



MA04G 全自动连续锁眼机
Automatic Buttonholes Indexer
对位精确的连续锁眼机
Accurate Buttonholes Alignment

目 录 Content

1 概述 Introduction.....	3
1.1 特征和应用 Features and Applications.....	3
1.2 使用建议 Using Recommendation	3
2 MA04G 全自动连续锁眼机介绍 Introduction of MA04G	4
2.1 设备规格 Machine Specifications.....	4
2.2 各部件名称 Name of Components.....	5
3 运输与拆包 Transportation and Unpacking.....	5
4 安装 Installation	6
4.1 显示屏和线架安装 Installation of Panel and Thread Stand.....	7
4.2 供电连接 Power Connection	7
4.3 气动系统连接 Pneumatic System Connection.....	8
4.3 其他安装操作 Other Installation Operation.....	8
5 操作 Operation	9
5.1 准备工作 Preparing Work.....	9
5.2 操作步骤 Operation Steps	10
6 操作模式 Operating Mode.....	11
6.1 主界面 The Main Interface.....	11
6.2 设置界面 Setting Interface.....	12
6.3 衣长编辑模式 Cloth Length Edit Mode	14
6.4 IO 测试界面 IO Test Interface	15
6.5 收料电机调试界面 Collecting Motor Debugging Interface.....	16
6.6 移料电机调试界面 Fabric Feeder Motor Debugging Interface	17
6.7 智能补扣界面 Smart Button Fill Interface.....	18
6.8 其他界面—应用参数界面 Other Interface—Application Parameter.....	19
6.9 报警及故障 Alarm and Fault Explanation.....	20
7 机器调试 Machine Debugging	22
7.1 移料机构长度调节 Feeding Mechanism Length Adjustment.....	22
7.2 收料机构长度与高度调节 Length and Height Adjustment of Collecting Mechanism	22
7.3 锁眼缝制参数调节 Adjustment of Button Sewing Parameter.....	23
8 维护 Maintenance	23
8.1 吸风口清洁 Suction Opening Cleaning	23
8.2 锁眼机维护 Sewing Head Maintenance	23
8.3 鼓风机故障 Blower Failure	23
8.4 维修翻转机头 Repair the Reverse Head	24
9 机头组装 Sewing Head Assembly.....	25
9.1 接油壶的安装位置 Installing Position of Oil Kettle.....	25
9.2 油盘安装位置 Installing Position of Oil Pan.....	26
9.3 机头安装 Installation of Sewing Head.....	27
9.4 机头电控箱与启缝装置安装 Installation of Control Box and Sewing Start Device	29
9.5 送扣装置安装 Installation of Button Feeding Device.....	29
9.6 机头感应器与送扣装置感应器的安装 Installation of Sensors of Head And Button Feeding Device.....	31
10 零件样本 Component Sample	34
11 电路图 Circuit Diagram.....	67

1 概述 Introduction

1.1 特征和应用 Features and Applications

MA04G 门襟自动锁眼机（简称“MA04G”）用于衬衫门襟的连续锁眼缝制，适用于大部分面料的门襟锁眼缝制，锁眼效果好，效率高，该设备标配一个缝制相关的程序控制显示平台，操作便捷。


在缝制过程中，缝制效果可通过修改参数实现，在缝制完成一片衬衫的门襟后，可自动完成收料，减少整理布料时间。整个缝制过程简便快捷，可一人操作多台机器。

MA04G Automatic Button Machine (in short "MA04G") is designed for continuous button attaching on shirt front plackets. It can be applied to most width of front plackets with perfect button attaching work and high efficiency. A standard display board is equipped to the machine in order to operate and control the sewing program conveniently.


In the sewing process, the sewing result can be achieved by modifying the parameters, after sewing a piece of shirt front placket, the fabric can be collected automatically, that helps reduce the time cost to tidy the fabric. The whole sewing process is convenient and fast, and one operator can operate multiple machines at the same time.

1.2 使用建议 Using Recommendation

MA04G 目前仅限于衬衫门襟的连续锁眼缝制，供应商不承担由于错误使用本机而造成的人员或财产损失!

这个符号  用于说明某个场景对操作者安全健康存在风险和危险，需特别注意。MA04G 配备有带机针的缝纫机头带压布功能的移料机构及压料机构、带吸风的宽度调节机构、带摆料杆的收料机构等，工作人员在操作机器时需特别注意!

MA04G is currently limited to button attaching on shirt front placket. The supplier shall not be liable for any loss or damage of personnel or property caused by the incorrect use of the machine!

This symbol  is used to indicate that a scenario poses a risk or hazard to the operator's safety and health and requires special attention. MA04G is equipped with sewing machine head with needle, vibration plate with button feeding and clamping device, fabric transfer and pressing mechanism with pressing function, fabric collecting mechanism with fabric swing rod, etc., operators need to pay special attention when operating the machine!

机器的特定的安全符号如下：

Specific Safety Symbols of the machine are as follows:



小心危险的电压 Watch out dangerous voltage



小心上部部件压伤 Watch out injury caused by upper part pressing



注意危险和驱动移动 Watch out danger and driver movement

如果没有注意到这些符号可能导致：

- 操作者的安全出现危险；Put Operator Safety in Danger
- 失去保修；Warranty Loss
- 制造商的免责。Manufacturer's liability exemption

在任何调节、更改或维护前，需要断电和断气。

Power outages and air outages are required prior to any adjustments, modifications, or maintenance.

MA04G 不可以暴露在雨和阳光等气候条件下。

The machine should not be exposed to weather conditions such as rain and sunshine.

2 MA04G 门襟自动锁眼机介绍 Introduction of MA04G

2.1 设备规格 Machine Specifications

表 2.1 MA04G 配置简介 Sheet 2.1 Machine Specifications

整机重量 Weight	265kg
机头 Head	1790G 锁眼机
使用机针 Needle	DP×5 11” ~ 14”
使用旋梭 Hook	DP 型全旋转旋梭
使用温度 Temperature	5℃~35℃
额定电压 Power	单相电压 220V±10%，Single phase
额定气压 Air pressure	0.6MPa
锁眼的数量（个） Buttonhole quantity	2-999
锁眼间距 Distance between buttonholes	35-550 mm
门襟的宽度(mm) Front placket width	20-45mm
门襟头到第一个锁眼起缝距离 Distance from the top of front placket to the first buttonhole	≥30mm
缝制长度范围(mm) Front piece length	≤660mm
自动锁眼程序存储数 Program saving	999
设备净尺寸 Machine measurement	长*宽*高（2150mm*880mm*1600mm）
整机净重 Net weight	235kg