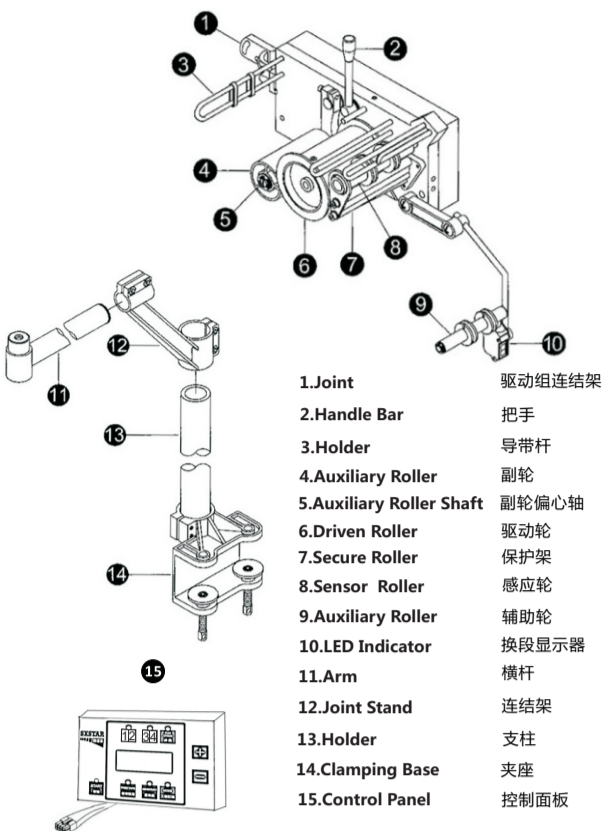


User's Manual
产品说明书
Section 4. Computerized Metering Device
MG 3-4 电脑送带装置

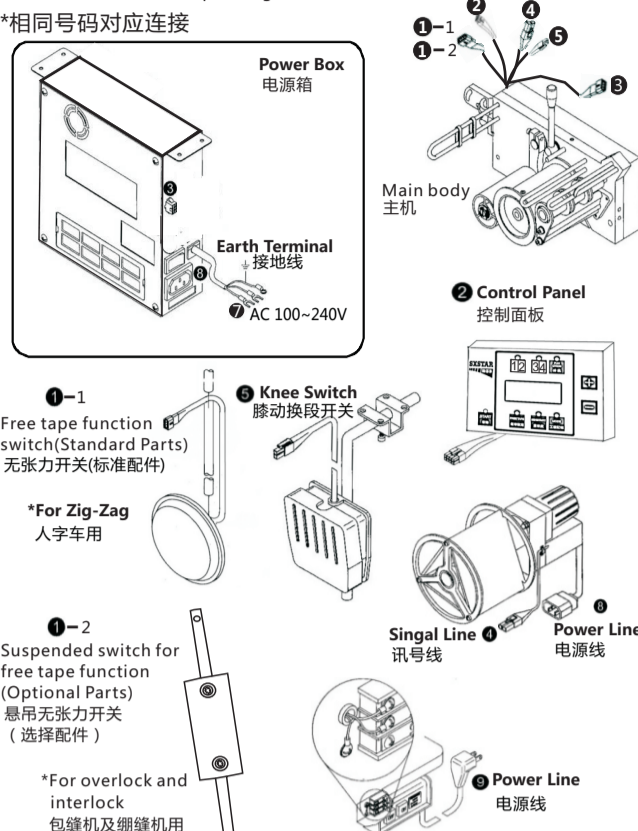
1.Component Name 组件名称



1. Joint 驱动轴连接架
2. Handle Bar 把手
3. Holder 导料杆
4. Auxiliary Roller 副轮
5. Auxiliary Roller Shaft 副轮轴心轴
6. Driver Roller 驱动轮
7. Securl Arm 保护架
8. Sensor Roller 感应轮
9. Auxiliary Roller 副轮
10. LED Indicator 换段显示器
11. Arm 臂杆
12. Joint Stand 连接架
13. Holder 支柱
14. Clamping Base 夹座
15. Control Panel 控制面板

2. Wiring Diagram 接线图

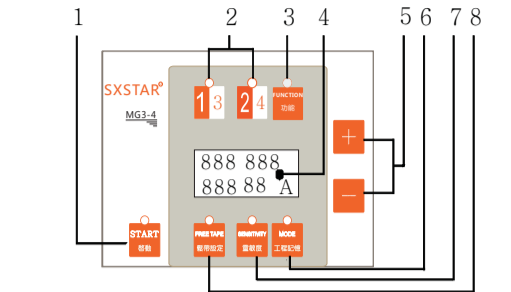
The same number corresponding connection
*相同号码对应连接



Free tape function switch (Standard Parts)
*For Zig-Zag 人字车用

*For overlock and interlock 包缝机及锁缝机用

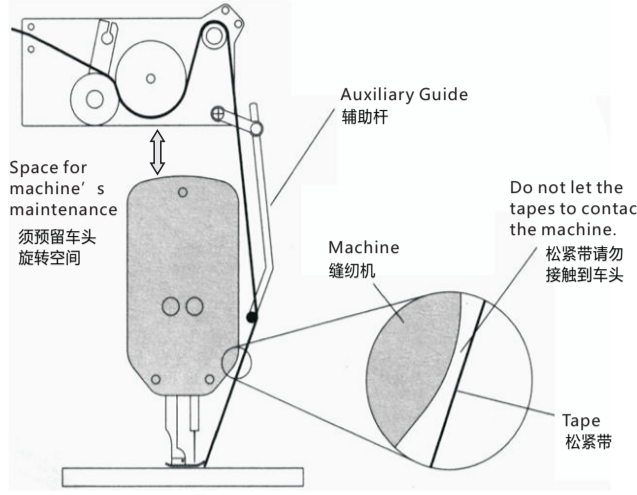
3. Control Panel 控制面板说明 (升级版显示)



1. START: Push START to normal sewing operation. 启动键：进入车缝模式。
2. SECTION TENSION: To set each SECTION TENSION, up to 4 different SECTIONs per program. 工程设定选择键：有四段工程可供设定松紧度。功能设定选择键：特殊功能设定。
3. FUNCTION SETTING KEY: Press this key to activate for setting the SPECIAL functions. 功能设定选择键：特殊功能设定。
4. DISPLAY WINDOW: Displays all the SECTIONs. 显示器 显示各段松紧度等设定值。
5. ←, → KEY: Use the ←, → KEY to modify settings. ←, → 键：用来更改各段的设定值。
6. MODE: Use this key to memorize up to 12 different programs from A-L. 工程记忆键：对存储12组(A-L)不同工程内容的资料。
7. SENSITIVITY: Adjust this value for different tapes and tensions for stable sewing. 灵敏度设定键：每段均可设定以达到稳定车缝效果。
8. FREE TAPE: To eliminate tension on the TAPE. 松带设定键：设定无张力送带值。

4. Hauteur&Guide Auxiliaire 高度调整与辅助杆调整

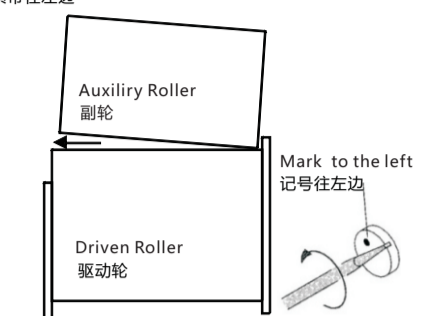
Please use the Auxiliary Guide to avoid the tape to contact the machine.
松紧带接触到头，将会影响到车缝尺寸，可用辅助杆调整。



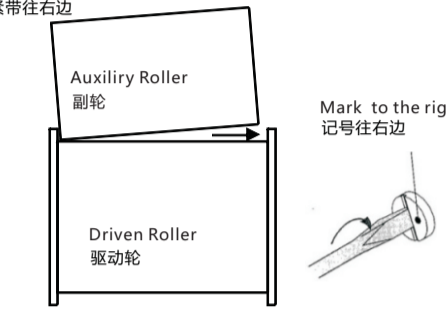
Space for machine's maintenance 维修空间
Do not let the tapes to contact the machine. 松紧带请勿接触到头

5. Adjustment for tape sliding over the roller 松紧带左右偏差调整

Adjust the tightness to the left
调整松紧带往左边



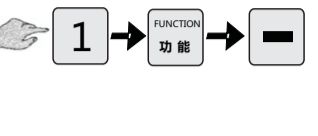
Adjust the tightness to the right
调整松紧带往右边



6.0kg Calibration (Upgraded version) 扫零校正 (升级版)

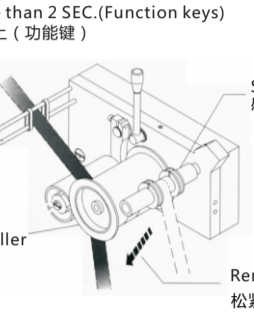
The following conditions need to do zeroing:
以下情况需进行扫零校正

1. After installation. 安装完成后扫零
2. If the device is feeding irregularly. 尺寸有异常不稳定的时候



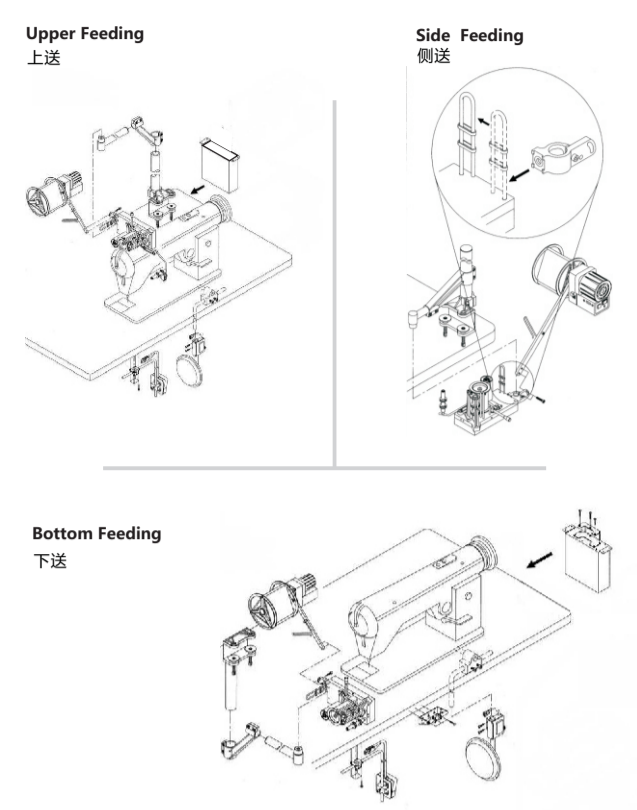
NOTE: If the value is not between 10-90 after Regular Calibration. The device needs to be. 注意：如果扫零后，其数值不在10-90之间时，即表示装置有问题，需要检修。

Push more than 2 SEC. (Function keys)
长按2秒以上 (功能键)



Remove the elastic tapesensor bar
松紧带移除传感器架

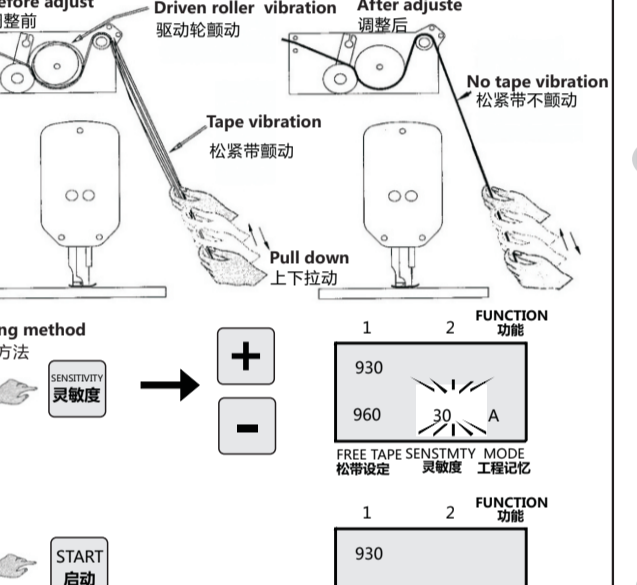
7. Installation instructions 安装方式图样说明



Upper Feeding 上送
Side Feeding 侧送
Bottom Feeding 下送

8. Sensitivity adjustment instructions 灵敏度调整操作说明

When the driven roller and the elastic occur sewn around fibrillation occurs constantly, the need to adjust the sensitivity of the value of each project can be adjusted, while adjusting the sensitivity. Larsson hand side of the belt lightening, until no shocks so far (sensitivity value from 00-99, the factory set value: 90)
车缝时驱动轮及松紧带发生后侧抖动不停时，需适当调整灵敏度，每段工程均可调整，以调整灵敏度。应调节手拉松紧带，直到无震动为止 (灵敏度值从00-99，出厂设定值为90)



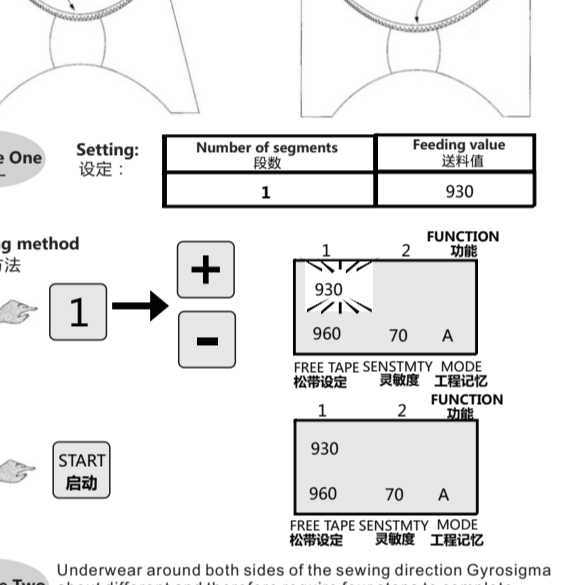
Setting method
设置方法

START 启动

9. Feeding Value Operating Instructions 送料值操作说明

Single section (if not required, Sec when the 2nd button press twice the number of segments being lifted)
单段工程 (如不需2、3、4段时，连续按两次功能键解除之段数)

Feeding value is small 送料值小
Feeding value is large 送料值大



Setting method
设置方法

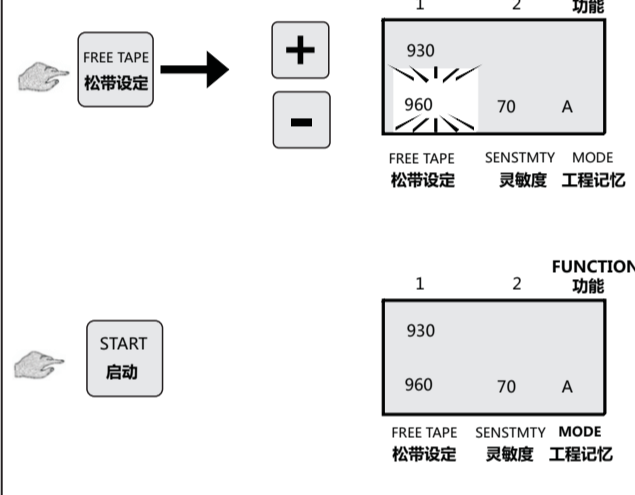
START 启动

Underwear around both sides of the sewing direction Gyroisma about different and therefore require four steps to complete (validation segments, segment display to see change)
内衣上侧两边缝制时左右侧布纹方向有所不同，因此需要4段来完成 (确认工作段数，可看换段显示器)

10. Free Tape Operation 松带值操作说明

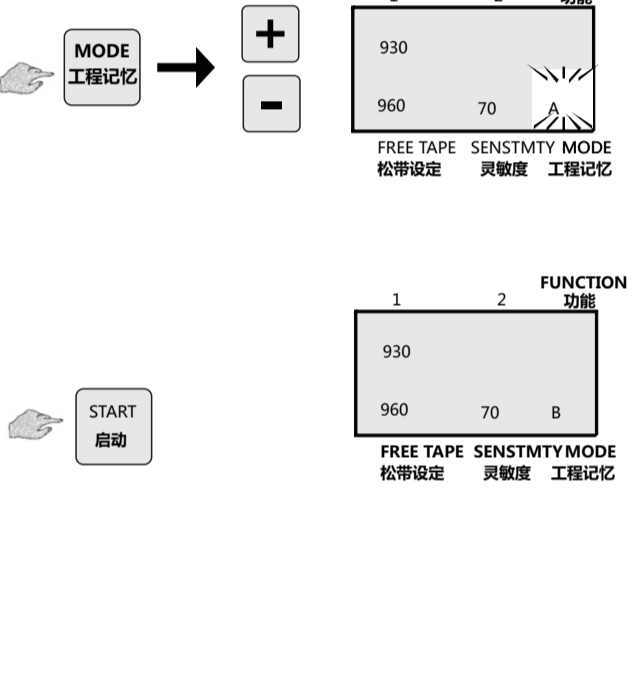
Loose with value setting, with different elastic band, you need to set a different value, otherwise the value will cause too much elastic band is too loose and fall, whereas the value of such elastic band is too tight and too removed from the cloth (factory setting: 980).
松带值的设定，配合不同的松紧带，需要设定不同的值，否则会造成松紧带太松而掉落，反之值太少使得松紧带太紧而掉出布料 (出厂设定值: 980)。

NOTE: This feature requires no tension switch operation.
注意：此功能必须配合无张力开关操作使用。



START 启动

11. Operation Guide 工程记忆操作说明

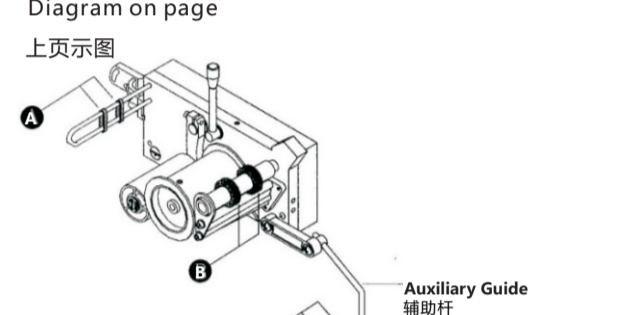


START 启动

12. Troubleshooting 故障排除

Symptoms 问题现象	Reason 原因	Countermeasure 对策
Abnormal vibration belt machine 送料机震动	1. Each bracket screws loose 支架固定螺丝松脱。 2. Sensitivity value is too high. 灵敏度太高。	1. Tighten loose screws. 上紧松动的螺丝。 2. reducing the sensitivity values. 降低灵敏度。
999 is still too tight 送带数值999仍然太紧	1. Sewing rod in contact with foreign objects collide. 缝杆有异物碰撞。 2. Induction value is not in the normal range. 感应值不在正常范围。	1. Please remove foreign matter. 清除异物。 2. Refer to zeroing, such value is not within the range 10-90, notify service personnel. 参照扫零校正，数值不在10-90范围内，通知服务人员进行处理。
No action belt machine 送料机无动作	1. power supply is not properly connected 电源未接妥。 2. Line System Open 线路系统故障。 3. control system failure 控制系统故障。	1. Refer to wiring diagram connecting the power. 参照接线图连接电源。 2. Check each line socket and the plug is loose their angle. 检查各线插座与插头是否松动角度。 3. Notify service personnel. 通知服务人员进行处理。
Screen does not display 无显示	Panel Fault 面板故障	Notify service personnel 通知服务人员进行处理
Numerical models can not remember 模式无法记忆	Memory failure 记忆体故障	Notify service personnel 通知服务人员进行处理
Starts, elastic band can not be pulled back to the tightness of the set 启动时，松紧带无法拉回至所设定的紧度	Tension switching action is not correct 张力切换动作不正确	Remove the power plug tension-free switch, if can normally pull back, said (1) no tension switch failure, notify service personnel. 移除无张力开关，如果可以正常拉回，说明 (1) 无张力开关故障，通知服务人员进行处理。
Elastic band has been very loose, but the effect is still down fabric wrinkle reduction can not be flat 松紧带已经非常松，但效果仍然是面料褶皱减少不能平整	Front differential gear because of the sewing machine, the differential too much, too much fabric to send 送料机的前差动齿太多，送过多的布料	Adjust the machine to send the main differential gear of the differential gear ratio is synchronized (1:1) 调整送料机前差动齿与主差动齿的传动比为同步 (1:1)
Forward with the process is not smooth: 送带过程不顺畅:	1.1. 000 ring width is too narrow limits to send process (problem resistance caused as shown below) 000 环宽太窄造成送带阻力大 (如下图所示)	1.1. 000 ring limit ring as shown sidemid presser foot guide pin devices and changes need to adjust the spring device are a little loose on the elastic band (Note: if the reading shift when sewing elastic band around, adjust the width of the ring 000 limit correct position). 000 限位环如下: 000 无弹脚穿针限位器及弹针上之限位器位置需调整限位器松紧度 (注: 如缝弹性带时读数有偏移, 调整 000 限位环位置)
Elastic band sewn at the front, or other physical contact with friction 弹性带缝制在车头或其物体接触产生摩擦	1-2. Adjust the auxiliary lever, all elastic contact with the front or isolate all objects (Refer to "assist" or "adjustment") 调整辅助杆, 将所有松紧带接触所有接触的车头或物体 (参照"辅助"或"调整")	1-2. Stretchable elastic material by adjusting the sensitivity, the greater the sensitivity, telescopic adjustment required is higher, but if the tone is too high sensitivity will produce more than the best fibrillation, while sensitivity is too slow to react when the product size more than the best fibrillation. 弹性带具有弹性材料通过调整灵敏度，灵敏度越高，伸缩调整所需越高，但如果调太高灵敏度时会产生更好的抖动，而灵敏度太慢对反应当产品尺寸更多的抖动。
Sensitivity adjustment not working 灵敏度调整不灵	3. Sewing and fabric cutting skilled staff gestures unequal size 缝制员手穿线及布料裁剪尺寸不均	3. Members of the sewing process, the cloth should be kept consistent pressure given gesture, do not suddenly relaxed, sometimes tight, and the fabric of the crop size to be consistent. 缝制员在手穿线过程中，应保持手穿线给予布料一致的张力，不可忽松忽紧，且布料的裁剪尺寸要一致。

Diagram on page 本页示意图



Auxiliary Guide 辅助杆

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