued>Mai tenance )

### >>维护措施

为保持机械始终牌最佳的运行状态，操作顺利，定期维护是非常重要的。定期维护除了可将停机的几率减到最小，还可以延长机器的寿命。

每日 检查机械装置以确保运转的平稳性及留意怪异噪音。  
检查送风管以防止漏气及损坏。 检查硅胶压  
辊以防磨损及损坏。

每周 检查所有压辊是否游间过度，所有游间应少于 5 毫米，如有需要，可以调整相应的轴轮皮带。

用机械油小心地润滑切割刀片，并抹去多余的润滑油。 机器停止动作并冷却后，按下测试按钮，检查短路开关，此时手柄会立即弹回关闭位置。 检查压辊气缸的上落速度，如有需要，可以通过使用位于压辊气缸上的空气速度调节器 对其进行调整。 目测所有的电子及机械部件是否有异常烧痕或松动现象。

检查风嘴空气压力连锁装置：逐渐降低风嘴的空气压力至低于 0.03 兆帕，此时报警信息出现，加热器的温度下降，随后加热器的电源会被切断。

提高空气压力至 0.2 自己兆帕，主菜单页上的“压力偏低”警报信息会消失。  
视情况维护 请清除压辊上的胶黏剂残余以防止物料缠绕在一起。 如  
有需要请更换老化的压辊。 请更换损坏的发热管，避免因旧组件破裂而  
跌落的物料阻塞风道。 若风嘴堵塞，请将其从加热器移开并轻拍风嘴以  
将异物从入口端放出。

### >>Maintenance measures

In order to keep the machinery in the best operating condition and smooth operation, regular maintenance is very important. In addition to regular maintenance Minimizing the rate can also extend the life of the machine.  
daily

Check mechanical devices to ensure smooth operation and pay attention to weird noises  
Check the air supply pipe to prevent air leakage and damage. Check the silicone pressure  
roller to prevent wear and damage. weekly

Check whether all the pressure reels have excessive play, all play should be less than 5 mm, if necessary, you can adjust the corresponding axle pulley belt.

Carefully lubricate the cutting blade with mechanical oil and wipe off excess lubricating oil.

After the machine stops and cools down, please press the test button to check the short-circuit switch, and the handle will immediately spring back to the closed position.

Check the up and down speed of the roller cylinder, if necessary, you can use the air speed regulator located on the roller cylinder to adjust it Make adjustments.

Visually inspect all electronic and mechanical parts for abnormal burn marks or looseness.

Check the air pressure interlocking device of the air nozzle: gradually reduce the air pressure of the air nozzle to less than 0.03 MPa, at this time an alarm message appears, The temperature of the heater drops, and then the power to the heater is cut off.

Increase the air pressure to 0.2 MPa, and the “low pressure” alarm message on the main menu page will disappear.

### Conditional maintenance

Please remove the adhesive residue on the roller to prevent the materials from being entangled.  
If necessary, replace the aging roller.

Please replace the damaged heating tube to prevent the falling material from rupturing the old component from blocking the air duct.

If the nozzle is blocked, move it away from the heater and tap the nozzle to release foreign objects from the inlet.

## >维护 (续) >Maintenance (continued )

### >>更换零件程序

#### 温度传感器

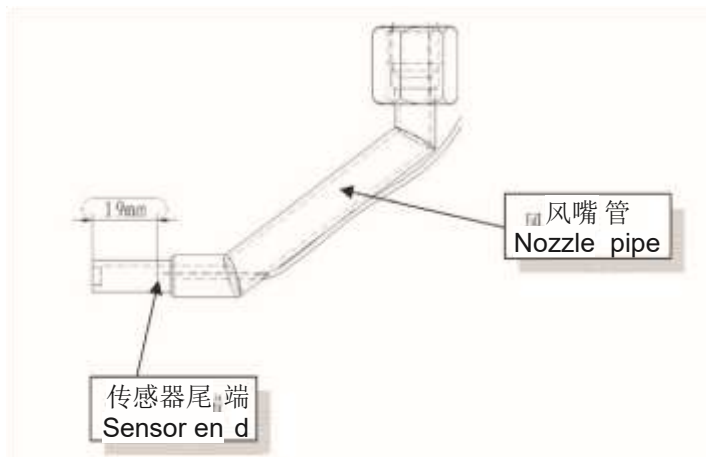
替换热电偶时，其尾端位置非常重要，必须与下图所示位置一样。请检测以确保热电尾端位于导管中央，不要接触到金属体部分。上述操作对传感器能否正确测量热风温度非常重要。

#### >>Replace parts program

##### Temperature Sensor

When replacing the thermocouple, its end position is very important and must be the same as the position shown in the figure below. Please check to ensure that the thermoelectric

Do not touch the metal part in the center of the tube. The above operations are very important for the sensor to correctly measure the temperature of the hot air.

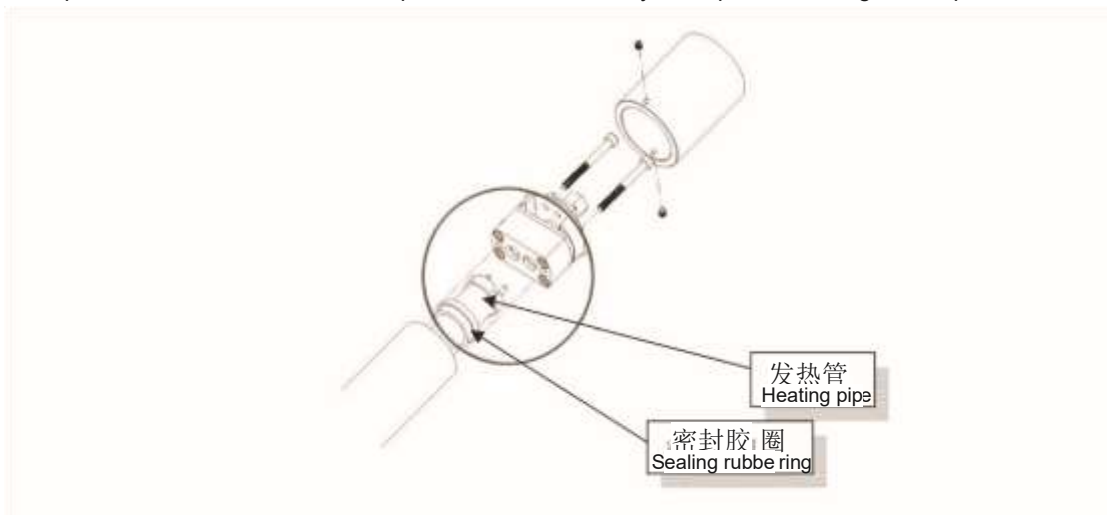


#### 发热管

移出加热器的顶罩及安全网以安装发热管。请小心地将发热管从连接插位出，更换破损的组件，同时必须确保红色密封胶圈已被正确装上。更换后的安装过程刚刚相反，更换新的发热管后，以 300℃ 的温度运行机器最少 10 分钟，令新的组件与加热器互相适应后，才能以更高的温度操作。

##### Heating pipe

Remove the top cover and safety net of the heater to install the heating pipe. Please carefully pull the heating tube out of the connection socket, replace the damaged component, and It must be ensured that the red sealing rubber ring has been installed correctly. The installation process after replacement is just the opposite. After replacing the new heating tube, Run the machine at a higher temperature for at least 10 minutes. After the new components and the heater are adapted to each other, they can operate at a higher temperature.



>>更换零件程序(续)

压辊

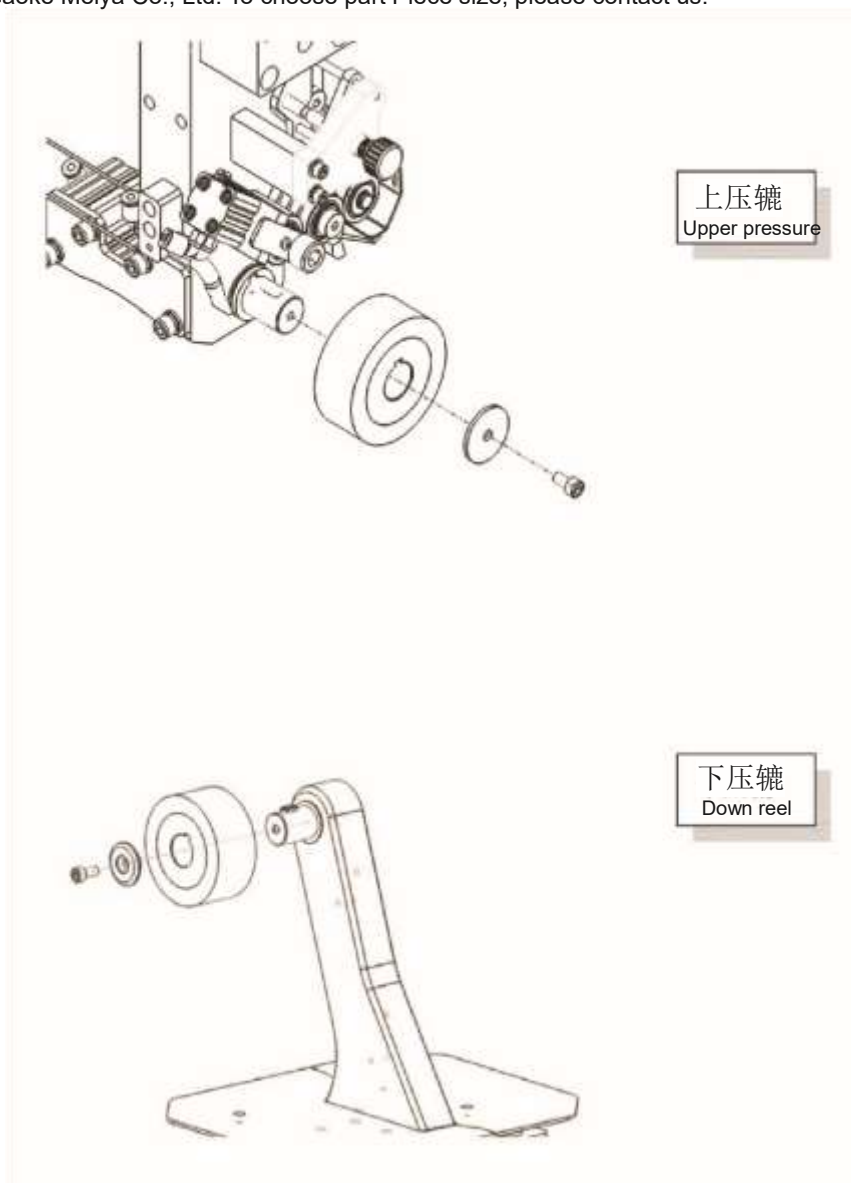
为保持机械的性能,当压辊出现破损迹象时,需要及时更换。更换过程如下图所示。请选择宽度及软度适合的压辊进行更换。为获得最佳性能,请使用高科美亚有限公司的专用零件替换。欲选择部件尺寸,请联系我们。

>>Replacement part program (continued )

Pressure reel

In order to maintain the mechanical performance, when the pressure roller shows signs of damage, it needs to be replaced in time. The replacement process is shown in the figure below. Please select width and

Replace the roller with suitable softness. In order to obtain the best performance, please use the special replacement parts of Gaoke Meiya Co., Ltd. To choose part Piece size, please contact us.



>故障排除

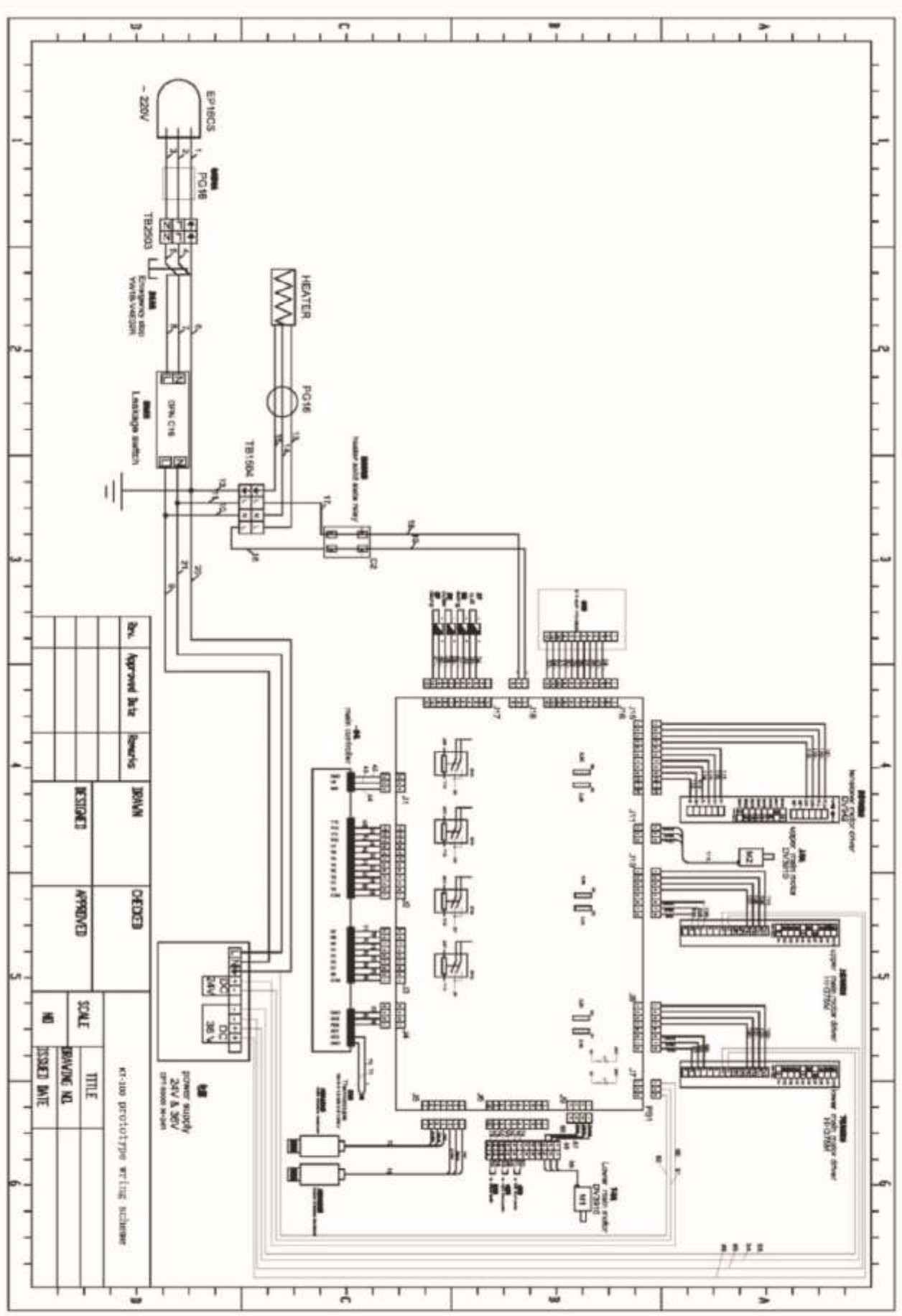
问题	产生原因	解决办法
某些部分无电力输出	电源线或插头有故障	检查供电连接
	短路开关跳闸	重设短路开关并检查产生原因
	总电源开关未开启	按下电源启动按钮（启动）
	接触不良	检查所有线路是否有松动连接
	变压器故障	检查开关式电源电压
马达无法动作	风嘴位于锁定位置	解除风嘴锁定模式
	主控制箱故障	更换控制箱
温度显示器不稳定	热电偶故障	更换温度感应器
	热电偶连接松动	检查并固定连接
	温度控制器故障	更换主电箱中的电路板
	热电偶延长线短路	查找位置并修理
	热电偶安装位置错误	查找传感器尾端位置并修理
温度显示器一直显示周围的温度	加热器没有开启	按下 <b>加热</b> 键启动加热器
	气压太低	检查空气供应是否断开
温度不正常地起伏	发热管损坏	更换发热管
	热电偶故障	更换热电偶
	软管交缠	加热器运行时检查软管间隙或箍口
	线路电压起伏	安装电压稳压器
	空气管道有异物	移开风嘴并清除其中的异物
加热器无法加热	固态继电器（SSR）故障	更换固态继电器（SSR）
	连锁压力低	提高风嘴气压
	加热器损坏	更换发热管

## >Troubleshooting

Problem	Cause	Solution
Some parts have no power output	The power cord or plug is faulty	Check power connection
	Short circuit switch tripped	Reset the short circuit switch and check the cause
	The main power switch is not turned on	Press the power start button (start)
	Poor contact	Check all lines for loose connections
	Transformer failure	Check switch mode power supply voltage
Motor can't move	The nozzle is in the locked position	Unlock nozzle lock mode
	Main control box failure	Replace the control box
Temperature display is unstable	Thermocouple failure	Replace the temperature sensor
	Loose thermocouple connection	Check and fix the connection
	Temperature controller failure	Replace the circuit board in the main electrical box
	Short circuit of thermocouple extension wire	Find location and repair
	The thermocouple installation position is wrong	Find the end of the sensor and repair it
The temperature indicator always shows the temperature of the turnover	The heater does not turn on	Press the <b>heating</b> button to start the heater
	Air pressure is too low	Check if the air supply is disconnected
The temperature fluctuates abnormally	Damaged heating tube	Replace heating tube
	Thermocouple failure	Replace thermocouple
	Hose entanglement	Check the hose gap or hoop when the heater is
	Line voltage fluctuation	Install voltage regulator
	Foreign matter in the air duct	Remove the nozzle and remove foreign objects
The heater does not heat	Solid state relay (SSR) failure	Replace solid state relay (SSR)
	Low chain pressure	Increase the nozzle air pressure
	Damaged heater	Replace heating tube

附表 A 风嘴气流对照表      Attached Table A Comparison Table of Air Nozzle Airflow

风嘴气压（兆帕） Air nozzle pressure (MPa)	气流（升/分钟） Air flow (L/min)
0.05	35
0.06	38
0.07	40
0.08	42
0.09	45
0.10	48



附表 C 气动图解 Schedule C Pneumatic diagram

