

SIRUBA

ORIGINAL

使用說明書與零件圖

INSTRUCTIONS BOOK & PARTS LIST

■ ASV-ATS100A

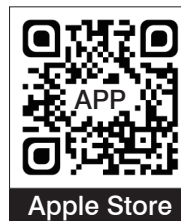


ENGLISH

ENGLISH

A WARM REMINDER

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.



GENERAL SAFETY INSTRUCTION

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.

Explanation of warning indications and labels.

	<p>HIGH VOLTAGE DANGER</p> <p>Do not open the power cabinet within 10 minutes after the power off.</p>		<p>Machine moving area!</p> <p>Stay away and keep clear to avoid injury.</p>
	<p>High speed moving area!</p> <p>Stay away and keep clear to avoid injury.</p>		

WARNING LABELS	WARNING LABELS
<p>A risk of cut and injury from moving parts. Stay away and keep clear.</p>	<p>Be aware that holding the sewing machine during operation can hurt your hands.</p>
<p>A risk of electric shock. Stay away and keep clear.</p>	<p>There is a risk of entanglement in the belt resulting in injury.</p>
<p>A risk of burn from the high temperature area. Stay away and keep clear.</p>	<p>There is a risk of injury if you touch the button carrier.</p>
<p>Avoid direct eye contact with the laser beam or other light source.</p>	<p>GENERAL SAFETY INDICATIONS</p> <p>The correct direction is indicated.</p>
<p>A risk of injury to head from upper contact. Apply proper protection (helmet) and keep clear.</p>	<p>Grounding connection as indicated.</p>

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 as soon as possible.
- (4) Failure 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 prevents 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.

PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

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.
- (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.

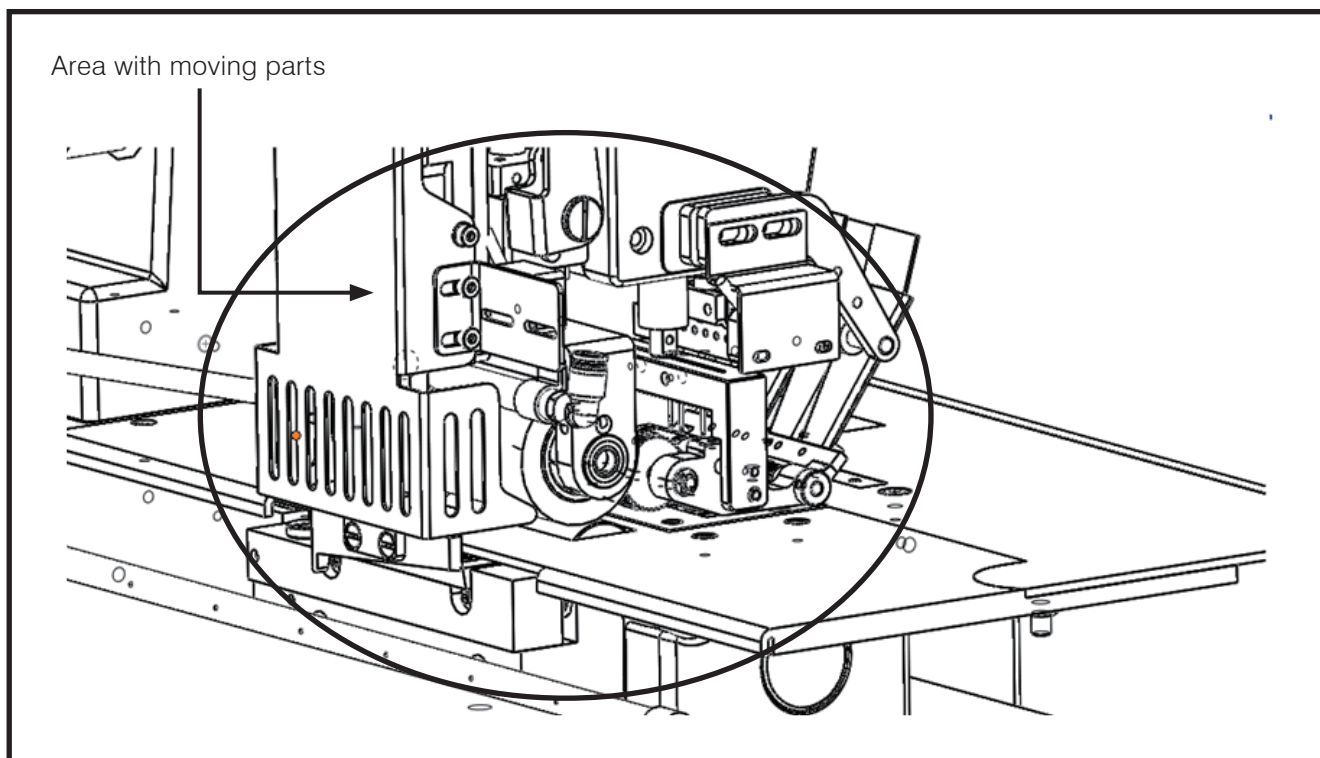
7. Service

- (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.

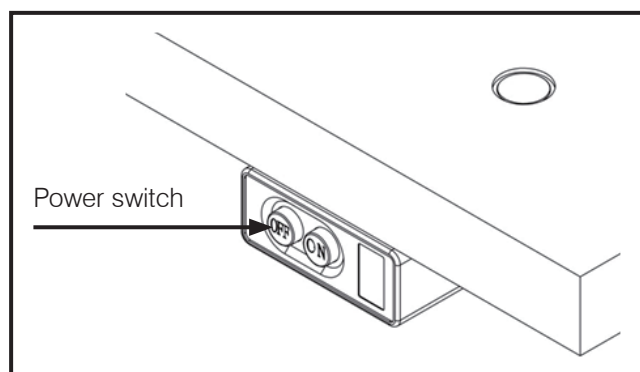
8. Working Environment

- (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.

SAFETY INSTRUCTIONS



1. Do not put your fingers into the area while machine is operating.
2. Must switch off the power before take down the cover for repair and maintenance.
3. Stick the electric shock alert pictorial marking at high voltage place which may cause human danger. Therefore, only the professional and electric technician could open the cover, while the electric place which have stuck on the alert pictorial marking need to be repair and maintenance.
4. If there's a necessity to stop the machine right away while machine operating, you could press the machine halt switch to switch the power off.
5. Power cord and pneumatic line pipe need to make sure being fixed and settle down. Do not put them disordered on the ground in case of people stumble and cause danger.
6. No matter under any circumstances, for your life safety, do not pull out the power ground wire while operating the machine.
7. For your safety, you need to stop your work and cut off the power, if it starts thundering.



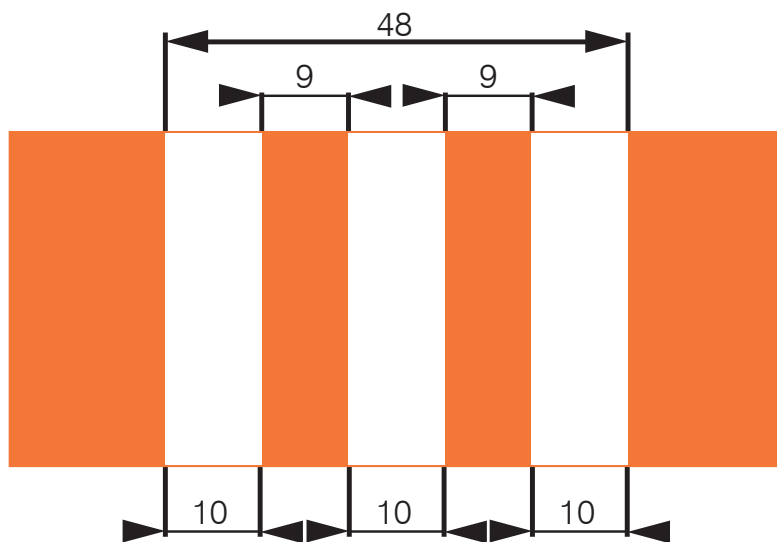
8. Must switch off the power before you leave your work or work ending.
9. Do not take down any cover while operating the machine.

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SPECIFICATION

Model	ASV-ATS100A
Sewing Way	Multineedle, 3-stripe attaching machine
Sewing Speed	Max 2000 SPM
Max 2000 SPM	UO X 113GS #11
Available Width Of Stitching Platform	440mm
Stitch Length	6.4mm

Stitch Length

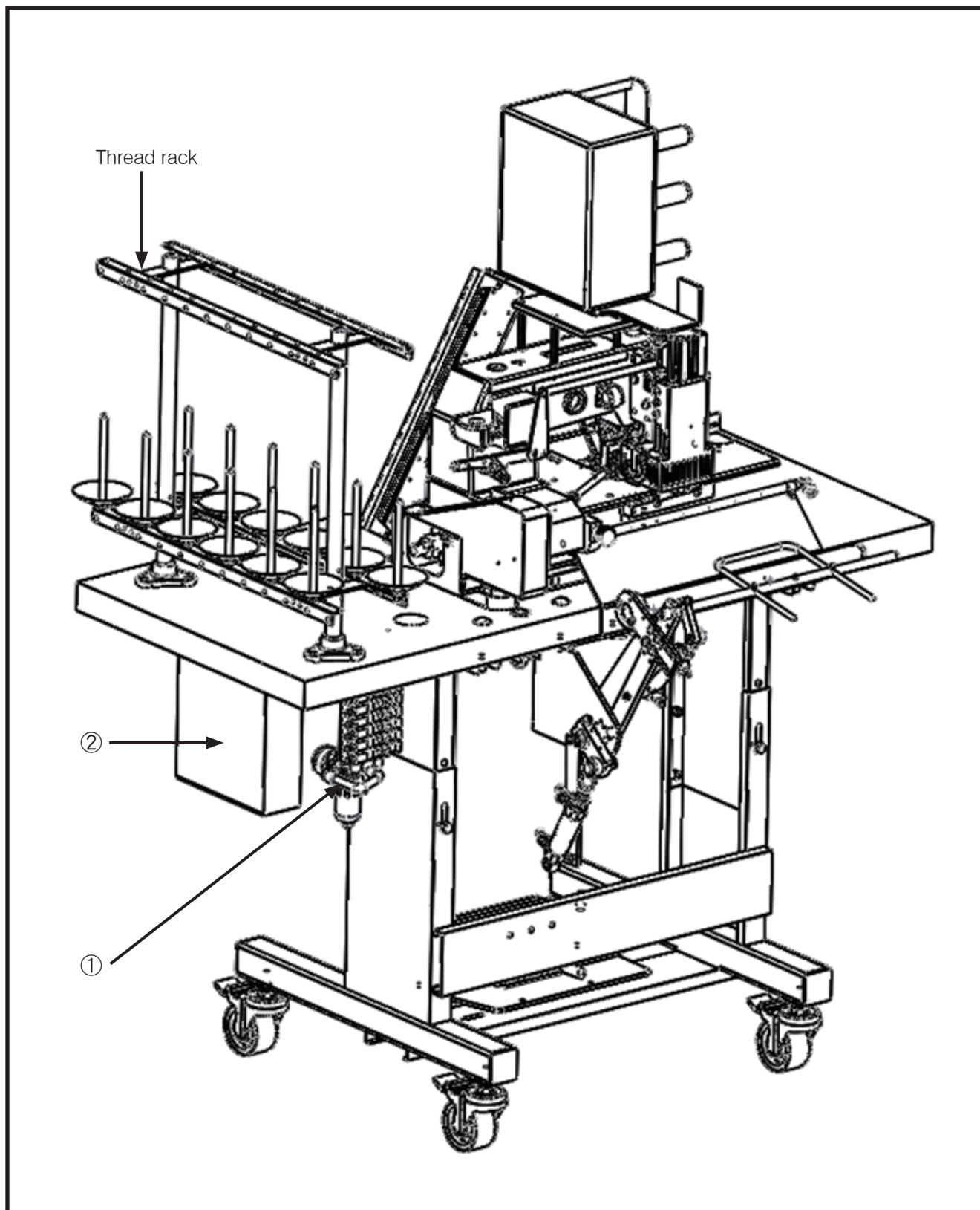


Voltage	Single Phase AC200~240V 50/60Hz
Air Pressure	0.5 Mpa (5Kg/c m ²)
Air Consumption	40 L/minute

※Material limit : essential requirement cloth length \geq 150 mm

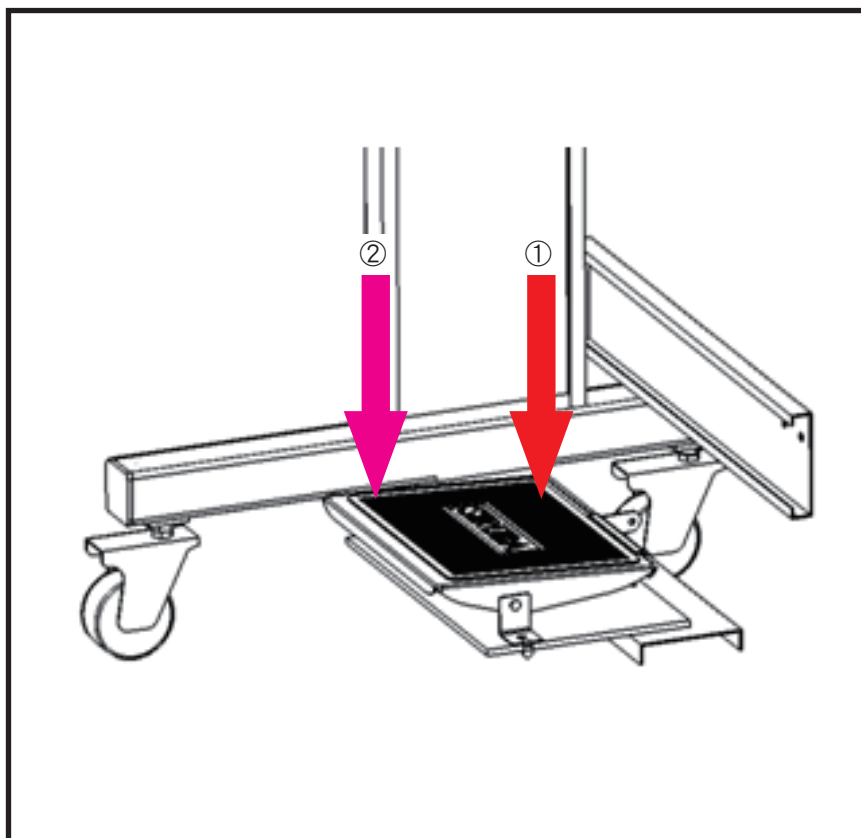
INSTALLATION

Air pressure pipe connection ① and electric control box power supply line ② .

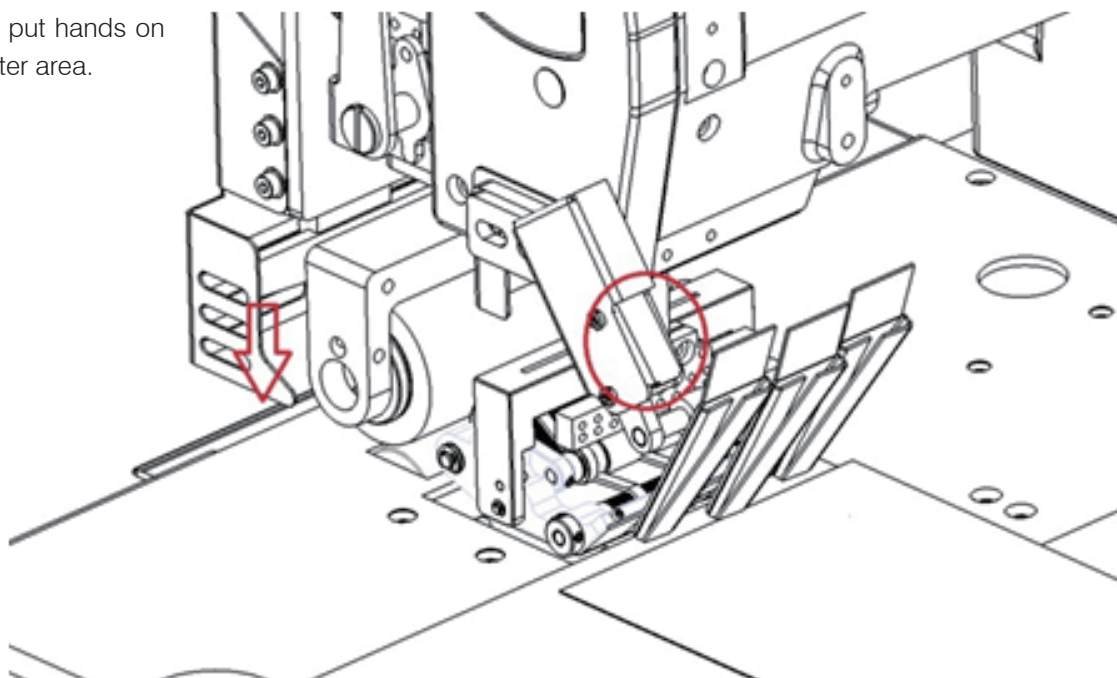


INSTRUCTIONS

- (1) Power and air pressure
 - A. Voltage
Rated voltage $220V \pm 10\%$.
The earth wire must be grounded.
 - B. Air pressure
Use 0.5Mpa (5kg/c m^2) .
- (2) Power on
Press the power on button then turn on the power of the 3-stripe attaching device.
- (3) Pedal control Step forward
 - ① direction to control the sewing speed.
 - Step forward ② direction to lift the presser.
- (4) Press the switch of fine-tuning cutter, the cutter will execute one cutting operation.



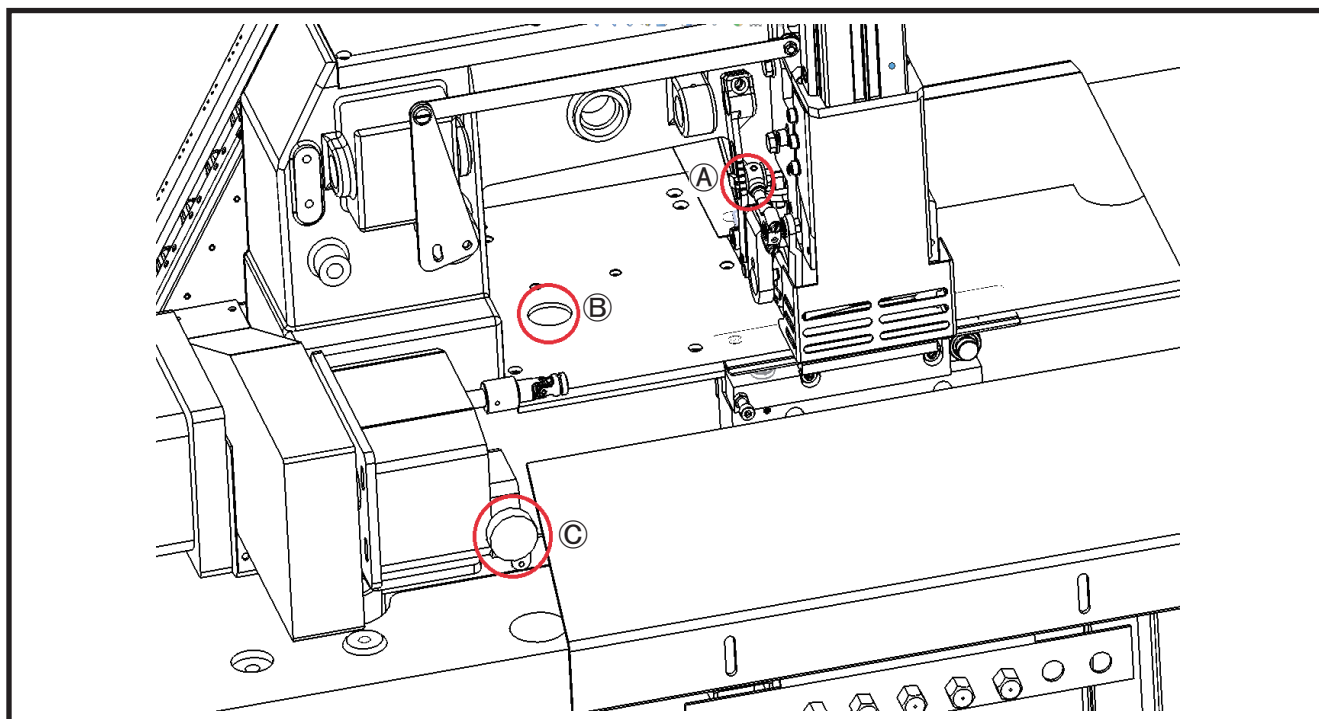
※ Do not put hands on the cutter area.



SET UP AND ADJUSTMENT

(1) Adjustments

Ⓐ Rear roller adjustment; Ⓑ stitch length adjustment knob; Ⓒ 3-stripe feeding speed adjustment.



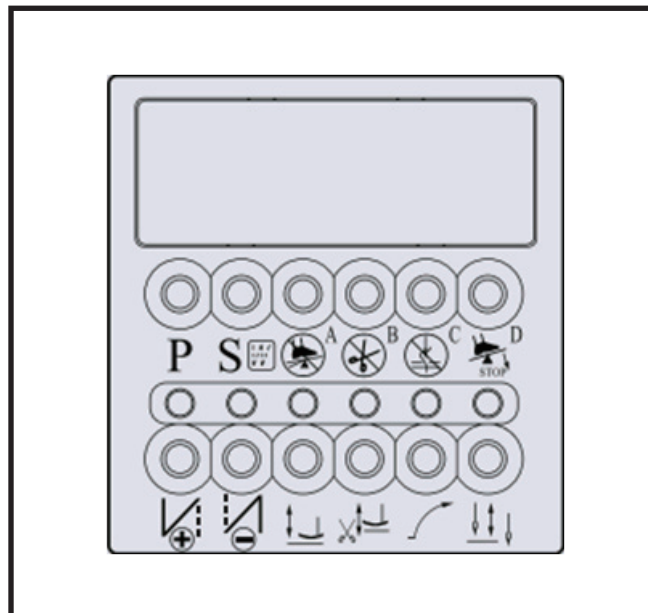
(2) Parameter setting

Press on the operation panel

A : shift ; B : hundreds digit ; C : tens digit ; D : units digit.

Parameter :







Display on panel	Contents
P5	Count stitches before cloth.
P6	Count stitches after cloth.
T7	Press, delay time
T8	Press, action time
T9	Cloth blowing, delay time.
TA	Cloth blowing, action time.
TB	Cut, delay time
TC	Clamp, delay time
TD	Clamp, action time



PARAMETERS TABLE




Parameters Code		Parameters Function	Range	Pre.setting	Description
1	H	Maximum sewing speed	50 - 9999 spm	1500	Maximum speed adjustments
4	N	Front cut sewing speed	50 - 8000 spm	200	Adjust front cutting speed
5	V	Rear cut sewing speed	50 - 8000 spm	200	Adjust rear cutting speed
47	MAC	Machine Code	0 - 101	29	Machine code switchover
60	L	Low speed	50 - 500 spm	200	Low speed adjustments
97	TK3	Cutter, action time	0 - 990 ms	10	Adjust cutter action time
114	UEG	Needle UP position stop angle	5 - 180 degrees	15	Adjust the needle up stop position.
206	N1	Stacking start	0 - 99 stitches	3	Stacker cylinder start

1. How to enter different parameter levels?

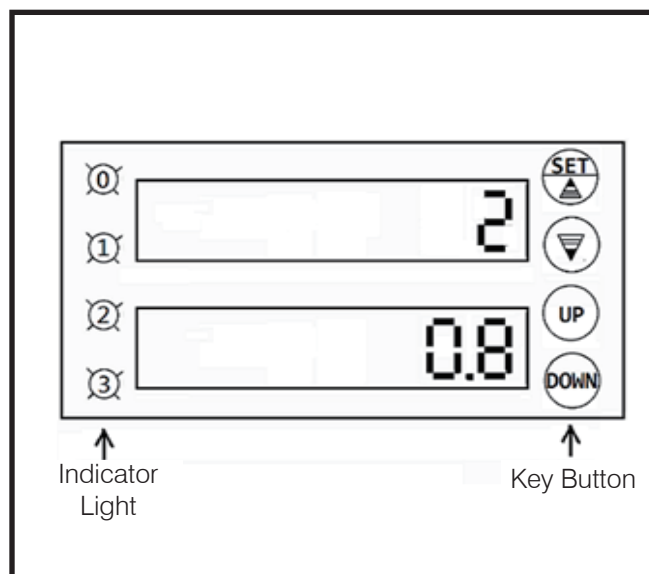
		POWER ON	(Level 1 【001-046】)		
	+	POWER ON	(Level 2 【047-122】)		
	+	POWER ON	(Level 3 【123-251】)		
	+	POWER ON	(Level 4 【176-251】)		
	+	POWER ON	(Level 5 【208-251】)		
	+		+	POWER ON	(Return to factory setting)




TAPE FEEDING DEVICE ADJUSTMENT

1. User Interface














Indicator Light	Status		
	OFF	ON	Flicker
L0_Error			
L1_(Upper feeding roller)	OFF	ON	Refill
L2_(Middle feeding roller)	OFF	ON	Refill
L3_(Down feeding roller)	OFF	ON	Refill

Add	Descriptions
D200	(Upper feeding roller)_Delay time(0.1S)
D201	(Middle feeding roller)_Delay time(0.1S)
D202	(Down feeding roller)_Delay time(0.1S)
D203	Down time(0.1S)



Key Button	Descriptions
	(Upper feeding roller)_ON/OFF
	(Middle feeding roller)_ON/OFF
	(Down feeding roller)_ON/OFF

2. Parameter settings (1-4) & On/Off (5-8)

- (1) Long press  key button 3sec. to enter settings.
- (2) Press  or  key button to select the parameters(D200 、 D201 、 D202 、 D203.....)
- (3) Press  or  key button to adjust the parameter values
- (4) Long press  key button 3 sec. to exit the settings
- (5) Long press  key button 2sec. to activate the upper roller (L1, light on). Long press  key button 2sec. to deactivate the upper roller (L1, light out), Loop running and display D200 (Upper feeding roller Delay time)
- (6) Long press  key button 2sec. to activate the middle roller (L2, light on). Long press  key button 2sec. to deactivate the middle roller (L2, light out), Loop running and display D201 (middle feeding roller Delay time)
- (7) Long press  key button 2sec. to activate the down roller (L3, light on). Long press  key button 2sec. to deactivate the down roller (L3, light out), Loop running and display D202 (down feeding roller Delay time)
- (8) L0 flickering - When indicator light and buzzer activate, user can push  key button to turn off the buzzer.

中文

中文

溫馨提醒

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。



安全警示

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。

警告標示說明

	高壓電危險 在機器關機後十分鐘內， 勿開啟電控箱。		零部件移動區
	零部件高速移動區 勿接近，以避免人員受傷。		勿接近，以避免人員受傷。

標告標示說明		標告標示說明	
	機器零部件移動區，勿接近，以避免人員損傷。		請注意，在操作過程中握住縫紉機會傷到您的手。
	有電，危險。		小心被機械捲件受傷！
	高溫度區！危險，勿靠近。		如果觸摸按鈕托架，可能會造成人身傷害。
	強光！勿直視，以避免眼睛受傷。	一般安全標示	
	小心頭部撞擊！		機器運行方向
			電氣接地位置標示

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) 為了避免機器突然起動造成意外，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。

在不同階段的注意事項

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) 所有接頭都必需要確實固定。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) 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

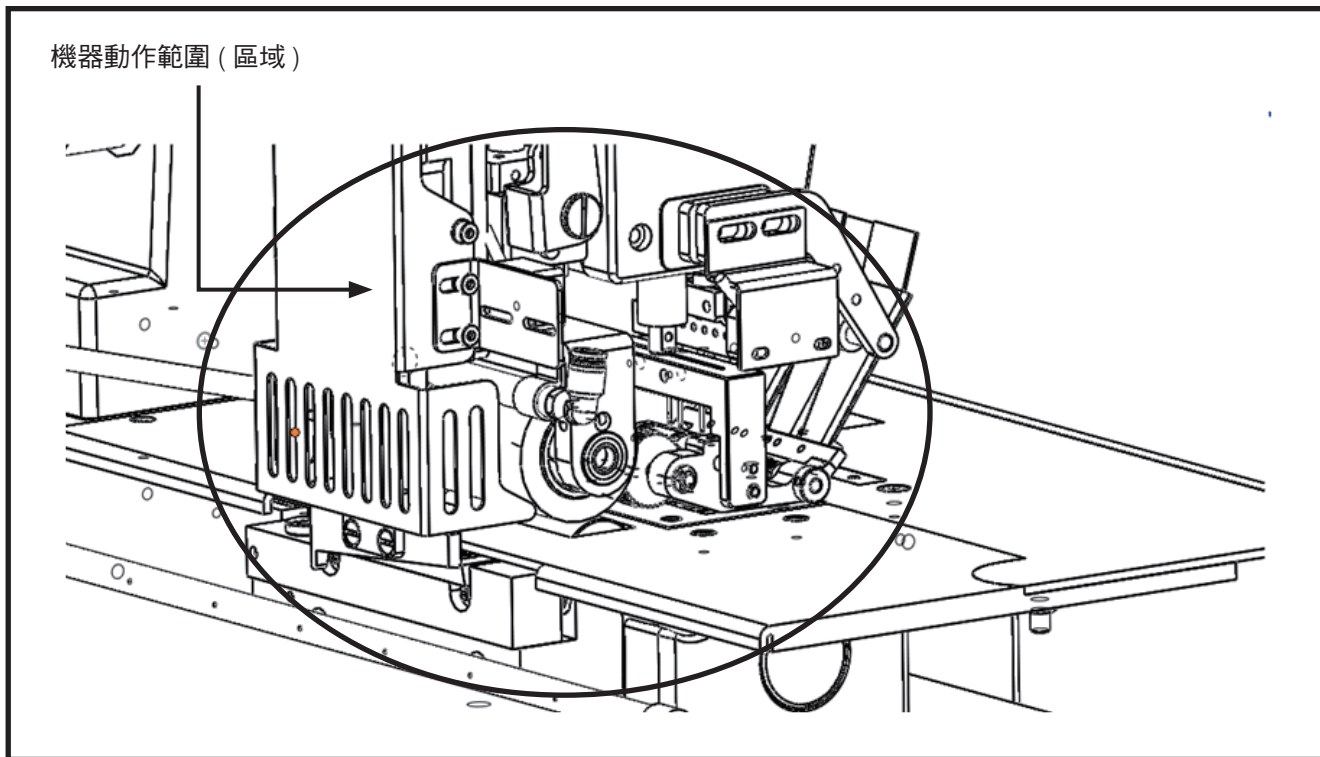
- (1) 只有合格的技師或工程師能夠進行維修服務，包含機器調整與修理。只採用原廠的零件進行更換。如果採用非原廠零件，或是因不當維修／調整所造成的傷害，本公司將不負任何責任。
- (2) 只有合格的技師或認證的工程師才能對電控系統進行維修或保養。
- (3) 當對氣動原件（如氣缸）進行維修保養時，務必先拔除風源，並將氣體完全洩除，以避免突然啟動。
- (4) 在調整或更換部件後，檢查所有螺絲是否鎖固。
- (5) 定期清潔是必需的。在清潔前務必先關閉電源，並確認機台完全停止。
- (6) 如果運作異常或不良，立即停止操作並關閉電源。聯絡授權經銷商或我們公司以尋求技術協助。
- (7) 當保險絲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

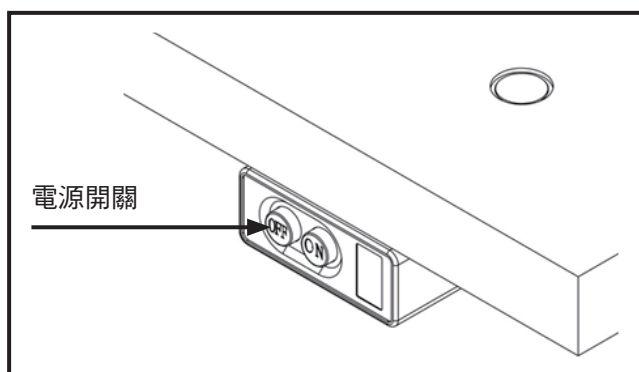
- (1) 機器必需不用電磁波干擾。
- (2) 電源供應必需良好且穩定。電壓波動不得超過 10%。
- (3) 隨時檢查空壓的壓力與品質。如果氣源不穩定，請安裝合適器材以改善。
- (4) 機器操作環境，室溫 5° C ~ 35° C, 相對濕度 35%~85%.
- (5) 為了保護電子元件與安全起見，當有劇烈氣溫變化而導致凝水時，立即關閉並拔除電源，並靜候至完全乾燥為止。
- (6) 為了安全起見，當有打電或閃電時，請停止操作，關閉並拔除電源。
- (7) 勿在機器週遭使用電視或收音機，以避免干擾。
- (8) 依當地法令規範，在操作中採取必要的防護。
- (9) 關於包裝材料，潤滑油品，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

安全注意事項

機器動作範圍 (區域)

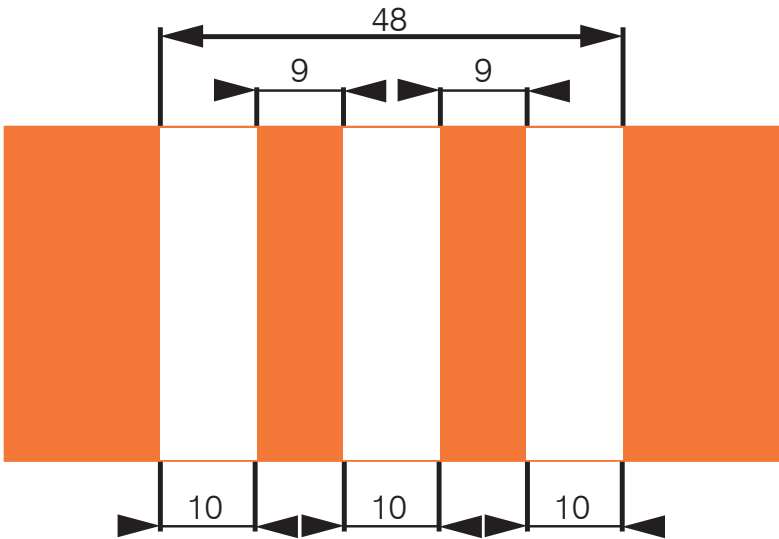


1. 機器在運轉時，不可將手指等放入該區域內。
2. 為了保修、檢修卸掉罩蓋時，必須將電源切到OFF。
3. 在有危及人體的高壓電處，貼有觸電危險警告標記。
在貼有本警告的電器控制部位而需要保修、檢修時，
打開罩蓋僅能由專業的電氣技術人員進行。
4. 機器運轉時，有必要馬上停止機器的時候，可以按下
斷電開關。
5. 電源線、氣壓管線需確實固定安置，不可散落在地面
，以免人員絆倒而發生危險。
6. 為了生命安全，在任何情況下，不可將電源地線拔掉
運轉機器。
7. 打雷時，為了安全要停止作業，切斷電源。
8. 離開機器工作地點時或工作結束後一定要將電源開關
轉到OFF。
9. 機器運轉下，不可卸下罩蓋類。



索引	頁
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設定及調整	4
電控箱參數表	5
貼條輔助送帶裝置調整	6
零件圖	7

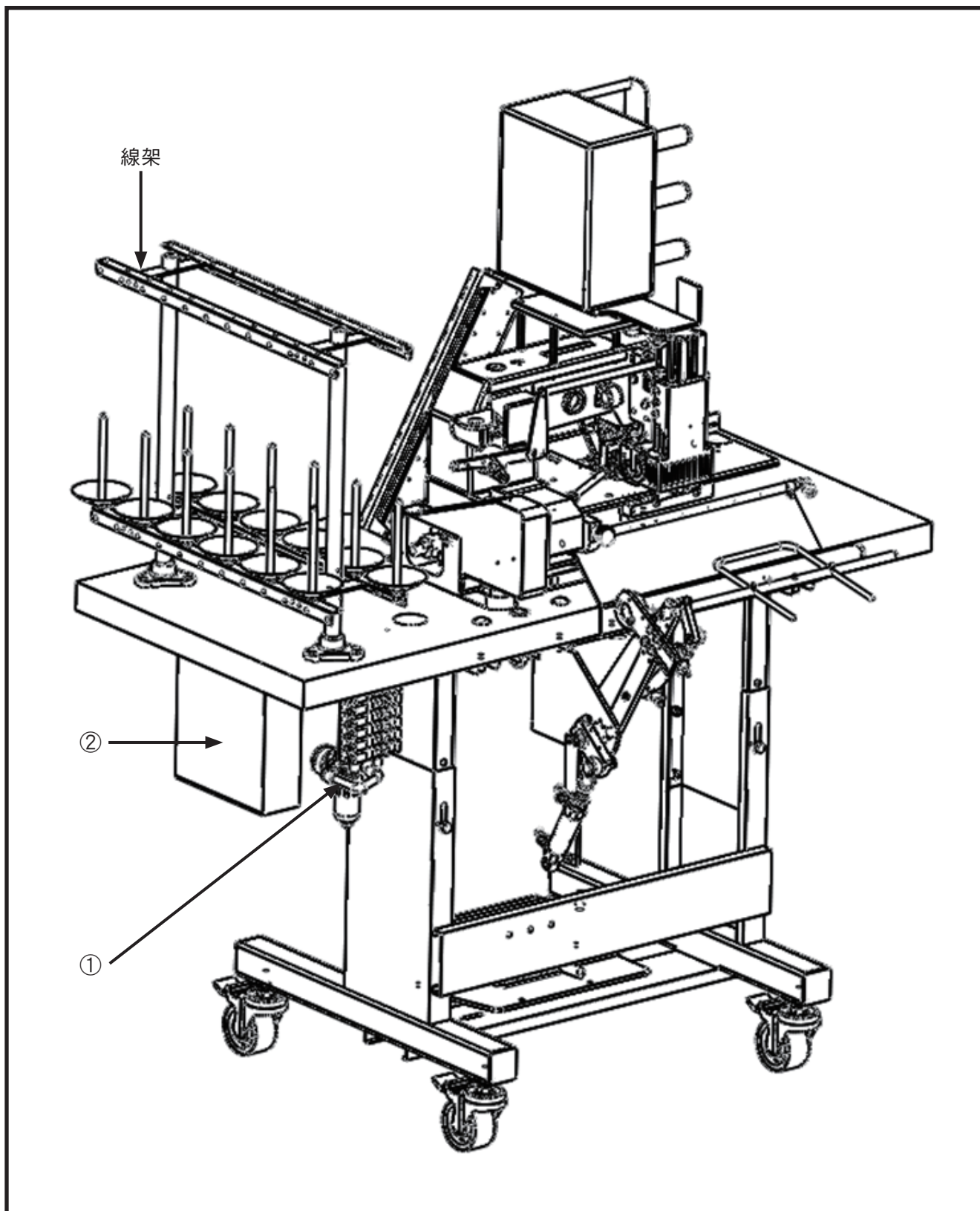
規格

型式	ASV-ATS100A
車縫型式	多針機、上帶車縫 Multineedle, 3-stripe attaching machine
車縫速度	最高 2000 rpm
使用針型	UOX113GS#11
車縫平台寬度	440mm
針距	6.4mm
<p>生產樣式</p> 	
電源電壓	單相 Single-phase AC220-240V 50/60Hz
氣壓	0.5 Mpa (5Kg/c m ²)
氣體消耗量	40 L/ 分 . 40 L/minute

※ 材質限制：基本布長 ≥ 150 mm

安裝

氣壓管接口① 與電控箱電源線②。



操作說明

(1) 電源與氣壓

A. 電壓

使用定額電壓 $220V \pm 10\%$ 。
接地線一定要接地。

B. 氣壓

使用 0.5Mpa (5kg/c m^2)。

(2) 電源開啟

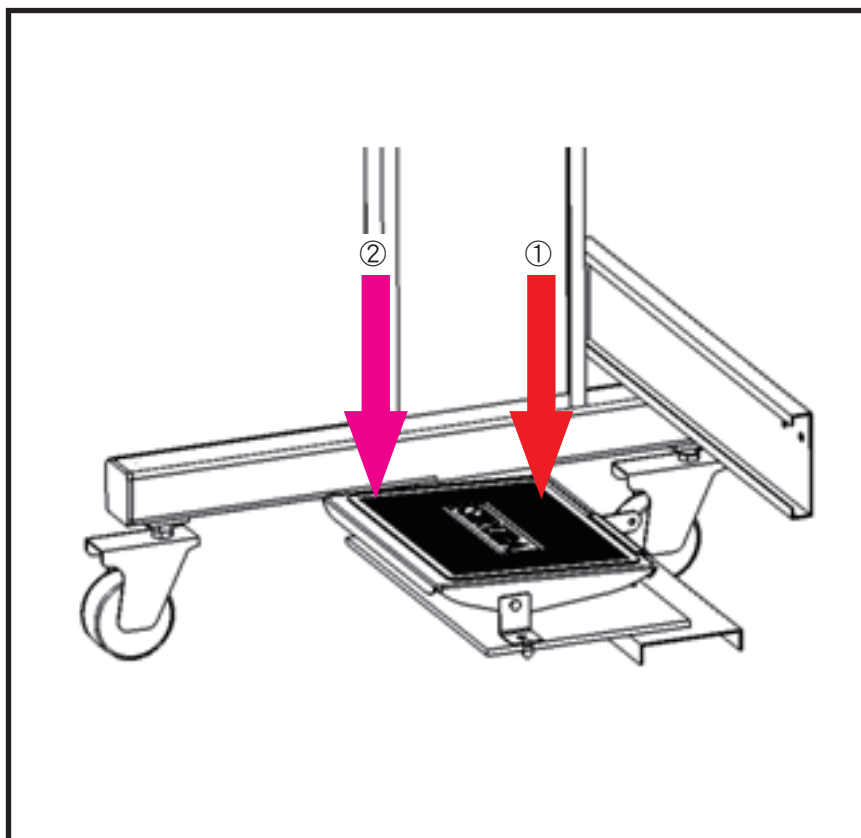
按壓電源 ON 後開啟三貼條輔助裝置電源。

(3) 腳踏板控制

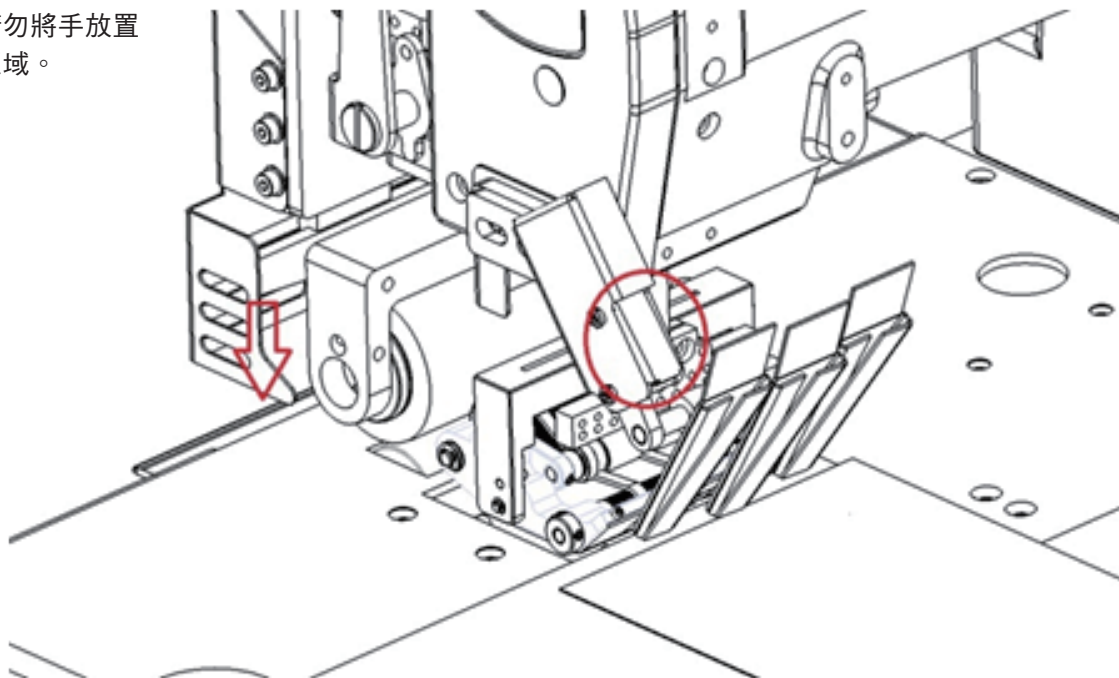
往①方向踩踏控制車縫速度。
往②方向踩踏壓腳抬起。

(4) 切刀微動開關

按下開關，切刀執行一次裁切。



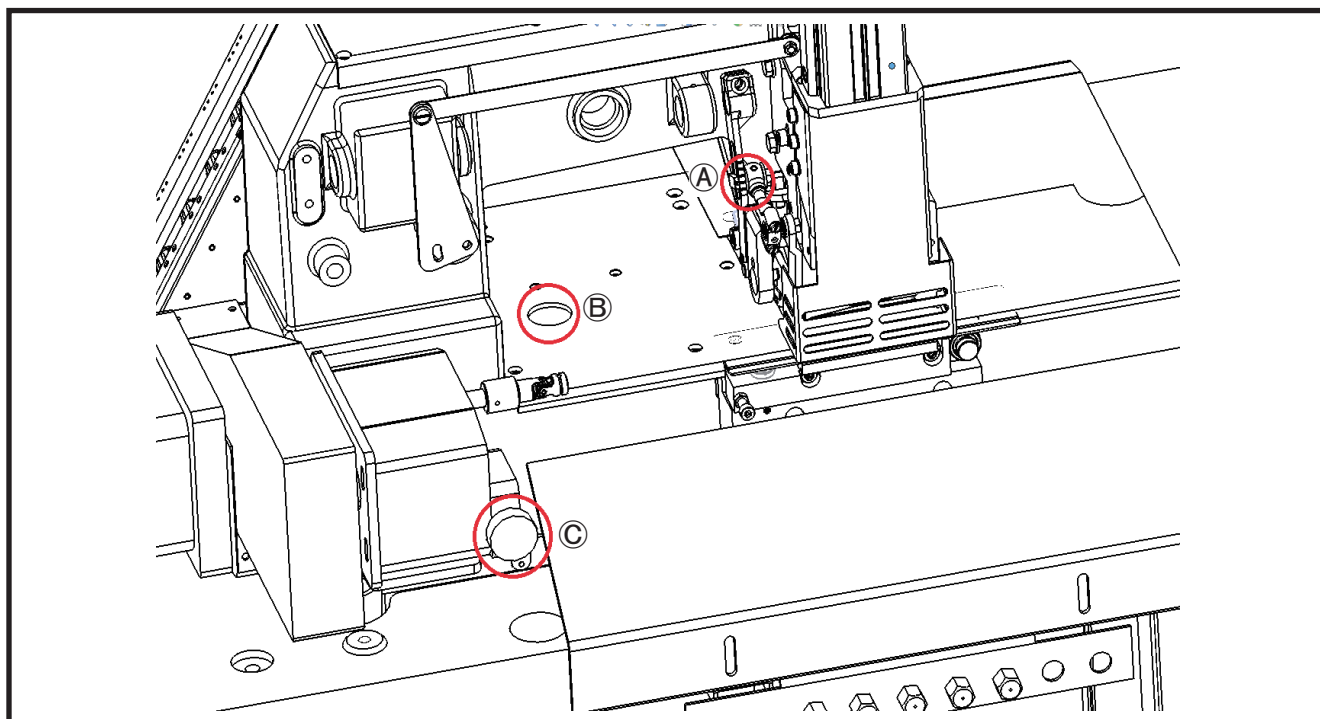
※ 注意請勿將手放置
切刀區域。



設定及調整

(1) 調整

①後帶布輪調整；②送距調整；③送貼條速度調整



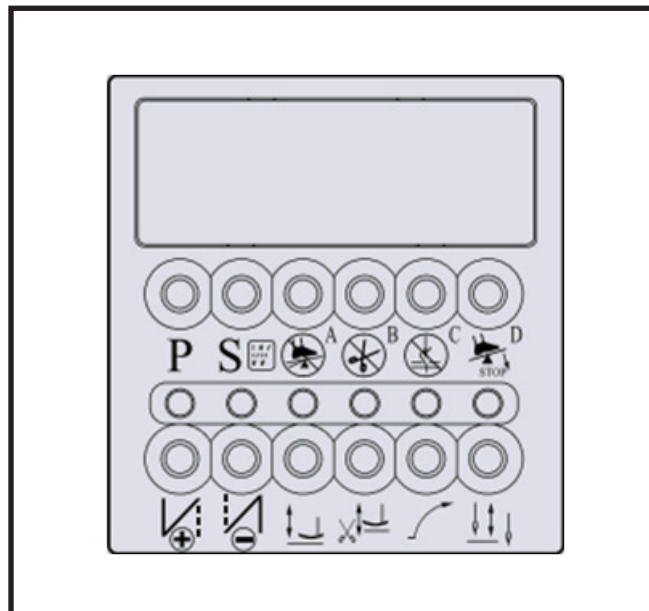
(2) 參數設定

按壓操作面板

A 切換；B 百位數；C 十位數；D 個位數

參數：







面板顯示	調整內容
P5	前切針數。
P6	後切針數。
T7	壓布出力、延遲動作。
T8	壓布出力、動作時間。
T9	吹布出力、延遲動作。
TA	吹布出力、動作時間。
TB	切刀輸出、延遲動作。
TC	夾布出力、延遲動作。
TD	夾布出力、動作時間。



電控箱參數表




參數碼		參數功能	範圍	預先設定	說明
1	H	最大車縫速	50 - 9999 spm	1500	調整最大速度
4	N	前切車縫速度	50 - 8000 spm	200	調整啟動前切縫速度
5	V	後切車縫速度	50 - 8000 spm	200	調整啟動後切縫速度
47	MAC	機器編碼	0 - 101	29	機器編碼轉換
60	L	低速	50 - 500 spm	200	低速調整
97	TK3	斬刀動作時間	0 - 990 毫秒	10	調整斬刀動作時間
114	UEG	針上位置停止角度	5 - 180 度	15	調校針上停位置
206	N1	收料壓布啟動針數	0 - 99 針線	3	針數控制收料壓布氣缸作動

1. 如何輸入不同參數等級？

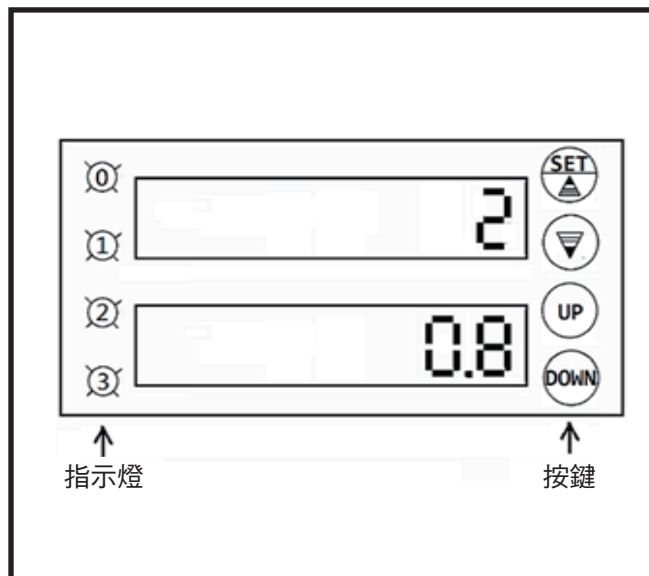
		電源開啟	(等級 1【001-046】)		
	+	電源開啟	(等級 2【047-122】)		
	+	電源開啟	(等級 3【123-251】)		
	+	電源開啟	(等級 4【176-251】)		
	+	電源開啟	(等級 5【208-251】)		
	+		+	電源開啟	(回到出廠設定)




貼條輔助送帶裝置調整

1. 操作面板














指示燈	狀態		
	熄滅 	常亮 	閃爍 
L0_ 異常指示			
L1_(上滾輪)	關閉	開啟	缺料
L2_(中滾輪)	關閉	開啟	缺料
L3_(下滾輪)	關閉	開啟	缺料

位址	功能
D200	(上滾輪)_ 停止延遲時間 (0.1S)
D201	(中滾輪)_ 停止延遲時間 (0.1S)
D202	(下滾輪)_ 停止延遲時間 (0.1S)
D203	異常停機時間 (0.1S)



按鍵	功能
	(上滾輪)_ 關閉 / 開啟
	(中滾輪)_ 關閉 / 開啟
	(下滾輪)_ 關閉 / 開啟

2. 參數設定 (1~4)& 開啟 / 關閉 (5~8)

- (1) 押著  鍵 3 秒鐘以上進入參數設定。
- (2) 利用  或  鍵，選擇欲修改之參數位址 (D200、D201、D202、D203……)
- (3) 利用  或  鍵，增加 (減少) 參數之數值。
- (4) 押著  鍵 3 秒鐘以上退出參數設定。
- (5) 押  鍵 2 秒以上滾輪 " 開啟 "(L1 常亮)、再押  鍵 2 秒以上滾輪 " 關閉 "(L1 熄滅)。
依序循環，同時顯示 D200(上滾輪 _ 停止延遲時間 (S))。
- (6) 押  鍵 2 秒以中滾輪 " 開啟 "(L2 常亮)、再押  鍵 2 秒以中滾輪 " 關閉 "(L2 熄滅)。
依序循環，同時顯示 D201(中滾輪 _ 停止延遲時間 (S))
- (7) 押  鍵 2 秒以下滾輪 " 開啟 "(L3 常亮)、再押  鍵 2 秒以下滾輪 " 關閉 "(L3 熄滅)。
依序循環，同時顯示 D202(下滾輪 _ 停止延遲時間 (S))
- (8) 異常時，L0 閃爍，外部異常燈與蜂鳴器同時動作 (可輕押一次  鍵關閉蜂鳴器)。

SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASV-ATS100	ATS-0002-A		1 / 1
				Date

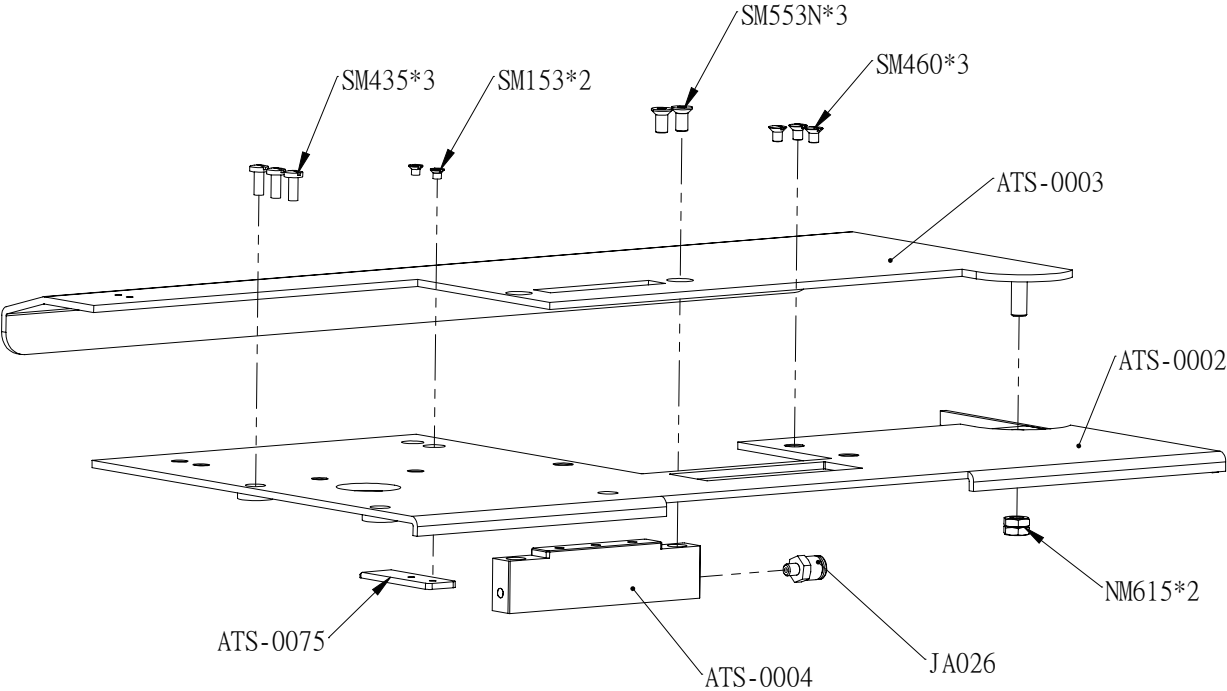
A

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E



SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASV-ATS100	ATS-0005-A		1 / 1
				Date

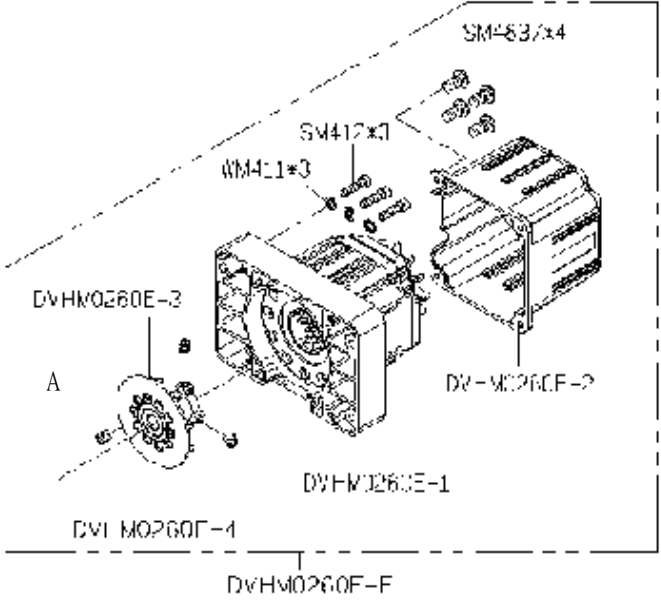
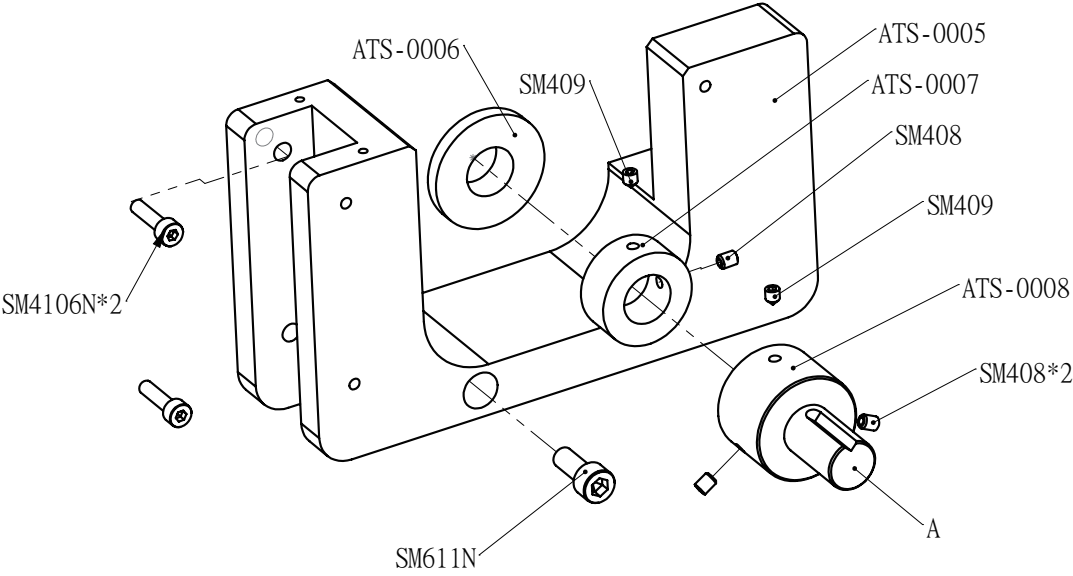
A

B

C

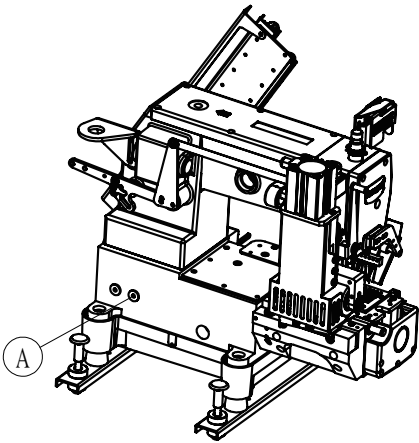
D

E



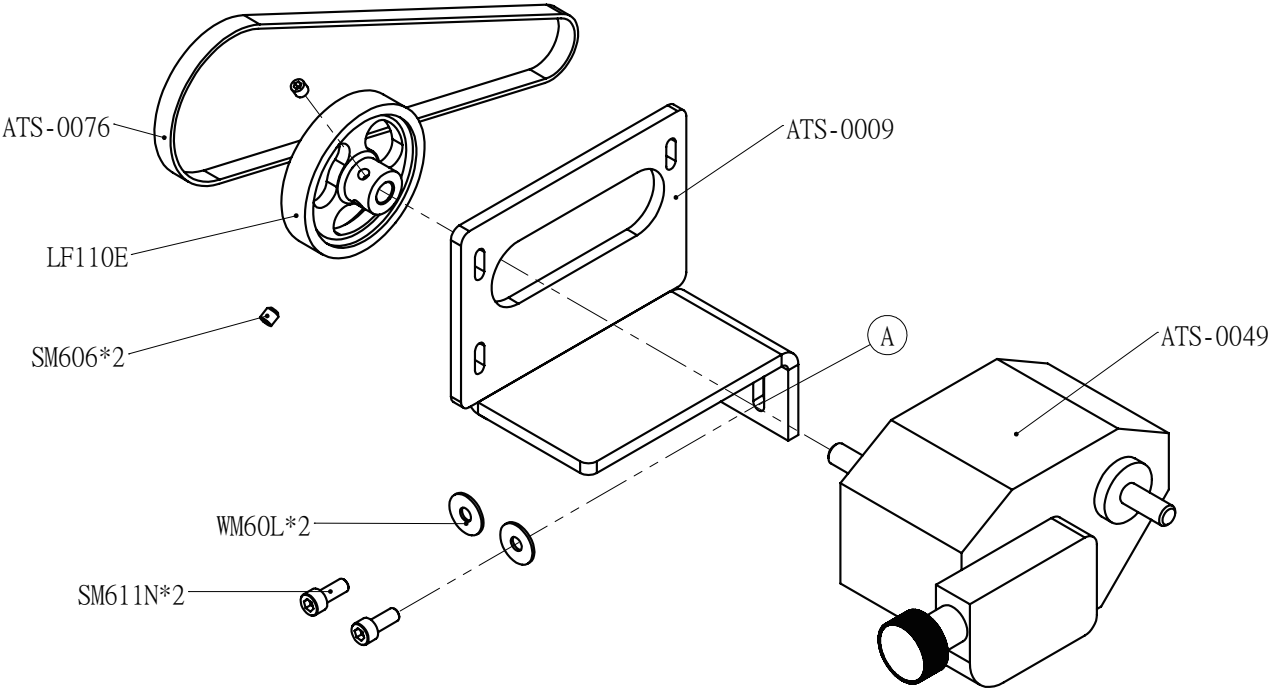
SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
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				Date

A



B

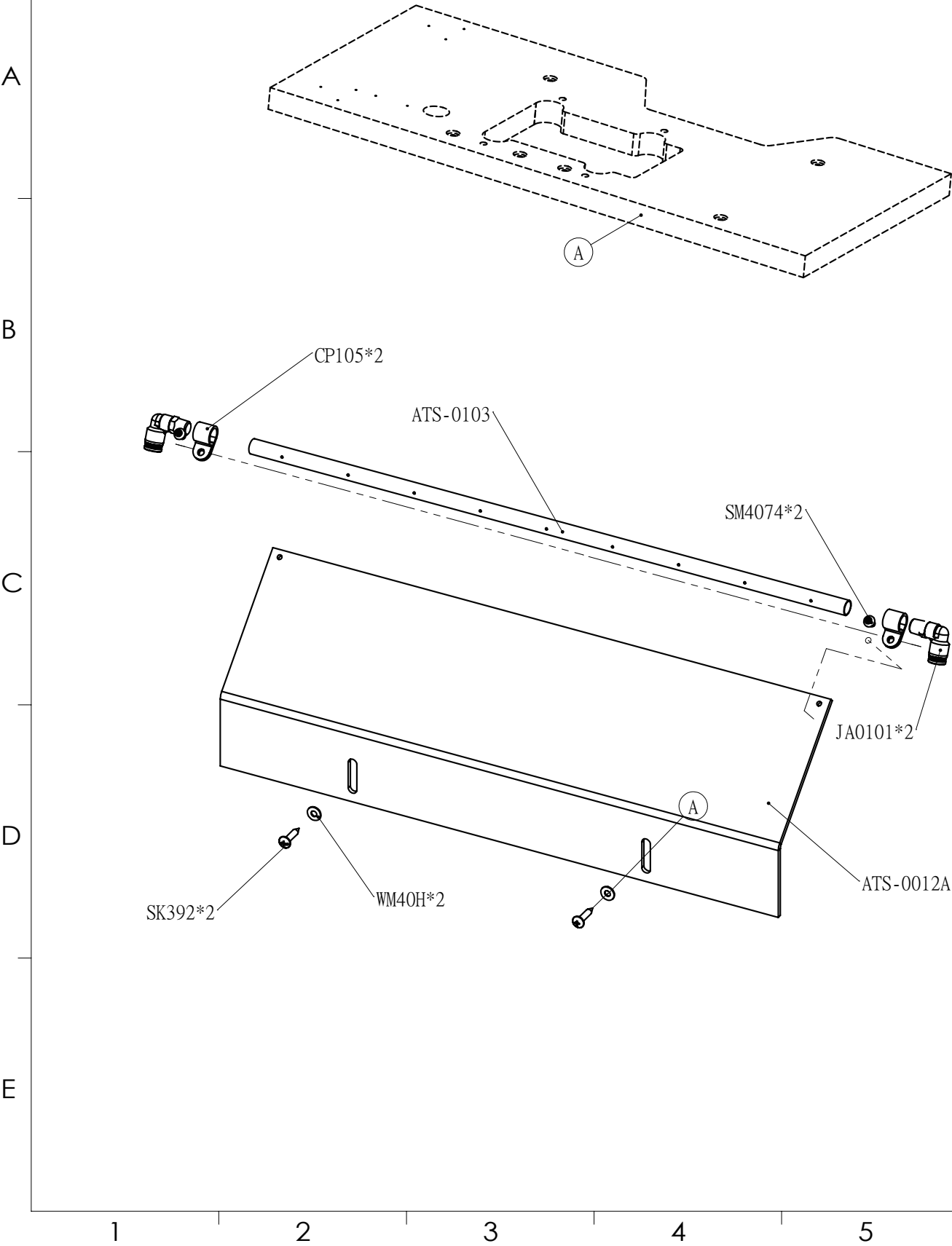
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<div>SIRUBA</div> <div>PARTS LIST</div>	Series	Parts Group	Subclass Remark	Page
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				Date

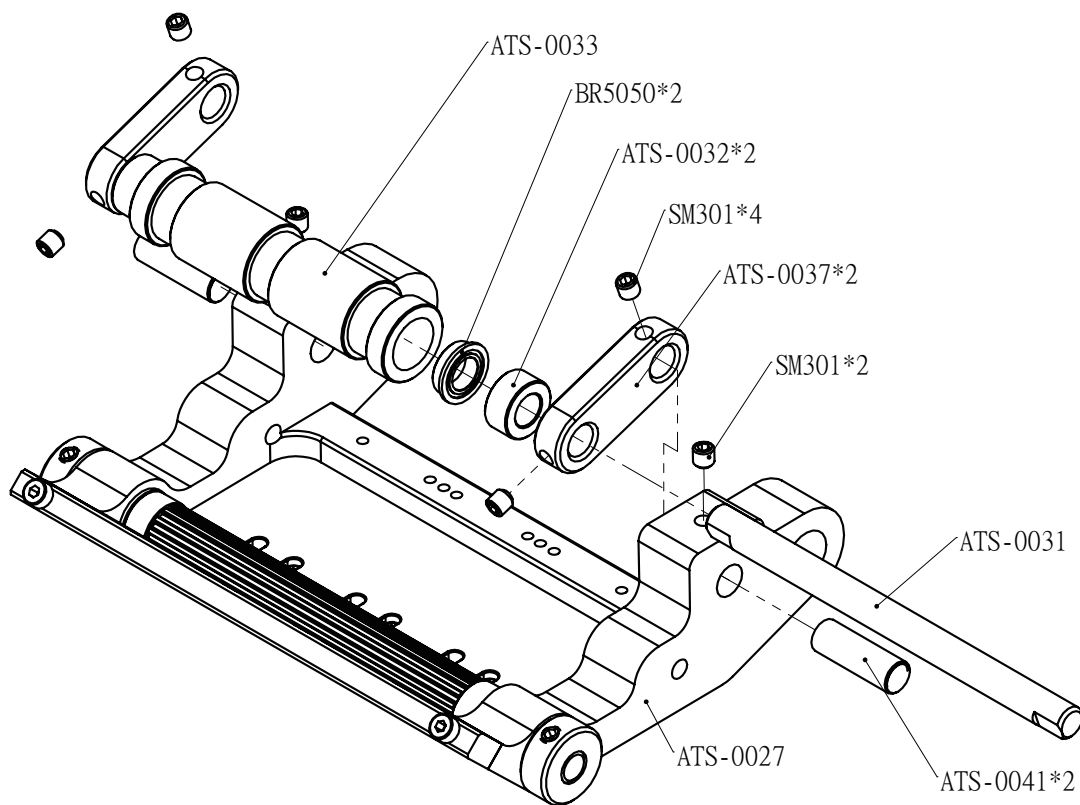
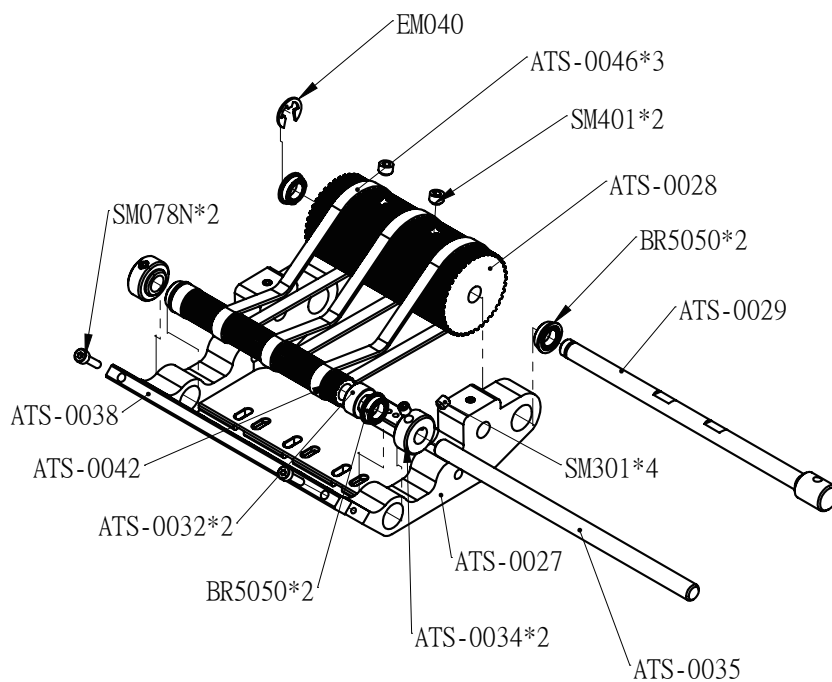
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1

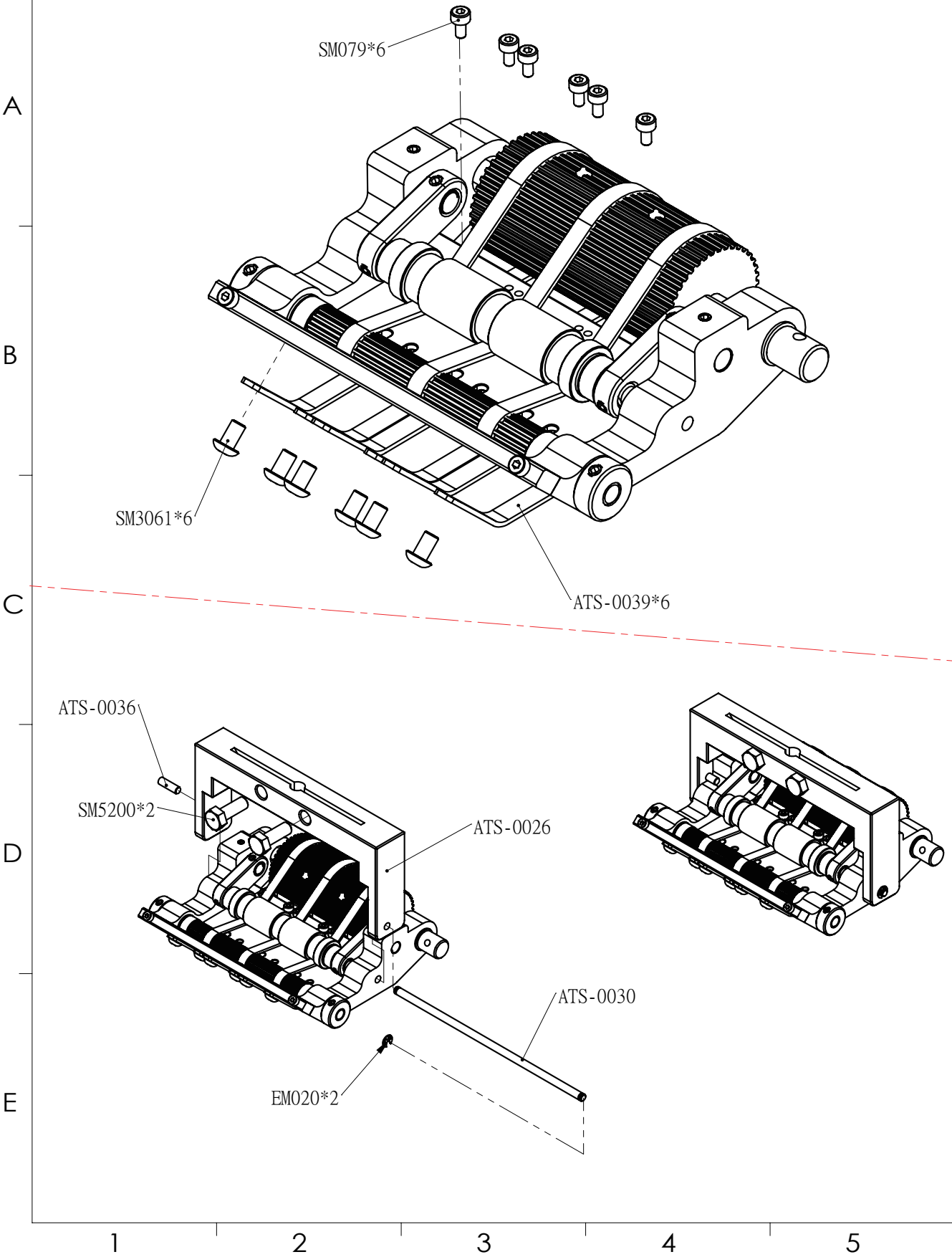
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3

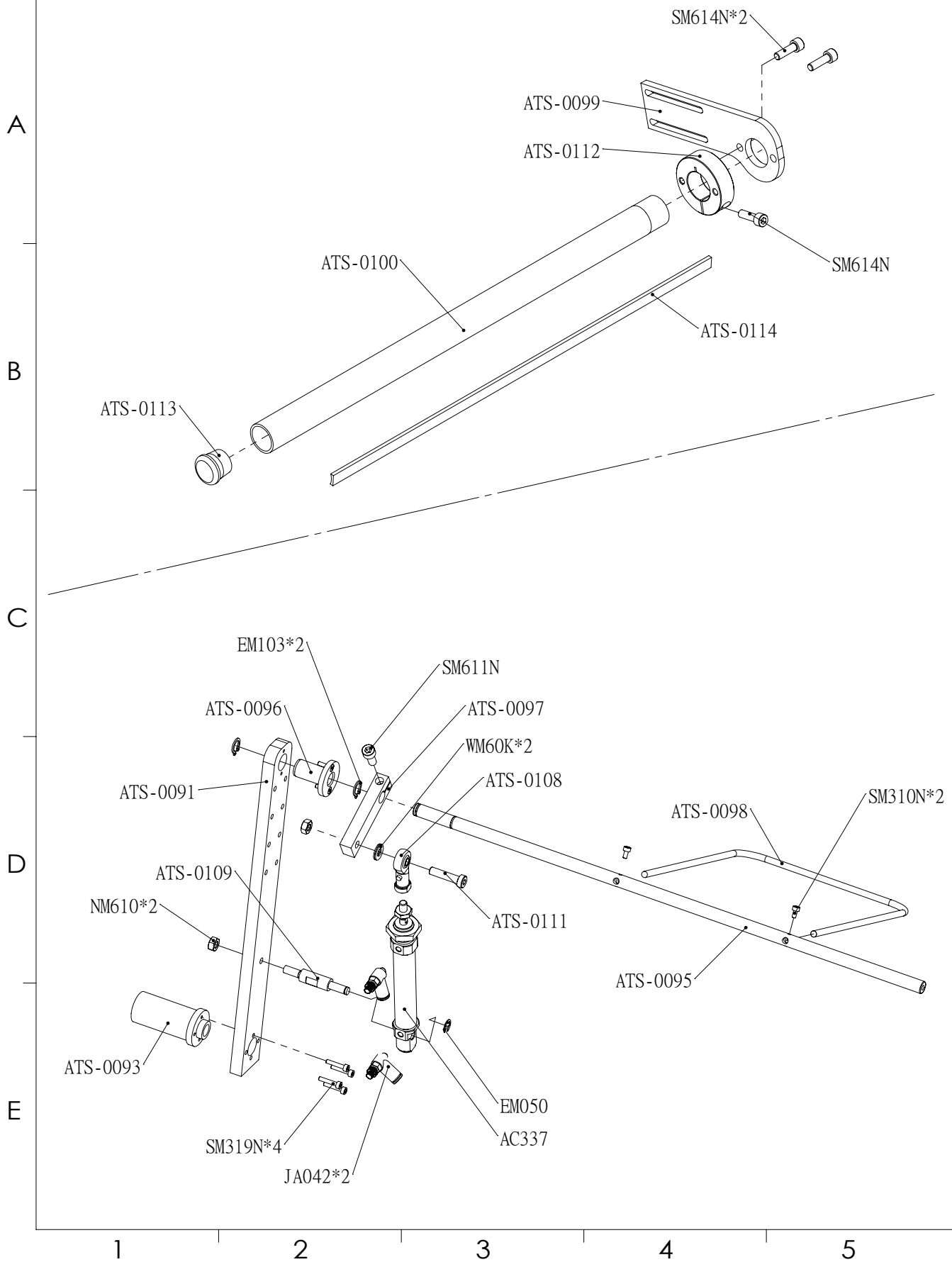
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SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
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				Date



<div>SIRUBA</div> <div>PARTS LIST</div>	Series	Parts Group	Subclass Remark	Page
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SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
		ATS-0090-A		2 / 3
				Date

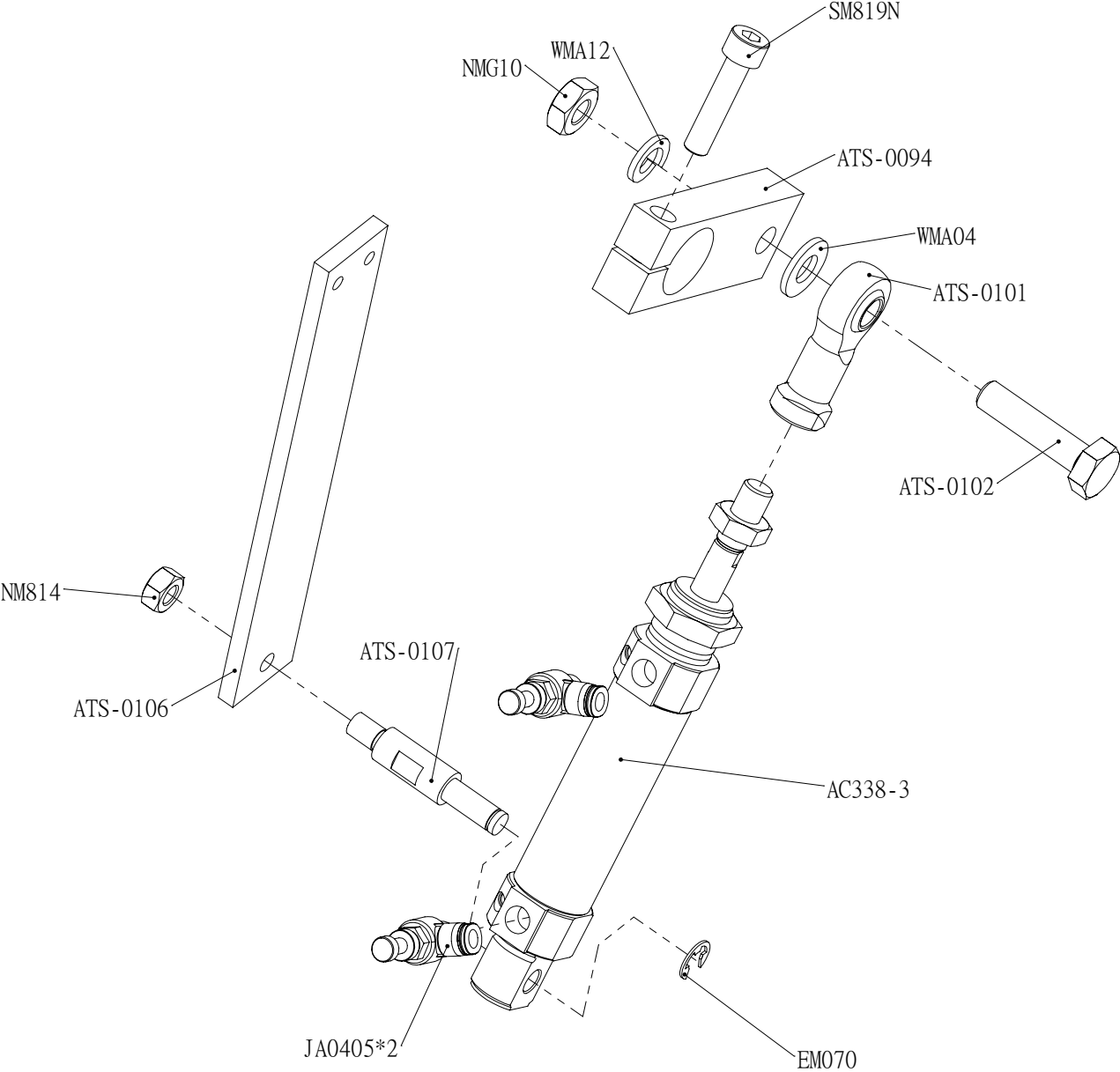
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				Date

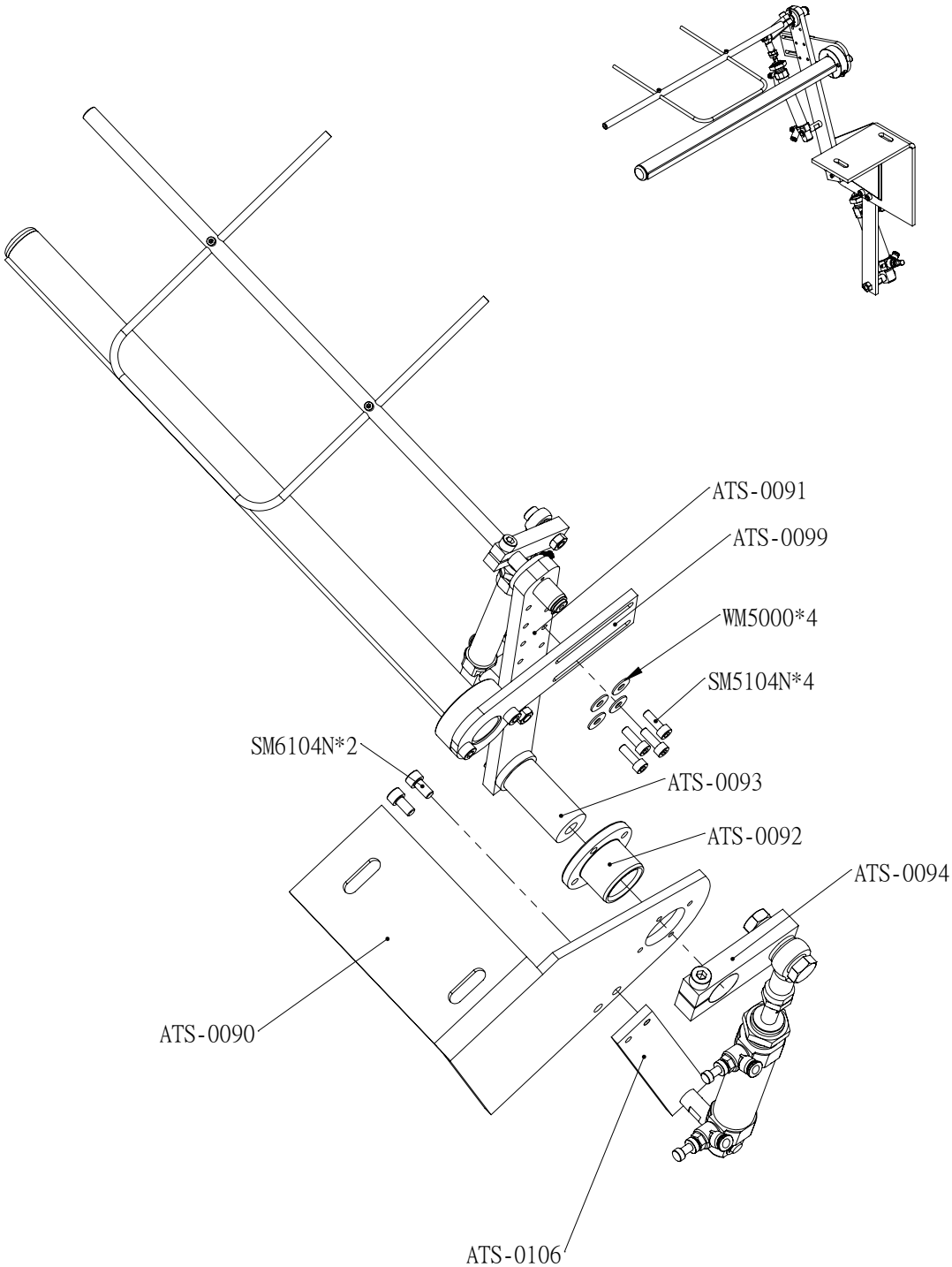
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高林股份有限公司
KAULIN MFG. CO., LTD.

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.
ASV-ATS100A.FEB.2020