369B Automatic Collar- Attaching Machine Operation Manual



Directory

1. Performance Advantages & Equipment Benefits
2. Equipment Specifications
3. System Operation and Function Introduction

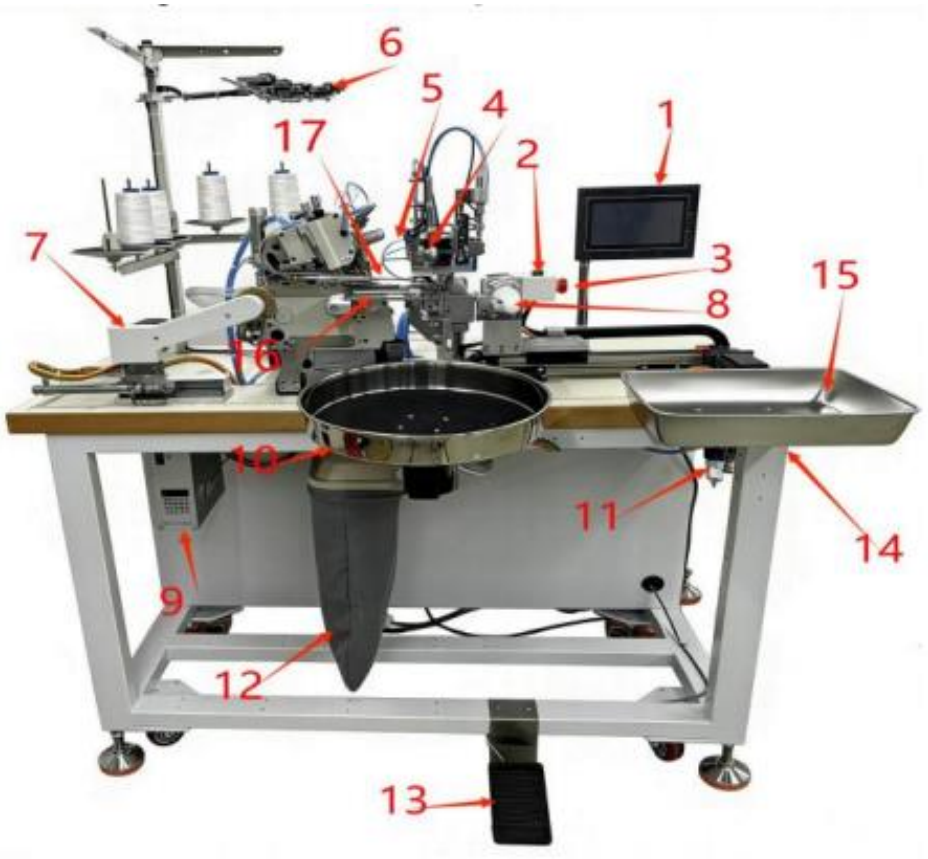
1. Performance Advantages & Equipment Benefits

1. Human- friendly user interface for efficient sewing- cycle setup
2. One- click size switching
3. Fully- automatic differential- speed segmented easing device
4. Fully- automatic collar- seam positioning device
5. Lower operator skill requirements; improved quality and productivity

2. Equipment Specifications

1） Machine Model	ML3 6 9 B	Head Brand	PEGASUS
2） Machine Dimension	L120 *W 85 * H153CM	Head Model	EXT5 1 1 4 - 0 3
3） Packing Dimension	L135 *W 95 * 155CM	Head Speed	MA7000R/ Mir
4） Rated Voltage	AC2 2 0 V	Sewing Fabric	Knitted Fabrics
5） Rated Power	2 . 2KW	Gross Weight	2 3 0 KG
6） Air Pressure	0.6 MPa	Net Weight	1 6 5 KG
7） Operation Interface	Touch Screen		

3. System Operation and Function Introduction



1. Display Screen
2. Start Button
3. Emergency Stop
4. Deviation Correction
5. Deviation Correction Sensor
6. Thread Breakage Sensor
7. Left Wheel
8. Right Wheel
9. Main- shaft Electric Control Box
10. Rotary Disk
11. Air Pressure Gauge
12. Dust Collection Bag
13. Foot Pedal
14. Power Switch
15. Collar Strip Placement Tray
16. Collar Positioning Jig
17. Edge- trimming Positioning Jig

Main Interface



1. Sewing Speed
2. Custom Style Name
3. Style Name Selection
4. Setting for Distance fromCollar Joint to Needle
5. Back- stitch Length Setting
6. Stitch Pitch
7. Size Code Selection
8. Processing Time
9. Production Counter
10. Clear Production Count / Reset Countertop Zero
11. Production Count Increase / Decrease
12. Reset
13. Threading
14. Parameter Setting
15. Manual Debugging
16. Machine Running Status Bar
17. Presser Foot Lifting

Manual Motor Test



Manual Cylinder Debugging



Input Signal Detection



Output Signal Detection



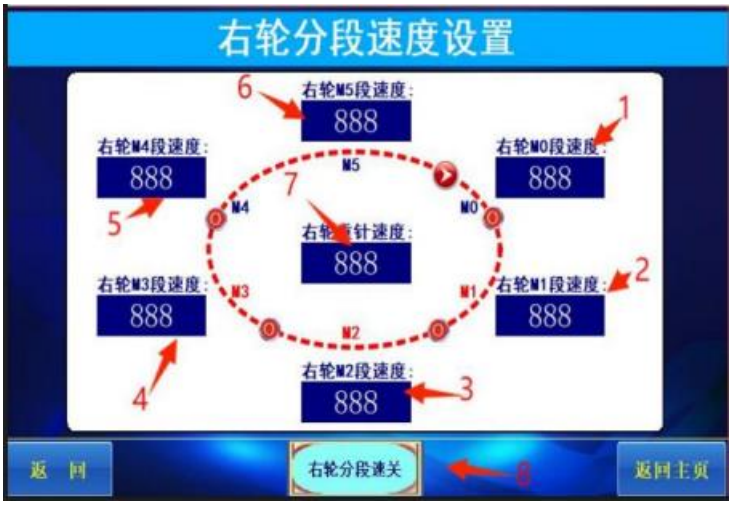
Common Parameters



1. Actual stitch distance of machine head
2. Delay suction- air thread- cutting time
3. Stitch count for end- of- seam suction- air thread cutting
4. Forward rotation speed setting for deviation correction
5. Stitch- distance setting for left- right wheels
6. Turntable speed setting
7. Reverse rotation speed setting for deviation correction
8. Rotation- distance setting for left wheel during thread cutting
9. Rotation- speed setting for left wheel during thread cutting
10. Right- wheel segmentation, click to enter right- wheel segmentation interface
11. Proportion diagram, click to enter proportion- diagram interface
12. Parameter code import, click to enter parameter- code import interface
13. Sewing- count table, click to enter sewing- count table interface
14. Differential import, click to enter differential import interface
15. Heavy- thread presser- foot lift OFF, click to turn green for Heavy- thread presser- foot lift ON

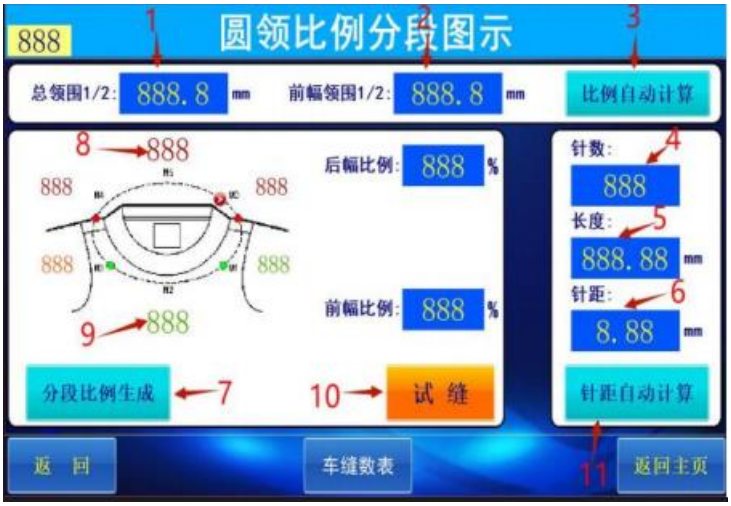
16. Thread- break switch No.1, click to turn orange- red for ON
17. Thread- break switch No.2, click to turn orange- red for ON
18. Thread- break switch No.3, click to turn orange- red for ON
19. Thread- break switch No.4, click to turn orange- red for ON

Right- Wheel Segmented Speed Setting



1. Speed setting for right- wheel segmentM0
2. Speed setting for right- wheel segmentM1
3. Speed setting for right- wheel segmentM2
4. Speed setting for right- wheel segmentM3
5. Speed setting for right- wheel segmentM4
6. Speed setting for right- wheel segmentM5
7. Speed setting for right- wheel heavy stitch
8. Enable / Disable right- wheel segmented- speed function

Schematic Diagram of Crew- Neck Proportion Segmentation



1. Length setting for 1/2 of total neck circumference
2. Length setting for 1/2 of front neck circumference
3. Auto- calculate proportion, long- press required b
4. Example: 12 stitches for 20 mm, input 12intostitch- count field
5. Example: 12 stitches for 20 mm, input 20intolengthfield
6. Stitch distance calculated automatically by system
7. Generate segmented proportion, long- press required
8. Back- panel proportion display
9. Front- panel proportion display
10. Enable / Disable test- seam function
11. Auto- generate stitch distance, long- press required

Size- grading Right- Offset Position Import



1. Garment- body size adjustment for sizeXS
2. Garment- body size adjustment for sizeS
3. Garment- body size adjustment for sizeM
4. Garment- body size adjustment for sizeL
5. Garment- body size adjustment for sizeXL
6. Garment- body size adjustment for size2XXL
7. Garment- body size adjustment for size3XL
8. Garment- body size adjustment for size4XL
9. Garment- body size adjustment for size5XL
10. Garment- body size adjustment for size6XL
11. Right- offset forward rotation
12. Right- offset reverse rotation
13. Right- offset reset to zero
14. Sizing stretch value

Segment- Stitch- Count Diagramfor EachSize



1. Generate segmented stitch count, long- press required
2. Set stitch count: configure M0- segment stitches, back- stitch count and collar- bone position
3. M0- segment setting button: one- key setup forall sizes
4. Back- stitch setting button: one- key setup forall sizes
5. Collar- bone setting button: one- key setup forall sizes M0. M0- segment stitch count M1. M1- segment stitch count M2. M2- segment stitch count M3. M3- segment stitch count M4. M4- segment stitch count M5. M5- segment stitch count

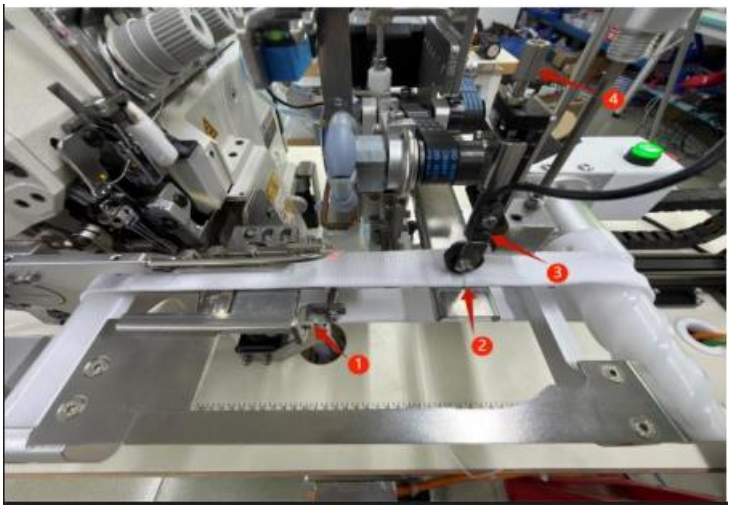
Differential Segment- Position Import



1. Adjustment of differential ratio for M0 sewing- zone position
2. Adjustment of differential ratio for M1 sewing- zone position
3. Adjustment of differential ratio for M2 sewing- zone position
4. Adjustment of differential ratio for M3 sewing- zone position

5. Adjustment of differential ratio for M4 sewing- zone position
6. Adjustment of differential ratio for M5 sewing- zone position
7. Adjustment of differential ratio for M6 sewing- zone position
8. Speed adjustment for differential low- speed mode
9. Speed adjustment for differential high- speedmode

4. Debug Page



1） Setting of collar width and notch

1. As shown in the figure, fit the collar strip under the presser foot.
2. Adjust ① front- collar side position.
3. Rotate ② collar notch directly below ③ sensor to light up sensor No.③.
4. If No.③ sensor is not lit, adjust ④until its light sup.

2） Setting of body neck circumference

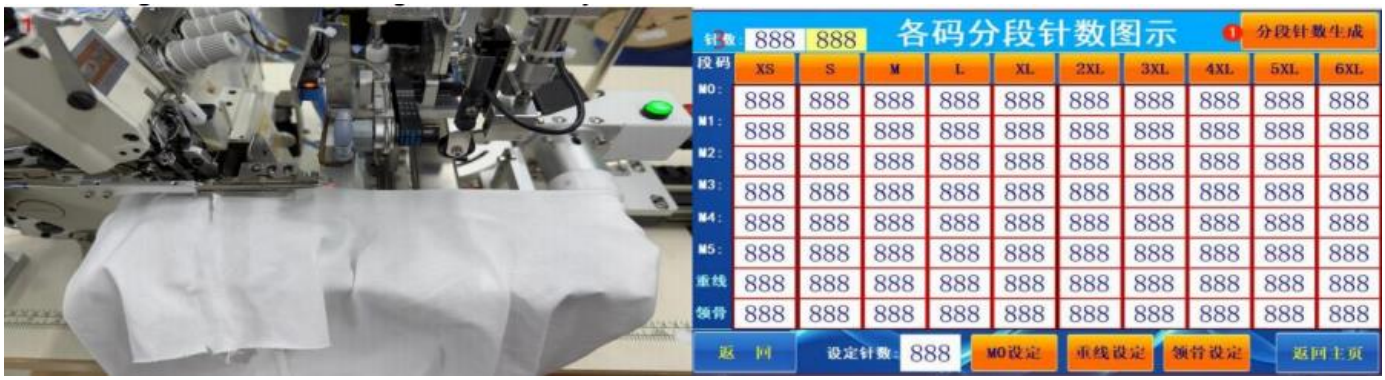






1. Input 260 mm (1/2 of total neck circumference measured in Figure 1) into ①.
2. Input 150 mm (1/2 of front- panel neck circumference measured in Figure 2) into ②.
3. Long- press ③; the system automatically calculates the ratio of front and rear panels.
4. Press ④; the system automatically calculates the segmented ratio for front and rear panels.
5. Input 30 mm into ⑤. Then count how many stitches are contained within the 30- mm length. Enter the actual counted stitch number into ⑥, and press ⑦. The system will automatically calculate the stitch pitch.

3） Setting of fabric- stretching width for body neck circumference





1. Press ① in Figure 2 to reset expansion to zero.
2. Fit the body neck- circumference onto the machine as shown in Figure 1.
3. Press ② in Figure 2 to stretch the body neck- circumference flat with moderate tension.
4. Select the corresponding size, then press④ in Figure 2 to write- in parameters.
5. Long- press ①in Figure 3. All settings are now completed