

# SIRUBA

ORIGINAL

使用說明書與零件圖

INSTRUCTIONS BOOK & PARTS LIST

■ASK-ASM101



## 溫馨提醒 A WARM REMINDER

請儘快下載 SIRUBA APP，並將您的機器註冊，以便獲得原廠的保固。APP 還提供多項有用的資訊。

please register your Siruba machine online or through Siruba App at once, as to gain the full warranty protection. You may also acquire more useful information through Siruba APP.





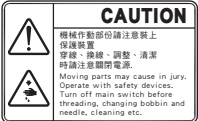
## 安全警示 GENERAL SAFETY INSTRUCTION

有關於縫紉機，自動化機構，以及其他輔助設備（以下統稱為機器），在工作中無可避免會接近機器移動區域，也就有伴隨著潛在風險。因此，我們強烈要求操作者，維修技師一定要先仔細閱讀並瞭解本操作手冊的內容。安全指示係包含了某些未載於規格書上的加裝配件。現場管理者有責任要求所有操作者要閱讀並瞭解機器的操作與注意事項。未能確實遵守本手冊所記載的事項，將可能導致機器的損害，或是人員的傷亡。

For the sewing machine, automatic mechanic system, and auxiliary devices (hereinafter referred as “machine”), it is inevitable to conduct work near moving parts of the machine. This means that there is always a potential risk from the moving parts. Operators actually operating the machine and service technicians performing maintenance and repair are strongly advised to read and understand fully the following instructions in advance. The safety instructions include items which are not listed in the specifications of your product. It is the manager/supervisor’s responsibility to have their fellow workers fully understand before operation. Fail to follow the instructions may cause damage to properties, severe injury or even death.

### 警告標示說明

Explanation of warning indications and labels.

	<p>高壓電危險 在機器關機後十分鐘內，勿開啟電控箱。</p> <p>HIGH VOLTAGE DANGER Do not open the power cabinet within 10 minutes after the power off.</p>		<p>零部件移動區 勿接近，以避免人員受傷。</p>
	<p>零部件高速移動區 勿接近，以避免人員受傷。</p> <p>High speed moving area! Stay away and keep clear to avoid injury.</p>		<p>Machine moving area! Stay away and keep clear to avoid injury.</p>

標告標示說明 WARNING LABELS	標告標示說明 WARNING LABELS
 <p>機器零部件移動區，勿接近，以避免人員損傷。 A risk of cut and injury from moving parts. Stay away and keep clear.</p>	 <p>請注意，在操作過程中握住縫紉機會傷到您的手。 Be aware that holding the sewing machine during operation can hurt your hands.</p>
 <p>有電，危險。 A risk of electric shock. Stay away and keep clear.</p>	 <p>小心被機械捲件受傷！ There is a risk of entanglement in the belt resulting in injury.</p>
 <p>高溫度區！危險，勿靠近。 A risk of burn from the high temperature area. Stay away and keep clear.</p>	 <p>如果觸摸按鈕托架，可能會造成人身傷害。 There is a risk of injury if you touch the button carrier.</p>
 <p>強光！勿直視，以避免眼睛受傷。 Avoid direct eye contact with the laser beam or other light source.</p>	<p>一般安全標示 GENERAL SAFETY INDICATIONS</p>  <p>機器運行方向 The correct direction is indicated.</p>
 <p>小心頭部撞擊！ A risk of injury to head from upper contact. Apply proper protection (helmet) and keep clear.</p>	 <p>電氣接地位置標示 Grounding connection as indicated.</p>

## 安全須知

### 危險

意外事件將會導致人員受傷甚至死亡，也會造成財產的損害。  
當有必要進行電控系統的檢修時，務必要關閉電源，並等候至少5分鐘以上才能打開電控箱／操作箱，以避免電擊。

### 注意

#### 1. 基本預防

- (1) 在操作前務必先閱讀操作手冊與其他機器電件的說明書，請妥善保存操作手冊與說明書以便隨時查閱。
- (2) 這些注意措施包含了機器上加裝，但未列在規格書上的項目。
- (3) 務必要戴護目鏡與手套，以避免破損零件所帶來的傷害。
- (4) 有裝戴心臟調節器的人員，請先詢問醫護人員有關注意事項。

#### 2. 安全裝置與警告標示

- (1) 操作前要檢查，並確認所有的安全設施有妥善安裝且運作正常。
- (2) 若安全設施因維修需要移動，在機器重新啟動操作前，請確認安全設施有重新安裝回原位，並且運作正常。
- (3) 機器上的安全警告標示要保持完整與可辨視。如果有污損或遺失，請儘以更新。
- (4) 未能確實遵守安全規範，將會導致人員受傷，甚至影響生命安全。

#### 3. 應用與修改

- (1) 嚴格禁止機器使用在非原始設計用途。也禁止以任何不是操作手冊上記載的方式來操作機器。
- (2) 嚴格禁止修改機器。任何未經原廠許可的變動將不在保固範圍內。
- (3) 機台一經修改變動，本公司將不擔負財務損失，人員傷亡的責任。

#### 4. 教育與訓練

- (1) 工廠主管人員有義務提供機台使用人（操作者／維修者）相關的教育訓練。良好的教育訓練不僅可以避免造成人員傷害，也可以避免財產的損失。
- (2) 操作人員操作機器之前，都必需接受過良好的訓練。
- (3) 機器的維修保養必須由合格的技師執行。

#### 5. 必須關閉電源的情況：

如何關閉電源：按壓下緊急停止開關（如果機器有配置的話），關閉電源，拔除電源線。

- (1) 當機器出現異常時，按下緊急停止開關（如果有配置），關閉電源。
- (2) 為了避免機器突然啟動造成意外，在操作機器前，要先確定機器電源關閉，再行開啟電源。
- (3) 當檢查或清潔機器時，關閉電源，並確定機器已完全停止運作。
- (4) 當維修機器時（如更換或調整零件），要關閉電源，並確定機器已完全停止運作。

#### 6. 拔除電源線時，務必要抓住電源插頭，而非抓住電源線，以避免斷裂，電擊，甚至火災。

#### 7. 當機器停止運作，且無人看管時，要關閉電源。

#### 8. 萬一停電或電力供應出現不穩，關閉電源，以避免意外發生。

## SAFETY PRECAUTIONS

### Danger

An accident means "to cause personal injury or death, or damage to property."

When it is necessary to perform service on electrical parts, be sure to turn the power off and wait for 5 minutes or more before opening the power cabinet/box in order to avoid electrical shock.

### Caution

#### 1. Basic precaution

- (1) Read the manual and other papers supplied with accessories of the machine before operation. Keep the manual and papers at hand for quick reference.
- (2) The content of this section includes items which are not listed in the specification of your product.
- (3) Always wear safety goggles and gloves to avoid accident caused by parts breakage.
- (4) For those who use a heart pacemaker, please consult the medical specialist first.

#### 2. Safety devices and warning labels

- (1) Check to ensure all safety devices are correctly installed in place and properly before operation.
- (2) If any of the safety devices is removed for service cause, please be sure to replace it back to position and verify that it works normally before resuming operation.
- (3) Always keep the warning labels adhered on the machine clearly visible. If any of the labels missing or contaminated, replace with a new one at soon.
- (4) Fail to obey instructions above may cause severe injury or death to the operators.

#### 3. Application and modification

- (1) It is prohibited to use the machine for any application other than its original intention, or in any manner other than that prescribed in the instruction manual.
- (2) Never modify or alter the machine. Any unauthorized change of the specification will not be covered by the warranty.
- (3) Our company assumes no responsibility/liability to damages, injuries, or death resulting from the machine which has been modified or altered.

#### 4. Education and training

- (1) The plant managers/supervisors are obliged to provide education and training to operators and service technicians. A good education/training plan not only avoids personal injury but also prevent damage to the property.
- (2) Only a well-trained operator is allowed to operate the machine.
- (3) Only a certified technician is allowed to perform service to the machine.

#### 5. Situations that you must turn off the power

Turning off the power: press EMG Stop (if there is one), switch off the power, and remove the power plug from the outlet.

- (1) When there is a failure or abnormality, press EMG Stop (if there is one), switch off the power.
- (2) To prevent accident resulting from abrupt start of the machine, before operating the machine, always turn off the power and switch on again.
- (3) When cleaning or inspecting the machine, make sure the machine stops completely after turning off the power.
- (4) When performing service (i.e. changing or adjusting any component), make sure the power is off and the machine stops completely.

#### 6. Remove the power plug by holding the plug section instead of the cord to avoid electrical shock, leakage, or fire accident.

#### 7. Turn off the power whenever the machine is left unattended between works.

#### 8. In case of a power failure or black out, turn off the power to avoid damage or accident.

## 在不同階段的注意事項

## PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

### 1. 運輸

- (1) 當搬運或移動機器時，請考量機器重量，選擇安全合適的方式。請參考機器規格。
- (2) 採取足夠的安全防護，以避免機台在搬運或移動中掉落。
- (3) 為避免意外，運送時不要重覆使用包裝材料。

### 2. 拆箱

- (1) 在拆箱前，檢查機器是否平穩放置，並採用適當的工具維持拆箱過程的穩定。
- (2) 進行拆箱時，遵循外箱上的指示，小心外箱上的釘子或碎片。

### 3. 安裝：

#### 3A. 桌板與腳架

- (1) 採用原廠的桌板以確保機器得到足夠的保護與支撐。如果在安裝或維修時，需要暫時將機器置放於物件上，請確定該物件有足夠的支撐力。
- (2) 如果桌板有裝置滾輪，滾輪需要有煞車鎖定機構，而且在操作與維修時，煞車機構必需鎖定。

#### 3B. 電線與管路

- (1) 電線與管路的材質必需符合規範與需求。
- (2) 電線與管路不能夠有折彎或壓迫。移動的零配件上，電線與管路需有至少 30mm 以上的預留量。
- (3) 接線時不能有跳火。
- (4) 所有接頭都必需確實固定。當拆除時，務必要抓住接頭本體。

#### 3C. 接地

- (1) 接地是必需的。且需由合格的技師來施工。
- (2) 在操作前需確認接地有確實。

#### 3D. 馬達

- (1) 馬達的選用，必需符合規範與需求。
- (2) 如果馬達為皮帶傳動，務必要安裝保護措施以避免捲入危險。

### 4. 在開始操作前

- (1) 在開啟電源前，確認所有接頭，電線，管路都完好無損，確實連結。
- (2) 檢查皮帶輪的轉向與標示為同一方向。
- (3) 確認腳架滾輪都已鎖定。
- (4) 保持作業範圍淨空。

### 5. 在操作中

### 1. Transportation

- (1) When lift or move the machine, please take the machine weight into consideration and apply a safe manner. Refer to the specification for the information you need for transportation.
- (2) Apply sufficient safety measures when lifting or moving the machine to avoid falling or dropping.
- (3) To avoid unexpected accident, do not reuse the packing material for transportation.

### 2. Unpacking

- (1) Before proceeding to unpacking, check the balance of the machine and apply necessary tools to hold the proper position.
- (2) When unpacking, follow the instruction printed on the cartoon. Be careful of the nails and chips when unpacking from a wooden rack.

### 3. Installation:

#### 3A. Table and Stand

- (1) Only adopt a qualified genuine table and stand to assure the holding support. In case you need to leave the machine on a surface temporarily for service, make sure the surface is strong enough to hold the weight.
- (2) If casters are applied to the table stand, adopt casters with a locking mechanism only and lock them well to secure the machine during the operation and service.

#### 3B. Cable and Wire

- (1) The cables and wires must comply with the specification and requirement.
- (2) The cables and wires shall be free from bending or extra force. Reserve a free space of at least 30mm between cables/wires and the moving parts.
- (3) Do not apply starburst connection when wiring.
- (4) All connectors must be fixed securely. And always hold the connector body when removing it.

#### 3C. Grounding

- (1) Grounding is necessary and must be done by a certified technician. (2) Check and ensure the grounding is secured before operation.

#### 3D. Motor

- (1) The motor must comply with the specification and requirement.
- (2) If there is a belt in the motor transmission, adopt or apply a proper protector to avoid entangling.

### 4. Before Operation

- (1) Before turning on the power, make sure all the connectors, cables, and wires are free from damage, dropout, or looseness.
- (2) Check and make sure the pulley rotation follows the same direction as labels.
- (3) Make sure all the stand casters are locked or fixed in position.
- (4) Keep the working area clean from obstacles.

### 5. During Operation

- (1) Always keep your fingers, hair, or clothing away from the moving components and moving area. Do not place your personal belongings on the machine.

- (1) 注意手，頭髮，衣服不在機件移動範圍。不要將個人物品置放於機器上。
- (2) 機器會高速運作。保持雙手遠離移動機件範圍。機器完全停止前不要靠近。
- (3) 在移動物件或重新設定機器時，注意不要被機器或零件撞擊。
- (4) 避免突然起動造成意外，在檢查或維修馬達或皮帶時，務必關閉電源並確認機器完全停止。
- (5) 機器停止時，伺服馬達是無聲的。注意要關閉電源以免突然起動。
- (6) 永遠保持電控箱的風扇與氣道淨空。

## 6. 潤滑

- (1) 請依照說明書指示，選用合格的油脂來潤滑機件。
- (2) 如果油品接觸到眼睛或身體，立即以清水沖洗。如有不適，立即尋求醫護人員協助。
- (3) 如果油品不慎進入身體，立即尋求最近的醫療協助。

## 7. 維修保養

- (1) 只有合格的技師或工程師能夠進行維修服務，包含機器調整與修理。只採用原廠的零件進行更換。如果採用非原廠零件，或是因不當維修／調整所造成的傷害，本公司將不負任何責任。
- (2) 只有合格的技師或認證的工程師才能對電控系統進行維修或保養。
- (3) 當對氣動原件（如氣缸）進行維修保養時，務必先拔除風源，並將氣體完全洩除，以避免突然啟動。
- (4) 在調整或更換部件後，檢查所有螺絲是否鎖固。
- (5) 定期清潔是必需的。在清潔前務必先關閉電源，並確認機台完全停止。
- (6) 如果運作異常或不良，立即停止操作並關閉電源。聯絡授權經銷商或我們公司以尋求技術協助。
- (7) 當保險絲故障，立即關閉電源，找出故障原因並予以排除後，更換同規格的新的保險絲。
- (8) 定期檢查與清潔風道，電線與管路。

## 8. 工作環境

- (1) 機器必需不用電磁波干擾。
- (2) 電源供應必需良好且穩定。電壓波動不得超過 10%。
- (3) 隨時檢查空壓的壓力與品質。如果氣源不穩定，請安裝合適器材以改善。
- (4) 機器操作環境，室溫  $5^{\circ}\text{C} \sim 35^{\circ}\text{C}$ ，相對濕度 35%~85%。
- (5) 為了保護電子元件與安全起見，當有劇烈氣溫變化而導致凝水時，立即關閉並拔除電源，並靜候至完全乾燥為止。
- (6) 為了安全起見，當有打電或閃電時，請停止操作，關閉並拔除電源。
- (7) 勿在機器週遭使用電視或收音機，以避免干擾。
- (8) 依當地法令規範，在操作中採取必要的防護。
- (9) 關於包裝材料，潤滑油品，以及機器（含零配件）的丟棄，請依各地政府法規的規範執行。

- (2) The machine is designed to run at high speed. Always keep your hands away from the moving area. Do not resume the work cycle until the machine stops completely.
- (3) Be careful not to be caught by the machine or components when removing or resetting the machine.
- (4) To avoid accident caused by abrupt start, when performing service on the motor or belt, make sure the power is off and the machine stops completely.
- (5) A servo motor is silent as the machine stops. Be sure to turn off the power to avoid an abrupt start. (6) Always keep the fan and airway of the power cabinet clean from any obstacle.

## 6. Lubrication

- (1) Apply only qualified oil and grease onto the parts as instructed in the manual.
- (2) If the lubricant contacts your eye or body, wash it off immediately. Consult a medical care if necessary.
- (3) If the lubricant goes into your body accidentally, go to the nearby medical care immediately.

## 7. Service

- (1) Only a certified engineer/technician is allowed to perform service to the machine, including adjusting and repairing. Use only genuine parts for replacement. Our company assumes no responsibility/liability for any accident caused by improper repair or adjustment, or the use of any parts other than genuine one.
- (2) Only a certified technician or authorized engineer is allowed to repair or maintenance the electric system.
- (3) When performing service to air-driven parts, like an air cylinder, first disconnect the air supply and expel the air completely to avoid abrupt start.
- (4) Check all screws and nut are fixed well after adjusting and replacement.
- (5) A periodical cleaning is necessary. Make sure the power is off and the machine stops completely before cleaning.
- (6) If the machine functions poorly or abnormally, stop the operation and turn off the power. Contact the authorized dealers or us to request for a technical service support.
- (7) When there is a fuse failure, turn off the power, find out the cause of the failure and apply solution to it, then replace with a new one with the same spec.
- (8) Periodically check and clean the fan airway and the cable/wiring.

## 8. Working Environment

- (1) The machine should be free from the affection of electro-magnetic wave.
- (2) The power supply should be in good and reliable condition, the fluctuation of rated voltage should be less than 10%.
- (3) Always check the air pressure and quality. Some extra device might be needed if the supply is not reliable.
- (4) The machine is designed to be used with ambient temperature  $5^{\circ}\text{C} \sim 35^{\circ}\text{C}$ , relative humidity 35%~85%.
- (5) To protect the electronic components and for safety cause, when there is a frost resulting from a dramatic temperature rise, disconnect the power and wait until it dry completely.
- (6) For safety cause, when there is a thundering or lightening, stop the operation and disconnect the power supply.
- (7) Do not use TV or radio nearby the machine as to avoid interference.
- (8) Apply necessary protection during operation. Follow applicable regulations set by local administration.
- (9) For disposal of packages, lubricant, and product, please follow the applicable regulations set by local administration.



## ASM 安全注意事項

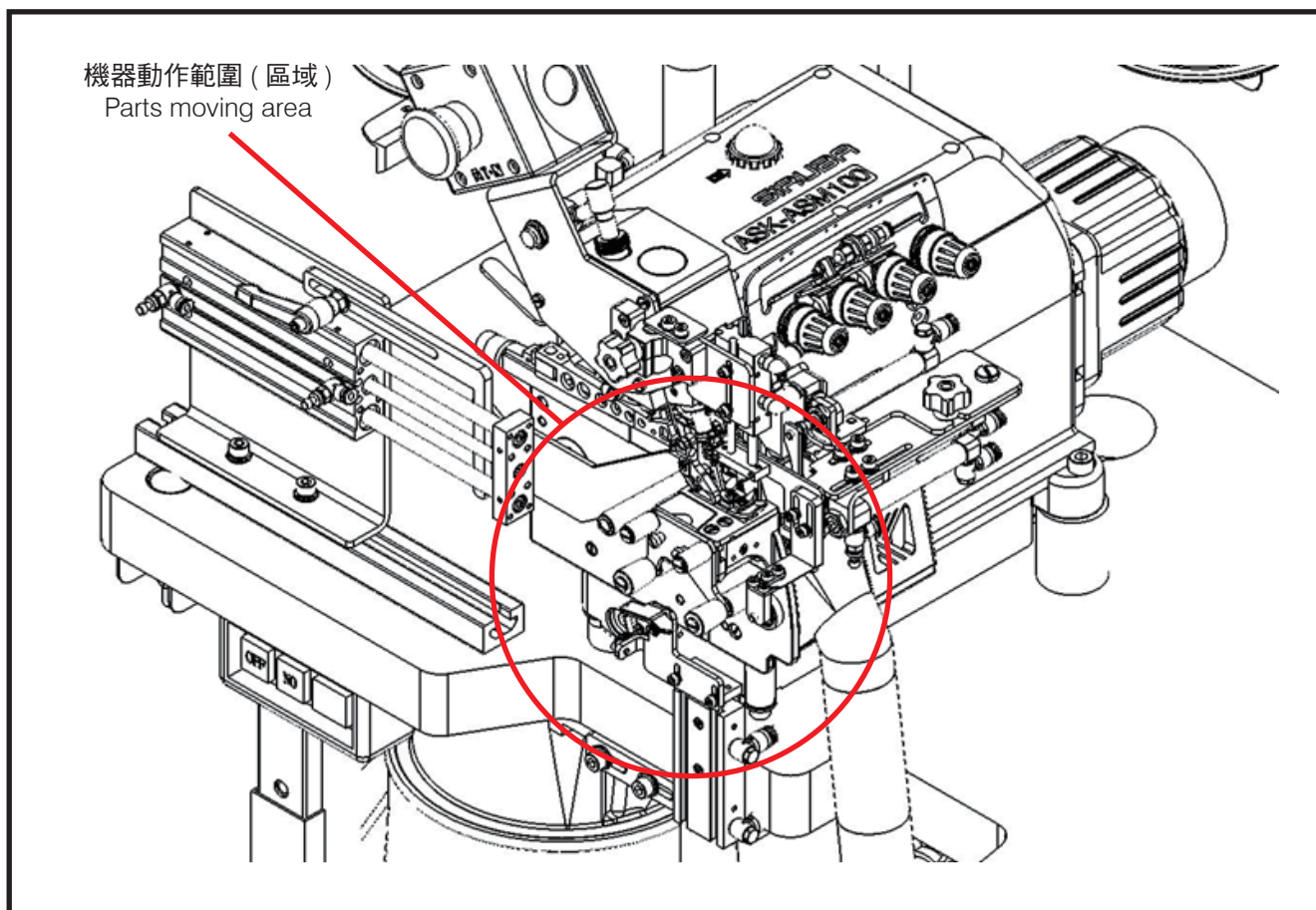
## SAFETY INSTRUCTION FOR AMS SERIES

### 機械移動區

永遠保持機械移動區域淨空，不受阻礙。

### Parts moving area

Always keep the moving area clean and free from any object.



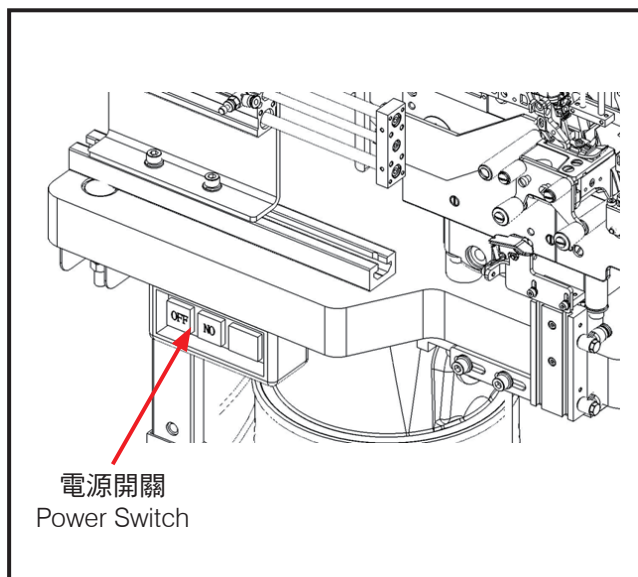
### 電源開關

1. 機器在運轉時，不可將手指等放入該區域內。
2. 為了保修、檢修卸掉罩蓋時，必須將電源切到 OFF。

### Power Switch

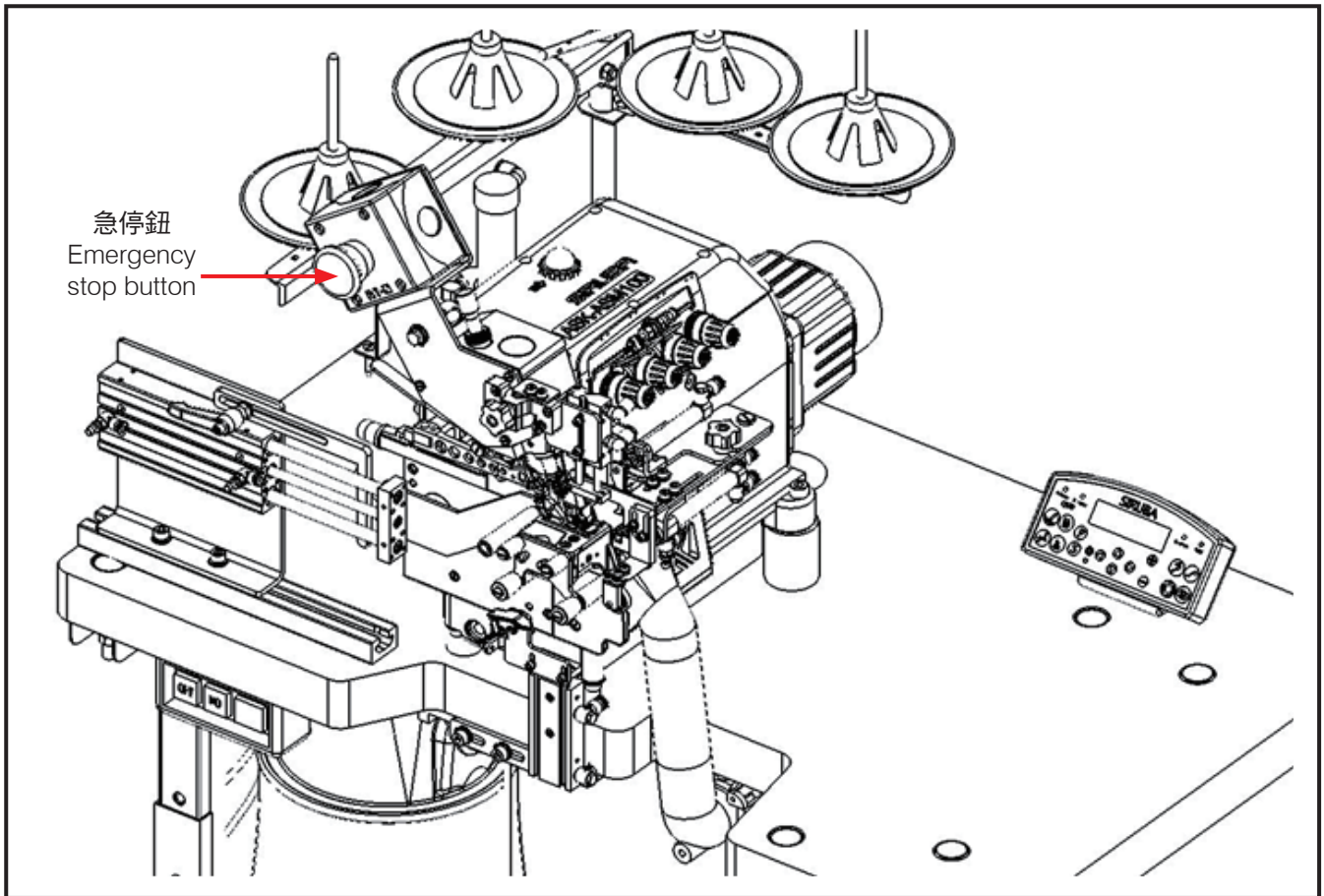
Always turn off the power when:

1. Performing service.
2. The machine is left unattended between works.



3. 在有危及人體的高壓電處，貼有觸電危險警告標記。  
。在貼有本警告的電器控制部位而需要保修、檢修時，打開罩蓋僅能由專業的電氣技術人員進行。
4. 機器運轉時，有必要馬上停止機器的時候，即刻按下急停鈕，按鈕閃爍即停止車縫動作。

3. In places with high voltages that endanger the human body, a warning mark of electric shock hazard is posted. When the electrical control parts with this warning need to be warranted or repaired, opening the cover can only be done by professional electrical technicians.
4. When the machine is running, when it is necessary to stop the machine immediately, press the emergency stop button immediately, and the button will flash to stop sewing.



5. 電源線、氣壓管線需確實固定安置，不可散落在地面，以免人員絆倒而發生危險。
6. 為了生命安全，在任何情況下，不可將電源地線拔掉運轉機器。
7. 打雷時，為了安全要停止作業，切斷電源。
8. 離開機器工作地點時或工作結束後一定要將電源開關轉到 OFF。
9. 機器運轉下，不可卸下罩蓋類。

5. The power cord and air pressure pipeline must be securely placed and not scattered on the ground to prevent people from tripping and causing danger.
6. For the sake of life safety, under any circumstances, do not unplug the power ground wire to operate the machine.
7. When thunder, stop the operation for safety and cut off the power supply.
8. Be sure to turn the power switch to OFF when leaving the machine's work place or after work.
9. Do not remove the cover when the machine is running.

## 索引 INDEX

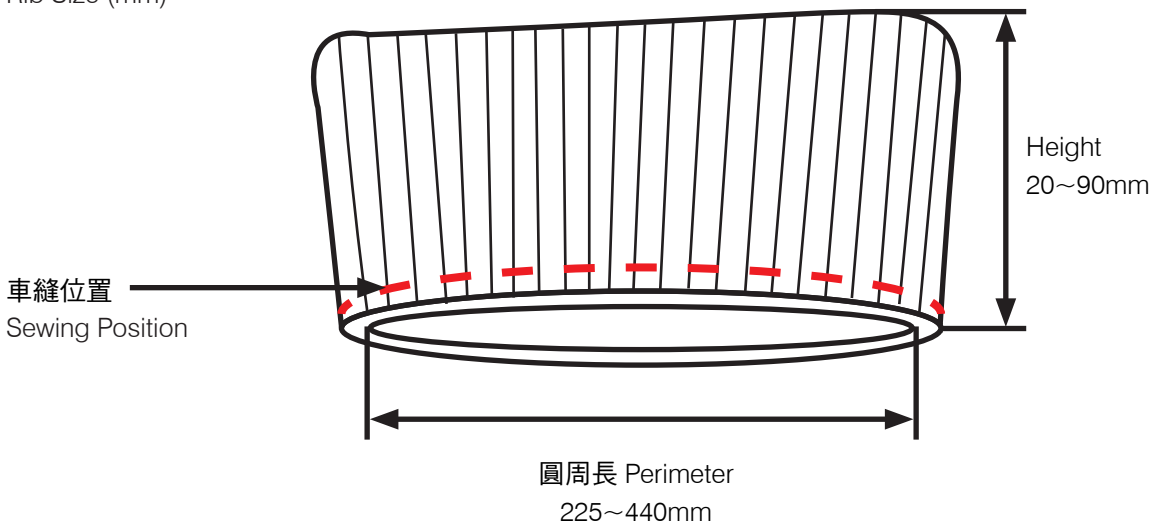
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## 規格

## SPECIFICATION

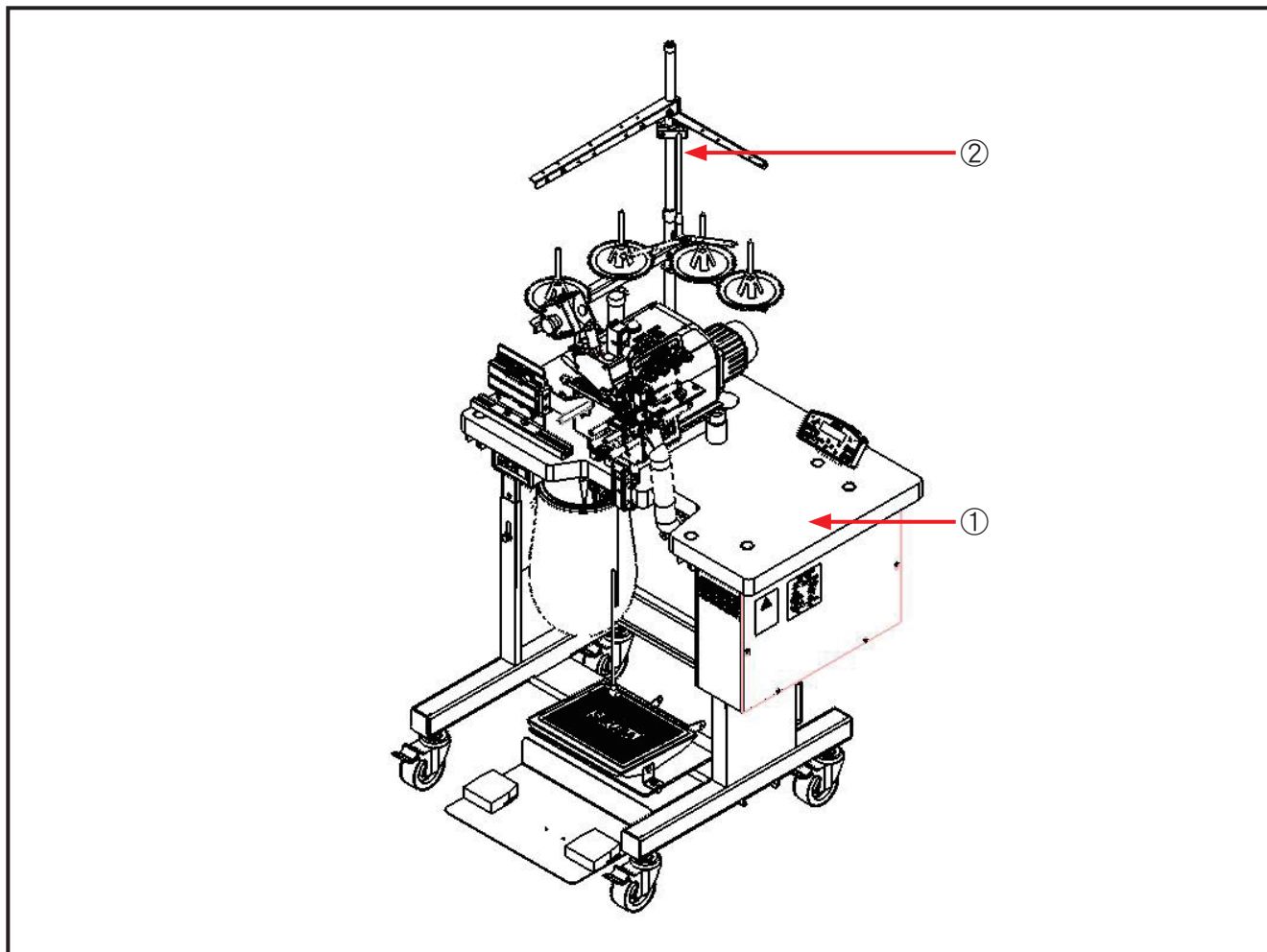
型號	Model	ASK-ASM101
搭配縫紉機機頭	Machine Head	SIRUBA 747KST-514H-4-2
車縫速度	Sewing Speed	5500 SPM ( Max )
使用針型	Needle Type	DC×27 #11
縫紉針距	Needle Distance	2mm
壓腳高度	Presser foot Height	7mm
線距	Thread Distance	3.8mm
包邊寬度	Overedge Width	4mm
<p>羅紋布尺寸 (mm) Rib Size (mm)</p>  <p>車縫位置 Sewing Position</p> <p>圓周長 Perimeter 225~440mm</p>		
布厚範圍	Fabric Thickness	7 mm ( Max )
氣體消耗量	Air Consumption	35 L/min
氣壓	Air Pressure	0.5 Mpa
電源電壓	Power Supply	Single Phase 1 Φ AC200~240V 50/60Hz
消費電力	Power Consumption	500 W ( Max )
機器尺寸	Machine Dimensions	(W)825×(D)640×(H)1622mm ( 含桌板、線架 With table and thread stand )

## 安裝

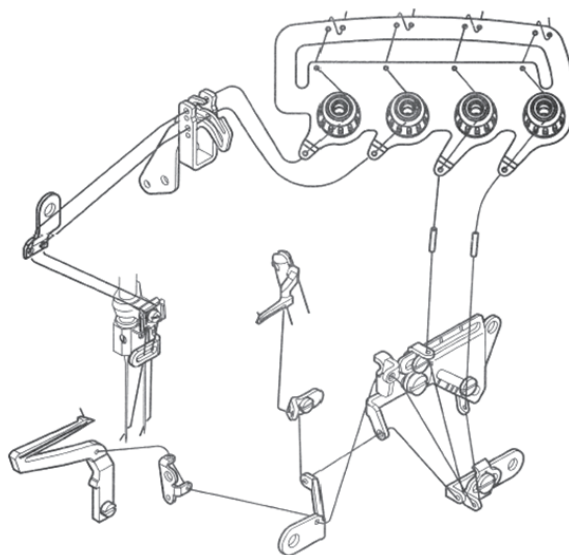
## INSTALLATION

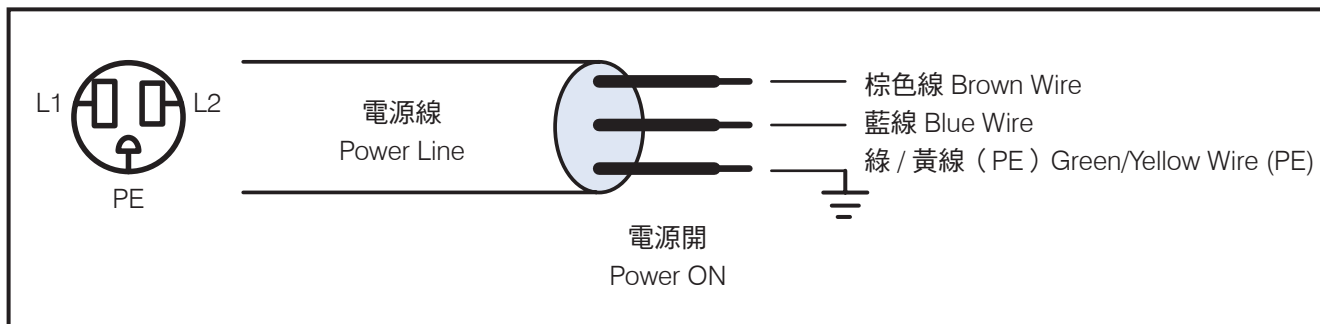
桌板①上，鎖附線架②。(線架組裝組請參照 747KST 使用說明書。)

Install the Thread Holder ② onto the Table ① .  
( Please refer to the operation manual of Siruba 747KST)



穿線圖  
THREADING



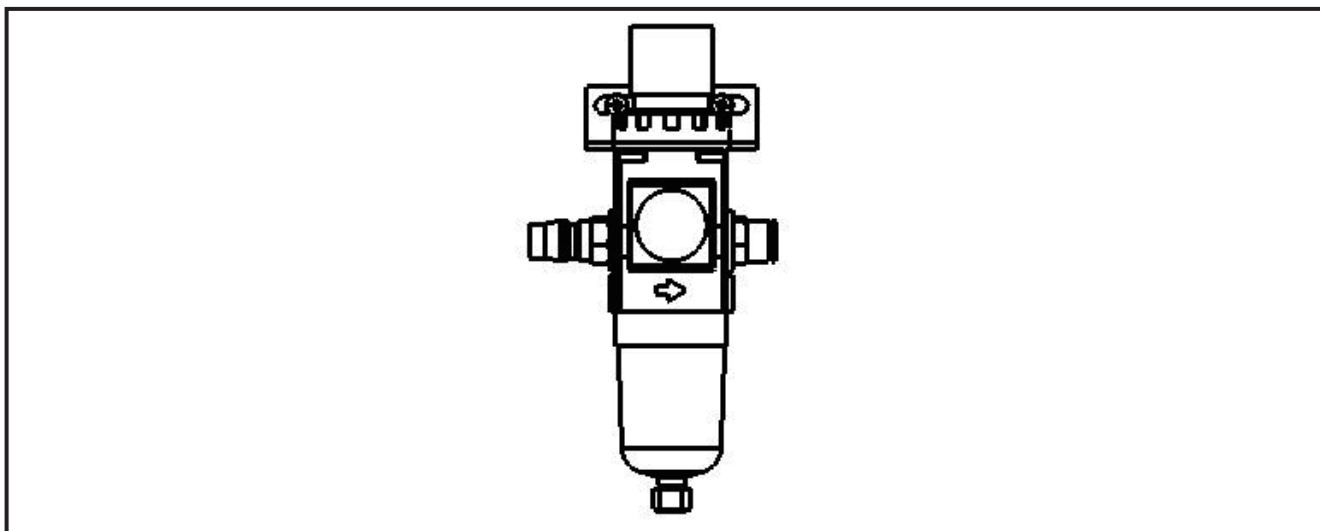


#### 電源連接

- (1) 檢查並設置電源和空氣供應。  
額定電壓：AC220V +/- 10%  
氣壓：0.5Mpa ( 5kg / cm<sup>2</sup> )
- (2) 檢查並確保接地線連接良好。
- (3) 檢查並確保電源開關已設置為 OFF 。
- (4) 電源連接：單相連接

#### Power Connection

- (1) Check and set the power and air supply.  
Rated Voltage: AC220V +/-10%  
Air Pressure: 0.5Mpa (5kg/cm<sup>2</sup>)
- (2) Check and make sure the grounding wires are well connected.
- (3) Check and make sure the power switch is set OFF .
- (4) Power Connection: Single Phase Connection



#### 空氣連接

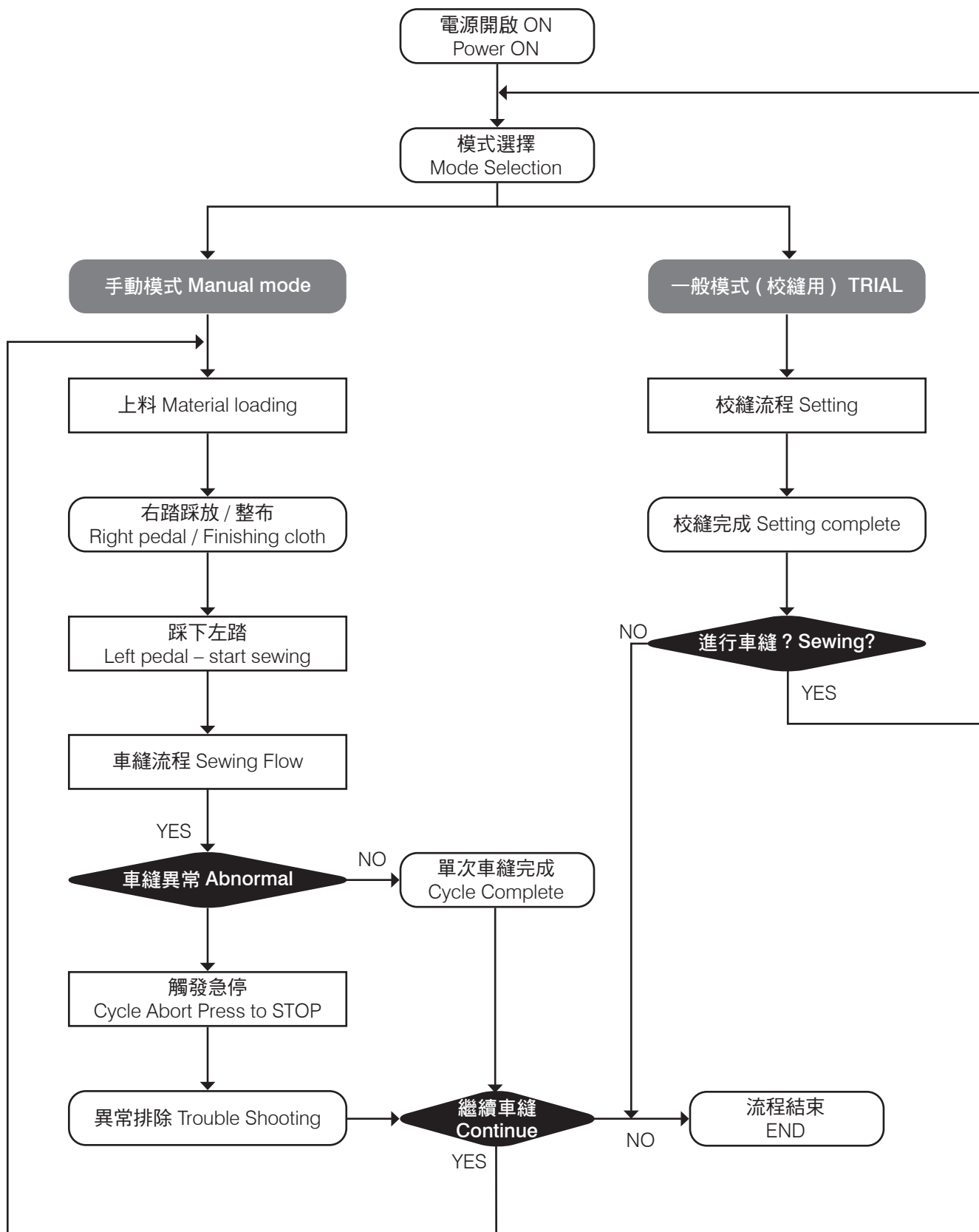
插入氣源。氣壓存在。如果需要重置，請拉起開關並旋轉到設定值。

#### Air Connection:

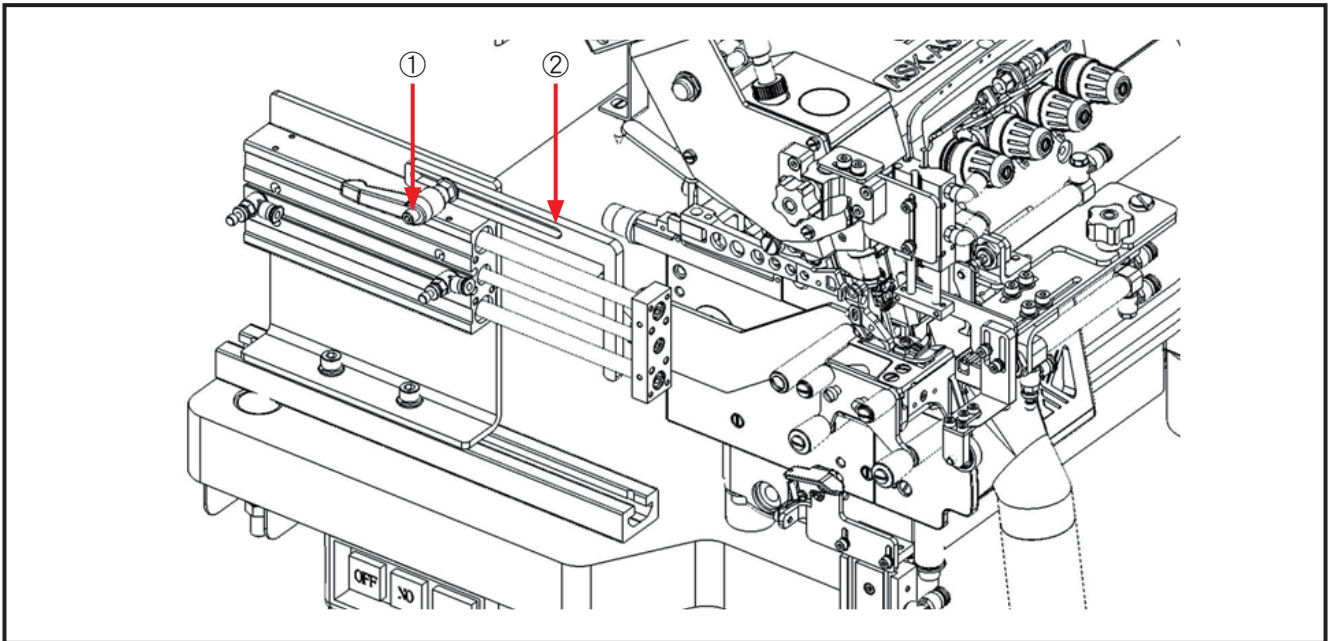
Plug the air supply. The air pressure is preset. In case you need to reset, pull up the switch and rotate to the setting value.

## 基本動作

## OPERATION FLOW





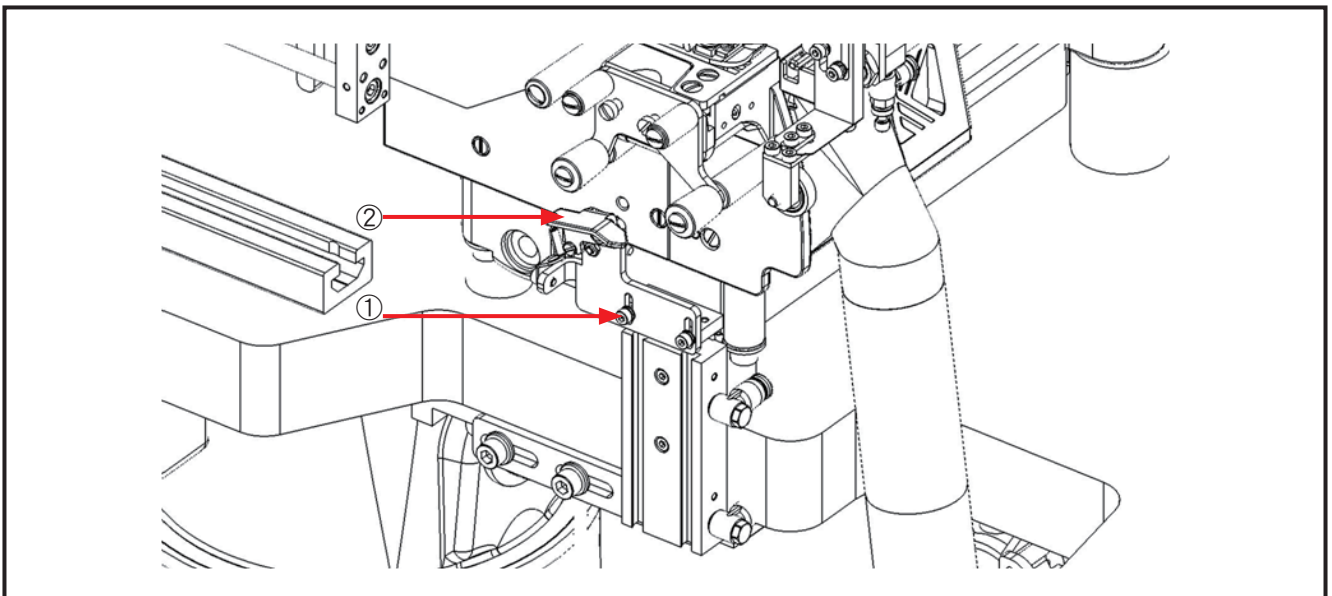


### 1. 撐布機構

逆時針方向將把手①鬆開後，調整汽缸擋板②至需求的高度，調整時汽缸擋板②須緊貼汽缸，至位置後再將把手①順時針旋緊。

### 1. Stretching System

(1) Release Lever ① and adjust Cylinder Block ② to the working position. The Cylinder Block ② must closely move along to Cylinder during the adjustment. Tighten Lever ① when complete.



### 2. 過骨感知機構

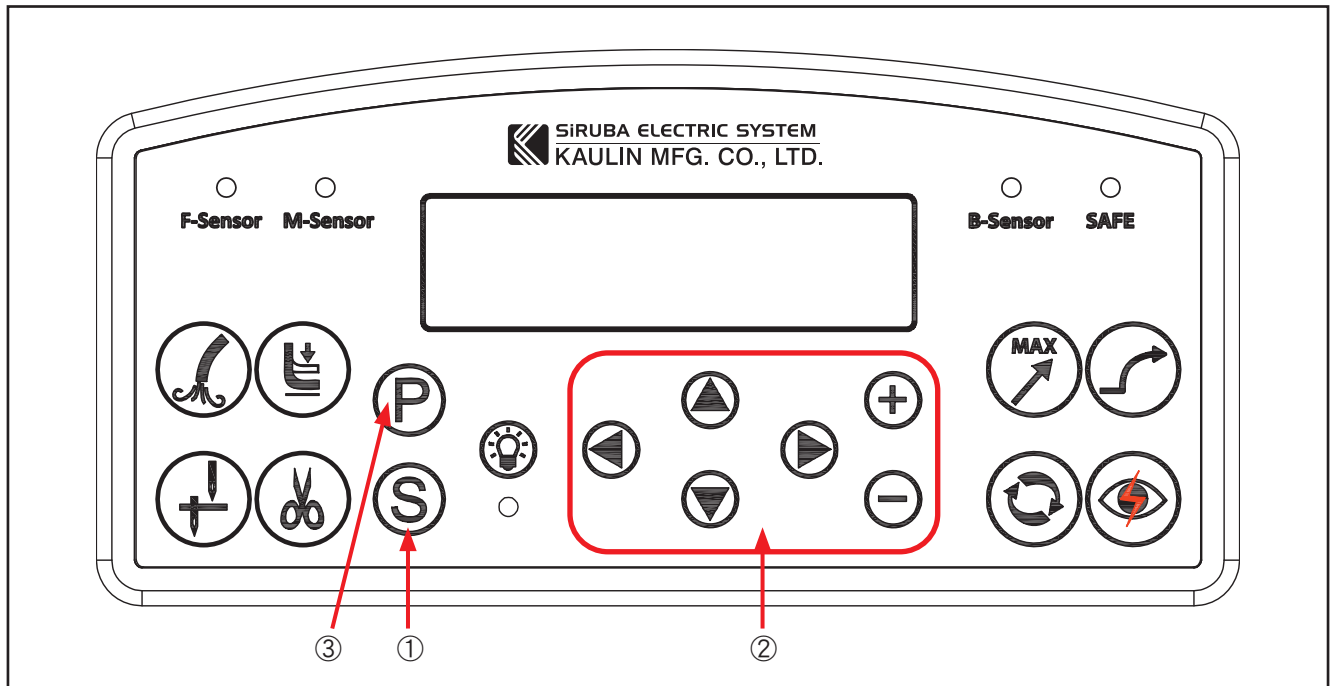
使用 2.5 號內六角鉸手將四顆螺絲①鬆開，即可調整過骨汽缸②前後位置至需求處。

### 2. Aligning System

Apply inner hex driver #2.5 to release the screws ①. Adjust the Cylinder Set ② to proper position.

## 選針盒操作設定

## PANEL & PARAMETERS



### 參數設定模式說明

#### 控制盒基本操作

- 步驟一：點擊按鈕①後，以按鍵區②輸入控制盒密碼：0168。
- 步驟二：密碼輸入完成後，再次點擊按鈕①進入參數選單。
- 步驟三：依據 P.08 附表選擇欲設定之項目後，點擊按鈕①進入設定畫面，即可使用按鍵區②更改設定值，選定數值後點擊按鈕③即可返回選單，完成此次設定。
- 步驟四：此時可於選單繼續選擇欲設定之項目進行參數變更，即重複步驟三。若已確認變更完成，則再次點擊按鈕③退至主畫面。

### Parameter Setting and Adjustment

#### Basic operation of control box

- Step 1: Click ①, enter the control box password in the Key area ② : 0168
- Step 2: After entering the password, click ① for the second time to enter the parameter menu.
- Step 3: After selecting the item to be set in the attached table of P.08, Click ① to enter the setting screen, use the area ② to change the set value, after confirming the value, click ③ to return to the selection list to complete the setting.
- Step 4: At this time, you can continue to select the item you want to set in the menu to change the parameters, that is, repeat step 3. After confirming that the change is completed, click ③ again to exit to the main screen.

## 參數表

※ 請勿更改標記為“請勿更改”的參數！

※ 有些參數需要密碼。有關密碼輸入，請參閱上述說明。

## Parameter List

※ **DO NOT CHANGE THOSE PARAMETERS THAT MARKED "DO NOT CHANGE" !**

※ Some parameters require passwords. Refer to instruction above for passwords input.

參數項 Item	參數碼 Code	參數功能 Function	設定範圍 Range	出廠值 Default	單位 Unit	說明 Description
1	H	伺服馬達速度調整 Speed Adjustment	200~5500	3000	rpm	本參數受 "66.HL" 最高速度限制管制 This parameter is limited by the highest speed limit "66.HL."
2	LMS	前慢速起縫功能開啟選擇 Selection of slow start function	ON/OFF	OFF	//	ON: 開啟 OFF: 關閉 ON: turn on OFF: turn off
3	L	前慢速起縫速度設定 Setting of slow start speed	200~5500	3000	rpm	車縫速度設定 Setting of sewing speed
4	LSS	前慢速起縫針數設定 Stitch setting of slow start	1~1000	30	針 Stitch	車縫針數設定 Setting of stitches 依參數 25 參考 sensor 過骨次數設定，為開始出發點 According to parameter 25, refer to the setting of the number of seams of the sensor, which is the starting point
5	FMS	後慢速結束縫功能開啟選擇 Selection of slow start function	ON/OFF	OFF	//	ON: 開啟 OFF: 關閉 ON: turn on OFF: turn off
6	L	後慢速結束縫速度設定 Setting of slow start speed	200~5500	250	rpm	車縫速度設定 Setting of sewing speed
7	FSS	後慢速結束縫針數設定 Stitch setting of slow start	1~1000	30	針 Stitch	車縫針數設定 Setting of stitches
8	KMS	計數器模式選擇 Selection of stitch counter mode	NOP/UTS	NOP	//	NOP: 關閉 UTS: 開啟功能 NOP: deactivate UTS: activate
9	TMD	機型選擇碼 Code of Machine Type	NOP: 一般車 CUFB: 大袖 CUFS: 小袖	依出貨規格設定 Set according to shipping specifications	//	NOP: 一般車 CUFB: 大袖口 CUFS: 小袖口 (另外，此參數不受按▲鍵重置出廠值影響。) NOP: general CUFB: CUFF BIG CUFS: CUFF SMALL Besides, the parameter won't be influenced by pressing the button ▲ of upward arrow.
10	KT	計數目標值設定 Setting of stitch target value	1~9999	99	次 Times	計數次數設定 Setting of stitch numbers
11	KV	計數值顯示 Stitch display	1~9999	0	次 Times	即時顯示 Instantaneous display
12	SV	車頭運轉速度顯示 Machine rotary speed display	200~5500	0	rpm	即時顯示馬達實際運轉轉速。 Instantaneous display the motor exact rotary speed.
13	MRM	伺服馬達運轉模式設定 Setting of motor rotary mode	NOP/MA	MA	//	MA: 半自動 MA: semi-auto
14	AA	步進汽缸啟動延遲 Stepping Motor Valve Delay	0000 ~9999	1	ms	按下啟動開關後延遲 ms 後，步進馬達轉輪前後電磁閥啟動 Enabling the stepping motor if delays few milliseconds after press the starting switch. (A. 順布步進馬達) (A. Shun cloth stepping motor)
15	BB	撐布輪汽缸啟動延遲 Brace wheel valve delay	0000 ~9999	5	ms	按下啟動開關後延遲 ms 後，撐布輪電磁閥啟動 啟動預備時 ON, 車縫結束時 OFF Enabling the brace wheel valve if delays few milliseconds after press the starting switch. ON at the start of preparation, OFF at the end of sewing. (E. 撐布輪 E. Brace wheel)

16	CC	壓腳汽缸啟動延遲 Foot Valve delay	0000 ~9999	40	ms	按下啟動開關後延遲 ms 後，壓腳放下 Put down the foot if delays few milliseconds after press the starting switch. (I. 壓腳 ) (I. Presser foot)
17	DD	過骨後車縫針數 Overlapping sewing stitch	0000 ~9999	CUFB:45(65) CUFS:80	針 Stitch	縫紉經過過骨 SENSOR 後，繼續縫紉針數 Sewing stitches after overlapping sensor. (過骨 SENSOR)
18	EE	車縫前啟動鬆線關閉針數 Loose stop stitch	0000 ~9999	1(0)	0 針 Stitch	設 0 為關閉鬆線功能；車縫前馬達啟動經過幾針後，關閉鬆線（正常情況下一直鬆線） Disabling the loose valve after delays few stitches after motor starting. (F. 鬆線氣缸 Thread release cylinder)
19	HH	後吸風針數設定 Suction, Cut and loose Stitch	0000 ~9999	70	針 Stitch	執行完參數 14 設定值後，執行後吸風針數設定 此為所有車縫程序的最後動作參數項，結束後回到待機準備狀態 Executing the suction, Cutting and loose stitch after the parameter This is the last action parameter item of all sewing procedures. After the end, it will return to the state of waiting for machine preparation. (C. 後吸風 Back suction) (F. 鬆線氣缸 Thread release cylinder)
20	FF	退布桿啟動後執行針數 Push stick open time	0000 ~9999	180(45)	針 Stitch	退布桿電磁閥執行針數 The executing time of push stick valve. (B. 退布氣缸 Ejection cylinder)
21	GG	退布桿啟動延遲針數 Push stick delay time	0000 ~9999	CUFB: 30(40~60) CUFS:60	針 Stitch	縫紉經過過骨 SENSOR 觸發，延遲針數後啟動退布桿電磁閥 (B. 退布氣缸) 以過骨 SENSOR 觸發為啟動參考點 Enabling the push stick valve after delays few milliseconds after overlapping. (B, Ejection cylinder) uses the overlapping trigger as the starting reference point
22	BS	後吸風動作延遲針數 Back suction action delay time	0000~ 9999	0	針 Stitch	當值設為 0 時：關閉 執行完參數 14 後，延遲吸風切線設定針數後，啟動參數 22 後吸風程序 (C. 後吸風) When the value is set to 0 : off After parameter 14 is executed, the number of stitches is set for the delayed suction thread trimming, the suction program after parameter 22 is started (C. back suction)
23	SO	車縫完成後吸風結束延遲 時間 Suction end delay after sewing is completed time	0000~ 5000	60(0)	ms	執行完參數 19 後，延遲參數 23 設定時間 After executing parameter 19, delay the setting time of parameter 23
24	IRD	步進馬達轉速設定 Speed adjustment of stepping motor	320~800	350		順布布進馬達轉速調整，數值越小轉速越高 Speed adjustment of stepping motor. The smaller the value, the higher the speed
25	BI	過骨次數設定 overlapping switch	0~99	1	次 Times	0: 關閉，不檢知股數，1~99: 過骨檢測次數設定 (過骨 SENSOR) (D. 過骨檢知氣缸) 啟動預備氣缸 ON，檢測到達設定過骨次數後 OFF 0: close 1~99: Set the number of times of passing the detection (overlapping SENSOR) (D. overlapping inspection cylinder) Start the reserve cylinder ON, Turn off after the detection reaches the set number of overlapping
26	OBS	外捲吹氣開啟 / 關閉 Outer curly blowing open/ close	ON/OFF	OFF		ON: 開啟，跟隨參數 27.SS 針數動作 OFF: 關閉，不動作 ON: Turn on, follow the parameter 27.SS stitch number action OFF: Closed, no action



27	OB	外捲吹氣結束針數 Number of stitches at the end of the Outer curly blowing	0000~9999	40	針 Stitch	G. 外捲吹氣，流程待確認壓腳抬起時啟動吹氣，直到過骨 SENSOR 觸發後，延遲設定針數後結束 G. Outer curly blowing, process to be confirmed. When the presser foot is lifted, start blowing until the overlapping is triggered, and the number of stitches will be delayed before the end is set.
28	IBS	內捲吹氣開啟 / 關閉選擇 Inner curly blowing on/off selection	ON/OFF	OFF		ON: 開啟，跟隨參數 29 針數動作 OFF: 關閉，不動作 Open, follow the parameter 29 stitches to operate OFF: Close, no action
29	IB	內捲吹氣結束針數 Number of stitches at the end of the Inner curly blowing	001~100	1(13)	針 Stitch	車縫啟動時前伸啟動吹氣，直到過骨 SENSOR 觸發後，到達參數 29 針數後結束，K. 內捲吹氣 When the sewing is started, stretch forward and start blowing, until after the overlapping sensor is triggered. End after reaching the parameter of 29 stitches K. Inner curly blowing
30	RO	縫合擋邊開啟針數 Number of stitches for opening and closing the ribs	0000~9999	CUFB:10 CUFS:35	針 Stitch	縫紉經過過骨 SENSOR 觸發後經過參數 30 設定值後電磁閥 ON, (H. 縫合擋邊) After sewing overlapping, SENSOR is triggered and after the setting value of parameter 30, the solenoid valve is turned on. (H. Sewing the ribs)
31	RC	縫合檔邊關閉針數 Number of stitches at stitch ribs closed	0000~9999	CUFB:61 CUFS:70	針 Stitch	經過設定針數後 OFF Turn off after setting the number of stitches
32	ATF	啟動模式選擇 Start mode selection	ON/OFF	ON		ON: 立式踏板模式 OFF: 控速器模式 ON: Vertical pedal mode OFF: Speed controller mode
33	INF	紅外線標示器 Infrared Marker	ON/OFF	ON		ON: 開啟 OFF: 關閉
34	ABC	運轉長吸風開關 Long suction start switch	ON/OFF	OFF		運轉即吸風開關 The switch of suction function during the operation. (C. 後吸風) (C. back suction)
35	SWC	吸風動作模式選擇 Select the mode of suction	1/2/3/4/5	3		1. 無吸風動作 2. 僅前吸風 3. 僅後吸風 4. 前後吸風 5. 機械吸風開啟 (手動模式有效) 1. No suction 2. Only the front suction 3. Only the back suction 4. The front and back suction 5. Mechanical suction (only for manual mode)
36	TIN	過骨伸縮動作模擬 Overlapping extension and contraction motion simulation	0、1、2、3	0~3		過骨布厚機構調整模擬 Overlapping cloth thickness mechanism adjustment simulation
37	HFS	縫紉件數計數歸零 The number of sewing pieces is reset to zero	ON/OFF	OFF		設 ON 後會將傳送值歸零後，自動回復 OFF After it is set to ON, the transmission value will be reset to zero, and then it will automatically return to OFF
38	DO	過骨 SENSOR 汽缸結束延遲針數 SENSOR Cylinder End Delay Needle Number	0000~9999	CUFB:0 CUFS:40	針 Stitch	當參數 17 針數到達後，延遲參數 38 設定針數後過骨 SENSOR 汽缸 & 導布桿氣缸 OFF (D) When the number of stitches in parameter 17 is reached, delay parameter 38 after setting the number of stitches. SENSOR cylinder & guide rod cylinder OFF (D)
39	INF	無彈性布料車縫模式 Non-elastic fabric sewing mode	ON/OFF	OFF		ON: 開啟功能 (撐布輪依參數 '40 設定動作) OFF: 關閉功能 ON: turn on the function (the cloth support wheel will act according to the parameter '40 setting) OFF: turn off the function
40	BO	撐布輪汽缸結束延遲針數 Number of stitches for the end of the cylinder of brace wheel	0000~9999	CUFB:45 UFS:120	針 Stitch	當過骨 sensor 被觸發後，延遲參數 39 設定針數後撐布輪氣缸 OFF (E) **非彈性布料調整用 After the overlapping sensor is triggered, the delay parameter 39 sets the number of stitches and the brace wheel cylinder is OFF (E) **For non-elastic cloth material adjustment

41	TCT	撐布輪動作模式 Brace wheel action mode	0、1	0		0: 標準模式 1: 兩次套料模式 Standard mode 1: Twice nesting mode
42~49			保留參數 Reserved parameters			
50	BR	鮑率設定 Baud rate setting	96、192、384、1152	384		四種傳輸速度：Four transmission speeds: 96---->9600，192----->19200，384----->38400，1152----->115200
51	TN1	針上 / 針下定位功能選擇 Function selection of the needle up/ down location	U/D/UD	U	//	U 為上停針、D 為下停針、UD 模式則為下停針，但全後踩執行提針抬壓腳。 U: The highest location D: The lowest location UD: The lowest location, but when the fully pedaling, the presser foot will be risen.
52	BUZ	按鍵蜂鳴器開關 Switch of buzzer	ON/OFF	ON	//	當壓腳保護 (30 秒) 或計數值到達時，蜂鳴器會發出嗶嗶兩聲。 When reaching the presser protection (30sec) or the counter-stitches value, the buzzer will beep twice.
53	TFD	動作功能檢查選擇 Selection to check the functions of the solenoid motion	0~9	0	//	各數字代表： 1. 抬壓腳氣動氣缸 (動作 2 秒) . I 2.OFF 3. 後吸風切線 (動作 50ms) C 4. 撐布輪氣缸 (動作 2 秒) E 5. 過骨 SENSOR 氣缸 D 6. 鬆線氣缸 (動作 2 秒) F 7. 退布桿氣缸 B 8. 順布步進馬達氣缸 A 9. 步進馬達啟動 10. 防外捲吹氣 G 11. 擋布桿汽缸 H 12. 防內捲吹氣 K 13. 控速器電壓值 (跳至參數 82) Each number represents: 1. Lift the presser foot to move the cylinder (action for 2 seconds). I 2. OFF 3. Back suction (action 50ms) C 4. Brace wheel cylinder (action for 2 seconds) E 5. SENSOR Cylinder D 6. Thread release cylinder (operating for 2 seconds) F 7. Ejection cylinder cylinder B 8. Stepping motor cylinder A 9. Stepper motor start 10. Anti- outer curly blowing G 11. Cloth rod cylinder H 12. Anti-Inner curly blowing K 13. Speed controller voltage value (skip to parameter 82)
54	FT	抬壓腳電磁鐵出力初始全額輸出時間 The initial full output time of presser electromagnet	0~990	250	ms	抬壓腳電磁鐵參數 請勿調整 DO NOT ADJUST the parameter of presser foot electromagnet.
55	FD	抬壓腳電磁鐵出力動作週期 % The motion cycle % of the presser foot electromagnet	10~50%	25	%	
56	FPM	抬壓腳電磁鐵動作時的保護功能開啟選擇 Select to turn on the protecting function when the presser foot electromagnet performs.	ON/OFF	ON	//	

57	FP	抬壓腳電磁鐵動作時的保護時間設定 Set the protection time when the presser foot electromagnet performs.	1~300	電磁閥 :120 Solenoid valve:120	秒 Sec.	
58	FMM	抬壓腳動作模式選擇 Select the mode of the presser foot.	ON/OFF	ON	//	當抬壓腳抬起時且“58.FMM” ON，啟動後延遲“59.FMS”時間後，壓腳自動放下。 When the presser foot is risen and the “58.FMM” is on, the front electronic eye detects the fabric and delays for “59.FMS”. The presser foot descends automatically.
59	FMS	壓腳放下延遲時間設定 Set the delay time when the presser foot descends.	1~3000	10	ms	
60	HT	半後踏抬壓腳確認時間 Confirm the time of half pedaling the presser foot	0~990	100	ms	半後踩延遲時間設定 Set the time of delaying as pedaling half.
61	FMD	伺服馬達啟動時間延遲 Delay the time of activating the motor.	50~500	500	ms	壓腳放下延遲時間“48.FMD”經過後，才允許伺服馬達啟動。 Descend the presser foot and after delaying for “48.FMD,” the motor will activate.
62	MSW	安全開關功能選擇 Function selection of safety switch	ON/OFF	OFF	//	ON: 開啟安全開關保護功能（當近接開關被移開時，停止所有機能且馬達不轉動），OFF: 取消安全開關保護。 ON: Activate the protection function from the safety switch (When removing the photoelectric switch, stop the entire device and the motor) OFF: Deactivate the protection.
63	SDA	針下停止角度 The stop angle as the needle descending	0-360	220	角度 Angle	勿調整 DO NOT adjustment
64	SUA	針上停止角度 The stop angle as the needle rising	0-360	30	角度 Angle	勿調整 DO NOT adjustment
65	ER	故障碼顯示 Fault code display	0~9		組 Set	可記憶最近 10 組故障代碼 The recent 10 sets of fault code can be memorized.
66	HL	車頭最高速度限制 The highest speed limit of the machine head	200~5500	3000	rpm	最高速度限制（最高優先權），“61.HL”設為 5500rpm 後參數“01.H”才能設定為最高轉速。 The highest speed limit (the highest priority), set “61.HL” as 5500rpm, and the parameter “01.H” can be set as the highest rotary speed.
67	ACR	輔助切線馬達速度 The motor speed of assistant trimming	200-5000	3000	rpm	VTE/CTE 模式下，在車縫機能完成後，按壓手動切刀開關可執行“切刀吸風輔助功能”。 With the mode of VTE/CTE, after sewing, the function of “trimming and assistant suction” can be activated by pressing the button of manually trimming.
68	ACS	輔助切線運轉針數 The rotary stitches of assistant trimming	1-99	20	針 Stitch	(F. 後吸風) (F. Back suction)
69	CS	踏板靈敏度調整 Adjust the sensor's sensitivity	1-10 段 1-10 section	2	1	調整“69.CS”可設定 OT/A 模式時控速器”踩一下”之踩踏深度判斷，作為馬達啟動訊號。段速越大則深度越深。 Adjust “69.CS” to set the OT/A mode and decide the depth of pedaling by stepping the speed control for the motor start signal. The bigger section, the greater depth.
70	NUF	開電自動提針 Needle auto-rising after turning on	ON/OFF	ON	//	ON: 開電後將自動提針至上停位位置 OFF: 無此功能 ON: The needle rises automatically to the highest position after turning on. OFF: None function
71	LSH	側板安全開關 Safety switch of side plate	ON/OFF	OFF	//	ON: 開啟 OFF: 無此功能 ON: Turn on OFF: None function

72	HVR	最高電壓紀錄顯示 The highest voltage record display	//	//	//	“72HVR”、“73LVR”可記錄控制盒 AC 入電最高與最低電壓有效值。 “72HVR” and “73LVR” can record the highest and the lowest current effective value of the control box AC.
73	LVR	最低電壓紀錄顯示 The lowest voltage record display	//	//	//	
74	PV	目前電壓顯示 Present voltage record display	//	即時顯示 Instantaneous display	//	
75	AOT	自動運轉測試全程時間設定 Time setting of auto rotary test throughout	1~500	240	小時	自動運轉測試全程時間設定 Time setting of auto rotary test throughout
76	AO1	自動運轉啟動時間設定 Time setting of activating the auto performance	1~20	2	s	自動運轉啟動時間設定 Time setting of activating the auto performance
77	AO2	自動運轉停止時間設定 Time setting of deactivating the auto performance	1~20	2	s	自動運轉停止時間設定 Time setting of deactivating the auto performance
78	AOS	自動運轉功能 Function of auto rotation	ON/OFF	OFF	//	ON: 車頭自動運轉測試開始；OFF: 自動運轉關閉 (關電即恢復 OFF 狀態) ON: Start the auto rotation test OFF: Deactivate the auto rotation (Shutting down restores to the OFF state.)
79	UTT	自動運轉時間顯示 Time display of auto rotation	1~1000	即時顯示 Instantaneous display	小時	運轉累積時數 Accumulate times by rotation
80	VER	軟體版本顯示 Display the software version		MBS1E1 (404)		顯示控制器軟體版本為 SXEX。 若按 ▼ 鍵顯示 UI 版本 The display controller firmware version is SXEX. If press ▼ key then display UI firmware version
81	LAN	液晶面板語言選擇 The language selection	//	英文	//	英文 / 繁體中文 / 簡體中文 English / Traditional Chinese / Simplified Chinese
82	FOO	控速器電壓顯示 Display the speed controller's analog voltage	0~4096	即時顯示 Instantaneous display	//	
83	GHT	機能式自動運轉 Functional automatic operation	ON/OFF	OFF		ON: 燒機自動運轉測試啟動 OFF: 關閉 ** 馬達運轉時，參數無法調整設定 ON: automatic operation, test start OFF: Closed ** Parameters cannot be adjusted when the motor is running
84	PS	Password	//	OFF	//	密碼鎖功能設為 ON 後，所有選針盒參數皆不能更改。 解鎖密碼為：0168。 PS: 此參數 ON 時，欲進入第二階參數請先按 S 顯示輸入密碼後，再按住 S 直到顯示反白可輸入的畫面。 Set the lock function as ON, all the parameters of the operation box cannot be changes. The unlock password: 0168 PS: When this parameter is ON, if you want to enter the second-level parameter, please press S to display the input first.
85	BKL	LCD 背光亮度 LCD Backlight	0%~100%	40%	//	
91	LDL	馬達升 / 降斜率 Motor speed slope	165、200、250、300、350	200	ms	馬達加速 / 減速斜率 Acceleration / deceleration slope 165ms, 200ms, 250ms, 300ms, 350ms



## 操作說明

## OPERATION

### 1. 電源與氣壓

#### (1) 電壓

使用額定電壓 AC 220V $\pm$ 10%，接地線必須接地。

#### (2) 氣壓

使用 0.5Mpa (5kg/c m<sup>2</sup>)。

### 2. 上料步驟

將預先準備之羅紋布料套入刷毛布料 (股朝外) 內，兩兩布邊相互齊平，並確認兩股對位正確，即可平整套入筒嘴至貼齊退布擋塊。

### 1. Power and Air Pressure

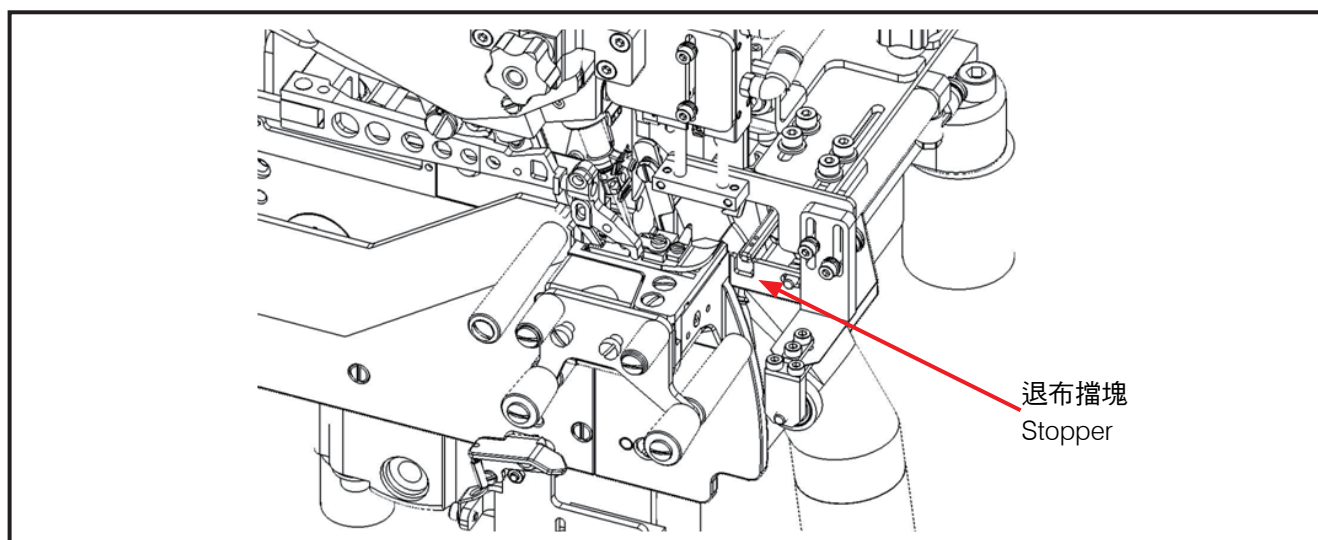
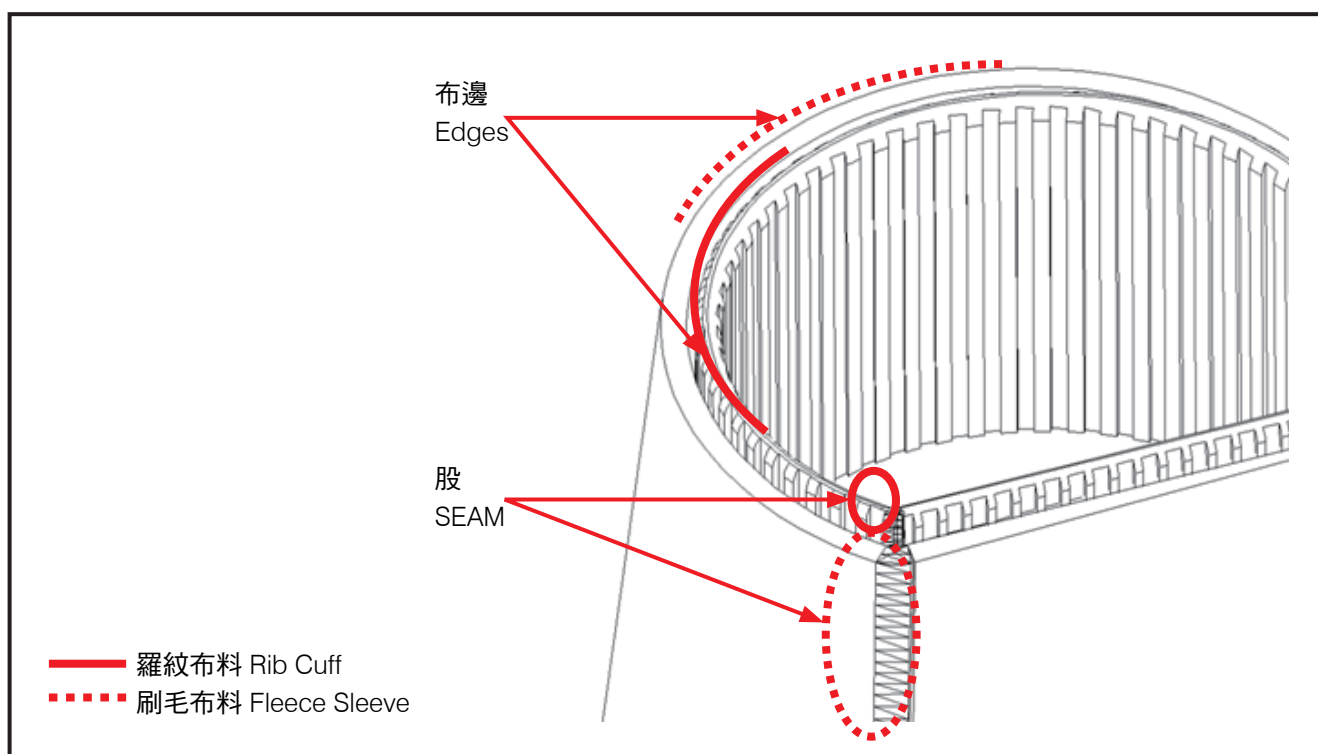
#### (1) Main Power

Rate Power Supply AC 220V $\pm$ 10%。Must be grounded。

#### (2) Air Supply Setting 0.5Mpa (5kg/c m<sup>2</sup>)。

### 2. To upload the material

Insert the rib cuff into the fleece sleeve (seam facing outward). Align the edges and make sure the seams are overlapped. Then load the material onto the sewing machine to the stopper.



## 3. 車縫流程

選擇要使用立式踏板或雙踏板。

### (1) 立式踏板

踏板後踩可控制撐布機構、壓腳的上升及下降，上料後前踩一下，即啟動車縫流程。

### (2) 雙踏板

右踏可控制撐布機構、壓腳的上升及下降，上料後踩左踏，即啟動車縫流程。

## 3. Sewing process

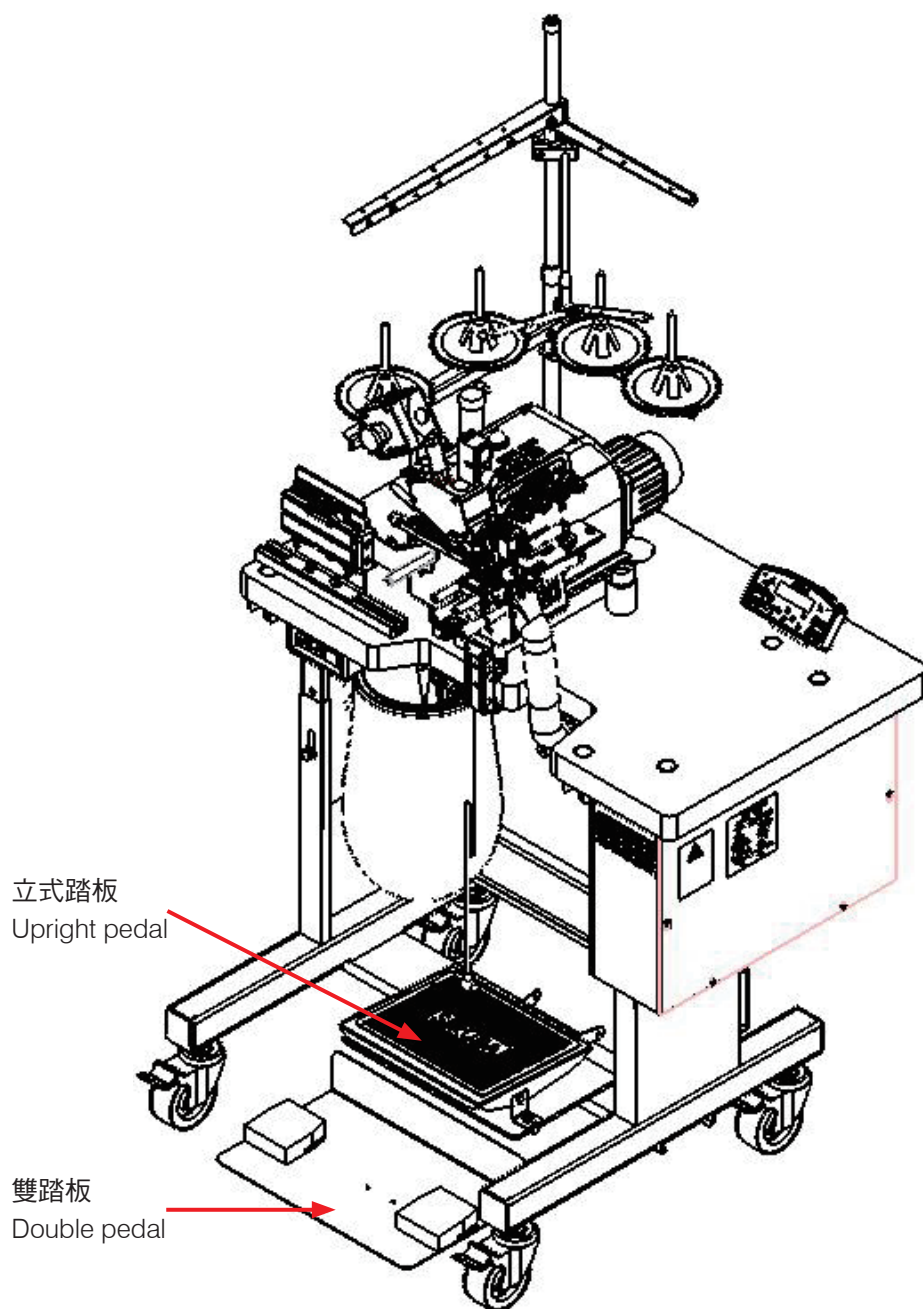
Choose to use vertical pedal or dual pedal.

### (1) Upright pedal

Step on the pedal backward can control the up and down of the fabric supporting mechanism and the presser foot. Step on the pedal forward after loading the material to start the sewing process.

### (2) Double pedal

The right pedal can control the up and down of the cloth support mechanism and the presser foot. After loading the material, step on the left pedal to start the sewing process.



## 異常排除

## TROUBLE SHOOTING

### 異常原因與對策

### Mechanic or finished quality issue


異常 Issue	原因 Cause	對策 Solution	參考 Reference
成品布料變形： ◆ 布料失去彈性 ◆ 袖口呈現波浪狀 Deformation： ◆ Poor elasticity ◆ Rippled cuff	◆ 撐開機構拉伸過度 ◆ 撐開機構拉伸距離不足 ◆ Stretching system over-stretches. ◆ Not enough stretching distance	調整撐開機構之拉伸量 Adjust the stretching system	撐布機構 Stretching System
車縫成品線跡對線不良 Poor stitching line	小滾輪傾斜角度有誤，故無法順利將線跡對齊 Angle error on Pulling Roller.	調整小滾輪與布面貼合角度與接觸量 Adjust the Roller angle and contact area with fabric.	過骨感知機構： B. 推布小滾輪 Cross Seam System： Pulling Roller
布料堆積： ◆ 嚴重積布 ◆ 送布無力 Fabric accumulation： ◆ Fabric overlapping ◆ Bad fabric feeding	◆ 順布滾輪擠壓過度，導致布料無法通過 ◆ 順布滾輪未順利貼靠布面 ◆ Aligning roller over-presses, causing fabric jam ◆ Poor contact of Feeding Roller against the fabric	調整順布機構與布面接觸量 Adjust the Roller angle and contact area with fabric.	順布機構 Aligning System
車縫狀態異常： ◆ 未車縫完成即停止 ◆ 車縫無法停止 Abnormal sewing： ◆ Sewing stops before operation completes. ◆ Sewing cannot stop	◆ 過骨感知 Sensor 過低，以至於布料輕微隆起即誤判為車縫完畢 ◆ 過骨感知 Sensor 過高，無法偵測過骨，則無法結束車縫 ◆ Cross-seam Sensor is too low, any tiny ridge may taken as operation completes. ◆ Cross-seam sensor is too high, cannot detect cross-seam to end the operation.	調整過骨感知機構之 Sensor 高低位置 Adjust the sensor of cross-seam system.	過骨感知機構： A. 過骨 Sensor Cross-Seam System： Cross-Seam Sensor
切線異常 Bad Cutting	◆ 退布後預留針數過少 ◆ 吸風切線針數過少 ◆ Not enough reserved stitch after ejection ◆ Not enough stitch after suction/cut	調整參數設定 Reset the parameter #14、#18	參數表： 項次 14、項次 18 Parameter List： Item #14、#18

## 電控故障排除

## Electronic Issues

選針盒顯示 錯誤碼 Error Code	異常現象說明 Cause	解決措施 Solution
Err 1	過電流保護 Over Current	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 確認 IGBT 模組工作正常。</li> <li>3. 一分鐘後重新送電。控制器若仍有錯誤碼顯示，請更換控制器並通知廠商。</li> </ol> <ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check if the IGBT module is normal.</li> <li>3. Reboot the system after 1 min. If the error code still exists, please exchange control box and contact Kaulin or authorized agents.</li> </ol>
Err 4	過電壓保護 Over Voltage	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 請檢查是否插錯供應電源或電壓過高。</li> <li>3. 如電壓過高，則待電壓回復正常後重新開機。如無，則一分鐘後重新送電。</li> <li>4. 控制器若仍有錯誤碼顯示，請更換控制器並通知廠商。</li> </ol> <ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check the power connection to the control box. Check if the power supply complied to specification.</li> <li>3. If the voltage is too high, please wait until the power is normal and then reboot. If not, reboot the system after 1 minute.</li> <li>4. If the error code still exists, please exchange control box and contact Kaulin or authorized agents.</li> </ol>
Err 7	堵轉檢知遮斷 Over Torque	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 檢查馬達動力線插頭配線是否接觸不良。</li> <li>3. 是否有異物纏繞機頭、其他機械結構干涉異常、或紡織物是否過厚。</li> <li>4. 確認切刀是否磨耗需更換。</li> <li>5. 排除後重新送電，若仍無法正常運轉，請通知廠商。</li> </ol> <ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check the power connection to motor.</li> <li>3. Check if there is a jam to the machine, mechanical interference, or if the textile is too thick.</li> <li>4. Check the trimmer condition, replace a new trimmer if needed.</li> <li>5. Reboot the system. If the error code still exists, please contact us or authorized agents.</li> </ol>
Err 8	選針盒通訊介面異常 Operation Box Communication Error	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 檢查選針盒連接線是否脫落、鬆動、破損、插入方向錯誤。</li> <li>3. 排除後重新送電，若仍無法正常運轉，請通知廠商。</li> </ol> <ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check if the power/cable connection to the operation box. Re-connect or replace if needed.</li> <li>3. Reboot the system. If the error code still exists, please contact us or authorized agents.</li> </ol>



Err 17	緊急停止 emergency stop	1. 關閉電源。 2. 檢查啟動鍵連接線是否脫落、鬆動、破損、插入方向錯誤。 3. 排除後重新送電，若仍無法正常運轉，請通知廠商。 1. Turn off the power. 2. Check if the power/cable connection to the START switch box. Re-connect or replace if needed. 3. Reboot the system. If the error code still exists, please contact us or authorized agents.
Err 20	控制器過熱保護 Control Box Over Heat	1. 關閉電源，10 分鐘後重新送電。 2. 控制器若仍有故障燈顯示，請通知廠商。 1. Turn off the power. Wait for at least 10 minutes until the control box cools down. 2. Reboot the system. If the error code still exists, please contact us or authorized agents.
Err 21	電機編碼板異常 Motor Encoder Abnormal	1. 關閉電源。 2. 檢查電機編碼器連接線是否接觸不良或馬達編碼器是否故障。 3. 排除後重新送電，若仍無法正常運轉，請通知廠商。 1. Turn off the power. 2. Check if the power/cable connection to the motor encoder. . Re-connect or replace if there is a bad connection or failure. 3. Reboot the system. If the error code still exists, please contact us or authorized agents.
Err 24	電磁閥異常 Solenoid Valve Abnormal	1. 關閉電源。 2. 檢查電磁閥接線是否有錯誤或是短路。 3. 排除後重新送電，若仍無法正常運轉，請通知廠商。 1. Turn off the power. 2. Check the connection to the solenoid valve. Re-connect or replace if needed. 3. Reboot the system. If the error code still exists, please contact us or authorized agents.
Err 60	控速器異常 Speed controller Abnormal	1. 關閉電源。 2. 檢查控速器接線是否有錯誤或是短路。 3. 排除後重新送電，若仍無法正常運轉，請通知廠商。 1. Turn off the power. 2. Check the power/cable connection to the speed controller. Re-connect or replace if needed. 。 3. Reboot the system. If the error code still exists, please contact us or authorized agents.
	安全開關檢知遮斷 Safety Switch Error	一般模式下，旋轉符號不轉動時： 1. 關閉電源，檢查縫紉機安全開關是否故障。 2. 排除後重新送電，若仍無法正常運轉，請通知廠商。 Under Trial mode, if the motor stops rotation: 1. Turn off the power and check the connection to safety switch. Re-connect or replace if needed. 2. Reboot the system. If the error code still exists, please contact us or authorized agents.

## SERVICE PARTS POLICY

To ensure the quality and safety of machine, all SIRUBA parts pass the highest quality inspection and test. For any case of adopting non-genuine SIRUBA parts for replacement and service, it may cause not only losing the warranty coverage, but also the unexpected damage to the operator and property.

In some cases, issues such as difficulty of obtaining parts might make it impossible for us to repair or replace malfunctioning items even if the service period has not yet ended. We ask for your understanding on this matter

To continuously provide our customers the high quality machines and service, we do not guarantee the parts supply service for the discontinued models after 5 years since the production stops.

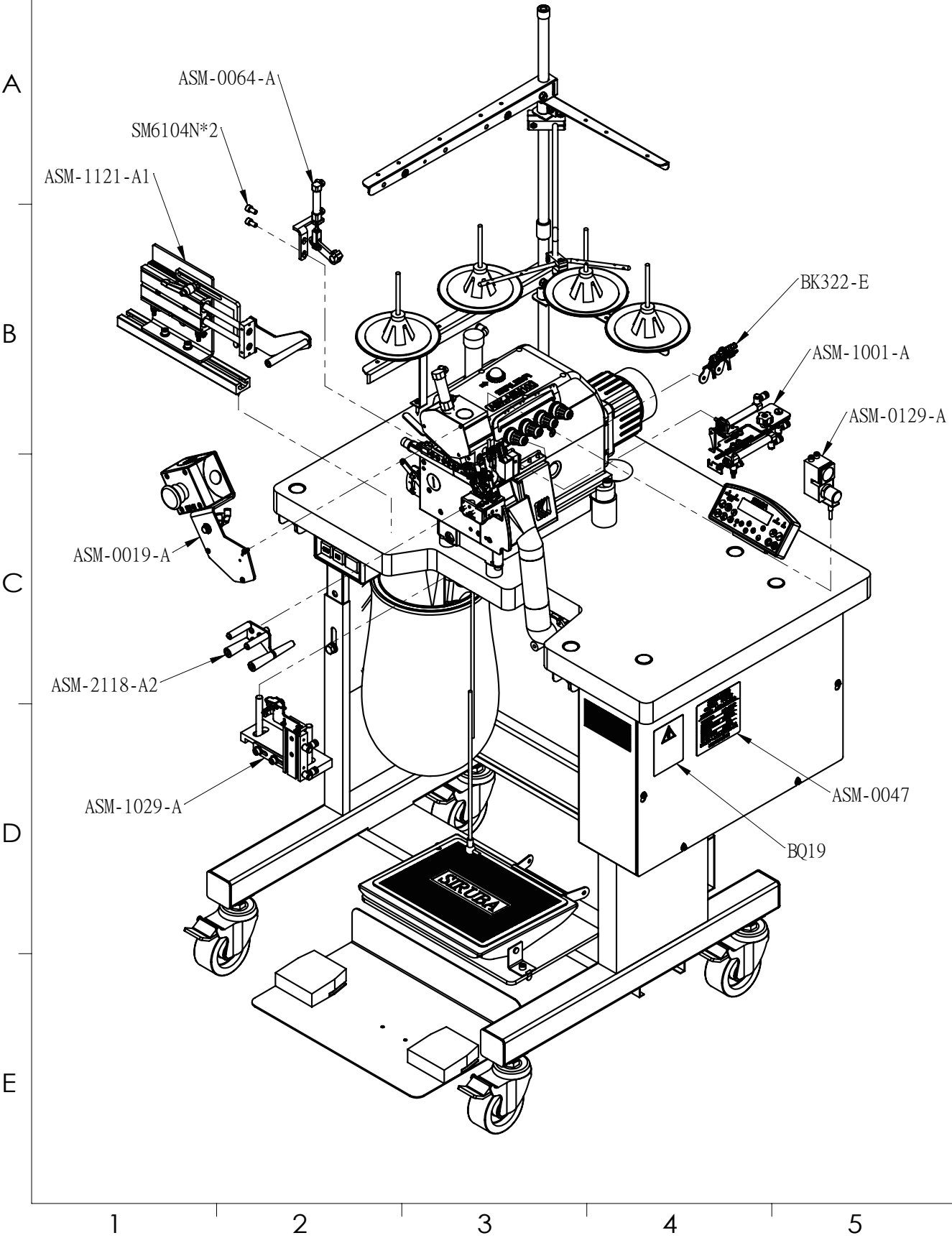
## 服務部分政策

為確保機器的質量和安全，所有 SIRUBA 部件均通過了最高質量的檢驗和測試。對於任何採用非正品 SIRUBA 部件進行更換和維修的情況，不僅可能導致保修範圍的損失，還可能導致對操作員和財產的意外損壞。

在某些情況下，即使服務期尚未結束，諸如難以獲得零件等問題也可能使我們無法修理或更換故障物品。我們要求您就此事達成諒解

為了不斷為客戶提供高質量的機器和服務，我們不保證自生產停止 5 年後停產的型號的零件供應服務。

<b>SIRUBA</b>  PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASK-ASM101	ASK-ASM101	ASK11	1 / 1
				Date
				2022/06/29



<b>SIRUBA</b>  PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASK-ASM101	BK322-E		1 / 1
				Date
				2022/06/29

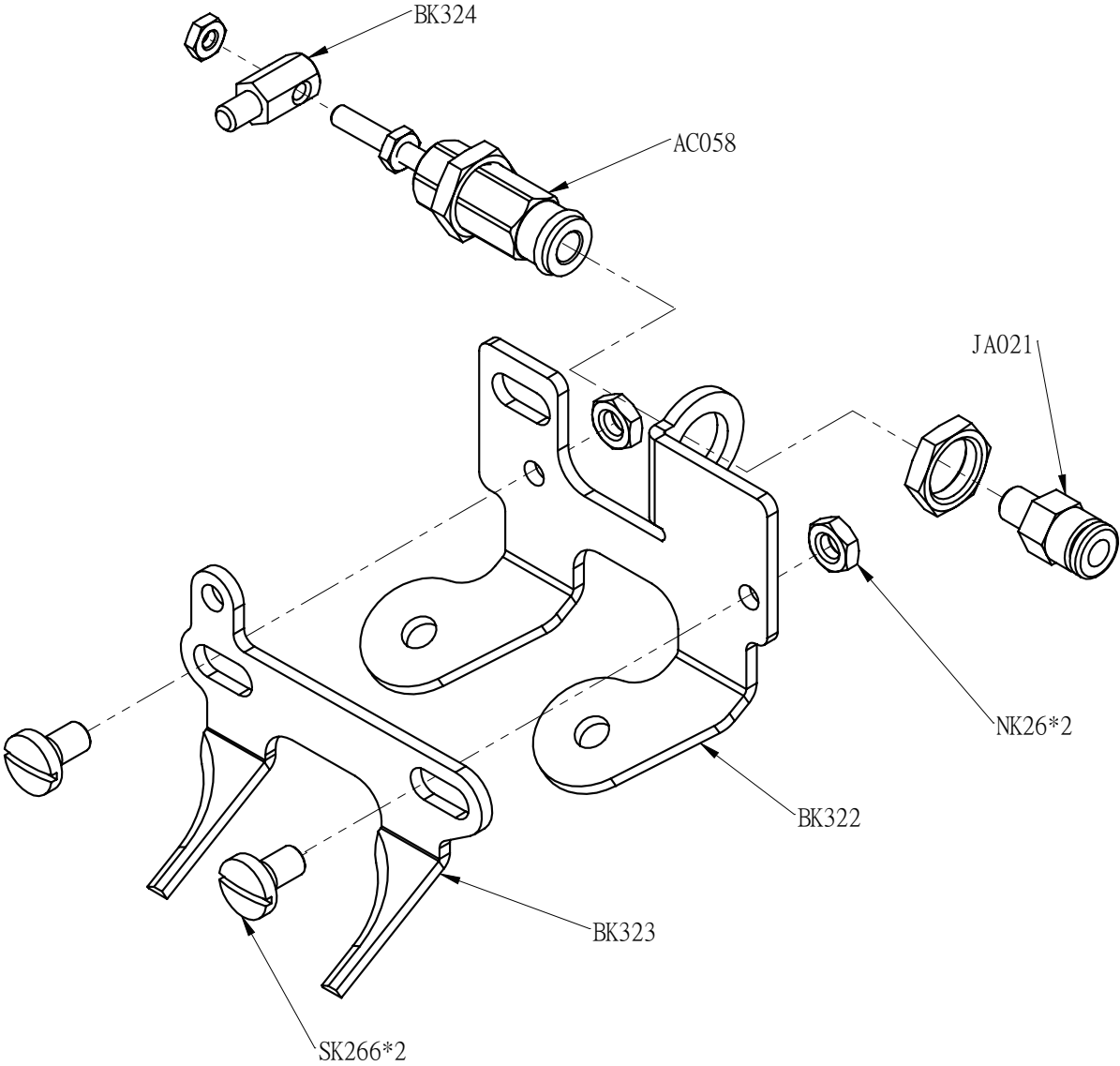
A

B

C

D

E



<div> <div>SIRUBA</div> <div>PARTS LIST</div> </div>	Series	Parts Group	Subclass Remark	Page
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				Date
				2022/06/29

A

B

C

D

E

1

2

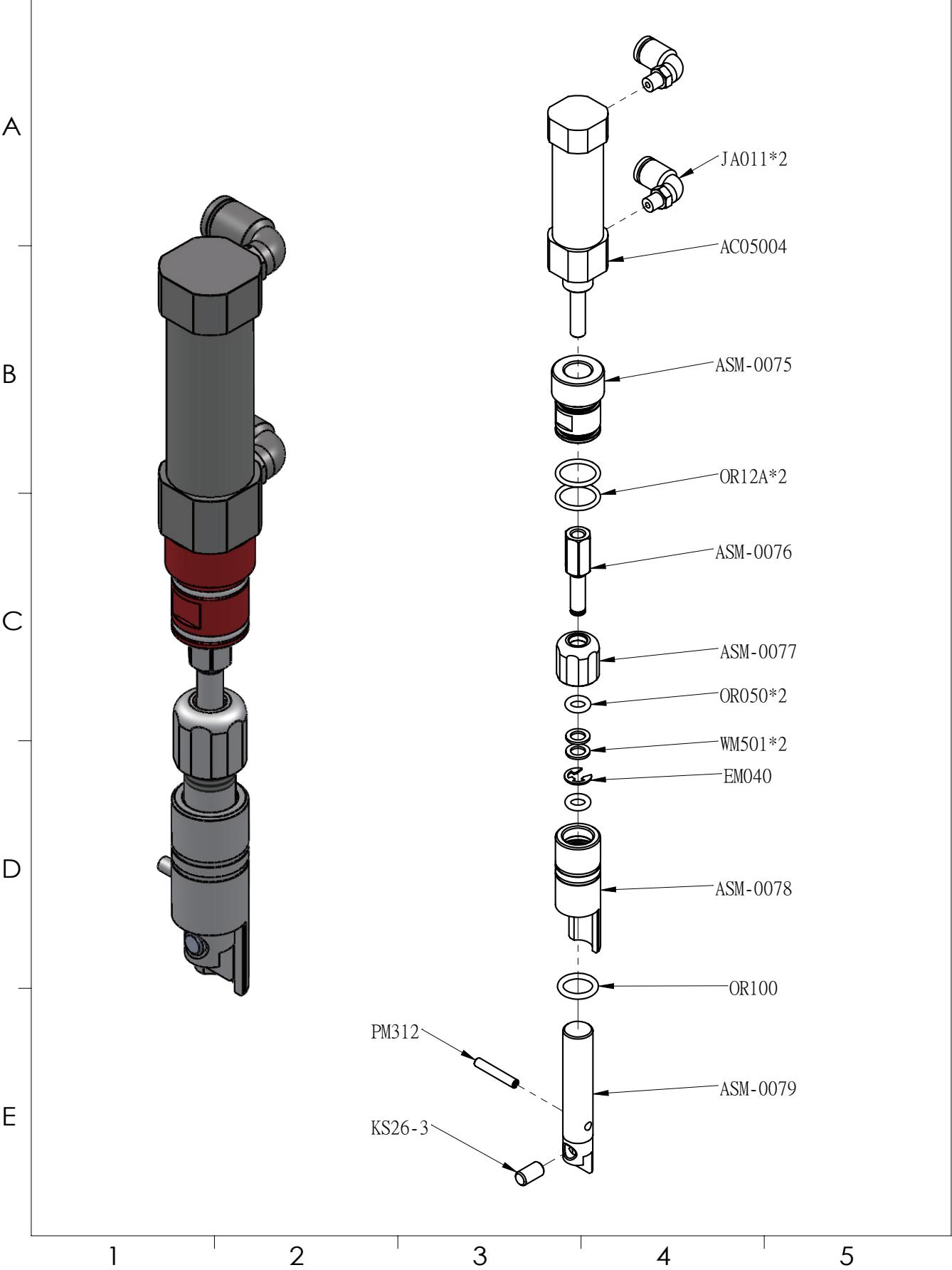
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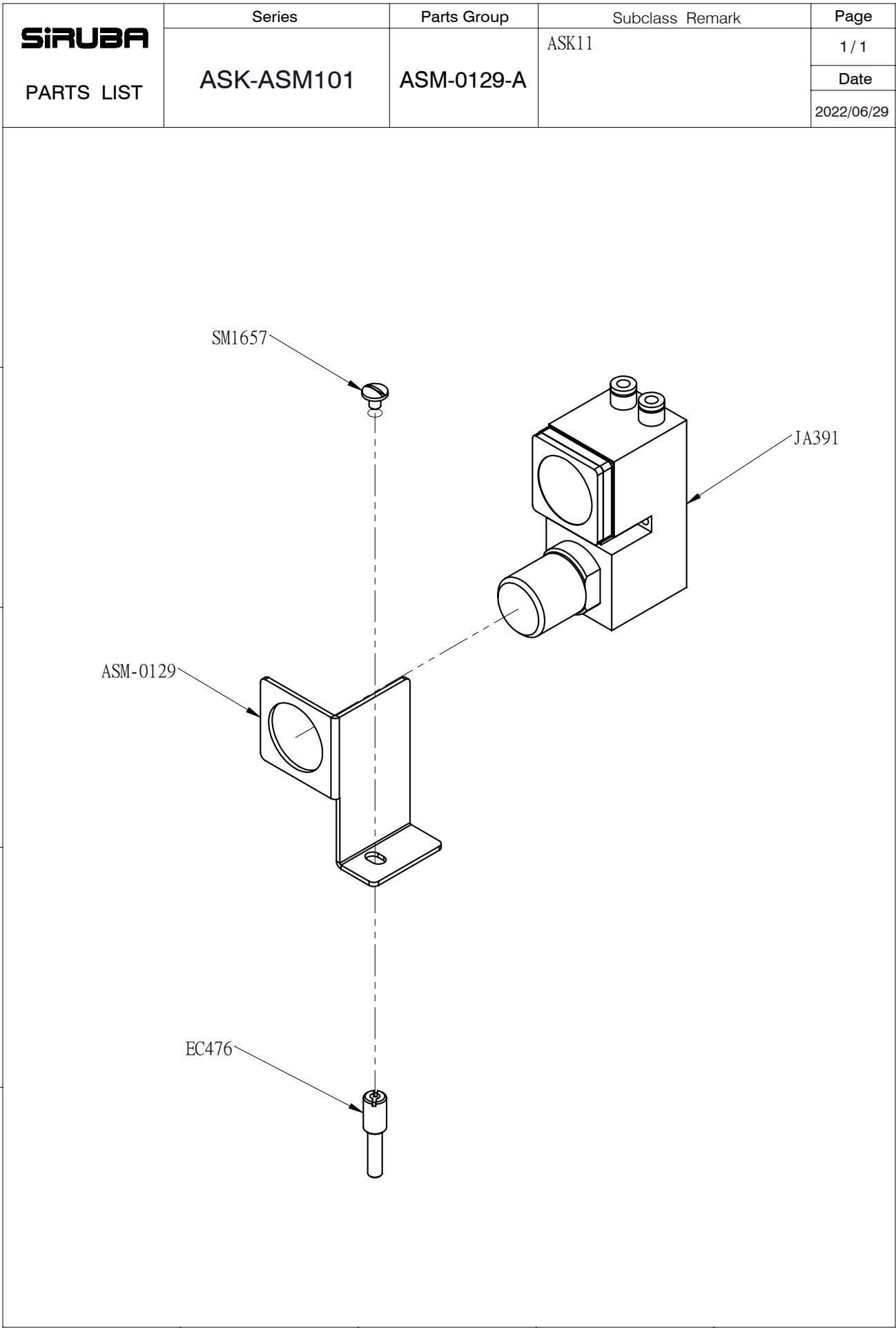
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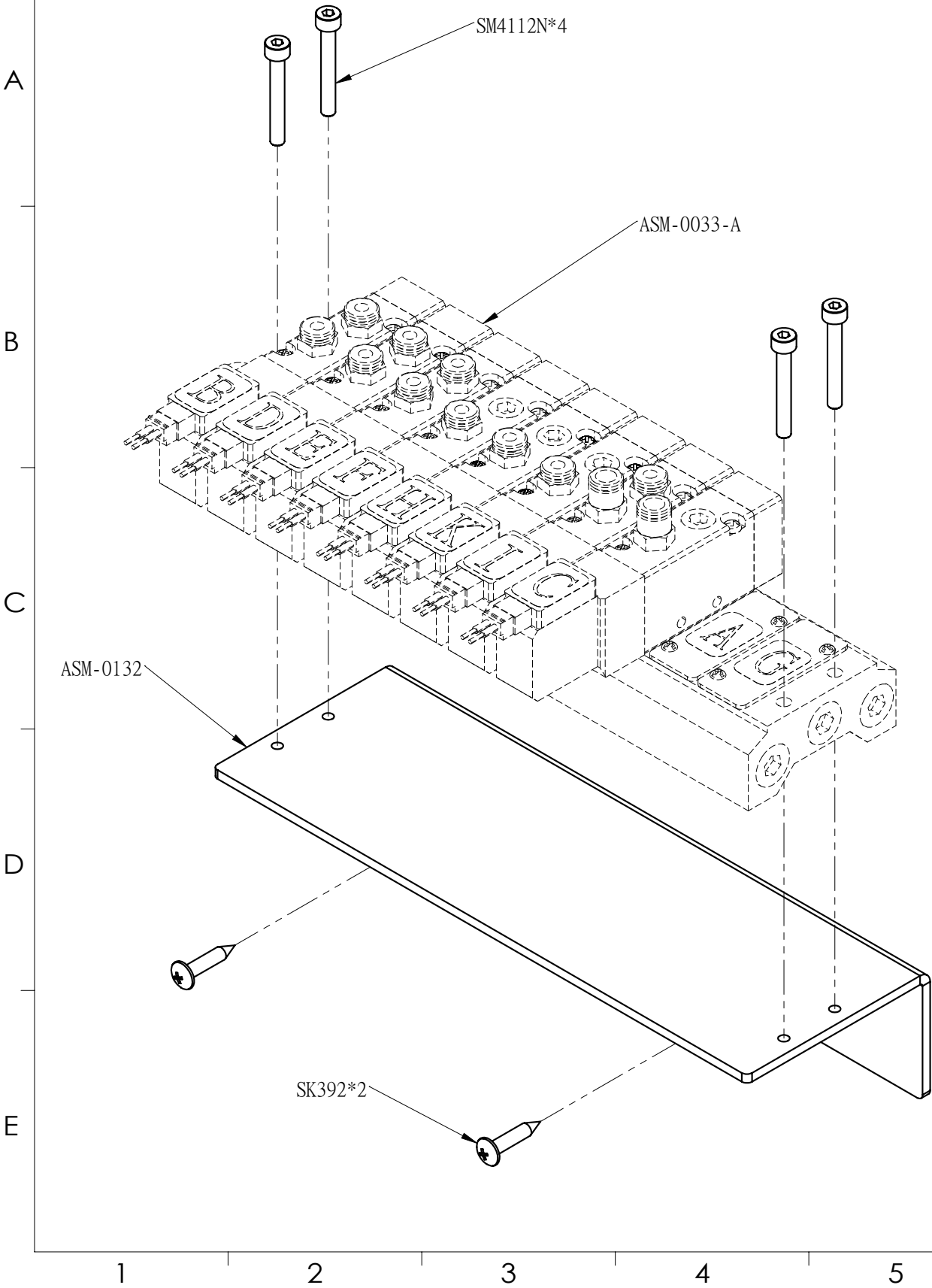


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				2022/06/29



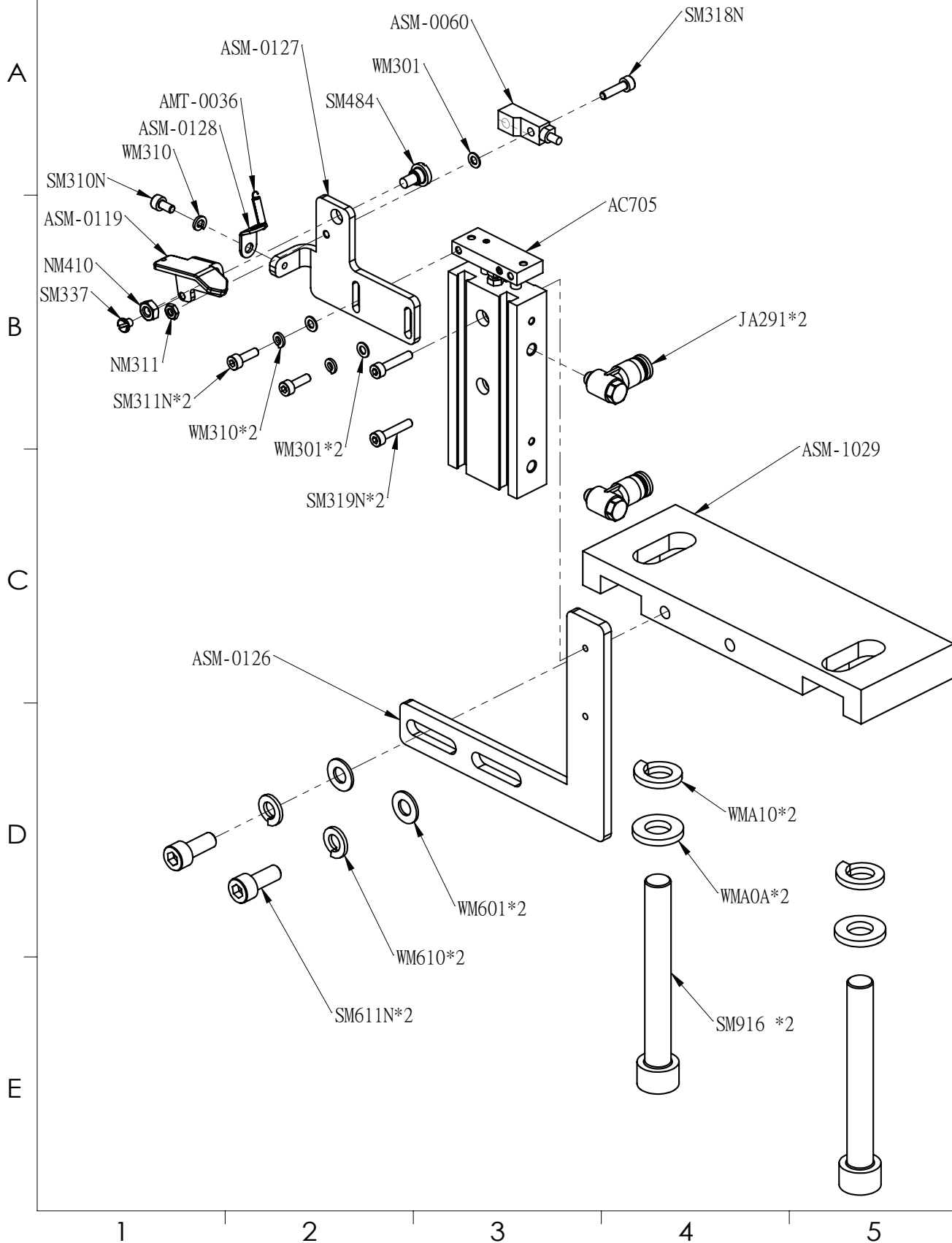


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	ASK-ASM101	ASM-0132-A	ASK11	1 / 1
				Date
				2022/06/29





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	ASK-ASM101	ASM-1101-A		1 / 10
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AC086\*2

JA291\*3

ASM-0124\*2

ASM-0125

ASM-0011

SM6803

ASM-1001

WM407\*6

WM410\*6

SM411N\*6

WM5000

SK265

ASM-1103

NM610N

ASM-1104

SM303

JA212

ASM-0116

ASM-0004

AC800

JA0401

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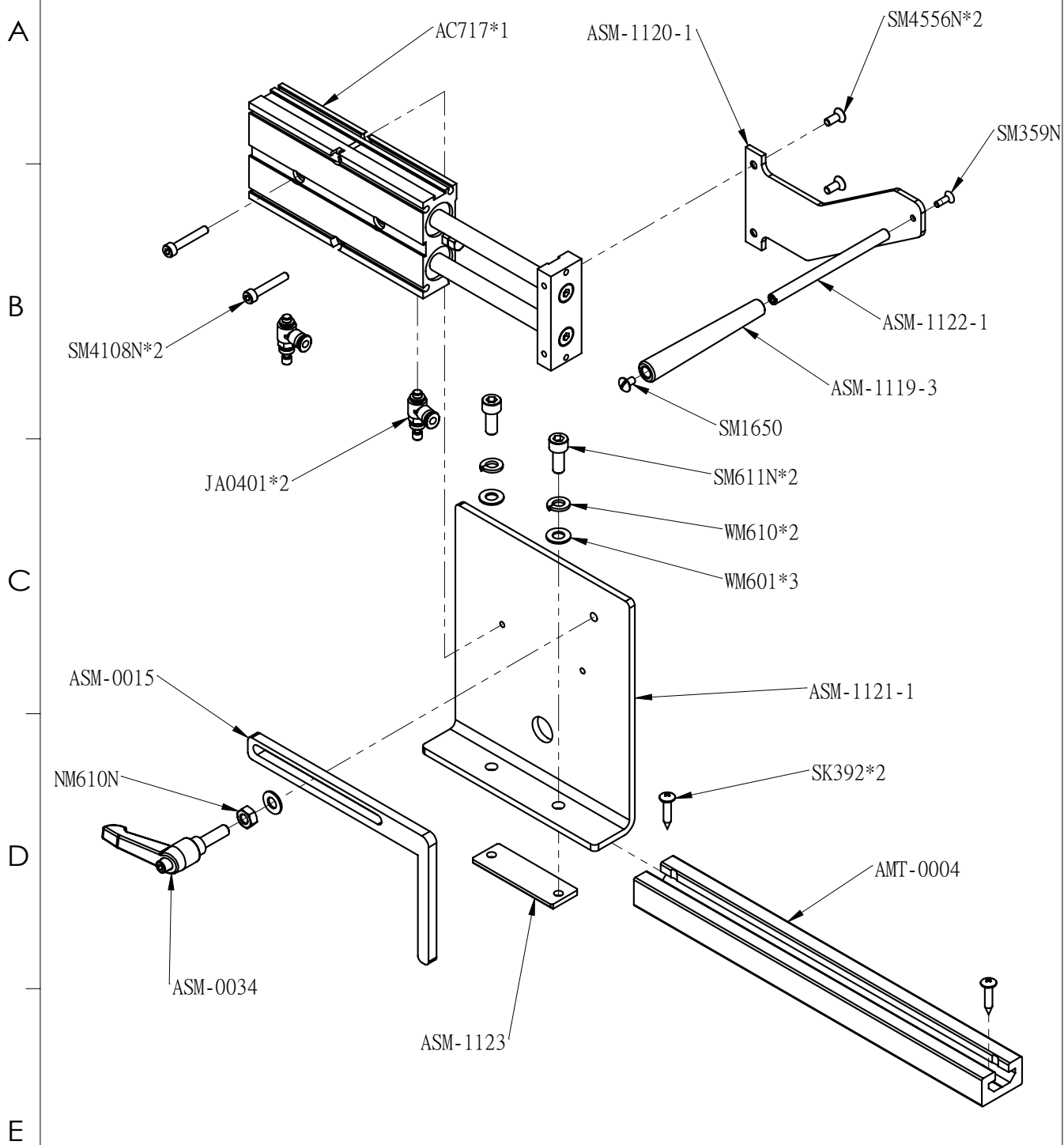
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<b>SIRUBA</b>  PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASK-ASM101	ASM-1121-A1	ASK11	3/10
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				2022/12/05



<b>SIRUBA</b>  PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASK-ASM101	ASM-2118-A2	ASK11	1 / 1
				Date
				2022/06/29

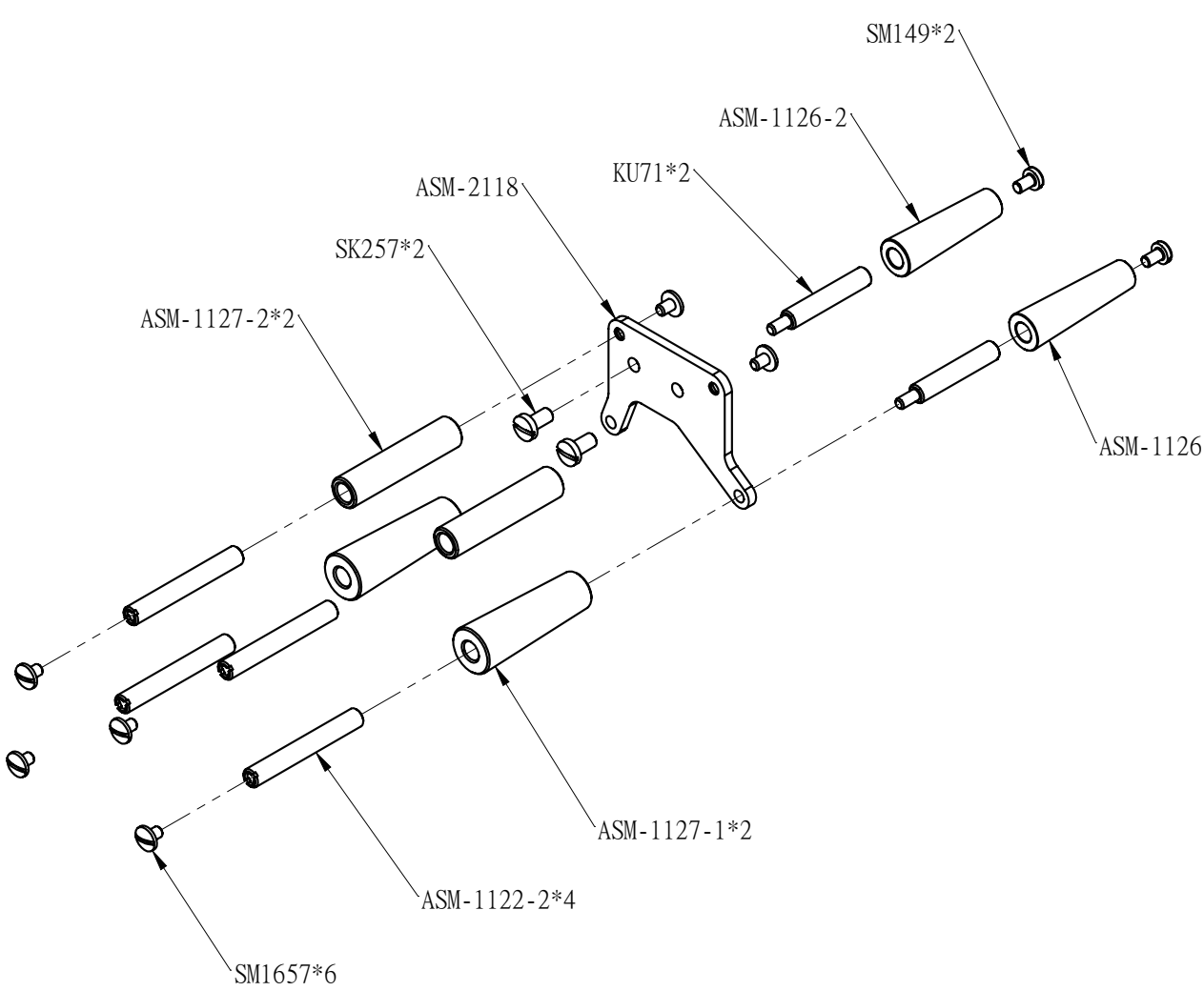
A

B

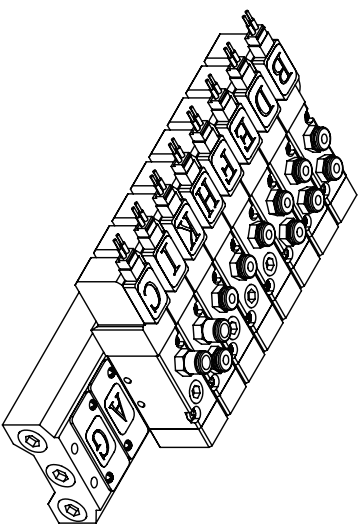
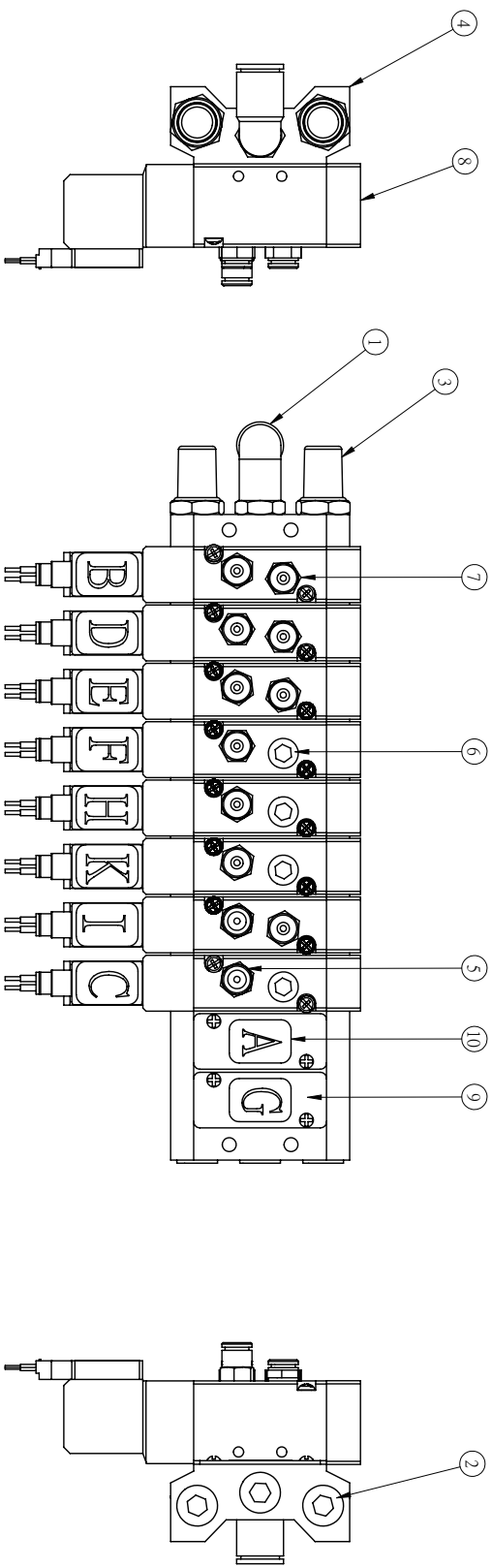
C

D

E

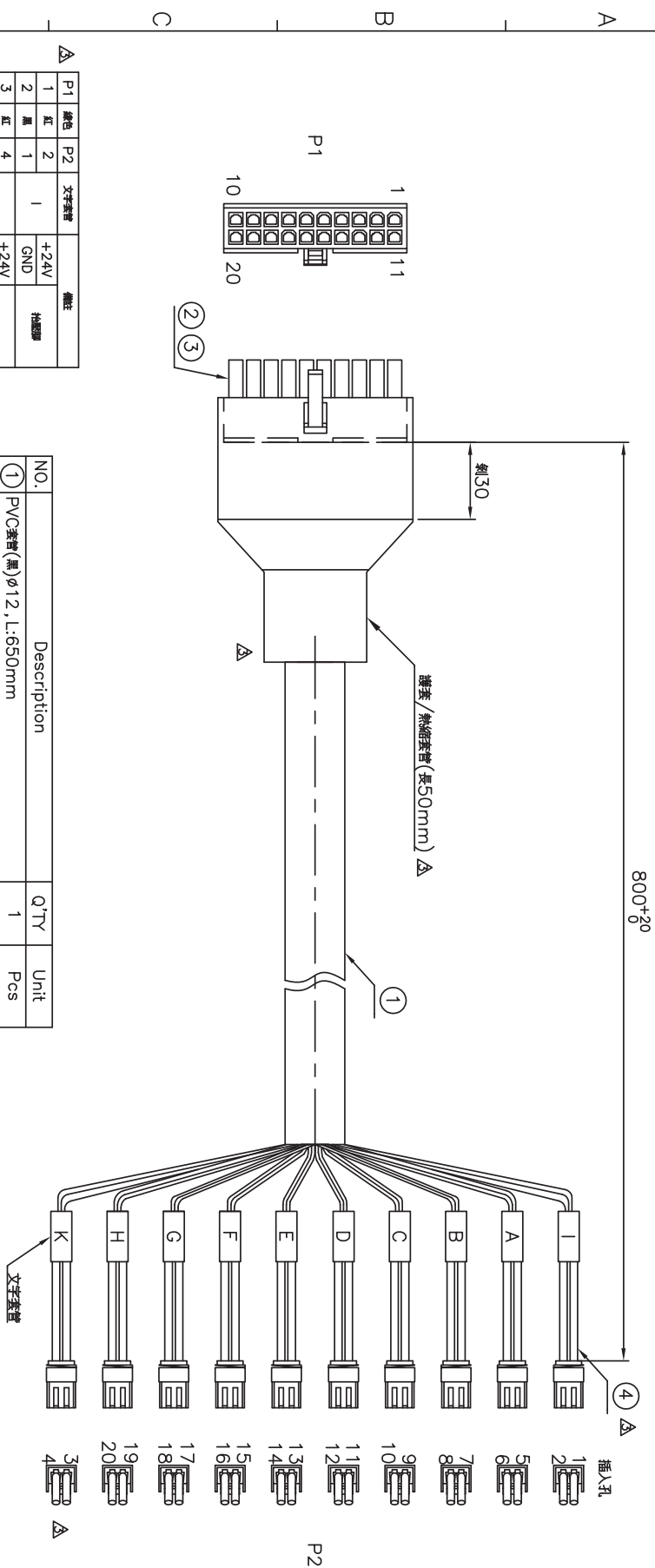


項次編號	零件名稱	數量
1	ASM-2118	1
2	ASM-1126-2	1
3	KU71	2
4	ASM-1127-1	2
5	ASM-1122-2	4
6	SM149	2
7	SM1657	6
8	ASM-1126	1
9	ASM-1127-2	2
10	SK257	2



市購品牌:CHELIC 氣立

高林關係企業									
熱處理：				軍改內容		中文品名			
硬 度：				No		電磁閥組			
硬面層深度：				No		Solenoid Comb.			
編號	零件名稱	數量	加工區分		表面處理：		第三角法		單位：mm
1	SOL8-02	1	尺寸區分	加工區分	切削加工	沖壓	鑄造	脫模	重量：1.5818
2	PT11/4"栓塞	3	0.5以上6以下	車、洗、鑽	加工	鍛造	脫模	重量：1.5818	比例：2:3
3	SL-02	2	6以上30以下	±0.1	±0.1	±0.2	±0.4	±0.2	日期
4	SK.5 M10	1	6以上120以下	±0.2	±0.3	±0.5	±0.5	±0.5	繪圖
5	MSDB6-01	2	30以上120以下	±0.3	±0.5	±0.7	±0.5	±0.5	校對
6	PT11/8"栓塞	4	120以上315以下	±0.5	±0.6	±1.0	±0.6	±0.6	覆核
7	MSDB4-01	10	315以上1000以下	±0.8	±1.1	±1.5	—	—	—
8	SK.5101 24VDC L	8	1000以上	±1.2	±1.8	—	—	核准	—
9	空格板	2	切削加工形狀・位置精度	◎	◎	公差付	1/4	△	角度公差：±2°
10	英文字母貼紙	10	表面粗度之範圍（Ra）	▽▽▽	0.2	▽▽▽	0.2-1.6	▽▽	2-6.3
註：成品符合歐規RoHS指令，實物實使用指令規範									



P1		P2		文字要素	備註
1	顏色	2		+24V	
3	黑	1	I	GND	柱頭部
2	紅	4		+24V	
4	白	3	K	GND	內部配氣
5	紅	6		+24V	
6	黑	5	A	GND	多通直通轉接 插頭/底座
7	紅	8		+24V	

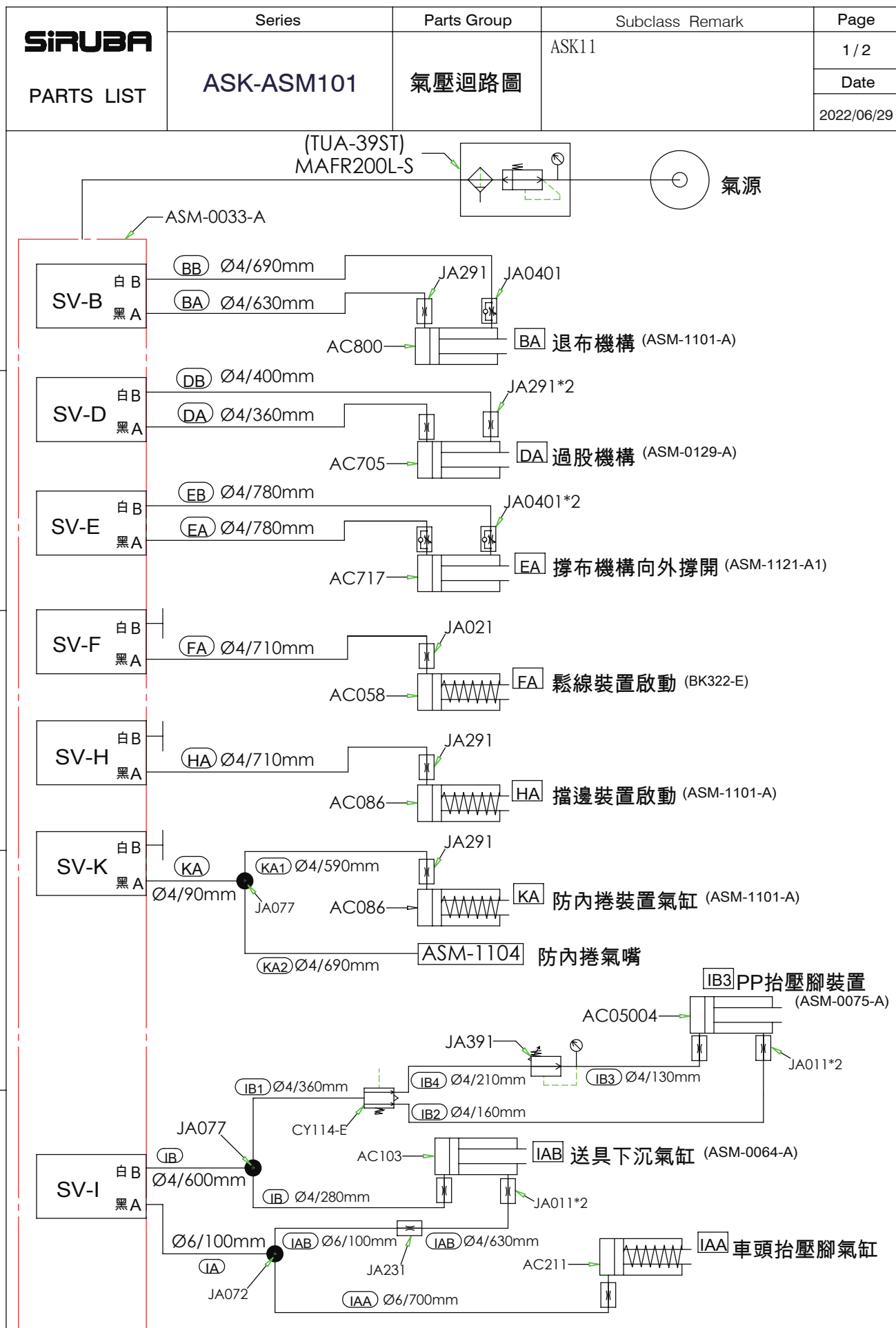
NO.	Description	Q'TY	Unit
①	PVC管(黒)φ12, L:650mm	1	Pcs
②	HOUSING:部品 H6657R1-20相同部品	1	Pcs
③	TERMINAL:部品 6657TP相同部品	20	Pcs
④	CABLE:UL1007 22AWG	20	Pcs

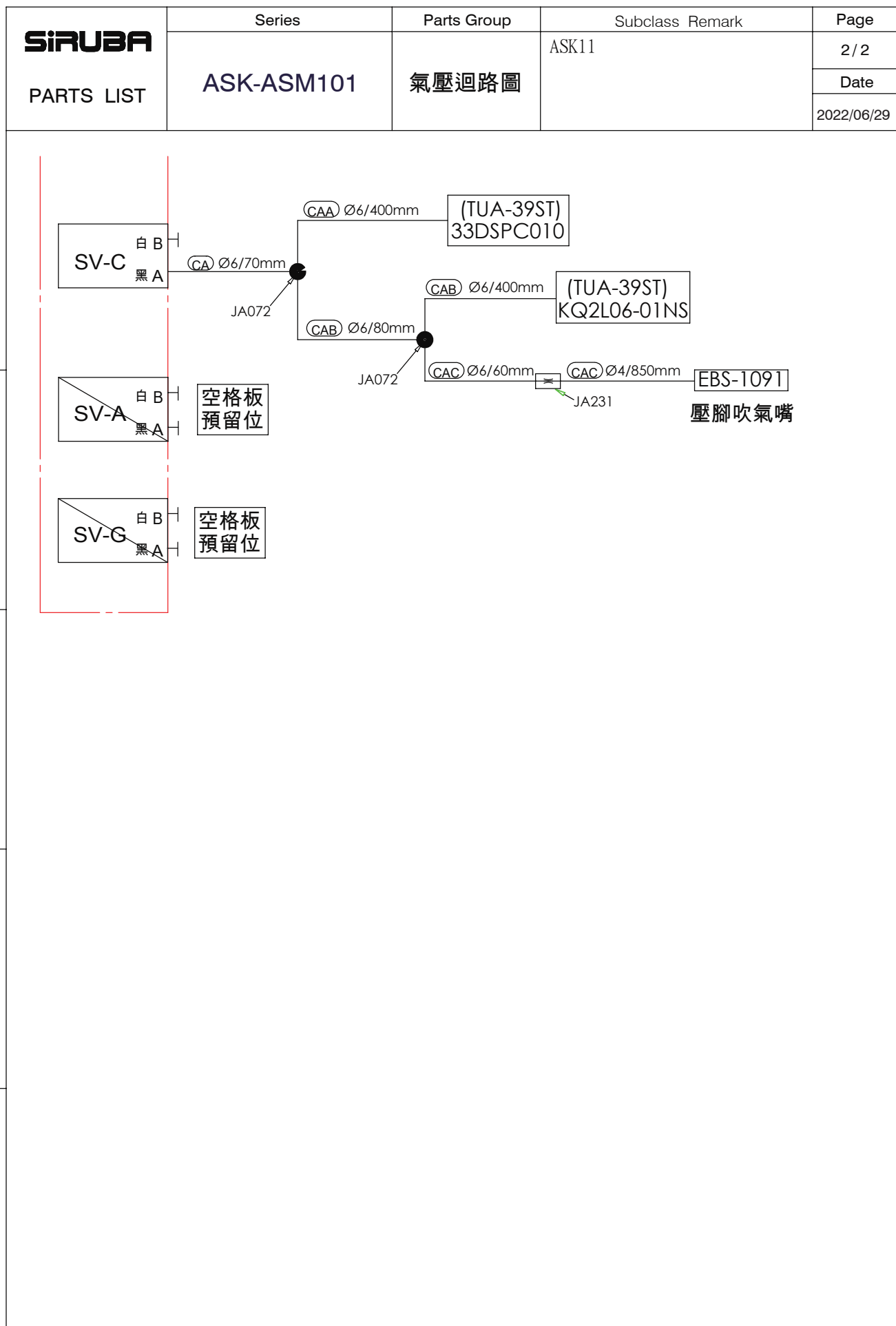
廠商	台灣氣立
廠商型號	NO
描述一	NO
描述二	NO

[illegible]

表 E109	1
	2
	3
	4
	5
	6
	7
	8
	9
	10









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.  
ASK-ASM101.DEC.2022