

SIRUBA

電控參數說明書

ELECTRONIC CONTROL PARAMETER MANUAL

■ ASP-EBJ502-U

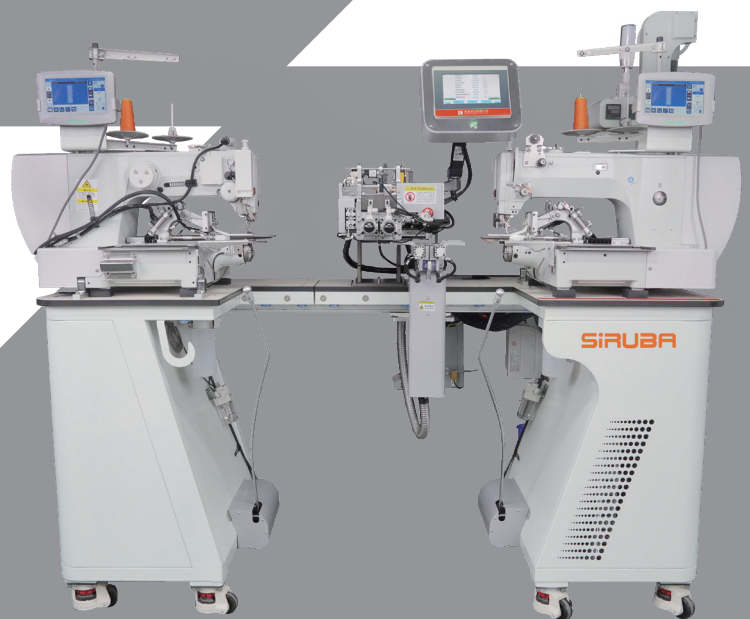


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1.1、 Application

This machine is a sewing machine for elastic joining, combining functions such as automatic feeding, automatic sewing, and automatic material collection. It improves production efficiency, saves labor, and achieves energy conservation and consumption reduction.

1.2、 Parameters

1	Dimension	L210cmxW110cmxH190cm
2	Needle	DP*17
3	Sewing speed	1800~2200rpm(suggest speed 2000rpm)
4	Air pressure	0.5Mpa 1.5L/min
5	Voltage	AC220V
6	Weight	420kg
7	Max power	6500W
8	Max current	30.2A

1.3、 Installation

1. pay attention to adjusting the foot cup to keep the equipment in horizontal line. Leave enough space for equipment operation, maintenance and repairment.



Rotate the red gear to the left to fix the foot cup

2. Installation of pedal and air blower

(1) Pedal



Right sewing head pedal connection



Left sewing head pedal connection

(2) Air blower



Air blower connection

7. Pneumatic tube connection

(1) Pneumatic tube connection



连接气管

(2) Rotate the valve to adjust the air pressure



Pull up the valve,
Rotate the valve:
Rotate left to increase the
pressure;
Rotate right to increase
the pressure.
Press down the valve
to knock the data as
5.

1.4、 Basic function



Parameter instruction

1. Cutter: long press the control the cutter.
2. Pressure roller rise: control the feeding press wheel.
3. Heating: switch(ON/OFF) of heating function for ironing.
4. Unmarked positioning: **logo** positioning device setting.
5. Dual head mode: Machine head working mode selection.
6. Employee management: can record employee' s output
7. Preset length: set the circumference of the elastic.
8. Actual length: The actual length of each elastic after sewing.
9. Correction: Manual input to correct length errors.
10. Preset output: Manually set the current output.
11. Left current output: Displays the current output of the left machine head.
12. Right current output: Displays the current output of the right machine head.
13. Left turntable setting: Set the number of operations that the left machine head has completed before the next turntable rotation.

14. Right turntable setting: Set the number of times the right machine head has completed before the next turntable rotation.
15. Left turntable quantity: Displays the quantity completed by the current left machine head.
16. Right turntable quantity: Displays the number of right machine head completed.
17. Total output: Displays the total output completed. Long press to clear.
18. Machine number: The production number of each machine.
19. Parameter setting:



(1)Left and right bobbin thread breakage detection: When the machine is working, the set value must be less than the average value of the red value displayed on the right, but greater than half of the average value, otherwise a breakage alarm will easily occur..

(2)Cutting time: Set the cutter action time (if the cutting is not continuous, the time can be increased; otherwise, it can be shortened)

(3)Push into the left and right sewing positions: Push the clamp into the position ready

for sewing. The larger the value, the more it is pushed in; the smaller the value, the less it is pushed in.

(4) Other parameters must be modified under the guidance of the manufacturer

20. Turntable jog: Manually control the turntable rotation.
21. Manual debugging: manual debugging to control sewing action.

1.5、Sewing pattern, Press foot setting

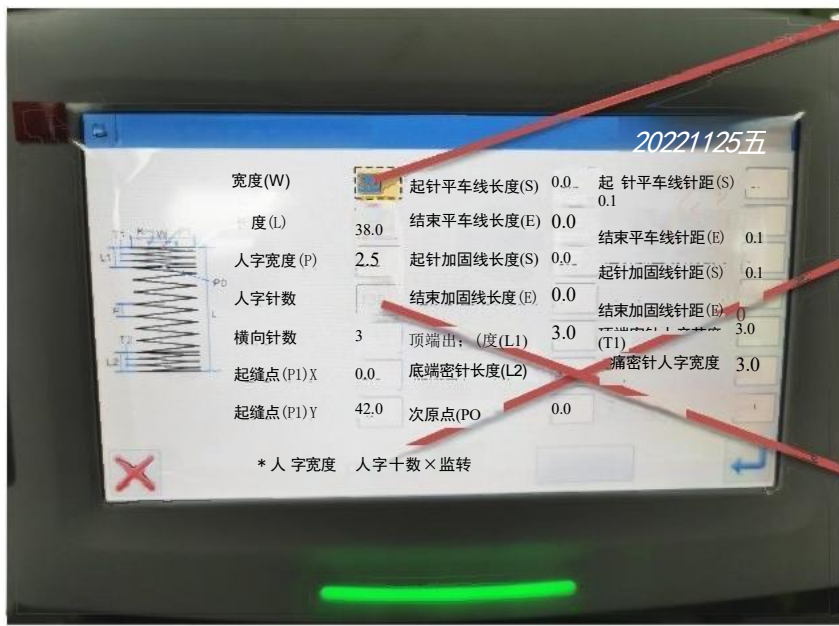
1.720 series(2210 head)——sewing pattern edit

(1) Click the pattern



Click the pattern

(2) Width, stitch

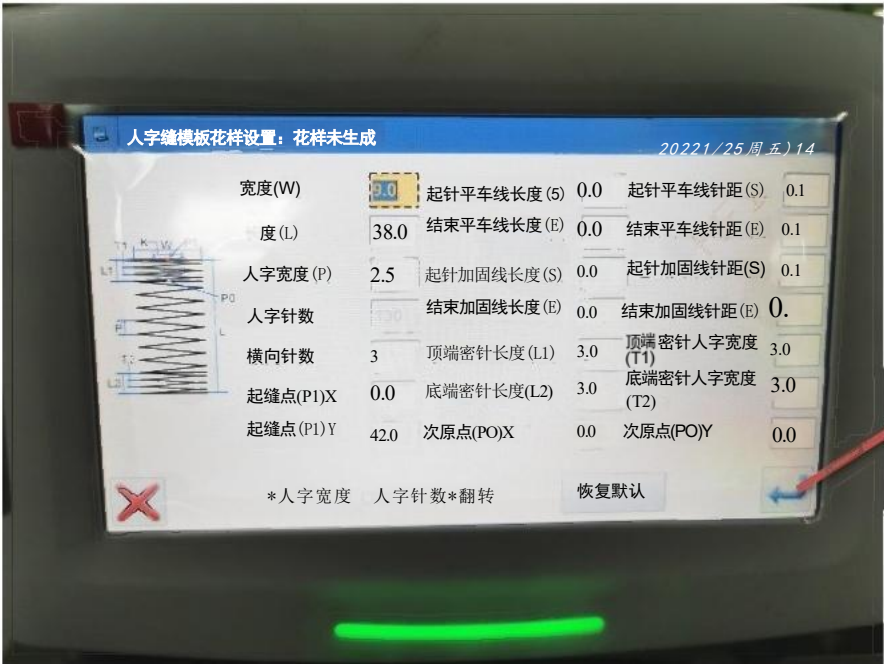


Elastic width setting

Stitches setting:
Click the number of herringbone (P) first

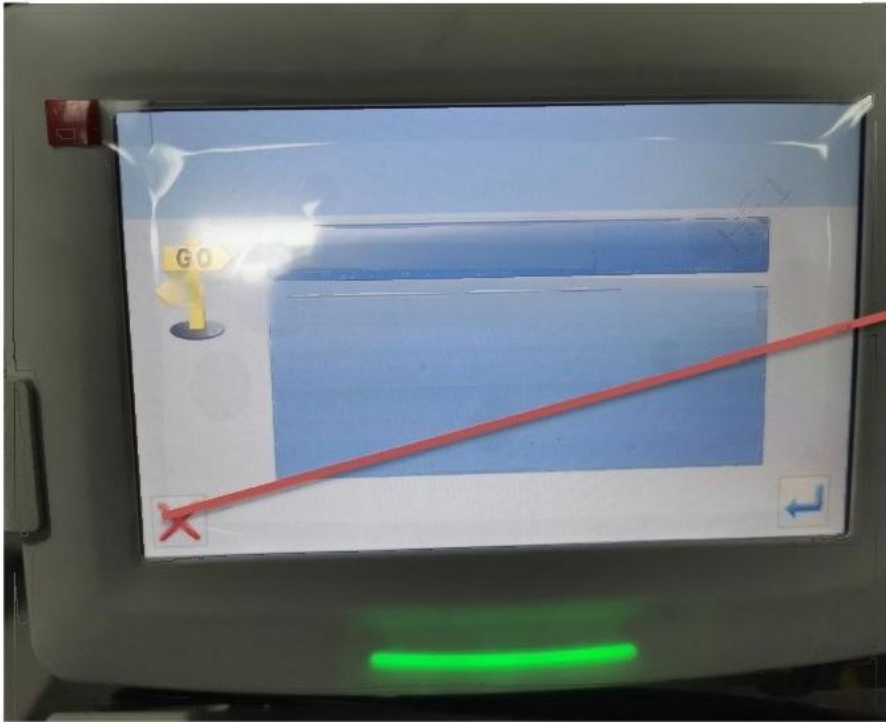
Then set the number of herringbone stitches.

(3) Click OK



After setting,
Click OK.

(4) Save the pattern



Click "X" to save the pattern

(5) Save as a new file



Click to
save it

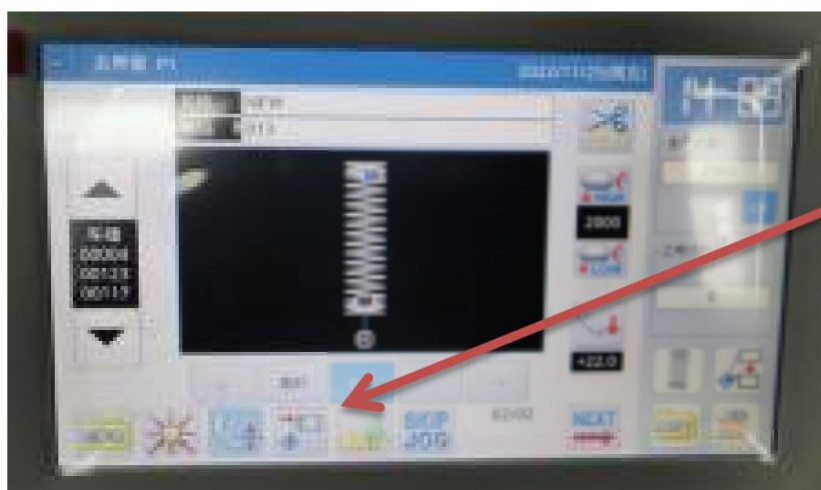
(6) Name the pattern and save it



Input the name

save

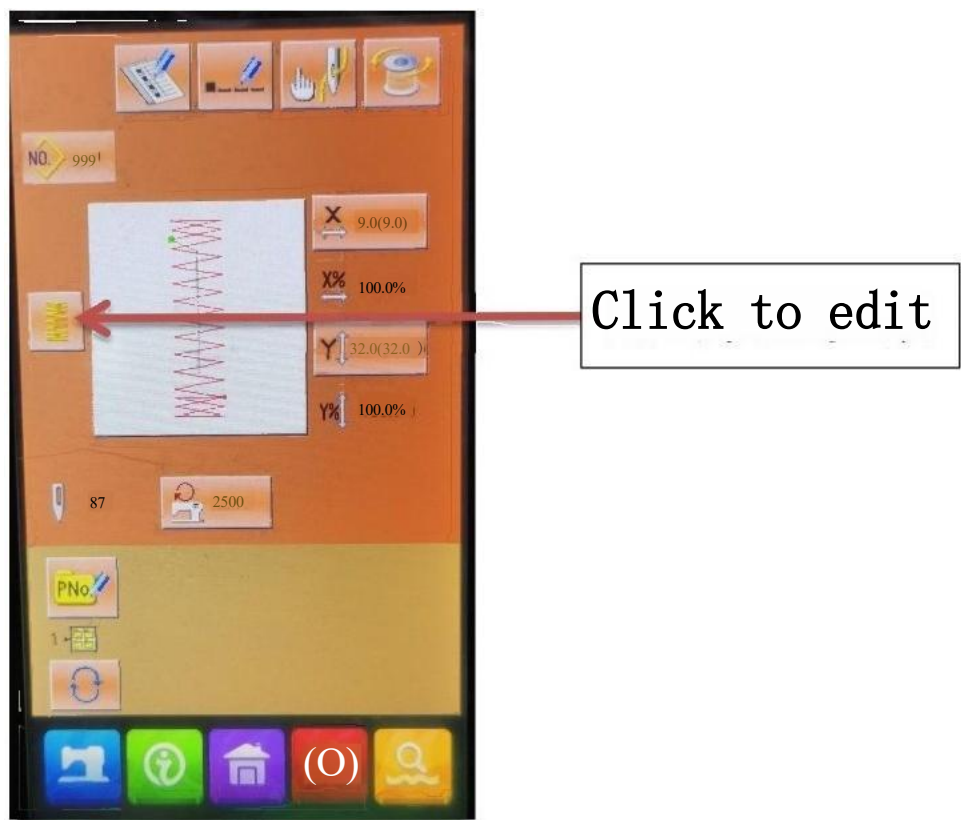
(7) Click here to get ready for sewing



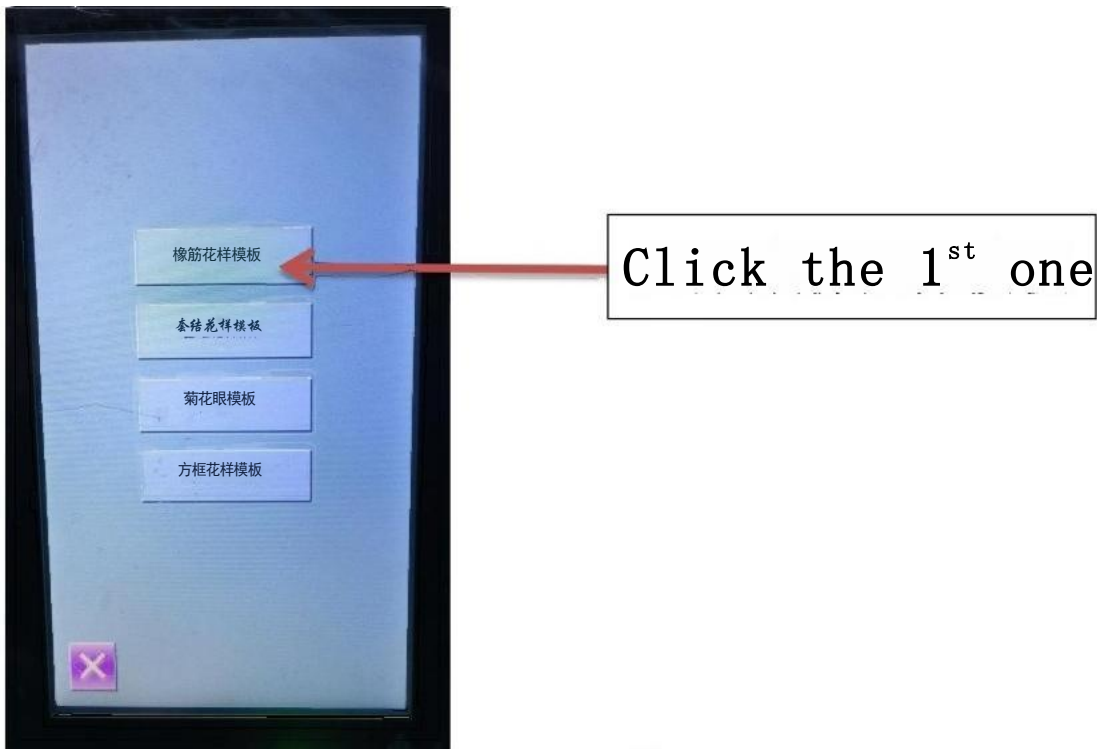
Click on "Return
to starting point"

2. The other series type ——Pattern edit

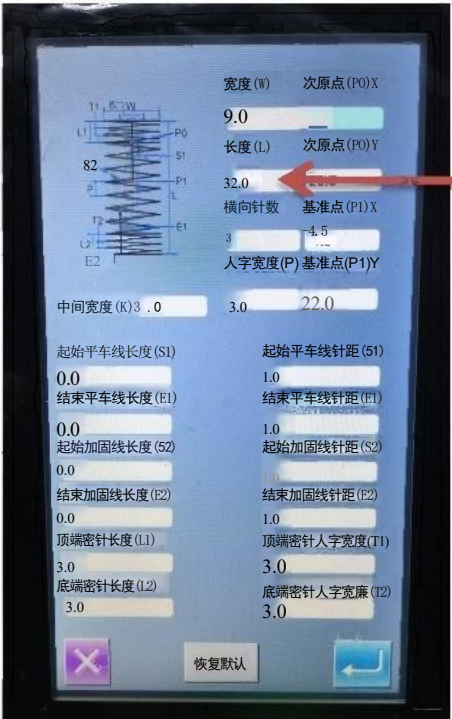
(1)Click here for pattern edit



(2)Click the 1st one



(3) Elastic' s width setting



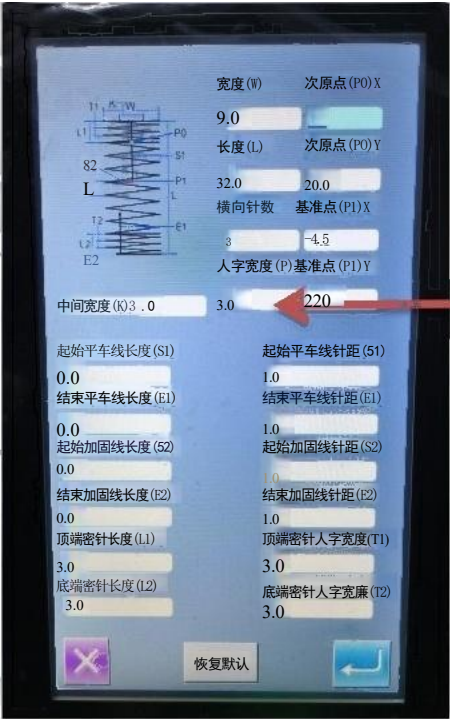
Click” L”



Input the width

Click OK to save

(4)Stitches setting



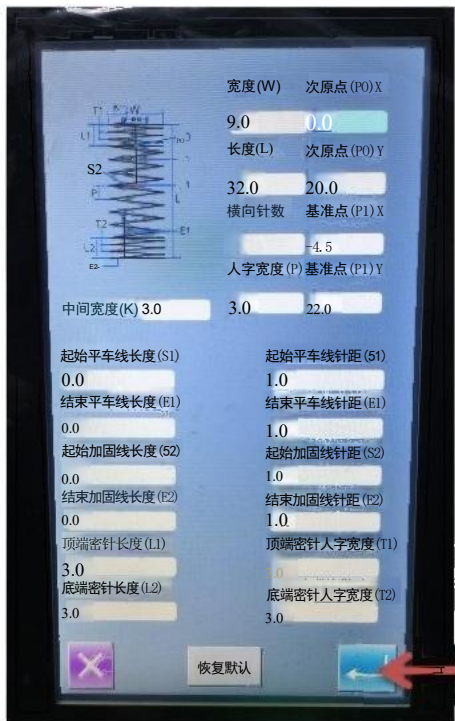
Click” P”



The more the data,the less the stitches
The Less the data,more the stitches

Click OK to save

(5) Save the pattern



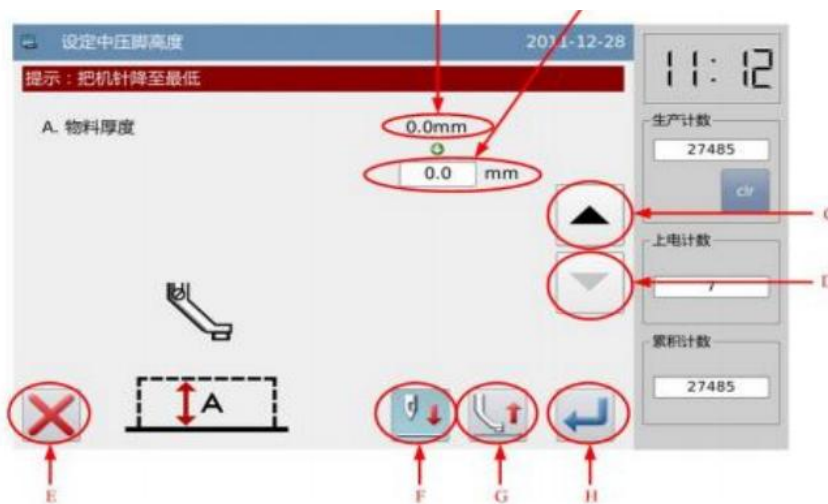
1. Click to save



2. Name a number

3. Save the number

3. Press foot setting



A: The current height of the middle press foot

B: Target height of medium press foot

C: Increase the height and press the middle foot 0.2mm each time

D: Reduce the height of the middle press foot by 0.2mm each time

E: Exit the current page and return to the previous page

F: Moving needle vertically



Drop of needle



Rise of needle

G: Press this key to make the middle press foot move towards the arrow direction



Press foot rise



Press foot drop

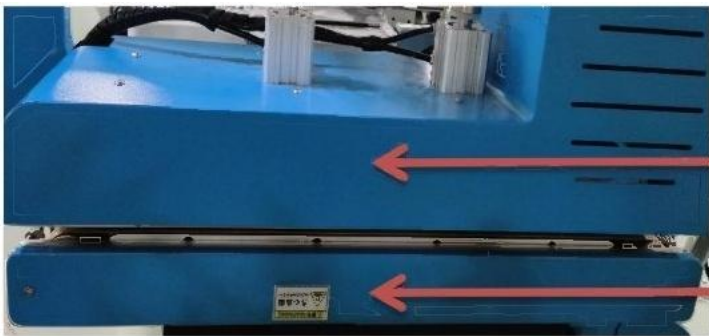
H: Save and exit

1.6、Function of buttons

1.Power Switch(ON/OFF)



2.Heater and heating buttons



Upper heater

Bottom heater



Setting upper temperature

Setting bottom temperature

2.1、Operating Instructions

1.Language selection



2.Preparation of sewing head

Click to back to the original sewing point.



3.Editor of patterns

(Please refer to 1.5 Instructions.)

4.Manual debugging, testing

5. If every step is OK, click start key to produce.

2.2、Equipment lubrication

All oil Windows of the equipment can be filled with oil (white oil) to the 2/3 interface

(1) Bartacking machine oil window



(2) Pattern sewing head oil window



2. The oil window should be checked once before each shift to check whether the oil is sufficient

3.Each moving part should be wiped clean each shift with white oil to keep the machine fully lubricated

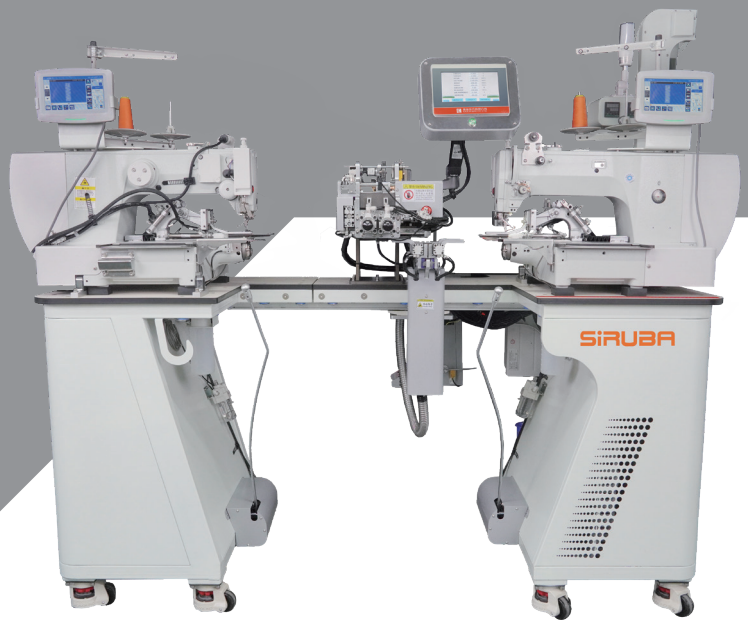
4.The waste oil tank at the bottom of the machine should be cleaned once a week

2.3Safety Operating Instructions

1	Things to pay attention to before operation	Check whether the location sensors are correct
		Please make sure that the air pressure is within the specified range
		Check whether there is any foreign body on the device
		Check whether the device is reset
		Please make sure the sewing machine is in the correct position
		Please make sure that the sewing line is correct
2	Matters needing attention in operation	Please check whether the device has abnormal sound
3	Note after running	Please turn off the power.
		Please turn off the air source
		Please clean the equipment and keep the equipment clean

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Best regards.



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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.
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