

SXSTAR[®]

MC-20K 自动切带送带装置产品说明书

AUTO CUTTING AND COMPUTERIZED METERING DEVICE

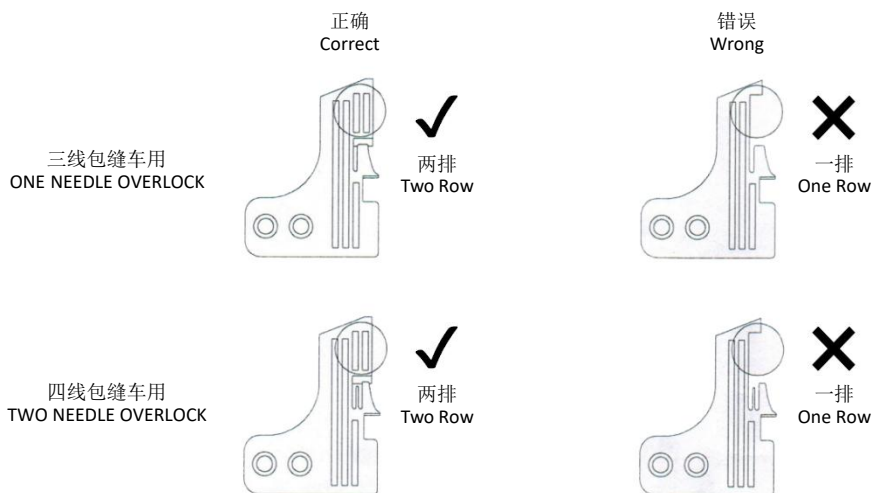
USER MANUAL

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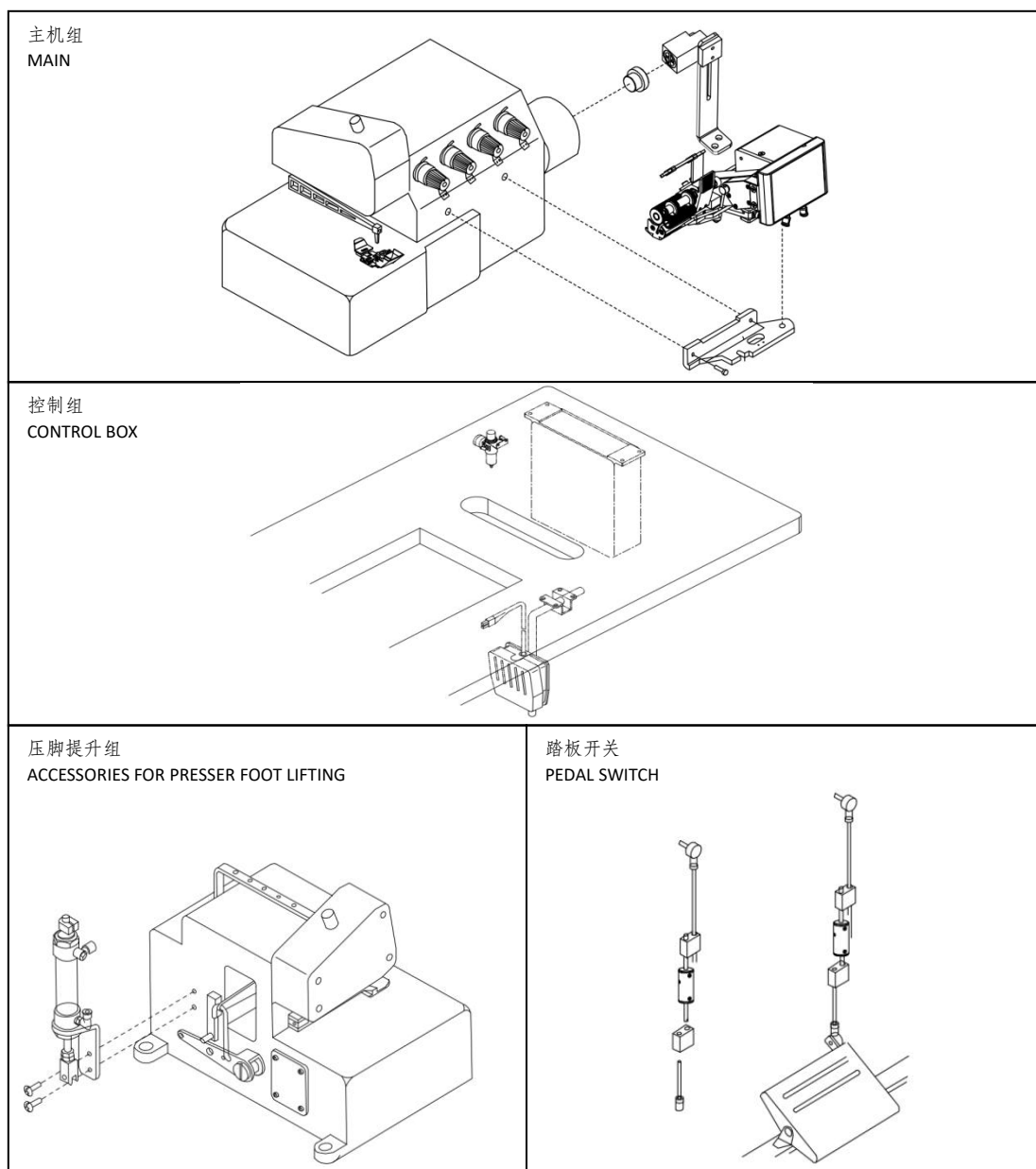
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注意：本送带机必须使用下列规格的针板

ATTENTION: This metering device must be operate with the following type of needle plate



一、组合图 Assembly combination



注意：编码器必须满足下述安装要求

ATTENTION: SY needle counter must satisfy the following installation conditions

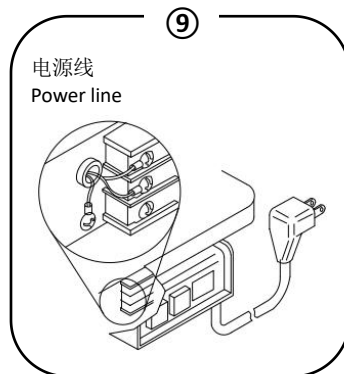
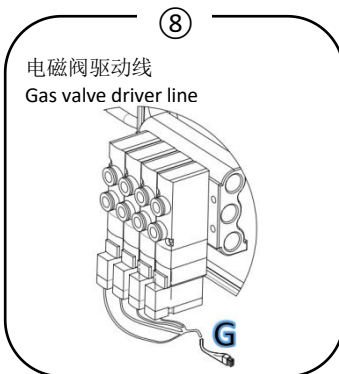
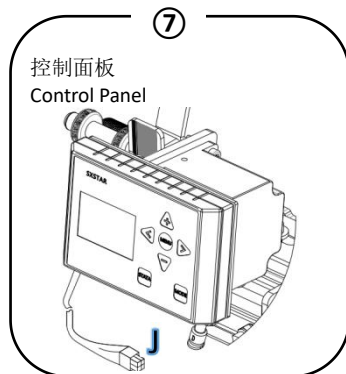
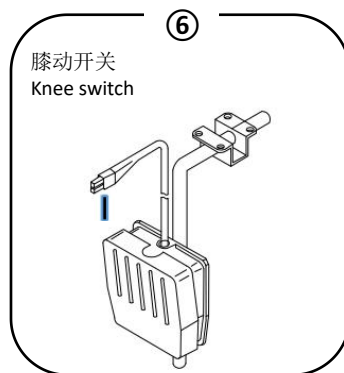
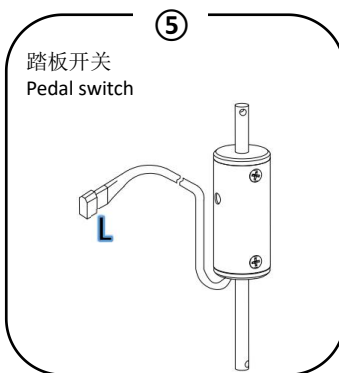
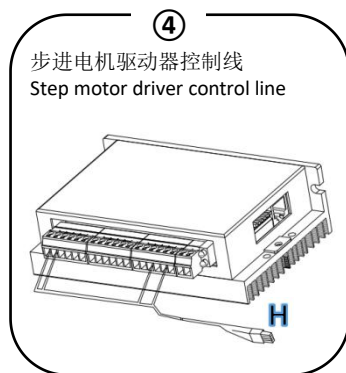
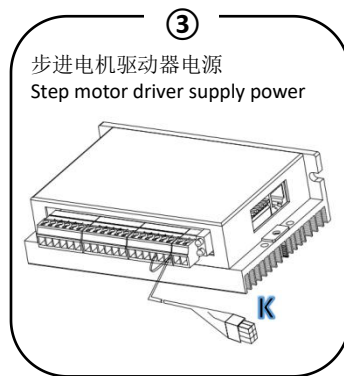
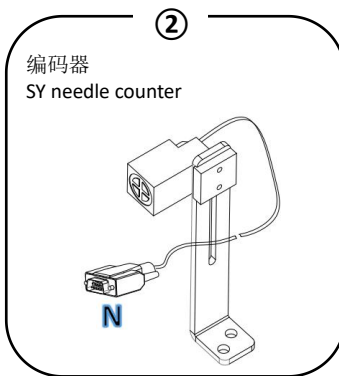
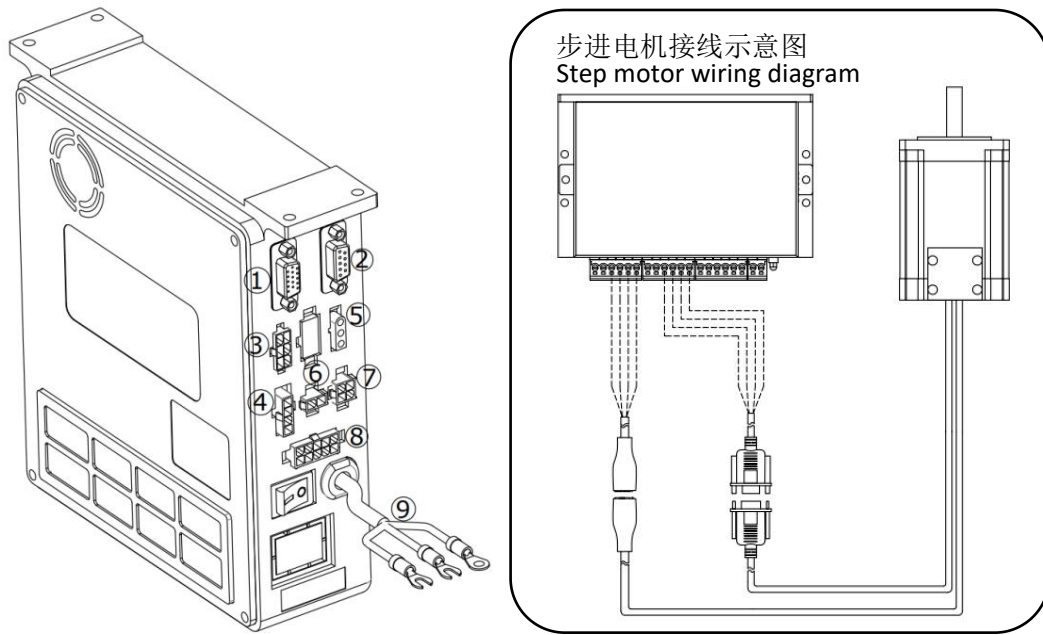


磁铁与编码器感应面间隔距离不得超过5mm
The distance between magnet and SY needle counter must not exceed 5 mm



磁铁与编码器感应面应保持中心对齐
Magnet should keep center align with SY needle counter

二、安装接线示意图 Wiring diagram description

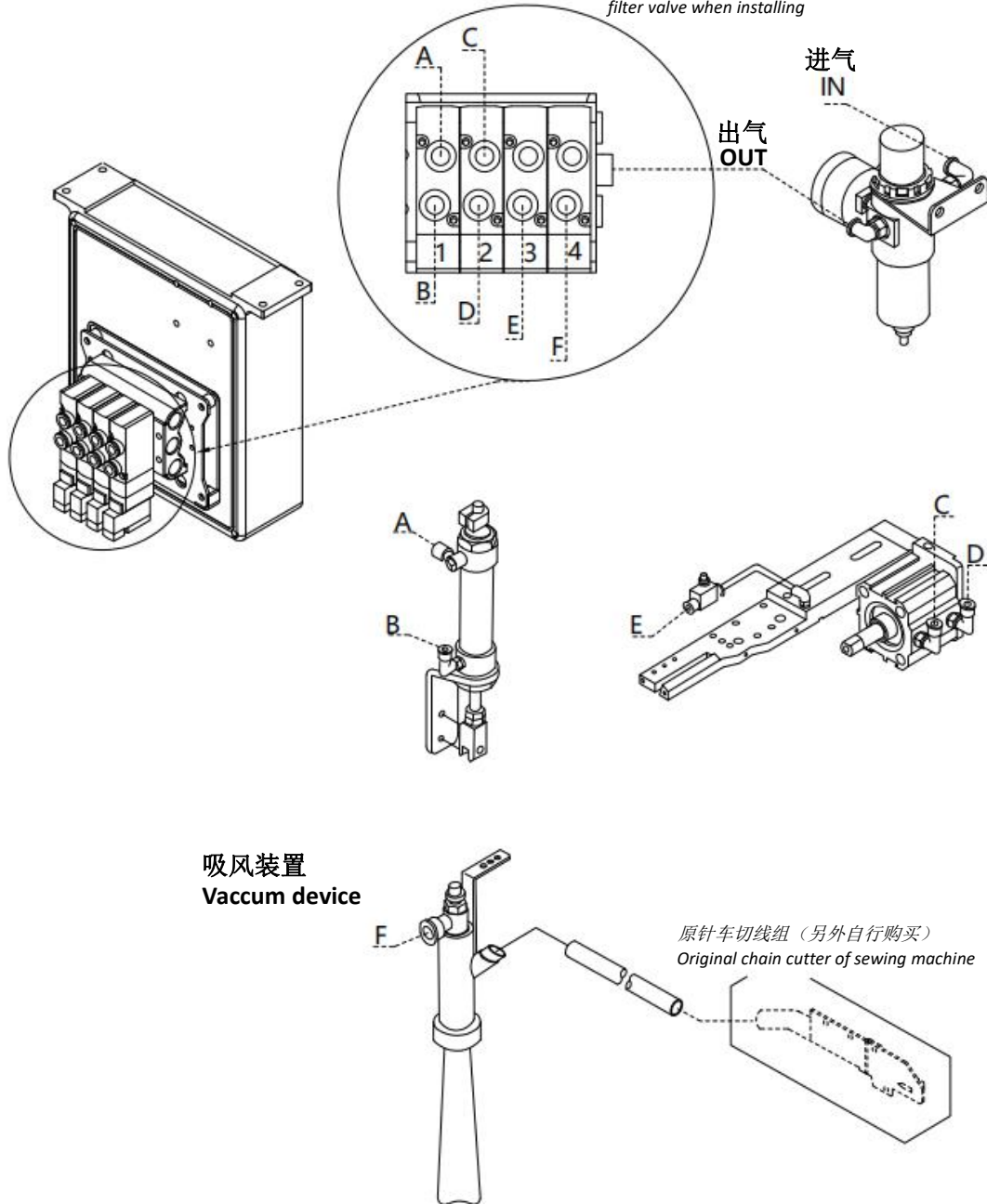


三、气缸管路示意图 Air hose diagram



注意：空压压力不得小于 4kgf/cm²

Note: The pressure air must not be less than 4kgf/cm²

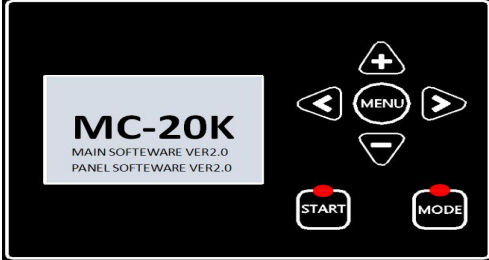
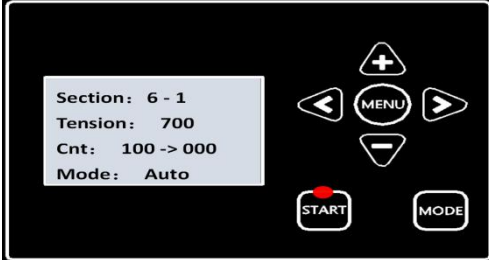
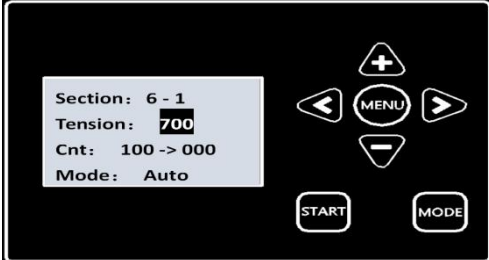
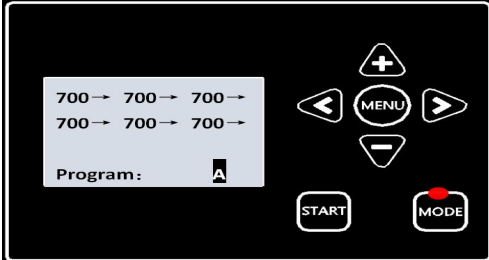
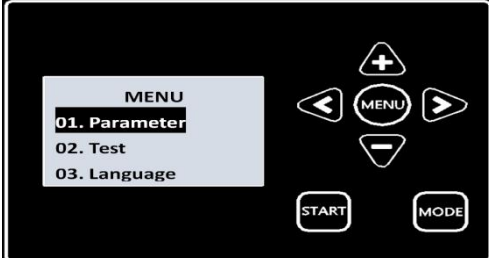
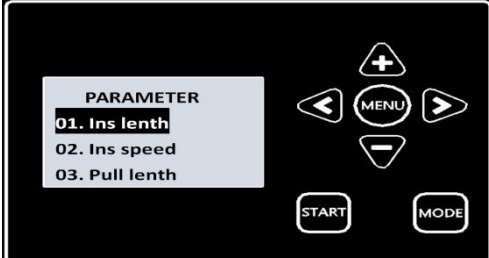
安装时注意区分滤水阀进排气方向
Pay attention to the inlet and outlet direction of filter valve when installing



四、按键说明 Button Reference

图标 ICON	按键名 Button name	按键用途 function	特别说明 specification
	启动键 Start button	进入车缝模式用 Enter work mode	按键灯亮起时表示进入工作模式 Start Button Led Turn light when in the Work mode
	菜单键 Menu button	用于进入工程参数设置和系统参数设置 Used for program setting and system setting	工程设置状态下，短按可切换设置项目 The program setting option can be selected by this button 长按进入系统设置页面 Long press to enter system setting page
 	工程段切换键 Section switch button	用于对工程段号进行操作 used for modify the section number	工程设置状态下，长按可以修改总工程段数量，短按可以切换当前工程段号 Long press for modify total section number and short press for modify section number
 	加减键 Addition and subtract button	用于系统功能选项切换及数值修改 Used for system option switch and value setting	
	模式键 Mode button	短按用于进入工程组选择页面 Short press used for modify program number 长按用于执行手动送料 Long press used for manual feeding	共有 10 组工程组可供选择 Up to 10 different program

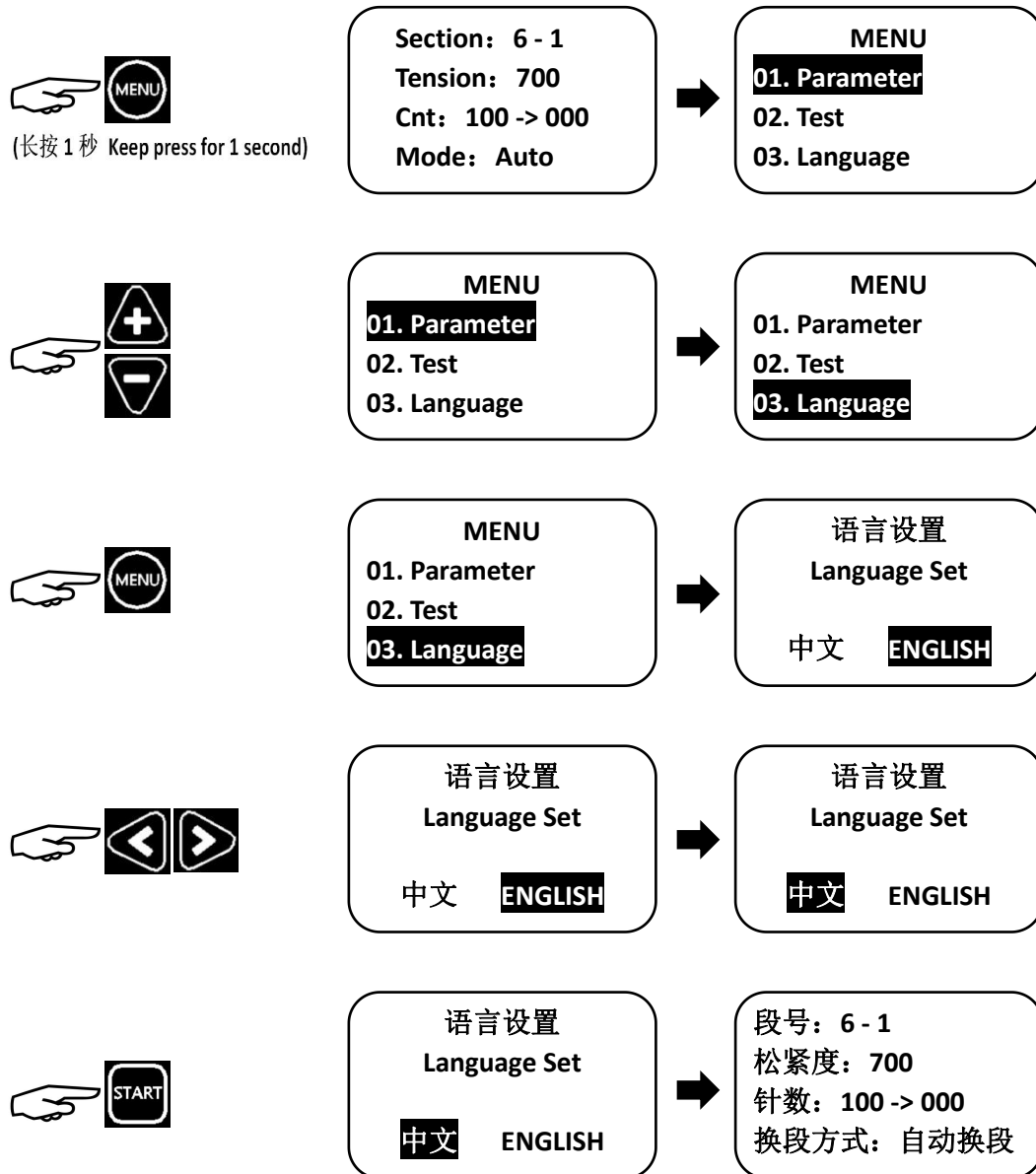
五、显示说明 LCD display Reference

<p>开机显示页面： Power on display:</p> <p>显示产品型号和系统软件版本 Display model and system software version</p> <p>(*注：开机固定显示 2 秒后进入工作显示页面) (Enter work mode display automatically after 2 second)</p>	 <p>The image shows the power-on display screen. On the left, a white box contains the text: 'MC-20K', 'MAIN SOFTWARE VER.2.0', and 'PANEL SOFTWARE VER.2.0'. On the right, there is a control panel with a central 'MENU' button, four arrow buttons (up, down, left, right), and two buttons at the bottom labeled 'START' and 'MODE'.</p>
<p>工作显示页面： Work mode display:</p> <p>显示工程段总数、当前工程段号、当前工程段松紧度、针数计数值及换段方式 Show the total section number 、 current section number 、 tension of current section 、 stitch setting and section switch mode</p>	 <p>The image shows the work mode display screen. A white box on the left displays: 'Section: 6 - 1', 'Tension: 700', 'Cnt: 100 -> 000', and 'Mode: Auto'. The control panel on the right is identical to the power-on screen.</p>
<p>工程设置页面： Section setting Display:</p> <p>黑底显示指示当前被选中工程参数 The black background indicate which program option is selected</p>	 <p>The image shows the section setting display screen. The white box on the left displays: 'Section: 6 - 1', 'Tension: 700', 'Cnt: 100 -> 000', and 'Mode: Auto'. The '700' value is highlighted with a black background. The control panel on the right is identical.</p>
<p>工程组选择页面： Program number setting display:</p> <p>显示当前工程组编号（共 10 组，每组最多包含 6 个工程段） Show current program number(up to 10 program , up to 6 section each program)</p>	 <p>The image shows the program number setting display screen. The white box on the left displays: '700 -> 700 -> 700 ->', '700 -> 700 -> 700 ->', and 'Program: A'. The control panel on the right is identical.</p>
<p>系统功能选项页面： System option display:</p> <p>显示系统功能选项 Show the system option</p>	 <p>The image shows the system option display screen. A white box on the left displays: 'MENU', '01. Parameter', '02. Test', and '03. Language'. The '01. Parameter' option is highlighted with a black background. The control panel on the right is identical.</p>
<p>系统参数选项页面： System parameter display:</p> <p>显示系统参数选项 Show system parameter option</p>	 <p>The image shows the system parameter display screen. A white box on the left displays: 'PARAMETER', '01. Ins lenth', '02. Ins speed', and '03. Pull lenth'. The '01. Ins lenth' option is highlighted with a black background. The control panel on the right is identical.</p>

六、语言设置 Language setting

面板提供中文和英文两种语言显示，用户可以根据实际使用需求选择合适的语言，具体操作方法如下图所示

System provide two type of language for use , including Chinese and English,user can learn how to select Language by course shown below



七、功能操作说明 Function operation guide

设备提供 10 组工程组，每组工程组最多可以包含 6 个工程段，每个工程段的松紧度、针数、换段方式都可以独立设定。其中换段方式包含手动换段、自动换段、手动切刀换段、自动切刀换段共四种模式

System provide up to 10 program , contain 6 section each program,and the tension 、 stitch 、section switch mode can be change independently each section. The section switch mode including manual switch 、 auto switch、 manual cutting 、 auto cutting.

手动换段：系统在用户按下手动换段开关后切换到下一个工程段

Manual switch:system switch to next section after user press manual switch.

自动换段：系统在针数计数值达到设定值后自动切换到下一个工程段

Auto switch:system switch to next section when stitch counting is reach to the setting.

手动切刀换段：系统在用户按手动切刀开关后切换到下一个工程段

Manual cutting:system switch to next section after user press manual cut button.

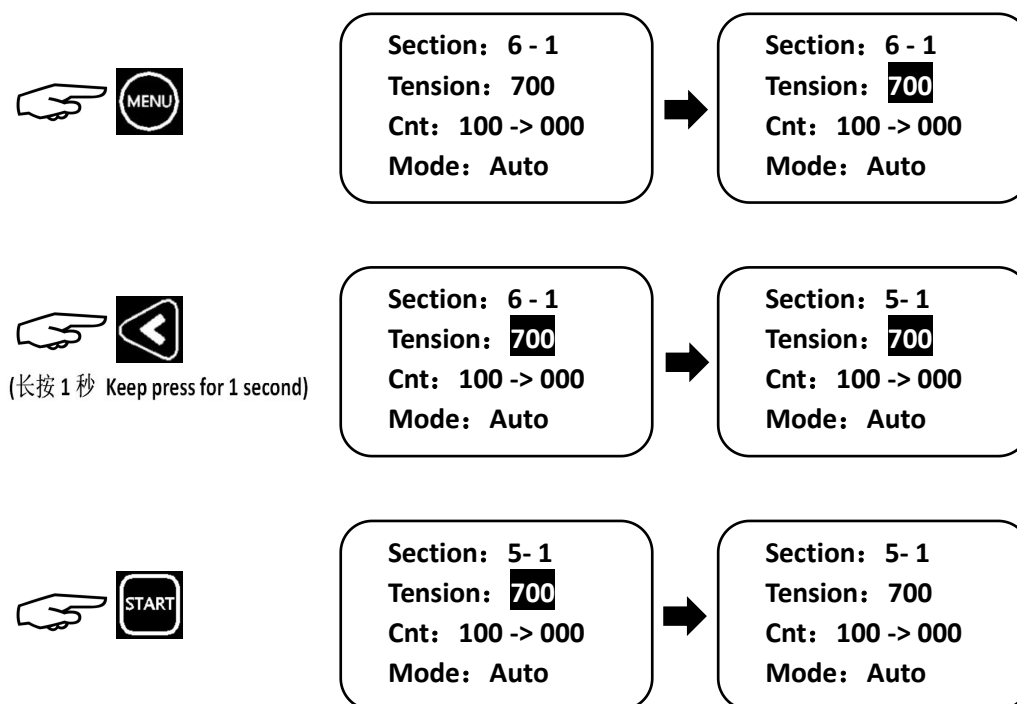
自动切刀换段：系统在针数计数值达到设定值后自动执行切刀并切换到下一个工程段

Auto cutting:system auto cut and switch to next section when stitch is reach to the setting.

1.工程总段数操作示例 Total section number operation guide

例 1.1：将工程总段数由 6 段设置为 5 段

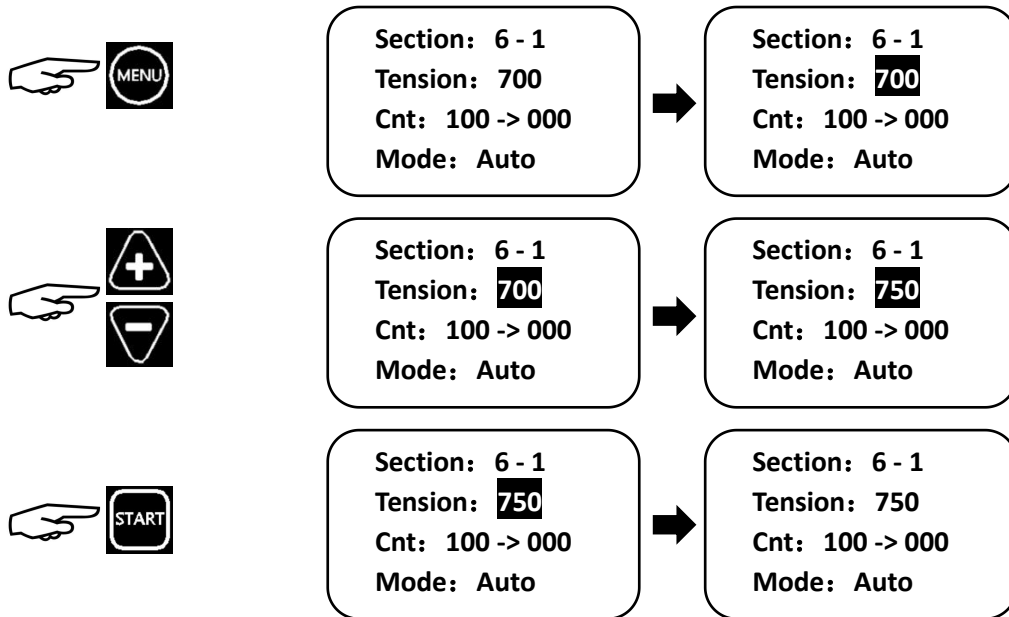
Example 1.1: modify Total section number to 5 from 6



2.松紧度操作示例 Tension setting guide

例 2.1: 修改工程段 1 松紧度由 700 修改为 750

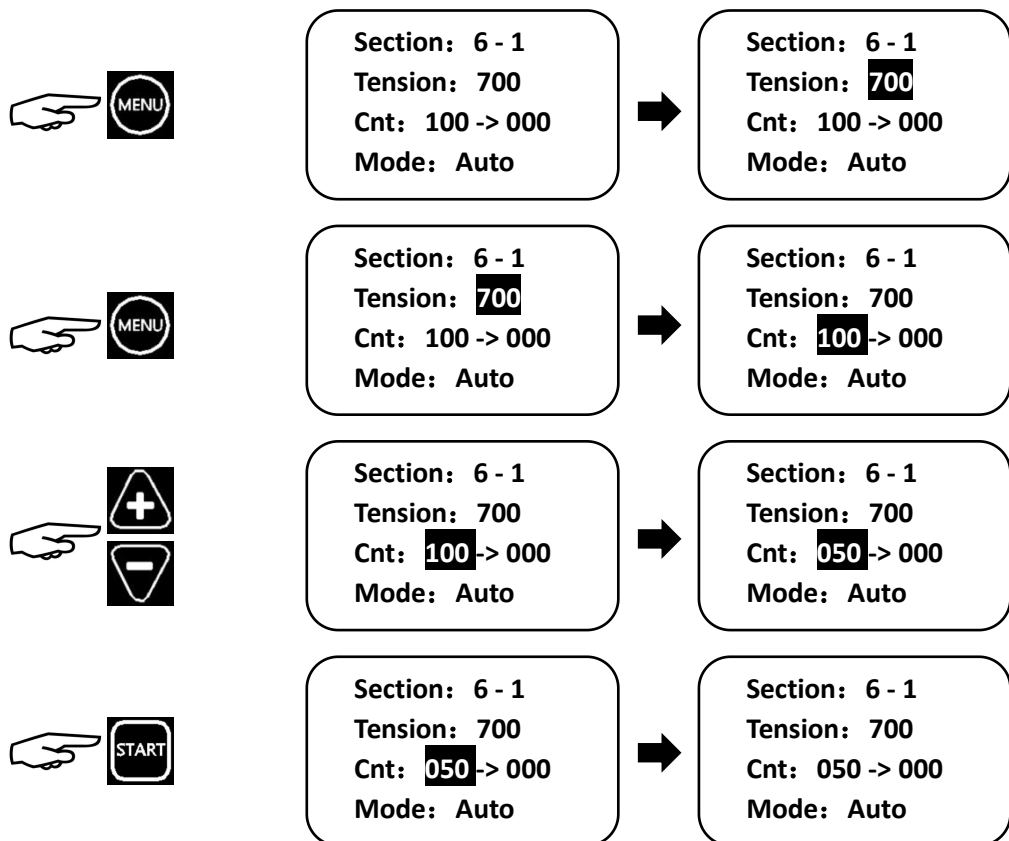
Example 2.1: modify tension of section 1 to 750 from 700



3.工程段针数操作示例 Stitch setting guide

例 3.1: 将工程段 1 针数设定值由 100 修改为 50

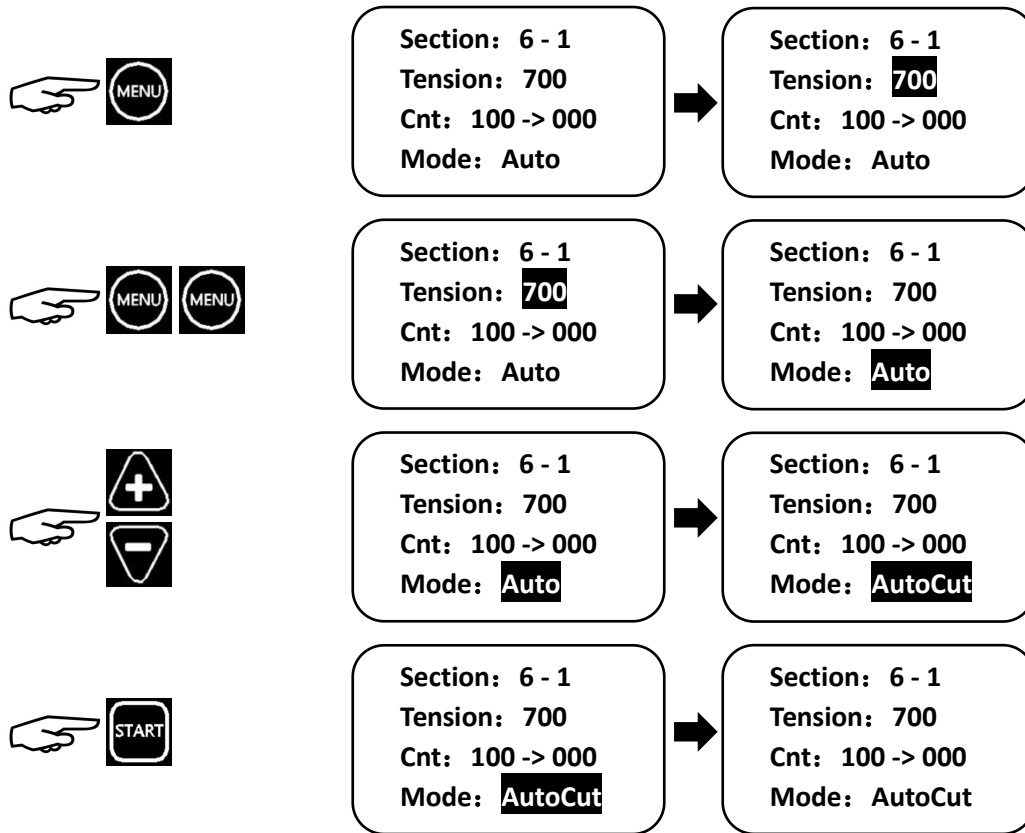
Example 3.1: modify stitch setting of section 1 to 50 from 100



4.工程段换段方式示例 Section switch mode setting guide

例 4.1: 将工程段 1 换段方式由自动换段设置为自动切刀后换段

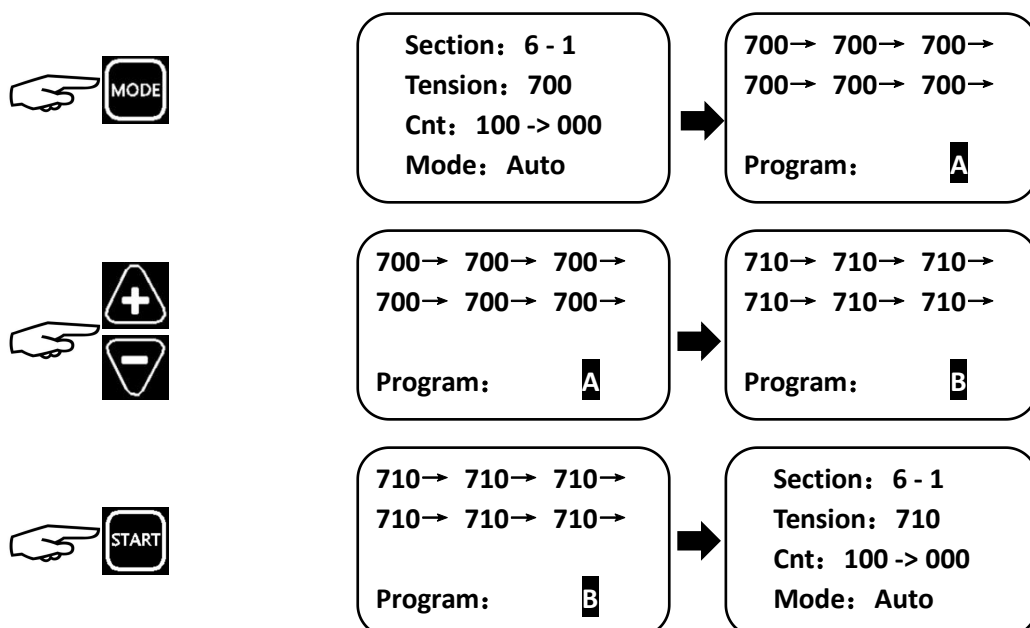
Example 4.1: modify section switch mode to auto cutting



5.工程组选择示例 Program number setting guide

例 5.1: 将工程组由工程组 A 切换到工程组 B

Example 5.1: switch program number to program B from program A



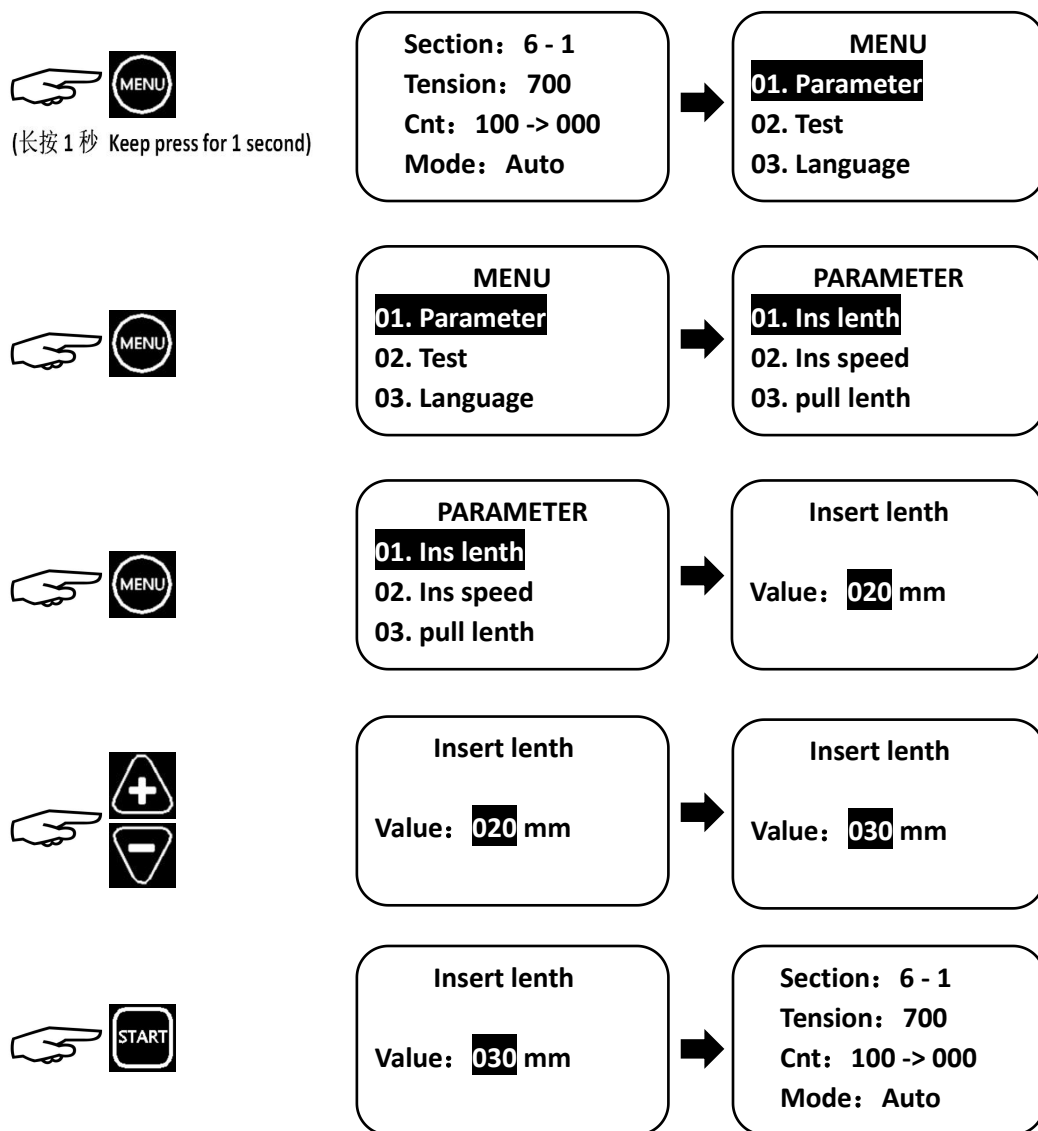
6.系统参数设定示例 System parameter setting guide

注：长按菜单键进入设置菜单，通过加键或减键切换选择项目，短按菜单键进入项目设定界面

Note: keep press for one second to enter system option mode, and selecting option by addition or subtract button, and then press menu to enter option setting page

例 6.1: 将进带长度由 20 毫米修改为 30 毫米

Example 6.1: Modify inserting length to 30mm from 20mm



八、参数说明 Parameter reference

参数信息如下文表格所示:

Parameter table is shown below

参数编号 Parameter ID	参数用途 function	最小值 Min	最大值 max	单位值 unit
01.Ins length	进带长度 Length of Tape inserting	00(35mm)	99 (134mm)	1 = 1mm
02.Ins speed	进带速度 Speed of Tape inserting	00(50mm/s)	99 (248mm/s)	1 = 2mm/s
03.Pull length	始缝松紧带回拉 Pull back tape at beginning sewing	00(无回拉) 00(no pull back)	99 (34mm)	1 = 0.35mm
04.Cut time	切刀闭合时间 Cutter Time	00(0.01s)	99 (1.00s)	1 = 0.01s
05.Slack set	切带后 TR 和真空吸风装置启动延迟针数 Stitch after cut to active TR and vacuum device	00	99 (99 针) 99 (99 stitch)	1 = 1 针 1 = 1 stitch
06.Foot mode	车缝完成停止后压脚自动提升进带 Pressure foot lifted up and insert the tape after completely operation	OFF	ON	
07.Inhale	始缝真空吸风装置动作针数 Vacuum activates stitch at beginning sewing	00	99 (99 针) 99 (99 stitch)	1 = 1 针 1 = 1 stitch
08.Feed delay	始缝时, 送带延迟针数 Stitch for start feed tape	00	99 (99 针) 99 (99 stitch)	1 = 1 针 1 = 1 stitch
09.Cut insert	切带后自动送带长度 Feed tape after cut	00	99 (34mm)	1 = 0.35mm
10.Preblow	进带前预先吹风时间 Blowing in advance before insert tape	00	99 (99ms)	1=1ms

九、故障说明 System fault reference

当系统出现故障时，面板会在面板显示相关故障信息

When system occur fault,LCD panel will display the error code,user can reference to the table below

面板显示 Panel display	故障信息 Fault information	解决 Solution
安全开关无效 Safe invalid	安全开关信号无效 Safe switch is unavailable	调整送带结构位置并锁紧 Adjust Feeder structure and make it fasten
通信错误 Com error	面板与主板通信异常 Panel communication fail	检查面板连接线是否松动 Check panel Connecting line
数据存储错误 Data error	系统存储器异常 Data Save fail	重启机器后若故障依旧存在则需联系相关技术人员进行维修 Reset the device ,it's necessary to contact technician if the fault is still available

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