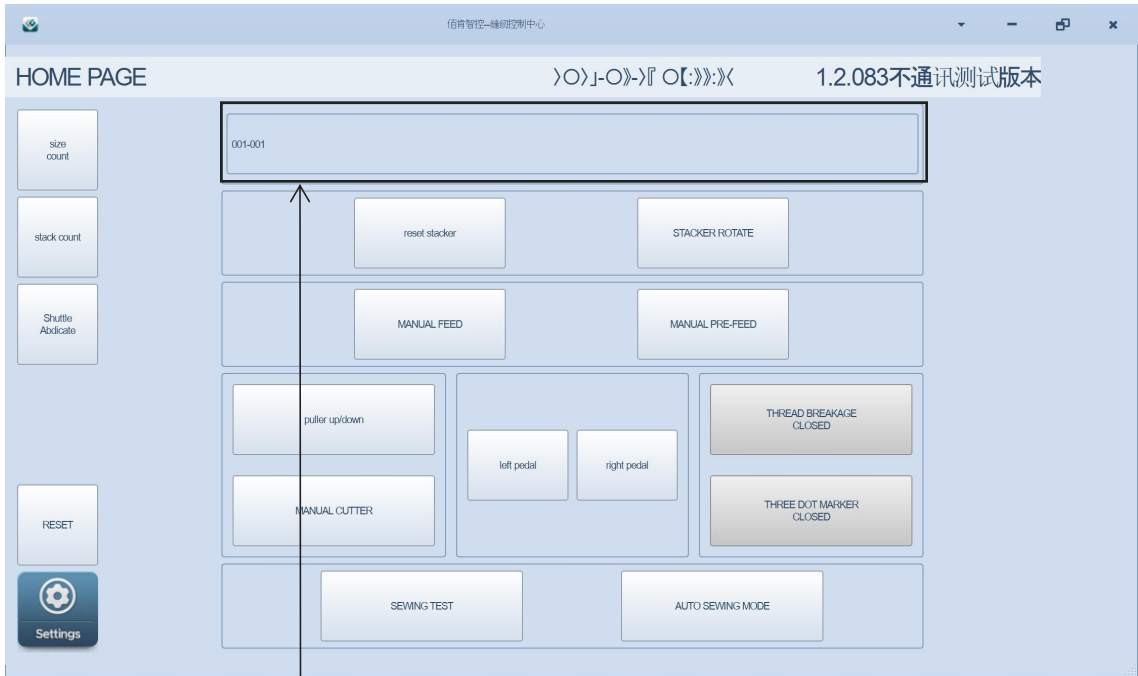


# MB1008B elastic jointer panel manuals



To reset output count

**Way to make new program for normal non-logo elastic**

Step 1: Enter this to select new program name number and rename from under option 'BASE' .

pls note this **Logo配置** 001-不配置 is for logo option setting only . Invalid for normal non-logo elastic.

Step 2: set elastic sewing length from option **Size** . Maximum can set 5 different sewing length and set each length sewing quantity separately .

Note: if run machine with logo device, pls switch on CCD option under **使用CCD** .

Step 3: Press **Reclaimer** to switch on/off stacker.

计划编号: 001  
计划名称: 001



To reset stacker count

<p>To reset stacker to stay in home position clockwise direction</p>		<p>To turn stacker for running one cycle counter-clockwise direction</p>	
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To make elastic folding a.s.m make to left side, for service / bobbin thread change purpose.

<p>To make elastic creaser feed more elastic only</p>		<p>To make feed motor feed more elastic at cutter entrance.</p>	
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<p>same result as press left pedal to make big press clamp down/up</p>	<p>after press left pedal, then press right pedal to make manual sewing test.</p>
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Reset machine. pls must always reset machine after any operation did in machine.

<p>To lift up presser bar for elastic position adjustment.</p>	<p>Thread break sensor switch</p>
<p>To make cutter run one time only</p>	<p>switch of this device</p>

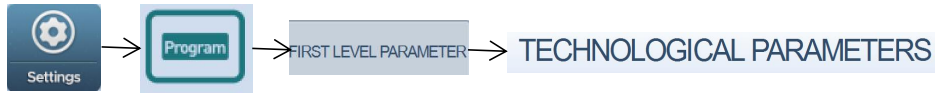


Entrance to access all settings

<p>To make one pcs elastic sewing testc</p>	<p>To make machine in continuous sewing output mode</p>
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## Way to parameter

### Way to level 1 parameter



#### FRONT/BACK MOTOR FEEDING LENGTH

No.1 To set where front/rear feeding motor stays at sewing head side when it's moving to sewing head to delivery elastic.

Note: to set front/rear motor at head stop position, pls set from below route which is visible than changing from this parameter directly.



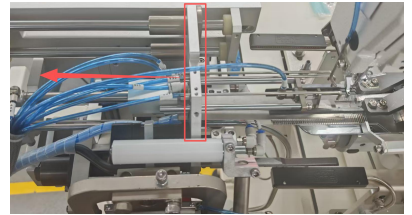
Settings->factory mode->single step check->Front and rear feeding-> --/++-> set sewing position.



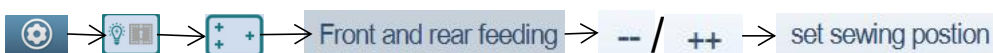
#### Return distance after feeding of front and rear feeding motor

No.2 To set where front/rear feeding motor stays at home origin when it returns back from sewing head to home origin after finishing delivering elastic.

Note: to set front/rear motor at home origin position, pls set from below route which is visible than changing from this parameter directly.



Settings->factory mode->single step check->Front and rear feeding-> --/++-> setting the stop position.



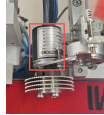
#### shuttle oil frequency

No.3 To set shuttle cooler work frequency, how many pcs finished then shuttle cooler will run one time.

#### elastic jointer handle mode

No.4 To set how to do next step once elastic joint is detected by encode.

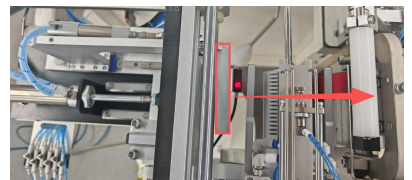
Option 1: To show error in panel & sewing stop  
Option 2: To automatical cut & continue sewing.



#### elastic clamp move out distance

No.5 To set where left side clamp motor stays at receiving position when it moves to right side to receive elastic.

Note: to set left side clamp motor stays at receiving position, pls set from below route which is visible than changing from this parameter directly.



Settings->factory mode->single step check->Front and rear feeding-> --/++-> setting the stop position.

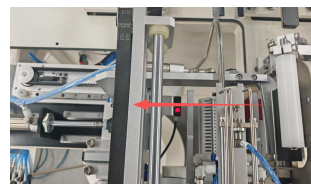


Note: No.5 parameter can make left clamp to catch more elastic at left side to achieve overlap with more elastic at left side.

#### elastic clamp return back distance

No.6 To set where left side clamp motor stays at home origin when it returns back to left side from right side.

Note: to set left side clamp motor stays at home origin position, pls set from below route which is visible than changing from this parameter directly.



Settings->factory mode->single step check->Front and rear feeding-> --/++-> setting the stop position.



### elastic length after clamp back to desired position

No.7 To tell machine control box the distance between cutter and left side clamp motor .

This parameter function as below:

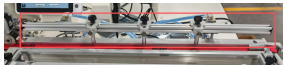
Support this parameter value set 140, and elastic setting length 500mm in panel.

Generally control box will detect feeding length  $500-140=360$ mm only to ensure final output sewn elastic length 500mm, but sometimes ,output sewn elastic length is not strictly 500mm as per setting in panel, then can adjust this parameter value to get exact output sewn elastic length with 500mm.

This value not avised to adjust frequently .

### 3 dot mark device working mode

No.8 Switch of this device.



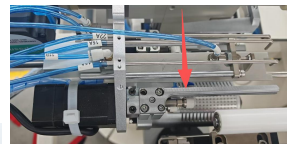
### Rotating clamping motor feeding position

No.9 To set where turning motor stays at turning position

Note: to set turning position,

pls set from below route which is visible than changing from this parameter directly .

Settings->factory mode->single step check->Front and rear feeding-> --/++-> setting the stop position.



Note: No.9 parameter can make turning clamp to catch more elastic at right side to achieve overlap with more elastic at right side .

### Offset distance from cutter to drum position sensor

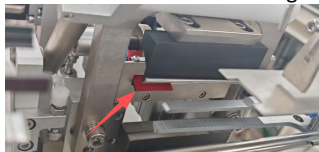
No.10 To set the compensation distance between cutter and elastic joint detect sensor.

Note: this parameter main function is to control cutting position at elastic joint point .

sometimes ,cutter doesn't cut elastic joint completely , this parameter can make more/less feeding of elastic joint to make it get cut completely .

### Prefeed width

No.11 To make elastic feeding more/less at sewing beginning to let left side clamp motor to catch it properly .



### 叠缝长度

No.12 To set elastic **overlap** length .

### Sequence of left and right rotation gripper actions

No.13 To adjust staying sequence of elastic's left side **overlap** or right side overlap by changing blowing sequence.

Option A: flat kiss.

Option B: left above right.

Option C: right above left

### Way to level 2 parameter (code: 080808/ bestctrl109)

Change under manufacturer instruction only.



### Way to level 3 parameter (code: 888888/ bestctrl109)

Change under manufacturer instruction only.



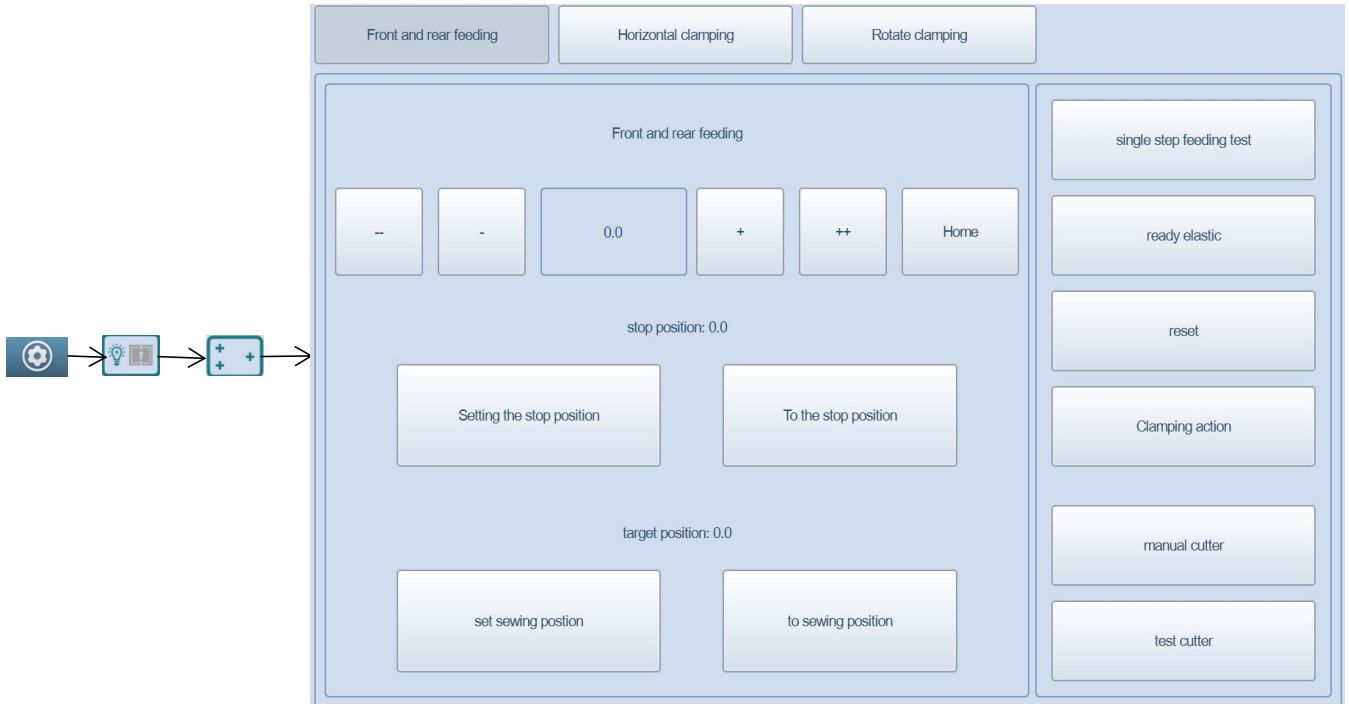


CCD Setting

## For Camera setting only . Invalid for normal non-elastic .

### Way to step check mode.

Settings->factory mode->single step check



#### Front and rear feeding

To set front/rear feeding motor stop at sewing head position, stay at home origin position

#### Horizontal clamping

To set left side clamp motor stop at cutter side receive position, stay at home origin position

#### Rotate clamping

To set turning clamp motor stop at ready to move to sewing head position, stay at home origin position

**single step feeding test** step check option, to check feeding test step by step. if one of step shows mechanical setting problem, can make correction at this option directly .

**ready elastic** To make one piece folded elastic ring test only .

**reset** To make machine all hardwares stay at home origin for ready status.

**Clamping action** To make left side clamp moves to right side to check if elastic clamping position OK. if clamping position not OK, can adjust from option **Horizontal clamping** directly to make clamping position stays at correct point.

**manual cutter** To make machine do one time cutting only.

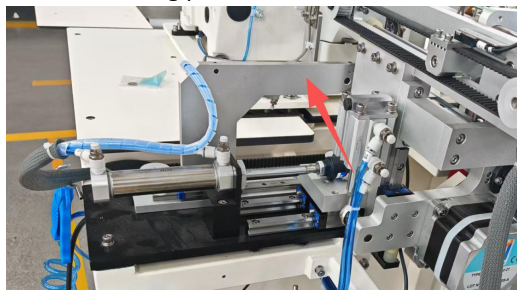
**test cutter** No use.

## Solutions if elastic kiss edge not in alignment.

Problem detail: Kiss edge(pic-1)) not in alignment.

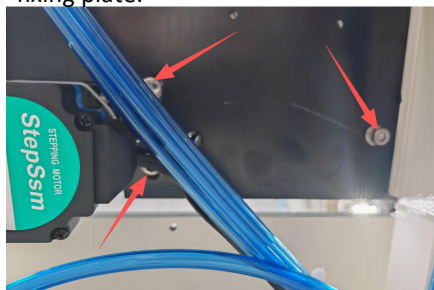


Solution: Adjust below left clamp position(pic-2) by releasing 3 fixing screws(pic-3) located under the fixing plate.



pic-2

3 fixing screws located under left clamp fixing plate.



pic-3