



热熔绕钮机使用说明

- 热熔绕钮机使用说明
- Automatic buckle machine instructions

1. 安全注意事项

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- 1.不要在没人看管和密闭空间内操作机器。
- 2.本机器一定要由经培训的人员操作使用。
- 3.本机器只可用于它本来设计的用途。
- 4.在任何情况下如要进行维修或更换零件，一定要确保电源和供气开关已关闭。 如在某些情况必需接上电源
才可以检查零件或设定 ----- **请小心不要让加热叉灼伤自己**
----- **它是非常烫的!**
- 5.一定要由经培训的合格机修或专业人员对机器进行维修。

1. Safety precautions

- To
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- 1. Do not operate the machine in an unattended and confined space.
- 2. This machine must be operated and used by trained personnel.
- 3. This machine can only be used for its originally designed purpose.
- 4. In any case, if you want to repair or replace parts, make sure that the power and air supply switches are turned off. If it is necessary to connect to the power supply in some cases
- Only then can you check the parts or settings ----- please be careful not to burn yourself with the heating fork ----- it is very hot!
- 5. The machine must be repaired by trained and qualified mechanics or professionals.

• 2 介绍

• 2.1重要事项

- 为避免任何问题或损坏机器的情况发生，请务必遵守下列指引。
- 1. 将机器电源线插上电源插座前，要确保电源为110V—220V的单相交流电。
- 2. 将机器气管接上压缩空气前，要确认空气压缩机中没有水分及能提供最小每时1立方米，气压最小为4巴的压缩空气。
- 3. 检查所有零件的外观是否良好无损。
- 4.检查所有关键零件运作是否顺畅。

• 2 Introduction

- 2.1 Important matters
- To avoid any problems or damage to the machine, please follow the guidelines below.
- 1. Before plugging the power cord of the machine into the power socket, make sure that the power supply is 110V-220V single-phase AC.
- 2. Before connecting the machine air pipe to compressed air, make sure that there is no moisture in the air compressor and can provide a minimum of 1 cubic meter per hour.
- Compressed air with a minimum pressure of 4 bar.
To
- 3. Check whether the appearance of all parts is good or not.
- 4. Check whether all key parts are operating smoothly.

• 2.2 日常保养

- 为使绕扣机最高效地运行,要求加热叉定期清洁。清洁的频率以每天绕扣子的数量而定。一般绕扣
- 10,000次或大约一周清洁一次。清洁时请先拔掉机器电源, 打开机器上盖, 然后取下不锈钢前盖。这
- 时加热叉依然会很烫,但也有利于清理它的过程 **小心不要灼伤自己!** 需清理加热叉的前面和背面以及加热叉不锈钢部分的
- 内部.上面的残留物可用比如螺丝刀等金属工具铲掉.
- 只有下列的零件需要加润滑油:
- 加热叉组件及绕线组件的直线滑轨-----每两个月一次加小量润滑油
- 固定扣子支撑器托子的中心轴-----每两周一次加小量润滑膏
- 推动扣子支撑器的“T”型推竿-----每两个月一次加小量润滑膏
- 另外的日常保养就是对机器清洁。每绕10,000个扣子或每周需打开面盖和前盖然后清理那些可能没有被机器自动清洁装置
- 吹走的剩余的废线。同时清洁所有工作中的零件以及检查它们的状况。任何损坏的零件一定要立刻更换。

• 2.2 Daily maintenance

- To
- In order to make the buckle winding machine run most efficiently, the heating fork is required to be cleaned regularly. The frequency of cleaning depends on the number of buttons wound each day. General deduction
- 10,000 times or approximately once a week. When cleaning, please unplug the machine first, open the top cover of the machine, and then remove the stainless steel front cover. This
- When the heating fork is still hot, it is also helpful to clean it. Be careful not to burn yourself! You need to clean the front and back of the heating fork and the stainless steel part of the heating fork.
- Inside, the residue on it can be shoveled off with metal tools such as screwdrivers.
- Only the following parts need to be lubricated:
- Linear slide of heating fork assembly and winding assembly----- Add a small amount of lubricant once every two months
- Fix the central axis of the button holder bracket-add a small amount of lubricating paste once every two weeks
- Push the "T" type push rod of the button support ----- add a small amount of lubricating paste once every two months
- The other daily maintenance is to clean the machine. Every 10,000 buttons or weekly need to open the face cover and front cover and then clean up those that may not have been automatically cleaned by the machine
- The remaining waste thread blown away. At the same time clean all working parts and check their condition. Any damaged parts must be replaced immediately.

• 2.3 安装

- 本机器既可独立安装，也可以安装在钉扣缝纫车旁配合钉扣车一起使用。
- 独立安装 ---- 把机器放在工作台的原定位，将机器电源关闭并打开机器面盖。找出机架底座的三个安装固定孔，并通过这三个孔将机器固定。废线是通过机器底部的斜槽排出的，因此为了使废线有效排走，工作台上需切出一方孔，方孔的位置尺寸如下图。底部斜槽被安装在机器底部可以使线头废料直接排出。

• 3.控制系统

- 这个控制系统是本公司为绕扣机独自研发而设计的，因此它能提供多种可选方式使绕扣的效果达致完美。

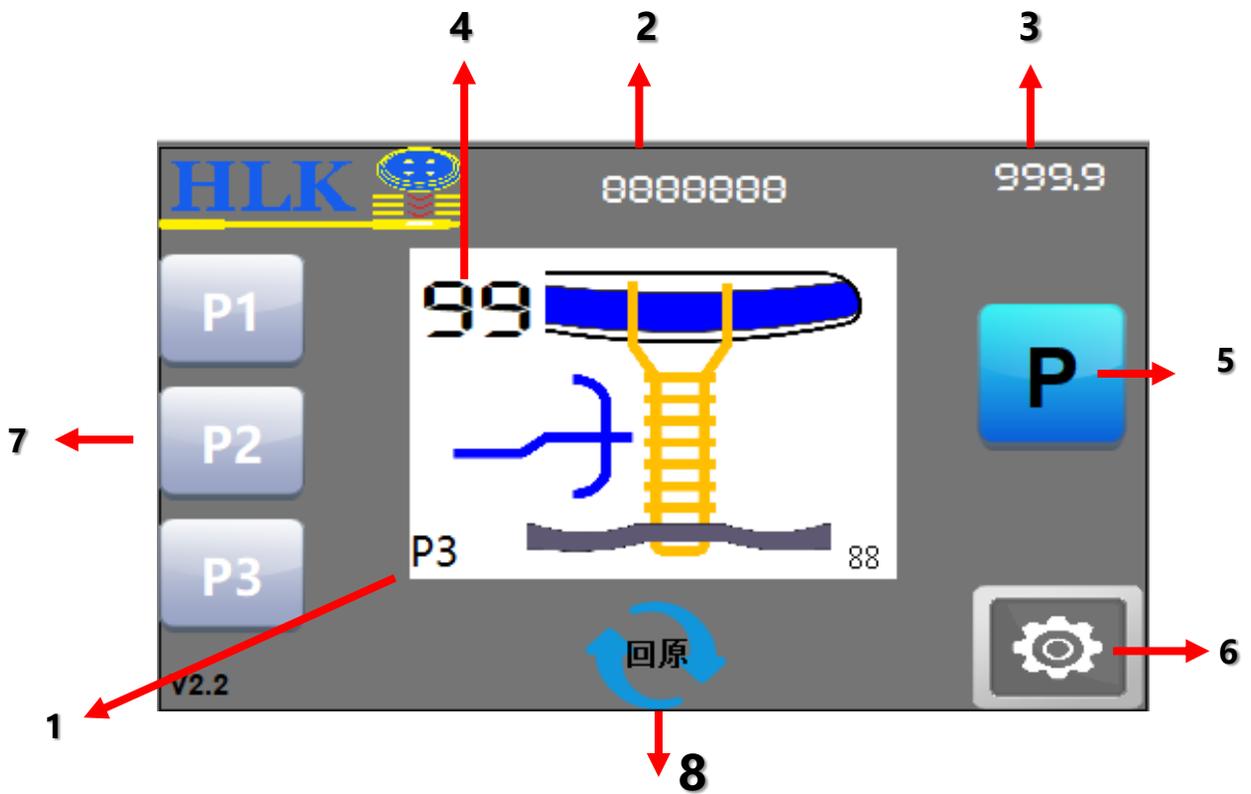
• 显示

- 本机安装了一个轻触式显示屏。通过这个显示屏可以控制机器的所有功能，以及其它比如计数和系统测试等特性也通过显示屏实现。
- 所有特性功能都是通过轻触显示屏上的电子按键来进行操作的。

• 2.3 Installation

- This machine can be installed independently, or it can be installed next to the button sewing machine and used with the button sewing machine.
- Independent installation ---- put the machine on the pre-position of the workbench, turn off the power of the machine and open the machine cover. Find the three mounting fixtures of the rack base
- Fix the holes and fix the machine through these three holes. The waste line is discharged through the chute at the bottom of the machine, so in order to effectively drain the waste line, the workbench
- A square hole needs to be cut out on the upper side. The position and size of the square hole are shown in the figure below. The bottom chute is installed at the bottom of the machine to allow thread waste to be discharged directly.
- 3. Control system
- This control system is designed by our company for the buckle winding machine independently, so it can provide a variety of options to make the winding effect perfect.
- Show
- The machine is equipped with a touch screen. Through this display screen, all functions of the machine can be controlled, and other features such as counting and system testing are also realized through the display screen.
- All feature functions are operated by tapping the electronic buttons on the display.

• 3.0 界面说明 Interface description



NO	按钮 button	按钮说明 illustrate	内容 content
1		显示当前模式 current mode	显示当前绕扣的模式 Display current winding mode
2		计数显示 count display	计数显示 可清除数量 count display
3		温度显示 temperature	显示当前温度 temperature display
4		绕扣圈数 Number of turns	设置及显示当前绕扣的圈数 Set and display the current number of turns of the buckle
5		穿线键 Threading	穿线模式进入 Enter threading mode
6		参数设置 parameter	参数更改/功能测试等 Parameter changes/functional testing, etc.
7		模式1 model1	模式1 用于一般平扣 General flat buckle
		模式2 model2	模式2 用于绕线圈数比较多的工艺 A process with a relatively large number of windings
		模式3 model3	模式3 用于较长纽扣绕线使用 Used for wrapping longer buttons
8		复位键 reset	机器原点复位使用 Return to origin

3.1 计数器设置

Counter settings



计数器显示：计数当前数量

计数器清0方法：点击计数器显示区域，然后按住启动开关（开关为绕扣面板处）

Counter display: counting the current quantity

How to clear the counter to 0: Click on the counter display area, then press and hold the start switch (The switch is on the buckle panel)

3.2 绕扣模式设置

Wrapping mode settings



 P1模式：平扣模式，为机器出厂默认模式。

Flat buckle wrapping mode

 P2模式：立扣绕脚模式，通常使用蘑菇扣类型。

Stand buckle wrapping mode

 P3模式：高扣模式，纽扣距离衣服不低于8mm。

High buckle mode

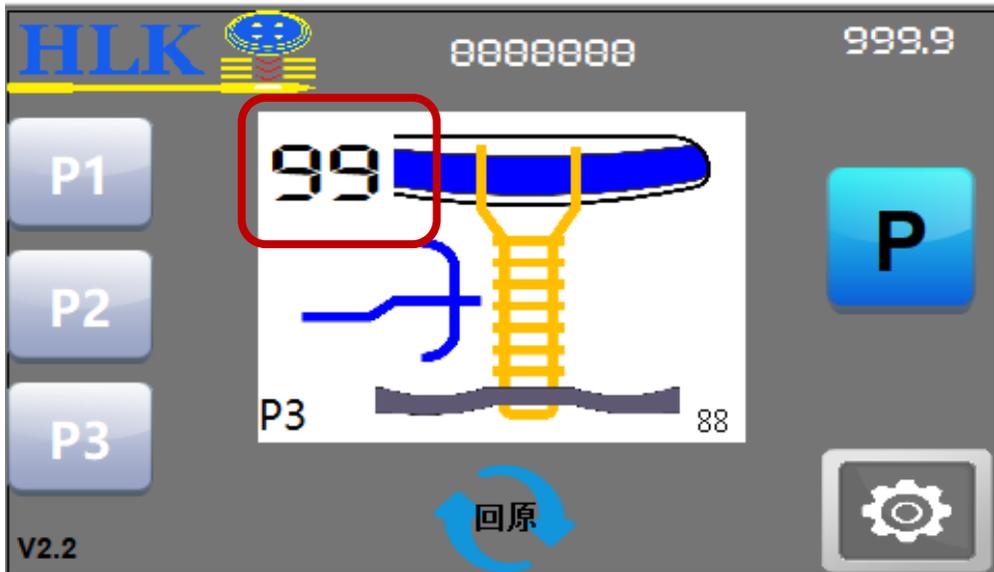
模式参考

- P1 平扣绕脚 
- P2 立扣绕脚 
- P3 高扣绕脚 

绕脚长度（绕之前）	绕圈数	纽扣类型
2.5-6 mm	6-15	
6-10 mm	12-20	
9-15 mm	25-30	

3.3 绕扣圈数设定

Setting the number of winding turns



按 圈数 键设定绕扣圈数，可根据工艺的需求来设定绕扣的圈数，
~~按 圈数 键可直接输入想要的圈数。

Press the number of turns key to set the number of turns of the buckle. The number of turns of the buckle can be set according to the needs of the process. ~~Press the number of turns key to directly input the desired number of turns.

圈数参考

- 01 平扣绕脚 
- 02 高扣绕脚 
- 03 立扣绕脚 

绕脚长度（绕之前）	绕圈数	纽扣类型
2.5-6 mm	6-15	I
6-10 mm	12-20	I
9-15 mm	25-30	I

3.4 温度显示 temperature display



显示当前温度，点击此处可以直接输入温度，（需权限）

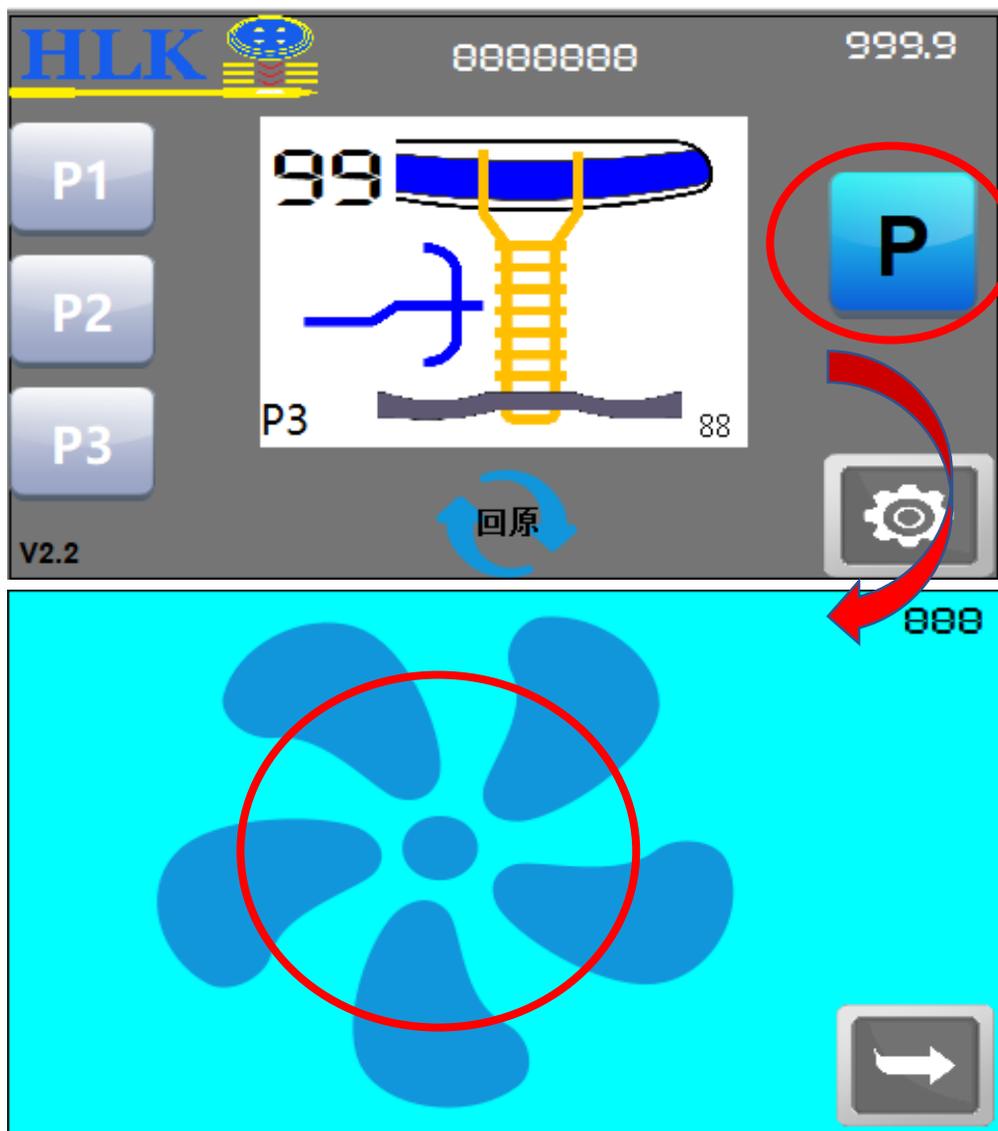
注：温度切勿调整过高，135°—160°温度最佳。

Displays the current temperature. Click here to enter the temperature directly (permission required)

Note: Do not adjust the temperature too high, 135°-160° is the best temperature.

3.5 穿线方法

Threading method



按 P键进入穿线模式，

按“吸风”键机器会自动把线吸进绕线管内，需手动把夹线器拉开，以便于把线顺利的吸进管内。

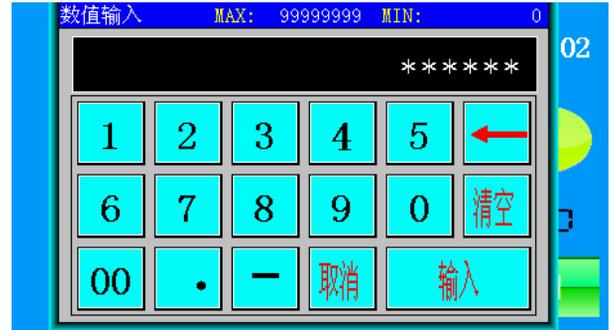
本机操作简单，易上手，不需特殊培训，直接操作即可。

Press the P key to enter threading mode.

Press the "Suction" button and the machine will automatically suck the thread into the bobbin tube. You need to manually pull the thread clamp open so that the thread can be smoothly sucked into the tube.

4. 系统设置进入方法

General settings

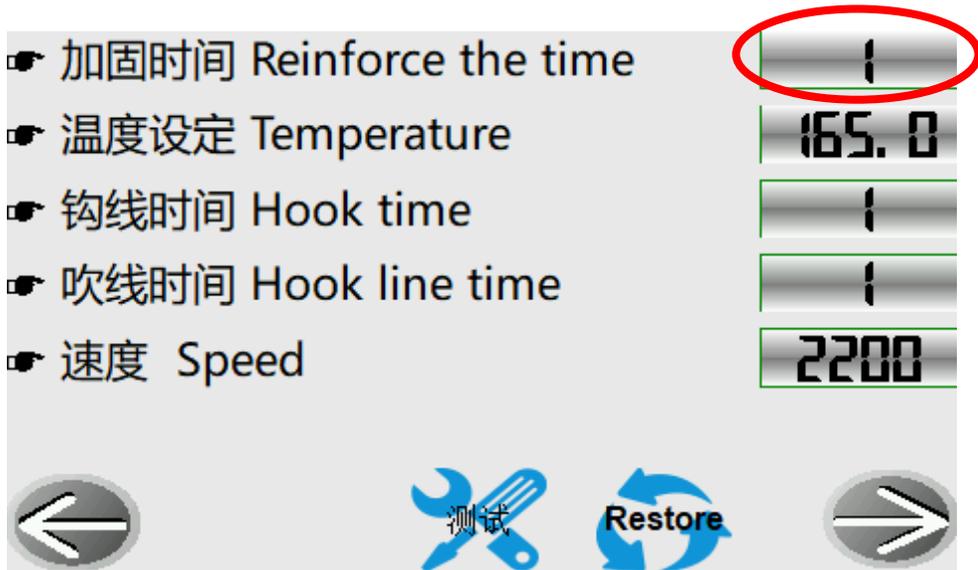


待机模式下长按参数键，输入密码666888进入常规设置,此密码仅供常规设置，最高权限密匙需向厂商索取。

In standby mode, long press the parameter key and enter the password 666888 to enter the general settings. This password is only for general settings. The highest authority key must be obtained from the manufacturer.

4.1 剪刀加热时间设置

Scissor heating time setting



点击加热时间的数字处可直接输入数字，根据剪刀加热的程度调整剪刀延时加热时间

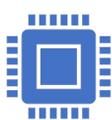
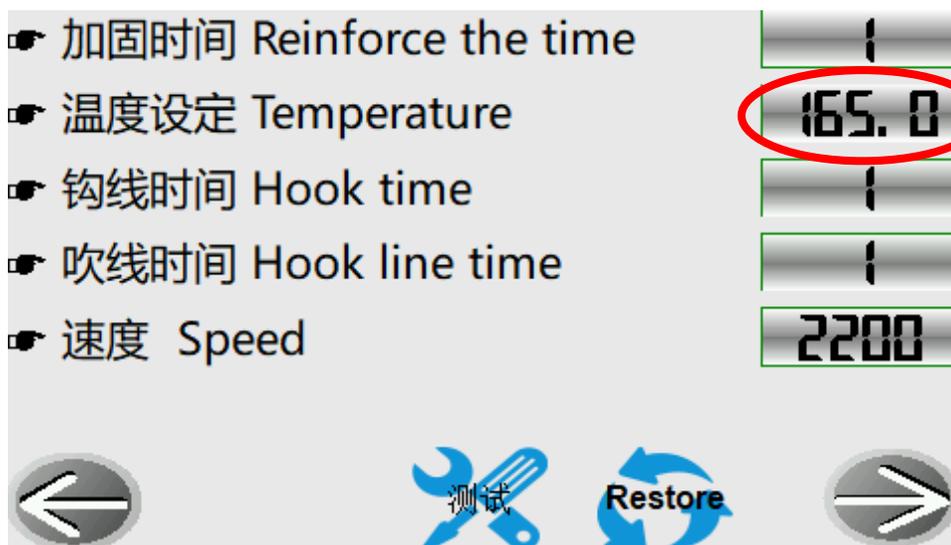
注意：数值为1-5，出厂默认为1，可根据加热程度，适当调整加大!!!

Click on the number of the heating time to directly enter the number and adjust the scissors delay heating time according to the degree of heating of the scissors.

Note: The value is 1-5, and the factory default is 1. It can be adjusted appropriately according to the degree of heating!!!

4.2 温度设置

temperature setting



点击温度设置处的数字，可直接输入温度数值，本机已预设好最佳温度，如需更改温度设置，请参考在135-170度左右，切勿设置温度过高，以免损坏衣服。

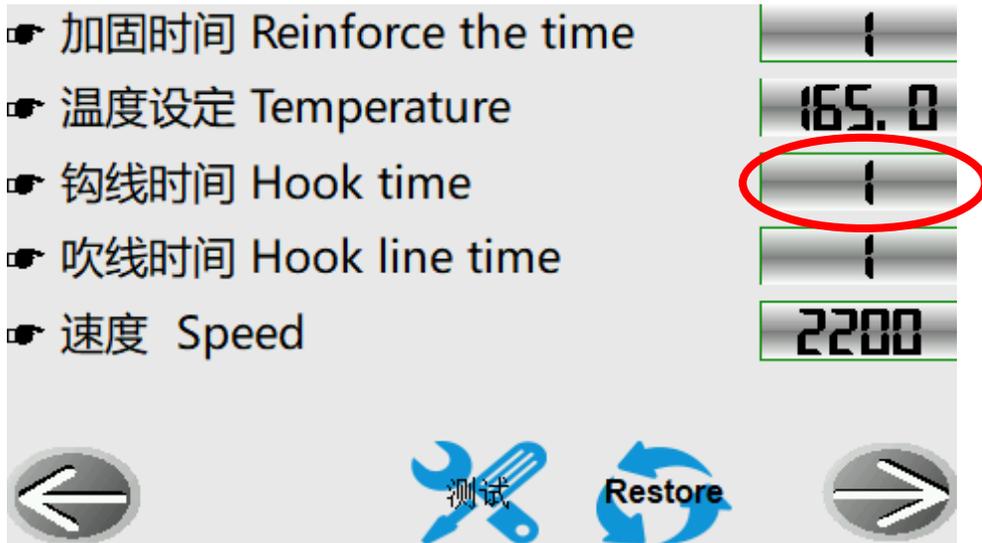
注意：为保证衣服的损坏，本机已把最高温度限制在190度。

Click the number at the temperature setting to directly enter the temperature value. The machine has preset the optimal temperature. If you need to change the temperature setting, please refer to around 135-170 degrees. Do not set the temperature too high to avoid damaging the clothes.

Note: To prevent damage to clothes, this machine has limited the maximum temperature to 190 degrees.

4.3 钩线时间设定

Hook thread time setting



钩线提前只限于在拉线钩，钩不住线的时使用，数值设置过大时，钩线时间越早，本机在出厂时已按常规预设圈数调整最佳状态，无需更改。

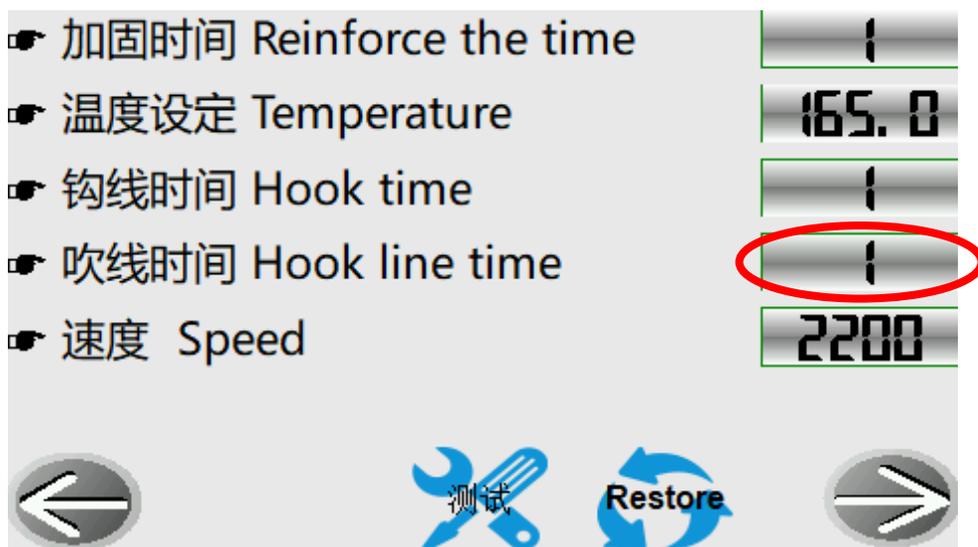
注意：机器在出厂时已把此功能设置在最佳状态，此参数只供技术员调试使用，非专业人员，误修改此参数值。

The thread hooking advance is only used when the thread hook cannot catch the thread. When the value is set too large, the hooking time will be earlier. This machine has been adjusted to the best state according to the conventional preset number of turns when it leaves the factory and does not need to be changed.

Note: This function has been set in the best state when the machine leaves the factory. This parameter is only for technicians to debug. Non-professionals may modify this parameter value by mistake.

4.4 吹线时间设定

Thread blowing time setting



吹线时间设定：此模式为拉线动作时，吹线头的清理时间长短，默认为：2

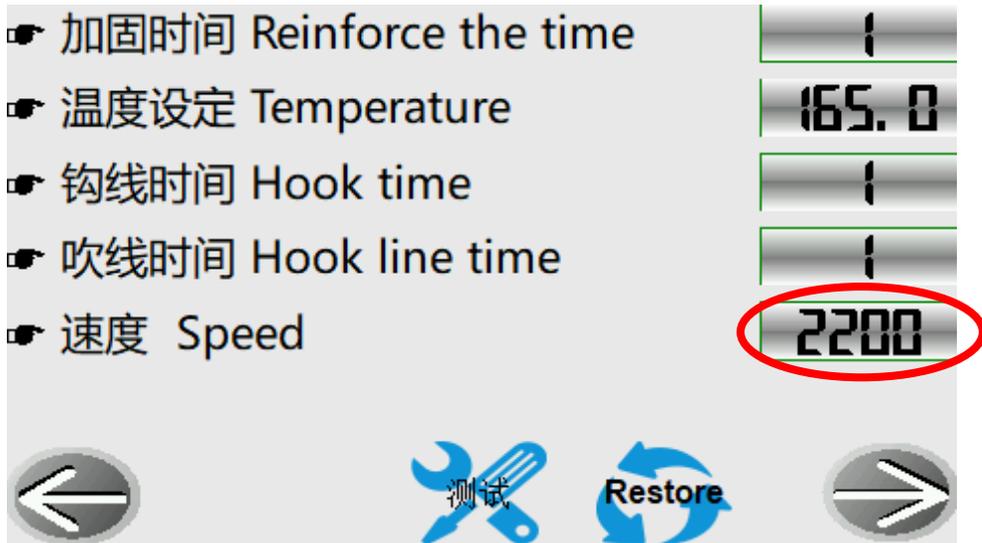
注意：机器在出厂时已把此功能设置在最佳状态，此参数只供技术员调试使用，非专业人员，误修改此参数值。

Thread blowing time setting: When this mode is the thread pulling action, the length of time for cleaning the thread blowing end, the default is: 2

Note: This function has been set in the best state when the machine leaves the factory. This parameter is only for technicians to debug. Non-professionals may modify this parameter value by mistake.

4.5 速度设定

Speed setting



速度设定：根据线质拉力不同，在线质差的情况下，尽可能速度降低。

注意：机器在出厂时已把此功能设置在最佳状态，此参数只供技术员调试使用，非专业人员，误修改此参数值。

Speed setting: According to the different tension of the thread quality, if the thread quality is poor, the speed should be reduced as much as possible.

Note: This function has been set in the best state when the machine leaves the factory. This parameter is only for technicians to debug. Non-professionals may modify this parameter value by mistake.

5.检测模式-剪刀架 Detection Mode-Scissor Holder

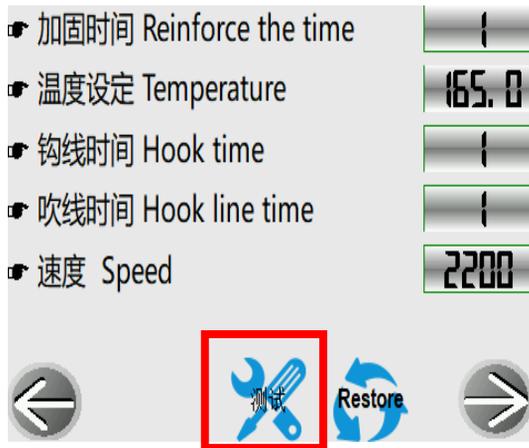


图1

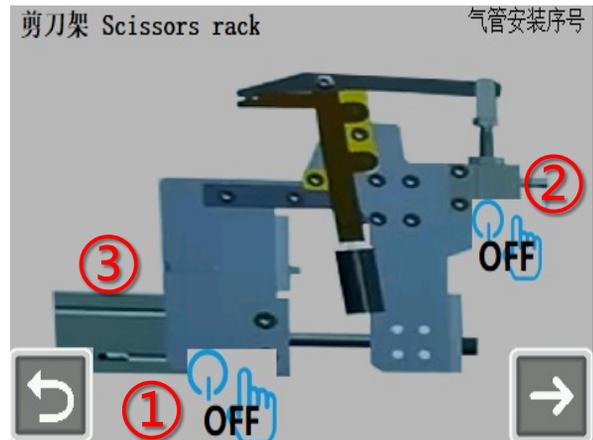


图2

点击检测模式图标进入检测模式，进入图二界面，点击图2中的①为剪刀架气缸，②剪刀合并气缸，（点击此位置气缸才会有动作）点击①的位置剪刀会伸出来，同时图2中③的位置会显示剪刀传感器指示灯亮起，则表明剪刀气缸和剪刀电磁阀正常，点击图2中①或②的如果剪刀架/剪刀合并无动作，则表明气缸/电磁阀有问题，需更换电磁阀/气缸。

Click the detection mode icon to enter the detection mode and enter the interface in Figure 2. Click ① in Figure 2 to represent the scissor holder cylinder, and ② the scissors merge into the cylinder. (The cylinder will move only when you click this position.) Click ① and the scissors will extend. At the same time, the picture The position of ③ in 2 will show that the scissor sensor indicator light is on, which means that the scissor cylinder and scissor solenoid valve are normal. Click ① or ② in Figure 2. If the scissor holder/scissors are combined and there is no action, it means that there is a problem with the cylinder/solenoid valve. You need to Replace solenoid valve/cylinder.

5.检测模式-拉线架

Detection mode-cable rack

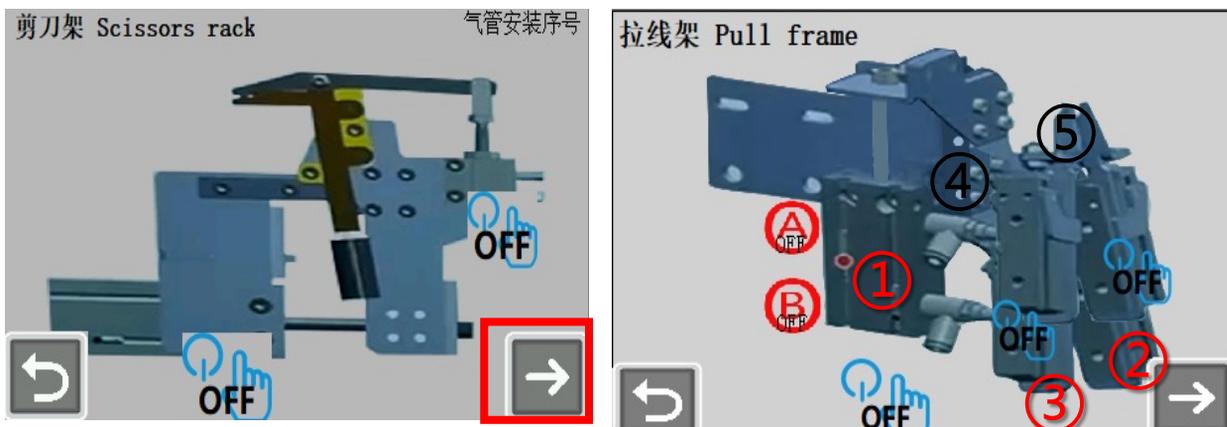


图1

图2

点击  进入下一页 拉线架测试 点击图2中 ①-②-③

① 拉线架气缸

② 拉线 L 气缸

③ 拉线 R 气缸

点击图2中的任意数字，气缸会伸缩动作，按需要测试的气缸点击图2中相应的数字。

图2中的④⑤处为拉线架气缸感应器，在无操作情况下④传感器为显示（ON），按下①

按钮，⑤传感器显示（ON）

如果剪刀架/剪刀合并无动作，则表明气缸/电磁阀有问题，需更换电磁阀/气缸。

Click to enter the next page. Cable frame test. Click ①- ②-③ in Figure 2.

① Cable stand cylinder

② Cable L cylinder

③ Cable R cylinder

Click any number in Figure 2, the cylinder will expand and contract. Click the corresponding number in Figure 2 according to the cylinder that needs to be tested.

④⑤ in Figure 2 is the cable frame cylinder sensor. When there is no operation, the ④ sensor is displayed (ON). Press ①

button, ⑤ sensor display (ON)

If the scissor holder/scissor combination does not move, it indicates that there is a problem with the cylinder/solenoid valve and the solenoid valve/cylinder needs to be replaced.

5.检测模式-电机架

Detection mode-motor frame

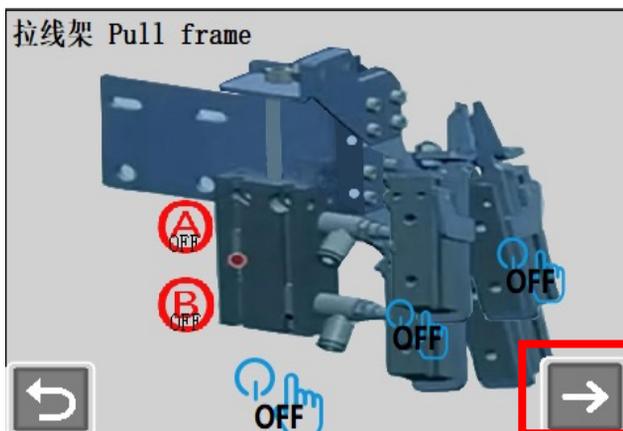


图1

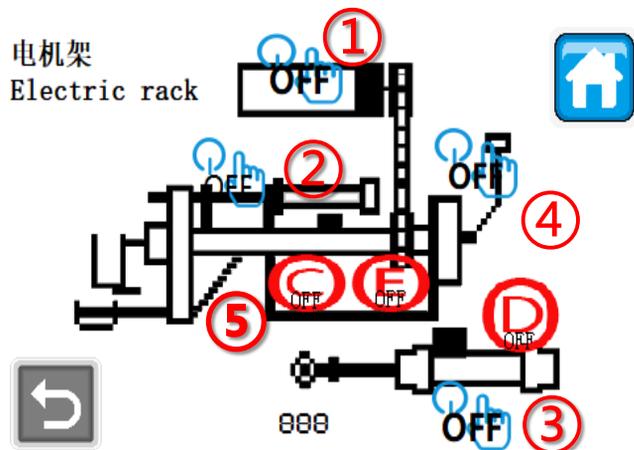


图2

点击  进入下一页 电机架测试 点击图2中 ①-②-③-④

① 电机正 / 反转测试

② 拉扣气缸

③ 电机架前后气缸

④ 穿线气缸

点击图2中的任意数字，气缸会伸缩动作，按需要测试的气缸点击图2中相应的数字。

图2中的 ⑤ 处为主轴0位感应器，在无操作情况下 ⑤ 传感器为显示 (ON)，交替2次按下①

电机正 / 反转测试按钮，⑤ 传感器会 (OFF-ON)交替显示，表明⑤ 感应器正常。

Click to enter the next page Motor rack test Click ①-②-③-④ in Figure 2

① Motor forward/reverse rotation test

② Pull button cylinder

③ Motor frame front and rear cylinders

④ Threading cylinder

Click any number in Figure 2, the cylinder will expand and contract. Click the corresponding number in Figure 2 according to the cylinder that needs to be tested.

⑤ in Figure 2 is the spindle 0-position sensor. When there is no operation, the ⑤ sensor is displayed (ON). Press ① twice alternately.

Press the motor forward/reverse test button, and the ⑤ sensor will display (OFF-ON) alternately, indicating that the ⑤ sensor is normal.

6.恢复出厂设置 Reset



点击 reset 键2次，机器参数会恢复到出厂默认参数值。

Click the reset button twice and the machine parameters will be restored to the factory default parameter values.

报警信息一览表

故障号	故障名称	复位方法
E01	加热温度过低	1.请稍后加热温度未到达设定温度, 2.检查温度感应器 3.更换感应器
E02	剪刀架F 感应器报警00	1.剪刀架没有返回, 检查气压是否满足在4.5BAR 2.剪刀架没有复位 3.进入检测模式测试感应器是否亮灯 4.更换感应器
E03	D 感应器报警	1.检查气压是否满足在4.5BAR 2.进入检测模式测试感应器是否亮灯 3.更换感应器
E04	拉线架A感应器报警	1.拉线架没有返回到位, 检查气压是否满足在4.5BAR 2.进入检测模式测试感应器是否亮灯 3.更换感应器
E05	拉线架B感应器报警	1.拉线架没有返回到位, 检查气压是否满足在4.5BAR 2.进入检测模式测试感应器是否亮灯 3.更换感应器
E06	温度感应器异常	1.检查感应器链接 2.更换温度感应器
E07	剪刀架F感应器报警01	1.检查气压是否满足在4.5BAR 2.剪刀架向左伸出是否到位 3.进入检测模式测试感应器是否亮灯 4.更换感应器
E08		
E09	拉线架B 感应器报警	1.检查气压是否满足在4.5BAR 2.拉线架下拉是否到位 3.进入检测模式测试感应器是否亮灯 4.更换感应器
E10	主轴C 感应器报警	1.关机重启, 机器自动检测回原点 2.待机状态下 C 感应器亮灯, 如果感应器灯不亮, 请更换感应器。

問題	原因	解決方法
按了開關制但機器沒有開動	電源沒接上機器 沒有電 開關制壞了 馬達壞了或沒有馬達 齒輪箱, 帶子等堵住了 光電管壞了	檢查電源和主發熱絲 檢查是否24v電源 通過輸入檢查檢查開關制 檢查馬達和是否24v馬達 檢查機器是否自由旋轉 檢查光電管和它的接駁
鈎沒有拿到線	馬達停在錯誤位置 鈎損壞了或停在錯誤位置	檢查指示器的設置 (拉线延时设定) 檢查鈎的設置
纏繞中途線斷了	供線太緊 管邊太鋒利, 蓋或鈎太緊	檢查線軸和拉線 除去所有鋒利的邊和做潤滑
在最後一轉的盤纏時鈎拿不到線	線管停在錯誤位置 鈎沒有正確地夾住線 多餘的線沒被除掉	檢查鈎的狀態和設置 清理鈎, 檢查下開關制位置和縮喉管狀況/設置 檢查設定和重新調整
線沒有束緊或留下線尾	熱叉設置不正確 熱叉污穢或磨損 最後的纏繞沒有到鞭碟那裏 (只可能發生在可調的長腳程式) 鈎的機組下得太快	清理熱叉/更換損磨的 調整纏繞次數或用倒退程式 重新調整
線的纏繞不夠緊	鬆緊裝置磨損了或安裝得不正確 鬆緊裝置彎曲了所以施不到壓在指定點 拉線不流暢	檢查鬆緊裝置的狀況; 如有需要便更換新的。正確安裝。 檢查鬆緊裝置的角度在90° C角。弄彎至合適角度數或更換一個新的。 檢查線軸和回捲線

problem	the reason	Solution
<p>Pressed the switch system but the machine did not start</p>	<p>The power is not connected to the machine</p> <p>No electricity</p> <p>The switch is broken</p> <p>The motor is broken or there is no motor</p> <p>Gearbox, belt, etc. blocked</p> <p>Photocell is broken</p>	<p>Check the power supply and the main heating wire</p> <p>Check if 24v power supply</p> <p>Check the switch by input check</p> <p>Check motor and 24v motor</p> <p>Check if the machine is spinning freely</p> <p>Check the photocell and its connection</p>
<p>Hook did not get the line</p>	<p>The motor stops at the wrong position</p> <p>The hook is damaged or stopped in the wrong position</p>	<p>Check indicator settings (pull delay setting)</p> <p>Check hook settings</p>
<p>Broken midway line broken</p>	<p>Supply line is too tight</p> <p>The pipe edge is too sharp, the cover or hook is too tight</p>	<p>Check spools and pull wires</p> <p>Remove all sharp edges and make lubrication</p>
<p>The hook can't get the line when the last turn</p>	<p>The line tube stops at the wrong position</p> <p>The hook does not hold the line correctly</p> <p>The extra line has not been removed</p>	<p>Check the status and settings of the hook</p> <p>Clean the hook, check the switch position and the hose condition/setting</p> <p>Check settings and readjust</p>
<p>The line is not tight or leaves the end of the line</p>	<p>Hot fork setting is incorrect</p> <p>Hot fork dirty or worn</p> <p>The last entanglement is not there to the whip (only possible in the adjustable long-legged program)</p> <p>The hooked unit is going too fast</p>	<p>Clean the hot fork / replace the damaged</p> <p>Adjust the number of windings or use the rewind program</p> <p>readjust</p>
<p>The winding of the thread is not tight enough</p>	<p>The elastic device is worn out or installed incorrectly</p> <p>The elastic device is bent so that it cannot be pressed at the specified point.</p> <p>The cable is not smooth</p>	<p>Check the condition of the tensioning device; replace it if necessary. Install correctly .</p> <p>Check the angle of the elastic device at an angle of 90 ° C. Bend to the right angle or replace it with a new one.</p> <p>Check spool and rewind line</p>

List of Warning

Code	Name	Release Method
E01	Heating temperature is too low	<ol style="list-style-type: none"> 1. Please wait until the heating temperature does not reach the set temperature, 2. Check the temperature sensor 3. Replace the sensor
E02	F sensor alarm	<ol style="list-style-type: none"> 1. The scissor holder does not return, check whether the air pressure is 4.5BAR 2. The scissor frame is not reset 3. Enter the detection mode to test whether the sensor lights up 4. Replace the sensor
E03	D sensor alarm	<ol style="list-style-type: none"> 1. Check whether the air pressure is within 4.5BAR 2. Enter the detection mode to test whether the sensor lights up 3. Replace the sensor
E04	A sensor alarm	<ol style="list-style-type: none"> 1. The cable rack has not returned to the position, check whether the air pressure is 4.5BAR
E05	B sensor alarm	<ol style="list-style-type: none"> 2. Enter the detection mode to test whether the sensor lights up 3. Replace the sensor
E06	The temperature sensor is abnormal	<ol style="list-style-type: none"> 1. Check the sensor link 2. Replace the temperature sensor
E07	Scissor frame F sensor alarm 01	<ol style="list-style-type: none"> 1. Check whether the air pressure is within 4.5BAR 2. Is the scissors frame extending to the left in place? 3. Enter the detection mode to test whether the sensor lights up 4. Replace the sensor

Code	Name	Release Method
E08		
E09	Cable frame B sensor alarm	<ol style="list-style-type: none"> 1. Check whether the air pressure is within 4.5BAR 2. Whether the pull-down frame is in place 3. Enter the detection mode to test whether the sensor lights up 4. Replace the sensor
E10	C sensor alarm	<ol style="list-style-type: none"> 1. Shut down and restart, the machine automatically detects and returns to the origin 2. In the standby state, the C sensor lights up. If the sensor light does not light up, please replace the sensor.



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