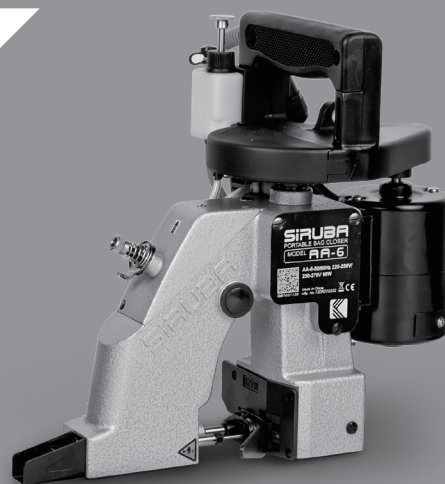


SIRUBA

使用說明書與零件圖

INSTRUCTIONS BOOK & PARTS LIST



■ AA



CE

危險水準的說明

Explanation of Dangerous Level

 <p>危險 Dangerous</p>	<p>如果忽視此標記而運行了錯誤的機械操作，保養時肯定會引起當事者或第三者人員重傷或死亡。</p> <p>Don't ignore the warning sign and don't proceed incorrect operation. Or it will cause the person or the third party seriously injured or dead during maintenance.</p>
 <p>注意 Caution</p>	<p>如果忽視此標記而運行了錯誤的機械操作，保養時有可能會引起當事者或第三者人員受傷及造成設備損壞。</p> <p>Ignoring this warning sign and proceed incorrect operation will cause the person involved or the third party wounded and equipment damaged during maintenance.</p>

警告圖案表示及表示標誌的說明

Explanation of Warning Signs and Labels

<p>警告圖案表示 Warning Sign</p>		<p>運動部位，謹防工傷事故</p> <p>Moving part, beware of industrial accident</p>
		<p>高壓部位，謹防觸電事故</p> <p>High voltage, beware of electric shock</p>
		<p>高溫部位，謹防燙傷事故</p> <p>High temperature, beware of burns</p>
<p>指示標幟 Instruction Label</p>		<p>禁止</p> <p>Prohibited</p>
		<p>地線的接線表示</p> <p>Indication of ground wiring</p>

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MODEL		AA-3/AA-6	
Net Weight (Kgs)	5	Noise Level, dB(A)	75.5dB(A)
Serial No.		Vibration(m/sec2)	
Dimension	Length 32cm	Width 22cm	Height 30cm

規格說明

針 : D5
馬達 : 1/8HP, 90W.
針距 : 7.2mm
重量 : 5kgs

SPECIFICATIONS

Needle : D5
Motor : 1/8HP, 90W.
Stitch length : 7.2 mm
Weight : approx.5 kgs

主要的特徵

- 1.單線環縫。
- 2.操作簡易
操作者以一手提著縫袋機，另一手拿著將被縫合的袋口，輕按控制鈕,即可開始縫,縫完後自動切斷線頭。
- 3.所有零組件都是經過嚴密設計，品質穩定，免於故障維修之苦。
- 4.可用於多層厚紙袋，PP/EE編織袋,棉,麻袋等。
- 5.可用於固定或懸吊式而無損於其手提縫紉之特性。

FEATURES

1. Single-thread chain stitching
2. Easy operation :
when the operator holds with one hand the opening of the bag to be sewn and carries the bag closer with another hand, then presses the power button and starts sewing.
When the sewing is finished , the thread will be automatically cut off .
3. Since all component parts have been carefully designed and produced, quality is very stable and reliable .
Due to this reason, the user(s) can be kept away from the trouble of repairs .
4. It can be applied to sew multi-layer PP/PE bags, and/or cotton, linen bags.
5. It can be mounted to a certain fixture for operating , or be hung together with a suspending spring from the ceiling for saving labor.

維修

除皮帶(A909)與馬達外(A900)需經常清潔及加油潤滑以維護機器的高品質車縫，但車縫澱粉類不宜加太多油。

MAINTENANCE

Check the motor belt (A909) and motor (A900) periodically.
Keep the machine clean after using and remember to oil the machine, so that it can provide you with a quality sewing. If the bag is carrying corn powder, or similar stuff, the lubricating oil can not be added too much to the machine .

馬達須知

不可將馬達控制鈕長時間按住不放，沒有車縫時，應立刻放開馬達控制鈕。

NOTICE

The operator is requested to stop pressing the power button(A806) when the sewing on one bag is finished. Otherwise the life of motor will decrease and / or possibly burn out.

穿線

為確保線已正確穿入於線架，請按圖1所示穿線。

For a correct threading, see FIG .1 and do accordingly .

THREADING

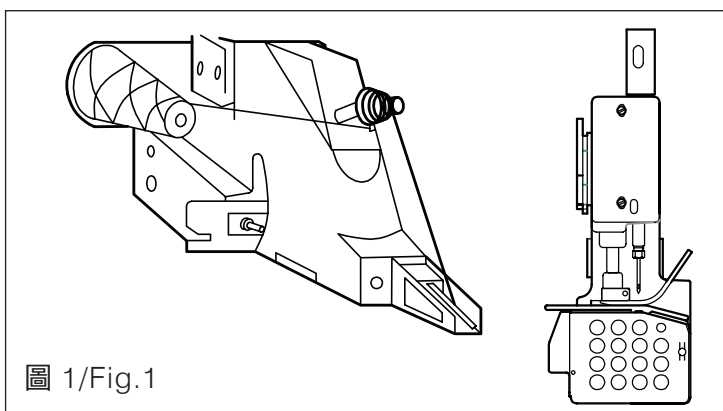


圖 1/FIG.1

針之安裝

拉動皮帶(A909)，讓針棒(A500)最高點至最上端，鬆開螺母(A501)，拿下舊針，再將新的針插入針棒孔頂點，鎖緊螺母(A501)，切記針之長溝要朝機器左邊，如圖2、3。

INSTALLATION OF NEEDLE

Pull the motor belt (A909), to make sure the needle bar (A500) lifts to its highest position. Loosen the screw (A501) of the needle holder, take off the old needle from the needle holder, and then insert the new needle to the hole of the needle holder. Fasten the screw. During installing, remember to keep the needle's long groove facing the left side of the machine. Please see Fig. 2&3.

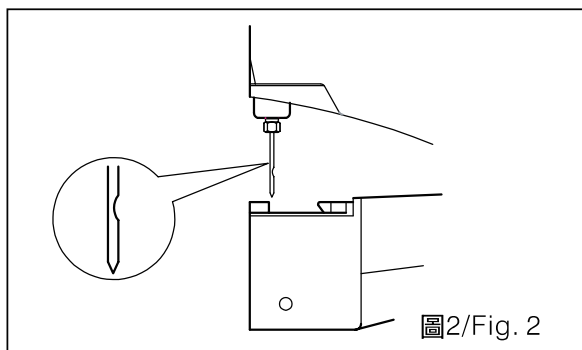


圖2/FIG. 2

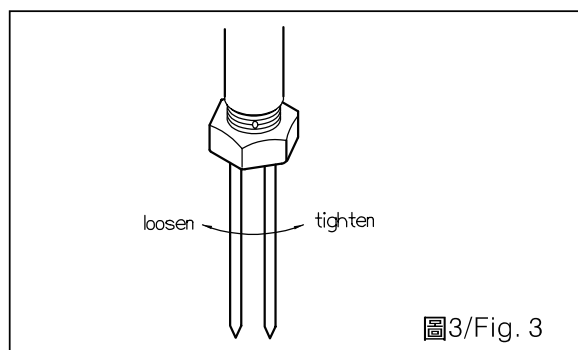


圖3/FIG. 3

針棒之調整

- 1.卸去針棒護板A101R，轉動皮帶(A909)，使勾針移至如圖4所示。
- 2.稍微鬆開針棒之螺絲(SA26)。
- 3.調整針的高度，如圖5所示，針與勾針(A300)會合時，勾針之尖端不超過針邊緣0.4mm，而且此時勾針之尖端下緣剛好跨過針之線孔上緣。
鎖緊針棒支件之螺絲(SA26)，再裝上針棒護板(A101R)，重新校對針與勾針(A300)兩者之間隙如圖6。

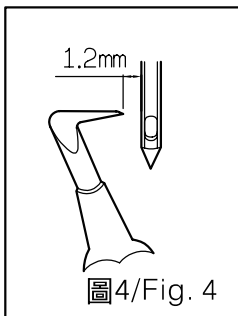


圖4/Fig. 4

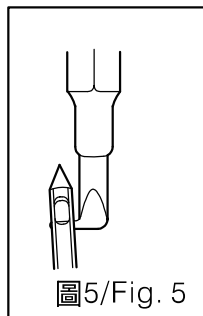


圖5/Fig. 5

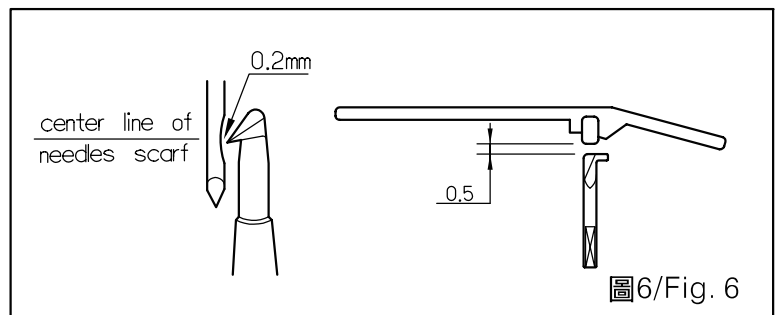


圖6/Fig. 6

ADJUSTMENT OF NEEDLE BAR

1. Release the needle bar cover (A101R), pull the motor belt (A909) to let the looper move as per the instruction of Fig. 4.
2. Slightly loosen the needle bar screw (SA26).
3. Adjusting the height of needle, please see Fig. 5. When the needle and looper (A300) meet together, the distance between the tip of looper and the needle can not exceed over 0.4mm. At the same time, the bottom edge of the looper's tip just passes over the needle hole.
Fasten the needle bar screw (SA26), put the needle bar protective cover (A101R) back, and then readjust the clearance between the needle and looper according to Fig. 6.

針距

正常之針距為7.2mm，而送料具(A203)高度約為2.7mm，假如針距不過長，則檢查如下：

- 1.送料具齒尖可能磨損，必須換新。
- 2.送料具可能陷下，以致送料具凸出針板之高度不及2.7mm，則調整送料具座之螺絲(SA22)即可。

STITCH LENGTH

The normal stitch length is 7.2mm, and the tips of the feed dog (A203) should be set higher than the needle plate(A210) by 2.7mm. If the stitch length is too long, check and do as follows :

1. The tips of feed dog may be worn out, then feed dog must be replaced.
2. The feed dog may possibly sink, and the height of the tips of feed dog over the needle plate is less than 2.7mm consequently. Loosen the feed dog holder screw (SA22) and adjust the feed dog.

勾針之安裝

- 1.轉動皮帶(A909)使送料具在最高點。
- 2.鬆掉勾針座螺絲(SA19)，取下勾針座(A301R)。
- 3.鬆掉勾針螺絲(SA03)，取下勾針(A300)。
- 4.換新勾針，插入勾針座內。
- 5.把勾針座裝入勾針座軸上(A303R)，調整勾針座如圖6，並鎖緊螺絲(SA03)。
- 6.調整勾針座(A301R)如圖4，並鎖緊螺絲(SA19)。

INSTALLING AND/ OR REPLACING THE LOOPER

- 1.Turn the motor belt (A909) to make sure the feed dog is at its highest position.
- 2.Loosen the looper holder screw (SA19) and take off the looper holder (A301R).
- 3.Loosen the screw (SA03) of looper, and take off the looper(A300).
- 4.Replace the old looper, and put the new looper to the holder.
- 5.Put the holder back to the holder bed (A303R) and adjust the height and timing of looper as per Fig. 6 and fasten the screw (SA03).
- 6.Adjust the position of looper holder (A301R) as per Fig. 4 and fasten the screw (SA19).

勾針之調整

1. 若只是更換勾針，不需要調整，但換過勾針軸(A303R) 或塑膠凸輪 (A310R) 就必須做調整。
2. 若換過勾針軸 (A303R)，需要調整勾針時，先轉動皮帶 (A909)，使勾針至回程之極點，勾針針端和針邊緣調整至距離約 1.2mm，如圖 4。
3. 若換過塑膠凸輪 (A310R)，要先調整凸輪位置。從凸輪較大端方向看，順時針第一顆螺絲與大心(A600R) 時位點對齊後微調固鎖，再如上敘述調整勾針。

ADJUSTING THE LOOPER

- 1.No need to do adjustment if it comes to change the looper only. However the adjustment is required when looper shaft(A303R) or plastic cam(A310R) are changed.
- 2.To adjust looper (after changing looper shaft A303R), turn the belt(A909) first to move looper back to the end. The distance between looper end and needle edge should be 1.2mm (please see graph 4)
- 3.To adjust cam position(after changing plastic cam A310R). Choose the larger end of the cam , aligning first screw(clockwise) and main shaft(A600R), lock slightly. Adjust looper as per above instruction.

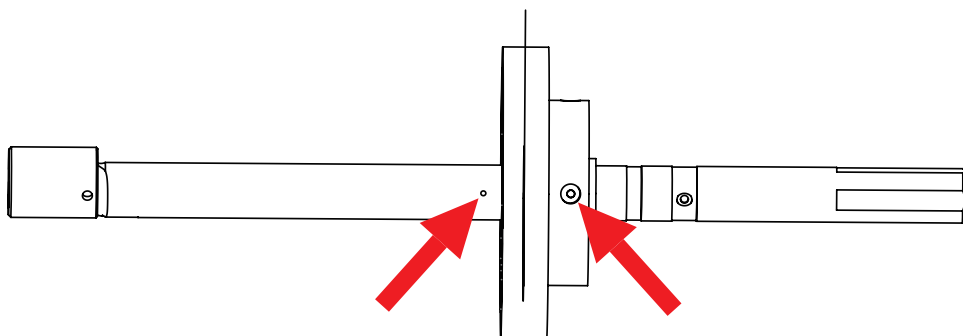


圖 7/Fig.7

故障排除

斷線

- 1.縫合壠青紙袋或防水紙袋，請先將線上油，以增潤滑防斷線。
- 2.若勾針損壞或調不正確，勾針針頭必須磨光或換新再重新調整。
- 3.不正確穿線或張力，如圖檢查穿線。

跳針

- 1.縫合壠青紙袋或防水紙袋，請先將線上油以增潤滑。
- 2.勾針位置配合不正確，檢查勾針位置如圖5、6。
- 3.針的位置放置不正確，檢查針位置如圖2。
- 4.過線彈簧可能受損，必須換新。

斷針

- 1.針安裝不正確，檢查針的長溝是否在機器的左邊，如圖。
- 2.勾針安裝是否不正確，如圖4調整。

不會打結

- 1.針板彎曲不平，弄平或換新。
- 2.押具可能磨損不平，換新。

針距不一

- 1.押具壓壓力不當，調整適當之壓力。
- 2.送料具磨損，換新。

TROUBLE SHOOTING

THREAD-BREAKING

- 1.Before sewing the pitch-coated bags or water-proof paper bags oil the thread first to increase the lubrication, so that thread breaking can be avoided.
- 2.If the looper is damaged or incorrectly adjusted, looper's tip needs to be polished or replaced, and then adjust once again.
- 3.The thread breaking may be caused by incorrect threading or wrong thread tension. Check the threading as per Fig. 1.

STITCH-SKIPPING

- 1.When sewing the pitch-coated bags or water-proof paper bags, the stitch-skipping easily happens. We suggest oiling the thread before sewing.
- 2.The position of looper may be wrong. Check the looper as per Fig. 5&6.
- 3.The position of needle is wrong, Check the needle as per Fig. 2.
- 4.Threading tension spring may be damaged. Replace the damaged one.

NEEDLE-BREAKING

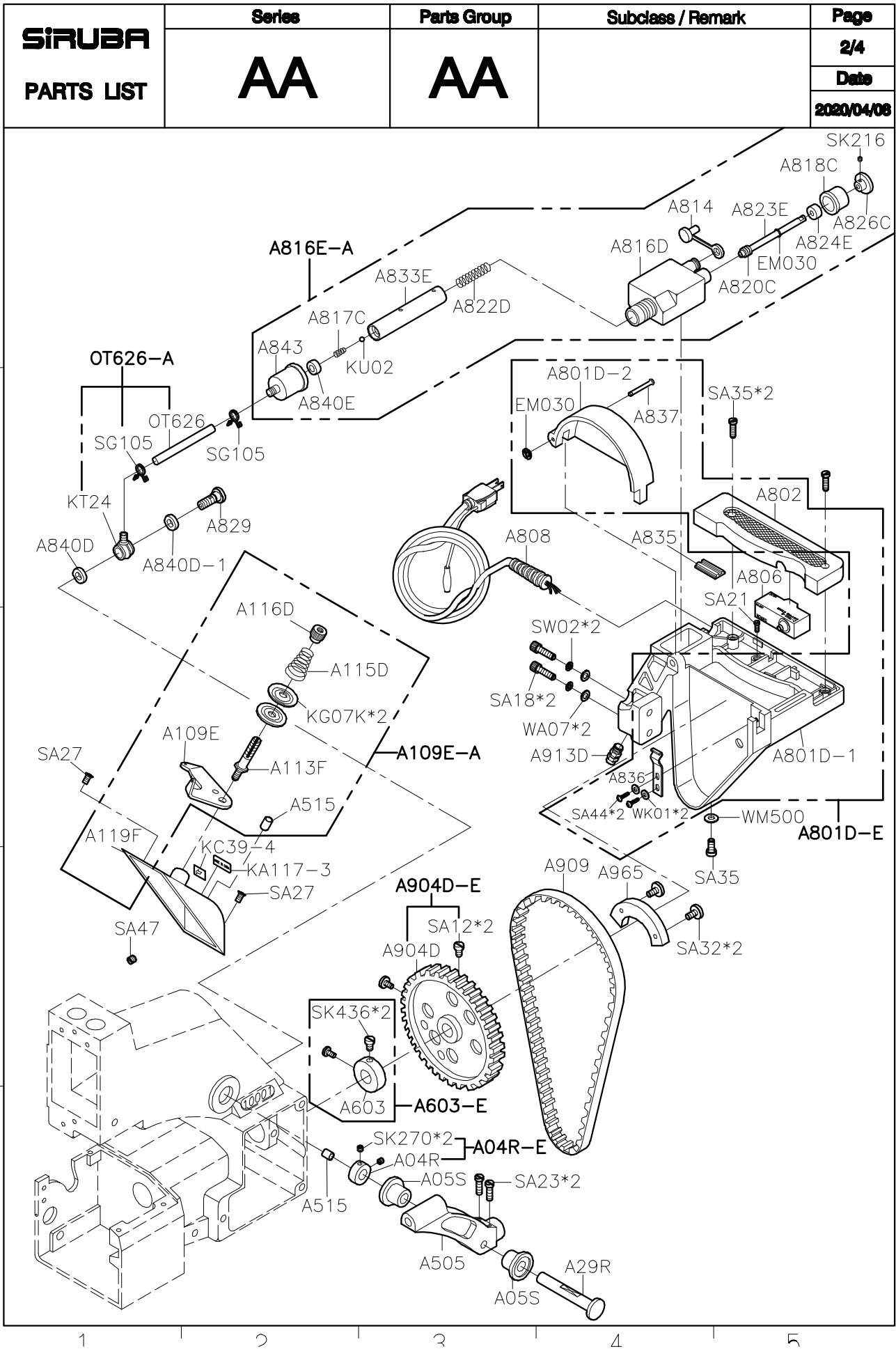
- 1.Incorrect needle installation. Check if the needle's long groove is facing the left side of the machine.
- 2.Incorrect needle installation. Check and adjust as per Fig. 4.

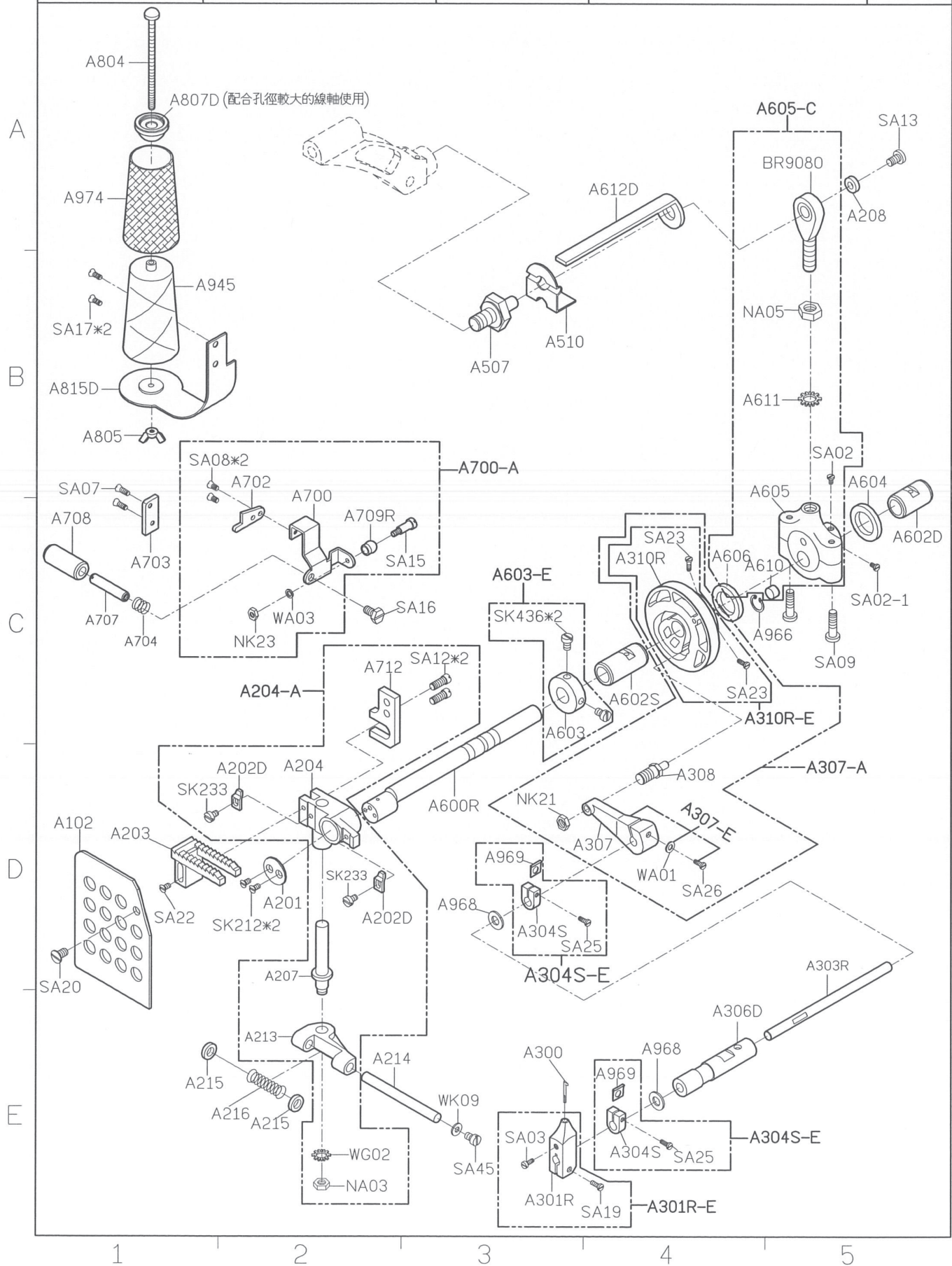
FAILURE IN SEWING

- 1.The needle plate may be deformed. Replace it.
- 2.The presser foot may be damaged. Replace it.

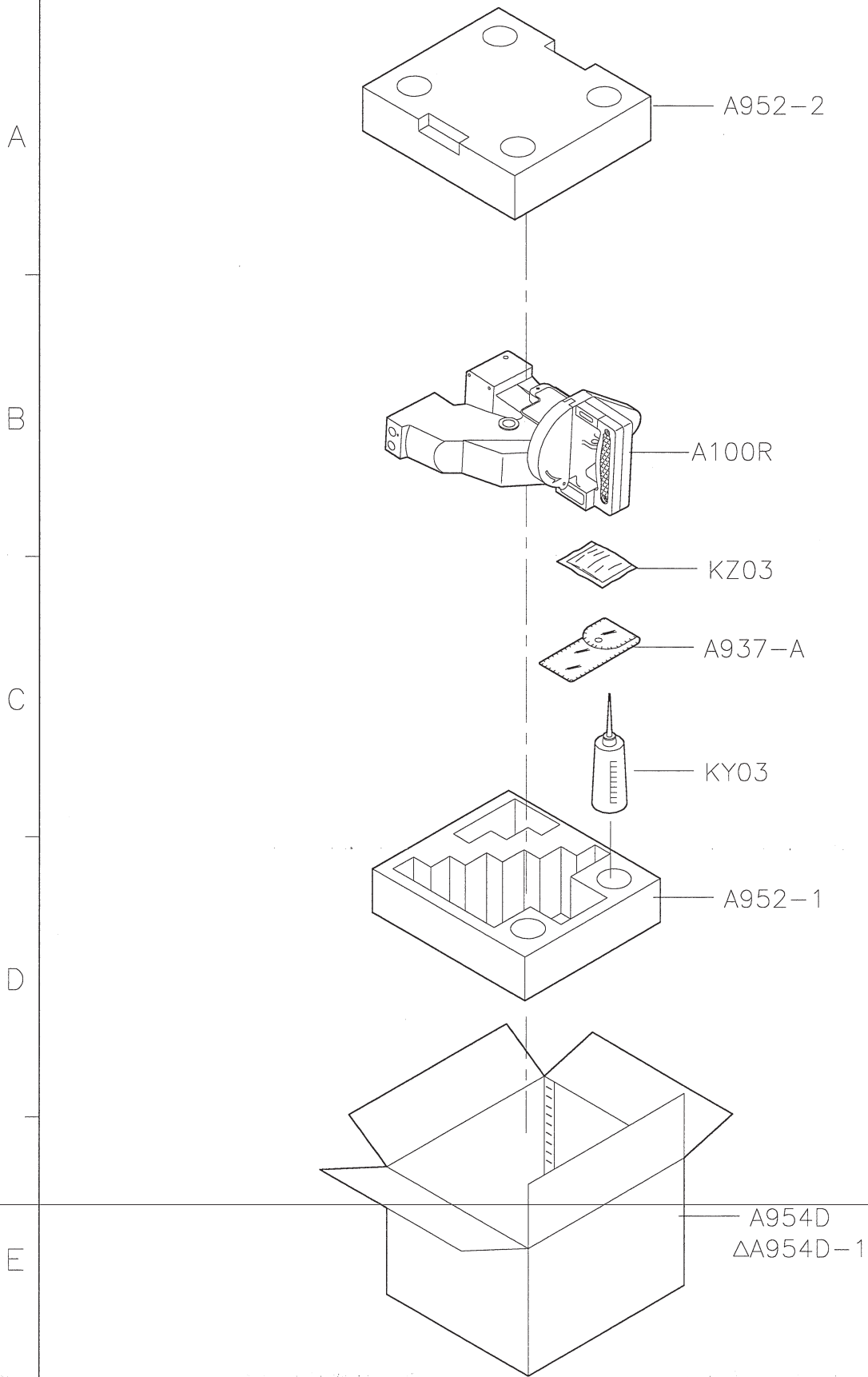
STITCHING BEING UNEVEN

- 1.The pressure of the presser foot may be improper. Adjust the pressure.
- 2.The feed dog is damaged. Replace it.





SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	AA	AA	△: For Domestic Sales 内銷	4/4
				Date
				2018/08/30

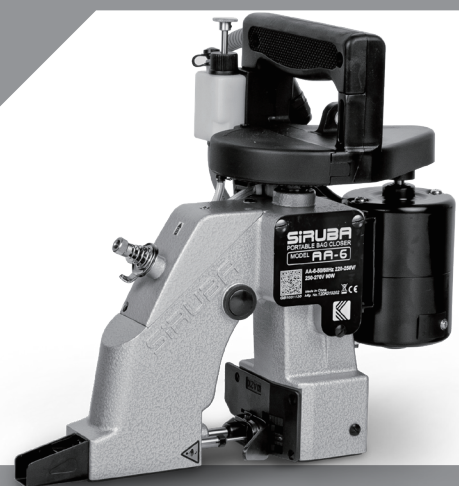


報廢流程

DEMOLITION PROCEDURE

1. 當機器需要被淘汰與報廢時，有一些基本規則必須採納、遵守以保護環境及公眾健康。
2. 所有的機器零組件必須依照下列分類來區分開：
 - (1) 所有護套、可伸縮軟管及塑膠或非金屬零件。
 - (2) 電器零件：開關、照明器具等。
 - (3) 絕緣材料：石棉、彈性/可伸縮橡膠片。
 - (4) 金屬：含鐵金屬、銅、青銅與黃銅、其他各種金屬。
3. 以此方法，所有材質可以正確的淘汰，回收再利用或鎔解為可再使用或再處理而不至於危害環境。

1. When the machine needs to be eliminated and demolished, certain basic rules must be observed to protect the environment and public health.
2. ALL machine components must be divided according to categories as the followings:
 - (1) All sheathes, flexible hosing and plastic or non-metal components.
 - (2) Electricity components: switches, or lighting components.
 - (3) Insulation materials: rock wool, and Flexible rubber strips.
 - (4) Metals: ferrous metals, copper, bronze and brass, various.
3. In this way, all materials can be eliminated correctly, recycled, or melted down for reuse or disposed of so that they do not harm the environment.



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由於對產品的改良及更新，本產品使用說明書中與零件圖之產品及外觀的修改恕不事先通知！
The specification and/or appearances of the equipment described in this instruction book & parts list are subject to change because of modification which will without previous notice.
A941D-1.MAY.2022