SiRUBA

使用說明書與零件圖

INSTRUCTIONS BOOK & PARTS LIST

ASO-ABF110A

一、简述

自动送扣装置由送料识别机构，气动纽扣传输机构，纽扣旋转落位机构，测厚机构，闸板调节机构，机械臂送扣机构，松线机构，集机、电、气结合控制机构组成。可与不同品牌型号的钉扣机兼容，具有送扣速度快，送扣稳定性高，故障率小，大幅度减轻劳动强度，提高生产效率，操作简单等特点。

二、技术参数

编号	参数内容	标准范围	备注
1	电源电压	110/220V	
2	额定功率	80W	
3	包装尺寸	580×630×500MM	
4	重量	40KG	
5	额定钉扣速度	19200-24000pcs/8h	
6	连续送扣速度	28800-31200pcs/8h	
7	送扣稳定性	99.7%	
8	纽扣直径	9-27mm	
9	建议气压	0.3-0.35Mpa	

一、安全警告

1、用户在安装使用此设备前，务必仔细阅读有关安全注意事项，以确保人身和设备安全。由于不遵守说明书的操作规定而造成的人身伤害或设备损坏，本公司将不承担任何责任。

2、安装前确保钉扣机压脚在不断针不跳线的情况下已调到最高。

3、机器连接电源之前，必须由具有电工安装资质的专业人员检查电源电压，频率，功率等参数是否与机器铭牌上的表示相符。机器金属外壳必须要和缝纫机的外壳用金属导线连接后再用接地线接到专门的保护地线上。

4、维修或调整设备时，必须先切断电源、气源以保安全。

5、任何时候不要把手放在机器的运动部位，以免造成伤害。压缩空气的进气总气源应在0.35－0.4Mpa之间。

四、面板功能介绍

数量　显示当前数量，按下该键，数量清零。

输出入指示灯　按下该键显示各系统工作指示灯。

送扣控制　按下该键设置震动时间、震动档位、送扣速度。

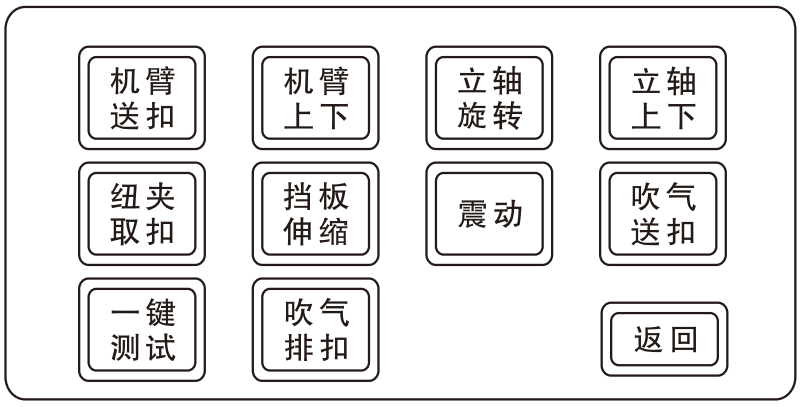
手动测试　按下该键进入功能页面，选择你想要测试的功能键，按下机器运转一次。

语言　多种语言切换

复位　在系统报警时按下该键进行复位。

启动　按下该键机器开始工作

停止　按下该键机器停止工作



机臂送扣　按下该键机臂送扣为逆时针转动；再按一下机臂顺时针旋转。

机臂上下　按下该键机臂向上动作；再按一下机臂向下动作。

立轴旋转　按下该键立轴旋转。

立轴上下　按下该键立轴往下，再按一下立轴往上。

钮夹取扣　按下该键扣夹展开，再按一下扣夹收回。

挡板伸缩　按下该键挡板伸出阻挡纽扣移动，再按下挡板缩回，纽扣可自由移动。

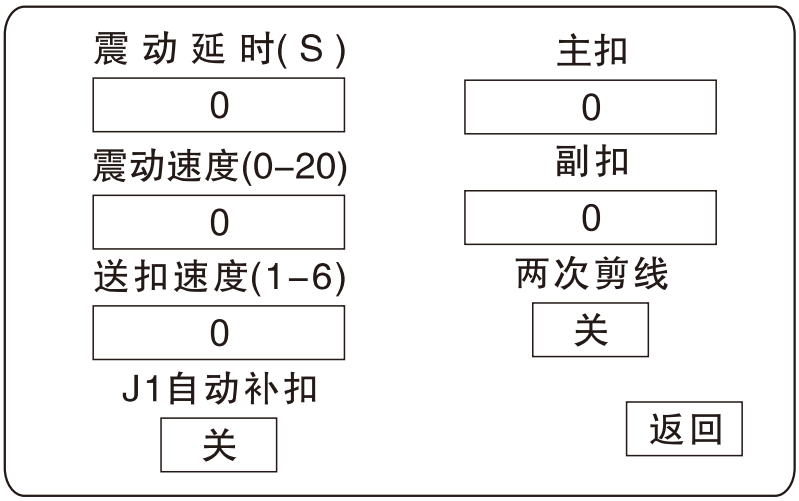
震动　按下该键震动盘启动。

吹气送扣　按下该键吹气送扣一次。

一键测试　按下该键自动单步运行。

吹气排扣　按下该键对输扣槽进行吹气排扣。

返回　按下该键返回上一页。



震动延时(S)：当机器停止工作时，振动盘延时停止振动，输入数字越大延时越久，最大延时30秒。

震动速度(0-20)：振动盘在振动时，输入数字越大振动力越大。

送扣速度(1-6): 数值越大，送扣速度越快；数值越小，送扣速度越慢。

主扣、副扣：钉扣前设置主、副扣的数量，其中一项数字为零，则不分主、副扣，系统都默认0。

两次剪线：按下该键，二次剪线功能开，钉扣机剪两次线，送扣机送一次扣，系统默认关。

J1自动补扣: 按下该键，J1扣夹气缸传感器关，自动补扣功能关闭，系统默认开。

J9调压阀：扣子从震动盘上送到送扣轨道时，再通过吹气把扣子送到爪臂上，建议气压在0.3－0.35Mpa之间。

手动补扣:当扣爪无扣时,按下该键进行手动补主扣。

测厚按键：按下该键,测厚压板抬起,取一颗要用的纽扣放上,再松开该键。

五、基本操作介绍

(一)开机操作

1、检查机器周边有无工具,异物。

2、接通总进气源,调节压力,确保压力表的数值在0.35－0.4Mpa之间。

3、接通电源，面板上的按钮指示灯变成绿色，触摸屏显示功能界面。

4、按下复位键，机器恢复到初始状态，即待机状态。

5、按下缝纫机准备键，压脚抬起，操作屏变为绿色，进入待机状态。

（二）初始状态:(待机状态)

编号	气缸名称	磁开关名称	状态	磁开关指示灯	备注
1	机臂上下气缸	X0(J2)	处于上方	亮	
2	纽夹取扣气缸	X1(J1)	合拢	有扣亮	手动放一颗纽扣
3	副扣传感器	X3(J7)			
4	手动补扣按钮	X4			
5	送扣原点	X6	到位	灭	
6	送扣到位传感器	X7	到位	亮	
7	测厚按钮	X10			
8	断针保护传感器	J28			

（三）换扣操作:

1、按下测厚按键（如图1所示），取一颗要用的纽扣放于压板下面（如图2所示）。自动测厚,自动测宽(如图3)及调整挡扣位置(如图4)，一键设置。

图1

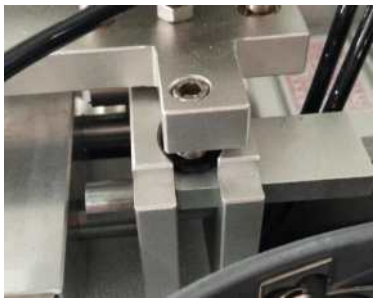


图2

图3

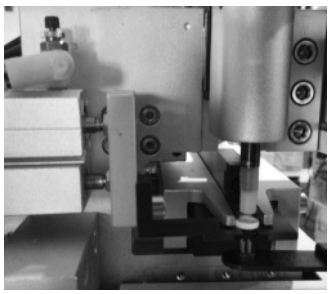


图4

2、换扣时，根据不同的纽扣直径来调整J1传感器的位置，以免误送扣。（如图**5**所示）

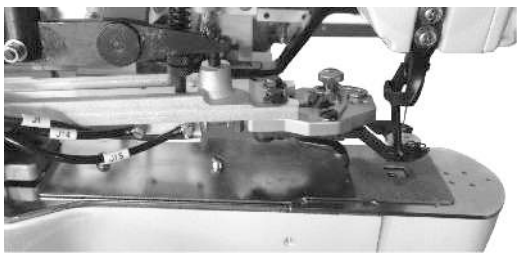


图5

图6

3、接通总气源，调节气压表压力在0.35－0.4Mpa之间（如图**6**所示）。

4、按下电源开关，电源指示灯亮，触摸屏显示功能页面（如图7所示），调节送料盘速度，以能够连续供应纽扣为准，让轨道充满扣子。

图7

5、抬起钉扣机压脚，按下"手动补扣"键（如图8所示）。

图8

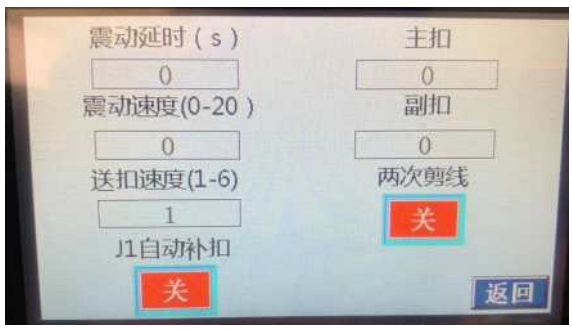


图9

6、按下"手动补扣键"，核对纽扣爪座规格是否合适，如果不匹配就要更换扣爪座(如图8)。

7、按手动测试键、再按挡板伸缩键。伸出闸板，调整纽扣间隙为0.2－0.5MM为佳。

8、主扣、副扣的设置：数量多的纽扣则为主扣，震动盘直接输送，数量少则为副扣，手动补副扣。钉扣前设置主、副扣的数量，其中一项数字为0，则不分主、副扣(如图9所示)。

钉副扣时,脚跟往后踩,扣爪送扣,送好扣后往前踩钉扣。

注:钉主副扣时,先取下扣夹上的扣子,再输入主副扣数量。

9、钉大扣(纽扣直径大于20mm)

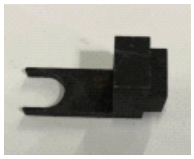
(1)把J6气管适当调小,让机臂送出慢一点,以不飞扣为准;

(2)把送扣速度调到1档;

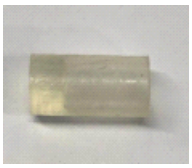
(3)送扣到位延时设置到0.06－0.09。

10、压扣部位调节:

压扣胶嘴　　压扣叉



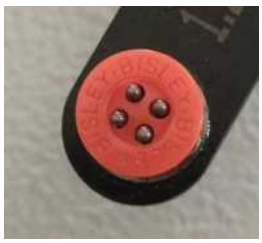
(1) 压扣叉



(2) 压扣胶嘴

(3)压扣胶嘴

图(4)



图(5)

1.机上安装(1)压扣叉和（2）压扣胶嘴

2.附件包配(1)压扣叉和（3）压扣胶嘴

3.特别说明:

＊（2）压扣胶嘴适合纽扣直径小于等于15mm的扣子

＊（3）压扣胶嘴适合纽扣直径大于15mm的扣子或纽扣中间突出的

4.以上为建议尺寸搭配，根据实际纽扣尺寸更换不同大小尺寸压扣胶嘴。

5.图(4)(5)：更换扣爪时，找一个跟纽扣孔相对应的扣爪，扣爪的针跟纽扣孔的四周必须要有间隙，以免压扣不稳。

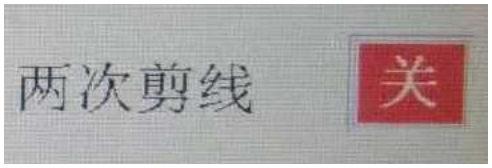
6.图(6):J10节流阀松开，气缸压力加大，压扣电机上升速度加快、拧紧气缸压力变小，压扣电机上升速度减慢。

7.图(6):压扣弹簧压力调节：薄的扣子顺时针往下压，调大压力；厚的扣子逆时针往上旋转，减小压力。以压扣通畅、压扣噪音小为准。

(6)

11、按下复位键，机器恢复到初始化状态。

（四）、支持钉扣机二次剪线功能



可支持钉扣机一次剪线功能和二次剪线功能

六、钉扣操作

按钉扣机说明书操作

七、故障排除

1、纽扣不落位

解决方法：

1、检查磁控开关位置
2、检查旋转立柱和送扣针板的中心位置
3、检查闸板位置
4、检查PLC 24V输入端是否正常
5、检查24V电源

2、不送扣：

解决方法：

1、检查自动送扣光电开关X6位置
2、检查机臂上升磁控开关X0位置
3、检查原点磁控开关位置
4、检查主板相关输入端
5、检查24V电源

3、震动器不工作：

解决方法：

1、检查震动输出电源是否有电压
2、检查485通信

重机款：1900、1903系列
感应固定支架安装正确位置

图(1)送扣传感器未安装前

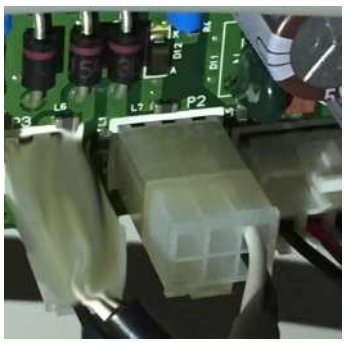
图(2)送扣传感器安装后

安装方法：先将（图1）钉扣机的接地线拆掉,再调节剪线连杆至最低点,然后将送扣机传感器安装在螺丝孔上,调节传感器与连接杆的位置使其相距0.5mm左右（传感器灯亮），见图(2)。

注意：不能碰到传感器。以免撞坏传感器。

兄弟款:438D、438FX系列
感应固定支架安装正确位置

图(3)438D电磁铁插座位置



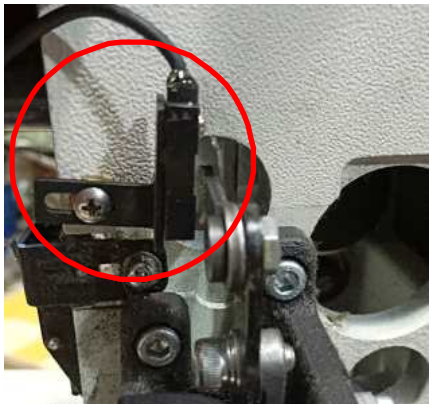
图(4)438FX电磁铁插座位置

图(5)送扣传感器安装后(438D、438FX)

安装方法：安装前找出钉扣机的剪线电磁铁见图(3)(4)，然后把线拨开，把送扣机的送扣传感器线并接在剪线电磁铁的上面，见图(5)。包上绝缘胶带。

注：在钉扣时，因钉扣机型号不同，可能出现送扣信号反应慢，在“送扣信号延时”功能里修改延时数值，数值越小，信号越快，系统默认0.10。

兄弟款:438HS系列
传感器感应固定支架安装位置



图(**6**)送扣传感器安装位置

安装方法：先在红圈标注的相应位置打孔,再调节剪线连杆至最低点,然后将送扣机传感器安装在螺丝孔上,调节传感器与连接杆的位置使其相距0.5mm左右（传感器灯亮），见图(6)。

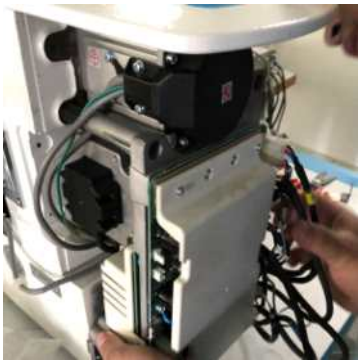
注意：不能碰到传感器。以免撞坏传感器。

图(**7**)电磁铁插座位置

图(**8**)J28断针保护传感器安装位置

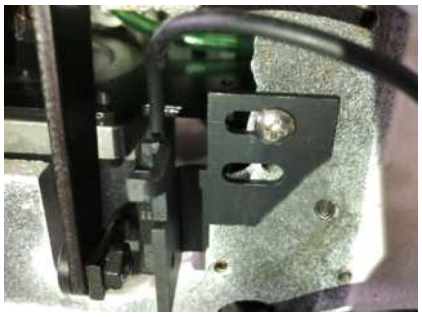
安装方法(J28断针保护传感器)：安装前先找出钉扣机的脚踏开关（图7）（P8位置）插座，把脚踏开关的电线插座拔出，找出其中一根红色的电线剪断，一端接J28传感器电线另一端接在J28传感器另一根(如图8），包上绝缘胶带，再将脚踏开关插到P8位置。

杰克款 一体机
传感器感应固定支架安装位置



图(**9**)安装前

图(**10**)安装前



图(**11**)送扣传感器安装后

安装方法：先将（图9）钉扣机的后面外壳拆掉后再把电控拆掉（见图10）,再调节剪线连杆至最低点,然后将送扣机传感器安装在螺丝孔上,调节传感器与连接杆的位置使其相距0.5mm左右（传感器灯亮），见图(11)。

注意：不能碰到传感器。以免撞坏传感器。

中捷款 一体机
传感器感应固定支架安装位置

图(**12**)安装前

图(**13**)传感器安装后

图(**14**)传感器安装后

安装方法：先将钉扣机的后面外壳拆掉（见图12），将传感器固定在钉扣机上，传感器灯亮（见图13），以确保剪线铁片在剪线时不会碰到传感器见图(14)。注意：不能碰到传感器。以免撞坏传感器。

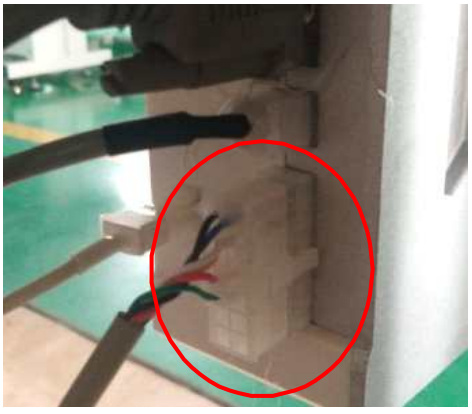
杰克款、中捷款 分体机
传感器感应固定支架安装位置

图(**15**)安装前

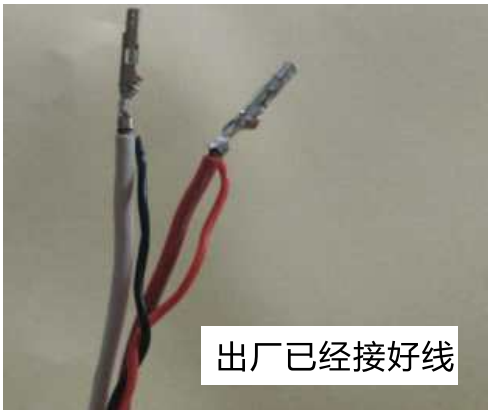
图(**16**)传感器安装后

安装方法：先将钉扣机的后面外壳拆掉（见图15），再调节剪线连杆至最低点，然后将送扣机传感器安装在螺丝孔上,调节传感器与连接杆的位置使其相距0.5mm左右（传感器灯亮），见图(16)。
注意：不能碰到传感器。以免撞坏传感器。

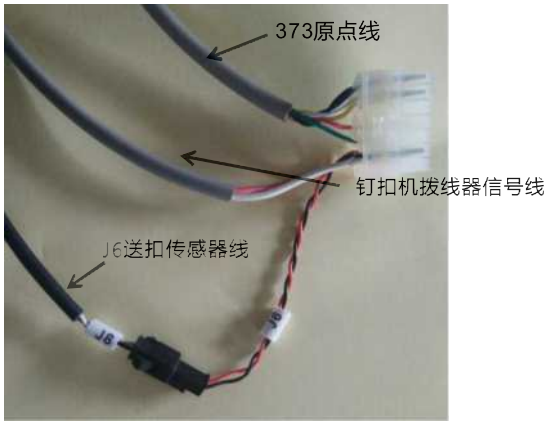
373D钉扣机
感应固定支架安装位置



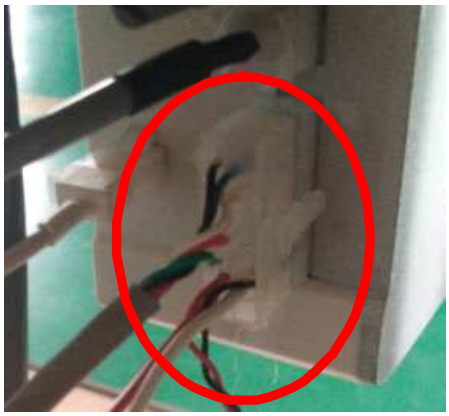
图(17)373D传感器安装前



图(**18**)



图(**19**)373D传感器安装后

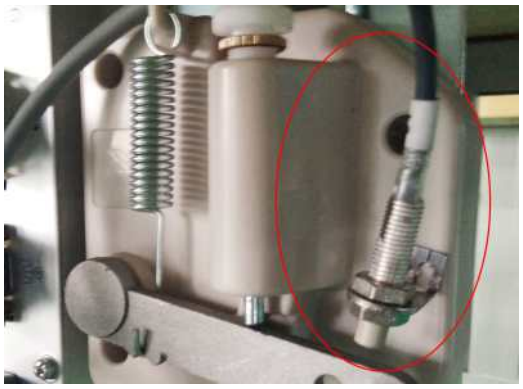


图(**20**)373D传感器安装后

安装方法: 安装前找出钉扣机的剪线电磁铁见图(17)、，然后将送扣传感器线并接在钉扣机拨线器信号线上(图18图19)，再插入到剪线电磁铁插头孔上（如图20）。

副扣送扣传感器安装位置

安装前(图**21**)



安装后(图**22**)

安装方法: 先安装传感器固定架,再安装J7断针保护传感器，脚踏往后踩到底，传感器调节到灯灭位置，拧紧螺丝，如图(**21**)(**22**)。

注意:不能碰到传感器,以免撞坏传感器。

J28断针保护传感器安装位置(保护钉扣机)

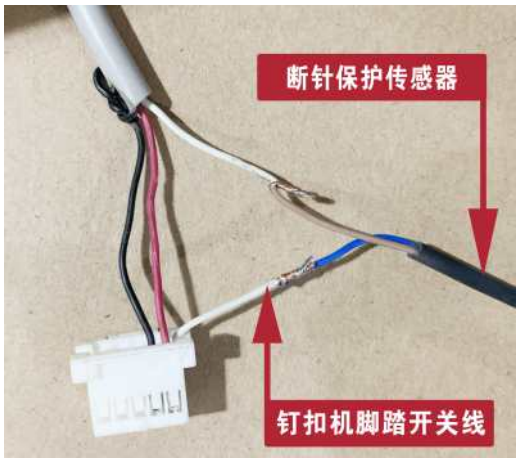


图23

安装方法: J28断针保护传感器接到钉扣机脚踏开关电线上，把脚踏开关的其中一根白色的电线剪断，一端接J28传感器电线其中一根，另一端接在J28传感器另一根,包上绝缘胶带(如图23)。

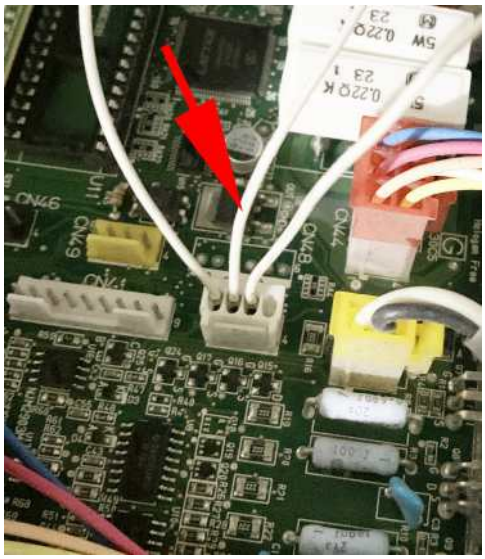


图24

安装方法(重机老款): J28断针保护传感器接到钉扣机脚踏开关电线上，把脚踏开关的中间白色线剪断，一端接J28传感器电线其中一根，另一端接在J28传感器另一根。包上绝缘胶带(如图24)。

I.Overview

Automatic button feeding device is composed of feeding identification mechanism, pneumatic button transmission mechanism, button rotating and falling mechanism, thickness measuring mechanism, gate adjusting mechanism, mechanical arm button feeding device, thread loosening mechanism, as well as mechanical, electrical and gas part and control mechanism. It can be compatible with different brands and models of button sewing machine, featuring quick button feeding speed, high button feeding stability, small failure rate, significant reduction of labor intensity, inprovement of production efficiency, simple operation, etc.

II. Technical Parameters

No.	Parameter contents	Standard range	Remarks
1	Power supply voltage	110/220V	
2	Rated power	260W	
3	Package size	580×630×500MM	
4	Weight	40KG	
5	Rated button sewing speed	19200-24000pcs/8h	
6	Continuous button feeding speed	28800-31200pcs/8h	
7	Button feeding stability	99.7%	
8	Button diameter	9-27mm	
9	Suggested air pressure	0.3-0.35Mpa	

III. Safety Warning

1.Before installing and using this equipment, users must carefully read the relevant safety precautions, to ensure personal safety and avoid equipment damage. The company will not bear any responsibility for any personal injury or equipment damage resulting from failure to comply with the operational requirements of this instructions.

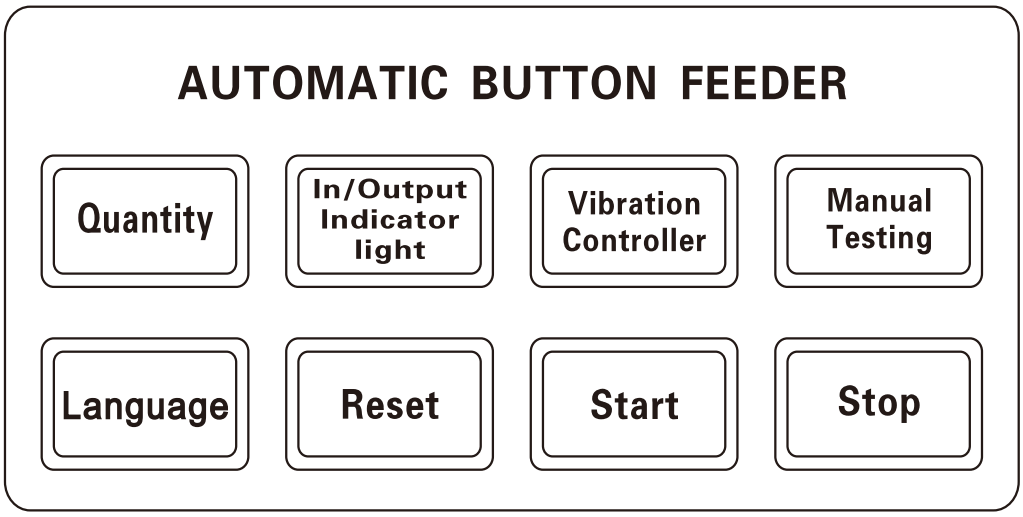
2.Before installation, be ensure the pressing foot working well at the highest area.

3.Before connecting the machine to the power supply, arrange the qualified professional electrician to check the power supply voltage, frequency, power and other parameters are in line with the identifications of machine nameplate. The metal casing of machine must be connected to the case of sewing machine using metal wire and then connected to the special protective grounding wire using grounding wire.

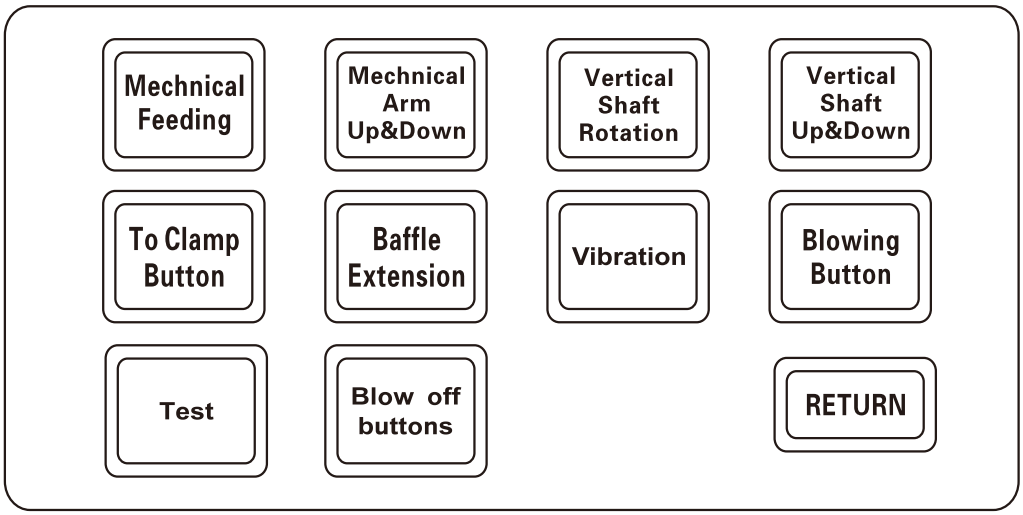
4.During the repair or adjustment of device, cut off the power supply and gas supply to ensure safety.

5.Do not put hands on the moving parts of machine to avoid injury. The total intake source of compressed air should be between 0.35 and 0.4Mpa.

IV. Introduction to Panel Functions

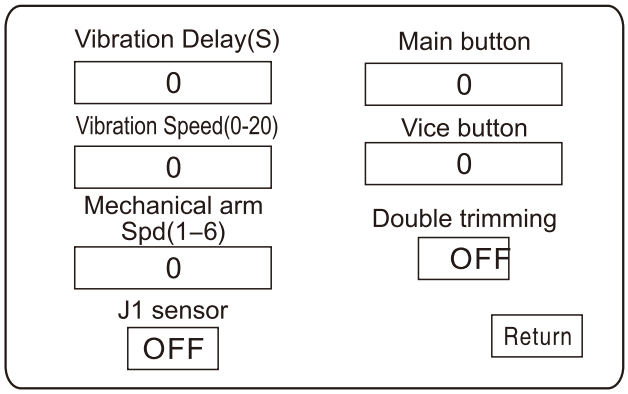


Quantity	“Quantity”: It shows the current quantity; the quantity will be reset after pressing this key.
In/Output Indicator light	“Output/input indicator light”:Display the working indicator lights of all systems by pressing this key.
Vibration Controller	“Button feeding control/Vibration Controller”:Set the time of vibration, gear of vibration and speed of button feeding by pressing this key.
Manual Testing	“Manual testing”:Enter function page by pressing this key, select the function button that you want to test, and make the machine run by pressing this key.
Language	“Language”:Multilingual switch.
Reset	“Resetting”:Pressing this key for resetting when the system is giving an alarm.
Start	“Start”:The machine will start working after pressing this key.
Stop	“Stop”:The machine will stop working after pressing this key.



Mechnical Feeding	“Feeding button by engine arm”: Engine arm will rotate anticlockwise after pressing this key; the engine arm will rotate clockwise after pressing this key again.
Mechnical Arm Up&Down	“Moving up and down of engine arm”: The engine arm will move up after pressing this key; and the engine arm will move down after pressing this key again.
Vertical Shaft Rotation	“Rotation of vertical shaft”: Vertical shaft will rotate after pressing this key.
Vertical Shaft Up&Down	The vertical shaft will move down after pressing this key and the vertical shaft will move up after pressing this key again.
To Clamp Button	Button clamp will be unfolded after pressing this key and the button clamp will be folded after pressing this key again.

Baffle Extension	The damper will stretch out to block the buttonfrom moving, and the damper will draw back and button can freely move after pressing this key again.
Vibration	Vibration start after pressing this key.
Blowing Button	Button feeding will be conducted once by blowing gas after pressing this key.
Test	Automatic single step operation after pressing this key.
Blow off Buttons	Blow off the buttons feeding groove after pressing this key.
RETURN	Return to the precious page after pressing this key.



Vibration Delay	The vibration disk will stop vibration lingeringly when machine stops working. The larger the input digits, the longer the delay. The maximum delay will last for 30s.
Vibration speed	The larger the input digits, the bigger the vibration force when vibration disk is under vibration.
Mechanical arm spd	The larger the value, the faster the mechanical arm speed; The smaller the value, the smaller the mechanical arm speed.
Main/vice button	Set the quantity of main and vice button before button attaching. If one digit is zero, the main and vice button will not be classified. The system default number is 0.
Double trimming	Open the secondary trimming function of button attaching machine if necessary, then press this key to launch the secondary trimming function, at this moment, the button attaching machine will shear line twice and button sender feeds button once. The system is opened by default.
J1 sensor	Press the key to turn off the sensor of J1 retaining clip cylinder, meanwhile, the automatic button feeding function is closed and the system is opened by default.
RETURN	Return to the precious page after pressing this key.

J9 pressure regulating valve by gas blowing: When buttons are delivered to button feeding track at the vibrating plate, feed the buttons at the gripper arm through gas blowing, and the recommended air pressure is between 0.3-0.35Mpa.

Thickness Measurement: Pressing this key, lift the pressing plate for measuring thickness, take one button to be used and place it on the plate, and then release this key.

Manually Feeding: Press this key for manually repairing button when there is no button in the gripper.

V. Introduction to Basic Operation

1.Start-up operation:

1.Check whether there are tools or foreign objects around the machine.
2.Connect to the gas source, adjust the pressure and ensure the value of pressure gauge is between 0.3-0.35Mpa.
3.After turning on the power, the button indicator lights at the panel will become green and function interfaces will be displayed on the touch screen.
4.After pressing the resetting key, the machine will be restored to the original state, namely standby state.
5.After pressing the preparation key of sewing machine, the presser foot will be lifted, and the operation screen will become green and the machine will enter standby state.

2.Original state:(standby state)

NO.	Name of cylinder	Name of magnetic switch	State	Indicator light of magnetic switch	Remarks
1	Cylinder for making mechanical arm move up and down	X0(J2)	At the up position	It is on	
2	Cylinder for making gripper take button	X1(J1)	Fold	It is on when there is button	Putting on button manually
3	Vice buttons sensor	X3(J7)			
4	Manually feeding button	X4			
5	Home position	X6	Correct degree position	It is off	
6	Correct degree position sensor	X7	Correct degree position	It is on	
7	Thickness measurement button	X10			
8	Needle protection sensor	J28			

3.Button change operation:

1.Press the thickness measuring key (as shown in Fig.1), and then take one button to be used and put it below the pressing plate for measuring thickness 、 width and adjusting the blocker automatically.(as shown in Fig.2 3 4).

Fig.1

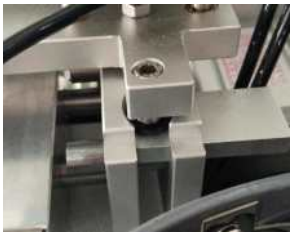


Fig.2

Fig.3

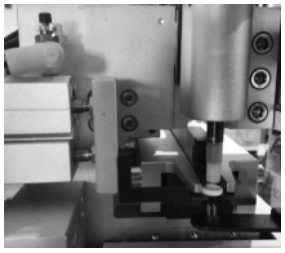


Fig.4

2. When change buttons, in order to feeding buttons correctly, according to the different size of button's diameter to adjusting the J1 sensor position. (as shown in Fig.5)

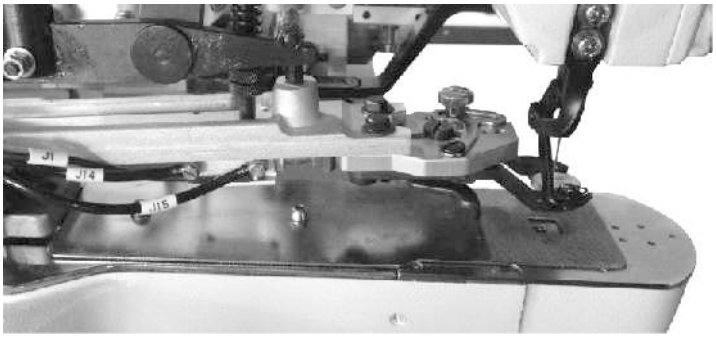


Fig.5

3.Conntect to the total intake air supply, adjust the pressure of gas pressure meter to be between 0.35-0.4Mpa. (as shown in Fig.6)

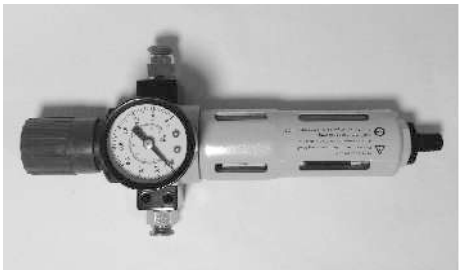


Fig.6

4.After pressing the power switch, the power indicator light will be on (as shown in Fig.7), the touch screen will display function page to adjust the speed of feed tray, so as to continuously feed buttons and make track full of buttons.

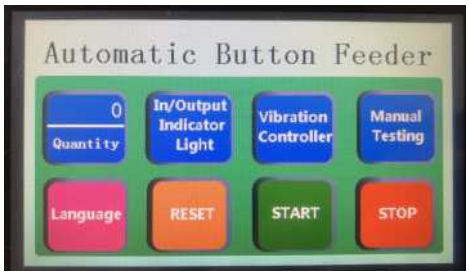


Fig.7

5. Lift the presser foot of button sewing machine, press the key "Manually Feeding button" .(as shown in Fig.8)

MANUALLY FEEDING

Fig.8

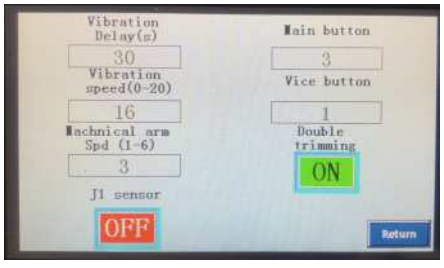


Fig.9

6.Press the key “Manually Feeding button”, check whether the specifications of button gripper base are appropriate, and replace it if the specifications are not appropriate.

7.Press the key “Manual testing” and then “Stretching out and drawing back of damper”. Stretch out the gate, and adjust the gap between buttons to be 0.2-0.5MM.

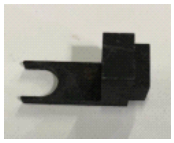
8.Main buttons & Vice buttons set : Large number of buttons for Main buttons through to the vibrate plate for feed. Little number of buttons for vice buttons by manual feed Before start, set the main buttons and vice buttons quantity. Vice buttons set “0” means only one type buttons for work.(Fig.9)

9.Sewing big size of button(over 20mm diameter)

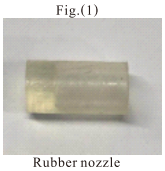
(1)With no flying buckle as the benchmark, appropriately reduce the J6 air pipe to show down the mechanical arm delivery.
(2)Adjust the mechanical arm feeding speed to 1.
(3)Send buckles in place delayed to set 0.06-0.09.

10.Pressing buttons area

Rubber nozzle Front guide block



Front guide block
Fig.(1)



Rubber nozzle
Fig.(2)

Rubber nozzle
Fig.(3)

Fig.4

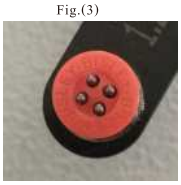


Fig.5

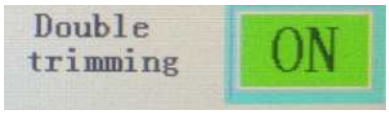
1.Original machine installed (1)Front guide block & (2)Rubber nozzle
2.Accessory packing with (1)Front guide block & (3)Rubber nozzle
3.Important note:
(2)Suitable for buttons size less than 15mm
(3)Suitable for buttons size over than 15mm or convex buttons
4.Suggestion collocation of above, please following the actual situations to change different size of front guide block and rubber nozzle.
In order to press buttons stability and smoothly on the pin plate, plz use correct demensions of the pin plate for buttons when replace the pin plate. (Important note. its the best size for the pin plate if all pins in the middle center position of the button’s hole)

5.Loosen J10 throttling valve to increase the cylinder pressure, meanwhile, the pressing button motor will rise at a higher speed, but the tightened cylinder pressure is decreased and pressing button motor rises at a slower pace.Fig4 5
6.Pressure control for the spring: For thin buttons, clockwise rotating the spring ,spring's pressure became bigger. For thick buttons ,anticlockwise rotating the spring, spring's pressure became small. Important note : All based on press buttons smoothly , stability, lower noisy as the standard.(Fig.6)

(6)

11.Press the key "Resetting" to restore the machine to initial state.

4. Support second time thread trimming function:



Support button sewing machine second time and one time thread trimming function

VI. Button Sewing Operations:

Conduct Operations according to the instructions of button sewing machine.

VII. Troubleshooting

1.Buttons do not fall to the proper position

Solution:

1.Check the position of magnetic switch
2.Check the central position of rotating column and button feeding needle plate
3.Check the position of gate
4.Check whether the 24V input terminal of PLC is normal
5.Check 24V power supply

2. Do not feed buttons:

Solution:

1.Check the position of photoelectric switch X6 for automatically feeding buttons
2.Check the position of magnetic switch X0 for lifting engine arm
3.Check the position of magnetic at origin
4.Check motherboard-related input terminal
5.Check 24V power supply

3. Vibrator does not work

Solution:

1.Check whether the vibration output power supply has voltage
2.Check 485 communication

Button sewing machine(JUKI type):1900 and 1903 series

Proper position for installation of sensor fixing support

Fig.1 Before the button feeder machine sensor is installed

Fig.2 After the button feeder machine sensor is installed

Installation method: Take the white fastener out of the machine (Fig.1), Adjust the trimming rod to the lowest level. Then install the button feeder's sensor on to the screws. Adjusting to make the distance between sensor and connector is 0.5mm(Fig.2).

Button sewing machine brother type/438D series 438FX siries

Fig.3 Electromagnet connector position(438D)

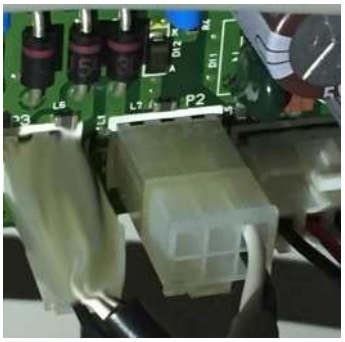


Fig.4 Electromagnet connector position(438FX)

Fig.5 After the sensor is installed(438D/438FX)

Installation method: Before installation, pill out the electromagnet sensor wires, connect together with the automatic button feeder's sensor, then connect on the PCB.(Fig.3 4 5)

Brother products: 438HS Series

Installation Position of Sensor Fixing Support

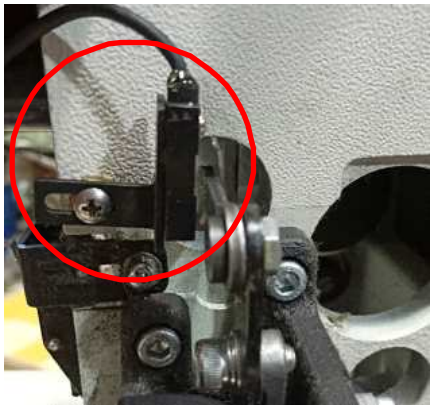


Fig.6 Installation Position of Button Sender Sensor

Installation method: The red circle with the corresponding position of the first punch ,bottom out the trimming connecting rod, install button attaching machine sensor in screw hole, adjust the sensor and connecting rod until the spacing is 0.5mm (sensor light is on), as shown in Fig. (6). Notes: Don't touch sensor for fear of any damage.

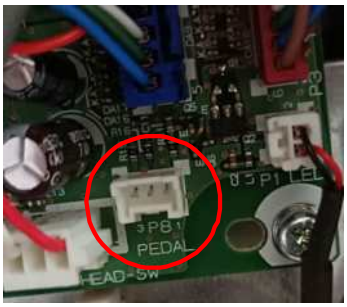


Fig.(7)438HS Electromagnet Socket Position

Fig. (8) Installation Position of J28 Broken Needle Protection Sensor (Protect the Button Attaching Machine)

Installation method: Find out pedal switch (Fig. 7) (P8 position) socket of button attaching machine before installation, pull out the pedal switch wire from socket, shear a red wire, connect one end with J28 sensor wire and link up the other end with another J28 sensor (Fig. 8), wrap the insulated tape and insert the pedal switch in P8.

JACK (JACK) all-in-one machine

Installation Position of Induction Fixing Support

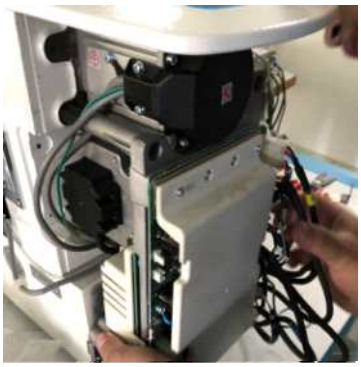


Fig. (9) Before Installation

Fig. (10) Before Installation

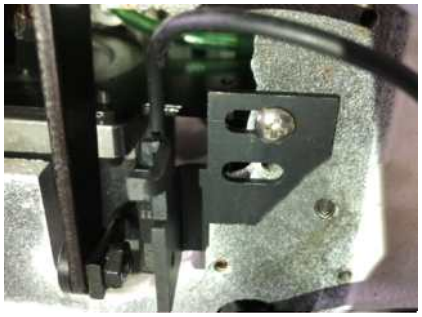


Fig. (11) After Button Sender Sensor Installation

Installation method: Pull down the back of the nailcatcher machine shell Fig(9),then Electric control tear down Fig(10), bottom out the trimming connecting rod, install button attaching machine sensor in screw hole, adjust the sensor and connecting rod until the spacing is 0.5mm (sensor light is on), as shown in Fig. (11).
Notes: Don't touch sensor for fear of any damage.

ZOJE all-in-one machine

Installation Position of Induction Fixing Support

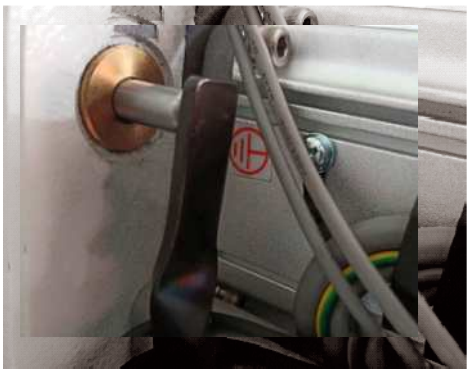


Fig. (12) Before Installation

Fig. (13) After the Sensor Installation Fig. (14) After the Sensor Installation

Installation method: Dismantle the shell behind button attaching machine (Fig. 12), fix the sensor on button attaching machine until sensor light is on (Fig. 13) and sensor is not touched by trimming iron (Fig. 14).

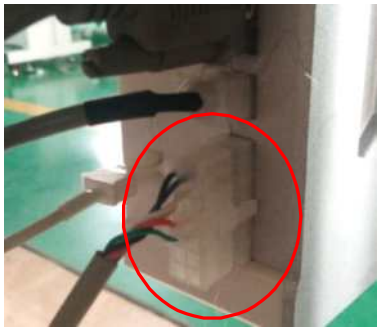
JACK and ZOJE split machine

Installation Position of Induction Fixing Support

Fig. (15) Before Installation Fig. (16) After the Sensor Installation

Installation method: Behind the nailcatcher machine shell down first (Fig.15), bottom out the trimming connecting rod, install button attaching machine sensor in screw hole, adjust the sensor and connecting rod until the spacing is 0.5mm (sensor light is on), as shown in Fig. (16). Notes: Don't touch sensor for fear of any damage.

Position for install the sensor(373D)



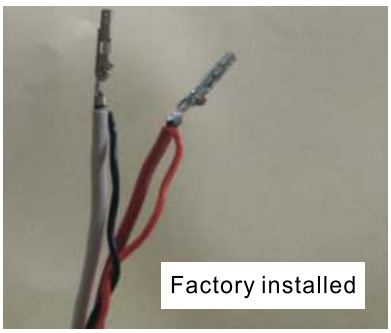


Fig.17 Before the 373D sensor is installed Fig.18

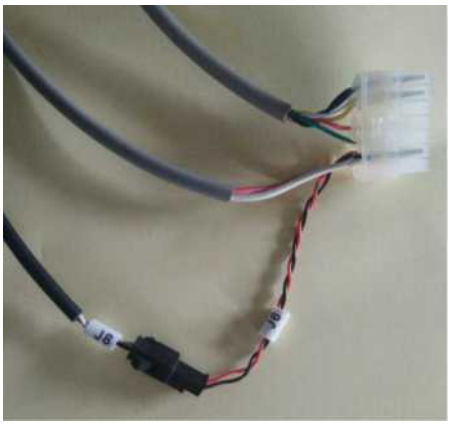


Fig.19 After the 373D sensor is installed

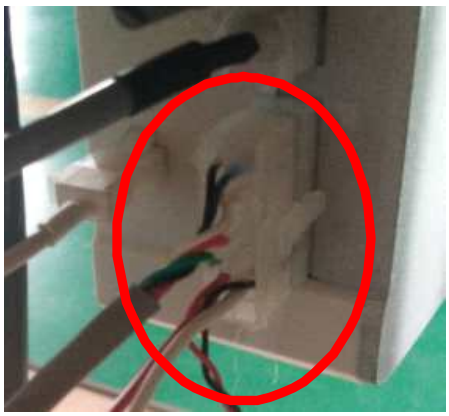


Fig.20 After the 373D sensor is installed

Installation method: Installation method: Before installing, find out the trimming electromagnet of the button attaching machine Fig. 17, then push the wire aside, connect the button feeding sensor of the feeder with the wiper signal cable, then insert jack. See Fig. (19)(20).

Proper position for installation of Vice button feeder sensor

Fig.21 Before the sensor is installed

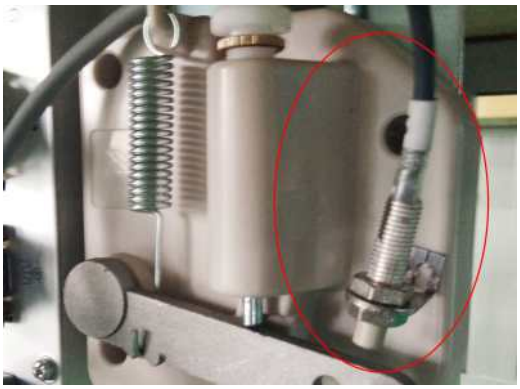


Fig.22 After the sensor is installed

Installation method: First install the sensor fixing rack, then install needle protection sensor. Stepped on the pedal at the backward, move the sensor to make the lamp go out. tighten the screw. Fig.(21) (22)

Installation position of J28 broken needle protection sensor

(protect button attaching machine)

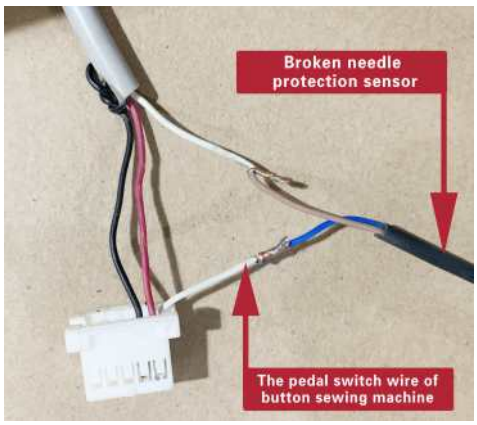


Fig.23

Installation method:

Connect J28 broken needle protection sensor to the pedal switch wire of button attaching machine, shear off one white wire of pedal switch, connect one end with that of J28 sensor and link up another end with corresponding wire of J28 sensor. Wrap the insulating tape around it (Fig.23).

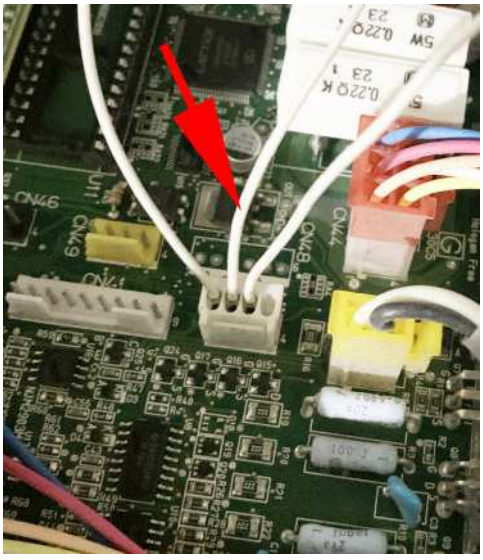
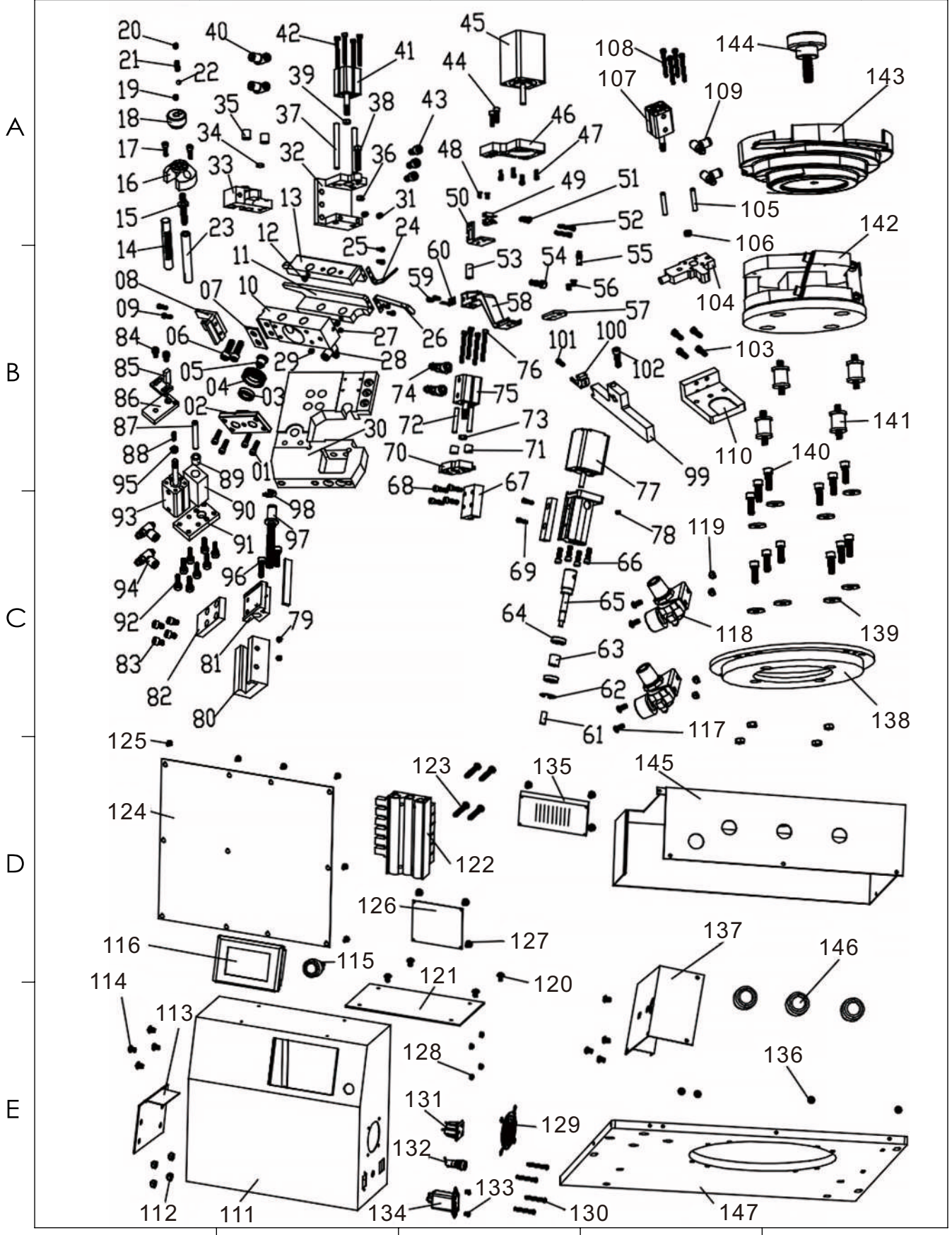


Fig.24

Installation method(Old style of JUKI):

Connect J28 broken needle protection sensor to the pedal switch wire of button attaching machine, shear off the white line in the middle of pedal switch, connect one end with that of J28 sensor and link up another end with corresponding wire of J28 sensor. Wrap the insulating tape around it. (Fig.24)

SiRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASO-ABF110A			1 / 1
				Date
				2021/5/28



SiRUBA

SEQUENCE LIST

Series	Parts Group	Subclass Remark	Page
ASO-ABF110A			1 / 2
			Date
			2021/5/28

Ref.N	Parts.No	Description	品名	Amt.Req
1	ABF1001	Hexagon socket screw M4*15L	內六角螺絲 M4*15L	4
2	ABF1002	Fixing plate	固定板	1
3	ABF1003	Bearing Φ19*Φ10*5	軸承 Φ19*Φ10*5	1
4	ABF1004	Gear	齒輪 (A)	1
5	ABF1005	Pillar screw	台柱螺絲 (B)	1
6	ABF1006	Hexagon socket screw M6*20L	內六角螺絲 M6*20L	2
7	ABF1007	Tilting pad	斜墊	1
8	ABF1008	Button tray	紐扣托盤	1
9	ABF1009	Hexagon socket screw M3*10L	內六角螺絲 M3*10L	2
10	ABF1010	Button guiding bar(B)	紐扣導條 (B)	1
11	ABF1011	Button side guiding bar(2)B	紐扣導邊條 (2)B	1
12	ABF1012	Fixing screw M5*5L	止付螺絲 M5*5L	1
13	ABF1013	Button side guiding bar(1)A	紐扣導邊條 (1)A	1
14	ABF1014	Guide gear rack(2)	導向齒條 (2)	1
15	ABF1015	Adjustment lead screw	調整牙桿	1
16	ABF1016	Adjustment base	調整座	1
17	ABF1017	Hexagon socket screw M4*15L	內六角螺絲 M4*15L	2
18	ABF1018	Adjustment handle	調整手柄	1
19	ABF1019	Fixing screw M5*5L	止付螺絲 M5*5L	1
20	ABF1020	Fixing screw M5*5L	止付螺絲 M5*5L	1
21	ABF1021	Spring	彈簧	1
22	ABF1022	Steel ball	鋼珠	1
23	ABF1023	Guide gear rack(1)	導向齒條 (1)	1
24	ABF1024	Guide vane(1)	導向片 (1)	1
25	ABF1025	Hexagon socket screw M2.5*6L	內六角螺絲 M2.5*6L	2
26	ABF1026	Guide vane(2)	導向片 (2)	1
27	ABF1027	Fixing screw M4*5L	止付螺絲 M4*5L	1
28	ABF1028	Three-way connector	三通接頭	1
29	ABF1029	Fixing screw M5*5L	止付螺絲 M5*5L	1
30	ABF1030	Frame plate	機架板	1
31	ABF1031	Fixing screw M5*5L	止付螺絲 M5*5L	2
32	ABF1032	Guide post base	導柱座 -B	1
33	ABF1033	Slider	滑塊	1
34	ABF1034	Rubber gasket	膠墊	1
35	ABF1035	Copper bushing	銅導套	2
36	ABF1036	M5 nut	M5 螺母	1
37	ABF1037	Guide pillar	導柱	1
38	ABF1038	Screw M5*30L	外六角螺絲 M5*30L	1
39	ABF1039	M5 nut	M5 螺母	1
40	ABF1040	Air pipe joint	氣管接頭	2
41	ABF1041	Air cylinder 25*10	氣缸 25*10	1
42	ABF1042	Hexagon socket screw M3*35L	內六角螺絲 M3*35L	4
43	ABF1043	Hexagon socket screw M6*12L	內六角螺絲 M6*12L	3
44	ABF1044	Hexagon socket screw M4*15L	內六角螺絲 M4*15L	2
45	ABF1045	Motor(42)	馬達 (42)	1
46	ABF1046	Motor base	馬達座	1
47	ABF1047	Hexagon socket screw M3*8L	內六角螺絲 M3*8L	4
48	ABF1048	Flat-head screw M3*6L	沉頭螺絲 M3*6L	2
49	ABF1049	Photoelectric sensor	光電傳感器	1
50	ABF1050	Sensor base	傳感器座	1
51	ABF1051	Hexagon socket screw M3*10L	內六角螺絲 M3*10L	1
52	ABF1052	Hexagon socket screw M3*20L	內六角螺絲 M3*20L	2
53	ABF1053	Motor shaft sleeve	馬達軸套	1
54	ABF1054	Hexagon socket screw M5*16L	內六角螺絲 M5*16L	1
55	ABF1055	Button gripper	紐扣爪	1
56	ABF1056	Flat-head screw M4*6L	沉頭螺絲 M4*6L	2
57	ABF1057	Button gripper base	紐扣爪座	1
58	ABF1058	Gripper arm	爪臂	1
59	ABF1059	Hexagon socket screw M3*5L	內六角螺絲 M3*5L	2
60	ABF1060	Photoelectric spacer	光電隔片	1
61	ABF1061	Rubber nozzle	膠嘴	1
62	ABF1062	Hole closing ring Φ17	孔擋圈 Φ17	1
63	ABF1063	Spacer bush	隔套	1
64	ABF1064	Bearing Φ17*Φ7*5	軸承 Φ17*Φ7*5	2
65	ABF1065	Pressing shaft	壓軸	1
66	ABF1066	Hexagon socket screw M4*15L	內六角螺絲 M4*15L	4
67	ABF1067	Sliding track	滑軌	1
68	ABF1068	Hexagon socket screw M4*15L	內六角螺絲 M4*15L	4
69	ABF1069	Hexagon socket screw M3*10L	內六角螺絲 M3*10L	2
70	ABF1070	Lifting block	舉升塊	1
71	ABF1071	Copper bushing	銅套	2
72	ABF1072	Guide pillar	導柱	2
73	ABF1073	M5 nut	M5 螺母	1

A B C D E

1 2 3 4 5

SiRUBA SEQUENCE LIST	Series	Parts Group	Subclass Remark	Page
	ASO-ABF110A			2 / 2
				Date
				2021/5/28

74	ABF1074	Air connector	氣管接頭	2
75	ABF1075	Air cylinder 25*10	氣缸 25*10	1
76	ABF1076	Hexagon socket screw M3*35L	內六角螺絲 M3*35L	4
77	ABF1077	Motor(35)	馬達 (35)	1
78	ABF1078	Fixing screw M4*5L	止付螺絲 M4*5L	1
79	ABF1079	Fixing screw M4*5L	止付螺絲 M4*5L	2
80	ABF1080	Sliding block base	滑塊座	1
81	ABF1081	Sliding block	滑塊	1
82	ABF1082	Air cylinder fixing plate(2)	氣缸固定板 (2)	1
83	ABF1083	Hexagon socket screw M5*8L	內六角螺絲 M5*8L	4
84	ABF1084	Hexagon socket screw M4*10L	內六角螺絲 M4*10L	2
85	ABF1085	Check block	擋塊	1
86	ABF1086	Guide plate	導板	1
87	ABF1087	Guide pillar	導柱	1
88	ABF1088	Hexagon socket screw M3*10L	內六角螺絲 M3*10L	1
89	ABF1089	Copper bushing	銅套	1
90	ABF1090	Guide rod base	導桿座	1
91	ABF1091	Vertical plate	立板	1
92	ABF1092	Hexagon socket screw M4*20L	內六角螺絲 M4*20L	8
93	ABF1093	Air cylinder 25*20	氣缸 25*20	1
94	ABF1094	Air connector	氣管接頭	2
95	ABF1095	M5 nut	M5 螺母	1
96	ABF1096	Hexagon socket screw M5*20L	內六角螺絲 M5*20L	2
97	ABF1097	Screw	螺桿	1
98	ABF1098	Split washer Φ10*1	開口擋圈 Φ10*1	1
99	ABF1108	Button depression bar	紐扣壓條	1
100	ABF1109	Front guide block	前導向塊	1
101	ABF1110	Hexagon socket screw M3*10L	內六角螺絲 M3*10L	1
102	ABF1111	Hexagon socket screw M4*15L	內六角螺絲 M4*15L	1
103	ABF1112	Hexagon socket screw M4*15L	內六角螺絲 M4*15L	4
104	ABF1113	Location-limited plate	限位板	1
105	ABF1114	Guide pillar	導柱	2
106	ABF1115	M5 nut	M5 螺母	1
107	ABF1116	Air cylinder 25*10	氣缸 25*10	1
108	ABF1117	Hexagon socket screw M3*35L	內六角螺絲 M3*35L	4
109	ABF1118	Air connector	氣管接頭	2
110	ABF1119	Location-limited base	限位座	1
111	ABF1220	Electric cabinet	電控箱	1
112	ABF1221	M4 nut	M4 螺母	4
113	ABF1222	Outer cover	外蓋	1
114	ABF1223	Philip's head screw M4*6L	十字頭螺絲 M4*6L	4
115	ABF1224	Start button	啟動按鈕	1
116	ABF1225	Control panel	控制屏	1
117	ABF1226	Philip's head screw M4*10L	十字頭螺絲 M4*10L	4
118	ABF1227	Pressure gauge	壓力表	1
119	ABF1228	M4 nut	M4 螺母	4
120	ABF1229	Philip's head screw M4*6L	十字頭螺絲 M4*6L	4
121	ABF1230	Top plate	頂板	1
122	ABF1231	Valve assembly	電磁閥連座	1
123	ABF1232	Philip's head screw M4*35L	十字頭螺絲 M4*35L	4
124	ABF1233	Back cover plate	後蓋板	1
125	ABF1234	Self-tapping screw M4	自攻螺絲 M4	11
126	ABF1235	Electronic motherboard	電子主板	1
127	ABF1236	Philip's head screw M4*6L	十字頭螺絲 M4*6L	4
128	ABF1237	M4 nut	M4 螺母	4
129	ABF1239	Mesh enclosure	網罩	1
130	ABF1240	Philip's head screw M4*35L	十字頭螺絲 M4*35L	4
131	ABF1241	Power socker	電源插座	1
132	ABF1242	Fuse	保險絲	1
133	ABF1243	Philip's head screw M4*6L	十字頭螺絲 M4*6L	2
134	ABF1244	Hoster socker	主機插座	1
135	ABF1246	Encoder	編碼器	1
136	ABF1247	Philip's head screw M4*6L	十字頭螺絲 M4*6L	4
137	ABF1248	Side plate	側板	1
138	ABF1249	Vibration base	震動底座	1
139	ABF1250	Gasket	墊片	8
140	ABF1251	Hexagon socket screw M6*20L	內六角螺絲 M6*20L	6
141	ABF1252	Shock pad	減震墊	4
142	ABF1253	Vibration base	震動座	1
143	ABF1254	Button plate	紐扣盤	1
144	ABF1255	With plastic bolt	帶塑螺栓	1
145	ABF1256	Main cover	主蓋	1
146	ABF1257	Button	按鈕	1
147	ABF1258	Baseplate	底板	1

A B C D E

1 2 3 4 5

Accessories List

PIC	Name	Details	Unit	Qty
	Air tube	3M	roll	1
	Power connector	-	PCS	1
	Wrenches	Size:10&12, 9&11, 8&10	PCS	3
	Hex wrenches	Size: 2, 2.5, 3, 4, 5	PCS	
	Fuse	5A	PCS	3
	Screwdrivers	Straight (3, 5, 6) mm	PCS	3
		Cross (5, 3) mm	PCS	2
	Tri-ply wood	☐ **Zoje: 11mm** ☐ **JUKI: 3mm** ☐ **Jack: 11mm+9mm** ☐ **Brother: 9mm**	PCS	1
	Screw for fix machines	-	PCS	3
	Screw	4*16	PCS	4
	Pin plate	2 pin (1.2x2.4, 2.7, 3.2, 3.4, 3.6, 3.8)	PCS	6
		4 pin (1.2x2.4, 2.7,3.2, 3.4, 3.6)	PCS	5
	Rubber tube	-	PCS	10
	Screw for fix pin plate	-	PCS	4
	Clamp	-	PCS	1

高林股份有限公司
KAULIN MFG. CO., LTD.

由於對產品的改良及更新 , 本產品零件圖及外觀的修改恕不事先通知 !
The specification and/or appearances of the equipment described in this parts list are subject to change because of modification which will without previous notice.
JML-18P05.MAY.2021