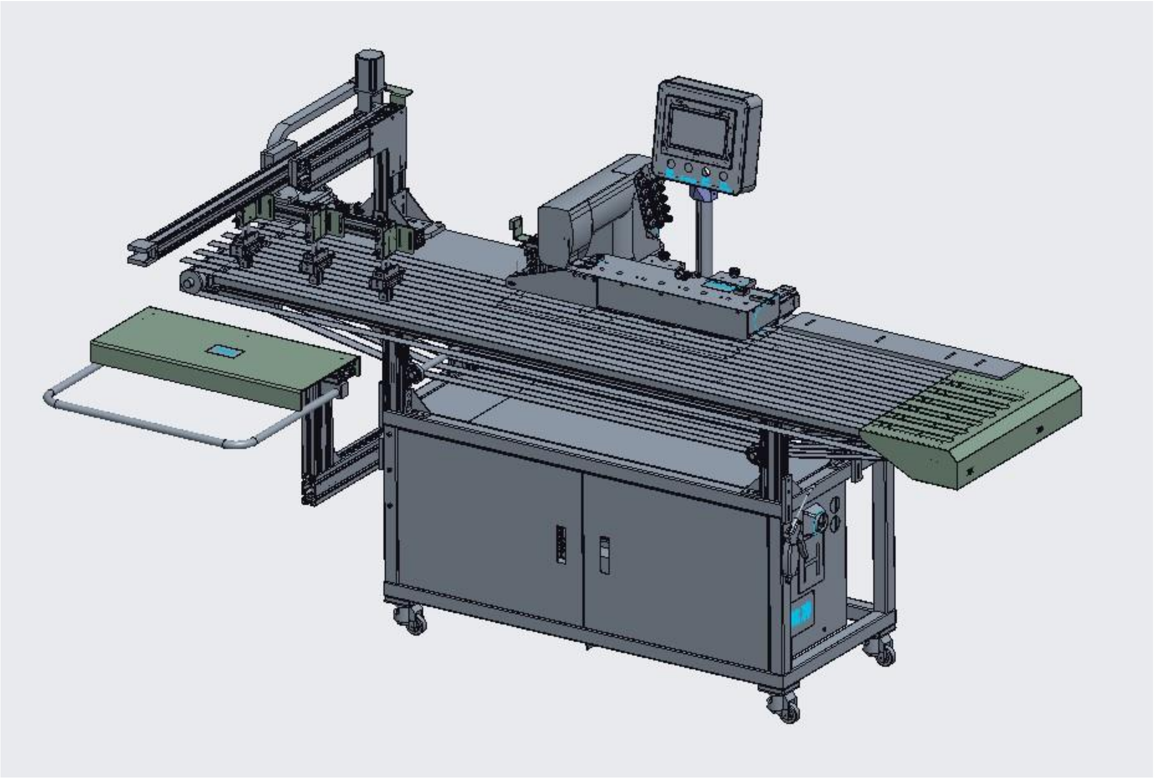
Automatic single piece bottom hemming machine instruction



注意
Caution

Preface

Follow the installation manual can help you finish the installation in a short time;
Before installation, assure the electric control box input voltage is AC220v.
Before installation， assure the machine work perfectly, trimming function stable. The thread clip as well as thread through position should be smooth.

警告
Warning

Shut down the power breaker before installation and only the technical can operate.
Please do not put the hand into the cutter protective cover when installation, adjustment, maintenance and sewing, otherwise may be dangerous.

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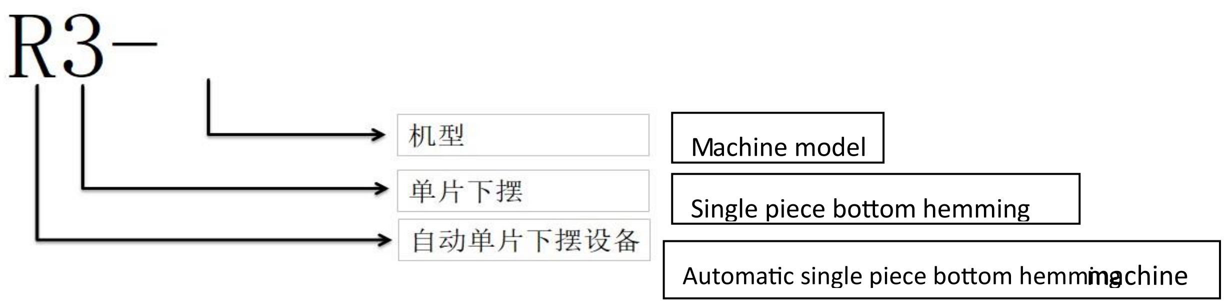
2. Major components
3. Operation interface button and meanings
4. Fault code and elimination.

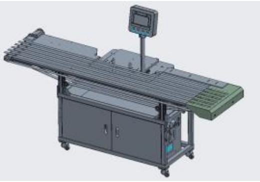
Equipment introduction

The equipment is suitable for POLO shirt single hemming (straight sleeve piece) sewing process, automatic folding, automatic sewing, automatic cutting, automatic receiving material.

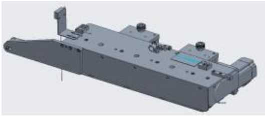
model description


R3-
机型
Machine model
单片下摆
Single piece bottom hemming
自动单片下摆设备
Automatic single piece bottom hemming machine

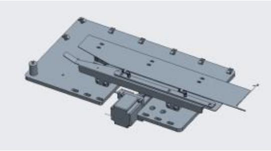
Major components



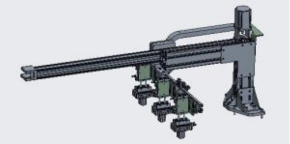
The sewing table component



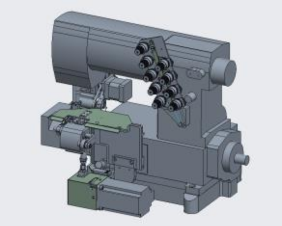
Upper belt component



Side-folding component

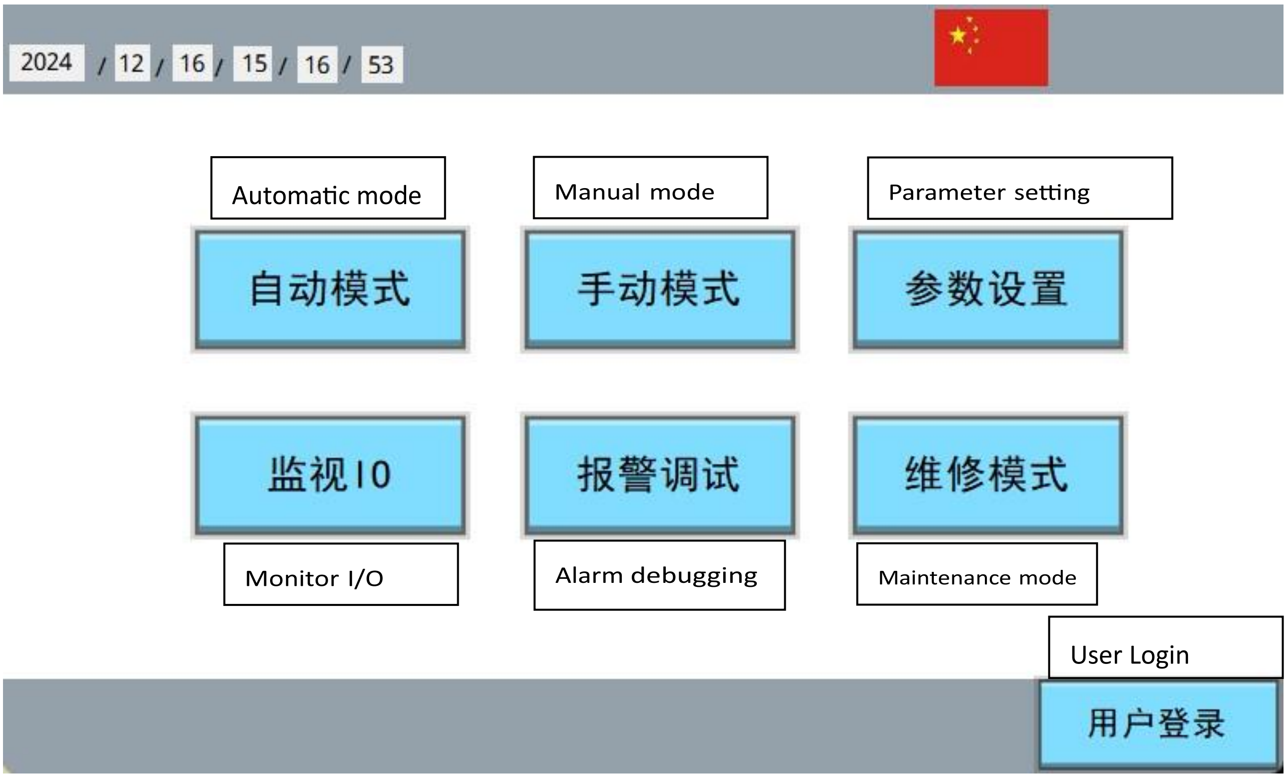


Material collection component



Machine head component

Operation interface button and meaning


2024 / 12 / 16 / 15 / 16 / 53
Automatic mode
自动模式
Manual mode
手动模式
Parameter setting
参数设置
监视IO
Monitor I/O
报警调试
Alarm debugging
维修模式
Maintenance mode
User Login
用户登录

Automatic mode: Click to enter the automatic mode interface.

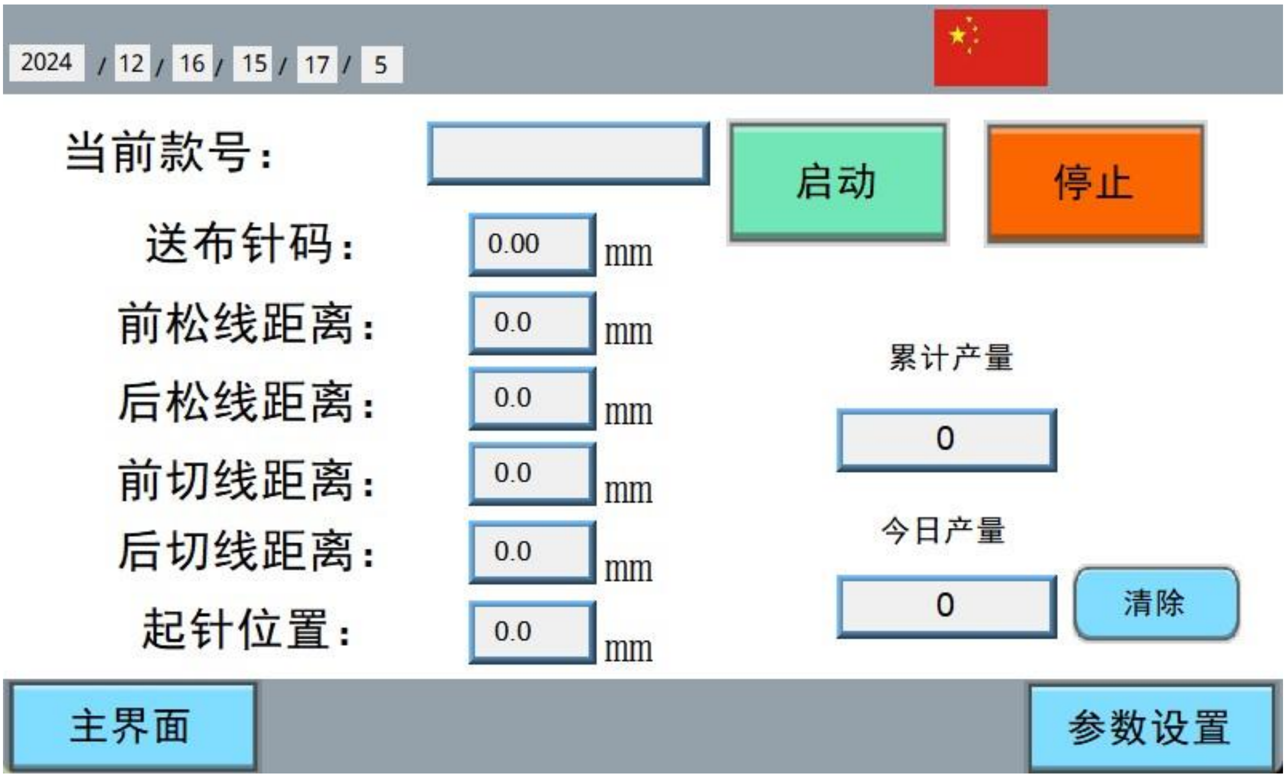
Manual mode: Click to enter the manual mode interface.

Parameter setting: Click to enter the parameter setting interface

Monitor I/O: Click to enter the I/O Input/output interface.

Alarm debugging: Click to enter the alarm debugging interface.

Maintenance mode: Click to enter the maintenance mode interface, after entering the interface will automatic lift the press foot, easy to pull out the head for maintenance.


2024 / 12 / 16 / 15 / 17 / 5
启动
停止
清除
主界面
参数设置

当前款号：

送布针码： 0.00 mm

前松线距离： 0.0 mm

后松线距离： 0.0 mm

前切线距离： 0.0 mm

后切线距离： 0.0 mm

起针位置： 0.0 mm

累计产量 0

今日产量 0

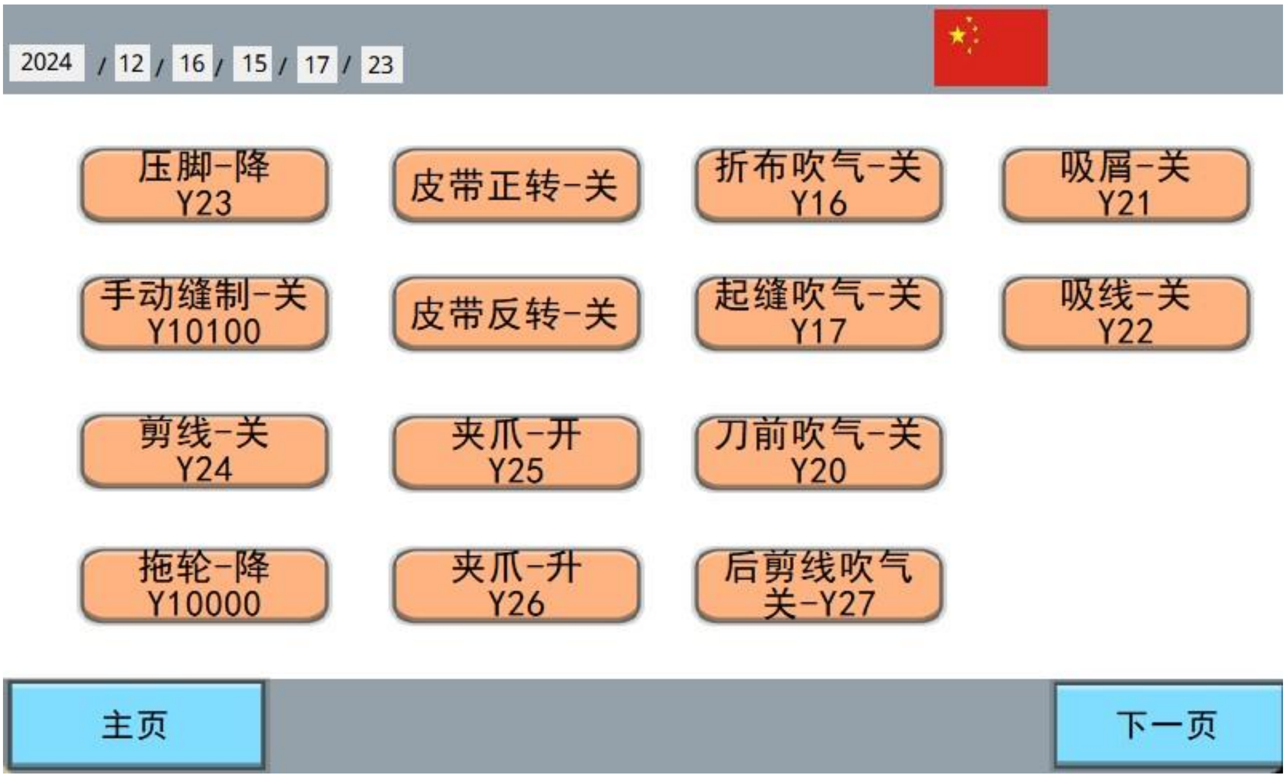
In order to avoid touching by mistake, the interface is only used for display. If you need to modify parameters, click the lower right corner to enter the parameter setting interface for modification.

Start: Click to start the device.

Stop: Click to stop the device.

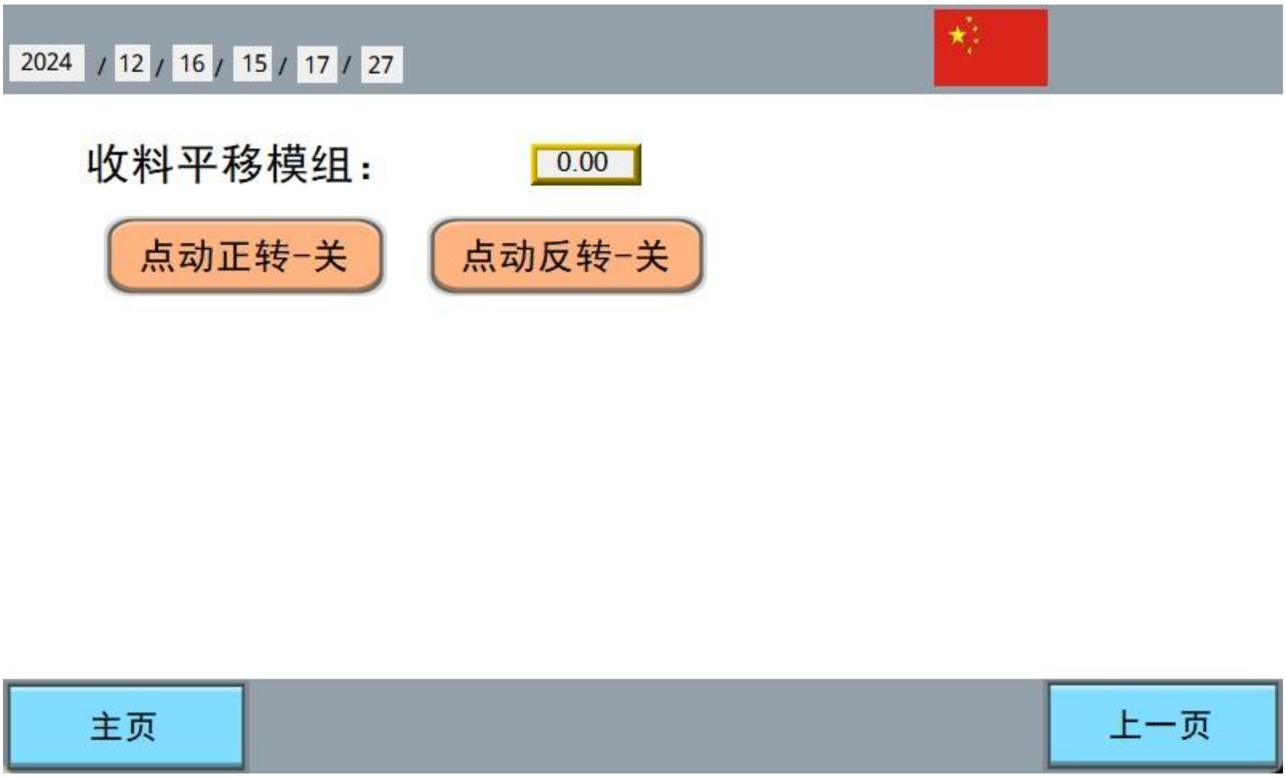
Home interface: Click to enter the home page.

Parameter setting: Click to enter the parameter setting interface. After entering the screen, you can modify related parameters.


2024 / 12 / 16 / 15 / 17 / 23
压脚-降 Y23
皮带正转-关
折布吹气-关 Y16
吸屑-关 Y21
手动缝制-关 Y10100
皮带反转-关
起缝吹气-关 Y17
吸线-关 Y22
剪线-关 Y24
夹爪-开 Y25
刀前吹气-关 Y20
拖轮-降 Y10000
夹爪-升 Y26
后剪线吹气关-Y27
主页
下一页

Press foot-drop: used to test the lift of the press foot. Click to test whether the solenoid valve and gas circuit controlling the lift foot are normal.

Belt turn forward - off: click the belt turn forward, used to test whether the motor is normal and whether the belt runs off.
Side-folding blowing - Off: Click to test whether the solenoid valve and gas circuit that control Side-folding blowing are normal, and the blowing will fold up the cloth edge.
Chip suction - Off: Click to test whether the solenoid valve and gas circuit that control chip suction are normal, and the blowing will suck away the cut cloth chips.
Manual sewing - Off: Click to control sewing machine start or stop.
Belt reverse - off: After clicking the belt reverse, used to test whether the motor is normal, or if the fabric gets stuck, reverse and remove the fabric.
Open the seam and blow - Off: Click to test whether the solenoid valve and gas circuit that control opening the seam and blowing are normal. The blowing will blow the sharp corner of the sleeve piece flat to avoid fabric wrinkles when entering the press foot.
Suction thread - Off: Click to test whether the solenoid valve and gas circuit controlling the suction thread are normal, and the blow will suck away the thread end.
Trim thread - Off: Click to test whether the solenoid valve, cylinder and gas circuit that control trimming thread are normal.
Clamping jaw - open: Click to test whether the solenoid valve, cylinder and gas circuit that control the opening and closing of the clamping jaw are normal, and the cylinder will grasp the fabric.
Blow in front of the knife - Open: click to test whether the solenoid valve and air circuit of the blow in front of the knife are normal. The blow will blow the cloth edge to the folding plate to ensure the width of the side-folding width is stable. At the same time, the bottom cloth will be blown flat to the cutting knife, and the cutting knife will cut off the excess fabric.
Clamping jaw - lift: Click to test whether the solenoid valve, cylinder and air circuit that control the lift of the clamping jaw are normal, which is used to lift and lower the clamping jaw after grasping the fabric when receiving materials.
After trimming thread blowing - off: click to test whether the solenoid valve and gas circuit controlling blowing are normal. When the fabric tail leaves the side-folding plate, the previous blowing can no longer blow to the fabric. The blowing starts and continues to blow to ensure the stability of size after side-folding.



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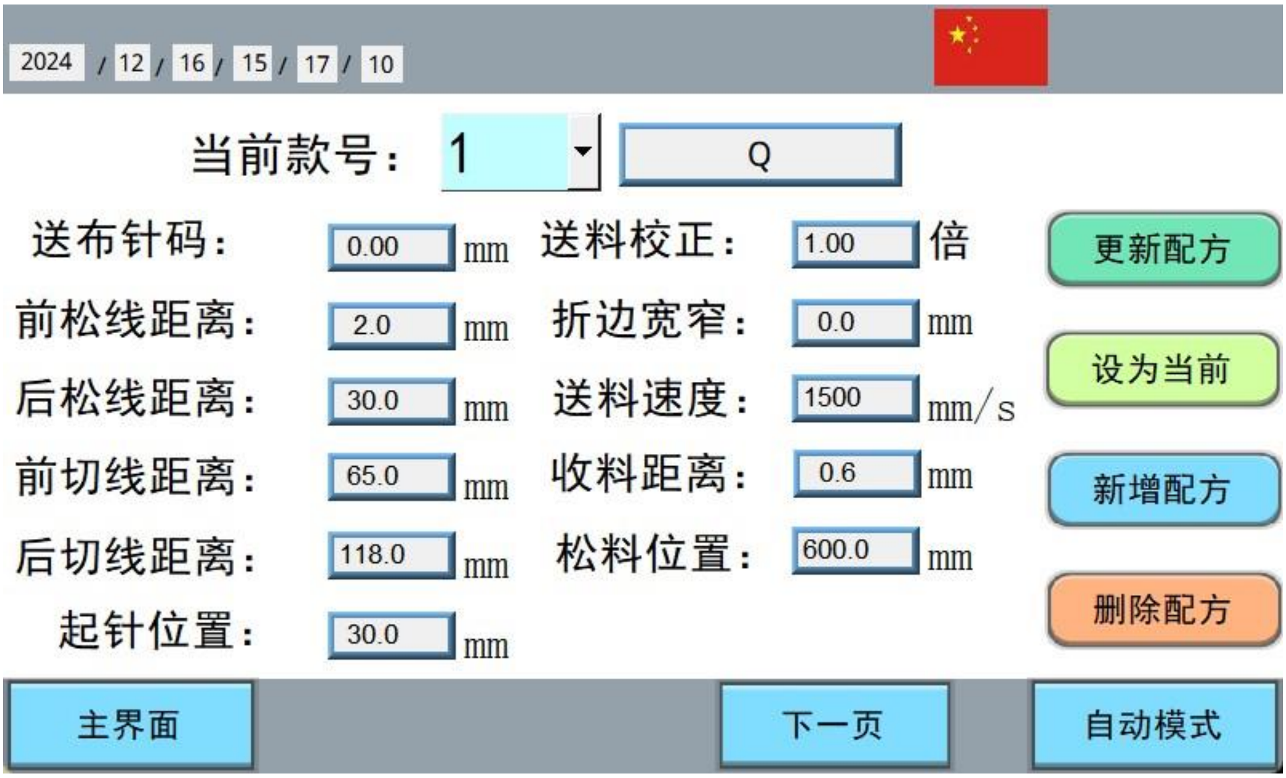
收料平移模组： 0.00

Receiving translation module: Displays the position of the module from the origin

Point forward turn - off: point forward turn of the receiving module, used to test whether the motor and the line are normal.
Point reversal - off: point reversal of the receiving module, used to test whether the motor and the line are normal.



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当前款号：1　Q

送布针码：0.00 mm
前松线距离：2.0 mm
后松线距离：30.0 mm
前切线距离：65.0 mm
后切线距离：118.0 mm
起针位置：30.0 mm

送料校正：1.00 倍
折边宽窄：0.0 mm
送料速度：1500 mm/s
收料距离：0.6 mm
松料位置：600.0 mm

Current model number: Display the model being processed, click to switch, you can set different models, save the next processing directly read the previous parameters.

Feeding fabric needle code: the speed of belt feeding fabric during sewing, this parameter should be synchronized with the sewing machine speed, if the setting is too large, the fabric will be deposited before the press foot, if the setting is too small, there will be waves behind the press foot.

Front loose thread distance: When the belt feed fabric covers the optical sensor, the fabric runs to the presser foot of the sewing machine, at this time, it is necessary to switch the empty thread to the normal thread (with fabric thread trace), click to set the front loose thread switching distance.

Back loose thread distance: When the fabric leaves the optical sensor, through the set distance, the fabric will leave the presser foot. In this case, you need to switch the normal thread (with fabric thread trace) to the empty thread to ensure that the fabric switches before leaving the presser foot. If the setting is too large, the thread will be broken.

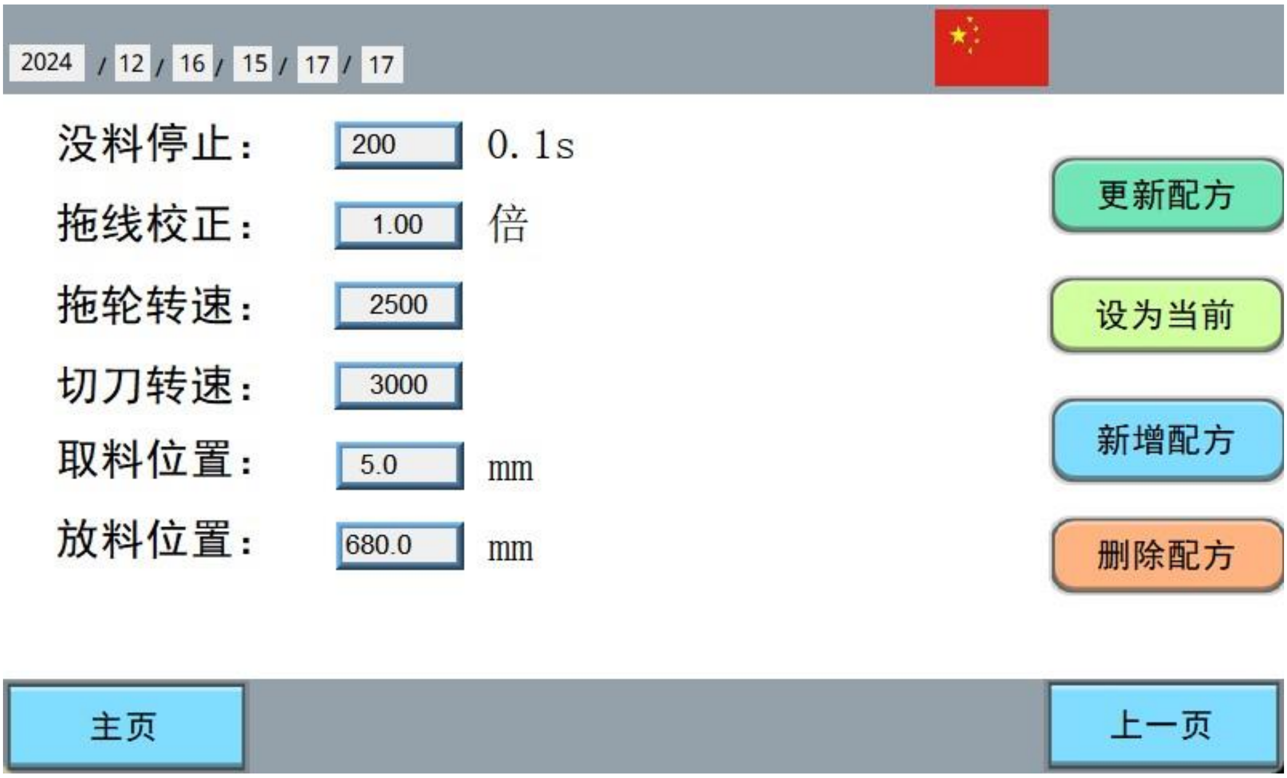
Front cut thread distance: When the belt feed fabric covers the optical sensor, through the set distance, it is necessary to cut off the thread at the front end of the fabric. If the setting is too small, the thread left on the fabric will be too long; if the setting is too large, the thread will be short. In order to avoid cutting the fabric, this parameter cannot be set too large.

Back cut thread distance: When the belt sends the fabric away from the optical sensor, through the set distance, it is necessary to cut off the thread at the back end of the fabric. If the setting is too large, the thread left on the fabric will be too long; if the setting is too small, the thread will be short. In order to avoid damaging the fabric, this parameter cannot be set too small.

Needle starting position: that is, the position of the first stitch. When the belt feed fabric covers the light sensor, the belt continues to drive the set distance of the fabric running to the presser foot. In order to avoid abnormal situations such as needle skipping and broken thread, the first stitch should be sewn on the fabric as far as possible. This parameter cannot be set too large, if the setting is too large to exceed the machine needle position, the front of fabric is easy to wrinkle and cannot be sewn.
Feed correction: Click to set the feed correction ratio, default 1.

Side-folding width: Click to set the width of the side-folding, set according to customer requirements, and then control by the motor. Note that before setting, the blowing fixed block next to the presser foot of the sewing machine should be adjusted away from the side-folding plate to avoid interference when the motor goes back to the origin.
Feed speed: Click to set the speed of the belt feeding fabric before sewing.
Receiving distance: When the fabric is sewn and left after the optical sensor, continue to run the set distance receiving cylinder begins to move down to grab the fabric.
Feeding position: After grabbing the fabric, the module motor runs to the receiving table position and begins to release the claw. Note that this parameter setting should be less than the feeding position.
Update formula: After modifying the parameters, click to update.
Set to current: After modifying the parameters each time, click to update the formula successively, set to current, that is, run according to the latest set parameters
Add formula: Click on the new formula, you can create a new style, the next sewing directly to the formula done before.
Delete formula: For models that are no longer produced, click to delete.
Home screen: Click to return to the home page.
Next: Click to go to the next page.

Automatic mode: Click to return to the automatic mode interface, after each parameter modification, click to update the formula, set it to current, and then return to the automatic mode to sew according to the set parameters.



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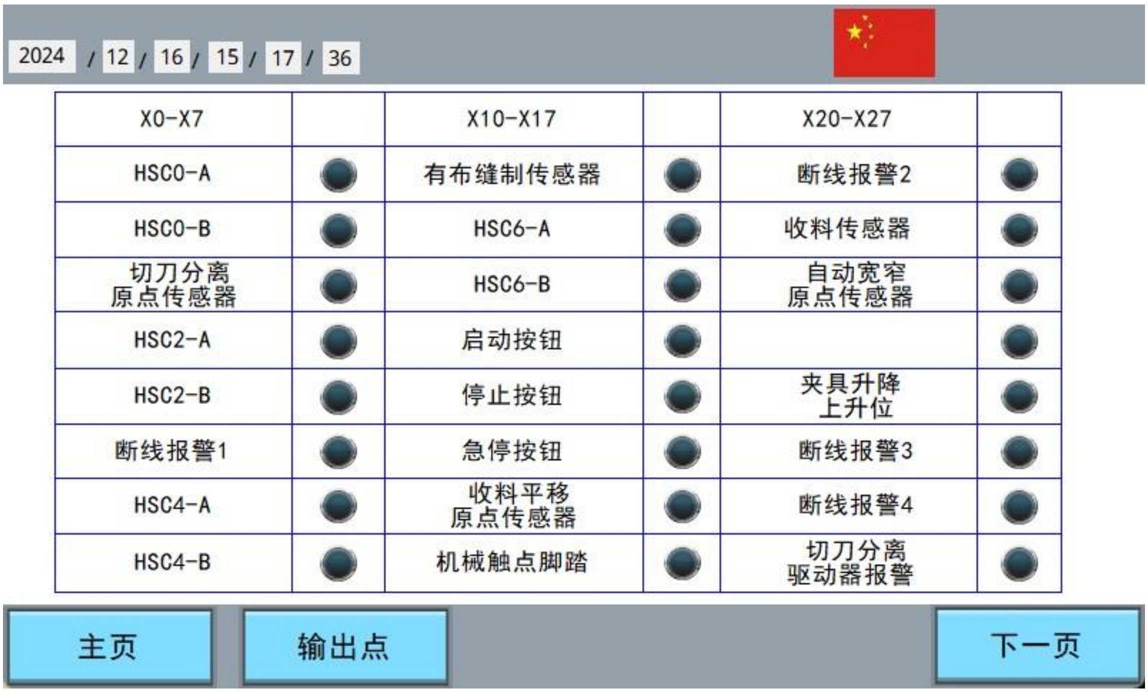
没料停止： 200 0. 1s
拖线校正： 1.00 倍
拖轮转速： 2500
切刀转速： 3000
取料位置： 5.0 mm
放料位置： 680.0 mm

No material stop: When the equipment is not operated for a long time, the equipment will stop running and enter the standby state after the set time, in order to save power.

Cutter speed: After the belt transport cloth covers the front optical sensor, the cutter will start in advance for pre-cutting. Click to set the cutter pre-cutting speed. When the sewing machine starts, the system will automatically read the sewing machine speed, and the cutter speed will be synchronized with the sewing machine speed.

Taking position: Click to set the position where the claw goes down to grab the fabric. If the setting is too large, the claw will easily catch the belt when it falls. In order to ensure the stability of the grab and the service life of the belt, the parameter cannot be set too large.

Placing position: After gripping the fabric, run to the receiving table. First loosen the gripping claw and then put the sewn fabric down on the receiving table. Click to set the position of placing the cloth.



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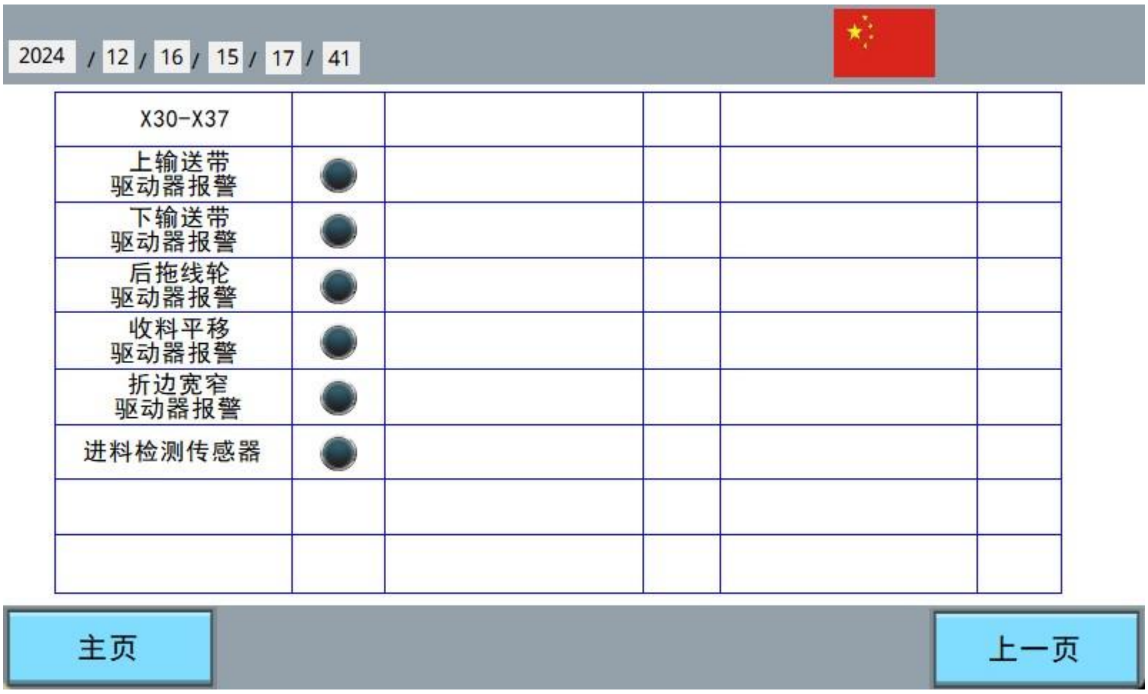
X0-X7		X10-X17		X20-X27	
HSC0-A	●	有布缝制传感器	●	断线报警2	●
HSC0-B	●	HSC6-A	●	收料传感器	●
切刀分离原点传感器	●	HSC6-B	●	自动宽窄原点传感器	●
HSC2-A	●	启动按钮	●		●
HSC2-B	●	停止按钮	●	夹具升降上升位	●
断线报警1	●	急停按钮	●	断线报警3	●
HSC4-A	●	收料平移原点传感器	●	断线报警4	●
HSC4-B	●	机械触点脚踏	●	切刀分离驱动器报警	●



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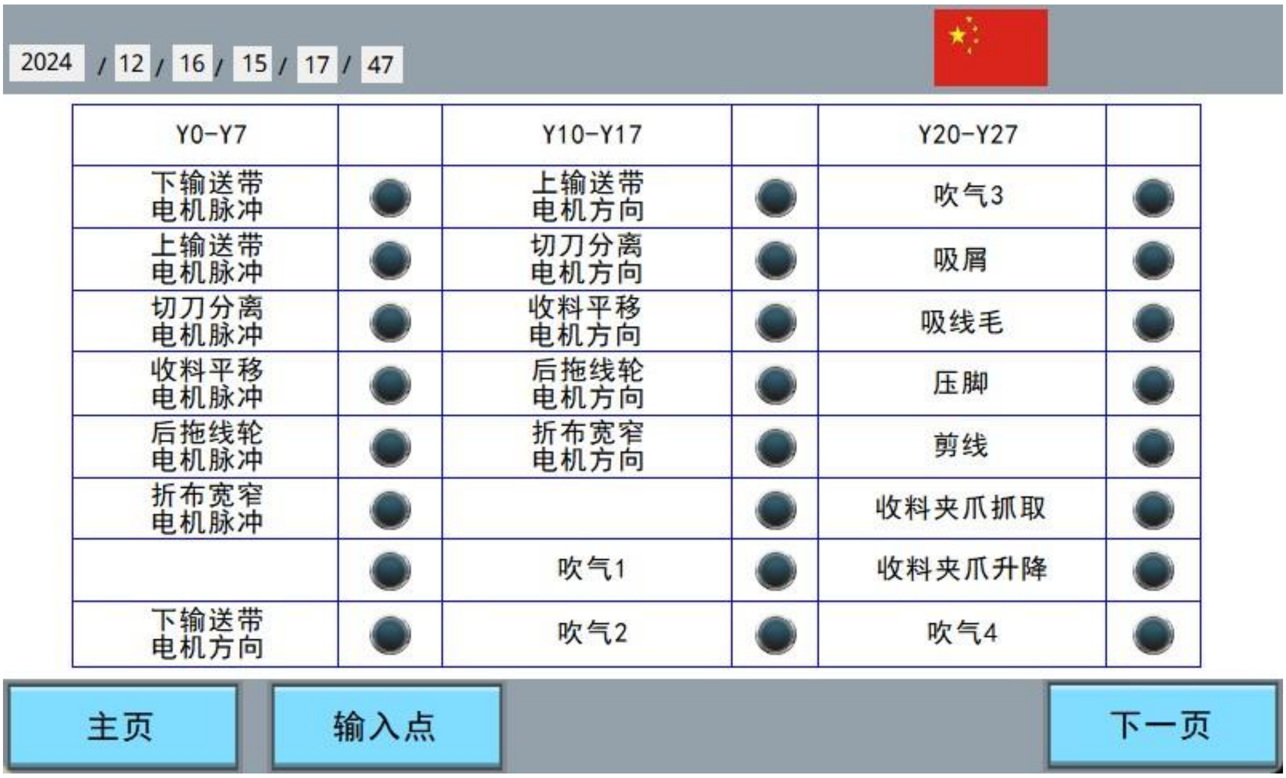
X30-X37					
上输送带驱动器报警	●				
下输送带驱动器报警	●				
后拖线轮驱动器报警	●				
收料平移驱动器报警	●				
折边宽窄驱动器报警	●				
进料检测传感器	●				

This interface is for all input ports of the device, used to check whether related electrical components and lines are normal.



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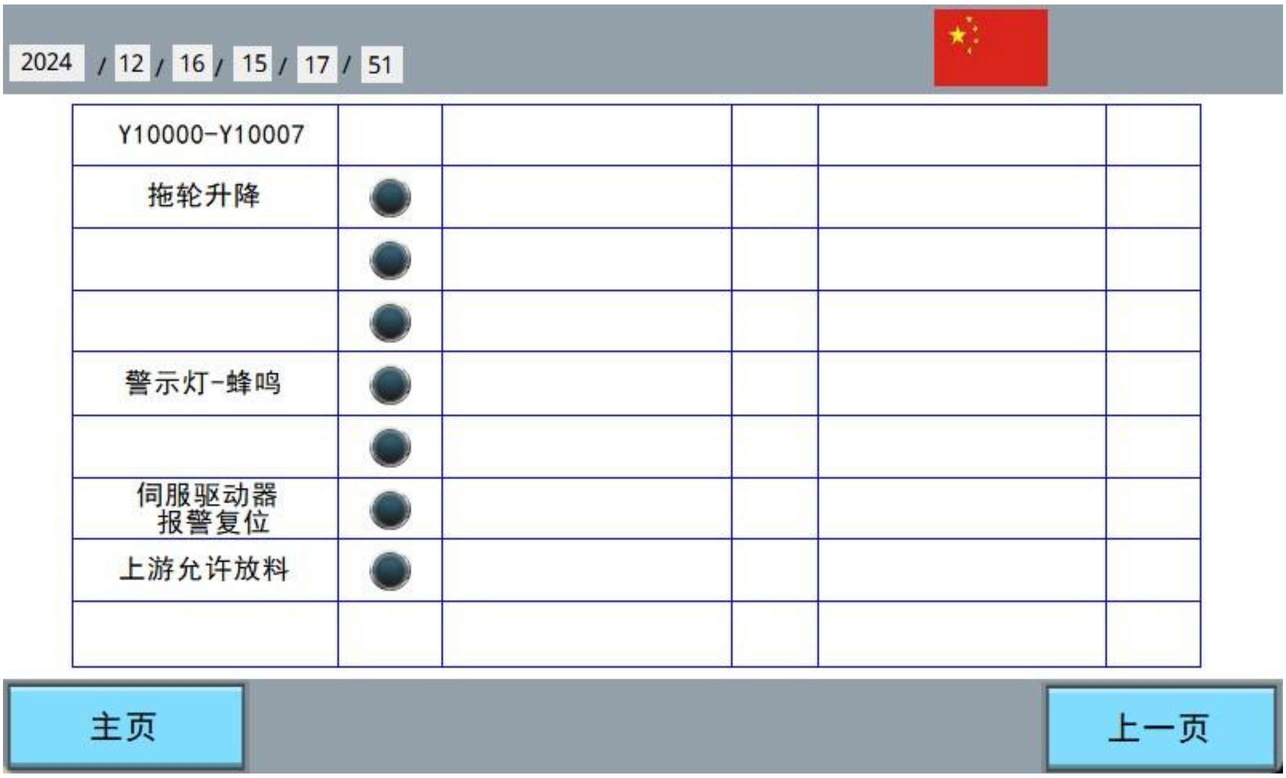
Y0-Y7		Y10-Y17		Y20-Y27	
下输送带电机脉冲	●	上输送带电机方向	●	吹气3	●
上输送带电机脉冲	●	切刀分离电机方向	●	吸屑	●
切刀分离电机脉冲	●	收料平移电机方向	●	吸线毛	●
收料平移电机脉冲	●	后拖线轮电机方向	●	压脚	●
后拖线轮电机脉冲	●	折布宽窄电机方向	●	剪线	●
折布宽窄电机脉冲	●		●	收料夹爪抓取	●
	●	吹气1	●	收料夹爪升降	●
下输送带电机方向	●	吹气2	●	吹气4	●



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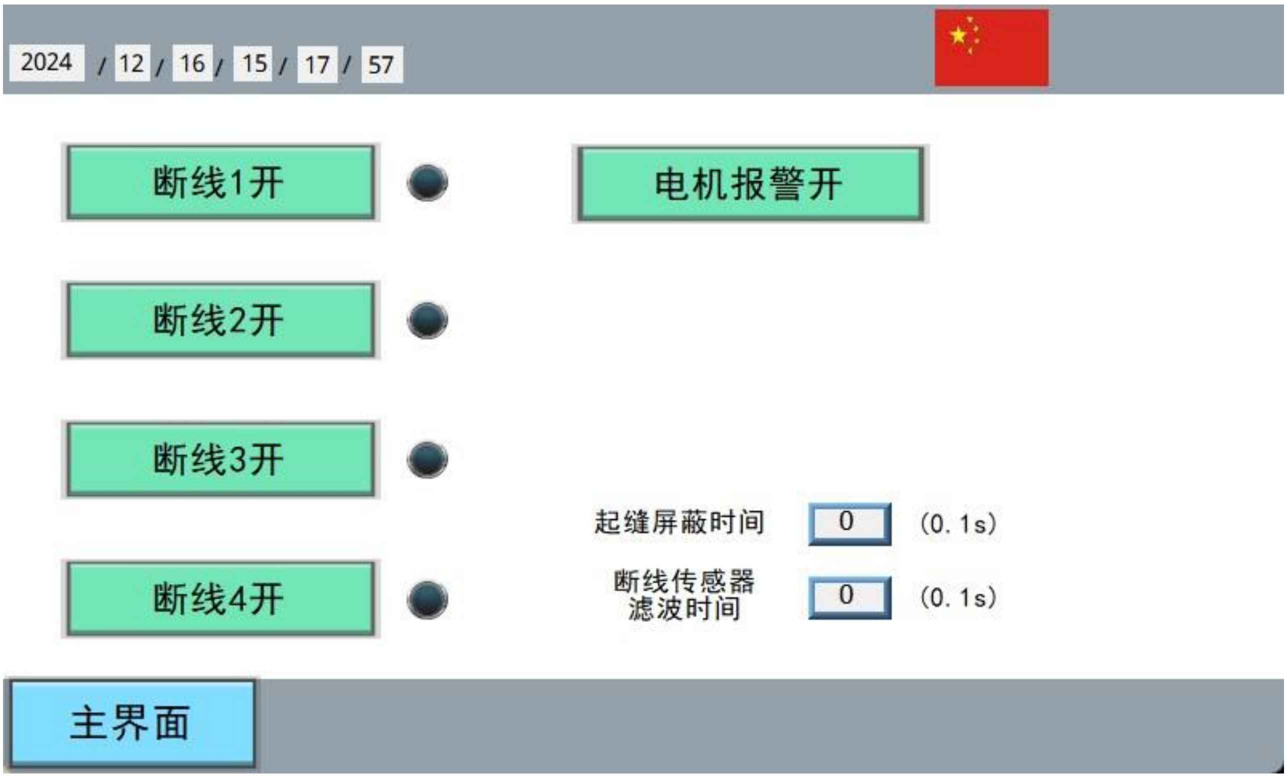
Y10000-Y10007					
拖轮升降	●				
	●				
	●				
警示灯-蜂鸣	●				
	●				
伺服驱动器报警复位	●				
上游允许放料	●				

This interface is for all output ports of the device, used to check whether related electrical components and lines are normal.



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起缝屏蔽时间 0 (0. 1s)

断线传感器滤波时间 0 (0. 1s)

Broken thread 1 on: When the broken thread alarm is on, if a broken line occurs, after the set broken thread sensor filtering time, the device will automatically stop, alarm, to avoid damage to the fabric.

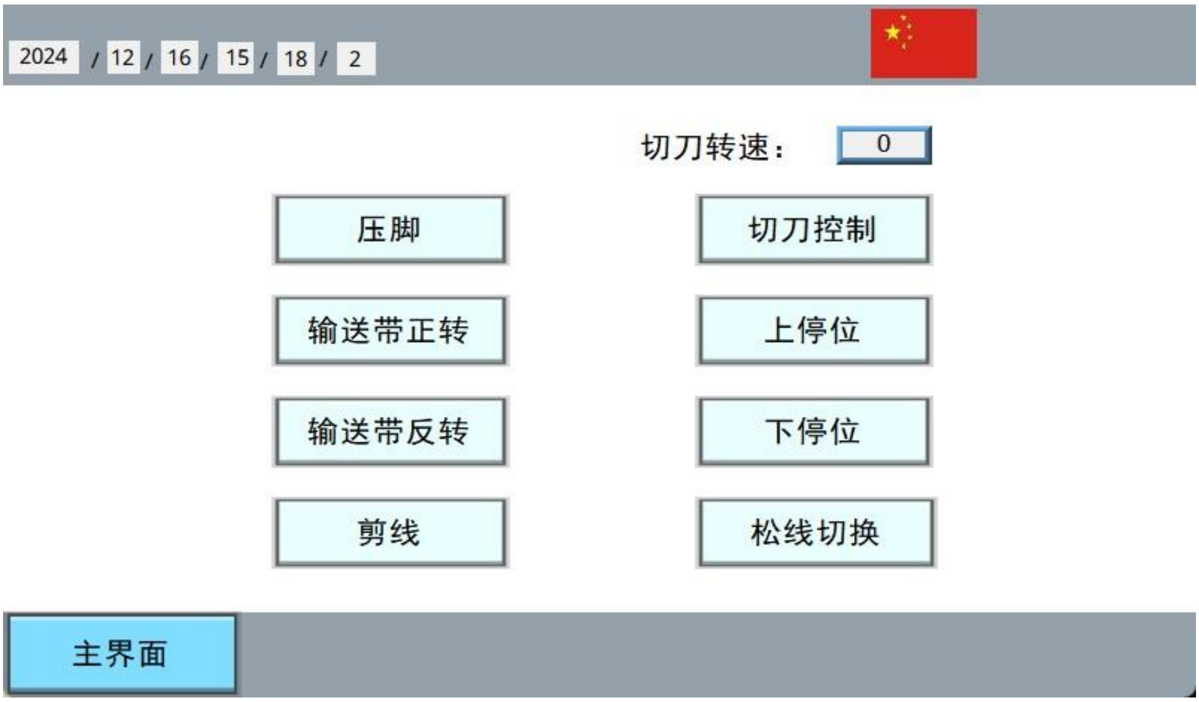
Broken thread 2 on: When the broken thread alarm is on, if a broken line occurs, after the set broken thread sensor filtering time, the device will automatically stop, alarm, to avoid damage to the fabric.

Broken thread 3 on: When the broken thread alarm is on, if a broken line occurs, after the set broken thread sensor filtering time, the device will automatically stop, alarm, to avoid damage to the fabric.

Motor alarm on: When the motor alarm is on, if the motor drive alarm occurs, it will prompt an alarm check to avoid damage to the motor.

Start seaming shielding time: Click set seam shielding time to avoid error detection. If the parameter is set too small, it is easy to error detection, that is, the system prompts that the thread is broken but the actual thread is not broken.

Broken thread sensor filtering time: When the thread is broken, after the set delay, the system will prompt broken thread.



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切刀转速： 0

Presser foot: After entering this interface, the presser foot will automatically lift. At this time, it is necessary to ensure that the presser foot is lifted and the cutter is at a low position before pulling the switch of the maintenance equipment. Otherwise, the side-folding width limit plate will be damaged when pulling.

Belt turn-off: click the belt turn forward, used to test whether the motor is normal and whether the belt runs off.

Belt reverse-off: Click the belt reverse, used to test whether the motor is normal, or reverse the cloth after the cloth is stuck.

Cut thread-off: After the broken thread is re-threaded, the sewing thread is adjusted normally. Click on the cut thread to cut off the excess thread.

Cutting tool control: The cutting tool will move up and down after clicking, which is used to check whether the cutting knife is sharp and whether the high and low settings of the cutting knife are correct.

Upper stop position: After clicking, the cutter will stop at a high position, which is used to check the size of the cutter opening and whether it is sharp.

Lower stop position: After clicking, the cutter will stop at the low position, which is used to check the opening size of the cutter. At the low position, the front end opening of the fixed knife and the active knife is 0-0.5mm.

Loose wire switch: used to debug thread trace, click to switch between normal thread trace (with fabric thread trace) and empty thread trace.

Home screen: Click to return to the home page.

4. Fault code and elimination

Emergency stop: When the equipment sewing abnormal, press the emergency stop button, the equipment will stop running, after eliminating the abnormal, rotate the emergency stop button to reset.