

SIRUBA

電控參數說明書

ELECTRONIC CONTROL PARAMETER MANUAL

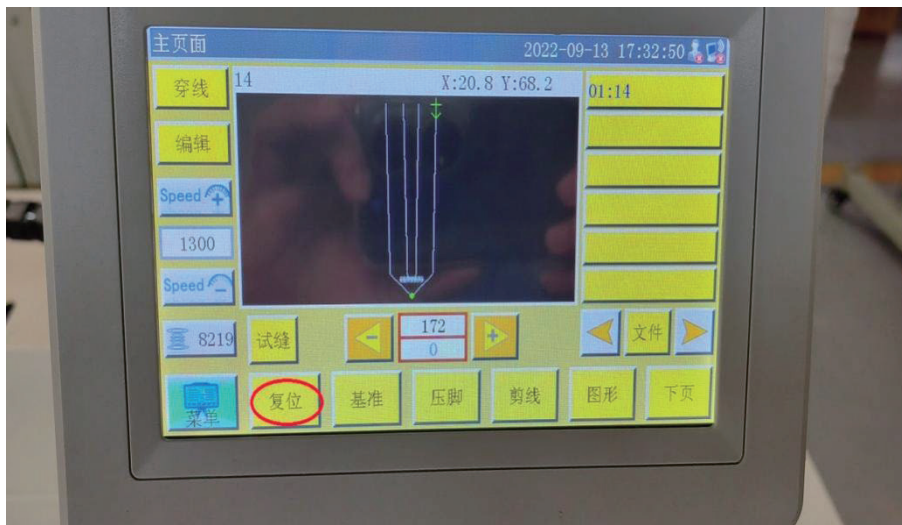
■ ASL-SVS100



1. 机器启动 Machine startup

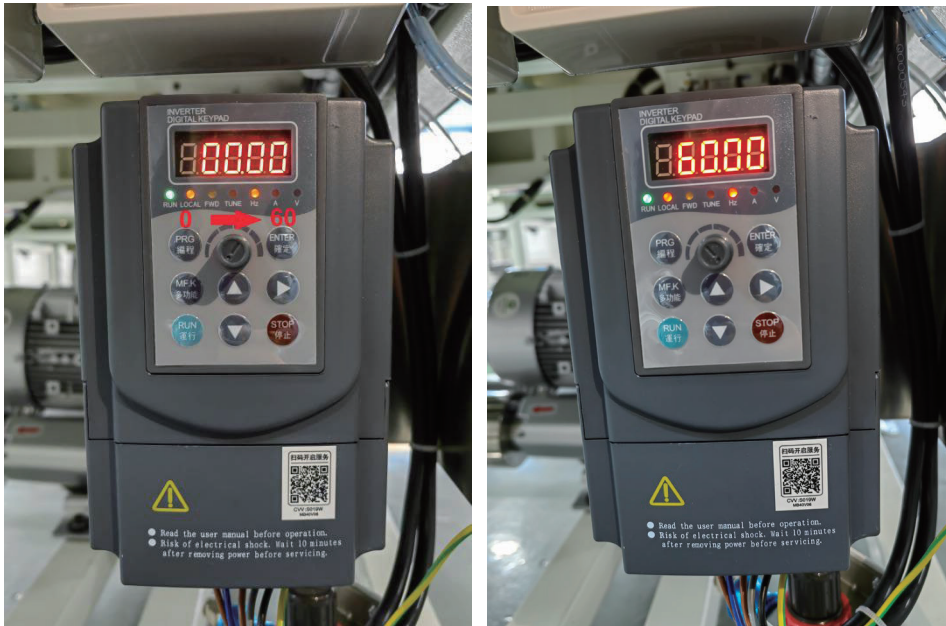
打开“电源开关” → 打开“吸风开关” → 操作屏启动并进入主界面 → 点击“复位”键 → 机器启动完成

Turn on the “Power Switch” → Turn on the “Air Suction Switch” → The operation screen starts and enters the main interface → Click the “Reset” key → the machine starts



该风机为微调速风机，可通过旋转按钮调整风机的风力，可调整范围为 0-60。(图 1) 我们可以根据实际布料的厚薄调整风机的风力，一般的使用范围是 40-60。(图 2)

This is a adjustable-speed wind drive. The suction power can be adjusted by rotating the button. The adjustment range is between 0 to 60. (Picture 1) We can adjust the suction of the fan according to the actual thickness of the sewing fabric, and the general usage range is 40-60. (Picture 2)



(Picture 1)

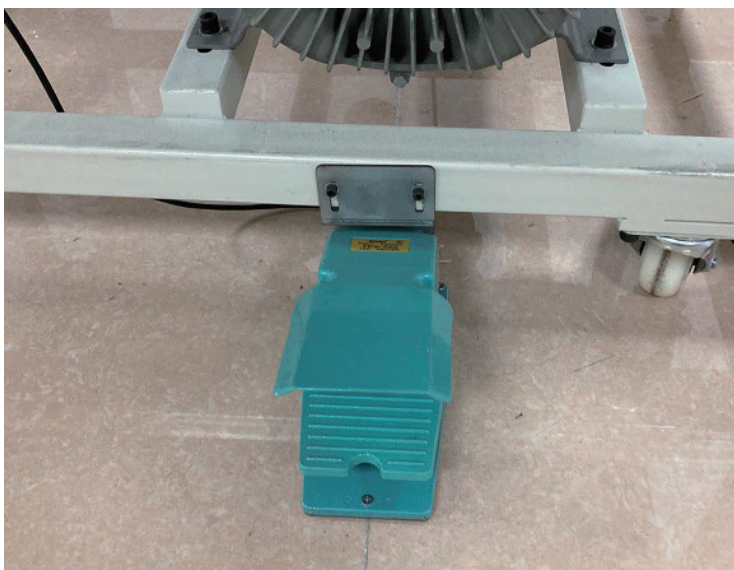


(Picture 2)

2. 主要按钮说明: Description of main buttons:

吸风: 启动吸风功能（脚踏跟操作板上的“吸风”按钮可同时操作吸风功能）

Air suction: to start the air suction function. (The “Air suction” button and the foot pedal can operate the air suction function at the same time)



启动：启动

Start: Starting



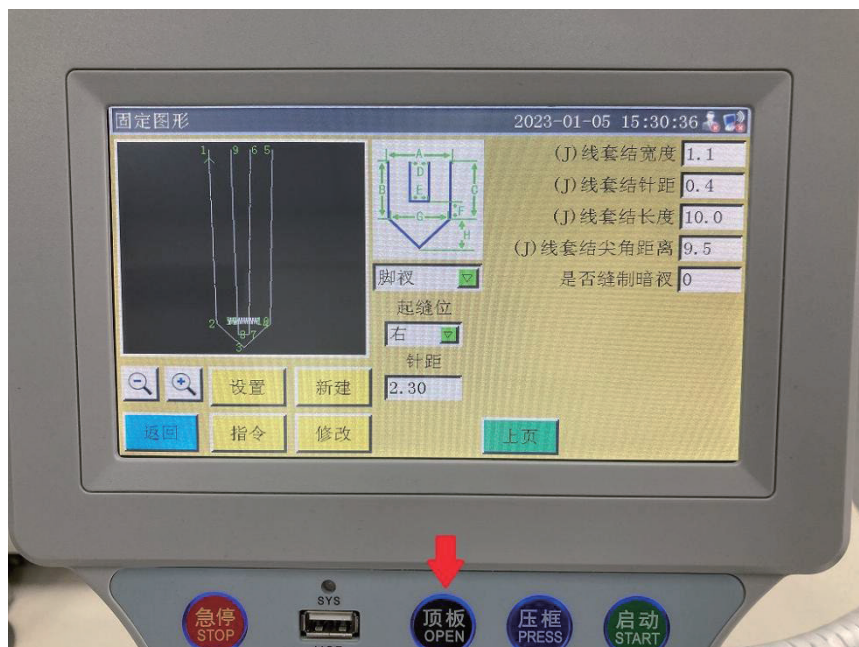
暂停：遇到紧急情况可以暂停

Pause: pause in case of emergency



顶板: 控制顶板的升降。更换线芯的时候需要先抬升顶板，更换线芯后，把顶板复位。

Open: This key is used to control the top plate. When replacing the shuttle, it is necessary to lift the top plate and return the top plate to its original position after replacement.

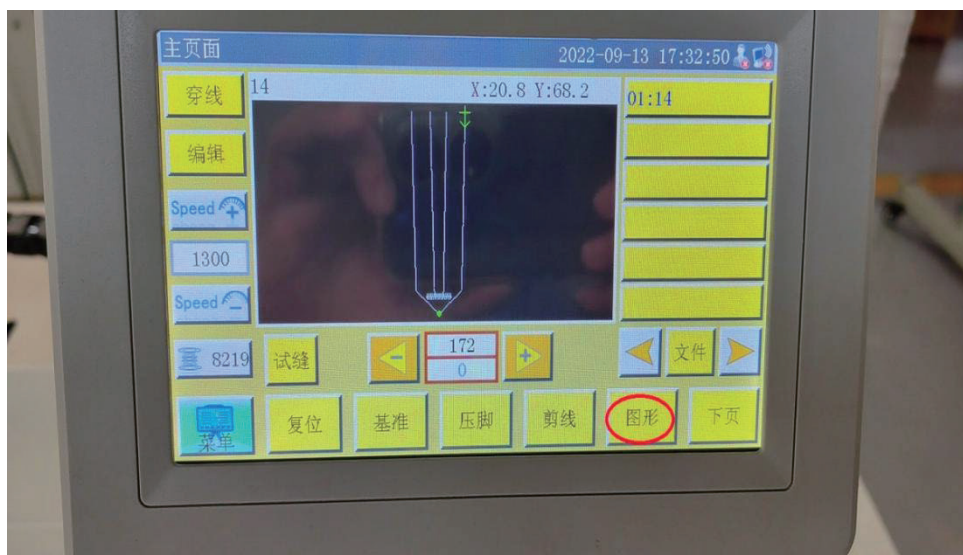


3. 两种车缝效果参数设置 Two sewing effect parameter settings

1) 三角衩 Triangular underpants

在主页面右边图形菜单列表选定需要修改的图形，点击右下角“图形”键，进入参数设置界面，根据效果需要调整预设参数。

Select the graphic to be modified from the graphic menu list on the right of the main page. Click the “Graphic” key at the right corner to enter the parameter setting interface, and adjust the preset parameters according to the effect.



参数 (A) 为宽度，该参数根据具体模具设定，不能随便修改。

The parameter (A) is the width of the foot fork. It set according to the specific mold and cannot be modified randomly.



参数 (B) 为左线高度，可根据需要调整。

操作：点击参数→调整参数→点击“修改”→完成修改并保存数据

Parameter (B) is the height of the left line. It can be adjusted as required.

Operation: Click the parameter → adjust the parameter → click “Modify” → complete modification and save the data automatically

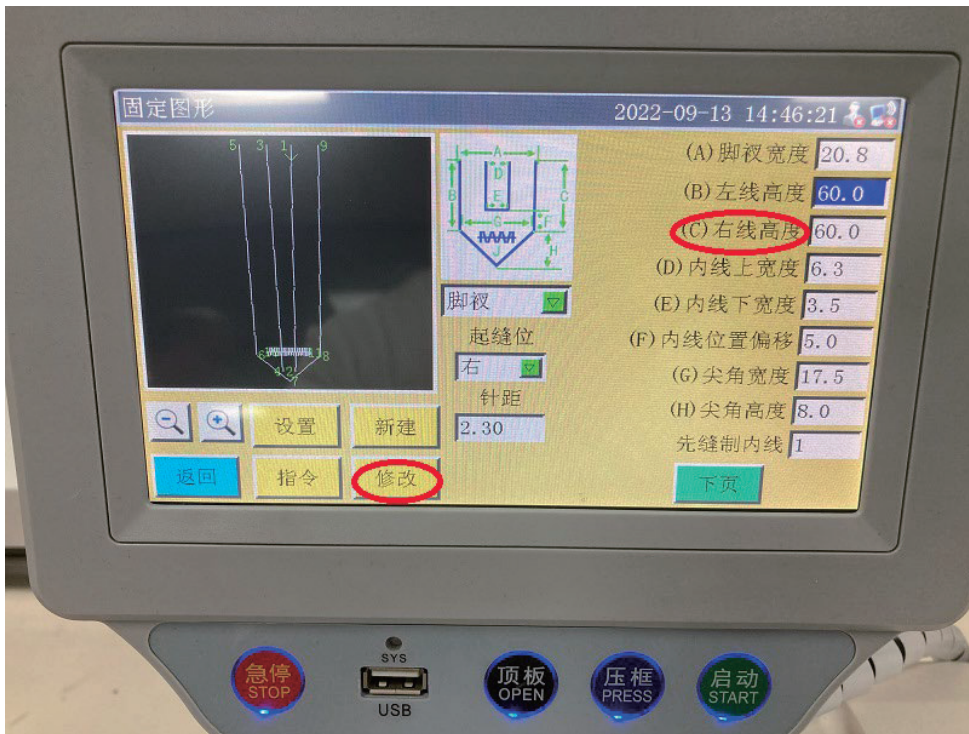


参数 (C) 为右线高度，可根据需要调整

操作：点击参数→调整参数→点击“修改”→完成修改并自动保存数据

Parameter (C) is the height of the right line. It can be adjusted as required.

Operation: Click the parameter → adjust the parameter → click “Modify” → complete modification and save the data automatically



如果是高低衩(B)和(C)的数值不一样, 如果是平衩(B)和(C)的数值一样。

If the height of the underpants is high and low, the parameter of (B) and (C) would be different. If the underpants are flat, the parameter of (B) and (C) would be the same.

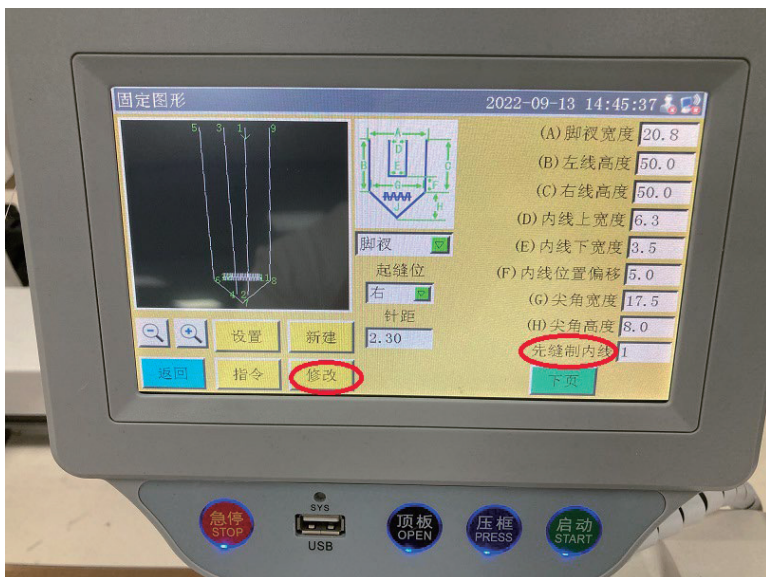


明衩暗衩设置：（明衩参数为“0”，暗衩参数为“1”）

Surface vent and hidden vent setting : (Code of surface vent is “0” , code of hidden vent is “1”)

操作：点击“先缝内线”→修改参数→点击“修改”→修改完成并保存数据→点击“下页”→点击“是否缝制暗衩”→修改参数→点击“修改”→修改完成并自动保存数据。（这两个数值必须一致）

Operation: click “Sew the inner thread first” → modify parameters → click “Modify” → modify and save the data automatically → click “Next” on the lower right corner → click “Sewing concealed foot fork” → modify parameters → click “Modify” → modify and save the data automatically. (These two parameters must be the same.)

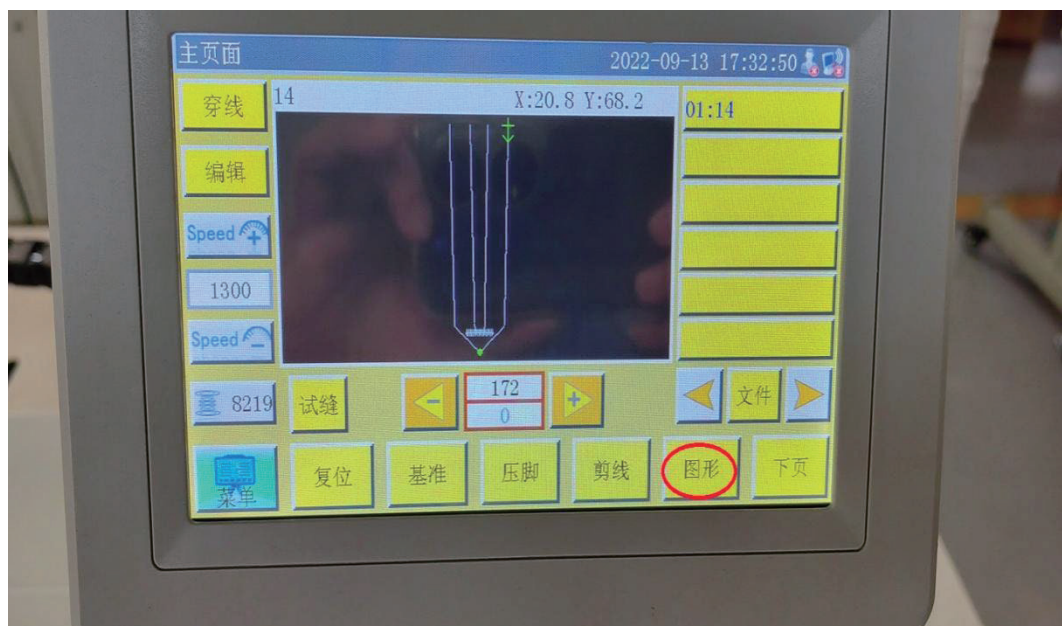




2) 平头衩 Flat head fork

在主页面右边图形菜单列表选定需要修改的图形，点击右下角“图形”键，进入参数设置界面，根据效果需要调整预设参数。

Select the graphic to be modified from the graphic menu list on the right of main page → click “Graphic” on the lower right corner → go to the parameter setting interface → adjust the preset parameters according to the effect.



参数 (A) 为宽度，该参数根据具体模具设定，不能随便修改。

The parameter (A) is width of the foot fork. It set according to the specific mold and cannot be modified randomly.



参数 (H) 为尖角高度

操作：点击参数→调整参数为“0”→点击“修改”→完成修改并保存数据

Parameter (H) is the height of sharp corner

Operation: click the parameter → adjust the parameter to “0” → click
“Modify” → complete the modification and save the data automatically



参数 (F) 为内线位置偏移

操作: 点击参数→调整参数为“0”→点击“修改”→完成修改并保存数据

Parameter (F) is the Interior line position offset

Operation: click the parameter → adjust the parameter to “0” →

click “Modify” → complete the modification and save the data

automatically



参数 (J) 为套结缝尖角距离

操作: 点击参数→调整参数为“0”→点击“修改”→完成修改并自动保存数据

Parameter (J) is the zigzag corner distance

Operation: click the parameter → adjust the parameter to “0” →

click “Modify” → complete the modification and save the data automatically



4. 参数(J)为套结相关数值(宽、高和针距),可根据需要调整。

操作: 点击参数→调整参数→点击“修改”→完成修改并自动保存数据

Parameter (J) is the zigzag data (width, height and step). It can be adjusted as required.

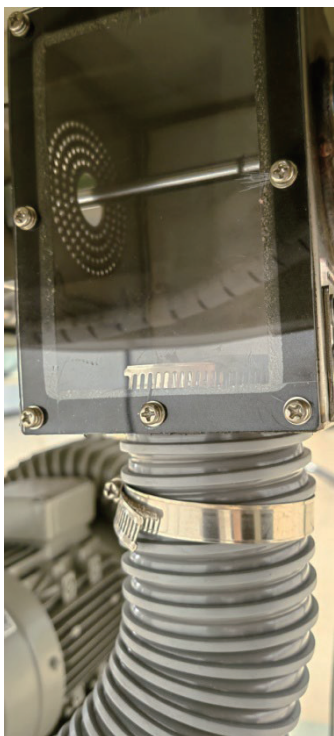
Operation: click the parameter → adjust the parameter as required → click “Modify” → complete the modification and save the data automatically



5. 注意事项: Attention

- 1) 脚衩机吸风换气盒，定时每一周清理灰尘垃圾。

The air suction box of the underpants machine regularly cleans the dust and garbage every week.



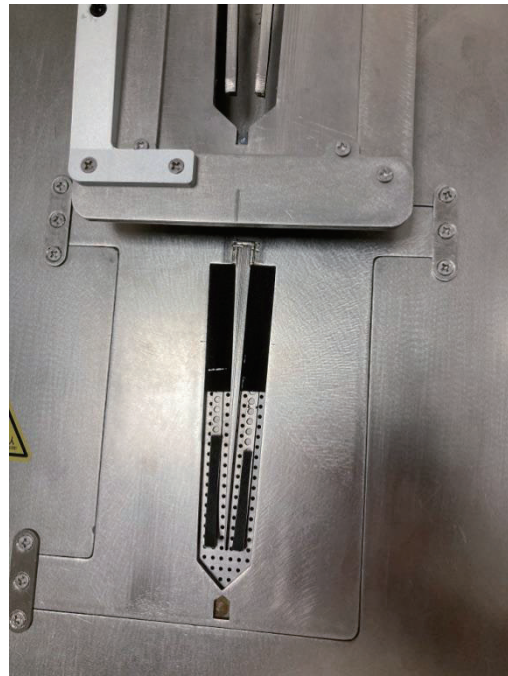
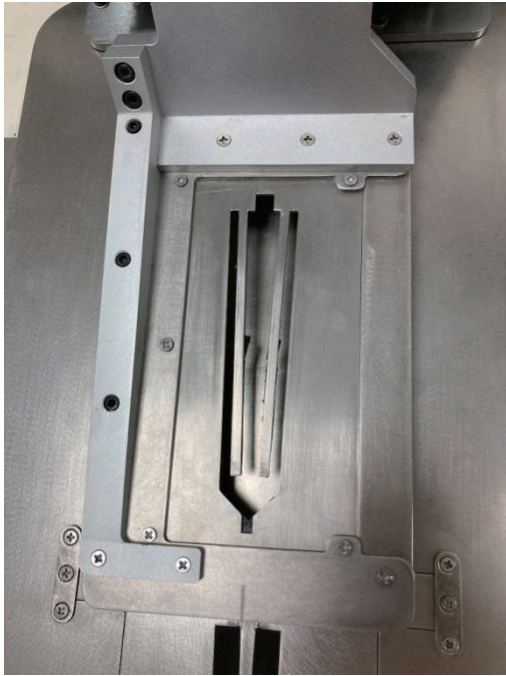
2) 机器气压要保持在 5 公斤以上

Keep the air pressure of the machine above 5 kg.

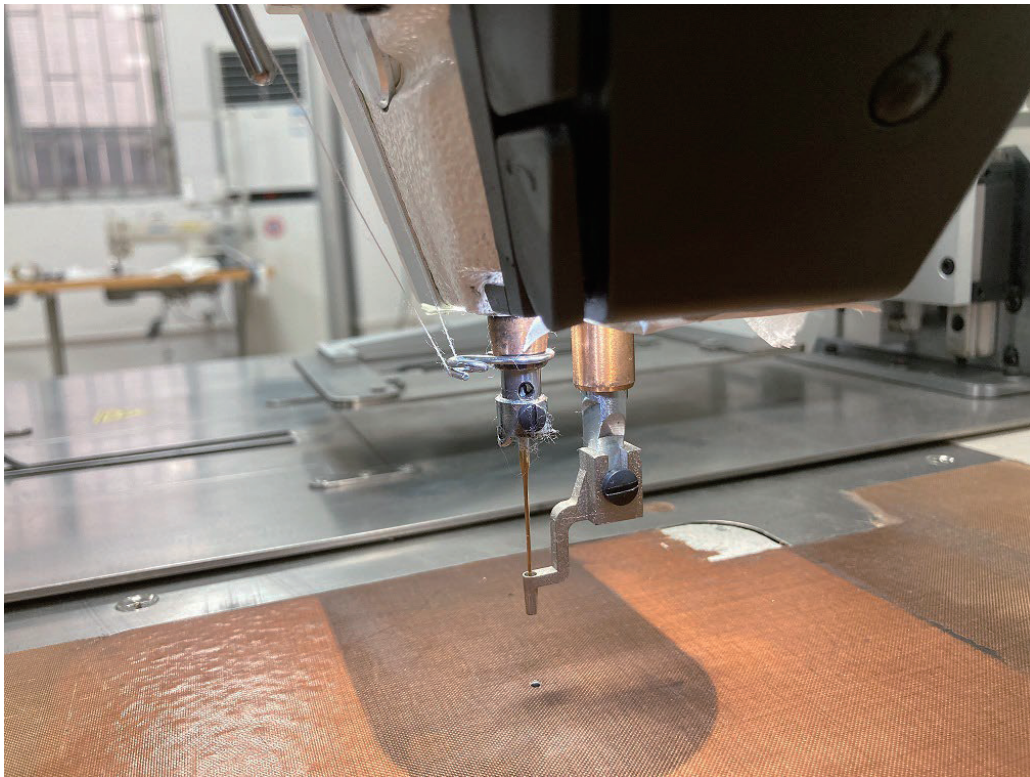


6. 易损件 Wearing parts

脚叉机活动模具上下 Foot fork machine movable mold up and down



脚衩机专用压脚 Underpants machine special presser foot





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