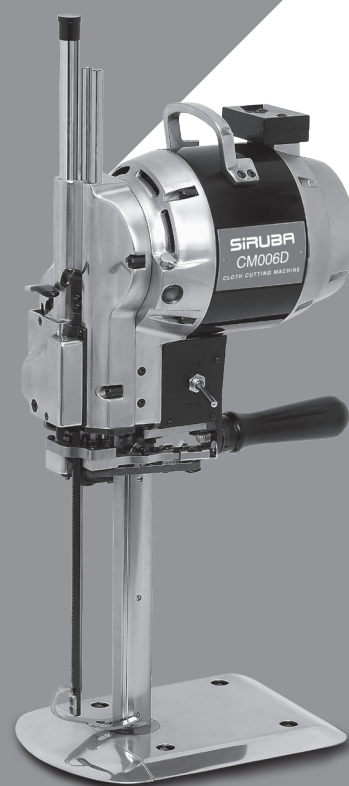


SIRUBA

使用説明書

INSTRUCTION BOOK

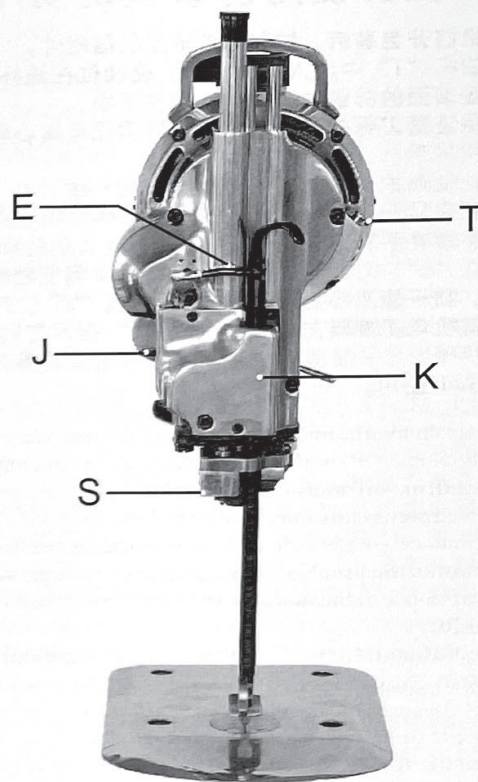
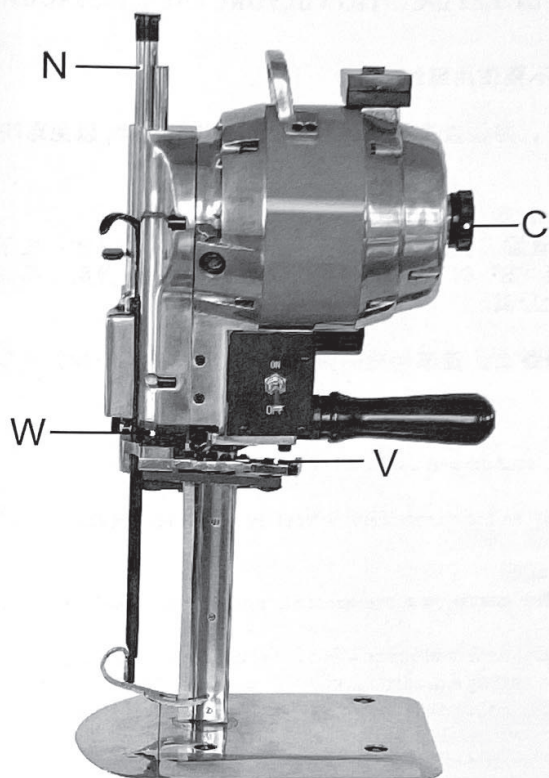
■ CM006D



CE

一、机器使用前事项说明 PLEASE READ THE EXPLANATION BEFORE USE THE MACHINE

- 1、新机打开包装后，按装箱单清点机器附件。
 - 2、向油杯“T”中注入30号机油，使油位在油杯标线之间，注意不要使用缝纫机油。
 - 3、机器表面的防锈油及油迹应擦洗干净。
 - 4、要保证磨刀器在自锁位置（即磨擦轮与偏心轮处于分离状态），并检查磨擦轮是否有油污，请擦干净，以免影响磨刀机构转动。
 - 5、保证使用的电压与机器所需电压相一致。
 - 6、开关应置于OFF位置，电源处应有接地线装置，插座接触良好牢固。
 - 7、用手旋转手轮“C”使刀片上下往复运动轻滑，若不轻滑，检查磨刀器的位置是否在自锁状态；调整方法：按下磨刀手柄“E”和抬起变向拨叉“J”到中间空档位置，并将磨刀架“S”向下移位，然后迅速将磨刀架稍微用力推向最上端，松开磨刀手柄“E”、变向拨叉“J”，使摩擦轮与偏心轮分离。
 - 8、裁剪机电机旋转方向应和手轮“C”指示方向一致。
 - 9、新机器或冬季使用前，在正常接通电源的情况下，应反复开闭数次，使部件充分润滑，然后空转3-5分钟，无异常现象方可使用。
- 1、Please check the amount of parts after open the package.
 - 2、Fill the tank "T" with No. 30 motor oil to reach the mark of oil tank, and do not use sewing machine oil.
 - 3、The antirust oil and smear of surface must be scrubbed away.
 - 4、The sharpener must be always in the locked position (friction-wheel and eccentricity wheel in the separate state), and the friction-wheel must clean to avoid turning malfunction.
 - 5、Guarantee the used voltage being in agreement with machine's voltage.
 - 6、On-off must in the position of "OFF", electrical source must have the earth-line equipment, and the terminal contact must all right.
 - 7、Turn the hand wheel "C" by hand to make the knife pump swimmingly, and must check the locked position of sharpener if not smooth. Adjust method: press the operating handle "E" of sharpener and uplift card ejector "J" to the middle position of zero shift, and move down the sharpener block to the topping position, finally loosen the operating handle "E" and card ejector "J" to separate the friction-wheel from the eccentricity wheel.
 - 8、Turning direction of cutting machine must being in agreement with the direction of hand wheel "c".
 - 9、The new machine or the machine be used before the winter, which must be turned on and turned off many times after turn-on the electrical source to make parts lubricant, it can be used after racing 3-5 minutes then have no abnormality.

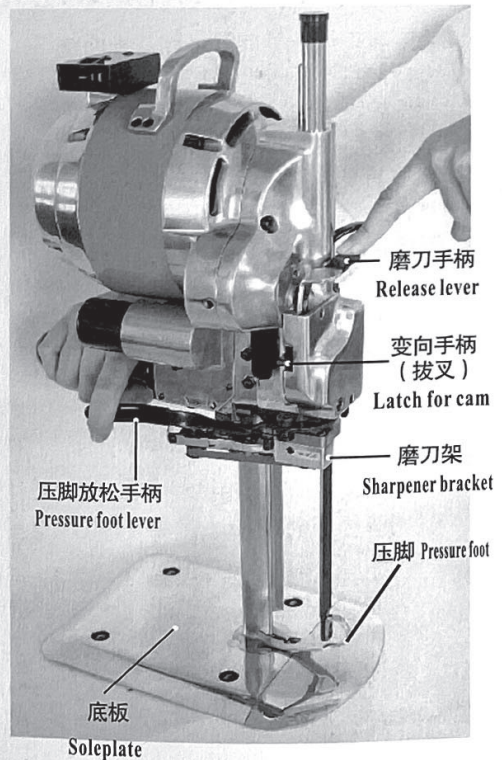


二、磨刀器的使用说明 OPERATING EXPLANATION

- 1、将机器离开裁料；
- 2、用手按动压脚放松手柄，将压脚与底板面接触；
- 3、用力慢慢按下磨刀手柄后松开，磨刀架向下移动再向上返回，同时驱动砂带旋转，对刀片进行磨削，一般经过磨削2-3次，刀片即可锋利。
- 1、Put the machine away from the sewing materials.
- 2、Press the pressure foot lever by hand, and connect the pressure foot with soleplate.
- 3、Slowly press the Release lever and then loosen, sharpener bracket move down and up returns again, simultaneity it drive abrasive belts to circumrotate and sharpen the knife, and the knife is sharp commonly after 2-3 times sharpening.

⚠ 注意事项 NOTICE

- 1、机器在裁剪时，切勿磨刀；
- 2、磨刀器正在磨刀时，切勿关掉电源；
- 3、机器未装刀片时，切勿磨刀以免造成机器的损坏；
- 4、按下磨刀手柄时，手要离开，否则磨刀架会停在某一高度位置，使刀片磨削不均；
- 5、按手柄时，切勿太快，以免引起磨刀手柄自锁，出现卡死现象。
- 1、Don't operate sharpener while cutting materials lay in machine.
- 2、Don't shut off motor while sharpener is in motion.
- 3、Don't operate sharpener without knife in machine.
- 4、When pressing Release lever, keep hand away, or else Sharpener stops at a certain height so that sharpener can't uniformly
- 5、Don't press lever so fast, or it will in the locked position.

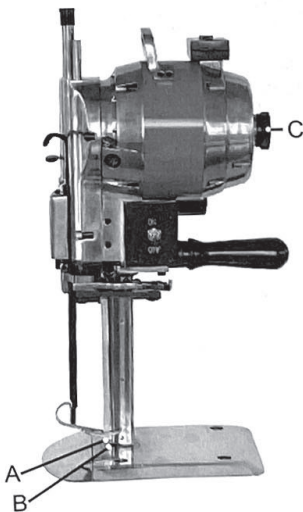


三、换刀片 CHANGE KNIFE

- 1、调整磨刀器处于自锁位置，保证偏心轮与磨擦轮分离状态。
- 2、用手转动手轮“C”，使刀片处于最低位置，抬起压脚到最上端，用四角套筒专用搬手松开刀片紧固方头螺钉，从立柱底部取出刀片。
- 3、用除尘器清除堆积在立柱刀壳槽中绒毛。
- 1、Adjust sharpener to the locked position and guarantee the friction wheel and eccentricity wheel in the separate state.
- 2、Turn hand wheel "C" by hand to make knife in the lowest position and uplift pressure foot to the topping position, then loosen knife square bolt with four-foot sleeve and take out knife from bottom of pillar.
- 3、Clean the dust in the knife slot of pillar by dust catcher.

⚠ 注意事项 NOTICE

- 1、更换刀片前，必须切断电源，旋转电机后端的手轮“C”使刀片处于最下端。
- 2、刀片装入后，应使刀锋转角点“A”处于脚板平面“B”2-3mm。转动手轮“C”，确保刀片上下轻滑，否则应重新调整。
- 3、紧固刀片螺钉时，用手扶住刀片，防止刀片向前移位。
- 4、开动磨刀器，检查磨刀器是否正常。
- 1、Must shut off the motor and turn hand wheel "C" of back-end to below before change knife.
- 2、The blade corner point "A" must in the baseboard plane "B" 2-3mm after encase knife, and turn hand wheel "C" to guarantee knife fluctuate swimmingly.
- 3、Buttress knife and rivet the position by hand while screw down square head screw.
- 4、Turn on sharpener and check it whether or not in gear.

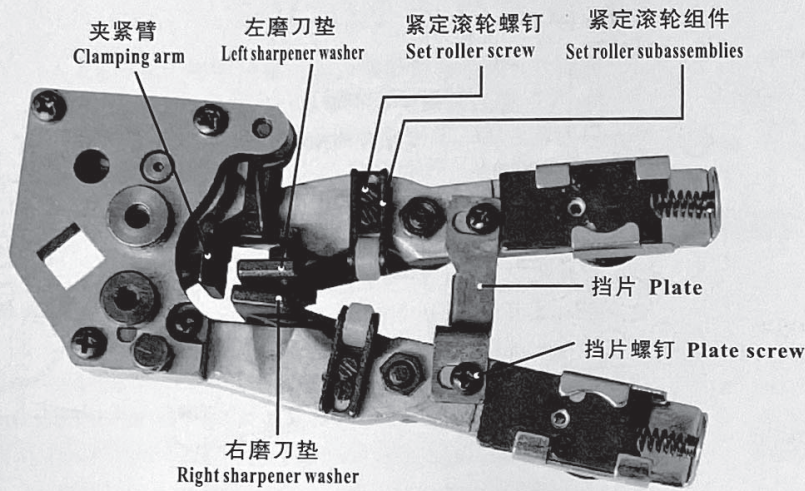


四、磨刀器的调整(切断电源) ADJUST SHARPENER (SHUT OFF ELECTRICAL SOURCE)

(一) 紧定滚轮架的调整 Adjust the set roller bracket

- 1、按下磨刀手柄在中间空档位置，将磨刀架移到下端位置松开挡片螺钉，使立柱与挡片分开；
- 2、松开左右紧定滚轮组件螺钉，调整左右紧定滚轮架对应的紧固螺钉；
- 3、将立柱挡片调至到靠住立柱，紧固挡片螺钉，保证磨刀架上下运动时，紧定滚轮沿着立柱两侧滚动不被卡住。

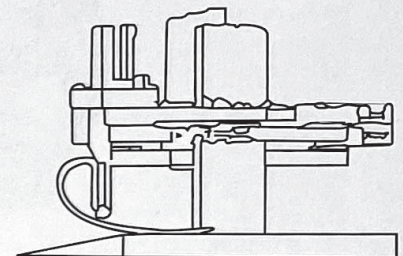
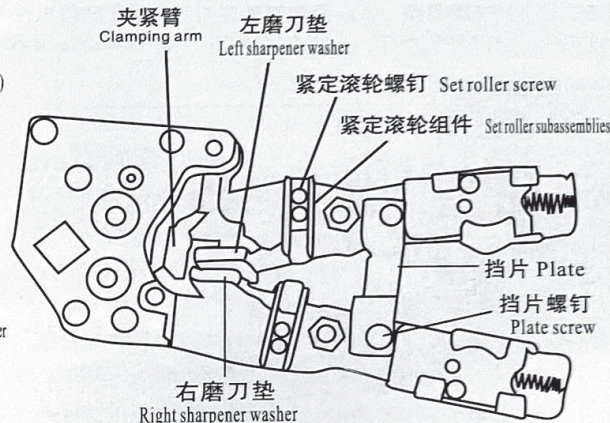
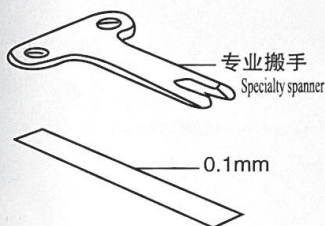
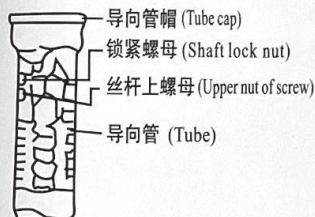
- 1、Press release lever to the middle blank shift, then loosen plate screw while sharpener bracket move to end position, and separate the pedestal from plate.
- 2、Loosen the left & right set roller subassemblies screw, then adjust binding screw of left & right set roller bracket.
- 3、Adjust pedestal plate against pedestal and bind plate screw to guarantee set roller rolling along the two side of pedestal while the sharpener pump.



(二) 磨刀垫及夹紧臂的调整 Adjust sharpener washer and clamping arm

- 1、左右磨刀垫应能自由转动，上下不允许有窜动，磨刀架上下运动过程中夹紧臂能起到固定磨刀垫作用；
- 2、若夹紧臂或左磨刀垫上的齿纹磨损，应立即更换；
- 3、磨刀架上装砂带时，左磨刀垫上的固定螺钉和刀片之间应确保0.1mm的间隙，如需调整，松开螺母将螺钉调整到规定要求的位置，再将螺母紧固。

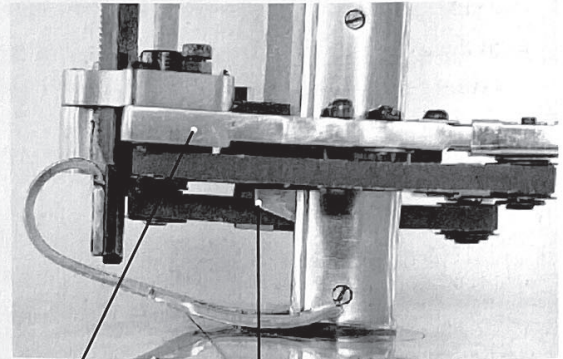
- 1、Right-and-left sharpener washer must turn freely and which not be patient of change, and clamping arm must rivet the sharpener washer while it pumping.
- 2、It must be changed at once if tooth veins of clamping arm or left sharpener washer were frayed.
- 3、Left sharpener washer must insure 0.1mm clearance between the settled screw and knife when fixing abrasive belts, and loosen nut adjust screw to the request position if need adjust.



(三) 磨刀器下限位置的调整 Adjust lower limit position of sharpener

- 1、当磨刀器上的磨刀架处于最低端位置，刀片处于最高端位置时，刀片的转角刀尖应在左磨刀垫上的砂带中间处，如砂带位置太高，刀片的尖部磨不到，如砂带位置太低，刀片的底部易将砂带戳掉，造成转角刀尖部磨成圆弧状。
- 2、将导向管上拆掉导向管帽。
- 3、将销插入导向管孔，防止丝杆上螺母转动，用搬手拆下锁紧螺母。
- 4、用螺旋或专用搬手调整，顺时针旋转，升高磨刀架下极限位置，逆时针旋转，降低磨刀架其下极限位置。(注：丝杆螺母转一圈，位移约0.8mm)
- 5、调整到正确位置后，装入锁紧螺母再插入销子挡住丝杆螺母，防止转动，拧紧锁紧螺母即可。

- 1、The corner knife point must in the middle of abrasive belts of sharpener washer while sharpener bracket in the lowest position and knife in the topping position, if position of abrasive belts too high or too low, the knife point will not to grind abrasive belts and the bottom of knife will tear abrasive belts and make knife wear to circular arc.
- 2、Remove tube cap from tube.
- 3、Insert pin in the tube and rivet upper nut of screw, then dismantle locknut with spanner.
- 4、Adjust sharpener bracket with screw or spanner, clockwise turning will hoist below limit position of sharpener bracket, and contrarotating will low below limit position of sharpener bracket. (Annotating: upper nut of screw move about 0.8mm per circuit.)
- 5、Cased locknut and insert it in pin to rivet upper nut of screw, and then screw down the locknut after adjust the right position.



磨刀架最低位置
Lowest position of sharpener bracket

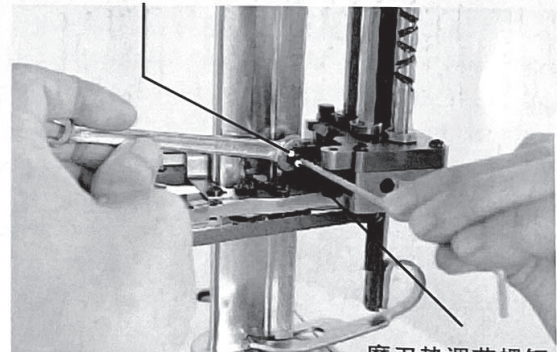
刀片最高位置
Topping position of knife

(四) 刀片磨削宽度的调整 Adjust grinding width of knife

- 1、刀片两侧磨削宽度大约1/12 (相当于1.2mm)。
- 2、装入新砂带和刀片时，在刀片刃口涂色，操作磨刀器，确保两侧刀刃磨削均匀，上下宽度一致，且不会出现卷刃现象；如需调整参照紧定滚轮架的调整方法。
- 3、当刀片磨损到2-3mm时，应适当调整左磨刀垫角度。方法：用扳 手放松左磨刀垫调节螺母，再用内六角扳手逆时针倒退，要求并使调节螺钉和刀片之间确保0.1mm的间隙，再将螺母紧固。如刀片磨损到4-5mm时，更换新刀片，调整左磨刀垫调节螺钉，保证刀片左右面磨削宽度一致。

- 1、Two sides grinding width of knife is about 1/12 (equal 1.2mm).
- 2、Paint the edge of knife and operating sharpener to guarantee two sides edge grinding symmetrical and equal width also not frizzy edge while cased new abrasive belts and knife. Please reference to the adjusting method of set roller bracket if need to adjust.
- 3、Must adjust the corner of left sharpener washer while edge is grinded to 2-3mm. Method: Loosen adjusting nut of left sharpener washer with spanner and contrarotate with socket head wrench to guarantee 0.1 mm clearance between adjusting screw and knife, then tighten the nut. Must change new knife and adjust the adjusting nut of left sharpener washer to guarantee the equal width, if knife is grinded to 4-5mm.

左磨刀垫调节螺母
Adjusting nut of left sharpener washer

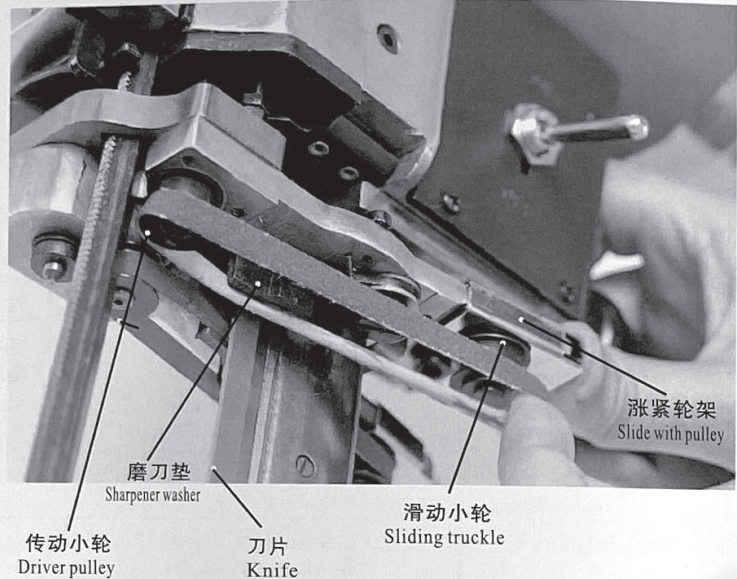


磨刀垫调节螺钉
Adjusting nut of sharpener washer

五、换砂带 CHANGE ABRASIVE BELTS

- 1、切断电源，磨刀器处于自锁位置，保证偏心轮与磨擦轮分离状态；
- 2、用手按下涨紧轮架，放松砂带张力，取下磨损的砂带；
- 3、将新砂带套入传动小轮中，砂带应确保放在磨刀垫与刀片之间，推动涨紧轮架，砂带套入滑动小轮上，用手转动滑动小轮砂带应旋转灵活。

- 1、Sharpener in the locked position while shut off electrical source, and guarantee friction wheel and eccentricity wheel in the separate state.
- 2、Press slide with pulley to loosen the abrasive belts and take off the grind ed abrasive belts by hand.
- 3、Enclose new abrasive belts to driver pulley and which must between sharpener washer and knife, then drive slide with pulley and enclose abrasive belts to sliding truckle, and which must turn neatly.



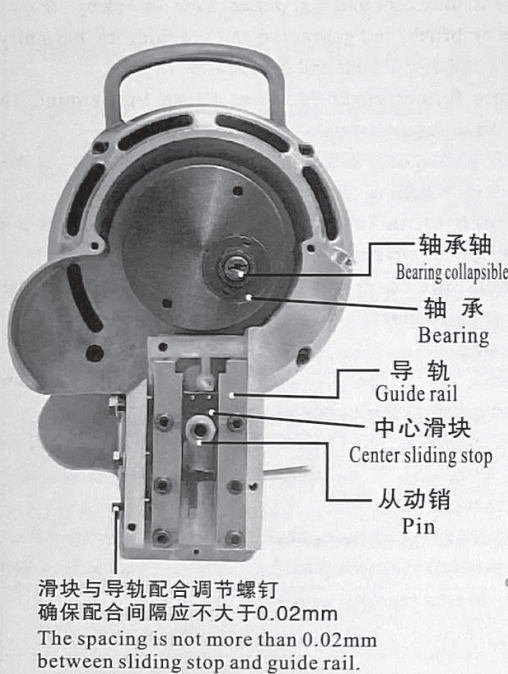
六、机器的故障分析及维修方法 MALFUNCTION&MAINTAINING

故障 Malfunction	主要原因 Main causes	检修方法 Maintaining method
电机起动时间过长(超过三秒钟) Start-up time of motor is too long (over three seconds)	电机线路, 开关接触不良 Switch of motor circuitry has poor contact.	清除电机内部的灰尘, 检查扭子开关, 离心开关, 电容器, 插座处是否有虚焊或脱落, 离心开关触点是否有绒毛或回弹失灵, 如有绒毛或切断器触点回弹失灵, 请拆下防尘盖用干净的布条将触点间的绒毛擦干净或更换零件。 Clean lint of motor and check various malfunctions such as switch, automatic cutting-out switch, capacitor, if receptacle has bad jointing or desquamation, and automatic cutting-out switch has lint or spring not working, please clean lint or change parts with cloth if it has lint or no spring.
	电机绕组断开 Motor winding has disconnection	拆下电机用万能表检测 Dismantle motor and check with omnipotent instrument
	电容损坏 Capacitance was shattered	诊断是否通路或断路、短路(用万能表检测) Diagnose the motor if well contact, turnoff or short by omnipotent instrument.
	使用电压低 Voltage is too low	标准要求定额 $\pm 10\%$, 应检查电压是否正常, 或使用电线太长。 Standard request ration is $\pm 10\%$, must check if the voltage well-balanced or electrical wire is too long.
	油粘度过高 Oil viscosity is too high	换30号机油 Change No.30 motor oil.
	机架部位滞重、偏重 Bracket is too heavy	参照机器使用前(一)第7、9条操作 Operating reference to No.7 and No.9 of first explanation before use the machine.

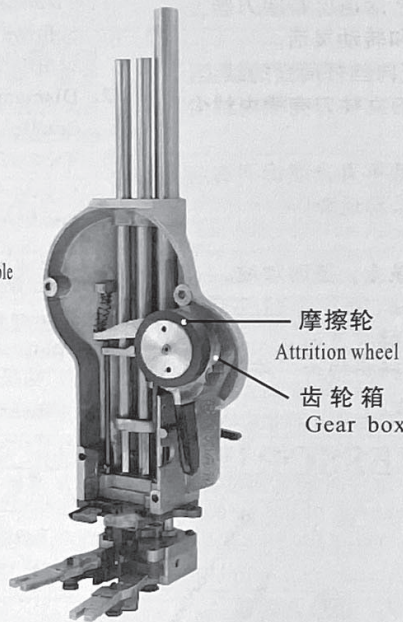
故障 Malfunction	主要原因 Main causes	检修方法 Maintaining method
启动磨刀手柄, 磨刀架不工作 Sharpener bracket not work while starting the sharpener handle.	磨擦轮与偏心轮分离状态 Friction-wheel and eccentricity wheel in the separate state	更换磨擦轮 Change attrition wheel
	磨擦轮或偏心轮沾油污迹 Friction-wheel or eccentricity wheel is smeary.	用干布擦干油污 Erase smear with dry cloth
	按下磨刀手柄时用力过猛或过快 It is overexert or too fast when press the sharpener handle.	请抬起变向柄(拨叉)重新启动, 几次后便知道怎样的力度最合适, 磨刀时应缓慢或稍微用力。 Please uplift the latch for cam to start again and you should know only strength for it, and then sharpen tardily and slightly.
磨刀不锋利 Sharpener obtuse	砂带损坏或刀片已磨窄、磨刀垫严重磨损 Abrasive belts, knife or sharpener washer is badly frayed.	换新的砂带或刀片、磨刀垫。参照三、四(四)、五。 Change the new abrasive belts, knife or sharpener washer. Refer to items such as three, No.4 of four, and five.
噪声大 Big noise	中心滑块与导轨之间间隙太大 Clearance is too big between center sliding stop and guide rail.	拆下连杆, 调整中心滑块与导轨, 使间隙不大于0.02mm, 且中心滑块上下运动轻滑自如(见附图一)。 Take off joint screw and adjust the clearance to not more 0.02mm between center sliding stop and guide rail, and center sliding stop turn freely. (Refer to figure one)
	偏心轮上的轴承磨损严重 Bearing of eccentricity wheel was badly frayed.	拆下偏心轮, 旋下轴承盖, 取出更换轴承。(见附图一) Take off eccentricity wheel and screw off bearing cover, and then take out changed bearing. (Refer to figure one)
	连杆与轴承或滑块纵动销有窜动 Remove between connecting rod and bearing or sliding stop pin.	调整连杆与轴承及从动销的配合, 拧紧牢固 Adjust juncture between joint screw and bearing, and then screw down it.
	磨擦轮磨损 Attrition wheel was frayed	拆下磨刀机匣, 顺时针旋下更换的磨擦轮(见附图二) Take off motor box of sharpener and screw off changed attrition wheel full clockwise. (Refer to figure two)

故障 Malfunction	主要原因 Main causes	检修方法 Maintaining method
空载时噪声大 Big noise because racing	磨刀机构中齿轮严重磨损 Gear of sharpener was badly frayed.	拆下磨刀机匣，顺时针旋下磨擦轮，取出更换的磨损齿轮（见附图二） Take off motor box of sharpener and screw off attrition wheel full clockwise, and then take out changed abrasion gear. (Refer to figure two)
磨刀架不正常滑落 Sharpener bracket slide abnormality	磨刀架内齿轮和双向丝杆无润滑脂 There is no lubricant grease in the inner gear of sharpener bracket and double direction screw.	拆下前凸罩，需加油脂 Take off the front raised cover and insert grease.
裁剪后布料底层有毛边 Bottom of cloth with deckle-edged after cutting out	1、磨刀后刀片卷刃；Knife has frizzy edge after sharpening. 2、刀片尖部不锐；Knifepoint is not sharp. 3、刀片安装位置不正确 The fixing position of knife is not correct.	1、更换刀片；Change the knife. 2、将刀片尖部开刃 Sharpen the knifepoint. 3、适当调整刀片位置。参照三、四（三）。 Properly adjust position of knife. Refer to items such as three and No. 3 of four.
脚板中间塞布毛 Slip cloth flock between baseboard	脚板磨损，中间间隙为0.9mm Baseboard was grinded and the middle clearance is 0.9mm.	更换左右脚板 Change left and right baseboard.
裁剪时手推机器阻力大 Resistance of machine is too big while cutting out.	底座滚轮中滚柱与轮之间被绒尘挤住 The space was full of lint between roll pillar and wheel in the base trolley.	从底座上面圆孔中压出滚轮，取出滚轮轴，清洗滚轮内及滚轮轴外表面。（见附图三） Extrude trolley from above hole of pedestal and take off trolley axle, and then clean inside and outside of trolley. (Refer to figure three)
磨削后的刀片两边宽度不一致 Width of both sides are not equal after grind.	磨刀垫角度偏移 Angle of sharpener washer has excursion.	适当调整左磨刀垫螺钉 Properly change left sharpener washer screw.
	刀片磨损2-3mm，磨刀垫角度偏移 Knife was grinded 2-3mm and angle of sharpener washer has excursion.	具体方法参照四（四）操作说明 Operating details reference to No.4 of fourth operating manual.

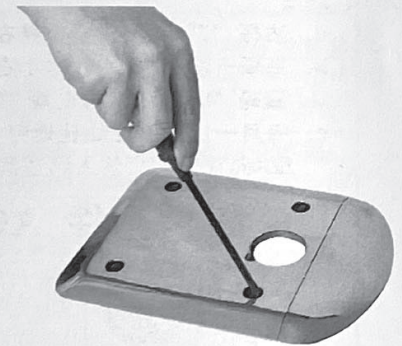
机器常见故障维修示意图 MACHINE MALFUNCTION AND MAINTAINING FIGURE



图一
Figure 1



图二
Figure 2



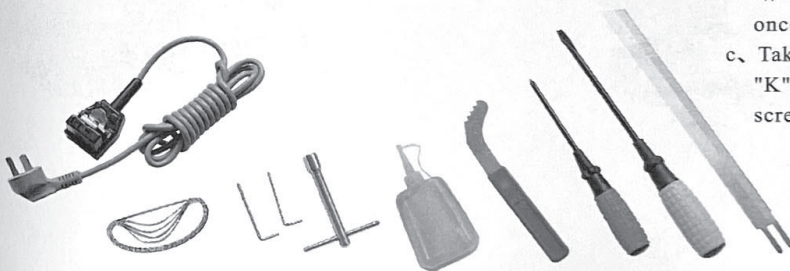
图三
Figure 3

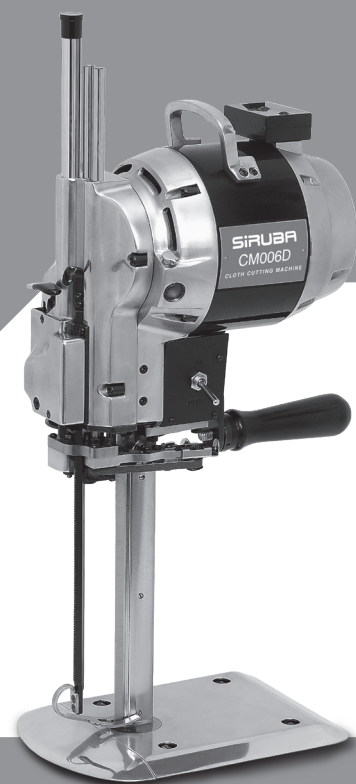
七、机器的维护与保养 MAINTENANCE

- 1、每周两次用吸尘器及风箱或刷子清除电机和磨刀器上的绒毛，保证机器正常通风散热和转动灵活。
- 2、每周一次拆下前罩“K”，清扫双向丝杆周围的绒毛。
- 3、每周一次取下刀片，用除尘板清扫立柱刀壳槽内绒毛，避免绒毛堆积在内影响机器运转。
- 4、不要向底座滚轮注油，若滚轮滚动不灵，请拆下清洗。
- 5、经常检查各紧固部位，不允许有松动现象。
- 6、润滑
 - a、油杯“T”油面需要保持在红线上，随时加油。
 - b、每周一次适当给：（1）右方轴“W”（2）砂带涨紧轮“V”（3）导向管“N”，部位注油。
 - c、每月一次拧下注油孔螺钉，往砂带架内，拆下前罩K向双向丝杆注入钙基润滑脂。

- 1、Clean lint of motor and sharpener twice a week by cleaner, bellows or brush, and guarantee the machine to normally ventilate and dispel heat and turn neatly.
- 2、Dismantle former cover "K" and Clean lint around the double direction screw once a week.
- 3、Take off knife and clean lint of scabbard with dust catcher to guarantee machine turn swimmingly.
- 4、Don't insert oil in base trolley, please dismantle it and cleaning if not turn neatly.
- 5、Must frequently check various set parts and there is not be patient of incompact.
- 6、Lubricating
 - a、Surface of oil cup "T" must keep in the red mark and insert oil in it momentarily.
 - b、Properly insert oil in positions such as right square shaft "W", abrasive belts slide with pulley "V" and guide rail "N" once a week.
 - c、Take off screw of oiling hole and dismantle former cover "K" to insert Calcium-based grease in double direction screw once a month.

八、随机附件 ACCESSORIES





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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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