



Mattress Production Technology Group Ltd

# MatraMax Tape Edger



## **Under-Table Operating Manual**

# Congratulations on the Purchase of Your M.P.T. Group Product

M.P.T. Group equipment is engineered and manufactured in accordance with Strict specifications, using high quality components and state-of-the-art Technologies that assure reliable, long-term performance. Your product has been thoroughly tested for proper operation prior to shipment.

Before unpacking and installing your new equipment, please read this Manual. It is your guide to safe installation, productive operation and effective maintenance. We recommend that you keep the manual available for future reference.

Carefully read the *Safety* section. Your product is designed for safe operation when used according to the published instructions. Potential hazards exist when operating instructions are not followed.

## ***Manufacturer of Equipment***

Mattress Production Technology Group Ltd.  
Newline Industrial Estate  
Newline  
Bacup  
Rossendale  
OL13 9RW

Telephone: 0044 (0) 1706 878558  
Fax: 0044 (0) 1706 878288

# Declaration of Conformity

## 98/37/EC

## 73/23/EEC

We,

**Mattress Production Technology Group Limited**

of

**Newline Industrial Estate, Newline, Bacup,  
Rossendale, Lancashire. OL13 9RW**

declare that under our sole responsibility for supply/manufacture of the product(s)

<b>Product Name</b>	Matramax
<b>Model Number(s)</b>	N/A
<b>Product Options</b>	All

to which this declaration relates, is in conformity with the following standards and other normative documents

### **Safety**

BS EN 60204--1:1993  
.Safety of Machinery -- Electrical equipment of machines.

EN 60335:Part 1:1988  
Safety of household and similar electrical appliances.

BS EN 292:1991  
Safety of machinery -- Basic concepts, general principles  
for design.

following the provisions of 98/37/EC and 73/23/EEC  
Directives

**Andrew  
Trickett  
Graham Jones**

**Company Directors**

M.P.T. Group Ltd., 5th May 2007

NB ref EN45014 (BS7514)

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## ***Section 1***

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## ***Safety***

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# Section 1

## Safety

### **1. Introduction**

Read and follow these safety instructions. Task and equipment specific warnings, cautions, and instructions are included in equipment documentation where appropriate. Make sure all equipment documentation, including these instructions, is accessible to all persons operating or servicing equipment.

### **2. Qualified Personnel**

Equipment owners are responsible for making sure that M.P.T.G. equipment is installed, operated, and serviced by qualified personnel.

Qualified personnel are those employees or contractors who are trained to safely perform their assigned tasks. They are familiar with all relevant safety rules and regulations and are physically capable of performing their assigned tasks.

### **3. Intended Use**

Use of M.P.T.G. equipment in ways other than those described in the documentation supplied with the equipment may result in injury to persons or damage to property.

Some examples of unintended use of equipment include

- using incompatible materials
- making unauthorized modifications
- removing or bypassing safety guards or interlocks
- using incompatible or damaged parts
- using unapproved auxiliary equipment
- operating equipment in excess of maximum ratings

### **4. Regulations and Approvals**

Make sure all equipment is rated and approved for the Environment which it is to be used in. Any approvals obtained for M.P.T.G. equipment will be voided if instructions for installation, operation, and service are not followed.

## **5. Personal Safety**

To prevent injury follow these instructions.

- Do not operate or service equipment unless you are qualified.
- Do not operate equipment unless safety guards, doors, or covers are intact and automatic interlocks are operating properly. Do not bypass or disarm any safety devices.
- Keep clear of moving equipment. Before adjusting or servicing any moving equipment, shut off the power supply and wait until the equipment comes to a complete stop. Lock out power and secure the equipment to prevent unexpected movement.
- Relieve (bleed off) hydraulic and pneumatic pressure before adjusting or servicing pressurized systems or components. Disconnect, lock out, and tag switches before servicing electrical equipment.
- To prevent injury, be aware of less-obvious dangers in the workplace that often cannot be completely eliminated, such as hot surfaces, sharp edges, energized electrical circuits, and moving parts that cannot be enclosed or otherwise guarded for practical reasons.

## **6. Action in the Event Of a Malfunction**

If a system or any equipment in a system malfunctions, shut off the system immediately and perform the following steps:

- Disconnect and lock out electrical power. Close pneumatic shutoff valves and relieve pressures.
- Identify the reason for the malfunction and correct it before restarting the equipment.

## **7. Disposal**

Dispose of equipment and materials used in operation and servicing according to local codes.

## ***Section 2***

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### ***Description***

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# Section 2

## Description

### **1. *Intended Use***

The MatraMax high speed electronic tape edge machine is a leader for Mattress producers in the world today. The MatraMax's innovative design features ensure a reduction in operator fatigue coupled with increased productivity.

### **2. *Features***

Available with a 300U high speed chain sewing head or a heavy duty lock stitch sewing head.

Pneumatic foot lift. (option available)

Extensive choice in binders.

Sewing head variable speed up to 3500 rpm.

Adjustable stitch length.

Power assisted carriage movement.

Power assisted table elevation.

Power assisted head positioning control.

Variable straight-line speed control.

Variable corner speed control.

Needle cooling system.

Tape feed synchronization system to eliminate drag of the tape and mattress.

## ***Section 3***

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### ***Installation***

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# Section 3

## Installation



**WARNING:** Allow only qualified personnel to perform the following tasks. Observe and follow the safety instructions in this document and all other related documentation.

### ***1. Transport***

Transport the unit so as to avoid damage. Do not throw the unit.

Use suitable packaging materials and sturdy cartons. See *Specifications* section for dimensions and weight.

Protect the unit from exposure to humidity, dust and vibrations.

### ***2. Unpacking***

Carefully unpack the unit to avoid damaging it. Check for damage caused during transport.

Save packing materials for possible later use. Otherwise recycle or dispose of properly according to local regulations.

### ***3. Removing***

Switch off the mains supply, then disconnect all electrical connections from the unit.

### ***4. Storage***

Pack the unit in suitable packaging materials and sturdy cartons. Protect from humidity, dust and large temperature fluctuations (condensation).

### ***5. Disposal***

Dispose of properly according to local regulations.

## 6. Electrical



**WARNING:** Allow only qualified personnel to perform the installation. Observe safety instructions.

- A single supply cable is required to the machine isolator. The supply should be fed from a suitable disconnect device. Introduce the cable into the panel using an IP6X cable gland. Ensure that all the electrical wires are suitably sized for the fan motor loading and adequate fuse/circuit protection is provided at the source of supply.

## 8. Setting Up the Unit

### Site Preparation



**WARNING:** Allow only qualified personnel to perform the installation. Observe safety instructions.

**NOTE:** MatraMax systems are generally delivered pre— assembled with the carriage along the short end of the table, but on occasions the sewing head will have been removed and packed separately. Machines with overhead electrics will also have been packed separately.

The machine must be slung or lifted from under the lower rail taking care not to damage the machine or any electrical cables.

**NOTE:** Care must be taken when lifting because of the unequal weight distribution caused by the position of the carriage.

**NOTE:** Installation of the MatraMax should not be undertaken without the presence of an M.P.T.G. representative or a suitably qualified person.

- Choose a level site on which to install the Matramax. If this isn't possible the four feet on the machine are adjustable.
- Seal concrete floors with a suitable material to avoid dust. Other floor surfaces should be of a type that is easy to keep clean.

***Section 4***

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***Operation***

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# Section 4 Operation



**WARNING:** Allow only qualified personnel to perform the following tasks. Observe and follow the safety instructions in this document and all other related documentation.

## 1. Introduction

- Turn on the electrical supply and ensure the emergency stop button is in the out position. (located near the top of the carriage) When the machine is powered up and ready to run the STOP, FORWARD, and the TABLE buttons will be illuminated.

## Under-Table MatraMax

## 2. Operator controls

SEWING  
HEAD  
UP/DOWN

DRAG

STRAIGHT  
SPEED

CORNER  
SPEED

TABLE

LOCK

AIR

START

STOP

CARRIAGE  
REVERSE

SEND

CARRIAGE  
FORWARD



Operator station controls

- 1) **START**

A single press on the start button activates the sewing head and carriage drives. The sewing head and carriage will then move under the control of the knee control pad. Once pressed the drives will remain active until the **STOP** button is pressed. The button is illuminated during the period when both drives have been activated.
- 2) **STOP**

A single press on the stop button will stop either or both of the sewing head and carriage drives. The stop button is illuminated when the carriage drive is not active.
- 3) **∧**(Carriage Forward)

Pressing and holding down the inch back button moves the carriage away from the operator. The button is always illuminated and when depressed the stop button illumination goes out.
- 4) **∨**(Carriage Forward)

Pressing and holding down the inch forward button moves the carriage towards the operator. The button is always illuminated and when depressed the stop button illumination goes out.
- 5) **LOCK**

A single press on the lock button activates the sewing head drive. The sewing head will then sew under the control of the knee control pad. Once pressed the drive will remain active until the **STOP** button is pressed. The button is illuminated during the period when the drive is active.
- 6) **AIR**

A single press of the air button turns on the fan for cooling the needle, pressing the button again turns the fan off. The button is illuminated when the fan is on.
- 7) **TABLE**

Pressing and holding down the table button will either raise or lower the table in the opposite manner to the previous time the table height was adjusted. The table button is always illuminated.
- 8) **SEND**

A single press on the send button drives the carriage back to the start position at the top of the table. The carriage can be stopped by pressing either the stop button or one of the inch buttons. The button is illuminated whilst moving back.
- 9) **STRAIGHT SPEED**

The straight speed potentiometer controls the maximum speed when the carriage is on a straight. Turning the dial clockwise to a higher number increases the speed.
- 10) **CORNER SPEED**

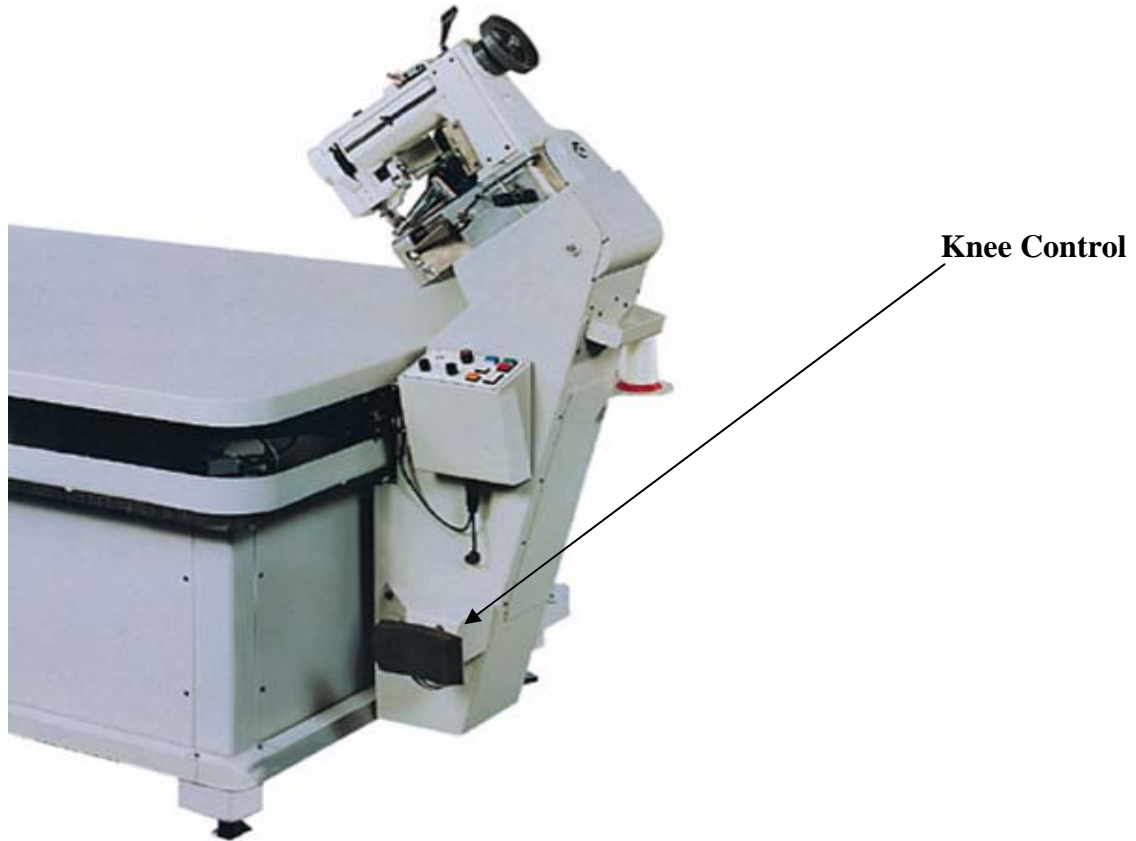
The corner speed potentiometer controls the maximum speed when the carriage is at a corner. Turning the dial clockwise to a higher number increases the speed.
- 11) **DRAG**

The drag control potentiometer controls the relative speeds of the sewing head and the carriage. Turning the dial clockwise (+) increase the carriage speed relative to the tape feed and turning the dial anticlockwise (-) reduces the carriage speed.
- 12) **HEAD UP/DOWN**

This is a three position toggle switch to change the angle of the sewing head. Pressing away from the operator raises the head and pulling towards the operator lowers the head.

## **Knee control**

The knee control regulates the operating speed of the machine. As the knee control pad is pressed in the carriage and sewing head will slow down, the more the pad is pressed the slower the carriage and sewing head will run. When fully pressed machine is stopped, and as the pad is allowed to move out the speed of the machine is increased to its maximum setting.





***Section 5***

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***Maintenance***

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# Section 5

## Maintenance



**WARNING:** Allow only qualified personnel to perform the following tasks. Observe and follow the safety instructions in this document and all other related documentation.

### 1. *Daily Maintenance*

Ensure that after every shift that machine is wiped clean.

### 2. *Weekly Maintenance*

Oil sewing head as per instructions in sewing head manual. Check for loose nuts and bolts on head, carriage and machine. These can come loose due to the vibration.

### 3. *Monthly Maintenance*

Grease the frog grease nipples. (bracket with guide wheels that holds the carriage to the frame of the machine) Grease the chain and the sprockets for the table up and down. Grease/oil any other moving parts/bearings.

## ***Section 6***

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# ***Troubleshooting***

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# Section 6

## Troubleshooting

**Contact MPTG service department:**

Mattress Production Technology Group Ltd.  
Newline Industrial Estate  
Newline  
Bacup  
Rossendale  
OL13 9RW

Telephone: 0044 (0) 1706 878558  
Fax: 0044 (0) 1706 878288

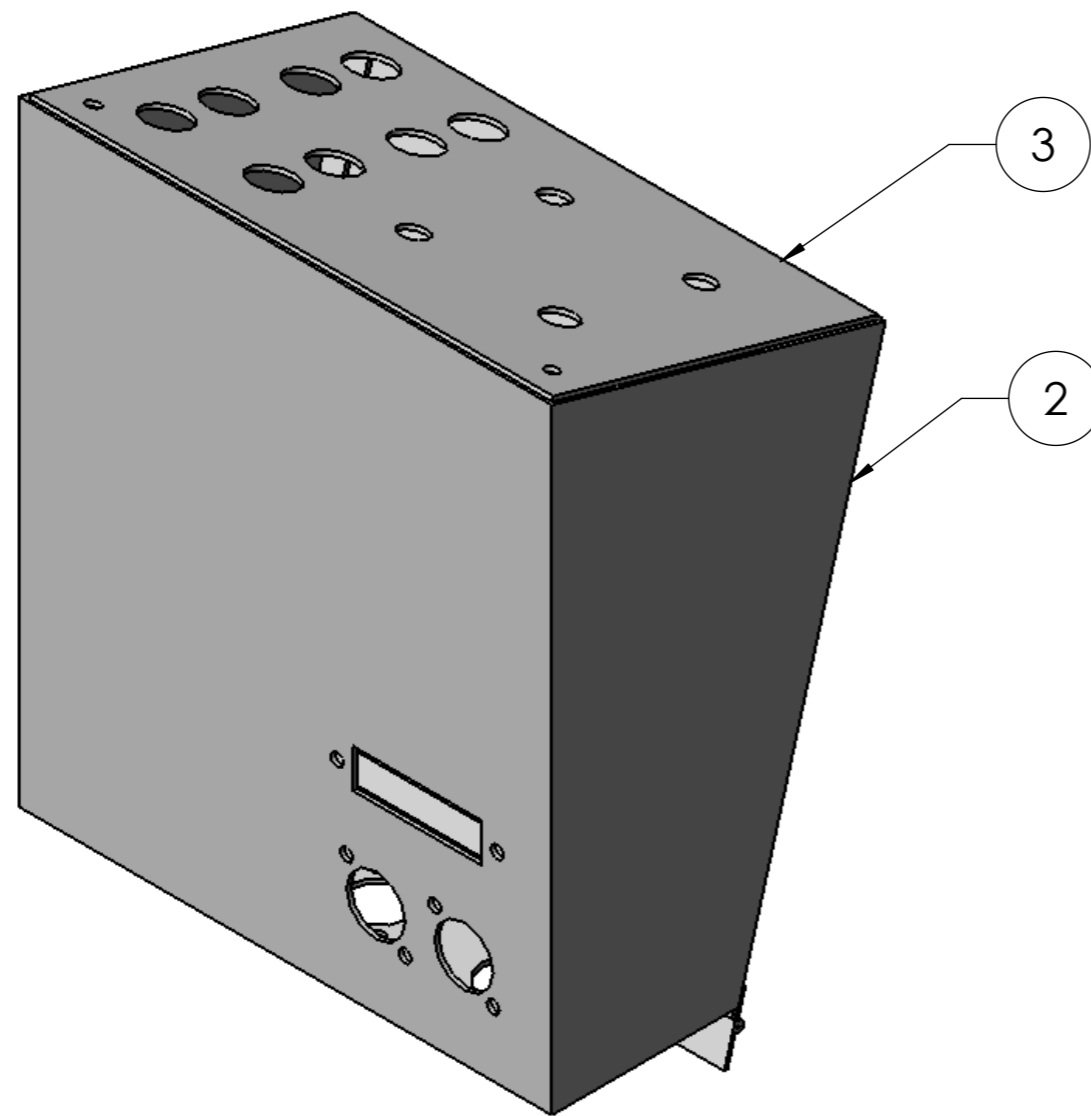
## ***Section 7***

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### ***Parts***

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	KIT-MTE-ELEC2-UT	CARRAIGE CONTROL STATION (BOM)	1
2	MTE-303A	STANDARD COVER	1
3	MTE-305	STANDARD HINGED COVER	1



THIS ASSEMBLY REQUIRES THE KIT LIST:  
 KIT-MTE-ELEC2-UT  
 CARRIAGE CONTROL STATION.

ALL UNTOLERANCED DIMENSIONS  
 ARE TO BE WITHIN  $\pm 0.39\text{mm}$   
 DO NOT SCALE DRAWING

THIRD ANGLE PROJECTION  
 REMOVE ALL BURRS AND SHARP EDGES

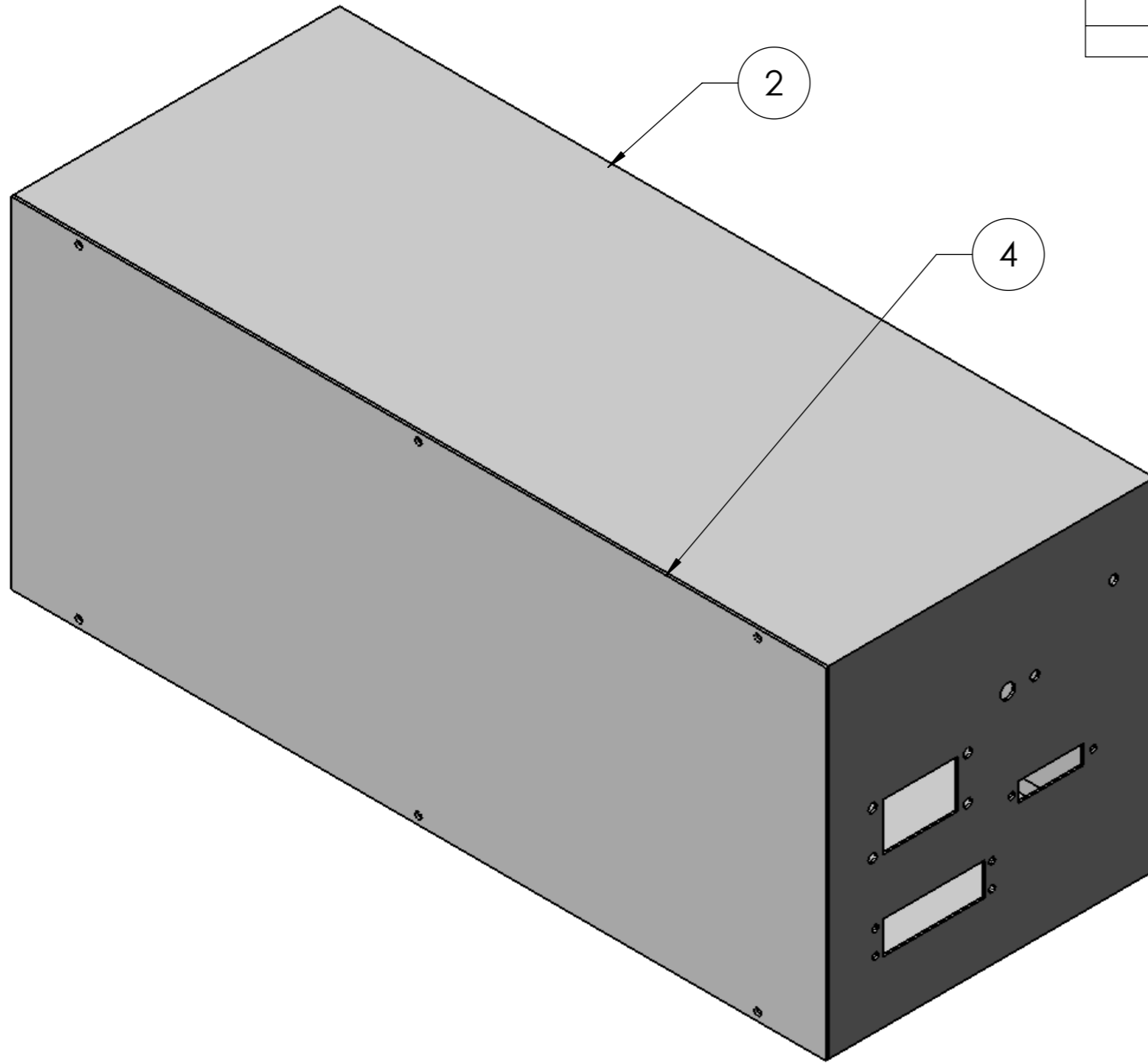


**MATTRESS PRODUCTION TECHNOLOGY GROUP**  
 New Line Industrial Estate, New Line,  
 Bacup, Lancashire, OL13 9RW,  
 TEL: +44 (0)1706 878558 FAX: +44 (0)1706 878288

NAME	SIGNATURE	DATE	ASSY NO:
S.PEEL		06/02/2007	
CHK'D			
APPV'D			
MFG			
NO. OFF	FINISH:	MATERIAL:	DWG NO.
1	SURFACE FINISH:	WEIGHT:	MTEE-002 UT

TITLE: <b>CARRAIGE CONTROL STATION</b>	
ISSUE:	A3
SCALE:1:5	SHEET 1 OF 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	KIT-MTE-ELEC1-UT	MAIN ELECTRICAL PANEL (BOM)	1
2	MTE-255	CONTROL ENCLOSURE	1
3	MTE-255A	BACKPLATE	1
4	MTE-255B	ENCLOSURE LID	1



THIS ASSEMBLY REQUIRES THE KIT LIST:  
 KIT-MTE-ELEC1-UT  
 MAIN ELECTRICAL PANEL (BOM)

ALL UNTOLERANCED DIMENSIONS  
 ARE TO BE WITHIN  $\pm 0.39\text{mm}$   
 DO NOT SCALE DRAWING

THIRD ANGLE PROJECTION  
 REMOVE ALL BURRS AND SHARP EDGES



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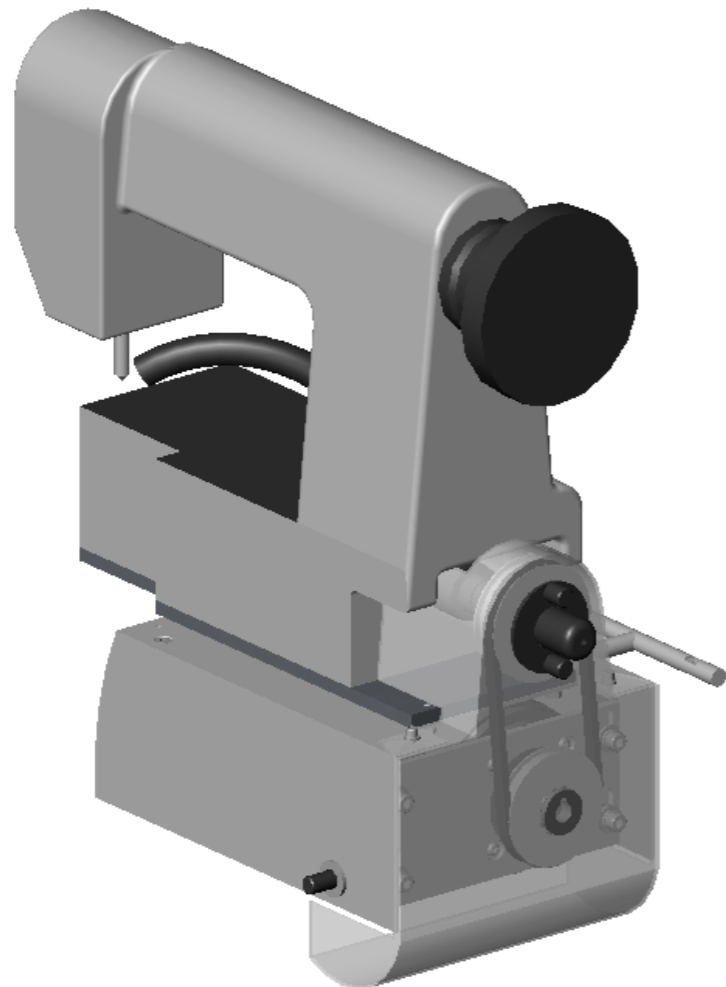
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DRAWN	S.PEEL		06/02/2007	
CHK'D				
APPV'D				
MFG				
NO. OFF	FINISH:	MATERIAL:	DWG NO.	
1	SURFACE FINISH:	WEIGHT:	MTEE-001 UT	ISSUE:
			SCALE:1:10	SHEET 1 OF 1

MAIN ELECTRICAL PANEL

A3

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	MTE-191A	MAIN BODY	1
2	MTE-211	MOTOR BASE PLATE PACKER	2
3	MTE-194	SEWING HEAD MOTOR	1
4	B18.22M - Plain washer, 8 mm, narrow		4
5	B18.22M - Plain washer, 12 mm, narrow		2
6	B18.22M - Plain washer, 6 mm, narrow		8
7	B18.22M - Plain washer, 5 mm, narrow		2
8	SPRING WASHER (M8)	DIFFERENT SIZE SPRING WASHERS	4
9	SPRING WASHER (M6)	DIFFERENT SIZE SPRING WASHERS	8
10	SPRING WASHER (M5)	DIFFERENT SIZE SPRING WASHERS	2
11	B18.3.1M - 8 x 1.25 x 25 Hex SHCS -- 25CHX		4
12	B18.3.1M - 6 x 1.0 x 12 Hex SHCS -- 12CHX		4
13	B18.3.1M - 5 x 0.8 x 12 Hex SHCS -- 12CHX		2
14	B18.3.1M - 4 x 0.7 x 25 Hex SHCS -- 25CHX		2
15	B18.3.4M - 6 x 1.0 x 12 SBHCS --N		4
16	MTE-288	SEWING HEAD DRIVE PULLEY	1
17	MTE-605		1
18	MTE-600		1
19	MTE-202	LINEAR ACTUATOR BRKT	1
20	B18.3.5M - 6 x 1.0 x 12 Socket FCHS -- 12N		2

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
21	MTE-149A	ACTUATOR BRKT PIVOT PIN	1
22	B27.7M - 3AM1-6		2
23	B27.7M - 3AM1-12		2
24	MTE-149	HEAD TILT PIVOT PIN	2
25	B18.3.6M - M6 x 1.0 x 8 Hex Socket Flat Pt. SS --N		2
26	B18.3.6M - M6 x 1.0 x 6 Hex Socket Flat Pt. SS --N		2
27	MTE-175-ASSY	BLOW PIPE ASSEMBLY	1
28	MTE-274	THREAD GUIDE	1
29	MTE-210	SEWING HEAD BASE PLATE	1
30	B18.2.3.2M - Formed hex screw, M6 x 1.0 x 16 -- 16CN		4
31	MTE-400	SEWING MACHINE	1
32	MTE-201	MOTOR SHAFT EXTENSION	1
33	MTE-289	SEWING HEAD DRIVE PULLEY	1
34	MTE-196	CLUTCH HOUSING	1
35	BT-585	NEEDLE ROLLER BEARING, RCB 101416	1
36	M4 CLINCH NUT	M4 CLINCH NUT	2
37	RS686840	Phenolic thumb knob, 14mm dia x M4	2
38	MTE-190	HEAD COVER	1
39	MTE-175A	COPPER BLOW PIPE	1
40	DE0051	DE0006, 0.37KW 4 POLE 415/3/50 B14/71 E/MOTOR	1
41	MTE-540	TIMING BELT 16T10530	1



**THIS ASSEMBLY IS REQUIRED FOR:  
UNDERTABLE AND LOW HEIGHT  
MACHINES**

ALL UNTOLERANCED DIMENSIONS  
ARE TO BE WITHIN ± 0.39mm  
DO NOT SCALE DRAWING

THIRD ANGLE PROJECTION

REMOVE ALL BURRS AND SHARP EDGES

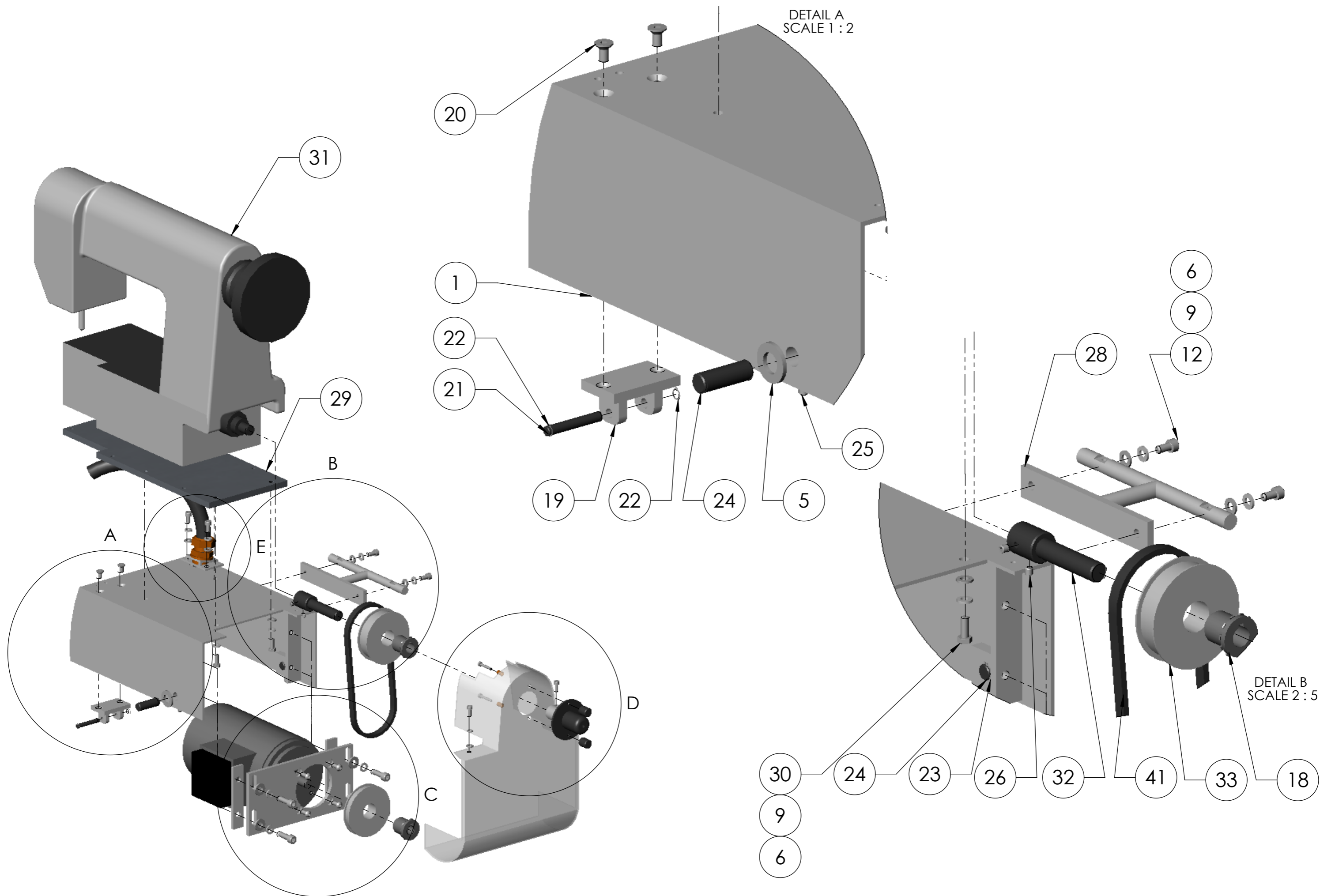


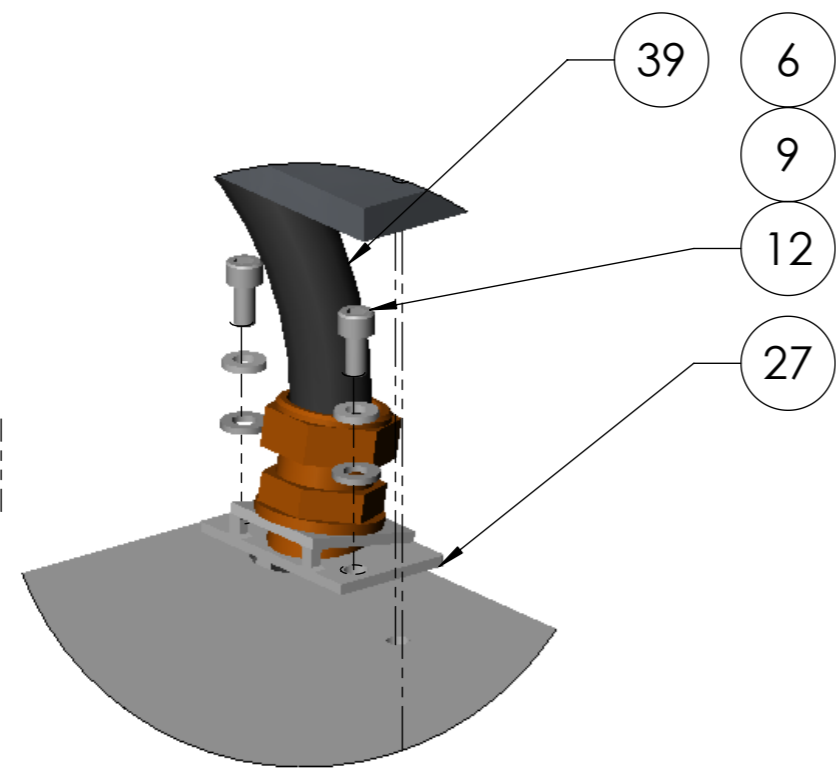
**MATTRESS PRODUCTION TECHNOLOGY GROUP**  
New Line Industrial Estate, New Line,  
Bacup, Lancashire, OL13 9RW,  
TEL: +44 (0)1706 878558 FAX: +44 (0)1706 878288

NAME	SIGNATURE	DATE	ASSY NO:
S.PEEL		25/01/2007	
CHK'D			
APPV'D			
MFG			
NO. OFF	FINISH:	MATERIAL:	DWG NO.
1	SURFACE FINISH:	WEIGHT:	MTEA-007 UT & LH

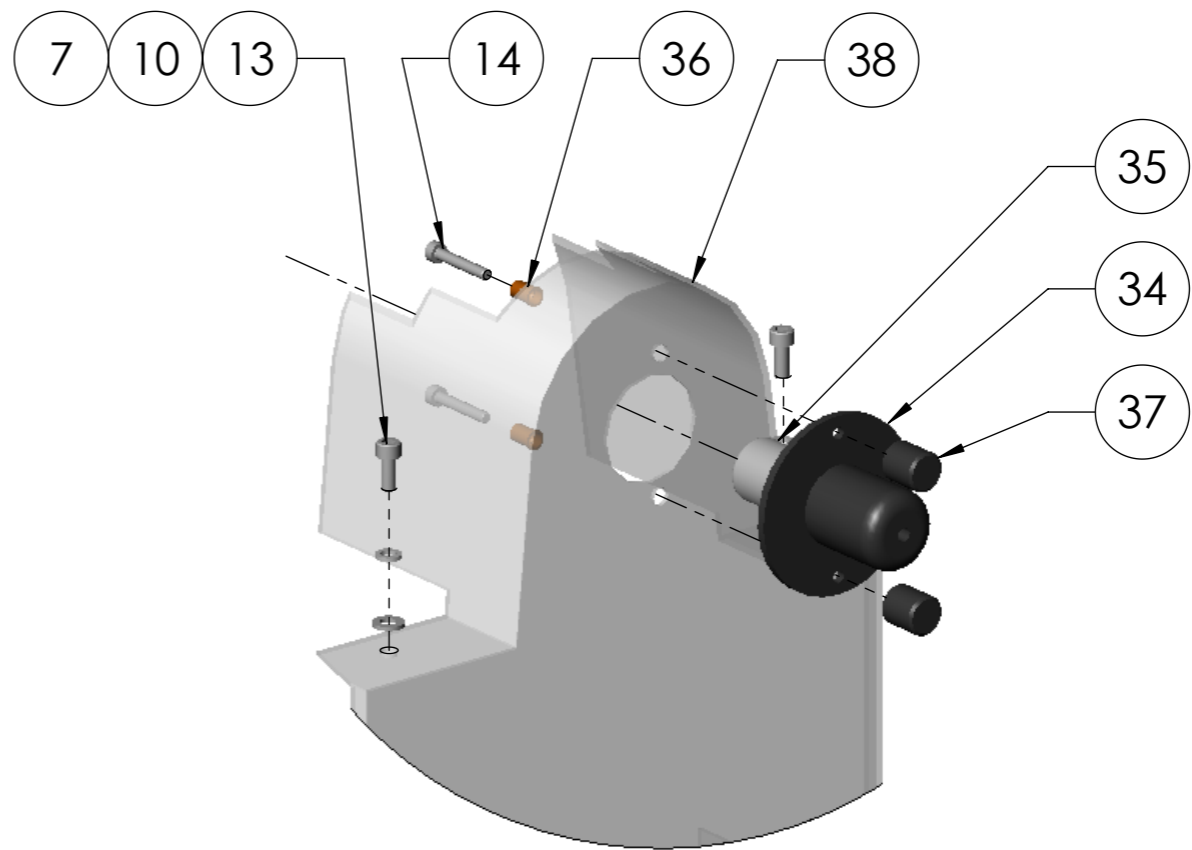
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ASSEMBLY OF SEWING HEAD TILT	ISSUE:
SCALE:1:10	SHEET 1 OF 3



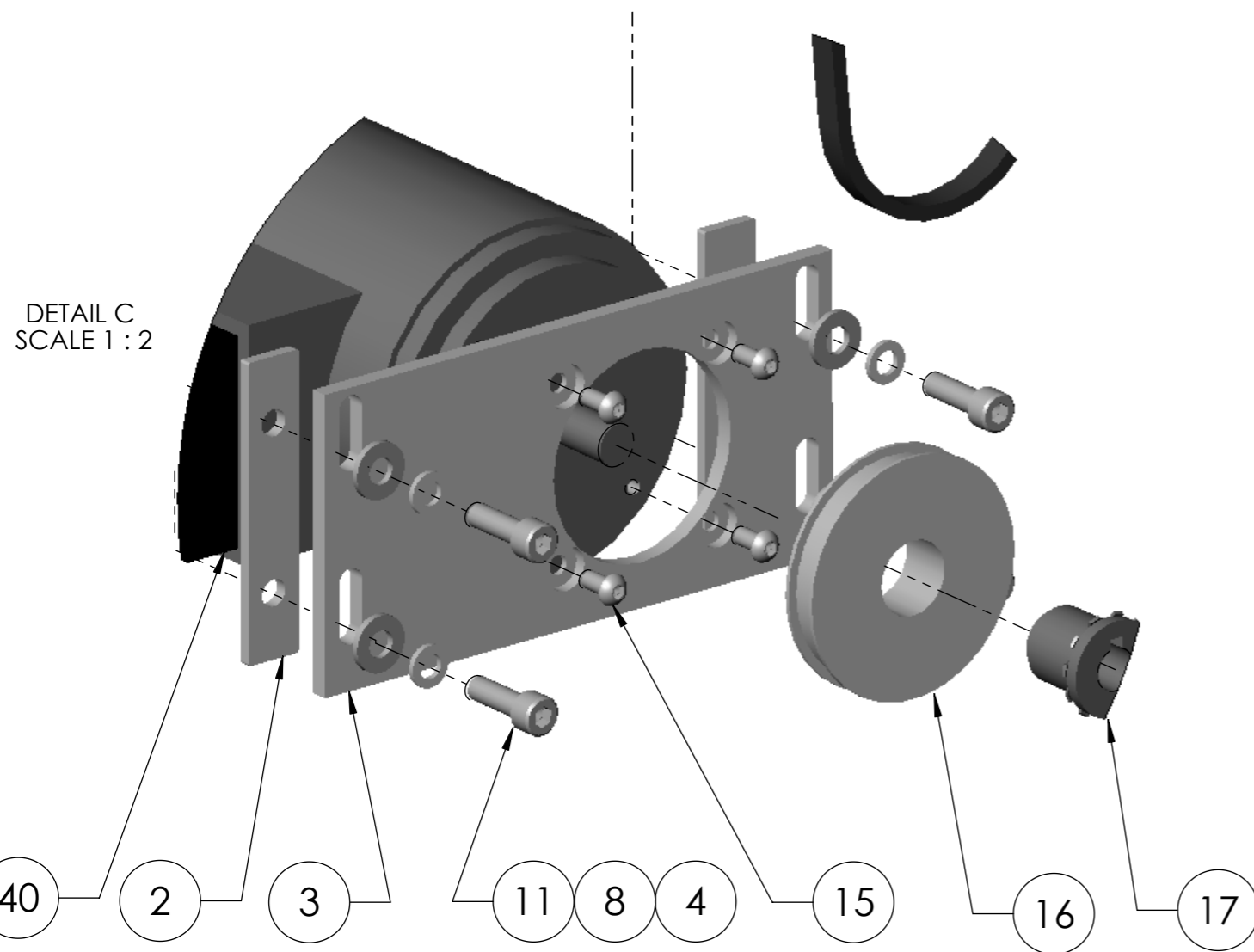




DETAIL E  
SCALE 1 : 2

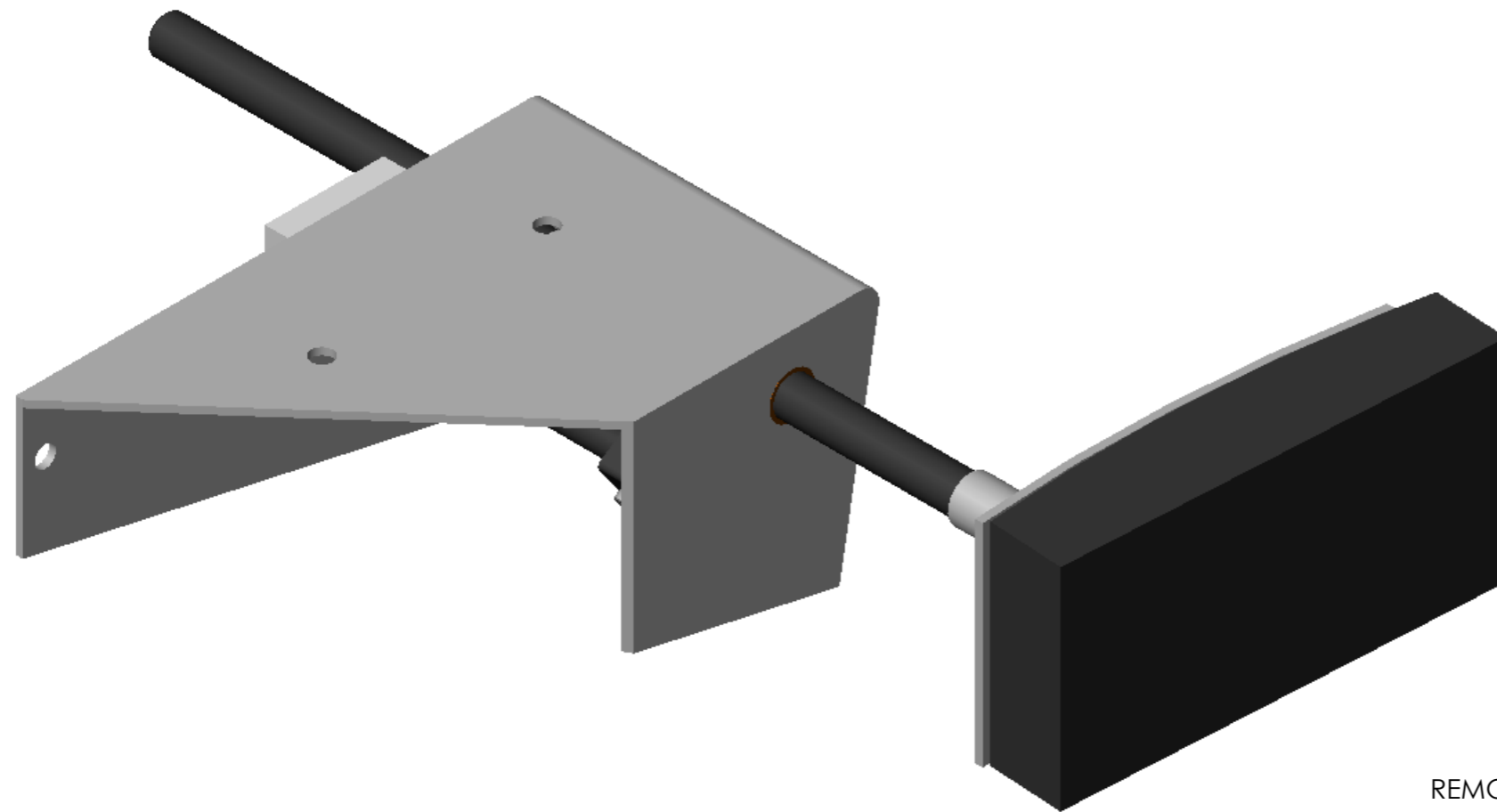


DETAIL D  
SCALE 2 : 5



DETAIL C  
SCALE 1 : 2

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	MTE-262	KNEE PAD HOUSING	1
2	MTE-525	ALL OLITE BUSH BEARINGS	2
3	MTE-140C	KNEE PAD SHAFT	1
4	MTE-165	KNEE PAD BRACKET	1
5	B18.3.6M - M10 x 1.5 x 10 Hex Socket Flat Pt. SS --N		1
6	B18.3.6M - M8 x 1.25 x 10 Hex Socket Flat Pt. SS --N		2
7	MTE-185	KNEE PAD SPRING	1
8	MTE-140A	TIE BRKT KNEE PAD ASSY	1
9	B18.22M - Plain washer, 16 mm, narrow		2
10	SPRING WASHER (M8)	DIFFERENT SIZE SPRING WASHERS	1
11	B18.3.1M - 8 x 1.25 x 35 Hex SHCS -- 35CHX		1
12	MTE-140B	GUIDE SHAFT	1
13	MTE-575	1/2" STD COLLAR	1
14	NR104	KNEE PAD SPONGE	1
15	MTE-316	KNEE PAD PLASTIC BRACKET	1



**THIS ASSEMBLY IS REQUIRED FOR:  
ALL MATRAMAX MACHINES**

ALL UNTOLERANCED DIMENSIONS  
ARE TO BE WITHIN  $\pm 0.39\text{mm}$   
DO NOT SCALE DRAWING

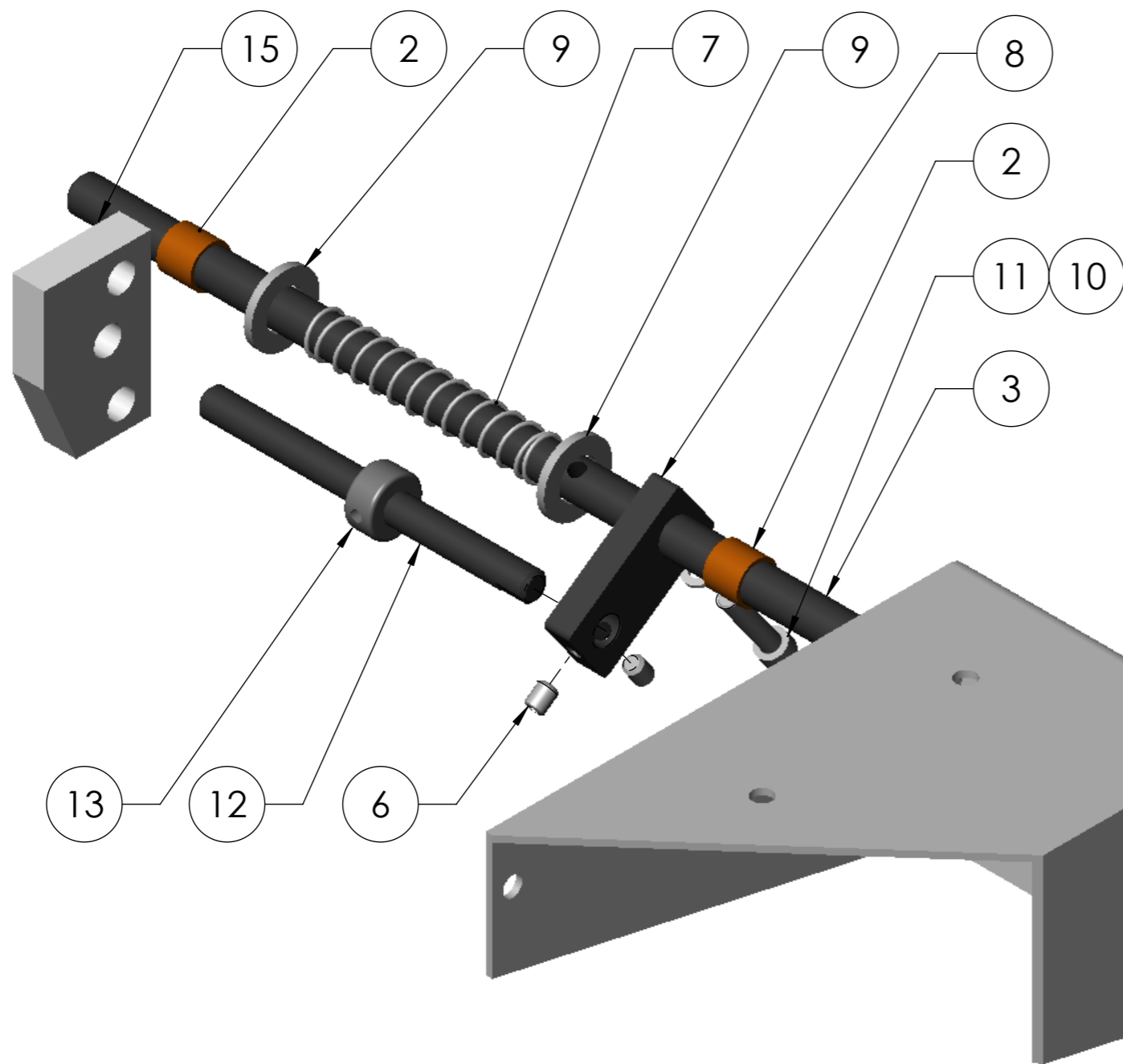
THIRD ANGLE PROJECTION  
REMOVE ALL BURRS AND SHARP EDGES



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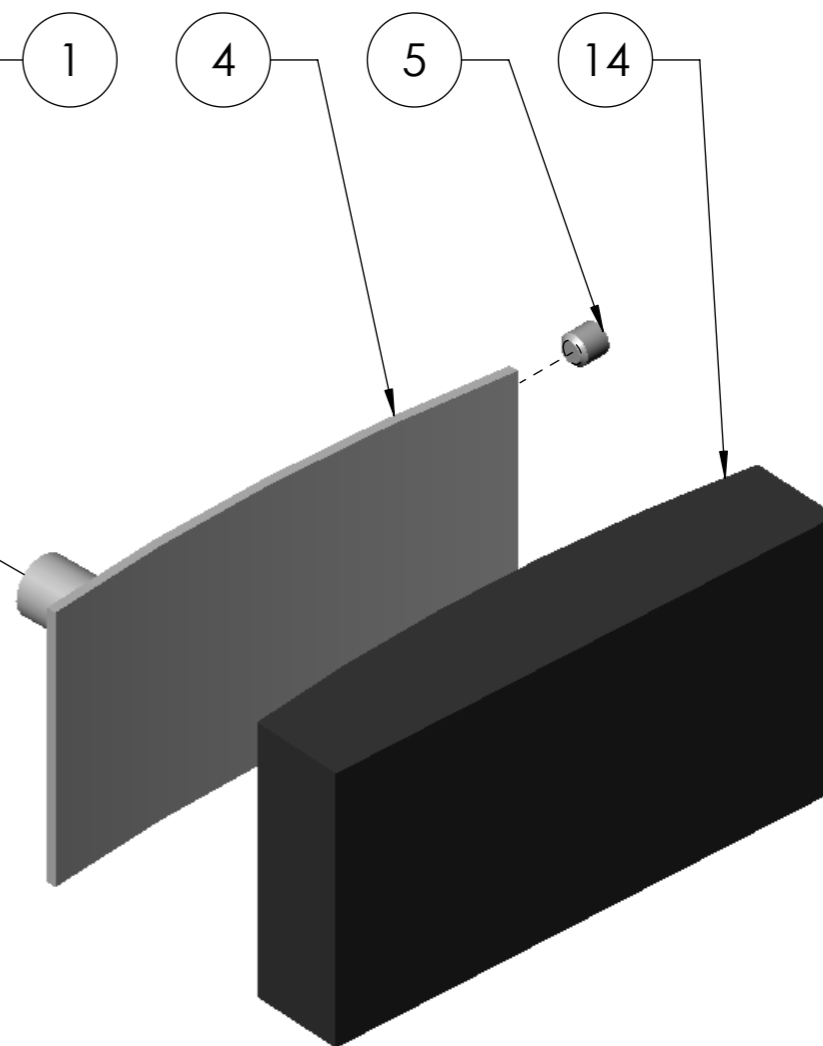
NAME	SIGNATURE	DATE	ASSY NO:
S.PEEL		06/02/2007	
CHK'D			
APPV'D			
MFG			
NO. OFF	FINISH:	MATERIAL:	DWG NO.
1	SURFACE FINISH:	WEIGHT:	MTEA-006

TITLE: <b>KNEE PAD ASSEMBLY</b>		A3
SCALE:1:10	ISSUE:	SHEET 1 OF 2



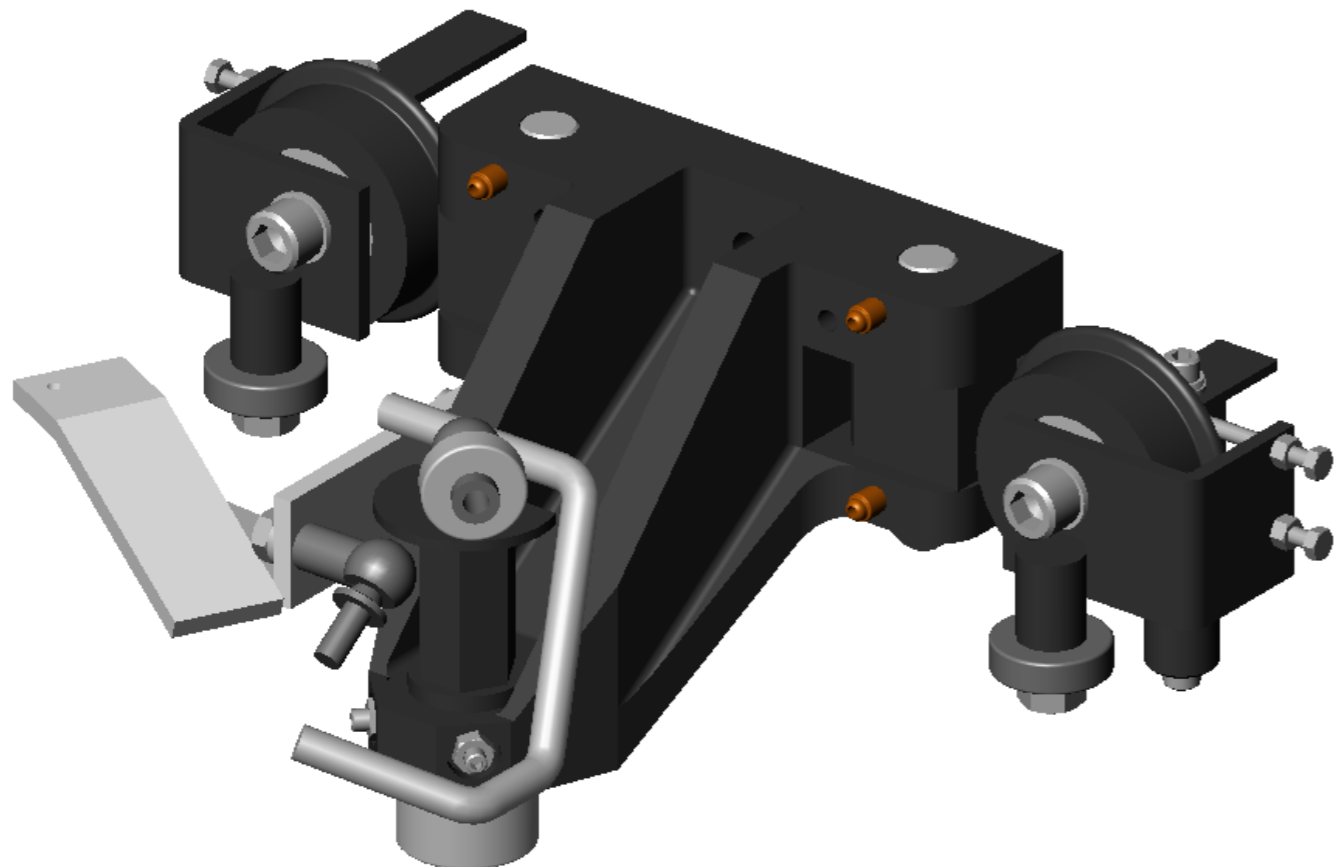
NOTE: MTE-140A NEEDS DRILLING WHEN LINED UP WITH THE HOLE IN MTE-140C. MTE-140C NEEDS TO BE TAPPED M8 THRU ALL.

NOTE: MTE-316, IS TO BE FITTED ON THE INSIDE OF THE CARRIAGE.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	MTE-100	CARRIAGE SUPPORT ARM (DEMONSTRATION)	1
2	MTE-106	CARRIAGE SUPPORT CRANK PIN	2
3	MTE-104LH	SUPPORT ARM CRANK	1
4	MTE-104RH	SUPPORT ARM CRANK	1
5	MTE-590	THRUST BEARINGS	2
6	GREASE NIPPLE	M6 GREASE NIPPLE	4
7	B18.3.6M - M8 x 1.25 x 12 Hex Socket Flat Pt. SS --N		2
8	B18.3.6M - M6 x 1.0 x 20 Hex Socket Flat Pt. SS --N		2
9	MTE-510	BEARING 1117-1/2	2
10	MTE-107	CARRIAGE WHEELS	2
11	MTE-105LH	SUPPORT BEARING CARRIER	1
12	MTE-105RH	SUPPORT BEARING CARRIER	1
13	SPRING WASHER (M12)	DIFFERENT SIZE SPRING WASHERS	2
14	SPRING WASHER (M6)	DIFFERENT SIZE SPRING WASHERS	4
15	SPRING WASHER (M10)	DIFFERENT SIZE SPRING WASHERS	2
16	B18.3.1M - 12 x 1.75 x 50 Hex SHCS -- 50CHX		2
17	B18.3.1M - 6 x 1.0 x 12 Hex SHCS -- 12CHX		2
18	B18.3.1M - 6 x 1.0 x 70 Hex SHCS -- 70CHX		1
19	MTE-153	CATCH FOR PROXIMITY SWITCH	1
20	MTE-153B	CATCH FOR PROXIMITY SWITCH	1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
21	B18.22M - Plain washer, 6 mm, narrow		4
22	MTE-193	GUIDE ROLLER	1
23	MTE-108	CAM FOLLOWER COLLAR	1
24	MTE-109	WASHER	1
25	B18.2.4.1M - Hex nut, Style 1, M6 x 1 --D-N		2
26	B18.2.4.1M - Hex nut, Style 1, M10 x 1.5, with 16mm WAF --D-N		2
27	B18.2.4.1M - Hex nut, Style 1, M5 x 0.8 --D-N		4
28	MTE-515	SINGLE ROW RADIAL BALL BEARINGS	2
29	B18.2.3.5M - Hex bolt M5 x 0.8 x 35 --16N		4
30	MTE-144A	BEARING EXTENSION LINK CONN NUT	1
31	MTE-144B	LINK ARM, BRG SUPP PLATE	1
32	B18.22M - Plain washer, 8 mm, narrow		1
33	RS689417	JOINT BALL & SOCKET, 8mm	1
34	MTE-505	CAM FOLLOWER BEARINGS	1
35	MTE-171-ASSY	ASSEMBLY OF TRUNKING SUPPORT	1
36	RS689417	JOINT BALL & SOCKET, 8mm	1
37	MTE-500	BEARING, 0/D 1 1/8" X I/D 1/2" X 3/8"	1
38	SPRING WASHER (M8)	DIFFERENT SIZE SPRING WASHERS	1
39	B18.2.3.2M - Formed hex screw, M8 x 1.25 x 16 --16CN		1
40	B18.3.1M - 6 x 1.0 x 25 Hex SHCS -- 25CHX		2



**THIS ASSEMBLY IS REQUIRED FOR:  
UNDERTABLE MACHINE**

ALL UNTOLERANCED DIMENSIONS  
ARE TO BE WITHIN ± 0.39mm  
DO NOT SCALE DRAWING

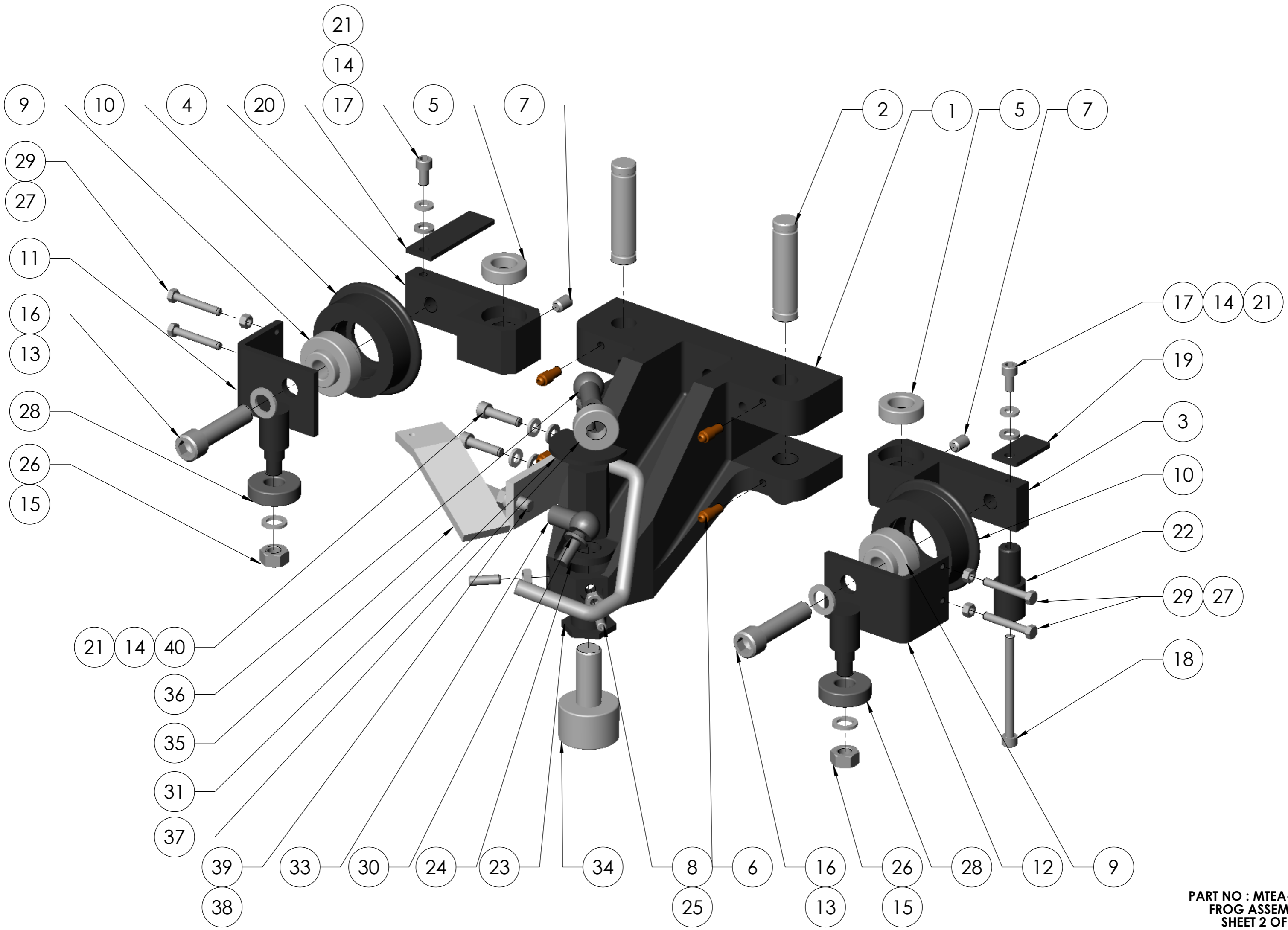
THIRD ANGLE PROJECTION  
REMOVE ALL BURRS AND SHARP EDGES

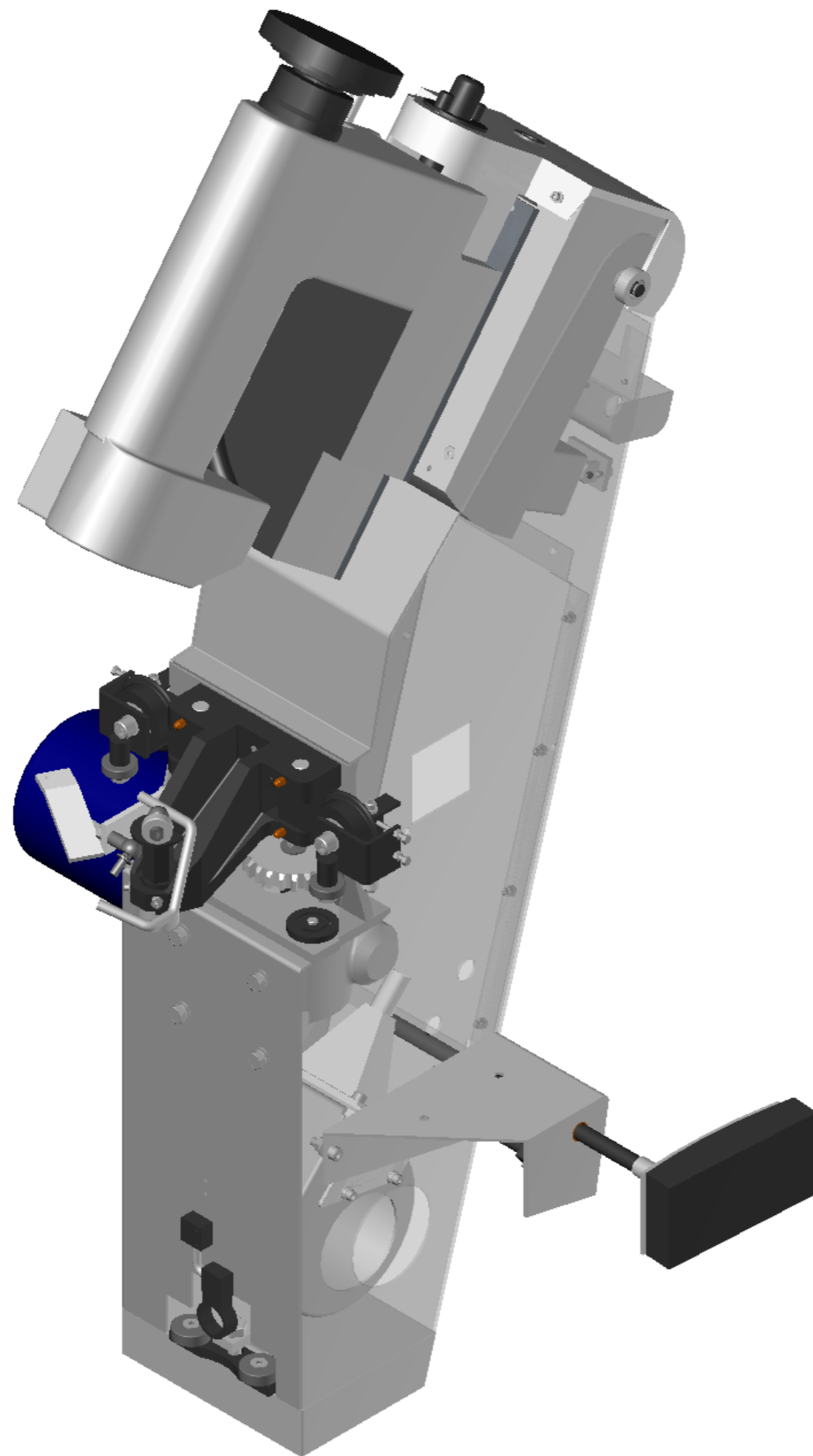


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New Line Industrial Estate, New Line,  
Bacup, Lancashire, OL13 9RW,  
TEL: +44 (0)1706 878558 FAX: +44 (0)1706 878288

NAME	SIGNATURE	DATE	ASSY NO:
S.PEEL		06/02/2007	
CHK'D			
APPV'D			
MFG			
NO. OFF	FINISH:	MATERIAL:	DWG NO.
1	SURFACE FINISH:	WEIGHT:	MTEA-005 UT

TITLE:	<b>FROG ASSEMBLY</b>	
ISSUE:		A3
SCALE:1:10	SHEET 1 OF 2	





ALL UNTOLERANCED DIMENSIONS  
ARE TO BE WITHIN  $\pm 0.39\text{mm}$   
DO NOT SCALE DRAWING

THIRD ANGLE PROJECTION  
REMOVE ALL BURRS AND SHARP EDGES



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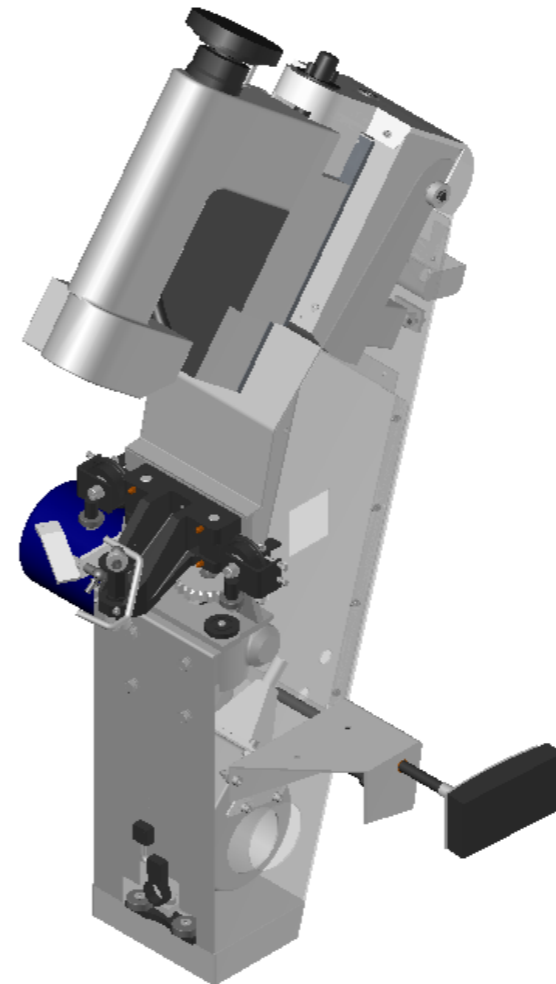
	NAME	SIGNATURE	DATE	ASSY NO:
DRAWN	S.PEEL		06/02/2007	
CHK'D				
APPV'D				
MFG				

TITLE:		<b>ASSEMBLY OF CARRIAGE</b>	
DWG NO.	<b>MTEA-004 UT</b>	ISSUE:	<b>A3</b>
SCALE:1:20	SHEET 1 OF 5		

NO. OFF	FINISH:	MATERIAL:
<b>1</b>	SURFACE FINISH:	WEIGHT:

ITEM NO.	PART NUMBER	DESCRIPTION	Default/QTY.
1	MTE-266	Carriage	1
2	DE0052	NMRV63 RATIO 40:1 B14/80	1
3	DE0053	T80 A4 0.55KW 4 POLE 415/3/50/B14	1
4	MTE-213	FIXING PLATE FOR MOTOR	1
5	MTE-214	NUT FOR FIXING PLATE	2
6	B18.22M - Plain washer, 10 mm, narrow		4
7	B18.22M - Plain washer, 6 mm, narrow		4
8	B18.22M - Plain washer, 12 mm, narrow		3
9	B18.22M - Plain washer, 8 mm, narrow		3
10	B18.22M - Plain washer, 5 mm, narrow		4
11	SPRING WASHER (M10)	DIFFERENT SIZE SPRING WASHERS	6
12	SPRING WASHER (M6)	DIFFERENT SIZE SPRING WASHERS	4
13	SPRING WASHER (M12)	DIFFERENT SIZE SPRING WASHERS	3
14	B18.2.3.2M - Formed hex screw, M10 x 1.5 x 30 --30CN		4
15	B18.2.3.2M - Formed hex screw, M6 x 1.0 x 12 --12CN		1
16	B18.2.3.2M - Formed hex screw, M12 x 1.75 x 35 --35CN		1
17	B18.2.3.2M - Formed hex screw, M12 x 1.75 x 30 --30CN		2
18	MTE-163	DRIVE SHAFT	1
19	MTE-204	CARRIAGE DRIVE GEAR	1
20	KEY 5 X 5 X 15-16" LG	KEY FOR MOTORS	1
21	KEY 8 X 7 X 20 LG	KEY FOR MOTORS	2
22	B27.7M - 3AM1-25		2
23	B27.7M - 3AM1-6		2
24	B27.7M - 3AM1-13	1/2" CIRLIP	2
25	B18.3.6M - M6 x 1.0 x 12 Hex Socket Flat Pt. SS --N		2
26	M6 x 25 x 1.50mm		1
27	MTE-102	STABILISING COLLAR	2
28	MTE-103	STABILISING COLLAR BEARING	2
29	B18.3.1M - 10 x 1.5 x 25 Hex SHCS -- 25CHX		2
30	B18.3.1M - 6 x 1.0 x 25 Hex SHCS -- 25CHX		2
31	B18.3.1M - 6 x 1.0 x 20 Hex SHCS -- 20CHX		2
32	B18.3.1M - 8 x 1.25 x 25 Hex SHCS -- 25CHX		7
33	MTE-202	LINEAR ACTUATOR BRKT	1
34	DE0064A	ACTUATOR	1
35	MTE-595	OILITE BUSH, O/D 3/8" X 1/4" I/D X 3/4" LG	1
36	MTE-149A	ACTUATOR BRKT PIVOT PIN	1
37	B18.3.4M - 6 x 1.0 x 16 SBHCS --N		2
38	B18.3.4M - 5 x 0.8 x 6 SBHCS --N		5
39	B18.3.4M - 5 x 0.8 x 16 SBHCS --N		4
40	MTE-176	BOBBIN STANDS	1
41	MTE-152	BOBBIN STAND PINS	2

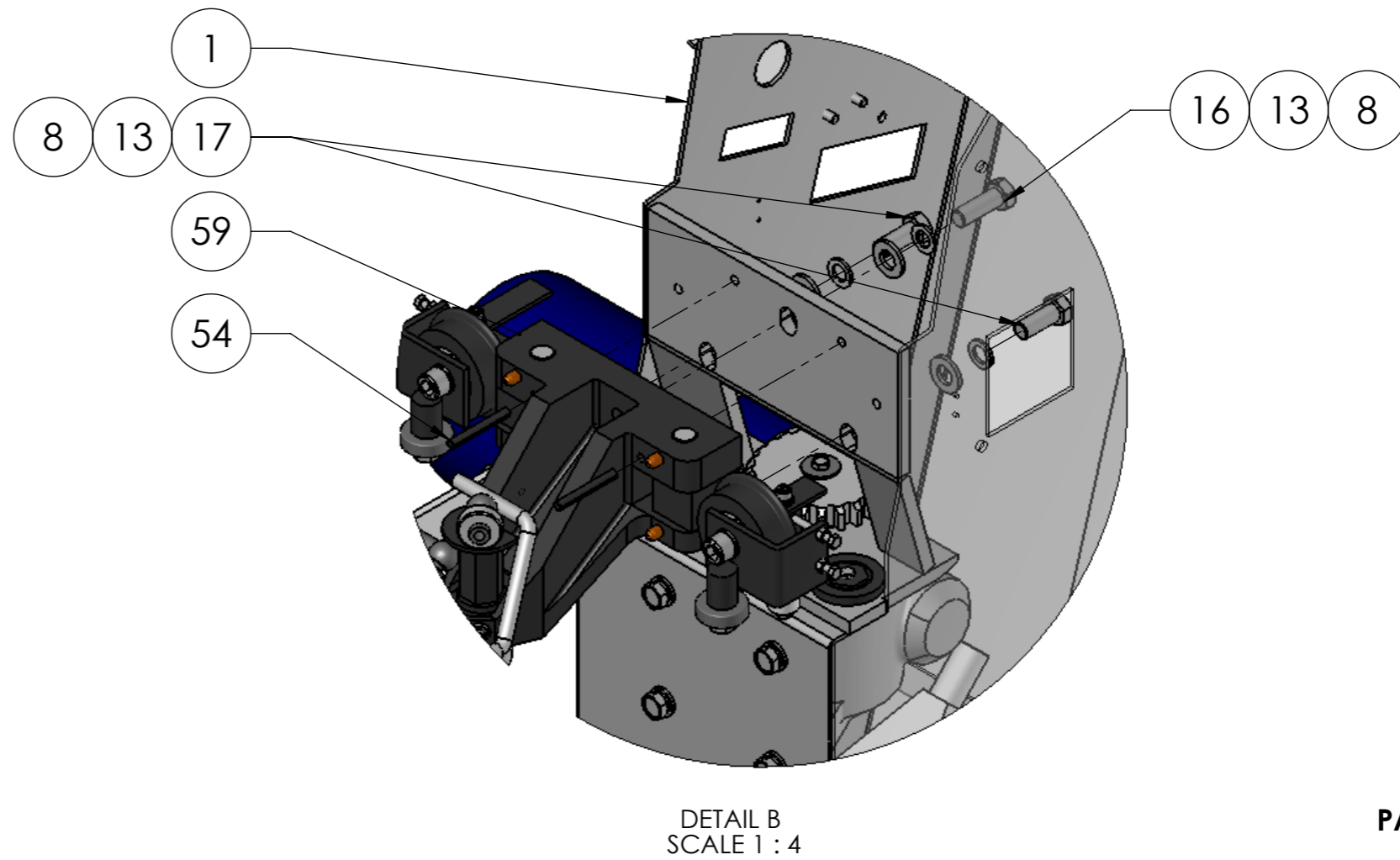
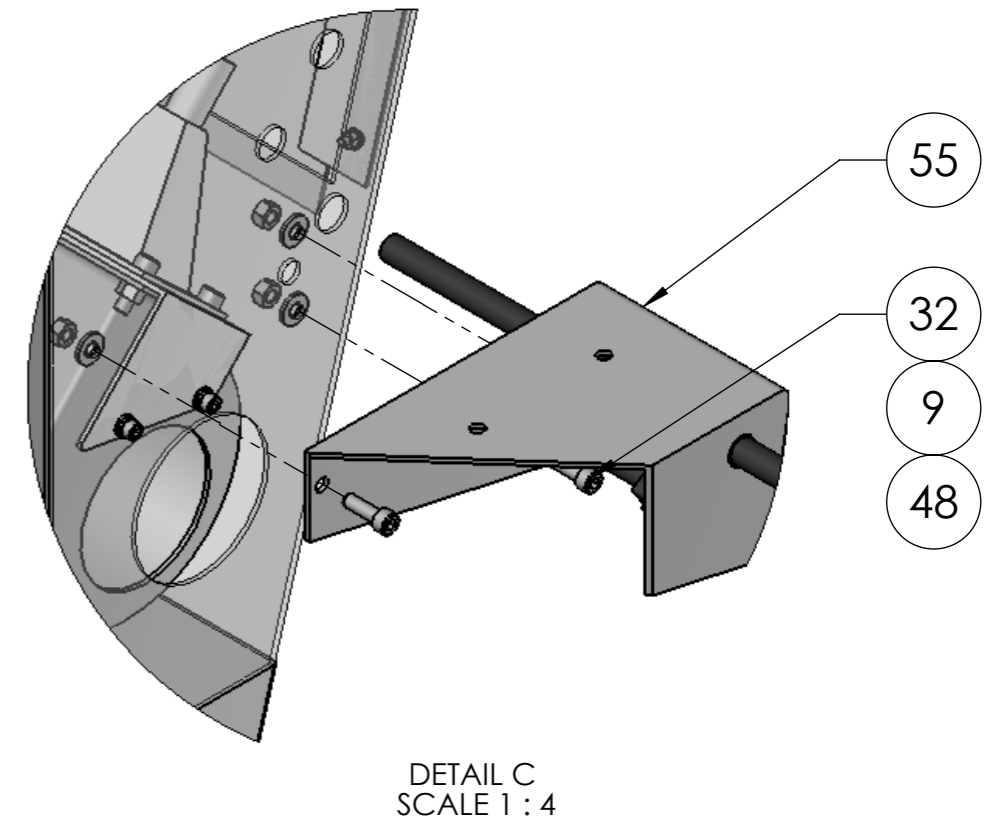
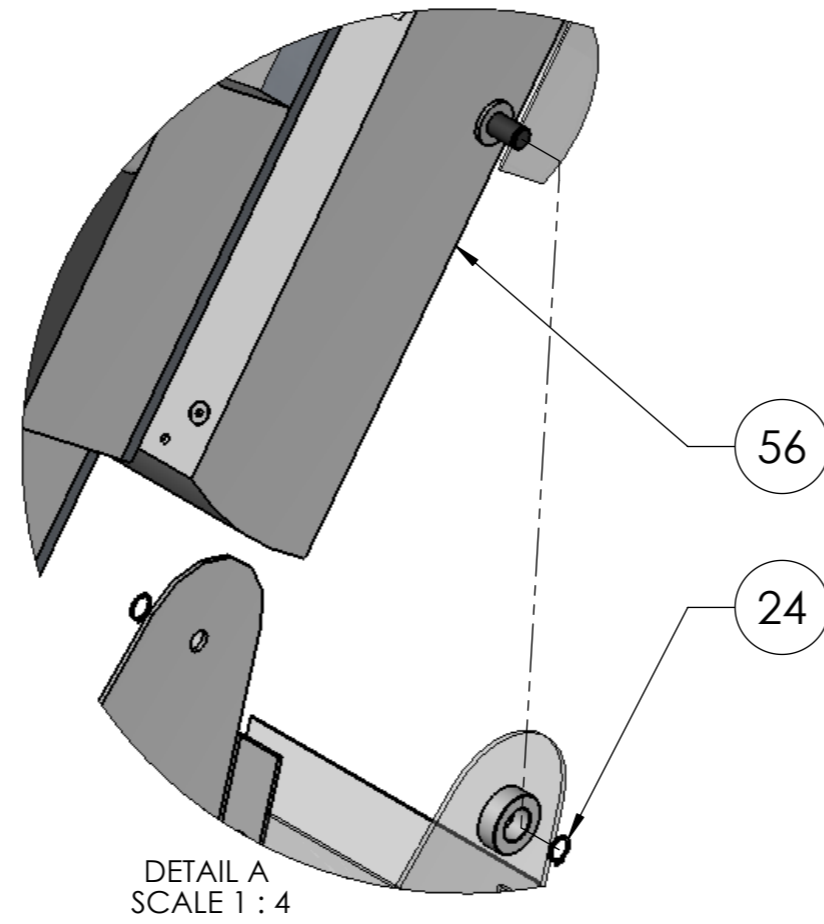
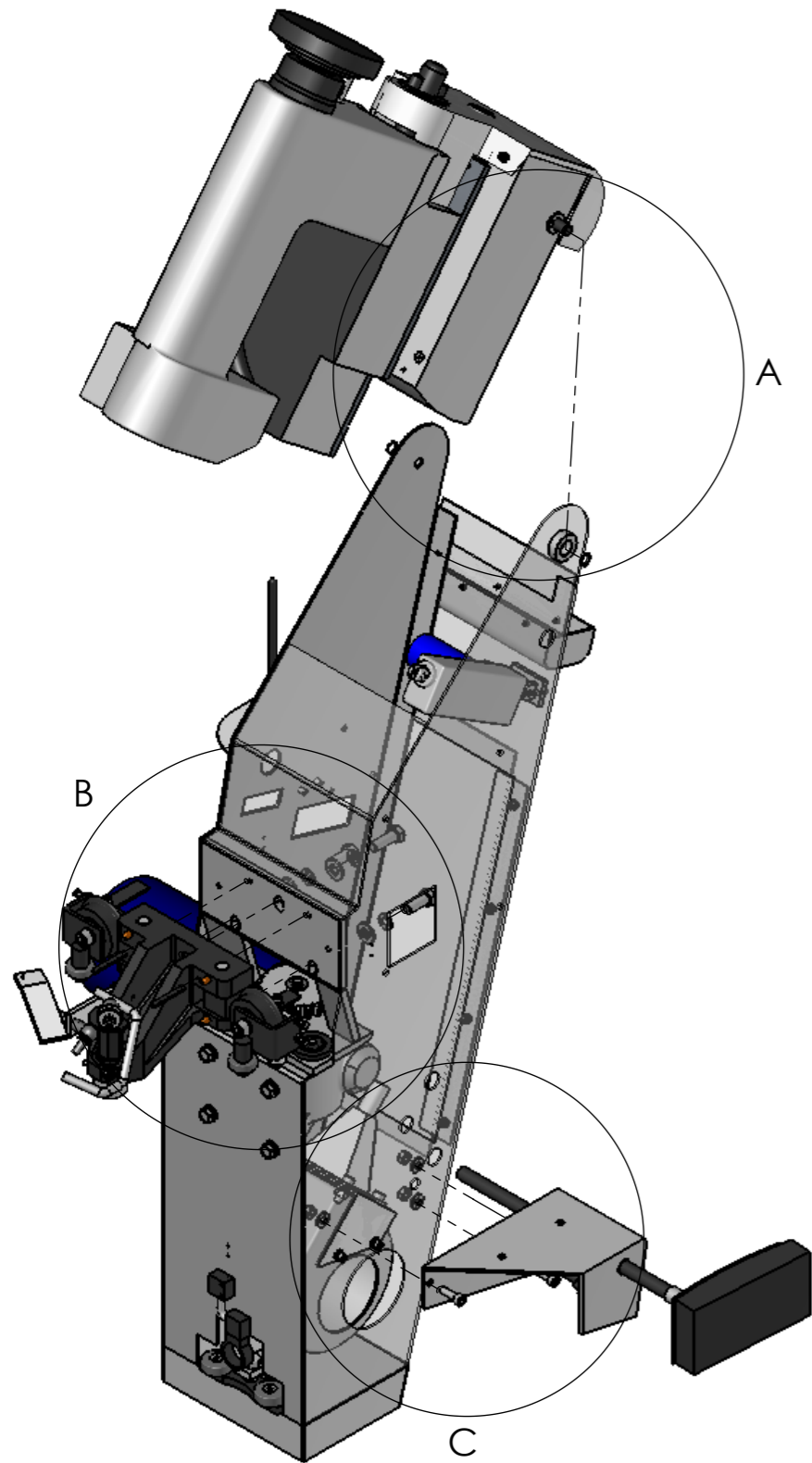
ITEM NO.	PART NUMBER	DESCRIPTION	Default/QTY.
42	B18.2.4.1M - Hex nut, Style 1, M8 x 1.25 --D-N		4
43	MTE-169	COVER PLATE	1
44	MTE-166	NEEDLE TRAY	1
45	MTE-264	FUNNEL BRACKET	1
46	MTE-263	FUNNEL	1
47	MTE260	BLOW MOTOR	1
48	B18.2.4.2M - Hex nut, Style 2, M8 x 1.25 --D-N		7
49	B18.2.4.2M - Hex nut, Style 2, M5 x 0.8 --D-N		4
50	MTE-180	CARRIAGE GUIDE BEARING SUPPORT	1
51	MTE-520	SINGLE ROW RADIAL BALL BEARINGS	2
52	B18.3.5M - 8 x 1.25 x 20 Socket FCHS -- 20N		2
53	M12 (45) SHOULDER BOLT	M12 X 30 (SHOULDER) M10 X 1.5 THREAD 15 LG	1
54	SELOC PIN, 1-4" X 2"	1/4" X 2", SELOC PIN	2
55	MTEA-006	KNEE PAD ASSEMBLY	1
56	MTEA-007 UT & LH	ASSEMBLY OF SEWING HEAD TILT	1
57	MTE-267	CARRIAGE DOOR	1
58	RS686-323	M6 X 10 LG THUMB SCREW	2
59	MTEA-005 UT	FROG ASSEMBLY	1
60	FAR3115379	UNIVERSAL SENSOR SUPP BRKT	1



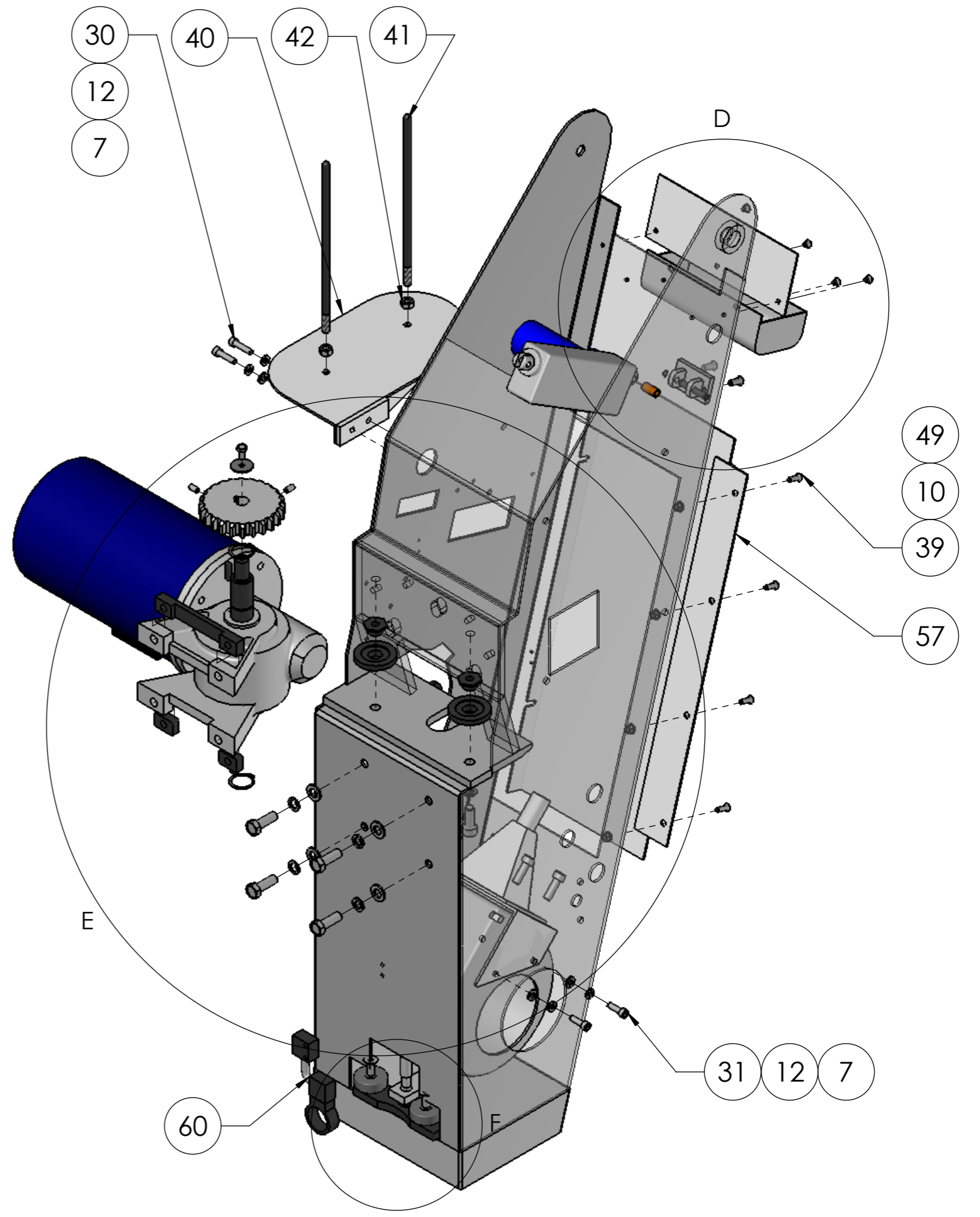
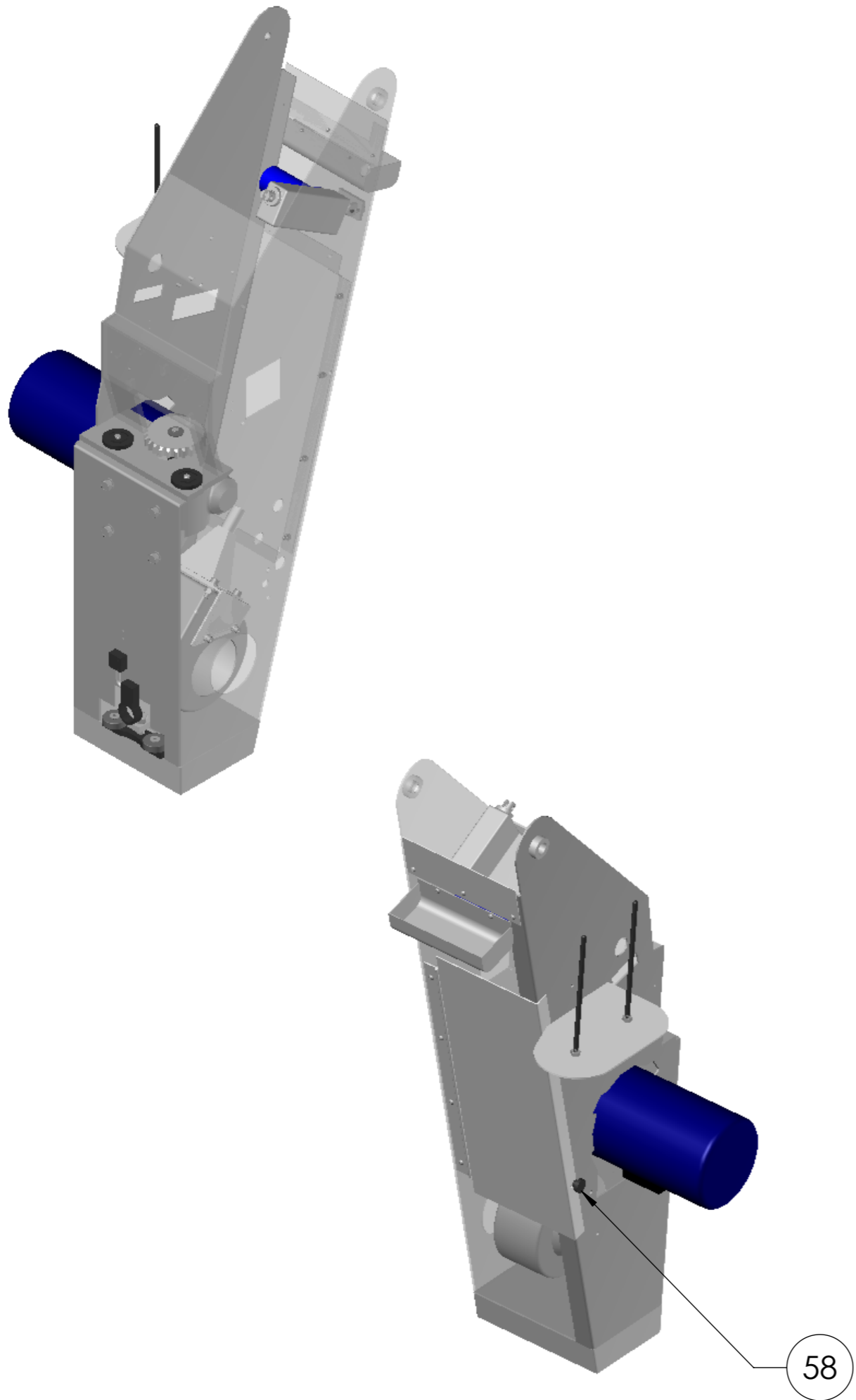
**PART NO - MTEA-004 UT  
BOM**

**SHEET 2 OF 5**

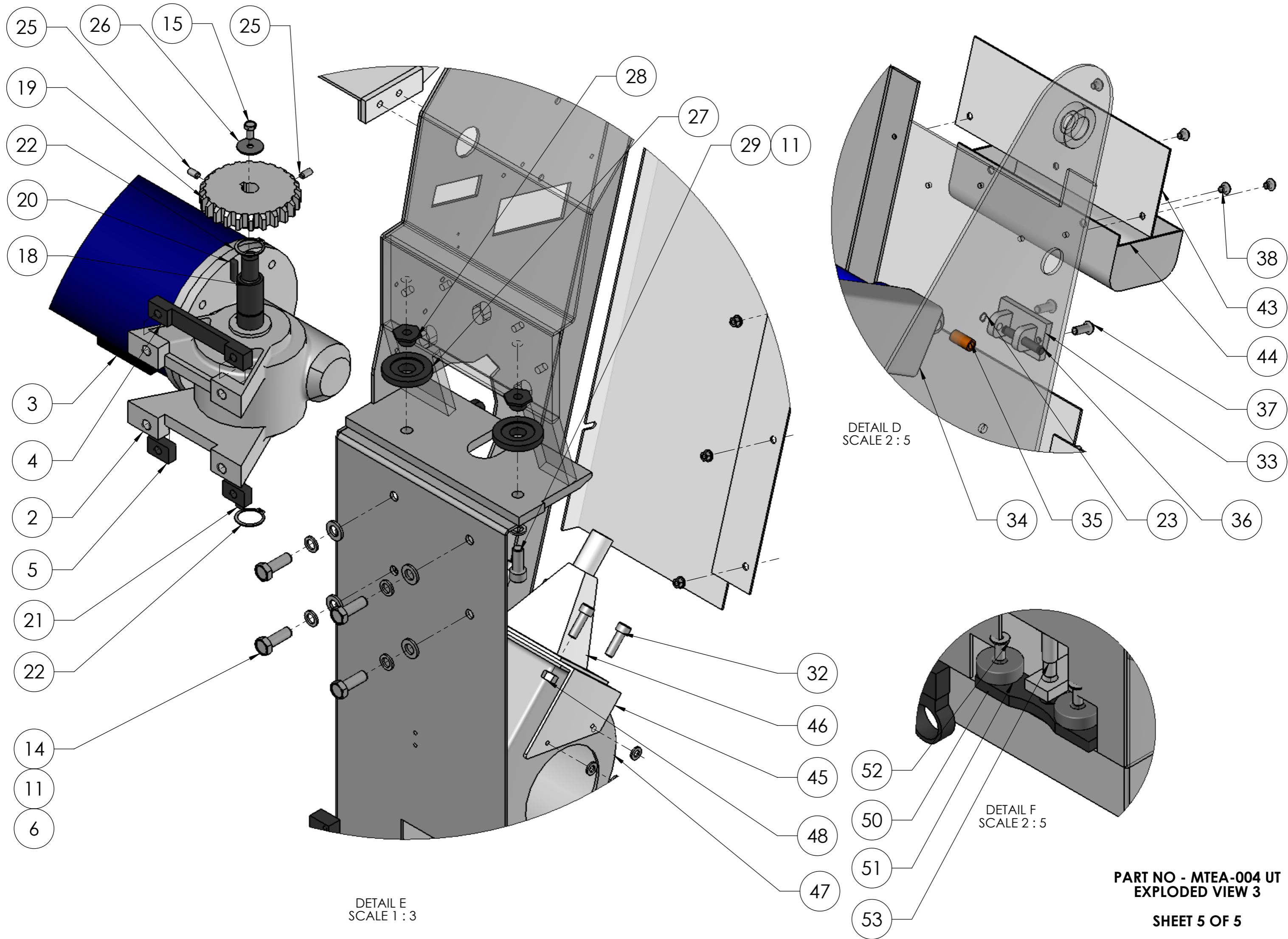




**PART NO - MTEA-004 UT  
EXPLODED VIEW 1**

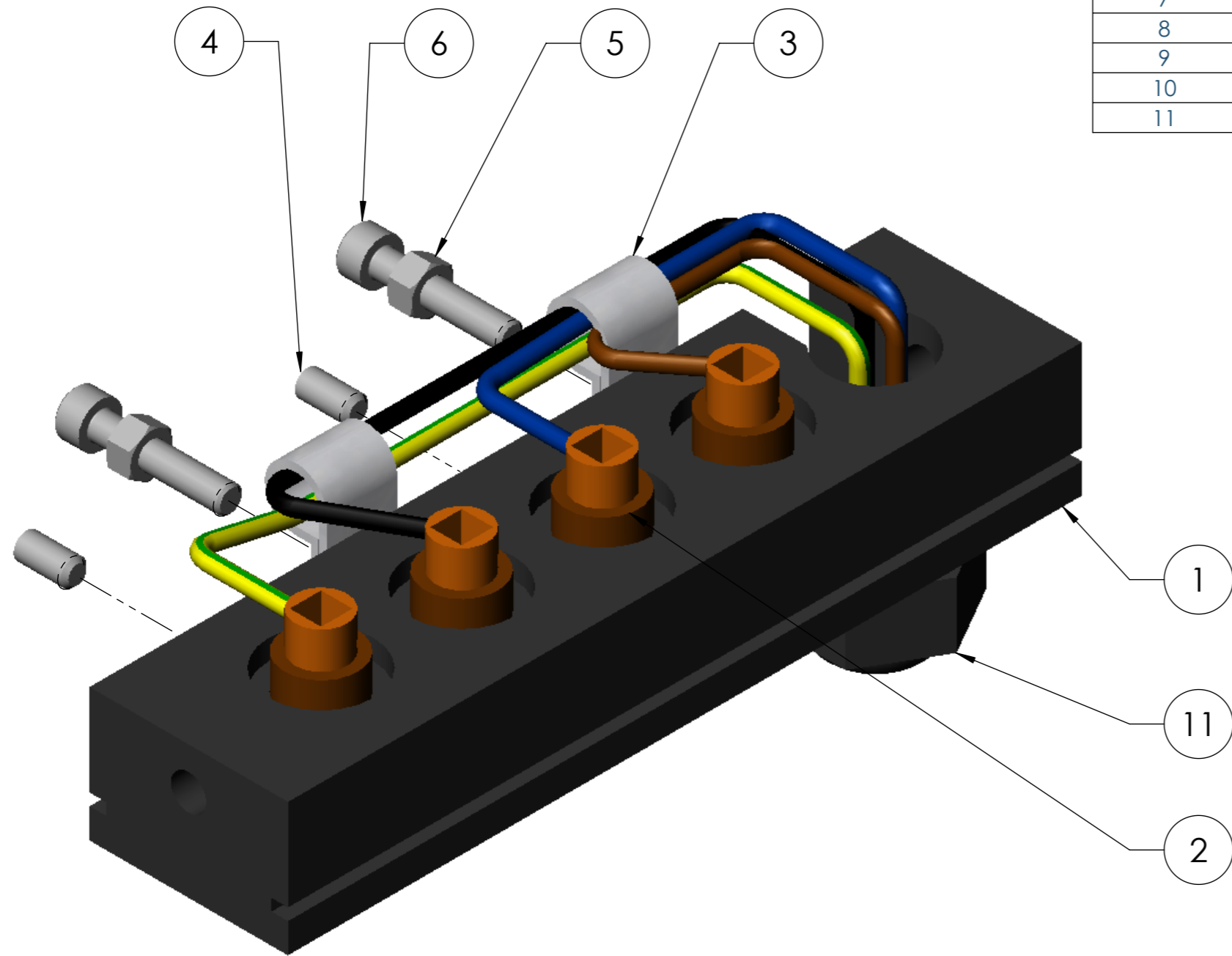


PART NO - MTEA-004 UT  
EXPLODED VIEW 2



**PART NO - MTEA-004 UT  
EXPLODED VIEW 3**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	MTE-131	BRUSH HOLDING BRACKET	1
2	BRUSH HOLDER	CARBON BRUSH HOLDER	4
3	WIRE BRKT		2
4	B18.3.6M - M5 x 0.8 x 10 Hex Socket Flat Pt. SS -- N		2
5	B18.2.4.1M - Hex nut, Style 1, M5 x 0.8 --D-N		2
6	B18.3.1M - 5 x 0.8 x 25 Hex SHCS -- 25CHX		2
7	GREEN & YELLOW WIRE		1
8	BLACK WIRE		1
9	BLUE WIRE		1
10	BROWN WIRE		1
11	CABLE GLAND		1



THIS ASSEMBLY IS REQUIRED FOR:  
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THIRD ANGLE PROJECTION

REMOVE ALL BURRS AND SHARP EDGES

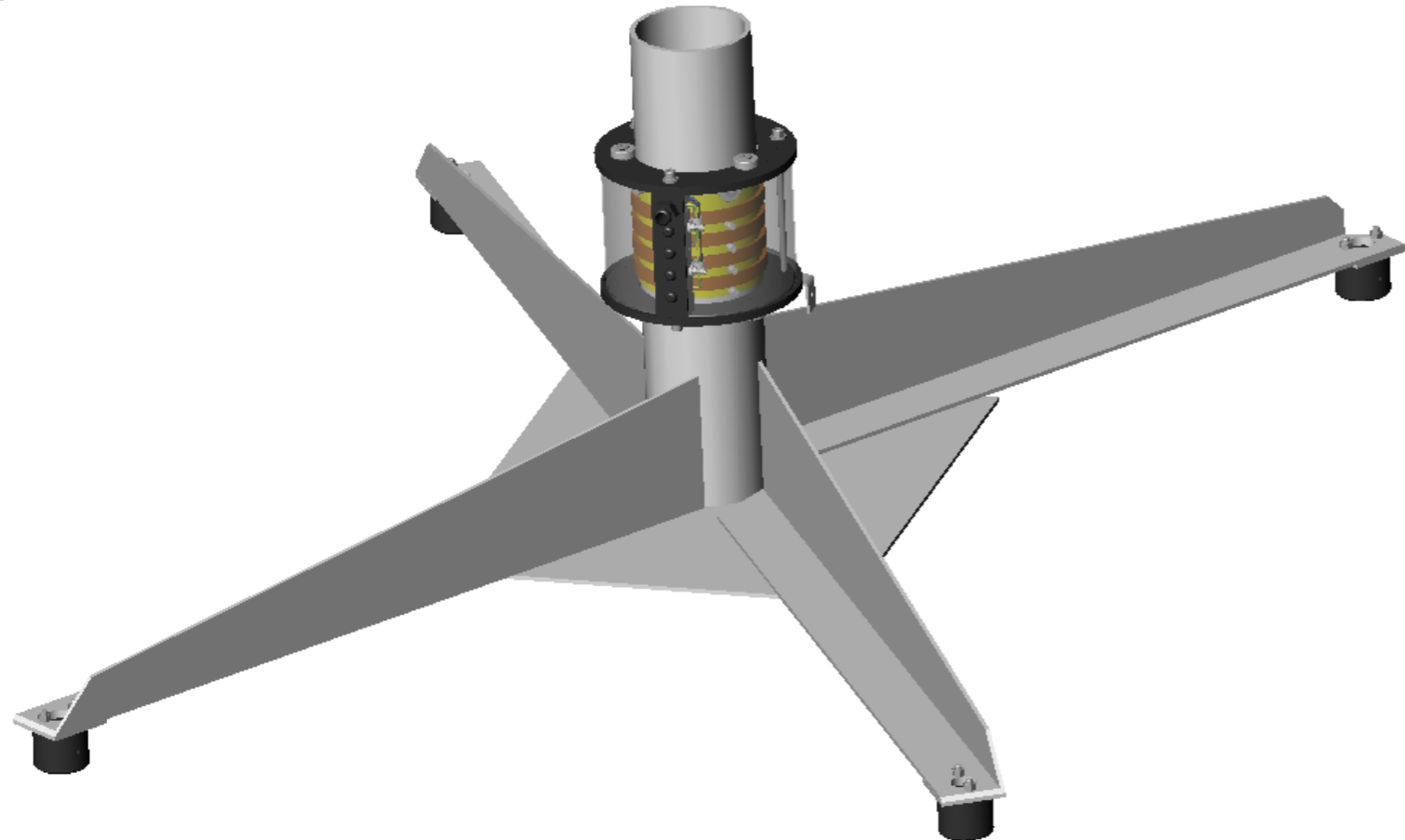


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TEL: +44 (0)1706 878558 FAX: +44 (0)1706 878288

	NAME	SIGNATURE	DATE	ASSY NO:
DRAWN	S.PEEL		28/11/2006	
CHK'D				
APPV'D				
MFG				
NO. OFF	FINISH:	MATERIAL:		DWG NO.
1	SURFACE FINISH:	WEIGHT:		MTEE-003

TITLE:		BRUSH HOLDER ASSEMBLY	
SCALE:2:1	ISSUE:	A3	SHEET 1 OF 1

CONTENTS	
DESCRIPTION	PAGE
FRONT PAGE & BOM	1
DETAILED ASSY 1	2
DETAILED ASSY 2	3
ASSY INSTRUCTIONS	4-5



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	MTE-124-ASSY	ASSEMBLY OF LOWER SPIDER	1
2	MTE-132	ROTATING DISC	2
3	MTE-500	BEARING, O/D 1 1/8" X I/D 1/2" X 3/8"	10
4	MTE-270	LEG COLLAR FOR UNDERTABLE SUPPLY	4
5	SPIDER SHIM		1
6	MTE-127	CONTACT RING	4
7	B18.22M - Plain washer, 8 mm, narrow		18
8	M5 X 1" ROD	M5 COPPER THREADED ROD, 1" LONG	1
9	M5 X 1 1/4" ROD	M5 COPPER THREADED ROD, 1 1/4" LONG	3
10	B18.2.4.1M - Hex nut, Style 1, M5 x 0.8 --D-N		8
11	B18.2.4.1M - Hex nut, Style 1, M8 x 1.25 --D-N		2
12	MTE-168	SLIP RING COVER	1
13	MTE-170	ANGLE FOR U.T CONTROL BOX	1
14	M8 SCREWED ROD	M8 SCREWED ROD X 27mm LG	8
15	B18.2.4.2M - Hex nut, Style 2, M8 x 1.25 --D-N	NYLOC NUT	10
16	MTE-124B	SCREWED ROD	2
17	SPRING WASHER (M8)	DIFFERENT SIZE SPRING WASHERS	6
18	B18.3.1M - 8 x 1.25 x 25 Hex SHCS -- 25CHX		4
19	B18.3.5M - 8 x 1.25 x 20 Socket FCHS -- 20N		4
20	B18.3.5M - 8 x 1.25 x 25 Socket FCHS -- 25N		4
21	MTE-160	NYLON INSERT	3
22	MTE-160A	NYLON CHEESE SCREW, M5 X 16mm	8
23	MTE-160B	NYLON SCREW INSULATOR, M5 X 5mm	8
24	MTEE-003	BRUSH HOLDER ASSEMBLY	1

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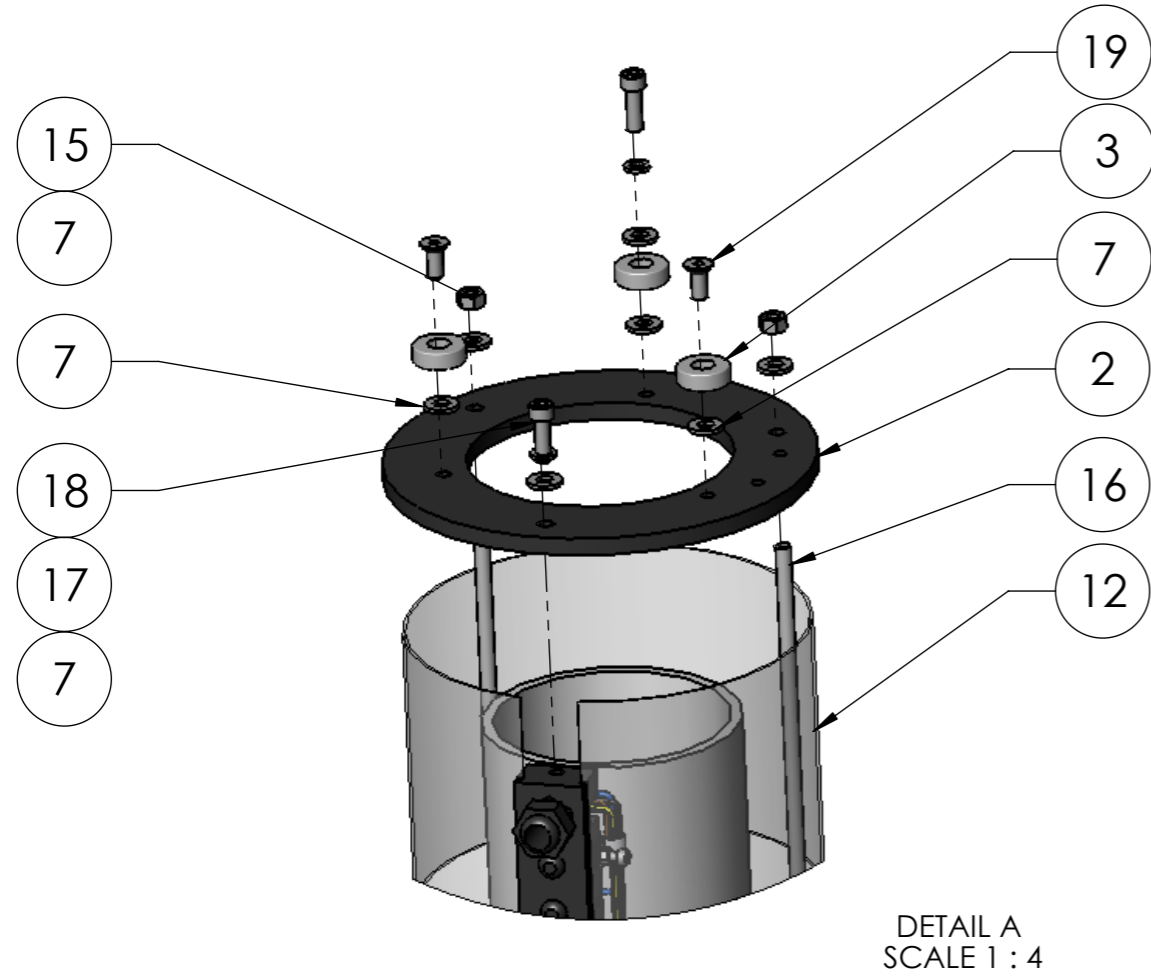
THIRD ANGLE PROJECTION  
REMOVE ALL BURRS AND SHARP EDGES



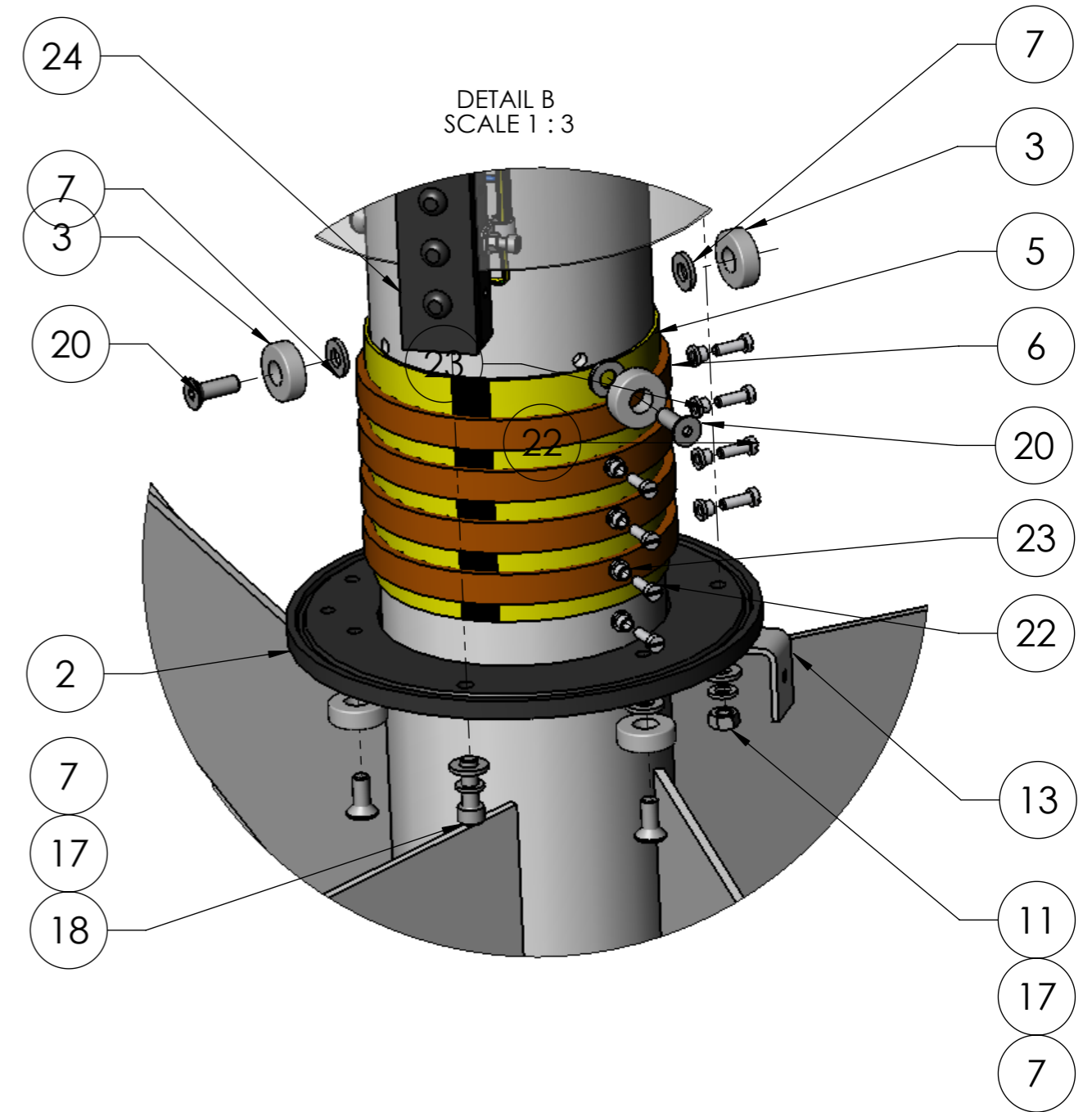
**MATTRESS PRODUCTION TECHNOLOGY GROUP**  
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TEL: +44 (0)1706 878558 FAX: +44 (0)1706 878288

NAME	SIGNATURE	DATE	ASSY NO:
S.PEEL		24/01/2007	
CHK'D			
APPV'D			
MFG			

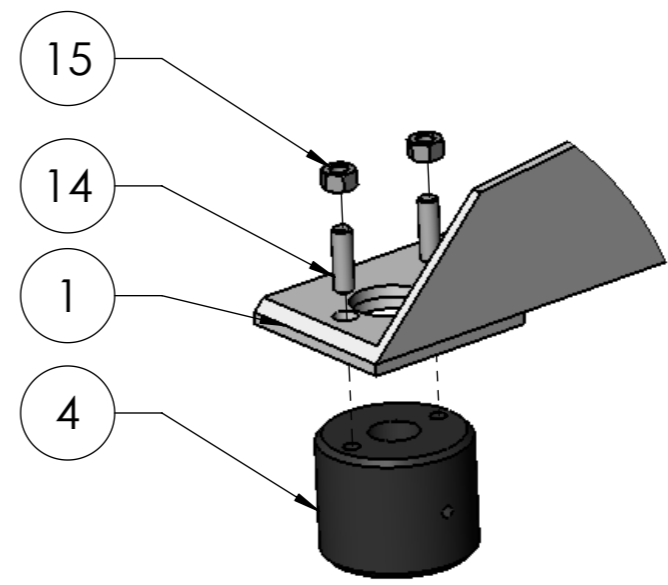
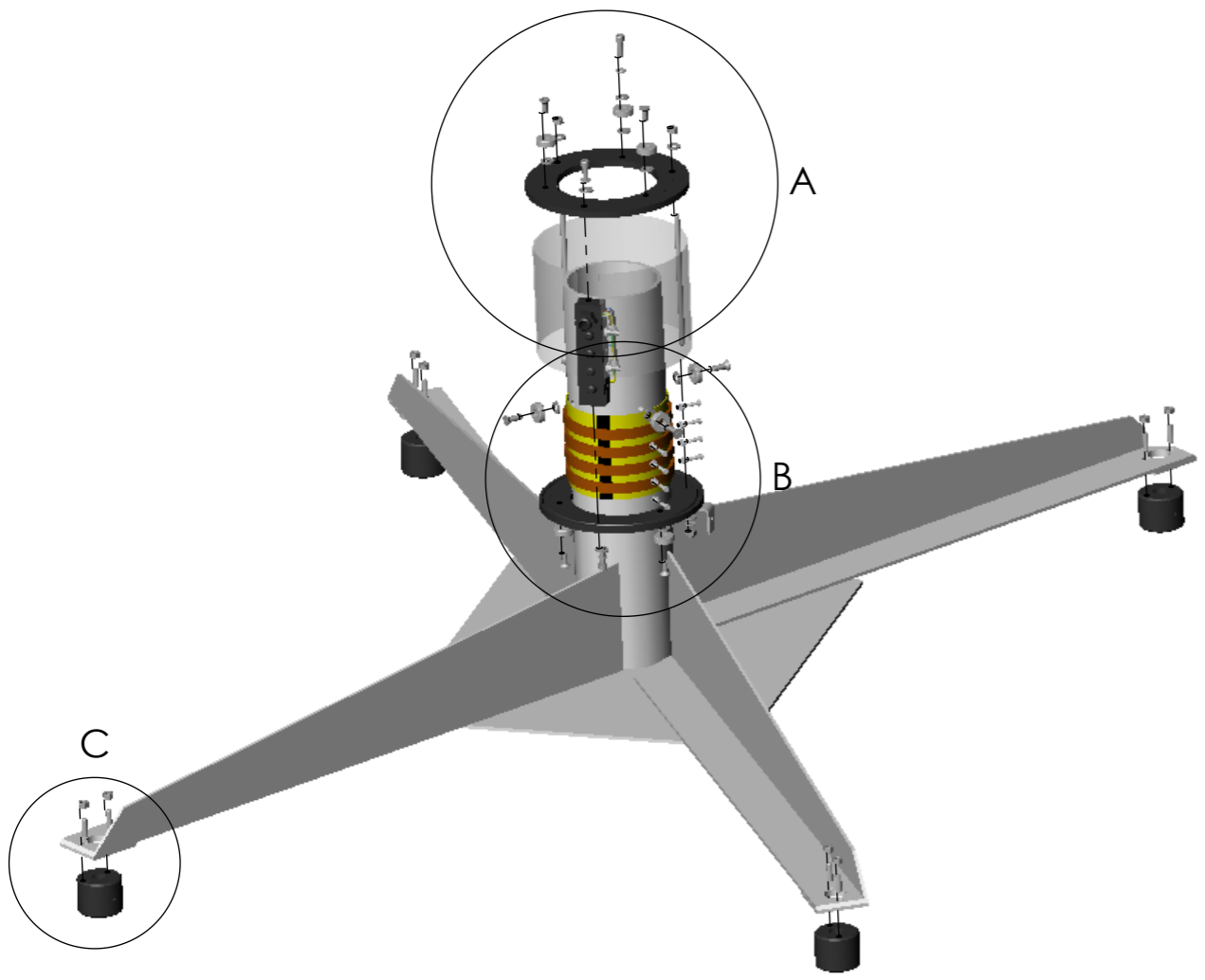
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NO. OFF <b>1</b>		FINISH:	WEIGHT:	SCALE:1:20
SURFACE FINISH:		SHEET 1 OF 3		



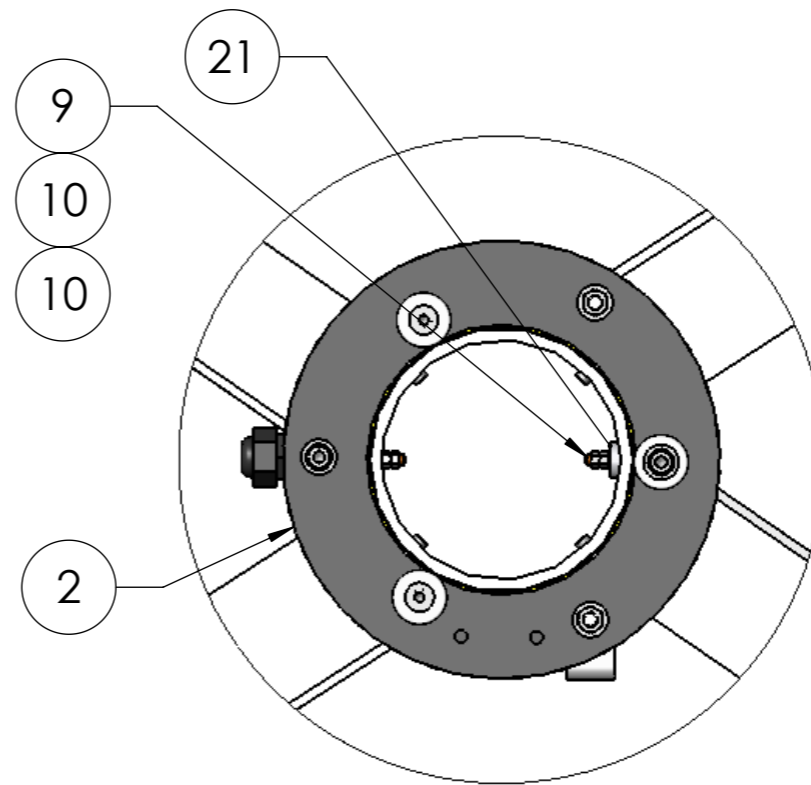
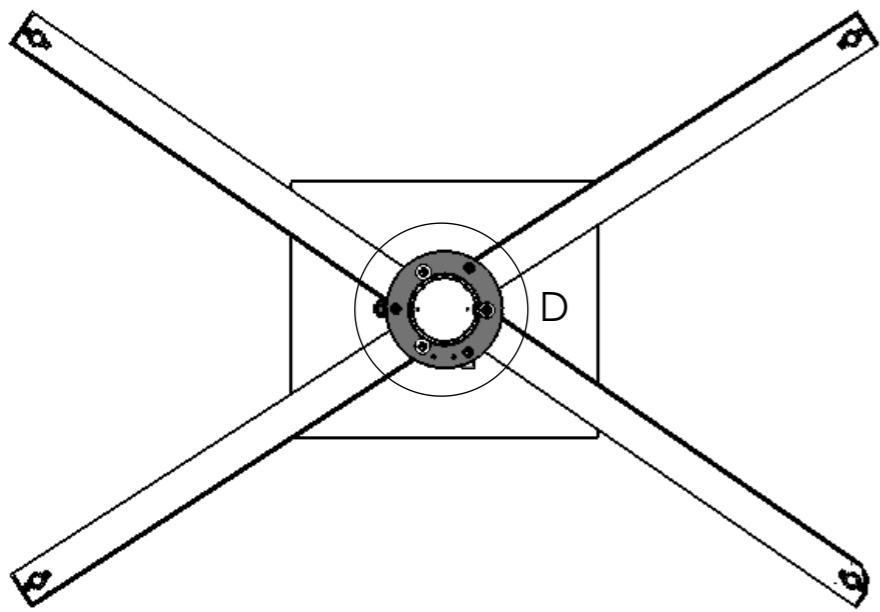
DETAIL A  
SCALE 1 : 4



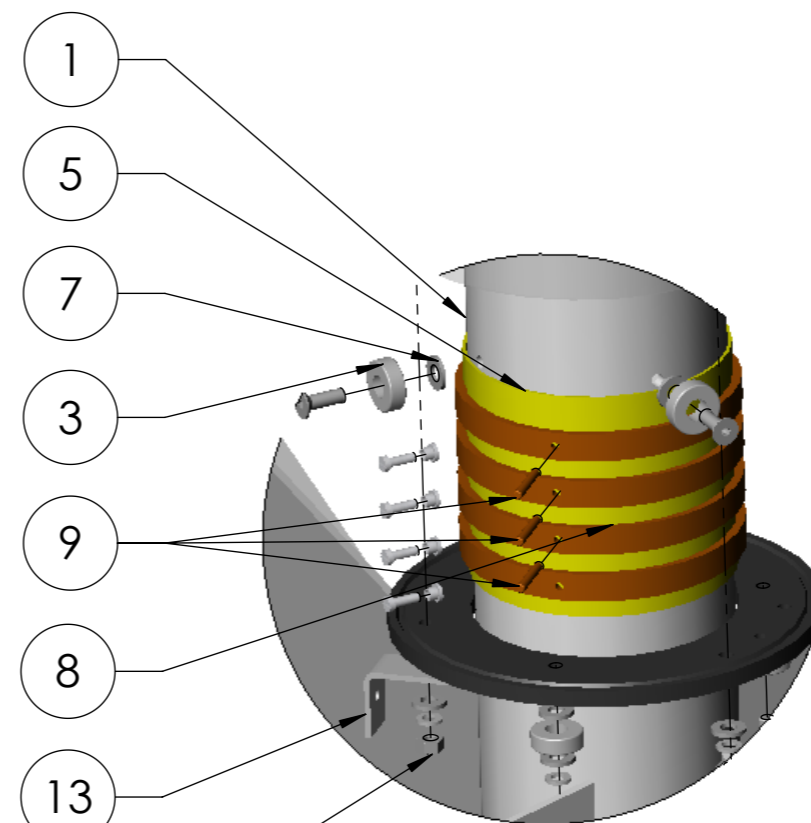
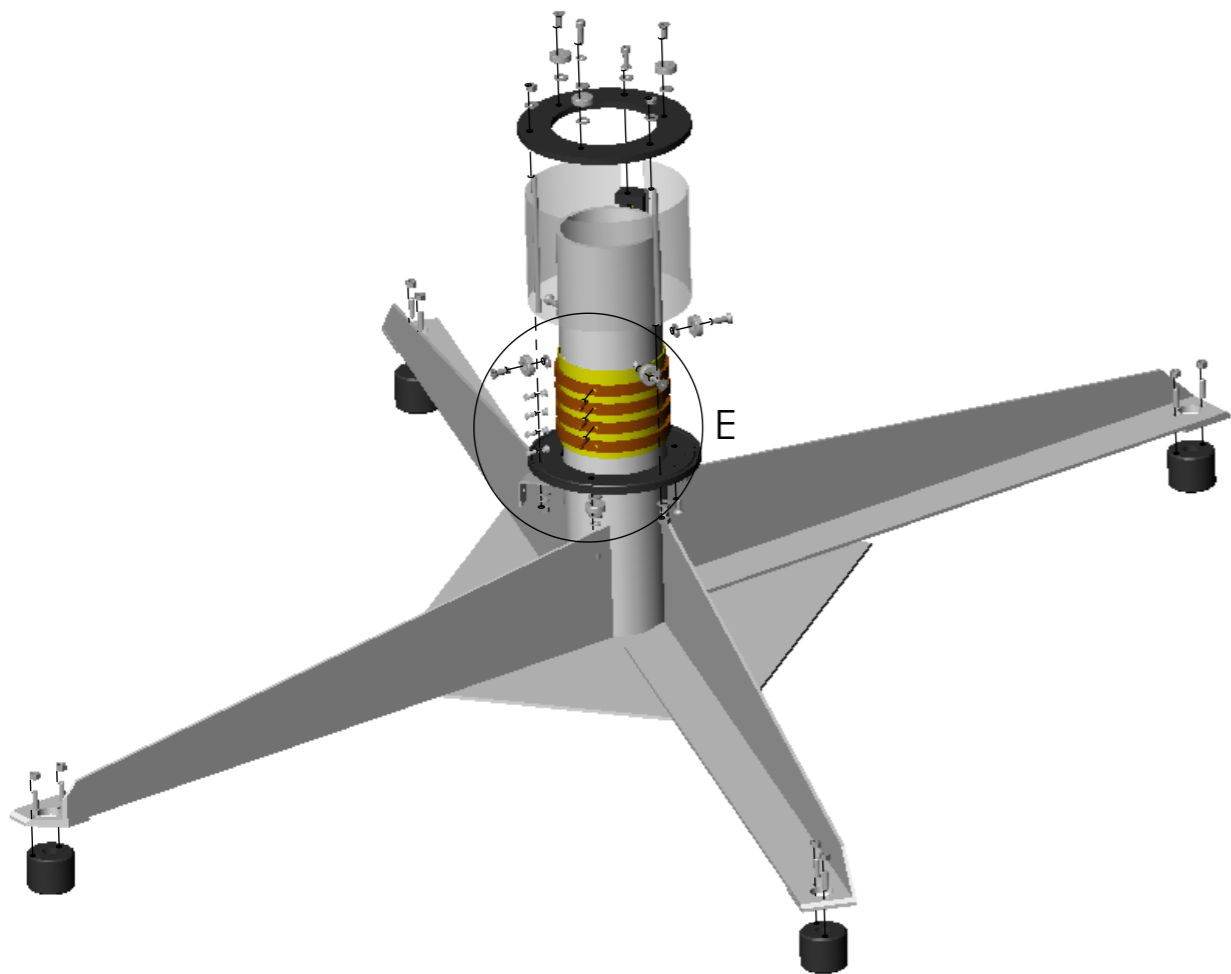
DETAIL B  
SCALE 1 : 3



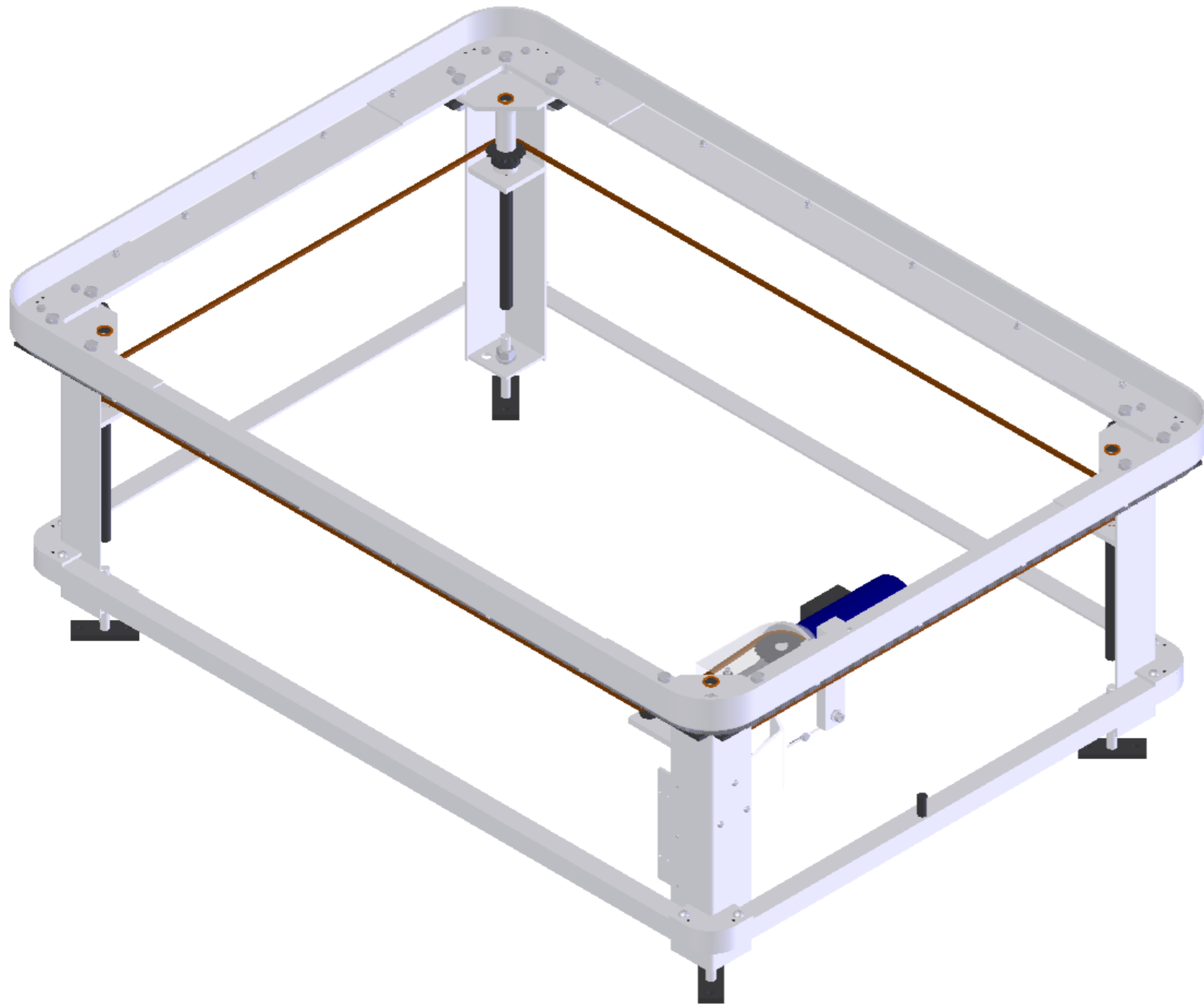
DETAIL C  
SCALE 1 : 3



DETAIL D  
SCALE 1 : 4



DETAIL E  
SCALE 1 : 4



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DESCRIPTION	PAGE
BOM	2
MAIN ASSEMBLY	3
ASSY OF LEGS & MOTOR	4
FITTING THE RACKS & QUADRANTS	5

**THIS ASSEMBLY IS REQUIRED FOR:  
UNDERTABLE MACHINES**

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THIRD ANGLE PROJECTION  
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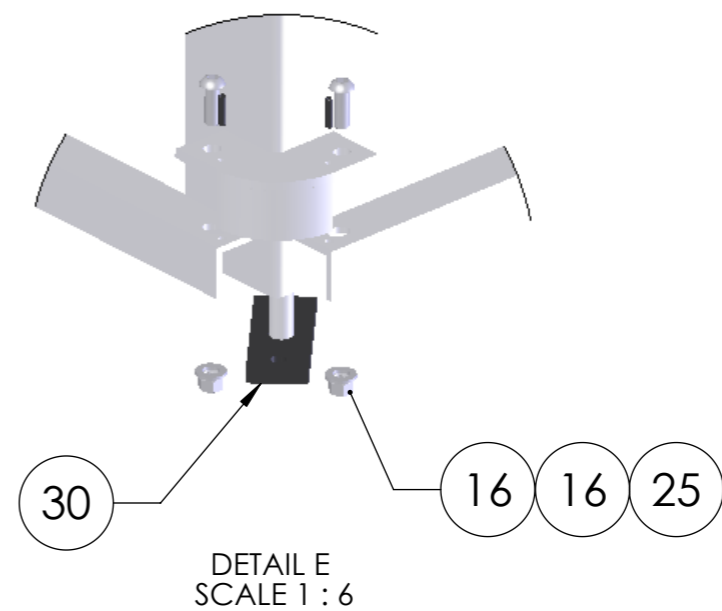
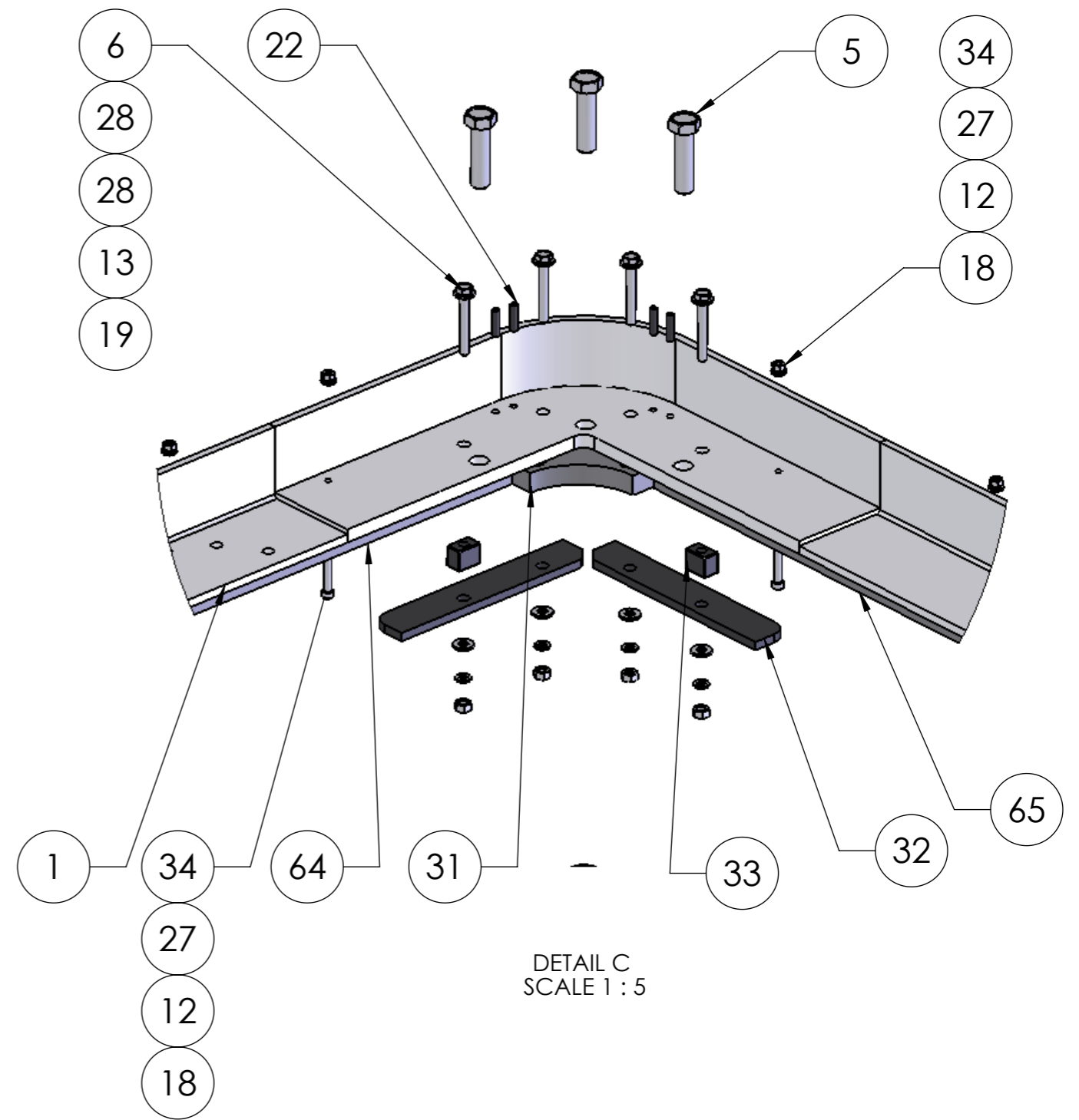
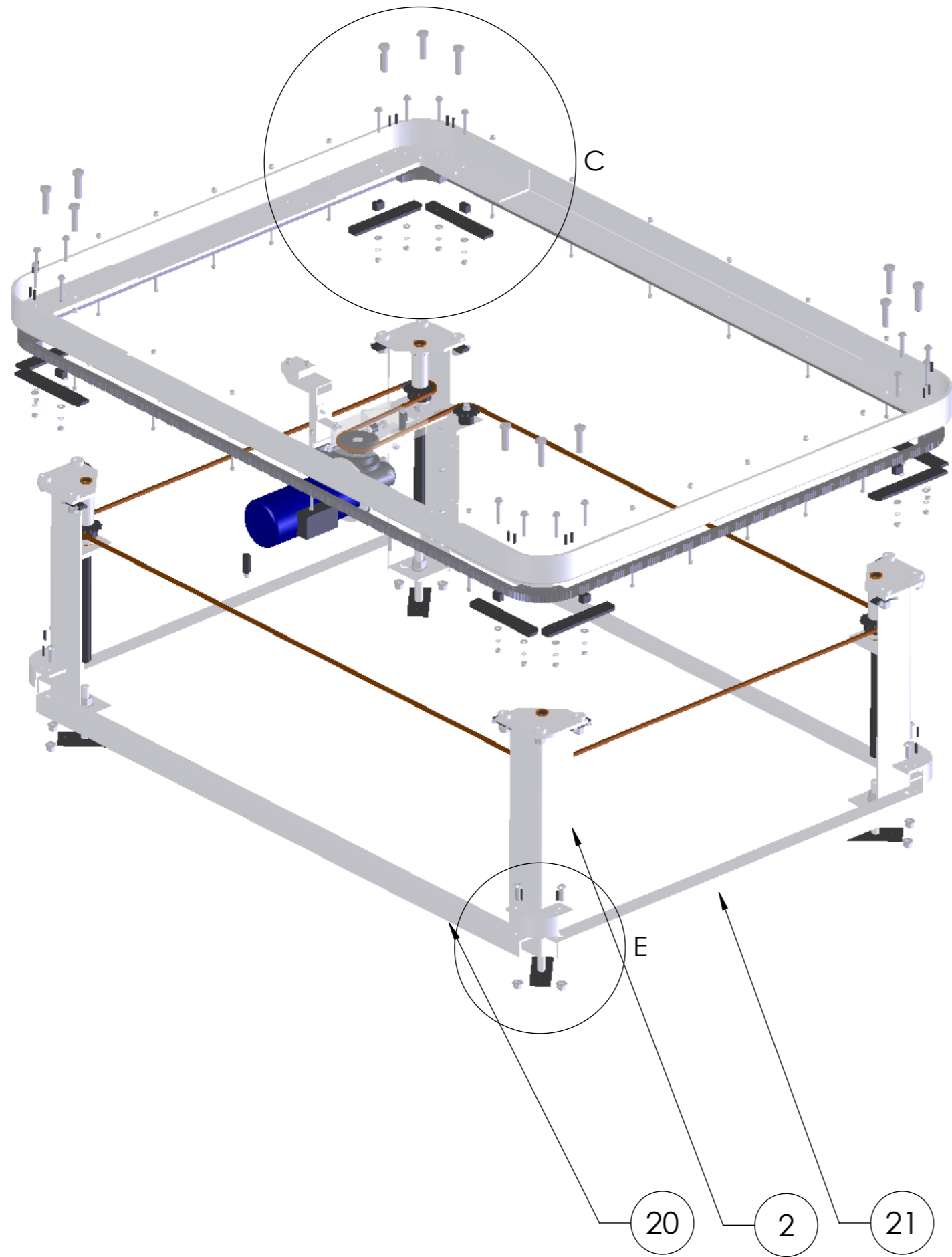
	NAME	SIGNATURE	DATE	ASSY NO:
DRAWN	S.PEEL		24/01/2007	
CHK'D				
APPV'D				
MFG				
NO. OFF	FINISH:	MATERIAL:		DWG NO.
	SURFACE FINISH:	WEIGHT:		MTEA-002 UT

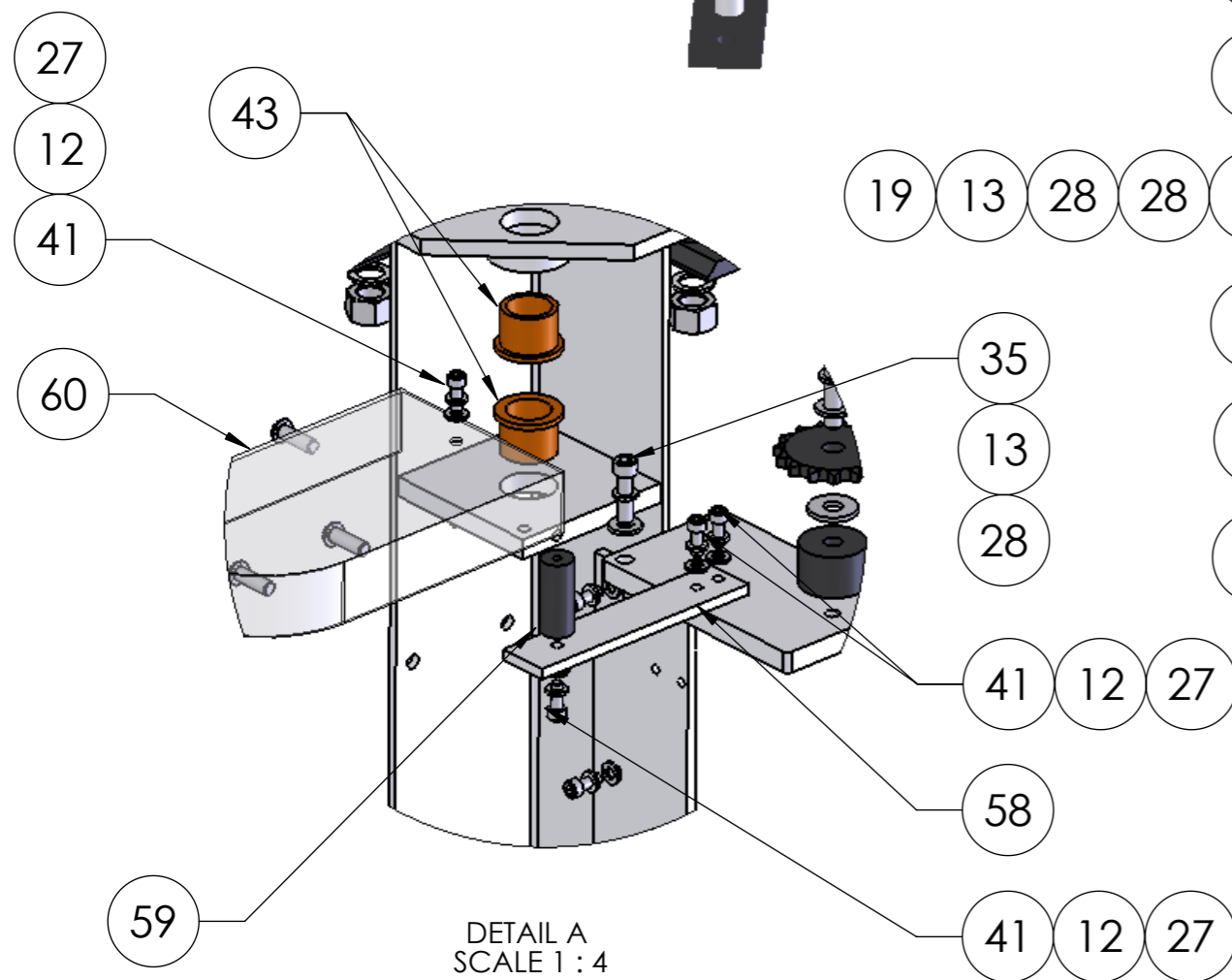
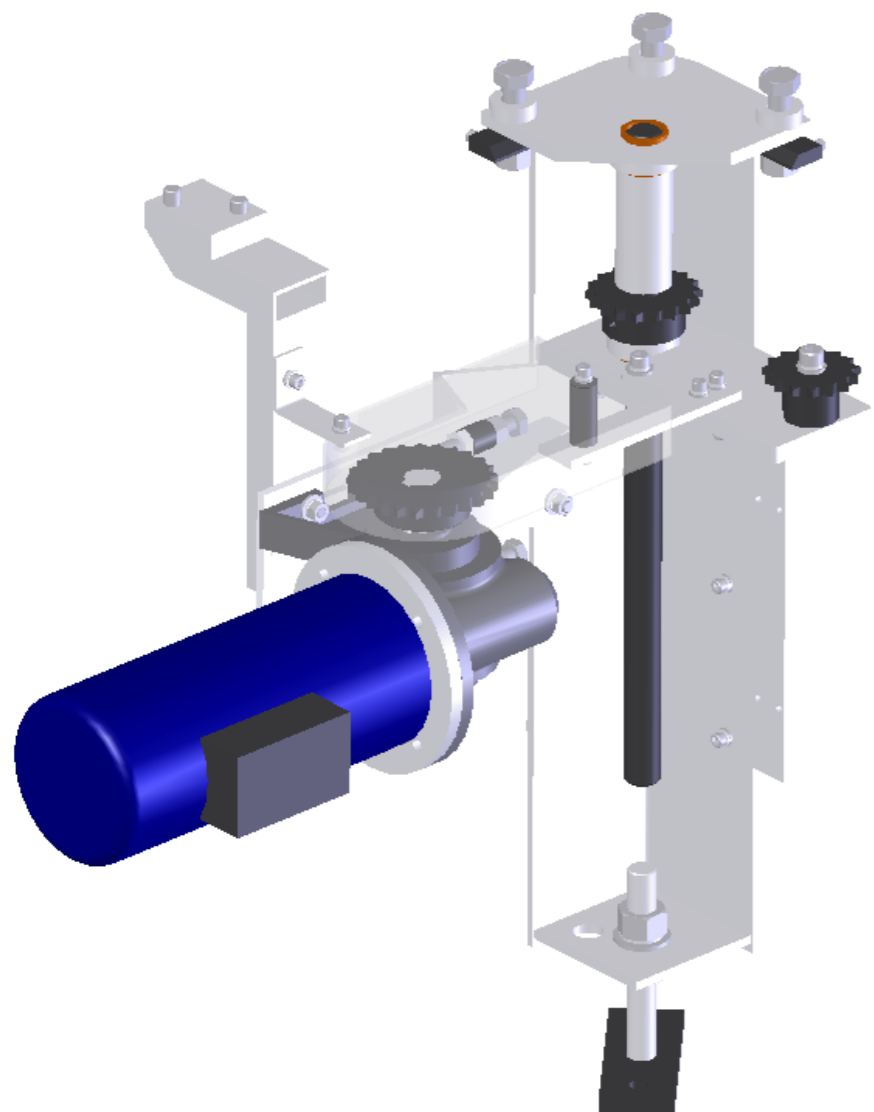
TITLE:	
ASSEMBLY OF THE FRAME	
SCALE:1:10	ISSUE:
SHEET 1 OF 5	A3



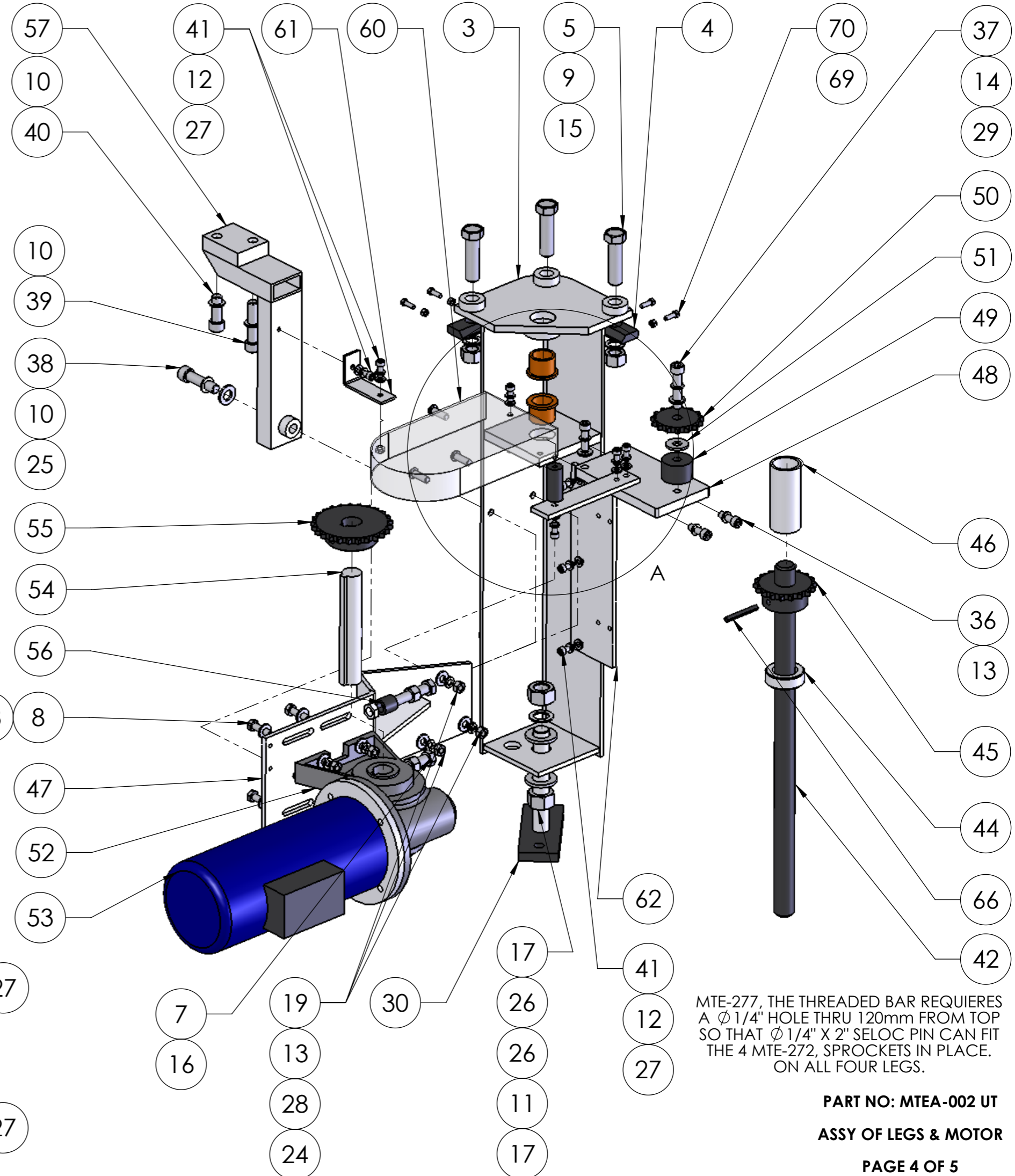
ITEM NO.	PART NUMBER	DESCRIPTION	Default/QTY.
1	MTE-268 STD	ASSEMBLY OF FRAME	1
2	MTE-116A	FABRICATION OF LEG	3
3	MTE-116A	FABRICATION OF LEG WITH HOLES	1
4	MTE-142	CORNER GUIDE PLATE ADJUSTER	8
5	B18.2.3.2M - Formed hex screw, M16 x 2.0 x 60 -- 38CN		12
6	B18.2.3.2M - Formed hex screw, M8 x 1.25 x 60 -- 22CN		16
7	B18.2.3.2M - Formed hex screw, M12 x 1.75 x 70 -- 70CN		2
8	B18.2.3.2M - Formed hex screw, M8 x 1.25 x 30 -- 30CN		4
9	SPRING WASHER (M16)	DIFFERENT SIZE SPRING WASHERS	12
10	SPRING WASHER (M12)	DIFFERENT SIZE SPRING WASHERS	11
11	SPRING WASHER (M20)	DIFFERENT SIZE SPRING WASHERS	4
12	SPRING WASHER (M6)	DIFFERENT SIZE SPRING WASHERS	32
13	SPRING WASHER (M8)	DIFFERENT SIZE SPRING WASHERS	26
14	SPRING WASHER (M10)	DIFFERENT SIZE SPRING WASHERS	1
15	B18.2.4.1M - Hex nut, Style 1, M16 x 2 --D-N		12
16	B18.2.4.1M - Hex nut, Style 1, M12 x 1.75 --D-N		10
17	B18.2.4.1M - Hex nut, Style 1, M20 x 2.5 --D-N		8
18	B18.2.4.1M - Hex nut, Style 1, M6 x 1 --D-N		22
19	B18.2.4.1M - Hex nut, Style 1, M8 x 1.25 --D-N		23
20	MTE-119	LOWER SUPPORT ANGLES	2
21	MTE-120	LOWER SUPPORT ANGLES	2
22	SELOC PIN, 1-4" X 1"	1/4" X 1", SELOC PIN	24
23	B18.3.4M - 12 x 1.75 x 35 SBHCS --N		8
24	B18.3.4M - 8 x 1.25 x 25 SBHCS --N		3
25	B18.22M - Plain washer, 12 mm, narrow		9
26	B18.22M - Plain washer, 20 mm, narrow		8
27	B18.22M - Plain washer, 6 mm, narrow		32
28	B18.22M - Plain washer, 8 mm, narrow		44
29	B18.22M - Plain washer, 10 mm, narrow		1
30	MTE-156	TABLE FEET	4
31	MTE-258	TABLE QUADRANT GEAR	4
32	MTE-141	CORNER GUIDE PLATE	8
33	MTE-159	SPACER BLOCK	8
34	B18.3.1M - 6 x 1.0 x 35 Hex SHCS -- 24CHX		22
35	B18.3.1M - 8 x 1.25 x 30 Hex SHCS -- 30CHX		1
36	B18.3.1M - 8 x 1.25 x 25 Hex SHCS -- 25CHX		2
37	B18.3.1M - 10 x 1.5 x 50 Hex SHCS -- 32CHX		1

ITEM NO.	PART NUMBER	DESCRIPTION	Default/QTY.
38	B18.3.1M - 12 x 1.75 x 50 Hex SHCS -- 50CHX		1
39	B18.3.1M - 12 x 1.75 x 55 Hex SHCS -- 55CHX		1
40	B18.3.1M - 12 x 1.75 x 35 Hex SHCS -- 35CHX		1
41	B18.3.1M - 6 x 1.0 x 16 Hex SHCS -- 16CHX		9
42	MTE-277	RISE & FALL SCREW	4
43	MTE-530	FLANGED OILITE BUSH, 1" I/D X 1 1/4" O/D X 1" LG,	8
44	MTE-570	BEARING LT 1" - 1/8"	4
45	MTE-272	18T JOCKEY SPROCKET	4
46	MTE-150	LEG SPACING TUBE	4
47	MTE-122	MOTOR BASE PLATE	1
48	MTE-143	JOCKEY WHEEL BRKT	1
49	MTE-144C	JOCKEY WHEEL SPACER	1
50	MTE-545	IDLER SPROCKET 15T X 1/2" PITCH, SIMPLEX	1
51	B18.22M - Plain washer, 10 mm, regular		1
52	DE0054	SW050PA RATIO 20:1 B14/80 FITTED WITH PA FEET	1
53	DE0055	HS80b4 0.75KW 4 POLE 240/1/50 B14/80 O/SIZE T/BOX	1
54	DE0056	MOTOR SHAFT	1
55	MTE-287	25T DRIVE SPROCKET	1
56	MTE-200	MOTOR PLATE BUSH	2
57	MTE-146 STD	MOTOR PLATE SUPPORT BRACKET	1
58	MTE-139A	CHAIN GUARD BRACKET	1
59	MTE-139B	CHAIN GUARD SPACING STUD	2
60	MTE-167	CHAIN GUARD	1
61	MTE-138	CHAIN GUARD BRKT	1
62	MTE-154	SWITCH PLATE	1
63	B18.3.1M - 6 x 1.0 x 20 Hex SHCS -- 20CHX		1
64	MTE-259-S	SHORT RACK FOR STD MTE MACHINE	2
65	MTE-259-L	LONG RACK FOR STD MTE MACHINE	2
66	SELOC PIN, 1-4" X 2"	1/4" X 2", SELOC PIN	4
67	MTE-560	22 FOOT x CHAIN 1/2" PITCH, SIMPLEX	1
68	MTE-565	CONNECTING LINK 1/2" PITCH, SIMPLEX	1
69	B18.2.4.1M - Hex nut, Style 1, M5 x 0.8 --D-N		16
70	B18.2.3.2M - Formed hex screw, M5 x 0.8 x 16 -- 16CN		16





DETAIL A  
SCALE 1 : 4



MTE-277, THE THREADED BAR REQUIRES A  $\varnothing 1/4"$  HOLE THRU 120mm FROM TOP SO THAT  $\varnothing 1/4" \times 2"$  SELOC PIN CAN FIT THE 4 MTE-272, SPROCKETS IN PLACE. ON ALL FOUR LEGS.

**PART NO: MTEA-002 UT**  
**ASSY OF LEGS & MOTOR**



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	MTEA-002 UT	ASSEMBLY OF THE FRAME	1
2	MTEA-003 UT	SPIDER ASSEMBLY	1
3	MTEA-004 UT	ASSEMBLY OF CARRIAGE	1
4	MTE-187		1
5	MTE-187	SIDE PANELS	1
6	MTE-189	END PANELS	1
7	MTE-189-1	END PANELS	1
8	B18.3.4M - 6 x 1.0 x 12 SBHCS --N		16
9	MTE-125-ASSY	ASSEMBLY OF UPPER SPIDER	1
10	SPRING WASHER (M10)	DIFFERENT SIZE SPRING WASHERS	2
11	B18.3.1M - 10 x 1.5 x 30 Hex SHCS -- 30CHX		2
12	B18.22M - Plain washer, 10 mm, narrow		2
13	MTE-123 UT STD	TABLE TOP FABRICATION	1
14	B18.22M - Plain washer, 8 mm, narrow		4
15	SPRING WASHER (M8)	DIFFERENT SIZE SPRING WASHERS	4
16	B18.3.1M - 8 x 1.25 x 25 Hex SHCS -- 25CHX		4

ALL UNTOLERANCED DIMENSIONS  
ARE TO BE WITHIN  $\pm 0.39\text{mm}$   
DO NOT SCALE DRAWING

THIRD ANGLE PROJECTION  
REMOVE ALL BURRS AND SHARP EDGES



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	NAME	SIGNATURE	DATE	ASSY NO:
DRAWN	S.PEEL		06/02/2007	
CHK'D				
APPV'D				
MFG				
NO. OFF	FINISH:	MATERIAL:	DWG NO.	
1	SURFACE FINISH:	WEIGHT:	MTEA-009 UT	ISSUE:
			SCALE:1:50	SHEET 1 OF 1

TITLE:  
**UNDERTABLE FINISHED ASSY**

A3

# Section 7

## Parts

### *1. Introduction*

To order parts, call the MPTG Customer Service Center or your local MPTG representative. Use these parts list illustrated within this section, and the accompanying illustration, to describe and locate parts correctly.

***Section 8***

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***Specification***

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# Section 8

## Specification

The machine is usually delivered fully assembled with the carriage along the short end of the table, but on occasions the sewing head will have been removed and packed separately. These dimensions are for a fully assembled machine.

### 1. Dimensions and Weights

Overall Height (mm)	69 inch
Width (mm)	55 inch
Length (mm)	97 inch
Weight (kg)	650 – 700 Kg

### 2. Noise

- Less than 70 db (A). Measured at a distance of 1 m from the surface of the unit.

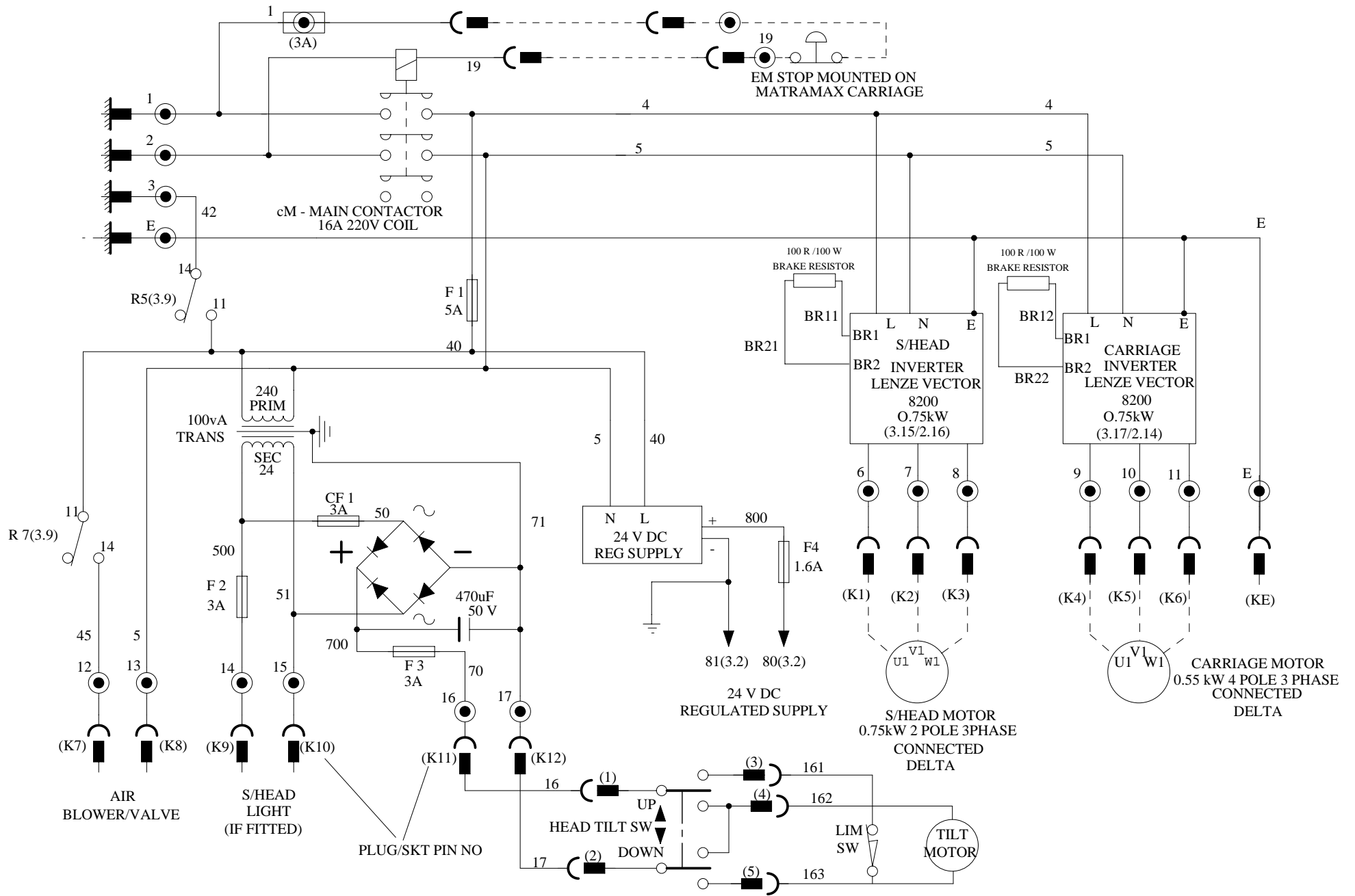
***Section 9***

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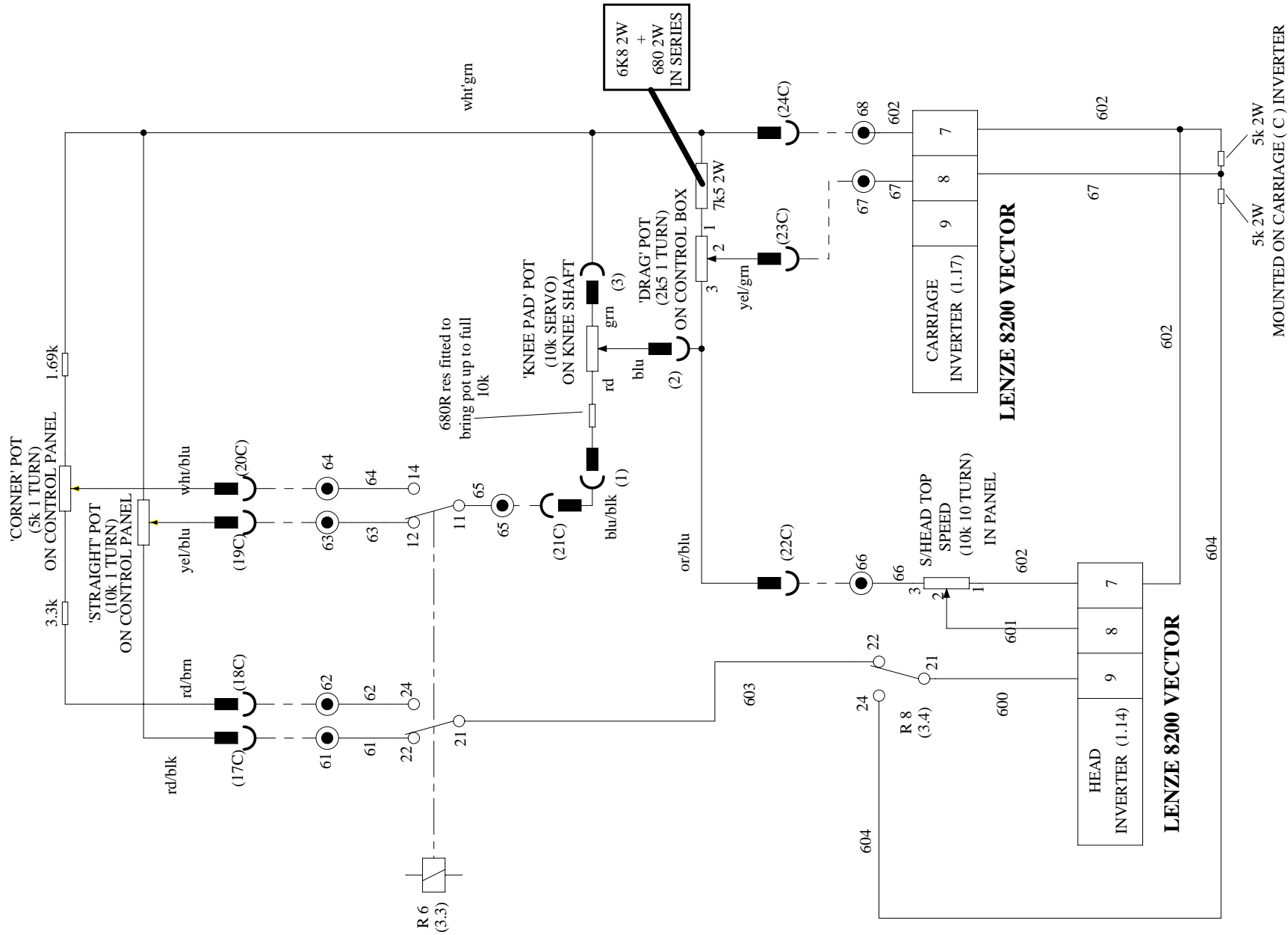
**Electrical Drawings**

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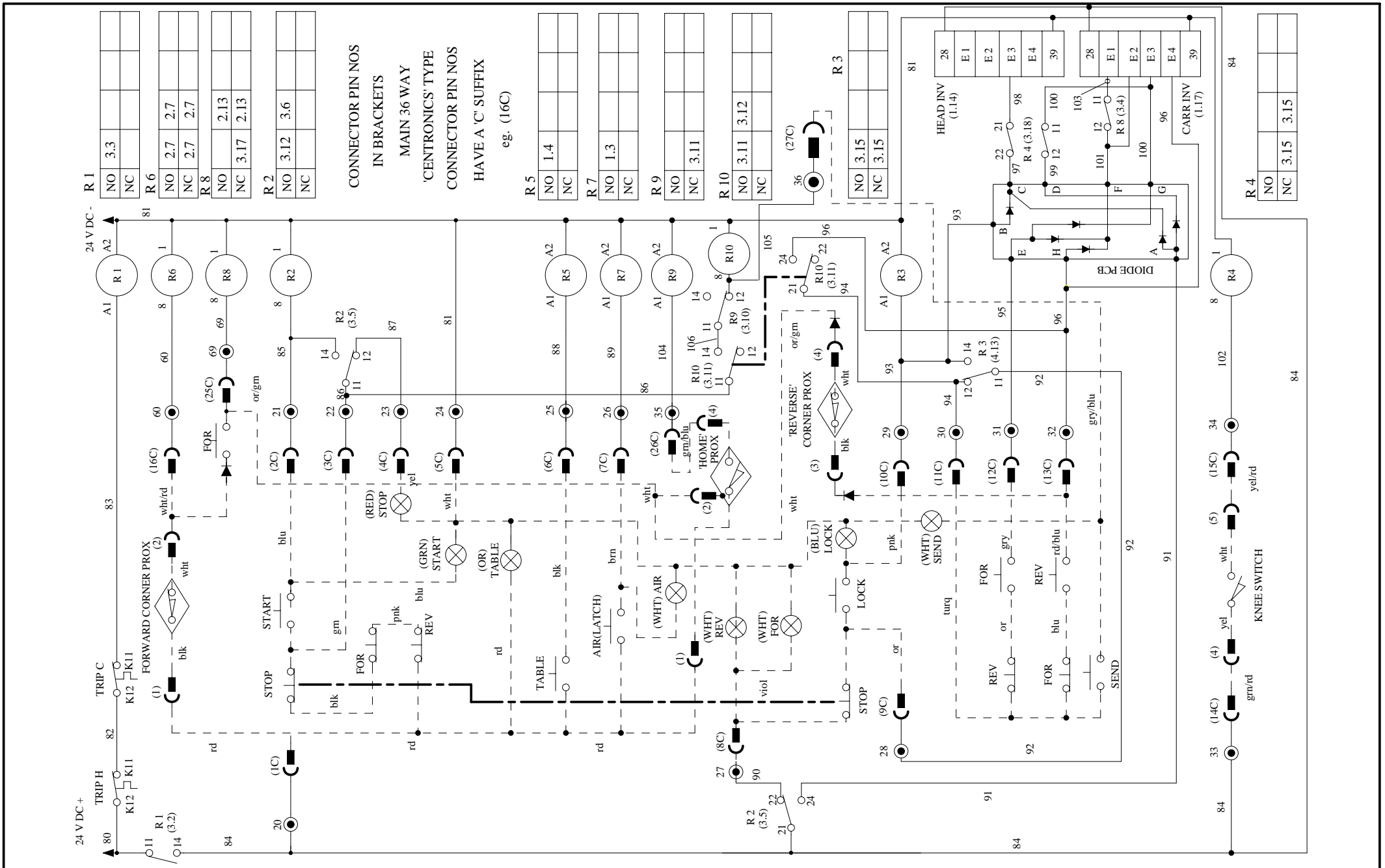




1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
MPT Group			MC. SERIAL NUMBER:			Model: <b>Matramax U/T Tape Edge Machine</b>			Detail: <b>Variable speed control using 8200 VECTOR inverter</b>			Drawn: <b>MB</b>		Date: <b>03/07/06</b>		Drawing No.		Sheet No: <b>1 of 5</b>	



1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
MPT Group			MC. SERIAL NUMBER:			Model: Matramax U/T Tape Edge Machine			Detail: Variable speed control using 8200 VECTOR inverter				Drawn: MB		Date: 03/07/06		Drawing No.		Sheet No: 2 of 5	



24 V DC -

R 1	
NO	3.3
NC	

R 6	
NO	2.7
NC	2.7

R 8	
NO	2.13
NC	2.13

R 2	
NO	3.12
NC	3.6

CONNECTOR PIN NOS  
IN BRACKETS  
MAIN 36 WAY  
'CENTRONICS' TYPE  
CONNECTOR PIN NOS  
HAVE A 'C' SUFFIX  
eg. (16C)

R 5	
NO	1.4
NC	

R 7	
NO	1.3
NC	

R 9	
NO	
NC	3.11

R 10	
NO	3.11
NC	3.12

R 3	
NO	3.15
NC	3.15

R 4	
NO	
NC	3.15

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
MPT Group			MC. SERIAL NUMBER:			Model: Matramax U/T Tape Edge Machine			Detail: Control circuit schematic using 8200 VECTOR inverter			Drawn: MB		Date: 03/07/06		Drawing No.		Sheet No: 3 of 5	

PARAMETER NO.	S/HEAD INVERTER		CARRIAGE INVERTER	
	PAR 1	PAR 2	PAR 1	PAR 2
C 007	15		15	
C 010	8		8	
C 011	115 (note i)		115 (note i)	80
C 012	0.8		0.8	1.5
C 013	0.8		0.8	0.4
C 014	2			
C 016	8 (note ii)			
C 037				80
C 105	0.8		0.8	0.4
C 106			15	
C 171	5	5	5	5

(C 011 = 115 WHEN 1k SERIES RESISTOR FITTED IN KNEE PAD SPEED)

NOTE i CARRIAGE: SET C 011 (PAR 1) TO GIVE 71 HZ CARRIAGE SPEED WITH 'SPEED' & 'DRAG' DIALS SET AT FULL SPEED

NOTE i SEWING HEAD: SET C 011 (PAR 1) TO GIVE 51 HZ SEWING HEAD SPEED WITH 'SPEED' DIAL SET TO FULL & 'DRAG' DIAL SET AT HALF SPEED

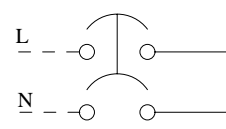
NOTE ii SEWING HEAD: CHECK CURRENT IS NOT TOO HIGH THROUGH THE SPEED RANGE AT THIS SETTING

Dip switches on Std. I/O set to 5V analogue input ie.

Switch Position				
1	2	3	4	5
OFF	OFF	ON	OFF	OFF

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
<b>MPT Group</b>			MC. SERIAL NUMBER:			Model: <b>Matramax U/T Tape Edge Machine</b>			Detail: <b>Inverter settings 8200 VECTOR INVERTER</b>			Drawn: <b>MB</b>		Date: <b>03/07/06</b>		Drawing No.		Sheet No: <b>4 of 5</b>		

MAIN ISOLATOR  
16 A DP MCB TYPE C



E

L N

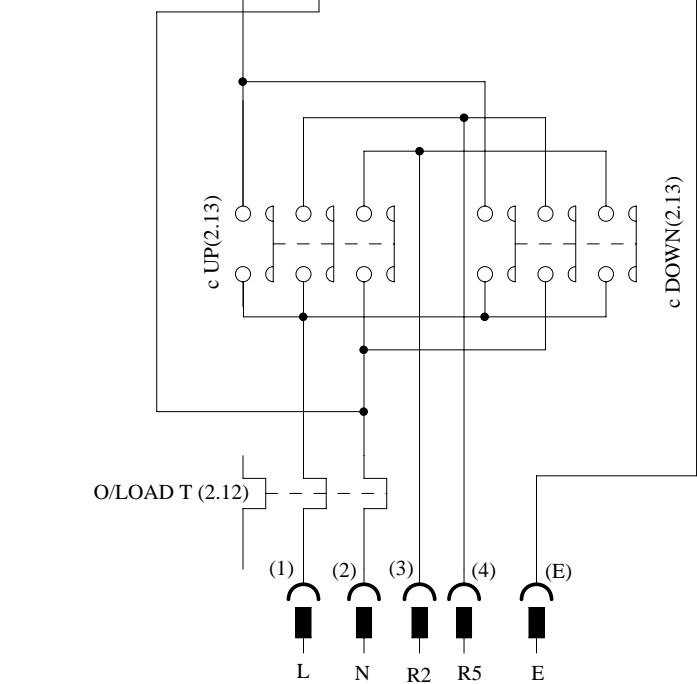
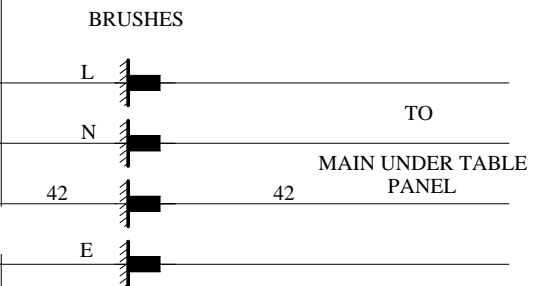
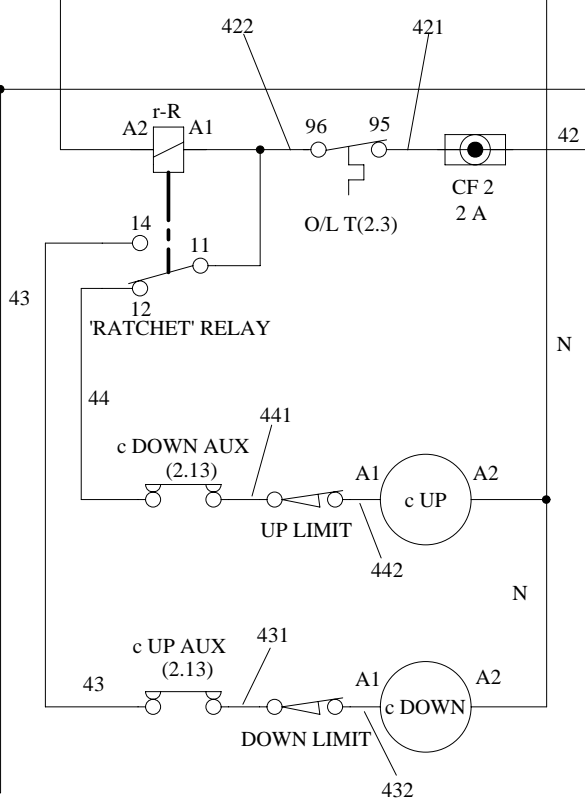


TABLE RISE & FALL MOTOR (0.75kW 4 POLE SINGLE PHASE)



cUP

NO	2.5	2.5	2.5	
NC	2.10			

cDOWN

NO	2.7	2.7	2.7	
NC	2.10			

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
MPT Group			MC. SERIAL NUMBER:			Model: Matramax U/T Tape Edge Machine			Detail: Elec Distribution Diagram for table rise/fall gear for Under table model				Drawn: MB		Date: 03/07/06		Drawing No.		Sheet No: 5 of 5	