

SIRUBA

電控參數說明書

ELECTRONIC CONTROL PARAMETER MANUAL

■ ASL-APO100



1. 开机

1)打开“电源开关”→ 打开“风机开关”（使用气压为 0.5-0.6 Mpa）→ 屏幕开启并进入主页面 →点击“复位”键 → 机器成功开机。





2) 把裁片按要求平铺在工作台上，在主页右侧的款式菜单栏里选择需要的款式（例如：01）。踩一下脚踏板，机器自动车缝和收料。





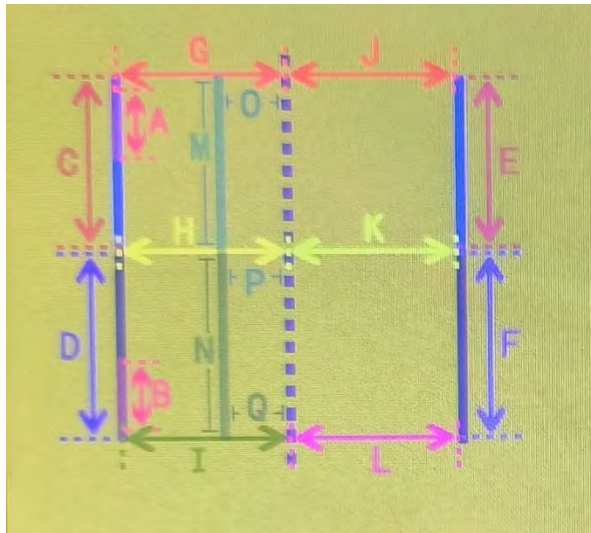


2. 两款模式设置

1) 平行线模式

在主页面右侧的款式菜单栏选择需要的款式 01，你可以在小窗口看到款式的图形展示。点击“修改”键进入参数设置页面，并且根据实际需要调整参数设置。





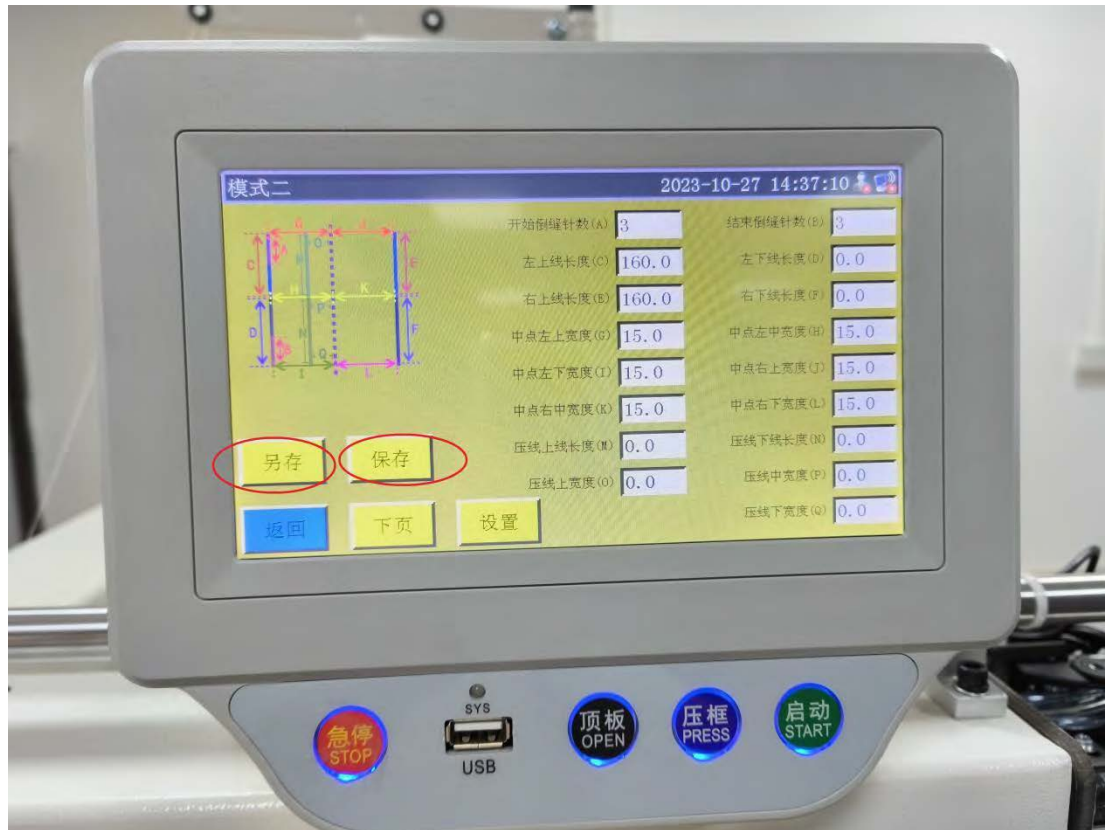
- (A) 开始倒缝针数
- (B) 结束倒缝针数
- (C) 左上线长度
- (D) 左下线长度
- (E) 右上线长度
- (F) 右下线长度
- (G) 中点左上宽度
- (H) 中点左中宽度
- (I) 中点左下宽度

- (J) 中点右上宽度
- (K) 中点右中宽度
- (L) 中点右下宽度
- (M) 压线上线长度
- (N) 压线下线长度
- (O) 压线上宽度
- (P) 压线中宽度
- (Q) 压线下宽度

点击“下页”键进入下页设置参数，并且点击“返回”键返回。



设置修改完成后，请点击“保存”键保存设置或另存为新的款式档案。点击“返回”键返回到主页，点击“复位”键让机器复位。



2) 曲线模式

在主页面右侧的款式菜单栏选择需要的款式 **03**，你可以在小窗口看到款式的图形展示。点击“**修改**”键进入参数设置页面，并且根据实际需要调整参数设置。





点击“下页”键进入下页设置参数，并且点击“返回”键返回。



设置修改完成后，请点击“保存”键保存设置或另存为新的款式档案。点击“返回”键返回到主页，点击“复位”键让机器复位。



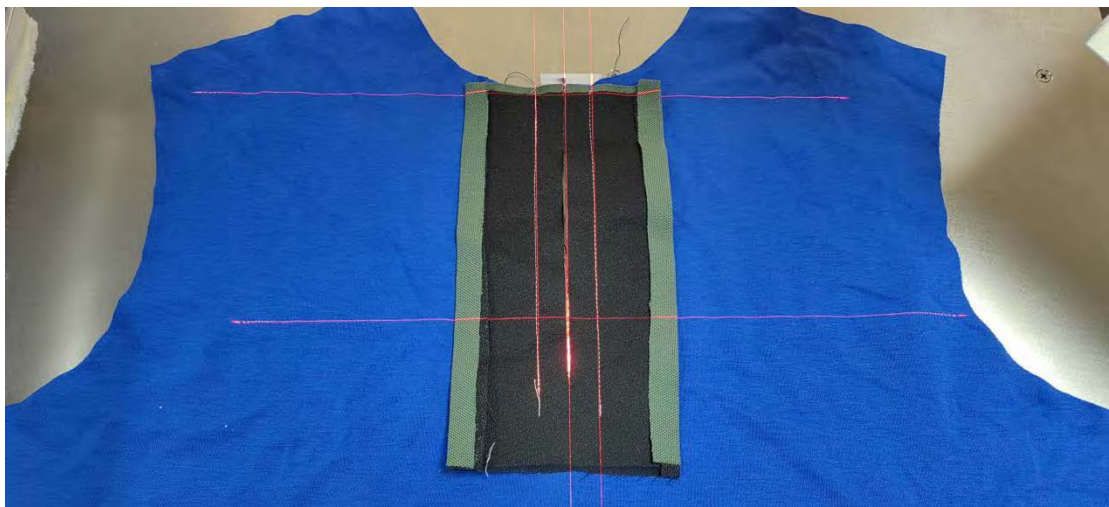
3. 优势功能

1) 送料功能：采用自动送料方式，增加定位精准度和提升效率。



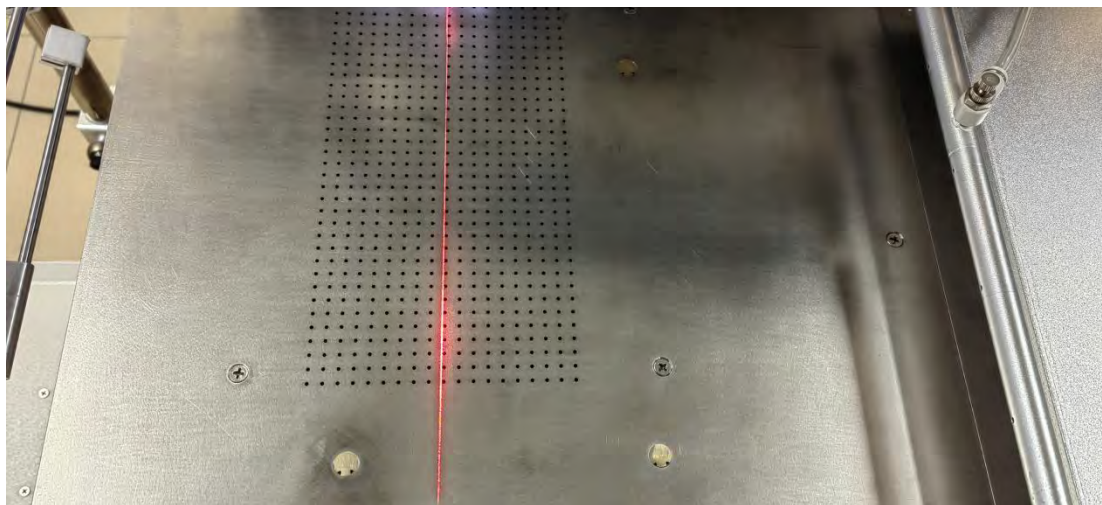
2) 激光定位功能：

铺布及车缝环节均配备有激光定位功能，增加车缝的精准度。

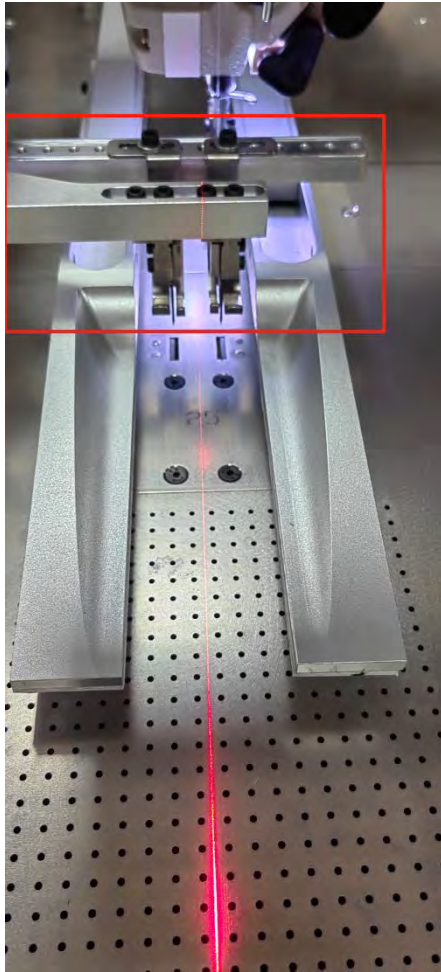


3) 吸风功能:

配备大马力风机，吸风功能有效防止布料上下错层。



- 4) 护切刀功能：
能有效阻止布料在切布时走位。

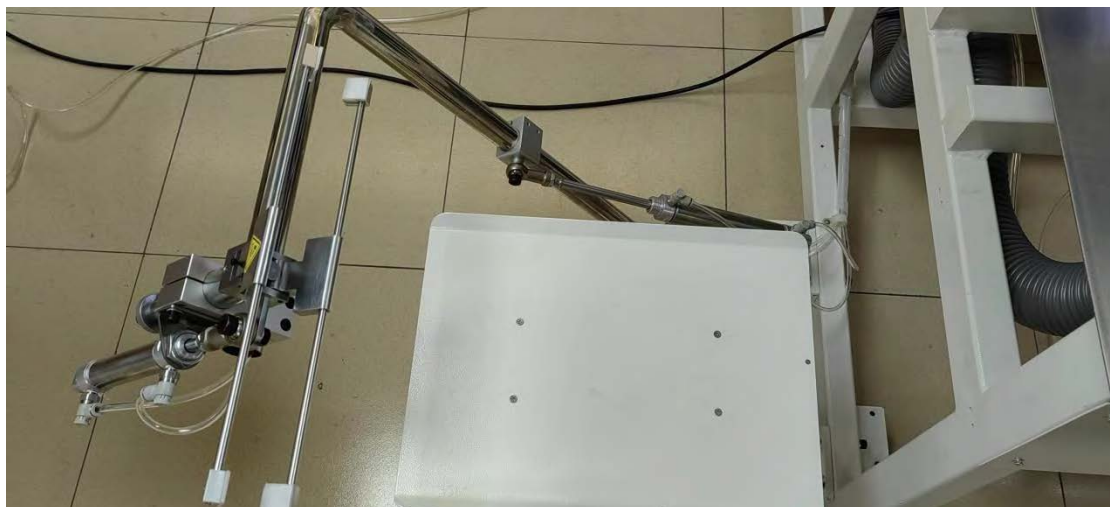


- 5) 压板扩张功能：
丝杠电机自动调节压板尺寸，且具有布压板扩张功能，让车缝更顺畅



6) 自动收料功能:

采用自动收料方式, 有效降低工人的劳动强度, 提升效率。



7) 门襟缝制种类:

机器适合多种门襟缝制

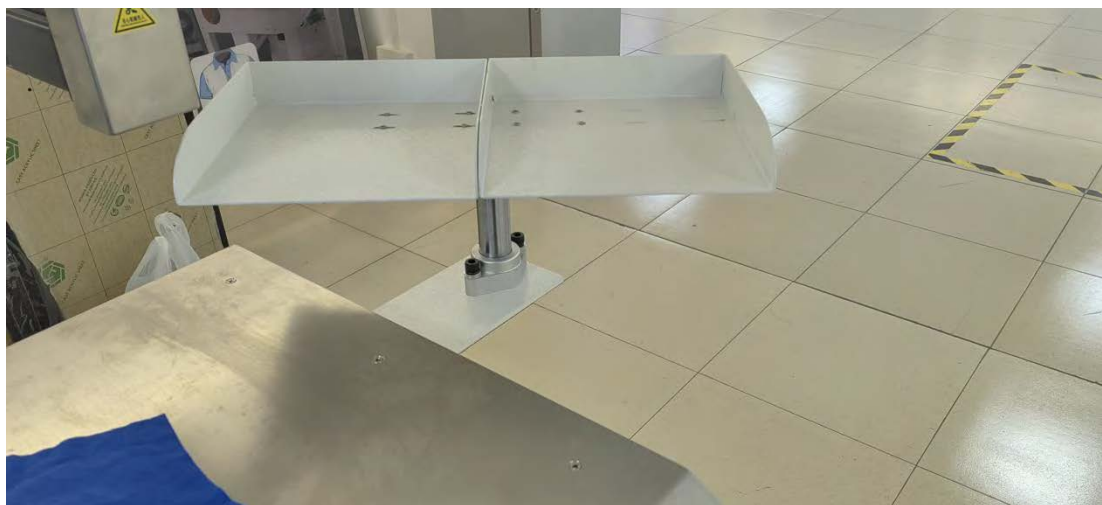


4. 需要安装的配件

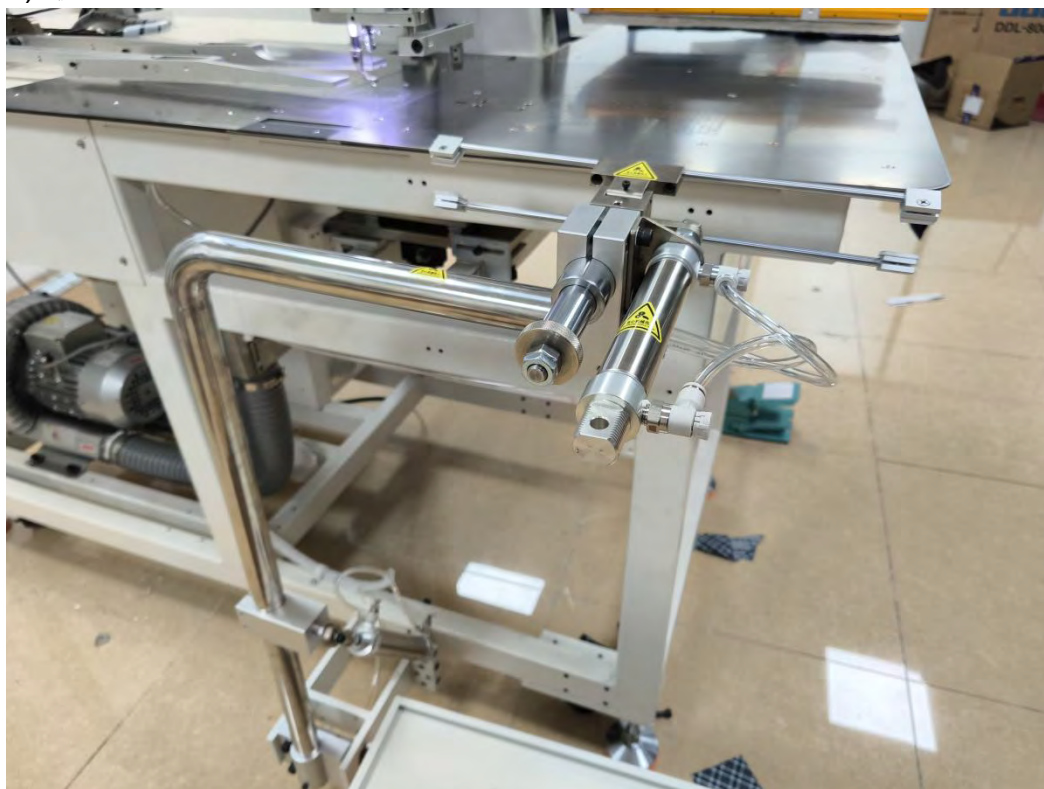
1) 脚踏



2) 裁片置物架

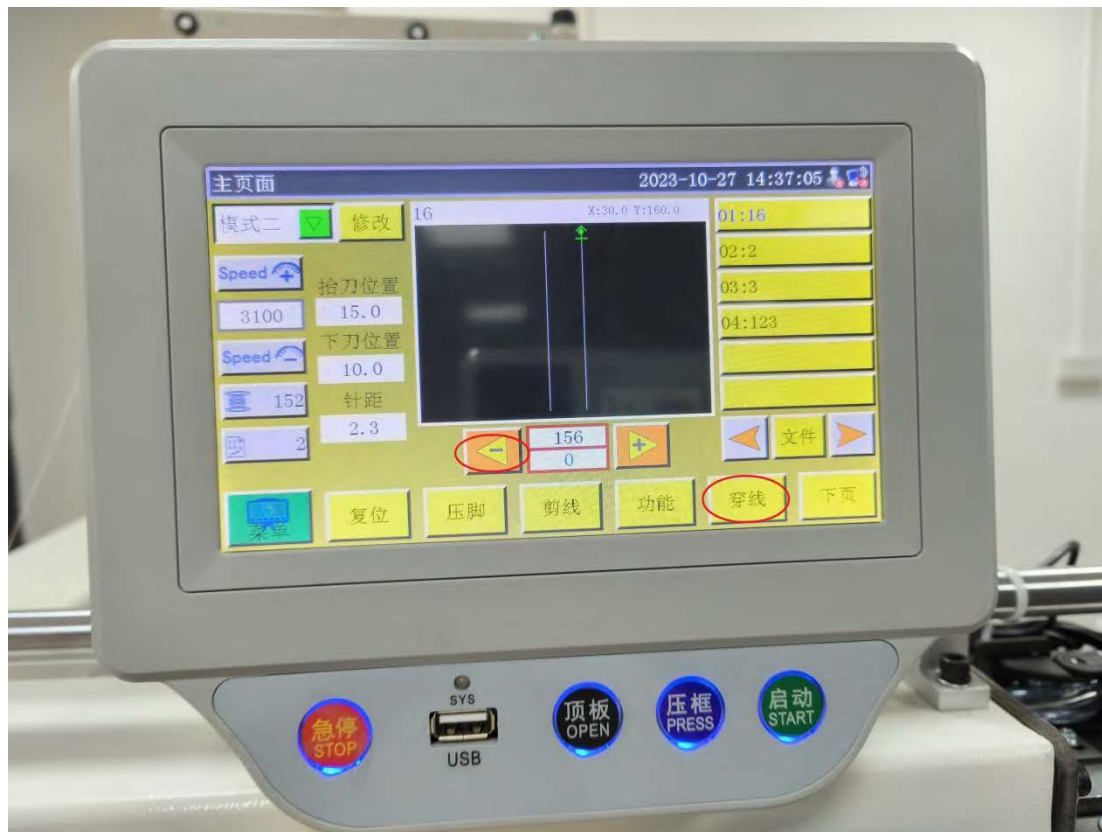


3) 收料装置

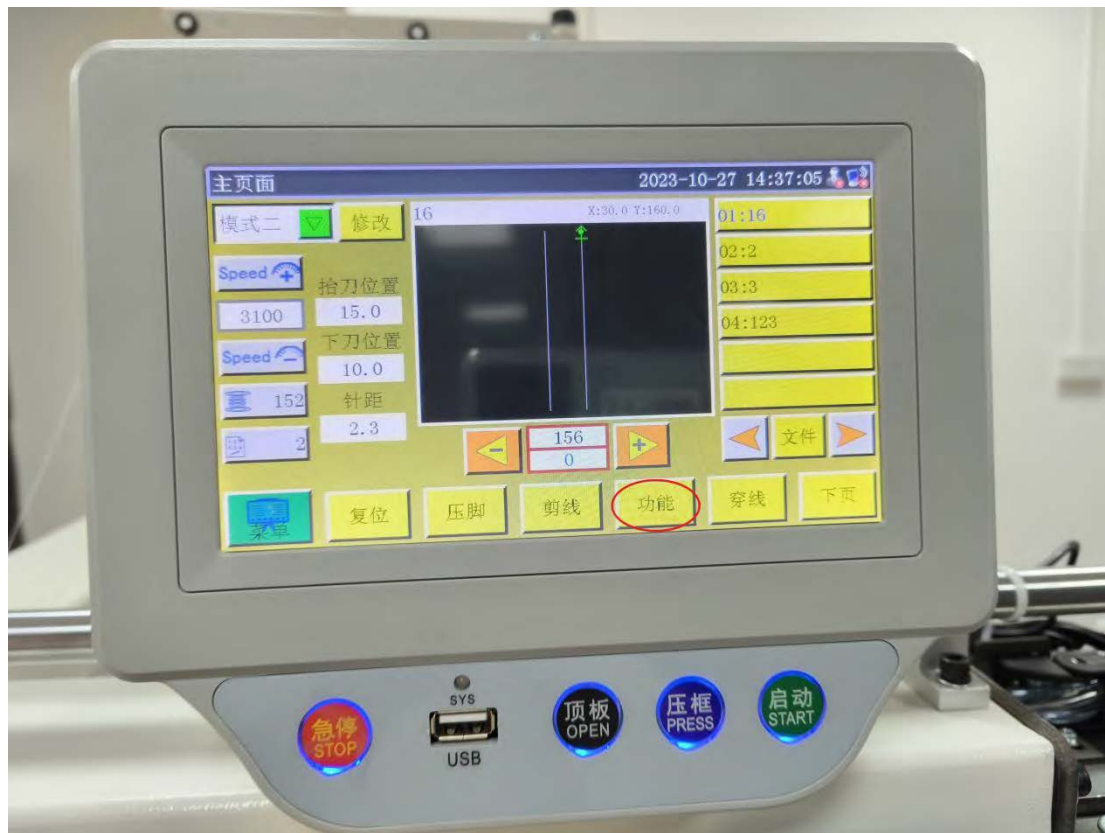


5. 其它设置

1) 当机器由于断线停机，请点击主页下方的“穿线”键，穿线孔会升起方便穿线，穿线完毕后，根据屏幕的提示操作。

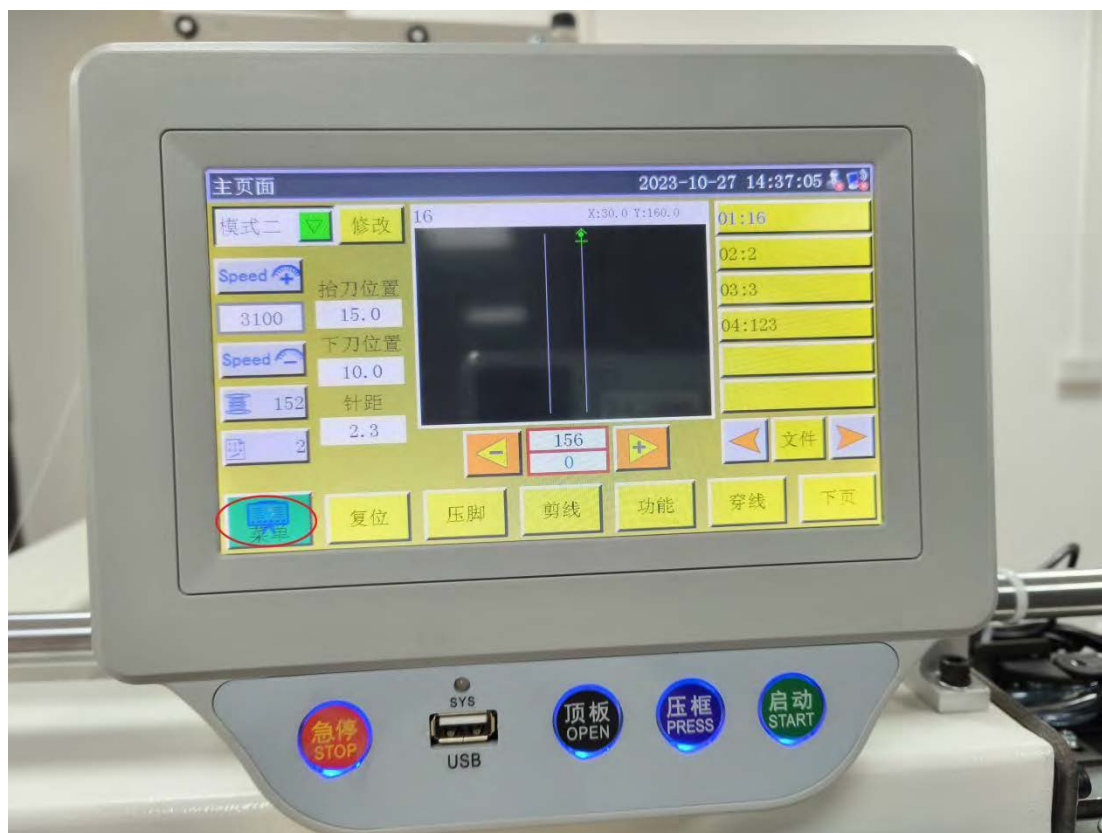


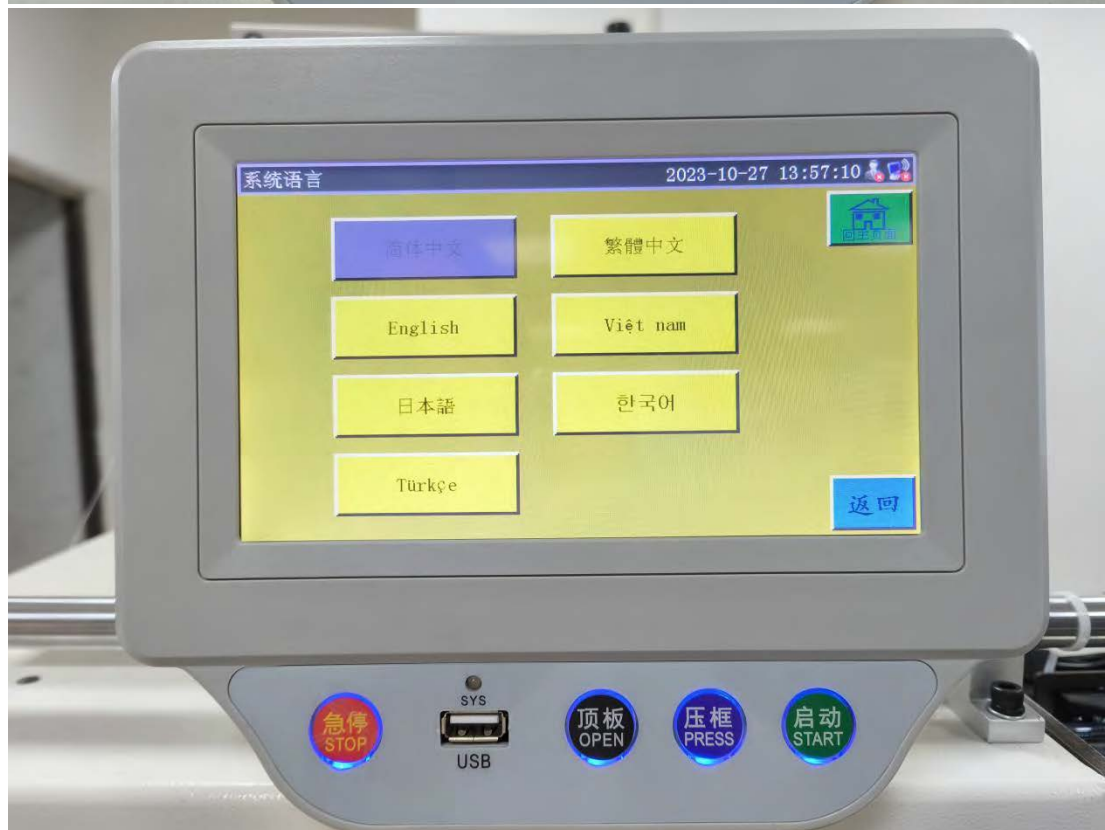
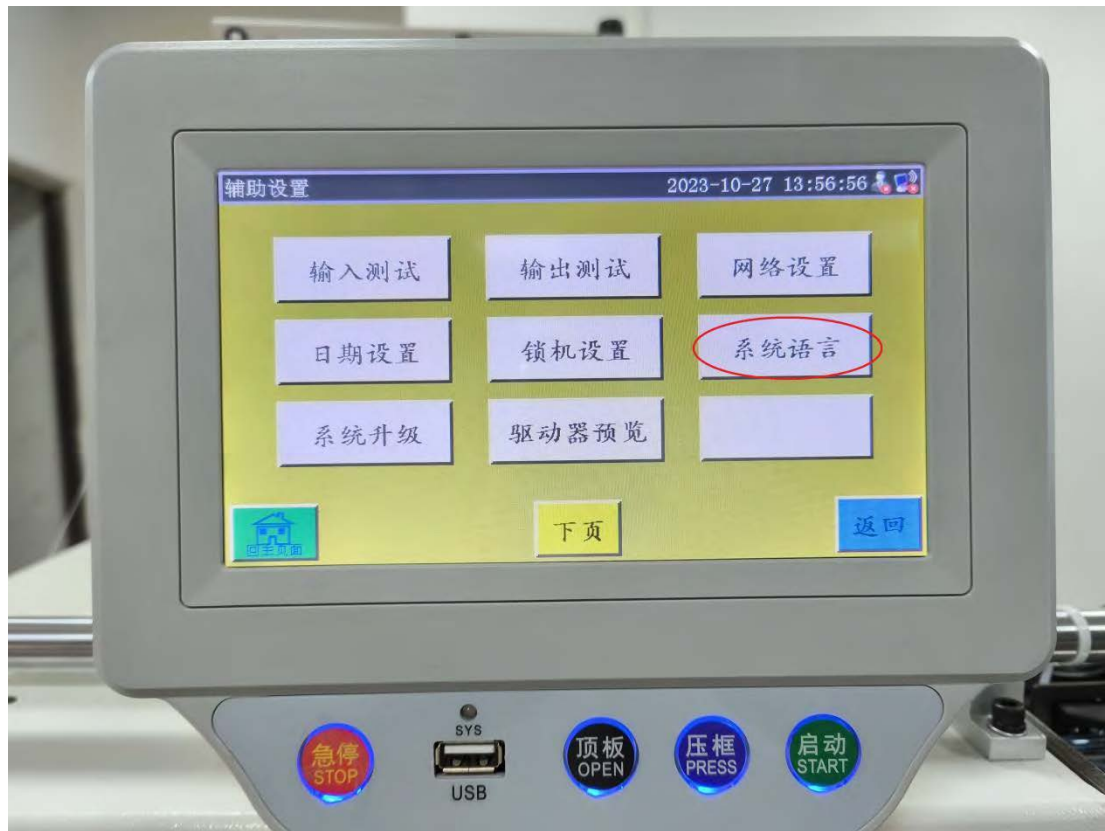
2) 收料装置可以根据实际需要关闭或打开。在主页面点击“功能”键，进入设置页选择打开或关闭收料开关，点击“保存”保存设置并返回主页面。



3)系统语言设置

点击主页面的“菜单”键，进入设置页面，选择“辅助设置”，进入辅助设置页面，选择“系统语言”，选择您所需要的语言并保存。





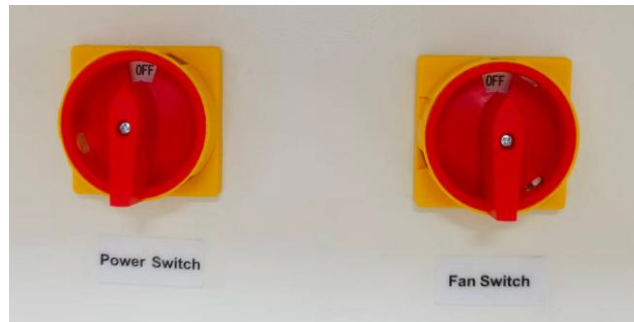
Automatic Polo Placket Setter Machine

ASL-APO100

Operation Instructions

1. Start the machine

- 1) Turn on the “**Power switch**” and “**Fan switch**” (for air suction function. The air pressure is set to 0.5-0.6 Mpa) → The monitor will be turned on simultaneously and enter the Home page interface.



Ensure the air go into the automatic sewing machine is clean and dry.

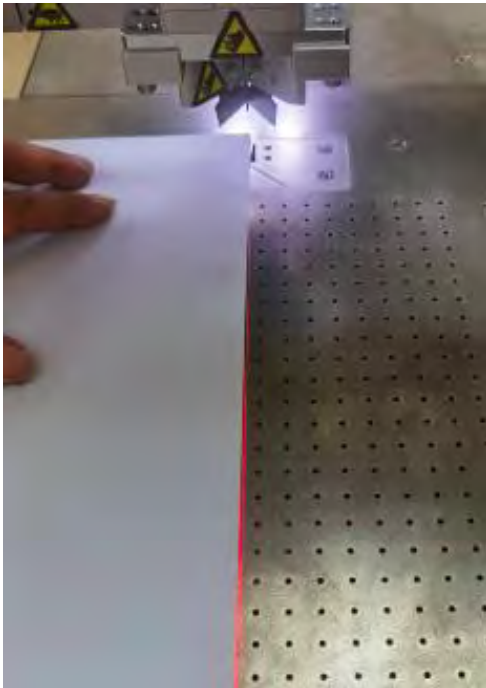
If the air come with water, it'll damage the machine seriously !!! Check from the glass tan, you can see if the air with water or not.

- 2) Before production, click “Reset” every time when the machine is turned on or any data in the control system was changed. Please refer to video “1. How to start the machine.mp4”.



2. Machine debug

- 1) Infrared position. Adjusted the sewing area (left side) infrared position first. Make sure the red line is in the center of cutter. Set up this as basic position to adjust the right-side infrared later.



- 2) Adjusted the right-side infrared position. Please refer to the video “2. How to adjust the right side infrared light.mp4”.
- 3) Adjusted the collecting jig position. Make sure the clamp can slightly hold the table edge parallelly.



- 4) Check the distance between feeding plate and two big pressing plates is around 1cm. Please refer to video “3. How to adjust the feeding plate position.mp4”



3. Start the production

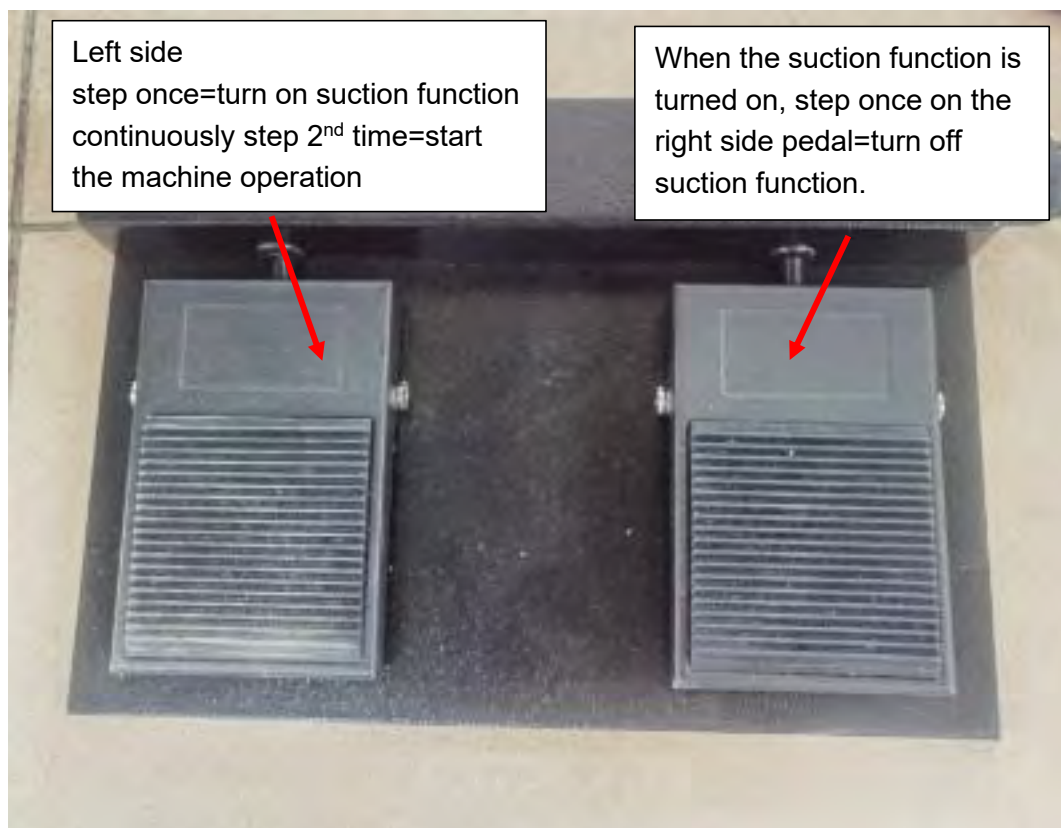
- 1) Click “Reset” on the Home Page.
- 2) Lay on the cutting piece on the working table with suction holes area.

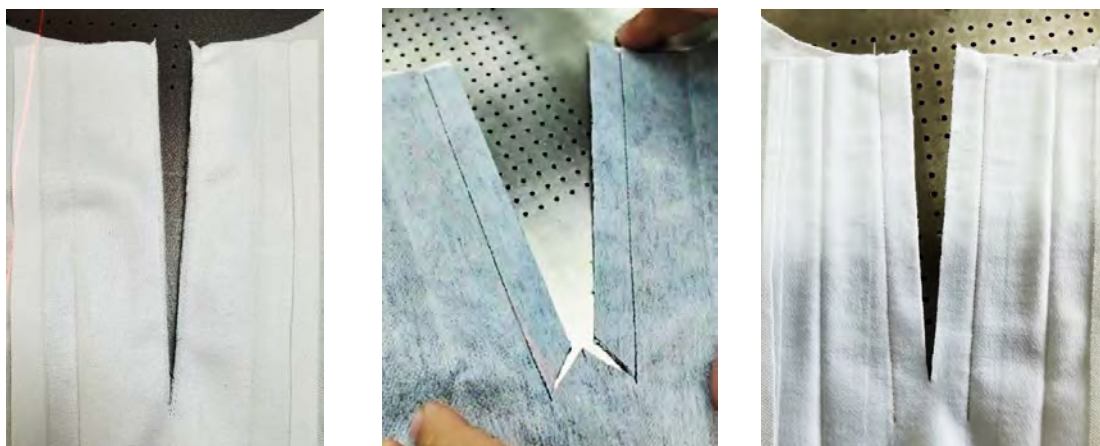


- 3) Select the style you need from the control system, which is on the right top of the Home Page.



- 4) Step once on the left pedal, start suction function. Continuously step 2nd time on the left pedal, start the operation. The machine will automatically finish sewing, cutting and collecting. Step once on the right pedal (cancel suction function).





(sewing results)

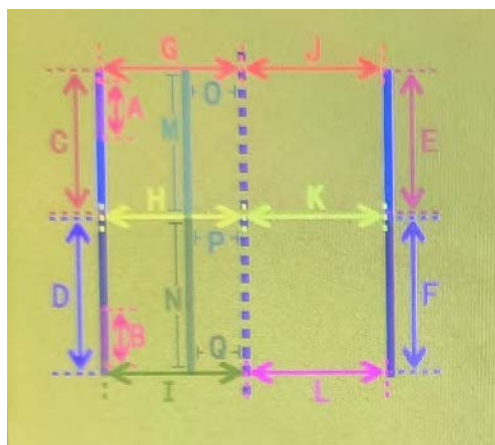
4. Sewing patterns switch. Please refer to video “5. How to modify and create new pattern.mp4”.

Operation: Select the pattern from the menu list (01, 02, 03) on the right top of the Home Page. You can check the style display on the small window. Click “Modify”, then adjust the preset parameters according to the actual requirements.





(adjust the preset parameters according to the actual requirements)



- | | |
|------------------------|-------------------------|
| (A) Start back | (J) Middle-left upper |
| (B) End back | (K) Middle-right middle |
| (C) Upper left length | (L) Middle-right lower |
| (D) Lower left length | (M) Upper line length |
| (E) Upper right length | (N) Lower line length |
| (F) Lower right length | (O) Upper line width |
| (G) Middle-left upper | (P) Middle line width |
| (H) Middle-left middle | (Q) Lower line width |
| (I) Middle-left lower | |

Click **“Next”** to the next page. Revised the parameters accordingly, then click **“Return”**.

Mode2 2023-10-27 14:31:08

Start back(A)	3	End back(B)	3
Upper left length(C)	160.0	Lower left length(D)	0.0
Upper right length(E)	160.0	Lower right length(F)	0.0
Middle-left upper(G)	15.0	Middle-left middle(H)	15.0
Middle-left lower(I)	15.0	Middle-right upper(J)	15.0
Middle-right middle(K)	15.0	Middle-right lower(L)	15.0
Upper line length(M)	0.0	Lower line length(N)	0.0
Upper line width(O)	0.0	Middle line width(P)	0.0
		Lower line width(Q)	0.0

Save as Save

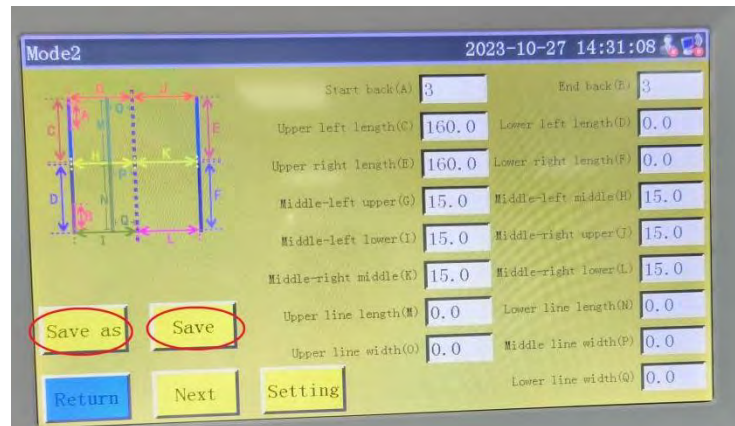
Return **Next** Setting

Mode2 2023-10-27 14:31:17

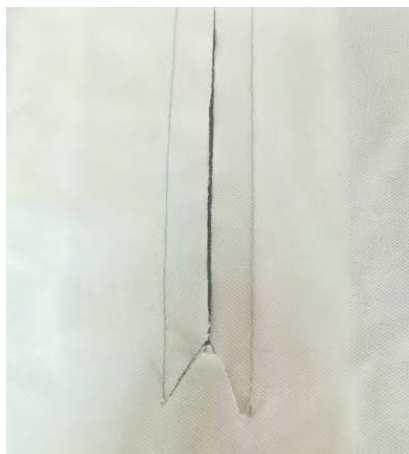
Lift up cutter	15.0	Put down cutter	10.0
Left foot height	0.0	Right foot height	0.0
Bottom foot height	0.0	Draw foot tension	2.0
Foot distance	380.0	Shrink number	0
Bottom stitches	0	Shrink step	0.0
Step	2.3	Needle distance	0.0
Press line delay(ms)	100	Start mode	Right ☒
Press line enable	Close ☒	Sewing bottom	No ☒
Cutting switch	Open ☒	Sewing top	No ☒

Return

After modifying the settings, click **“Save”** to save the data, or click **“Save as”** to create a new pattern. Click **“Return”**, go back to the Home Page. Click **“Reset”** to ready the machine.



The sewing results.

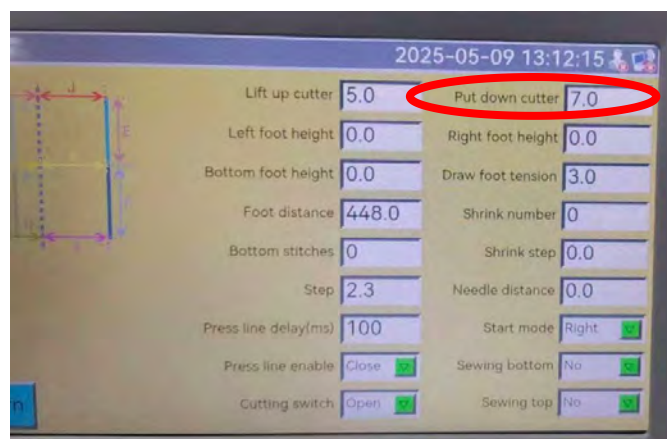
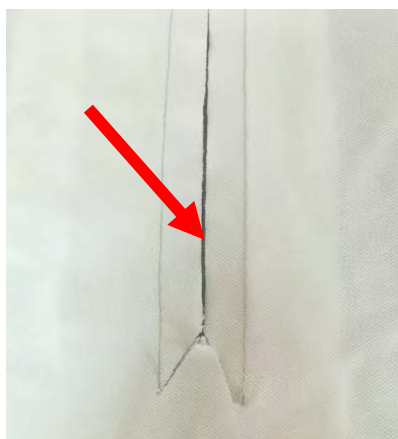


(parallel lines)



(V lines)

If you want to adjust the central knife cutting position, revise the figure in “Put down cutter”.

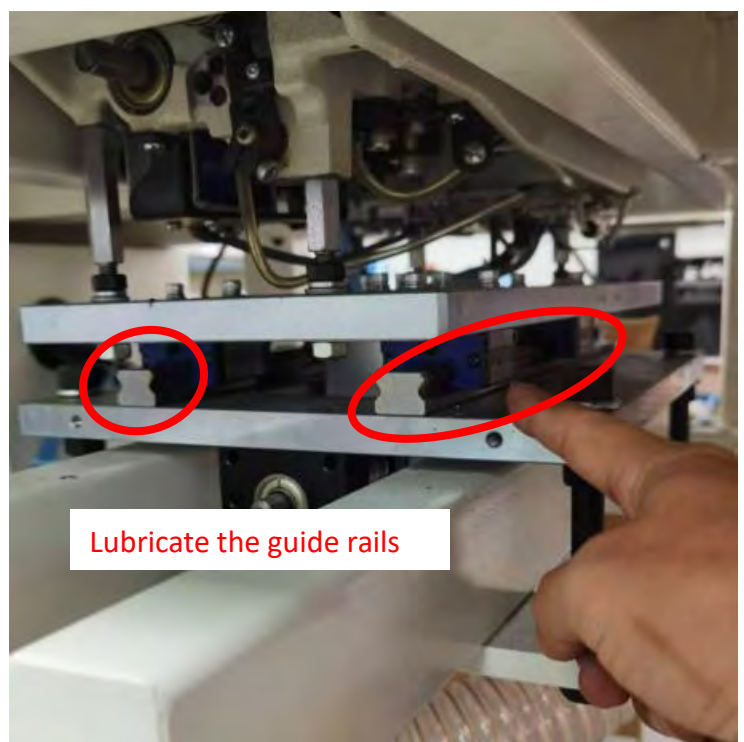
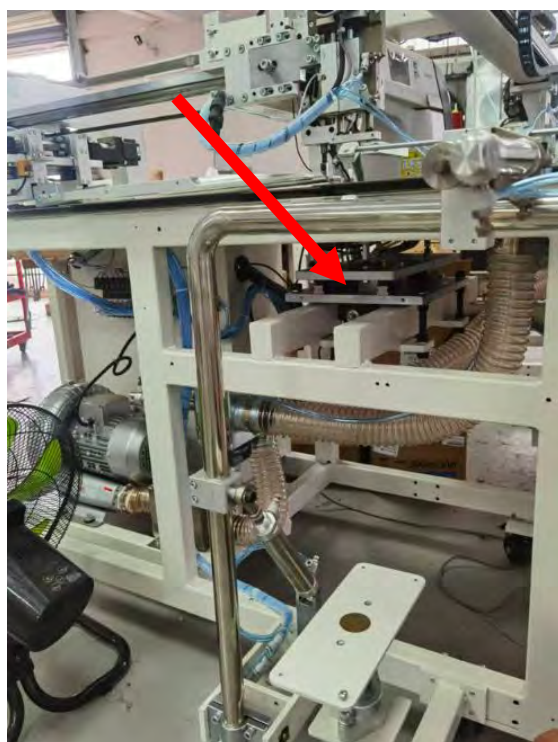


5. It's important to set the auto counting function. (When the machine matched with bobbin thread breakage detection function, this function is optional and up to your application requirement.)

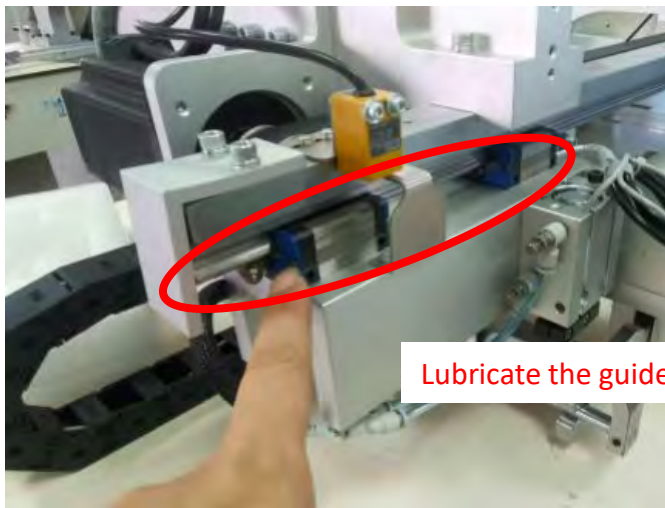
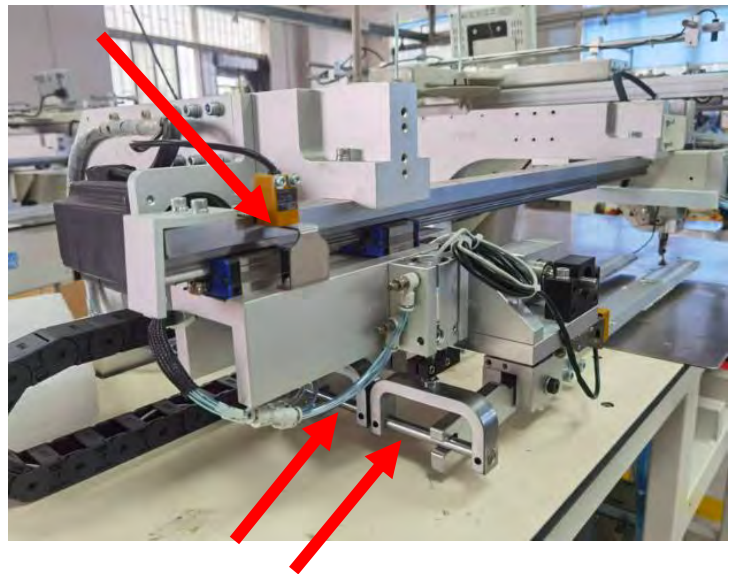
- 1) Once you set up the auto counting function, the machine will stop automatically when reach the "Total length of the bobbin thread".
- 2) Operation: please refer to video "6. How to set the auto counting function.mp4".

6. Maintenance.

- 1) Lubricated the machine every half year or according to your actual usage.
Please add grease on the area shown in **red circles** as below.



Lubricate the guide rails



Lubricate the guide rails



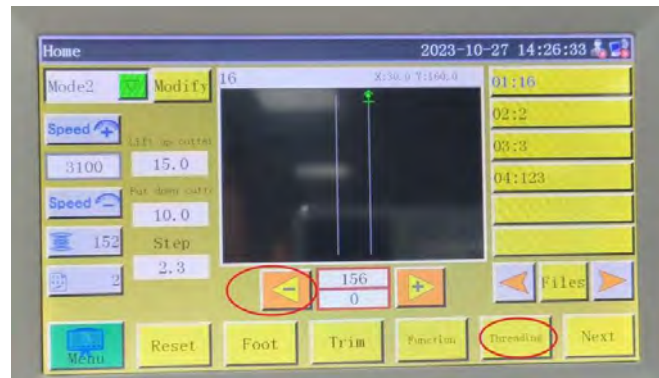
2) Open and clean the filter inside every week.



7. FAQ

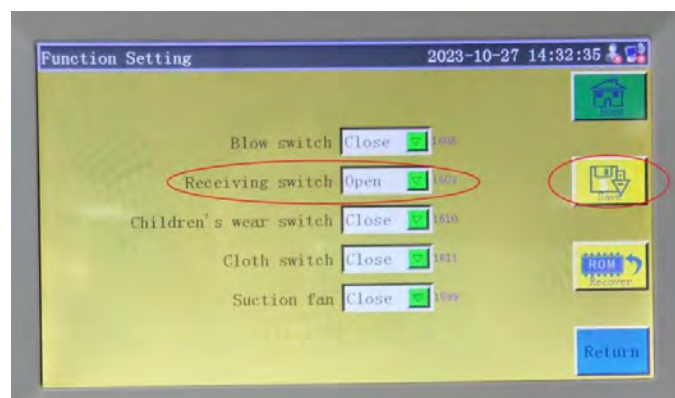
1) How to do when the machine was stopped due to thread breakage?

Click **“Threading”** on the Home Page. The needle protector will go down and expose the needle hole. After finished threading, continuously click . The needle will go back to previous stitching stop position. Finally, click **“START”** on the monitor frame, the machine will go on unfinished process.



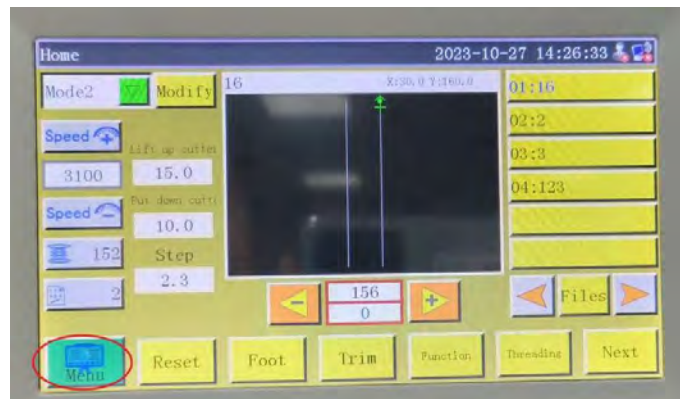
2) How to stop the auto collecting function?

On the Home page, click **“Function”**, select open/close from **“Receiving switch”**. Click **“Save”** - **“Return”**.

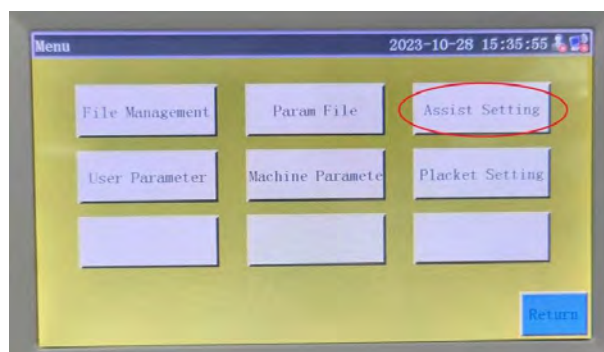


3) How to change the language?

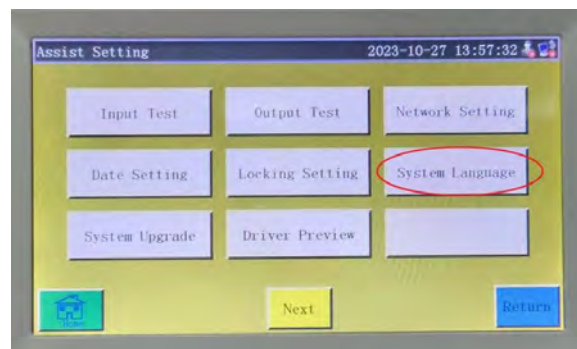
On the Home page, click “Menu”.



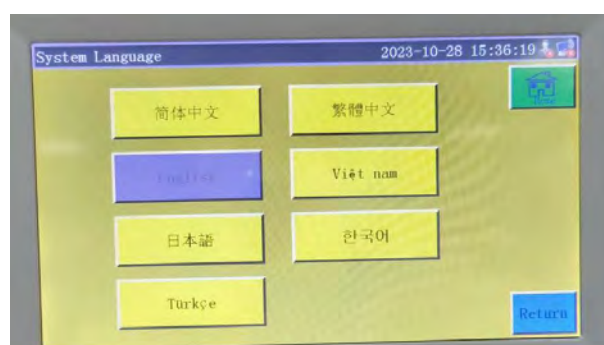
Click “Assist Setting”



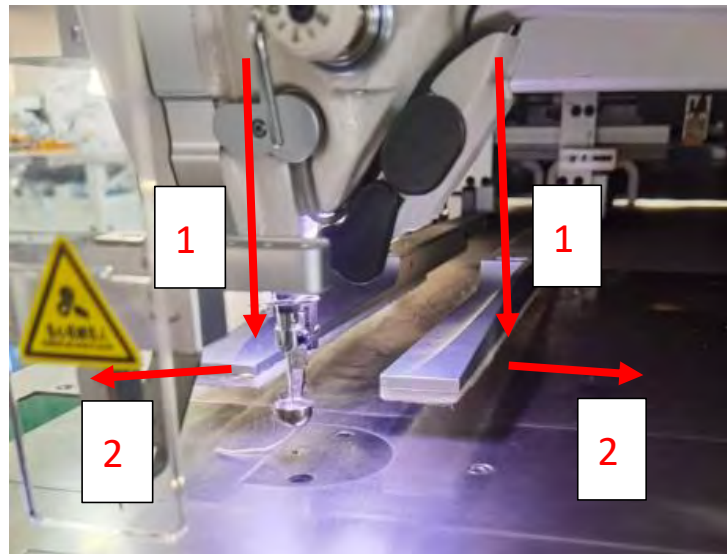
Click “System Language”



Select the language you need, then click “Save”- “Return”- “Return”- “Return”.



- 4) How to adjust the presser foot stretching distance? Please refer to the video “9. How to adjust the presser foot stretching distance?”



The presser foot will stretch the fabric a little, so the stitching and cutting will be more neatly and beautiful.

- 5) How to change from single knife to double knives? Please refer to videos “How to change from single knife to double knives.mp4(1) & (2)”.
- 6) How to thread for machine with bobbin thread breakage detection function?



Please refer to video “12. How to threading for machine with/without Bobbin Thread Breakage Detection Function.mp4.”

- 7) How to sharpen the Y cutting blade? Please refer to the video “13. How to sharpen the Y cutting blade?”

8) How to sharpen the upper knives?

We use special hard material for the central single/double knives, so sharpen with sandpaper is not workable. You have to use grinding machine.



9) How to adjust the sensitivity of bobbin thread breakage detection? Please refer to video “14. How to adjust the sensitivity of bobbin thread breakage detection.mp4”.

10) How to turn on/off the pre-feeding function? Please refer to the video “15. How to turn on the pre-feeding function.mp4”.

Warranty service is limited to under normal use and maintenance, which follow the “Operation Instruction”, the “Installation Manual” and all the videos manufacturer provided.

When you have any questions or problems, please contact the sales immediately. We will try to solve your problems as soon as possible. Thanks for purchasing!

Automatic Polo Placket Setter Machine

ASL-APO100

Installation Manual

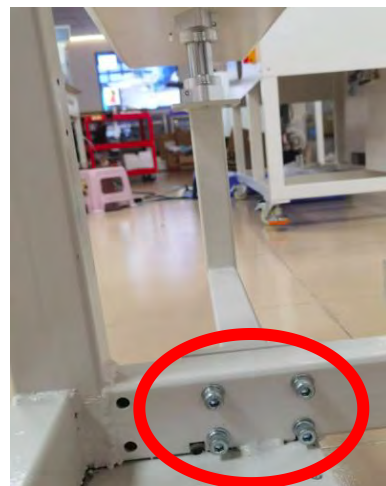
1. Install the small stuff tray on the right side. Please refer to the red circle.



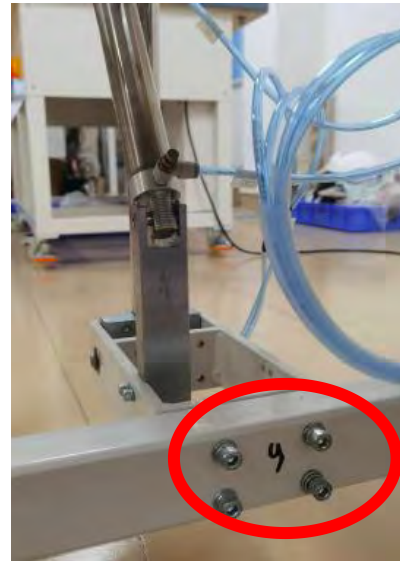
2. Install the monitor. Please refer to the red circle.



3. Install the collecting tray on the left side. Please refer to the red circle.



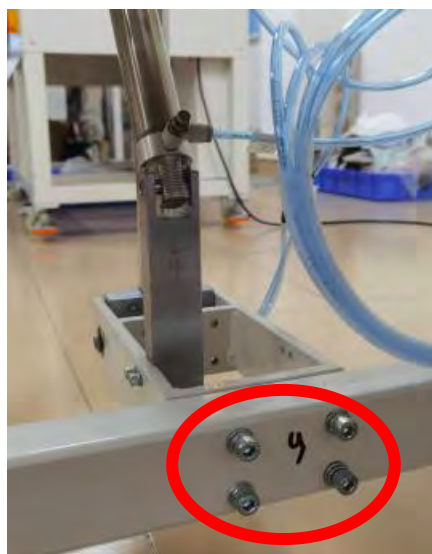
4. (1) Install the auto collecting jig. Please refer to the red circle.



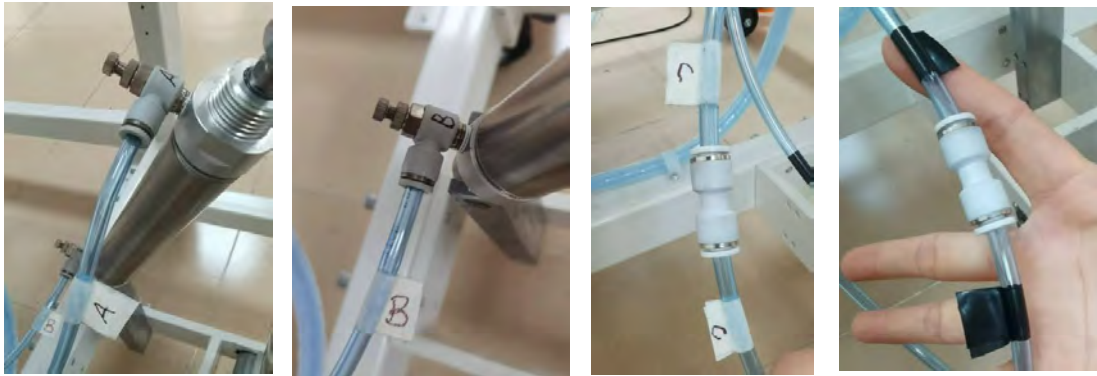
Check if the auto collecting jig is parallel with the table. Try if the jig can hold the table correctly.



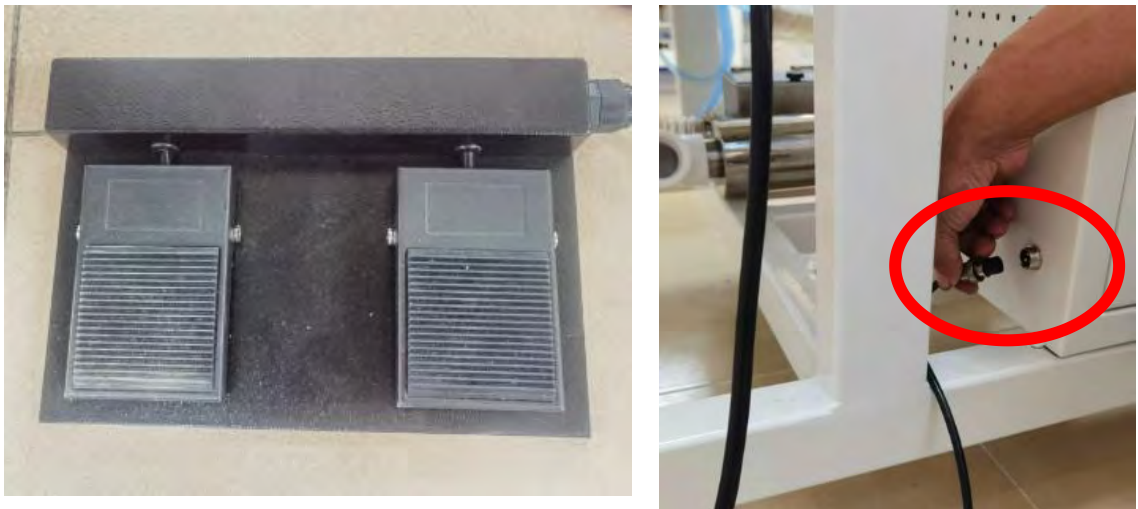
If not parallel with the table, loose the screws in below red circle and adjusted the auto collecting jig position.



(2) Connect 4 pieces pipes from the air compressor. Letter matching.



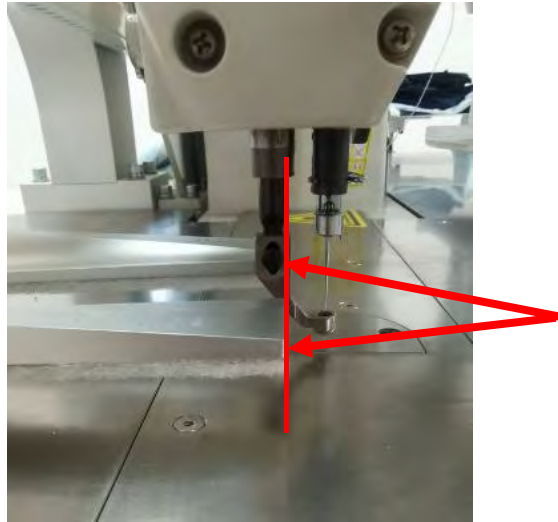
5. Install the pedal. Please refer to the red circle.



6. Connect with the air compressor. Connect to the power 220V, 50HZ.



7. Aline the tip of big presser foot with the pole of small presser foot, otherwise the sensor can't detect correctly.



8. Move the sewing head to ensure the needle is in the center of two big presser feet.



9. Add lubricated oil for the new sewing head.





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.
ASL-APO100.DEC.2025