

6200 Covered cloth buttons machine

User Operational Instructions

Version: V01

Thank you very much for using our Product . For your safety and correct use. Please read this instruction carefully before operation. if find problems or better suggestions. Please contact us. So that we can modify it as soon as passable. The manual maybe updataed by anytime.thanks.

Distributed By:



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Notes

1. Please Read this manual carefully before operating the Machine. And strictly abide by this regulation.
2. The operator must know the knowledge of safety production and be qualified in training before operating the machine
3. Before power on, the operator must check the machine state, Make sure no waste around of sensor, keep the work table clear
4. Before the machine run,must check start switch sensor position block is no problem(can see the sensor state LED) ,make sure block size less then 3mm between the up mold and down mold.then Multiple operations confirm the sensor is normal.
5. In the process of operation, if there is a big noise, must be stop working, and report to the administrator. After clearing the fault, you can continue to work.
6. Only the professional personnel can installation or debugging Mold,must be test pass then can to use work.
7. When the mold is replaced, the position of the start-up sensor must be adjusted strictly by pressing "mold installation and debugging".
8. In the process of operation,No smoking! No play game! No Fatigue operation! No drink !
9. After the stamping is started, it is strictly forbidden to put hands or other parts of the body into the dangerous area (especially after the stamping is started, it is forbidden to enter the dangerous area by artificially righting the workpiece).
10. Auxiliary tools (special tweezers, hooks, suction cups or feeding and receiving mechanism) should be selected for small parts processing. When the die is stuck, only tools are allowed to release and take out the blank.
11. Only one operator, disable many operator to operating
12. Do not wear gloves to operate the equipment
13. The machine must be to connect the grounded.
14. Must turn off system power,when repair or change mold.
15. The foot must be off the pedal,after operating for every time.
16. When leaving or work end, the machine must be turn off the power
17. After work end,please keep work table clear and save tools
18. In order to ensure the safety of the operator, it is forbidden to interfere with the sensor trigger function of the pedal artificially.

Maintenance items

- 1、 Weekly must cleaned mold around and machine fixed seat。
- 2、 Weekly must add some oil of stamping axis.
- 3、 Add some oil for stamping shaft and gear, when worked more then one million

Important note:

If you do not follow the above contents to operate and maintain the machine, our company will not be responsible for the problems caused

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1、 Safety caution

- 1.1 Users must thoroughly and carefully read this manual before installing and using the product.
- 1.2 Use power voltage indicated on the nameplate of the control box in $\pm 10\%$ Ranges.
- 1.3 To avoid the false operation, please keep the product away from the high electromagnetic machinery or electro pulse generator.
- 1.4 Temperature & humidity :
- a. Please operate the motor at the temperature Form 5°C to 45°C .
 - b. Please do not work under the direct sun light or outdoor.
 - c. Don't operate near the heater.
 - d. Please keep the room humidity in the range of 30%~95%
 - e. sea level less then 1000 meters
- 1.5 make sure the protect grounding is no problem.
- 1.6 For the safety protection, it is recommend to install the Residual Current Breaker/Relay.
- 1.7 When the user leaves the sewing machine or sewing machine is not going to be used for a time, in order to prevent accidents caused by sudden start, please make sure the power switch is turned off.
- 1.8 All spare parts for repair must be approved or supplied by the manufacturer.
- 1.9 High voltage in control box! After the power is turned off, wait for at least 10 minutes before opening the control box cover.
- 1.10 Maintenance and repairs must be done by the specially trained personnel.
- 1.11 When the machine punches, the output torque of the servo motor is very large. Any part of the body under the punch is likely to suffer perforation or comminuted injury.
- 1.12 When installing and debugging the machine, only one person is allowed to operate it. Avoid the safety accidents caused by the uncoordinated operation of many people!



- 1.13 When the  icon Twinkle, no fingers or other parts of the body are allowed to enter the stamping area.

- 1.14 Danger prompt



This symbol indicates the caution on installation, risks that may cause Personal injury or risk to the machine.

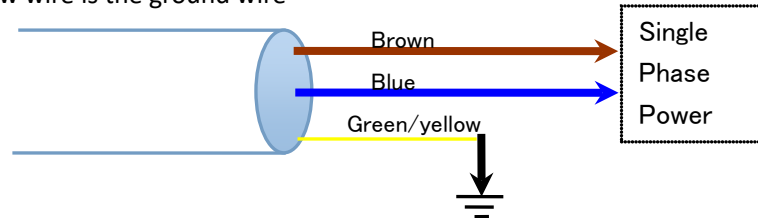


This symbol indicates a high voltage area or electrical risks and warnings.

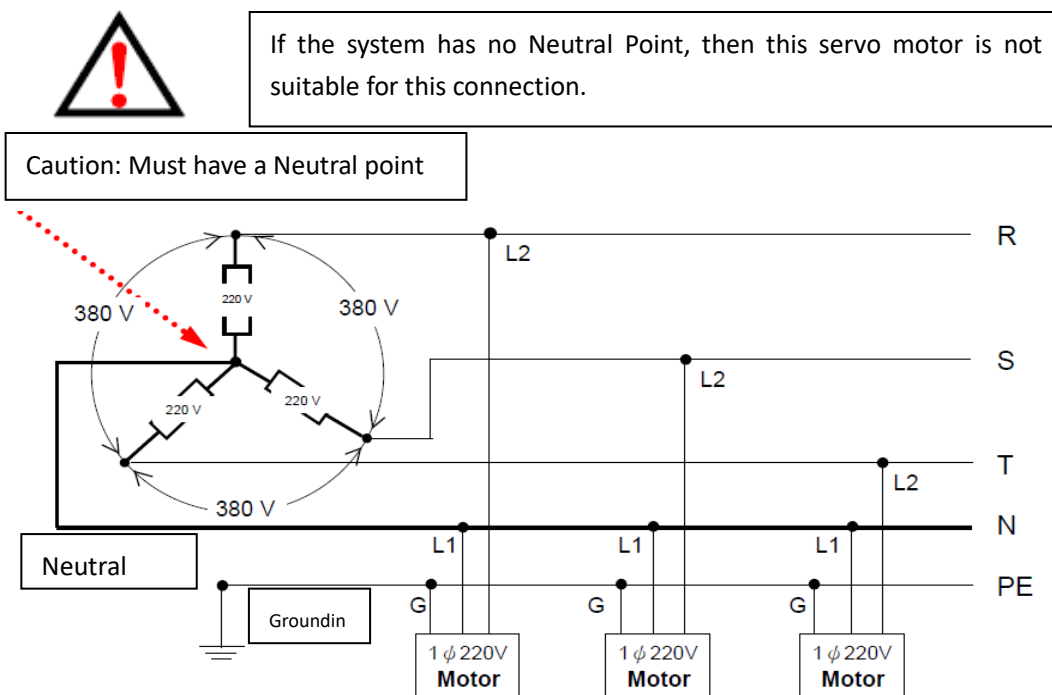
2、Power Connection and Grounding

2.1 Single phase connection

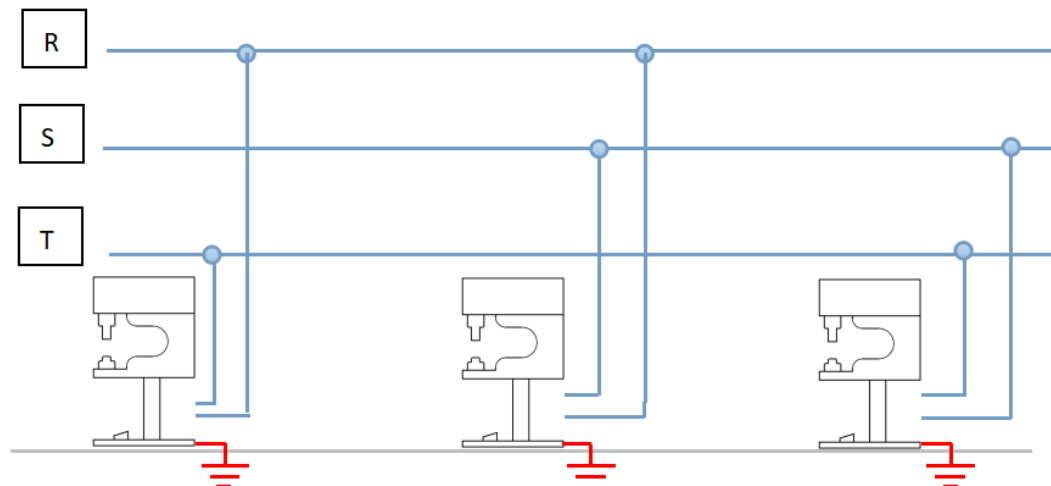
Green/yellow wire is the ground wire



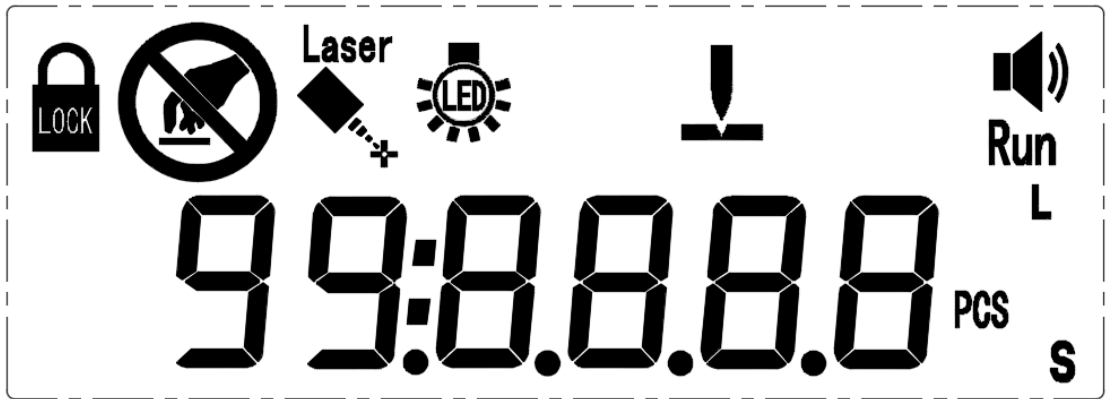
2.2 How to connect a 1 Φ / 220 V power from a 3 Φ / 380 V power source



2.3 The load balance when use a 1phase 220V motor in a 3phases 220V power supply. See the following picture for the load balance



3、Display description



Icon	Icon description	Operation method
	Child lock function. In this mode, all key are invalid. until Unlock key operation can be accept	Long press key, can be unlock
	if This icon show,means the motor is standby,No hand to enter the stamping area.	
	if This icon show,means the laser is output	
	if This icon show,means the LED is output	
	if This icon show,means the system is debugging operation (size debug function)	
	if This icon show,means the speak output is enable	
	if This icon show,means the motor is running	
	if This icon show,means the top start sensor is activation	
	The icon is Counting unit	

	if This icon show,means the bottom start sensor is activation	
	the two digits before the  ,means the current stamping stroke gear.	
	Following the  four digits means the current workpiece count	

workpiece count Explain:

Display quantity	Data explanation
	As shown in the figure: The current stamping stroke gear is 99. The current workpiece count is 9999
	As shown in the figure: The current stamping stroke gear is 99. The current workpiece count is 19999(Every decimal point means workpiece count added is 10,000)
	As shown in the figure: The current stamping stroke gear is 99. The current workpiece count is 49999 (the maximum number of workpiece count is 49999, if more the number, system will Automatic clearing). In the process, the  key can be cleared.

4、Keynote description

Key icon	Function description	Operation instructions
	In normal mode, increase of adjusting stamping stroke gear In parameter adjustment mode, adjust the serial number of parameters	
	In normal mode, decrease of adjusting stamping stroke gear In parameter adjustment mode, adjust the serial number of parameters	
	Safety Mode for Position Detection of Up and Down Start Sensors In this mode, the sensor is triggered up or down, and the motor will not run. Only used to adjust the position of up and down start sensor	 always Twinkle 。 L and S Display by actual signal induction
	Long press can entry the parameters adjustment mode. In the parameter adjustment mode, first trigger the key can stored data to Eeprom. second trigger the key will exit current mode	
	In normal mode, long press the key can clear workpiece count. in Parametric Adjustment Mode, The key can Increase one Thousand.	
	In normal mode, increase of LED brightness in Parametric Adjustment Mode, The key can Increase One hundred.	
	In normal mode, increase of laser brightness in Parametric Adjustment Mode, The key can Increase ten.	
	In normal mode, increase of motor run speed. in Parametric Adjustment Mode, The key can Increase	
	Long press can entry the height adjustment mode. in Parametric Adjustment Mode,	

	The key can decrease one Thousand.	
LED- 照明- 	In normal mode, decrease of LED brightness in Parametric Adjustment Mode, The key can decrease One hundred.	
LASER- 激光- 	In normal mode, decrease of laser brightness in Parametric Adjustment Mode, The key can decrease ten.	
SPEED- 速度- 	In normal mode, decrease of motor run speed. in Parametric Adjustment Mode, The key can decrease	

5、 mold Installation and Debugging (Automatic Adjustment)

installed or replaced the mold, must adjusted the height position

When the mold installed ok, then turn on the power supply

MODE
long Press the 自动调模 key. The system will enter the automatic mode adjustment mode. The

 " icon will display. At the same time, the  icon will flicker quickly. In the lower left corner of the display screen, three numbers "000" are displayed, means that the current stamping stroke gear is zero.

MODE **MODE**
always hold press the 自动调模 key or click 自动调模 key, the motor will run step by step downward. When the position of the mold is touched, the system will automatically return to the top stop position. The system will automatically record the bottom position.

In automatic mode adjustment mode, If you want to exit adjust mode. always press **清零** **ZERO** key can exit automatic mode adjustment mode. and motor will run to the top stop position

Manual Adjustment of Stamping Height

when the automatic mode adjustment finish, you can try to stamp a sample, if sample is not ok. try adjustment Stamping height by Manual. use the key ▲ and ▼, can adjustment. When "SW= XX" is displayed, it can also be quickly adjusted by "⊕", "⊖".

6、Parameter Adjustment and Parameters Table

Long press  key, enter the parameter adjustment mode. Use  、  key can change The serial number of parameters. The  、  key can modify the data value of the parameters. After the modification is completed, press  key to stored, then the display value will flickers twice, prompting the user that the data is being stored.

序号	名称	最小值	最大值	默认值
0	BZ_SW	0	9	5
3	LED_VOL	0	9	5
4	LASER_VOL	0	9	5
5	BL_VOL	1	7	6
6	MTR_SPEED	0	9	0
7	MTR_SW	0	99	20
16	Left position S1	0	1400	400
17	Right position S2	0	1400	500
18	Middle position S3	0	1400	400
19	Middle position stamping switch S3	0	1	0
20	CH_LOCK	0	1	0

7、The mold position Adjustment of Covered cloth buttons

Note:

turning on the power, follow the voice prompts to complete all self check actions. Before operation, please ensure that there are no items stacked on the left and right sides of the mobile platform.

Calibration of the left buttons position:

- 1、pressing the  button more then 2 seconed, system will into the position calibration

mode. Lcd Display “ MTR-INI ”, then the buttons mold fix movable platform will run to zero position.

2、 After the find zero position is completed, will be displayed S1-XXXX, where XXXX represents the current sensor position value.

3、 At this time, can move the buttons mold fix movable platform to left slide by hand. make sure the buttons mold Under the stamping mold.

4、 motor spindle Slowly lower by pressing the  button head.make sure the buttons mold and stamping mold is coincide by your eyes observe.if no coincide can move the buttons mold fix movable platform by hand.

5、 Press the M key once. stamping motor will slowly down to the bottom, completing the inspection of the mold depth.then stamping motor will slowly up to stop position.

6、 Press the OK button again to store the coordinate data and pressing depth data of the current position. The display will flash twice, indicating that it has been stored

Calibration of the right buttons position:

1、 follow the above operation, system will be displayed S2-XXXX, where XXXX represents the current sensor position value.

3、 At this time, can move the buttons mold fix movable platform to left slide by hand. make sure the buttons mold Under the stamping mold.

4、 motor spindle Slowly lower by pressing the  button head.make sure the buttons mold and stamping mold is coincide by your eyes observe.if no coincide can move the buttons mold fix movable platform by hand.

6、 Press the M key once. stamping motor will slowly down to the bottom, completing the inspection of the mold depth.then stamping motor will slowly up to stop position.

7、 Press the OK button again to store the coordinate data and pressing depth data of the current position. The display will flash twice, indicating that it has been stored

8、 the buttons mold fix movable platform will run to zero position. Calibration finish.

8、 One key to reset factory setting

If user want restore all parameters to factory setting.method is as follows:

清零

Before power-on, hold press the **ZERO** button, release the key, then display "--", wait this display finish. All parameters already restored to factory setting.

9、Error list

code	Error Explain	Repair method
E1	Hardware overcurrent	1. maybe the motor connect line is short 2. Re-energize and see if the fault can be removed.
E2	Undervoltage of AC in	Check the current supply voltage of the electronic control box. is below 180V AC voltage?
E3	Power adapter overvoltage	Check the current supply voltage of the electronic control box. Is more than 260V AC voltage?
E4	Unconnected fault of motor power line	Check the motor power line maybe loose
E5	Main Board Data Memory Fault	If it can't be solved after restart, please contact the sales
E6	Start switch error	Check start board
E7	U sensor zero status error	If it can't be solved after restart, please contact the sales
E8	V sensor zero status error	If it can't be solved after restart, please contact the sales
E9	Motor overspeed error	If it can't be solved after restart, please contact the sales
E10	Encoder AB loost	Check motor encoder line maybe loose
E11	Encoder UVW error	Check motor encoder line maybe loose
E12	Encoder comunication error	Check motor encoder line maybe loose
E13	Encoder eeprom error	Check motor encoder line maybe loose
POW OFF	Power off Tips	

10、Comparing the Display Value of Seven-Section Digital Tube with the Actual Value

Digital part

Actual character	0	1	2	3	4	5	6	7	8	9
Display character	0	1	2	3	4	5	6	7	8	9

character part:

Actual character	A	B	C	D	E	F	G	H	I	J
Display character	A	b	C	d	E	F	G	H	I	J
Actual character	K	L	M	N	O	P	Q	R	S	T
Display character	K	L	M	N	O	P	Q	R	S	T
Actual character	U	V	W	X	Y	Z				
Display character	U	V	W	X	Y	Z				