

产品使用说明书

OPERATION MANUAL

节能绷缝机

POWER SAVING INTERLOCK MACHINE

安全须知

对于缝纫机本身各种装置，我们充分考虑到它的安全性。请遵照基本的操作方法，安全的进行工作。

●拆除为保证安全所设置的装置，零件的情况下使用，是非常危险的，请绝对不要拆除后使用。

●缝纫机在使用时，请不要在缝纫机台板上放置工具及缝纫时不必要的物品。

●在对缝纫机进行检查、修理、清扫等维护作业时，请关掉电源开关，将电源插头从插座上拔下，并确保跟踪缝纫机踏板也不会转动之后，再进行操作。

OBSEVE THESE SAFETY PRECAUTIONS

Though We takes the utmost care to produce safe sewing machines and devices, operators should follow these basic safety rules.

●To prevent accidents , do not remove safety devices or parts while operating the machine.

●Do not leave tools or other unnecessary objects on the machine table while operating the machine.

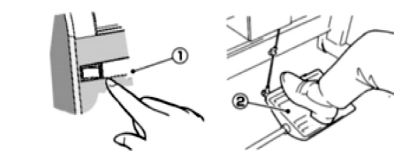
●Always turn off the power, unplug the machine and then make sure that the machine does not run by pressing the pedal before performing any maintenance, such as checking, repairing, cleaning, etc.

注意

使用离合式马达的情况下，在关掉电源①后因惯性作用会继续旋转。这时如不注意踩动缝纫机踏板②时，缝纫机会突然动作，这是很危险的。请在关掉电源后，仍继续踩动踏板②，直至缝纫机完全停下来为止。

Caution

A clutch motor keeps on running for a while by inertia after turning off the power① suddenly. If the machine pedal② is stepped on inadvertently , it is dangerous as the machine will start running unexpectedly. Keeping on stepping on the pedal② until the machine comes to a stop after turning off power suddenly.



- 在离开缝纫机台时，务必关掉电源。
- 停电时也请务必关掉电源。
- 为了总是安全地，运转良好的使用缝纫机，日常的点检是不可缺少的，请予以注意。

- Turn off the power before leaving the machine table.
- In the event of a power failure, be sure to turn off the power.
- Check that the machine is securely grounded.

缝纫机的清扫

缝纫机的清扫，以针板槽及送布牙周围为主。

Cleaning the machine

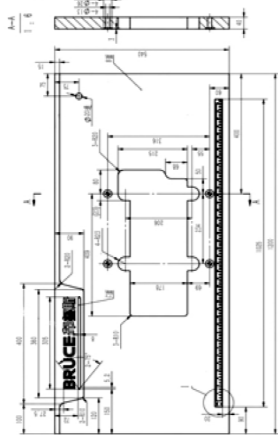
Mainly the slots of the needle plate and the feed rows should be cleaned.

台板加工图

Schematic diagram to the machine table

请参照下图进行台板的加工

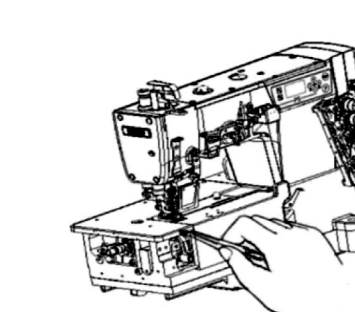
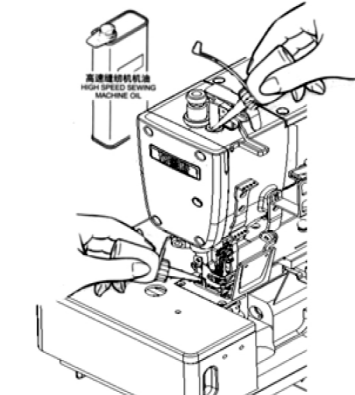
Cut the referring the diagram



手动给油 Manual lubrication

手动给油是在缝纫机最初开始使用时，或相当一段时间重新开始使用时，请给油2~3滴油。机油请使用本公司指定的 [HIGH SPEED SEWING MACHINE OIL] (ISO粘度与VG22相同)。

Supply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused for some time. Note: Use [HIGH SPEED SEWING MACHINE OIL] recommended por (ISO VG22)



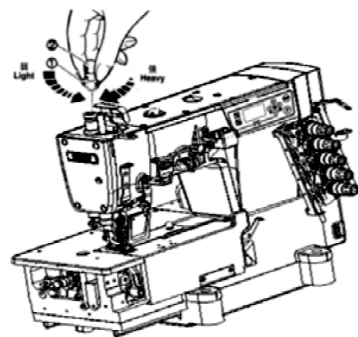
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压脚压力调节

压脚压力的调节是松开螺帽①和旋转螺丝②来进行的。在能获得平稳针脚的范围内，尽量调得松一些为好。

Adjusting the presser foot pressure

Loosen adjusting (1) nut and turn adjusting screw(2) to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.

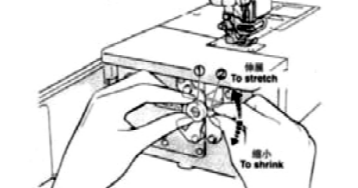


差动比的调节

差动比是通过松开螺帽①后，把调节杆②上下移动来进行调节的，调节后请拧紧螺帽①。

Adjusting the diff. feed ratio

Loosen nut (1) and move the lever up(2) and down to obtain the correct differential feed ratio then tighten nut (1).



针脚长度的调节

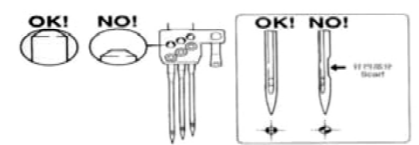
握住针距调节按钮，旋转手轮，针距调节按钮会陷入更深之处。这时边握住针距调节按钮，边转动手轮，使校准标记对准所希望的数值。针脚长度调节。注：针脚长度的调节

换针

- 1.准确辨认针的前后，请将针凹向着后方，即背向操作者进行安装。
- 2.针要牢固的插到孔的最深处。

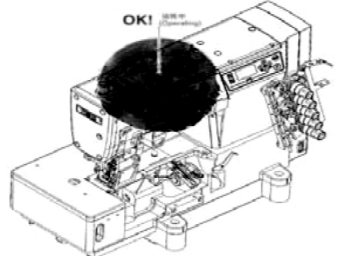
Replacing the needle

1. Check the needle carefully to see that the scarf is turned to the rear of the machine.
2. Insert the needle to the proper depth, and fasten securely.



检查机油的循环

Cleaning the oil circulation

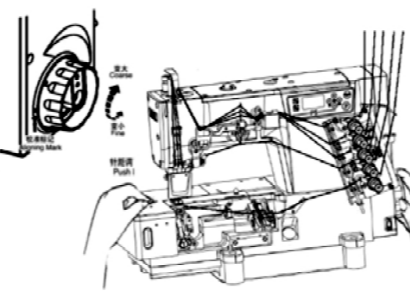


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务必请在调节差动比之后进行。

Adjusting the stitch length

While pressing the push button, turn the handwheel to seek the position at which the push button goes further into the depth. Then keeping the button pressed, turn the handwheel and set the desired scale to the aligning mark. Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.

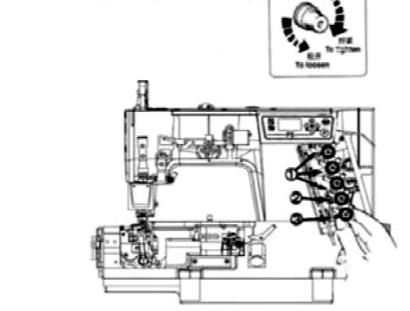


线状态的调节

线状态的调节是用针线状态螺帽①，上装饰线状态螺帽②，下针线状态螺帽③来进行调节。

Thread tension

Make tension adjustments with the needle thread knob (1), top cover thread knob(2) and looper thread knob(3).



油过滤器的检点与更换

- 机油过滤器，请于每6个月来点检或更换一次。
- 检点和更换每隔6个月进行一次！

Cleaning and replace the oil filter

- Check and replace the oil filter every six months.
- Check and replace every 6 months !

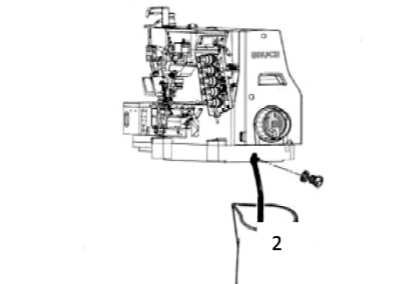


换机油

机油的更换，请在使用开始一个月后更换一次。然后，每6个月更换一次。

Replacing the oil

Replace the oil one month after the first use and every six months thereafter.



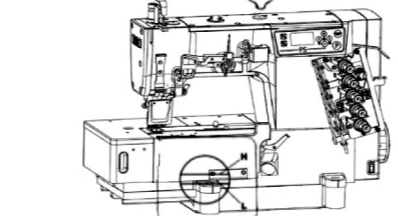
2

供油

加油量是使油面处于I线与L线之间为好。当油面低于L线时，就要及时补充机油。机油请使用杰克公司指定的 [HIGH SPEED SEWING MACHINE OIL] (ISO粘度与VG22相同)。

Lubrication

After filling the oil pan, the oil level should lie between (H) and (L) lines. Add oil when the oil level reaches or goes below (L) line. Note: Use Jack designated oil [HIGH SPEED SEWING MACHINE OIL] (ISO VG22)

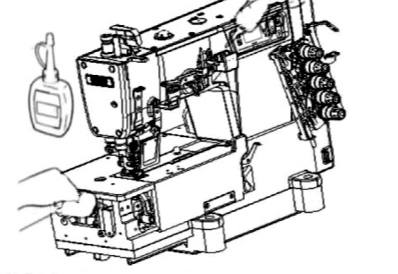


给HR装置供油

为了防止布纤维或线被切断，请尽早给HR装置供油。注：硅油请使用本公司指定的冷却油。[请使用日本UNION CARBIDE (株) 的UCCL-4S10]

Filling the HR device with silicon oil

Fill the device with oil before it is too low in order to prevent needle thread breakage and fabric damage. Note: Use recommended silicon oil [UNION CARBIDE CORPORATION] UCCL-4S(10)



穿线的方法

- (1) 请掀起护眼板，打开机盖 (3处)。
- (2) 抬起弯针挑线架。
- (3) 把机上的原有的线与缝线用线绑在一起。
- (4) 按下弯针挑线架，弯针挑线架回到原位。
- (5) 将针线拉到针眼前，剪掉结头再次穿好针线。
- (6) 弯针线，上装饰线直到拉出接头来后，用剪刀剪齐接头，整齐。

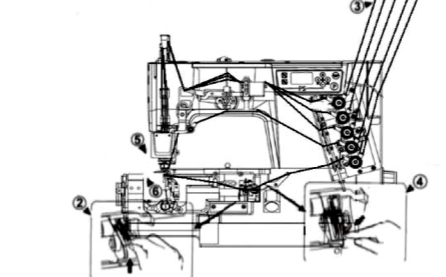
Threading

- (1) Open the eye guard and three covers.
- (2) Take up the bracket.

- (3) Knot the preset thread and the thread being used together to thread the machine.
- (4) Press down the bracket after threading. The looper thread take-up comes back.
- (5) Needle tread Trim the knots off neatly before passing through the eye of the needle to thread.
- (6) Looper thread , Top cover thread Trim the knots off neatly after passing through the eye of the looper.

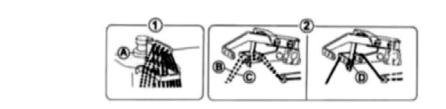
若机上原来没有线，请参照穿线图正确进行穿线。

Be sure to thread the machine correctly by referring to the threading diagram.

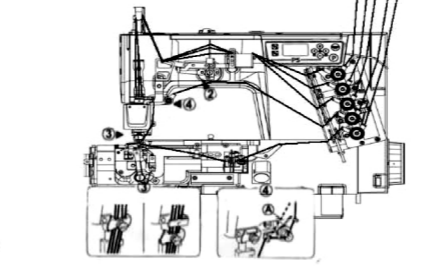


穿线图 (2针, 3针用) Threading diagram

- ① 若使用伸缩大的线时，为点线A的方向。(通常为实线方向) Broken lines(A) For more stretchable thread.
- ② 装饰线太松弛时用B，用B仍松弛时用C，装饰线太紧时用D。If the top cover thread is too loose use broken line(B), use broken(C). If the top cover thread is too tight use broken line(D).
- ③ 穿伸缩大的线时 穿伸缩小的线时 For more stretchable thread For less stretchable thread
- ④ 穿伸缩大的线时用点线E方向 Broken lines(E) For more stretchable thread
- ⑤ 若使用伸缩大的线时，为点线F方向。(通常为实线方向) Broken lines(F) For more stretchable thread.



Solid lines for ordinary thread.



BRUCE 高速绷缝机相关技术参数									
高行程数据									
机型	×□□□								针杆行程
PS-01GB/02BB/06CB	356	9.7	3-3.2	9.8	5-5.3	17	6.2	0.8-1.2	33.4
	364	9.3	2.6-2.8	9.4	5-5.3	17	6.2	0.8-1.2	33.4
PS-23BB	356	9.7	3-3.2	9.8	5-5.3	17	6.2	0.8-1.2	33.4
PS-23GB(L)	256	9.7	3-3.2	9.8	5-5.3	17	6.2	0.8-1.2	33.4
标准行程数据									
机型	×□□□								针杆行程
PS-01GB/02BB/06CB	356	8.5	3.2-3.5	8.5	5-5.3	17	6.2	0.8-1.0	30.8
	364	8.1	2.8-3.1	8.5	5-5.3	17	6.2	0.8-1.2	30.8
PS-23BB	356	8.1	2.8-3.1	8.5	5-5.3	17	6.2	0.8-1.0	30.8
PS-23GB(L)	256	8.1	2.8-3.1	8.5	5-5.3	17	6.2	0.8-1.2	30.8

绷缝P5-D电控箱操作说明书

在P界面，长按+键3秒，参数将恢复出厂设置。(J4、J5、J6的监控数据除外)

4.操作参数说明表 Parameter description

The panel shows "P", press + for 3 seconds, the parameter will back to factory setting.

5.错误码说明表 Error code description

错误 Error code	内容 Reasons	对策 Solutions
E1	电机堵转 Motor stuck	请转动手轮检查机头是否卡住或者干涩转动困难；请检查电机插件是否松动或者脱落；请检查加工物料是否过厚，电机因阻力不足而无法贯穿；请检查机器是否缺少润滑油。 The motor run out of load capacity, please reduce the load capacity for the motor and then restart the motor; Please check if the plug of motor loose or drop; Please check if the sewing machine is too heavy; Please check if the machine needs lubrication.
E2	软件过流 software over-current	请关机后重新上电，如果不能消除报警，请检查：电机负荷过重，请减轻负荷后重启电机；Motor used too much, Restart machine after several minutes, then please check if the fabric much too heavy.
E3	参数保存异常 Parameter save abnormal	出现此种状况，需要关闭电源，稍后再打开电源开关即可；恢复出厂设置（长按+键3秒不松开）；若重启或者恢复出厂设置后也不能解决，建议联系客服协商解决。Restart machine after several minutes or reset machine (press + 3s) ; If the problem unsolved, please contact dealers.
E4	电机霍尔信号异常 Hall of the motor with problem	请检查电机编码器插头连接是否可靠，编码器信号线是否有断线，插头是否退出或者变形。Please check if the 10core line connect well or not, please check if the connect line of hall is well or not.
E5	定位器信号异常 The synchronizer signal	请检查定位器是否连接电缆；请检查上下定位器是否正常。 Forget to insert the synchronizer cable before turn on the machine To check the both up needle position signal and the down needle position signal is working.
K	机头灯亮度调节 LED light adjustment	0: 关闭 off 1: 亮度 1~3 level 1~3
L	缝纫限制速 Limited sewing speed	05-55 50 以 500rpm 为单位递减 Decline by 500rpm every time
M	停针位开关 Switch of needle position	0-1 1 0: 关闭 off 1: 开启 on
H	休眠时间 Dormancy time	0-6 3 0: 关闭 off unit: 10min
V	速度显示使能 Speed display	0-1 0 0: 关闭 off 1: 开启 on
r	欠压检测开关 under-voltage	0-1 0 0: 关闭 off 1: 开启 on
Y	过压监测开关 over-voltage	0-1 1 0: 关闭 off 1: 开启 on
b	起缝断线检测延时计数	0-10 5 0-10: 针数 number of needles
T	断线检测使能和滤波针	0 3-10 7 0: 关闭 off 3-10: 针数 number of needles
EA	硬件过流 Hardware over-current	请关机后重新上电；请检查供电电压是否过高；请尝试恢复出厂设置。Please cut off the power and restart; Please check whether the supply voltage is normal; Please try to restore factory defaults.
Eb	系统过电压 System over-voltage	立即切断电源，并检查供电电压是否过高，如果是，请调整供电电压到额定电压后再开机工作(额定电压: 220V)。Immediately cut off the power, and check whether the supply voltage is too high, if yes, please adjust the rated voltage, then start to work (rated voltage: 220v).
EC	系统欠电压 System under-voltage	请检查供电电压是否正常，请等待电源重新开启/复位 (请仔细检查电源板各项功能)。Mean the voltage abnormal, please check if the voltage is normal or not; Means waiting for the power, and need to restart again or recover to the factory reset.
Ed	刹车电阻保护 The safeguard of brake resistance	请检查刹车电阻插头是否松动或脱落；请检查供电电压是否正常；请尝试恢复出厂设置或将电源重启；Please check whether the resistance plug is well or not; Please check if the voltage is normal or not and restart again or recover;

在F界面，长按+键3s，进入监参参数，并显示J
The panel shows "P", press + for 3 seconds, inter monitoring parameter, and it shows "J"

J1	实时速度 Real-time Speed	显示的数×100=实际速度的 showing number multiples by 100 equal to the real speed.
J2	实时功率 Real-time Power	显示的数×10=实际功率 the showing number multiples by 10 equal to the real power.
J3	输入电压 Input Voltage	显示的数×10=实际电压 the showing number multiples by 10 equal to the real voltage.
J4	历史电压 Historical Voltage	显示历史输入最低电压和最高电压 Display the historical lowest input voltage and highest input voltage.
J5	历史错误代码 Historical Error	显示最新的 5 个错误代码 Display historical error code (only show the latest 5).
J6	累计运行时间 Cumulative Running Time	显示的数×100=实际时间 (Hour) the showing number multiples by 10 equal to the real time (hour).

3.恢复出厂设置 Factory reset

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