

High-speed & Intelligent Glove Knitting Machine

B-Mac Pro-7/10/13/15/18G/21G

USER MANUAL(1.0 version)



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1. Instructions for use



图 1

Switch up to open the machine, will pop up the “Last

shutdown is being reset, the system will enter the reset state” prompt window, click on the green ‘√’ OK. Before using the machine, please first set the required pattern (see glove settings and glove parameters) , then check whether the yarn is connected, there is no broken yarn, and finally begin to reset the whole (see the main interface) , click the green button and the machine begins to work. Note: When setting the pattern, you must choose the same size as the aluminum roller, otherwise it will cause firing pin and damage the machine

2. Home screen

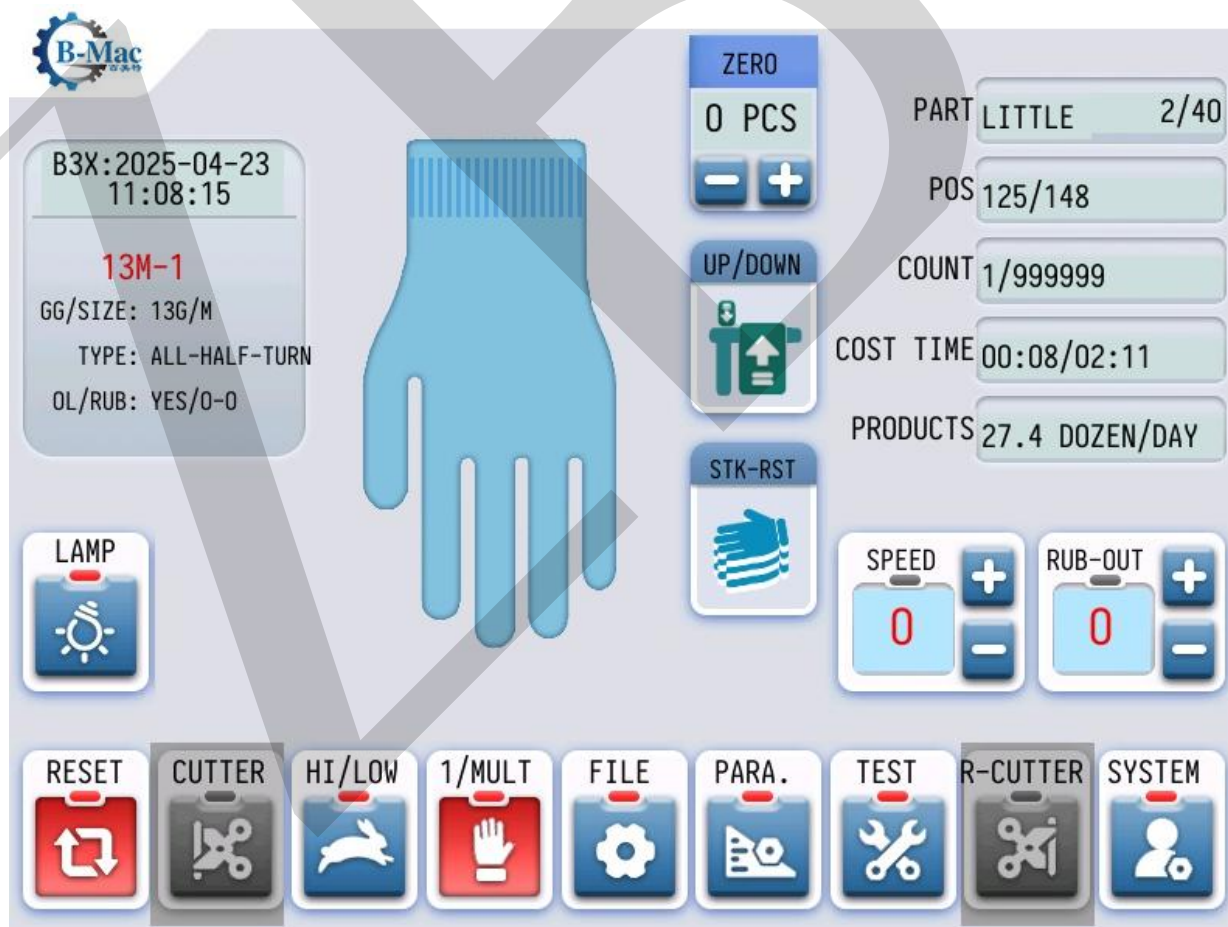


图 2

RESET: to return all the controllable parts of the machine to zero position
(Head moved to the right, click on the start button to start the overall reset)

CUTTER: control main yarn scissors to cut yarn, available after the whole reset

HI/LOW: click to switch between high and low speed operation

1/MULT: click to switch knitting one glove or multiple gloves

FILE: create glove pattern and some function settings (see pattern settings)

PARA: glove speed setting and glove function setting (see glove parameters for details)

TEST: to detect whether the electrical part of the fault

Electric Scissors: control the right side of the pair of electric scissors to cut yarn

SYSTEM: machine upgrade, important parameters management settings interface

PART: the total number of laps and the current number of laps of the current glove knitting part

POS: the current position of the machine stroke and the head

COUNT: show the current number of gloves only, click to set or clear the number of gloves only

COST TIME: the time it takes to complete a single glove

PRODUCTS: the theoretical output of gloves produced by the machine in 24 hours

SPEED: The Machine's current knitting glove speed, click, can change the speed

RUB-OUT: control the width of the glove grommets, starting at 50, click to change the value

UP/DOWN: on the conveyor belt of the beater, the pressing gloves lever is lifted to facilitate the holding and placing of the gloves

STK-RST: control the device of the crimping machine to return to the zero position

LAMP: turn on or off the lighting above the glove rack

3. Pattern set-up



图 3

Display glove machine model, level, size and some functions

TYPE: display and select normal forehand and backhand, normal 1 forehand and backhand, fancy forehand and backhand, half fingered forehand and backhand, half pack forehand and backhand

Hand, all-inclusive forehand and backhand, sleeve forehand and backhand, etc.

FINGGERTIP: Show and select semicircle, full circle

Gloves circle number: show the number of working lines of each part of the gloves, users can click and set their own

COLOR MODULE: click on the button below the color will appear the type of yarn color used

KNIT PART: show the name of the glove part

Glove function: display and modify the various functions of gloves

3.1. Two-color insert settings

2 COLOR INSERT												
	COLOR#	BEGIN	NO-THR EAD	END	NO-THR EAD		2 COLOR CUTTER	OVERLOCK CUTTER	M-CUT.	M_REL.	E-CUT.	E-REL.
01	0	0	0	0	0	01	0	0	0	0	0	0
02	0	0	0	0	0	02	0	0	0	0	0	0
03	0	0	0	0	0	03	0	0	0	0	0	0
04	0	0	0	0	0	04	0	0	0	0	0	0
05	0	0	0	0	0	05	0	0	0	0	0	0
06	0	0	0	0	0	06	0	0	0	0	0	0
07	0	0	0	0	0	07	0	0	0	0	0	0
08	0	0	0	0	0	08	0	0	0	0	0	0
09	0	0	0	0	0	09	0	0	0	0	0	0

INPUT "." / "+" COPY ROW/COL, RANGE 0-999
 NO THREAD: 0-NO 1-YES
 2-FRONT YES 3-BACK NO

PGUP PGDN CLEAR ↻

图 4

COLOR#: color number is divided into "1", "2", "3", color number 1 corresponds to the right yarn mouth for palm double color, double Color scissors or electric scissors for thread cutting; color number 2 corresponds to the front left hot melt yarn mouth for finger or palm double color, hot melt scissors for thread cutting, color number 3 corresponds to the front right yarn mouth for finger or palm double color, double-color or electric scissors for wire cutting

BEGIN: the number of rows to start with for this section of data

END: the number of end rows of this segment of data

NO-THREAD: "0" all no; "1" all have; "2" out have, go in no; "3" go in have, go out no

2 COLOR CUTTER: control two-color scissors cutting line, two-color scissors line number should be greater than the end of the line

OVERLOCK CUTTER: control hot melt scissors cutting line, hot melt scissors line number should be greater than the end of the line

M-CUT: control the main yarn scissors in the number of circles cut thread

M-REL: control the main shear in which lap pay-off

E-CUT: control the number of circles in the electric scissors cut wire

E-REL: control the electric shear wire in the number of turns

PGUP: click to return to previous page

PGDN: Click to return to next page
 CLEAR: Deletes all data in the current interface
 Back: click to return to the previous screen

3.2. U3 setting



图 5

CYCLE: the interval in which U 3 is repeated, E. G. Input 3 is every 3 turns
INSERT: the number of laps of U 3 in the cycle interval
BEGIN: the number of rows to start with for this section of data
END: the number of end rows of this segment of data
 PGUP: click to return to previous page
 PGDN: Click to return to next page
 CLEAR: Deletes all data in the current interface
 Back: click to return to the previous screen

3.3. Rubber band setting

RUBBER									
	RATIO	INSERT	CMD	BEGIN	END	OUT RATIO			CUTTER
01	0	1	0	0	0	50	01		0
02	0	1	0	0	0	50	02		0
03	0	1	0	0	0	50	03		0
04	0	1	0	0	0	50	04		0
05	0	1	0	0	0	50	05		0
06	0	1	0	0	0	50	06		0
07	0	1	0	0	0	50	07		0
08	0	1	0	0	0	50	08		0
09	0	1	0	0	0	50	09		0

PGUP PGDN INPUT "." / "+" COPY ROW/COL, RANGE 0-999 CLEAR ↻

图 6

RATIO: the rubber band cycle of the interval, such as input 3 is 3 laps for a cycle

INSERT: number of rubber bands in a cycle interval

CMD: control the rubber knife to cut the line. "1" means cut, "0" means don't cut

BEGIN: the number of rows to start with for this section of data

END: the number of end rows of this segment of data

OUT RATIO: Used to modify the width of the gloves, the default value of 50, can be set

CUTTER: control the number of rubber knife coil, forehand generally set "1", backhand default "12"

PGUP: click to return to previous page

PGDN: Click to return to next page

CLEAR: Deletes all data in the current interface

Back: click to return to the previous screen

3.4. Density setting of ejector pin



图 7

FRONTDEN: set pre-density data, density value arranged 1 ~ 32, value 1, the densest gloves

BACKDEN: set before the density data, density value arrangement 1 ~ 32, value 1, gloves the densest

BEGIN: the number of rows to start with for this section of data

END LINE: the number of end rows of this segment of data

PGUP: click to return to previous page

PGDN: Click to return to next page

COPY: copies all current parameters

CLEAR: Deletes all data in the current interface

Back: click to return to the previous screen

3.5. Needle position setting of roller

DRUM POS							
	TARGET N UMBER	LOOP	INSERT	BEGIN LINE	END LINE	ACT POSI TION	ACT LINES
01	0	0	0	0	0	0	0
02	0	0	0	0	0	0	0
03	0	0	0	0	0	0	0
04	0	0	0	0	0	0	0
05	0	0	0	0	0	0	0
06	0	0	0	0	0	0	0
07	0	0	0	0	0	0	0
08	0	0	0	0	0	0	0
09	0	0	0	0	0	0	0

PGUP PGDN COPY INPUT "." / "+" COPY ROW/COL, RANGE 0-999
 CLEAR ↻
 COPY: 1. COPY TO ALL FINGER
 2. COPY 4-F AND 5-F PALM

图 8

TARGET NUMBER: the actual number of rows corresponding to the roller pin

LOOP: number of turns in a loop

INSERT: the number of target cells to insert in a loop

BEGIN LINE: the number of starting rows of data for this segment

END LINE: the number of end rows of this segment of data

ACT POSITION: "0" means the head to the left jump roller, "1" means the head to the right jump roller

Number of laps: the number of laps at which the action begins

PGUP: click to return to previous page

PGDN: Click to return to next page

COPY: copy an entire line of parameters

CLEAR: Deletes all data in the current interface

Back: click to return to the previous screen

3.6. Speed setting of blowing air



图 9

SPEED: set the knitting speed per turn

BEGIN: the number of rows to start with for this section of data

END: the number of end rows of this segment of data

BLOW: blowing setting, “0” means no blowing, “1” means full circle blowing, “2” means the nose is on the left

Blow when the nose is on the right

BEGIN: the number of rows to start with for this section of data

END: the number of end rows of this segment of data

PGUP: click to return to previous page

PGDN: Click to return to next page

CLEAR: Deletes all data in the current interface

Back: click to return to the previous screen

4. Glove parameters



图 10

Speed setting interface

Used for setting the knitting speed of each part of gloves

Shift Speed Mode:

High Speed Mode: 1: the speed of the last lap of each finger and four fingers is the corresponding high speed. 2: four fingers

Palm and five fingers palm of the first lap speed is the corresponding high-speed

Low Speed Mode: 1: the speed of the last lap of each finger and four fingers is "Needle changing speed". 2: four fingers

Palm and five fingers palm of the first lap speed is "Needle speed."

4.1. Function setting interface



图 11

DROP TEST: check whether drop detection is enabled when the glove passes through the drop sensor after knitting. After enabling the drop detection open, in the gloves when no induction will alarm, not in the gloves when the induction of 30 seconds will also alarm, then explain where the gloves blocked

LCD OFF(MIN): the display screen will automatically become black screen to save power when turned off

SPEED ADJUST ON/OFF: the option “Yes” allows adjustment of weave speed in the home screen, “No” does not

OVERLOCK MELT SELECT: Do Hot Melt when the selection of the corresponding hot melt yarn mouth

TAKEOFF SEQUENCE OF GLOVES: take-off sequence can be divided into front take-off and back take-off according to requirements

SEQUENCE OF MAIN-CUTTER: divided into “First cut after sealing” and “First seal after cutting” two modes

MELT NO LINE FUNCTION: Hot melt wireless head special function on and off

RUBBER SPEED: when enabled to do rubber band in accordance with the speed, don't do rubber band by five palm speed, disable the use of rubber band speed

OVERLOCK MELT LEFT CUT: enabled will cut wire on the left, disabled cut wire on the right.

SEQUENCE OF RIGHT CUTTER: divided into "First cut after sealing" and "First seal after cutting" two modes

DROP GLOVE BLOW: "On" or "Off" glove blowing

4.2. Parameter setting interface

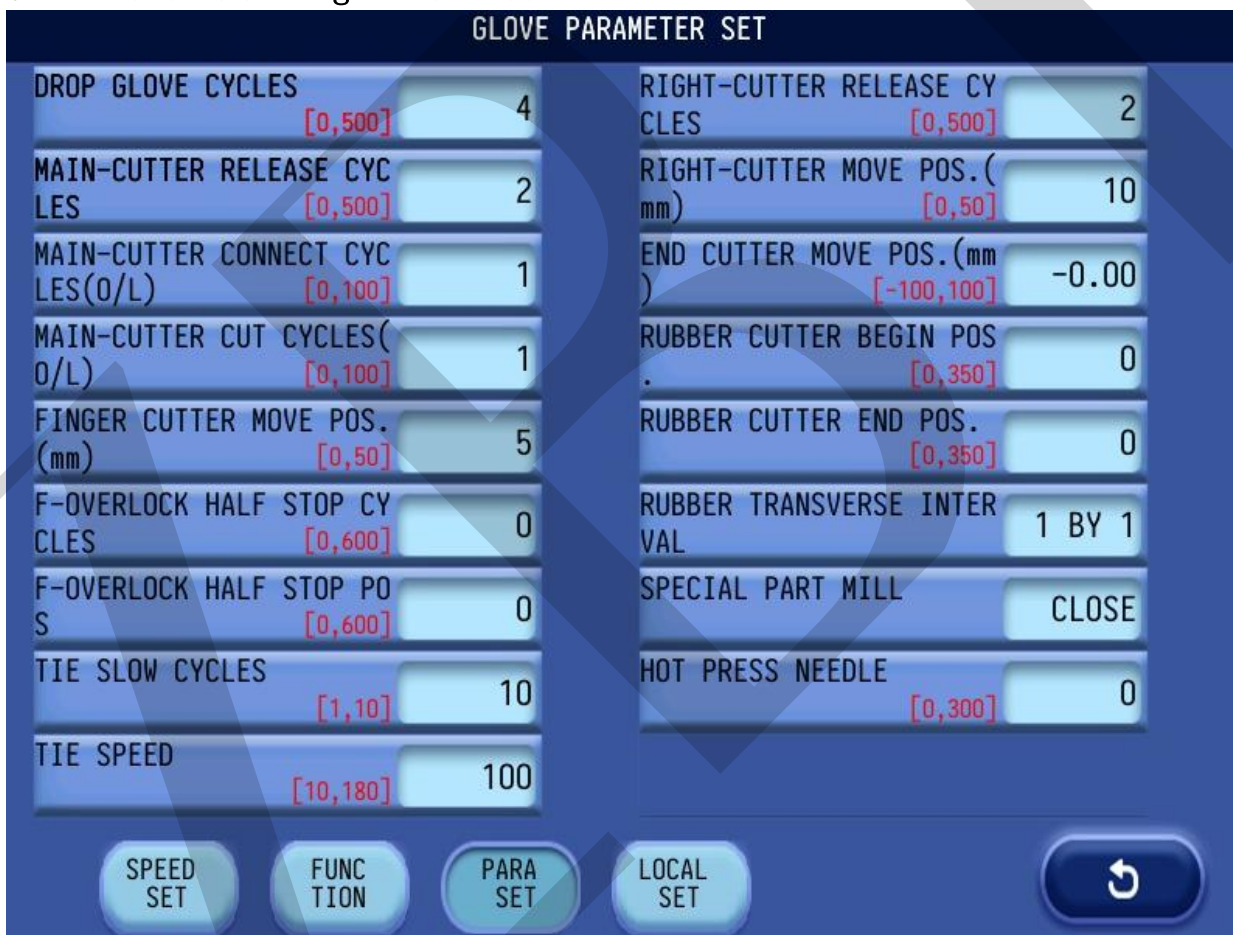


图 12

DROP GLOVE CYCLES: the number of laps the main motor runs empty after the glove weaving is completed.

MAIN-CUTTER RELEASE CYCLES: when the scissors are opened and part of the yarn is released, the number of turns of the fingers has been woven.

MAIN-CUTTER CONNECT CYCLES (O/L): main scissors hook coil number of hot melt done.

MAIN-CUTTER CNT CYCCLES (O/L): main scissors cut wire when the number of hot melt done.

FIGER CUTTER MOVE POS (mm) : the distance a finger moves while cutting a wire.

F-OVERLOCK HALF STOP CYCLES、 F-OVERLOCK HALF STOP POS: these two parameters are used when making two-color fingers, in order to make Finger at the end of the two-color not directly cut off and set the "Number of turns" refers to the number of turns delay wire cutting, "Position" refers to the machine Head left to half stop

TIE SLOW CYCLES: the number of laps at slow speed when using the knotter.

TIE SPEED: the speed at which the knotter is used.

RIGHT-CUTTER RELEASE CYCLES: right scissors cut line after waiting for the number of coils after the line.

RIGHT-CUTTER MOVE POS (mm) : the distance the right scissor rod moves while the right scissor line is being cut.

END CUTTER MOVE POS (mm) : the distance the right scissor rod moves after the right scissor line has been completed.

RUBBER CUTTER BEGIN POS: the position of the Machine Head when the rubber band scissors begin to work

RUBBER CUTTER END POS: Rubber band scissors work at the end of the head position

BUBBER TRANAVERSE INTERVAL: rubber band high and low pin arrangement ratio

SPECIAL PART MILL: open the gloves can choose the finger or other parts of the mill

HOT PRESS NEEDLE: the position of the head when the last turn of the hot melt is encrypted by the front ejector

4.3. Settings of this machine



图 13

FRONT DENSITY BAR DEEP: the depth of the triangle of the pressing pin pushed by the front ejector pin when pressing the pin.

BACK DENSITY BAR DEEP: when pressing the pin, the back ejector pin pushes the triangle of the pin down.

MAIN YARN RELEASE POS-1: double-layer scissors used.

MAIN YARN RELEASE POS-2: double layer scissors used.

LEFT-CUTTER HOOK ADJUST: left scissors line correction value.

RIGHT-CUTTER HOOK ADJUST: Right Scissors line correction value of the position.

LEFT-CUTTER CUT ADJUST: left scissor line position correction.

RIGHT-CUTTER CUT ADJUST: Right Scissors line position correction.

MELT REALEASE POS. OF MACHINE: Head in the hot melt reel position correction value.

3 COLOR MODE: 1 closed state: “1” bicolor for palm bicolor or “After the hot melt” ; “2”

Bi-color for finger and palm bi-color or “Pre-hot melt”

2 open state: “1” and “3” dual-color can be used for finger and palm dual-color “Front hot melt” with 3

No. 1 yarn mouth, “Back hot melt” with No. 1 yarn mouth

MAIN YARN CONTROL: choose the main yarn nozzle in the head running left suction or right suction

TWO CUTTER FUNCTION: “Enable” and “Turn off” double layer scissors

RIGHT-CUTTER ENABLE: set the right scissors function, you can set “Disable” or “Enable”

RIGHT-CUTTER PIN ENABLE: set the right scissor bar function, you can set “Disable” or “Enable” by yourself

DRUM WAITING: off: Roller Jump Grid, the head did not stop; Open: Roller Jump Grid, the head waiting

GLOVE SETTING ENABLE: glove speed and part of the function can not be modified after closing

STACKER EABLE: turn play machine function on or off.

CLOSE BREAK YARN: change to zero after the alarm is normal, change to any number of gloves and the corresponding number of turn broken yarn without alarm

5. System administration



图 14

- SYSTEM UPGRADE:** displays the system version number and the version number of the printer and the upgradeable programs on USB
- 语言/LANGUAGE:** click to switch between Chinese and English
- ERROR RECORD:** Error Timing, error description, statistics, and Sōsei
- SERVO PARA:** View or modify master servo parameters
- PAYMENT:** Decrypt and load the instalment file according to the customer's situation
- DISK MANAGMENT:** pattern files, machine parameters, system parameters, the whole dozen machine parameters of the input and output
- SYSTEM PARA:** set the main motor speed, drum speed and the speed of the stepper motor
- MACHINE PARA:** The Machine factory debugging good mechanical position parameters
- TIME SET:** Click on set time
- ASSEMBLY:** for assembly personnel and inspection personnel to fill in their own number and view the information of other assembly personnel, in which the factory parameters inspector filled in the number, the machine automatically keep the current factory parameters. This parameter can be used to restore factory settings
- LOAD DEFAULT:** if the parameters are modified and you don't know what went wrong, you can revert to the factory configuration parameters
- PASSWORD SET:** modify and manage the machine on a parameter to open the password

Drive parameters, machine parameters, system parameters these three parameters belong to the machine production enterprise control parameters Number, not open to users.



5.1. Model parameters

MACHINE PARAMETER	
GAUGE	[5.0,30.0] 13G
SIZE	M
D3	DISABLE
CURRENT MACHINE PARA.	ENTER
CURRENT DRUM SET	ENTER
MACHINE HEAD POS. ADJUST	[0,40] 25
JUMP CHANGE PIN	DISABLE
RELEASE LINE HEAD POS.	[-200,200] 0
BAR POS	ENTER
OIL TIME	[0,10] 2
OIL INTERVAL TIME	[0,1440] 800
SPEED AFTER OIL	[10,180] 120
SLOW LINE AFTER OIL	[1,50] 3
R-CUTTER CLOSE POS	[-200,200] -100
STACKER	ENTER
STITCH MOTOR DIR	REVERSE

图 15

GAUGE: the number of stitches per inch on a machine

SIZE: the size of the glove

D3: enabled or disabled, depending on model configuration

CURRENT MACHINE PARA: the model parameters of the current model

CURRENT DRUM SET: the roller parameters under the current model

MACHINE HEAD POS. ADJUST: Drum Action when the head position

JUMP CHANGE PIN: enable or disable pin change after enable pin change after enable

RELEASE LINE HEAD POS.: the head in the positive and negative stroke according to the number of needles set out

BAR POS: set the motor position of the ejector pin in knitting, half needle and pressing needle

OIL TIME: the time of one oiling

OIL INTERVAL TIME: the interval after automatic oiling

SPEED AFTER OIL: refueling speed can be set, appropriate to reduce, prevent the machine from high-speed Oil Splash

SLOW LINE AFTER OIL: the number of laps sustained at slow speed during refueling

R-CUTTER CLOSE POS: the position of the right shearing rod when the right scissors seal the line

STACKER: Enter the packaging machine setup interface

5.2. Parameters of the current model

CUR-MACHINE PARAMETER			
RING FINGER PRESS POS [0,350]	162	RUBBER MOTOR LEFT STOP POS [0,500]	200
MIDDLE FINGER PRESS POS [0,350]	195	RUBBER MOTOR RIGHT STAR T POS [0,500]	270
INDEX FINGER PRESS POS [0,350]	228	RUBBER MOTOR RIGHT STOP POS [0,500]	90
THUMB PRESS POS [0,350]	260	2-COLOR THUMB POS A MOD IFY [-50,50]	0
RING FINGER PRESS POS M ODIFY [0,100]	20	2-COLOR INDEX FING POS A MODIFY [-50,50]	0
MIDDLE FINGER PRESS MOD IFY [0,100]	20	2-COLOR MID FING POS A MODIFY [-50,50]	0
INDEX FINGER PRESS MODI FY [0,100]	20	HOOK LINE HEAD POS [-20,10]	4
THUMB PRESS MODIFY [0,100]	20		
RUBBER MOTOR LEFT START POS [0,500]	20		

图 16

HEAD POS: the head in each part of the glove travel position

STITCH HOLDER POS: knife position for each finger

CUTTER POS: the position of the master scissors rod on each finger

Ring finger, middle finger, index finger, thumb pressure needle position: ring finger, middle finger, index finger, thumb pressure needle when the head position

Ring finger, middle finger, index finger, thumb pressure needle position modification: ring finger, middle finger, index finger, thumb pressure needle position offset

RUBBER MOTOR LEFT STOP POS: Rubber Motor Stop Head left position.

RUBBER MOTOR RIGHT START POS: rubber motor starting head left position.

RUBBER MOTOR RIGHT STOP POS: Rubber Motor Stop Head right line position.

2-COLOR THUMB POS A MODIFY: position correction of position a when doing bicolor thumb

2-COLOR INDEX FING POS A MODIFY: position correction of a position when two-color index finger is used

2-COLOR MID FING POS A MODIFY: position correction of a position while doing two-color middle finger

5.3. System parameters

5.3.1. Speed setting

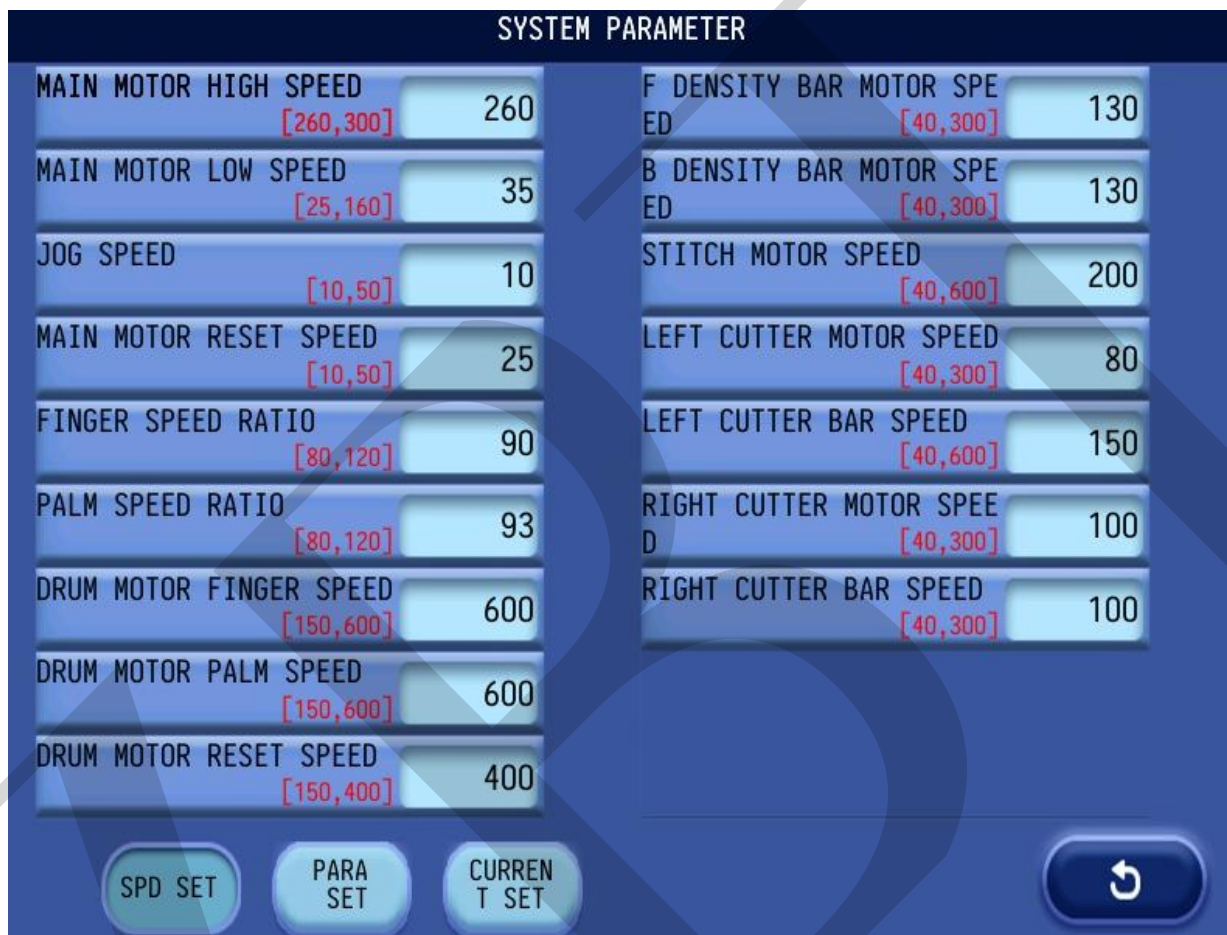


图 17

MAIN MOTOR HIGH SPEED: refers to the main motor high speed for the lowest “260” , the highest “300” , recommended to use the speed of “260” , within the scope of the speed can be adjusted

MAIN MOTOR LOW SPEED: refers to the main motor speed for the lowest “25” , the highest “160” , recommended use speed for “25” , within the scope of the speed can be adjusted

JOG SPEED: refers to the main motor actuation when the speed for the lowest “10” , the highest “50” , recommended use speed for “10” , within the scope of the speed can be adjusted

MAIN MOTOR RESET SPEED: refers to the main motor reset action when the speed of the lowest “10” , the highest “50” , recommended to use the speed of “25” , within the scope of the speed can be adjusted

FINGER SPEED RATIO: refers to the weaving of fingers when the speed of the percentage “80” , the highest “120” , recommended to use the speed of “90” , within the scope of the speed can be adjusted

PALM SPEED RATIO: refers to the woven part of the palm speed percentage “80” , the highest “120” , recommended speed for “93” , within the scope of the speed can be adjusted

DRUM MOTOR FINGER SPEED: refers to the drum motor in the weaving finger action speed for the lowest “100” , the highest “600” , recommended use speed for “600” , within the scope of the speed can be adjusted

DRUM MOTOR PALM SPEED: refers to the lowest speed of “100” and the highest speed of “600” when the motor is weaving. The recommended speed is “600” . The speed can be adjusted within the range

DRUM MOTOR RESET SPEED: refers to the drum motor in the implementation of the reset action when the speed of the lowest “100” , the highest “500” , the recommended speed is “400” , within the scope of the speed can be adjusted

F DENSITY BAR MOTOR SPEED: refers to the front push rod motor working speed of the lowest “20” , the highest “600” , recommended speed of “120” , within the scope of the speed can be adjusted

B DENSITY BAR MOTOR SPEED: refers to the back push rod motor working speed of the lowest “20” , the highest “600” , recommended speed of “120” , within the scope of the speed can be adjusted

STITCH MOTOR SPEED: refers to the knife motor working speed for the lowest “20” , the highest “600” , recommended speed for “120” , within the scope of the speed can be adjusted

LEFT CUTTER MOTOR SPEED: refers to the left scissors motor working speed for the lowest “20” , the highest “120” , recommended speed for “60” , within the scope of the speed can be adjusted

LEFT CUTTER BAR SPEED: refers to the left scissor pole motor working speed for the lowest “20” , the highest “300” , recommended use speed for “120” , within the scope of the speed can be adjusted

RIGHT CUTTER MOTOR SPEED refers to the right scissors motor working speed for the lowest “20” , the highest “120” , recommended use speed for “60” , within the scope of the speed can be adjusted

RIGHT CUTTER BAR SPEED: refers to the right scissor pole motor working speed for the lowest “20” , the highest “300” , recommended use speed for “120” , within the scope of the speed can be adjusted

5.3.2. Current setting:

Adjust the working current and holding current of each motor of the equipment (for non-professionals, adjust with caution)



图 18

6. Electrical testing



图 19

This interface is the electrical test interface, used to detect whether the electrical part of the fault

SIGNAL TEST: detect the input signal of the machine

OUTPUT CONTROL: detect whether the motor running and direction is normal, whether the motor zero is normal

COMMUNICATION TEST: check whether the communication signal is normal

SOLENOID TEST: check whether the electromagnet is working properly

STACKER TEST: Test Leveler the position of each motor and return to zero state is normal

MAIN MOTOR: check whether the main motor is running properly

Back: click to return to the previous screen

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