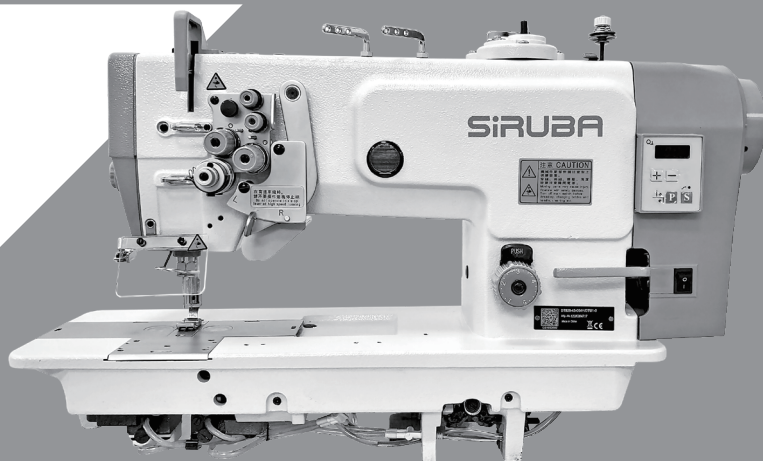


# SIRUBA

使用説明書

INSTRUCTIONS BOOK

■DT828



## 溫馨提醒 A WARM REMINDER

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。

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.



## 安全警示 GENERAL SAFETY INSTRUCTION

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。

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.

### 警告標示說明

Explanation of warning indications and labels.

	<p>高壓電危險 在機器關機後十分鐘內，勿開啟電控箱。</p> <p>HIGH VOLTAGE DANGER Do not open the power cabinet within 10 minutes after the power off.</p>		<p>零部件移動區 勿接近，以避免人員受傷。</p> <p>Machine moving area! Stay away and keep clear to avoid injury.</p>
	<p>零部件高速移動區 勿接近，以避免人員受傷。</p> <p>High speed moving area! Stay away and keep clear to avoid injury.</p>		

標告標示說明 WARNING LABELS	標告標示說明 WARNING LABELS
<p>機器零部件移動區，勿接近，以避免人員損傷。 A risk of cut and injury from moving parts. Stay away and keep clear.</p>	<p>請注意，在操作過程中握住縫紉機會傷到您的手。 Be aware that holding the sewing machine during operation can hurt your hands.</p>
<p>有電，危險。 A risk of electric shock. Stay away and keep clear.</p>	<p>小心被機械捲件受傷！ There is a risk of entanglement in the belt resulting in injury.</p>
<p>高溫度區！危險，勿靠近。 A risk of burn from the high temperature area. Stay away and keep clear.</p>	<p>如果觸摸按鈕托架，可能會造成人身傷害。 There is a risk of injury if you touch the button carrier.</p>
<p>強光！勿直視，以避免眼睛受傷。 Avoid direct eye contact with the laser beam or other light source.</p>	<p>一般安全標示 GENERAL SAFETY INDICATIONS</p> <p>機器運行方向 The correct direction is indicated.</p>
<p>小心頭部撞擊！ A risk of injury to head from upper contact. Apply proper protection (helmet) and keep clear.</p>	<p>電氣接地位置標示 Grounding connection as indicated.</p>

## 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) 為了避免機器突然啟動造成意外，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。

## 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 at soon.
- (4) Fail 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 prevent 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 of 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.

## 在不同階段的注意事項

## PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

### 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. 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.

- (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。

- (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° C ~ 35° 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.



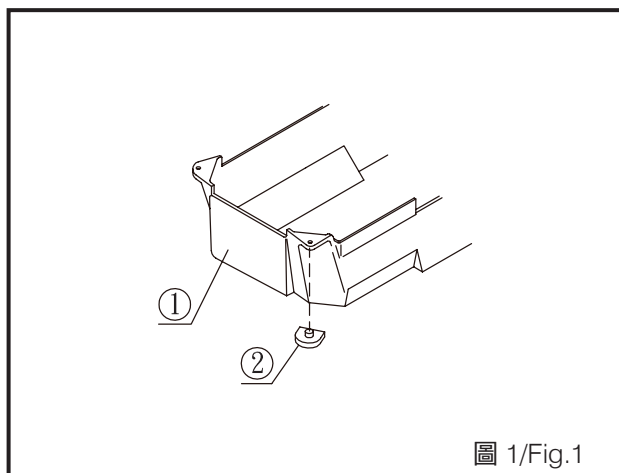
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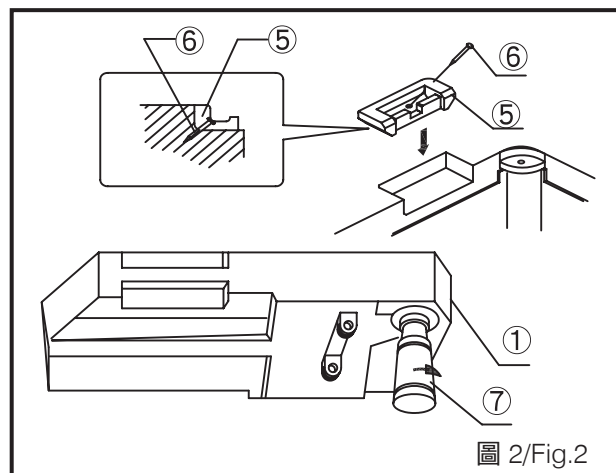
## 安裝油盤

1. 將油盤底墊片②\* 4 插入油盤①。(圖 1)
2. 將油盤①放入桌板凹槽中，轉角成一直線。
3. 將橡膠墊片⑤\*2 桌板 U 型切口，用釘子⑥\*2 將其固定。(圖 2)
4. 將塑膠油壺⑦鎖緊於油盤①。



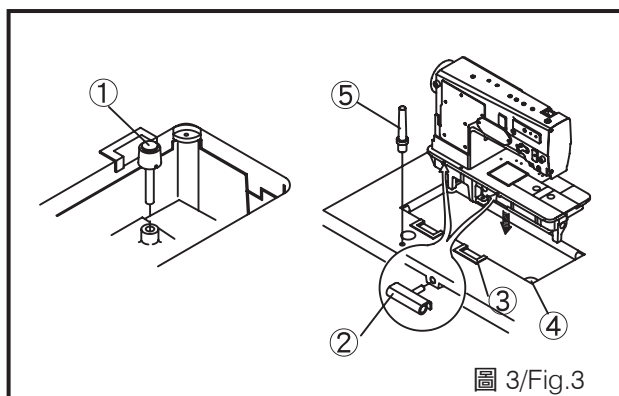
## OIL PLATE INSTALLATION

1. Insert four oil plate bottom spacer ② into the oil pan ① . (Fig. 1)
2. Put the oil pan ① into the flute of the table, and the corners will be in alignment.
3. Place 2 rubber spacers ⑤ into the U shape flutes and fix them by two nails ⑥ .(Fig.2)
4. Please secure the oil pot ⑦ on the oil pan ① .



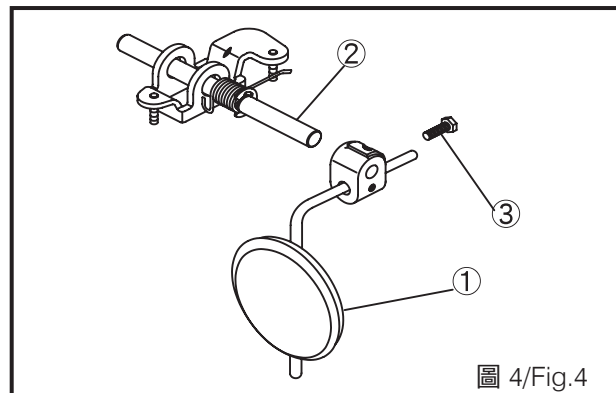
## 機頭安裝

1. 膝動抬押具桿①放入油盤。(圖 3)
2. 鉸鍊②x2 插入機頭孔。
3. 調整鉸鍊②放入墊片③調整好後，再將機頭放在桌板上墊片④上調整好，機頭在油盤正上方。
4. 將軸襯⑤敲入桌板孔中。
5. 確定軸襯⑤有敲入桌板孔內，若沒確實敲入，久而久之將會鬆動。機頭如後傾時，會產生不穩移動現象。



## INSTALL MACHINE HEAD

1. Place knee lifting bar ① into oil plate. (Fig.3)
2. Insert 2 hinges ② onto machine head top.
3. Clamp the hinges ② onto the spacer ③ and then place machine head on the spacer ④ on the work table, which is on top of the oil table.
4. Knock the pillow ⑤ into the hole of the worktable.
5. Be sure the pillow ⑤ is fixed in the hole of the worktable. If the pillow isn't properly placed, it will loose when time goes by. It may cause unstable movement when the machine head is tilted back.



## 膝動抬押腳機構安裝與調整

## KNEE LIFTER INSTALLATION AND ADJUSTMENT

### 1. 膝動抬押腳機構安裝 (圖 4)

膝動抬押腳①裝入油盤膝動抬押腳桿②上，並且確保用螺絲③固定鎖住。

### 2. 膝動抬押腳機構調整 (圖 5)

- (1) 將押具⑤用手動抬押腳桿④抬起。
- (2) 鬆開螺帽⑥。
- (3) 旋轉螺絲⑧，使膝動抬押腳連桿⑦與抬押具桿距離大約 2mm。
- (4) 確定鎖固螺帽⑥。
- (5) 放鬆螺帽⑨。
- (6) 轉動螺絲⑩，直到螺絲頂端和膝動抬押腳連桿的距離大約 8mm。
- (7) 移動膝動抬押腳板，當螺絲⑩頂碰油盤時，標準押腳與針板的距離 10mm，用螺絲⑩作調整。
- (8) 調整確定後，螺帽⑨鎖住。

### 1. Knee lifter installation (Fig.4)

Insert the knee lifter ① into the knee lifter bar ② and use screw ③ to secure it

### 2. Knee lifter adjustment (Fig.5)

- (1) Lift up presser foot ⑤ by using manual lifter bar ④.
- (2) Loose the nut ⑥.
- (3) Turn the screw ⑧ and let knee lifter bar ⑦ is at 2mm distance from the lifter bar.
- (4) Secure the nut ⑥.
- (5) Loose the nut ⑨.
- (6) Turn the screw ⑩ until the top of the screw is at 8mm distance from the knee lifter bar.
- (7) Adjust knee lifter foot plate. If the screw ⑩ touches the oil plate, it shall be adjusted by turning screw ⑩. The distance between standard foot plate and needle plate is 10mm.
- (8) After all adjustments are completed, secure the nut ⑨.

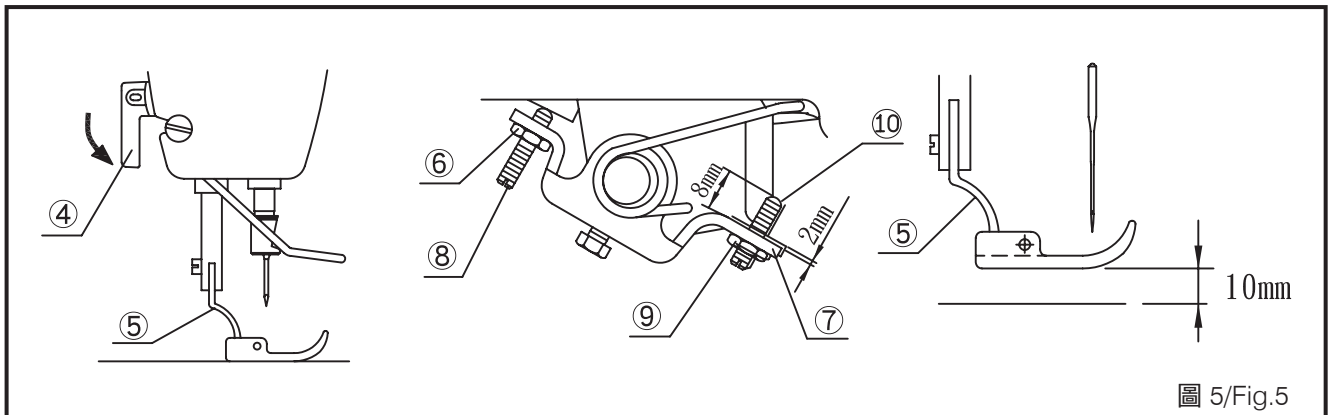


圖 5/ Fig.5

## 馬達與電控箱安裝

## MOTOR AND ELECTRIC CONTROL BOX INSTALLATION

A. 將①底座裝入機頭上 (注：圓角方向朝左上角)，用② M5\*10 內六角螺絲鎖緊。

B. 將用③轉子裝入主軸上並用④ M5\*6 無頭內六角螺絲鎖緊 (注：轉子要與機頭圖 A 內部軸承裝到位)。(圖 6)

A.install ① plate into the machine(note: the round corner is up to the left ), then use ② M5\*10 hexagon screw locking.

B.Install ③ rotor on the spindle and lock with ④ M5\*6 headless hexagon screws.(Note: rotors should be in place with the internal bearing of picture A). (Fig.6)



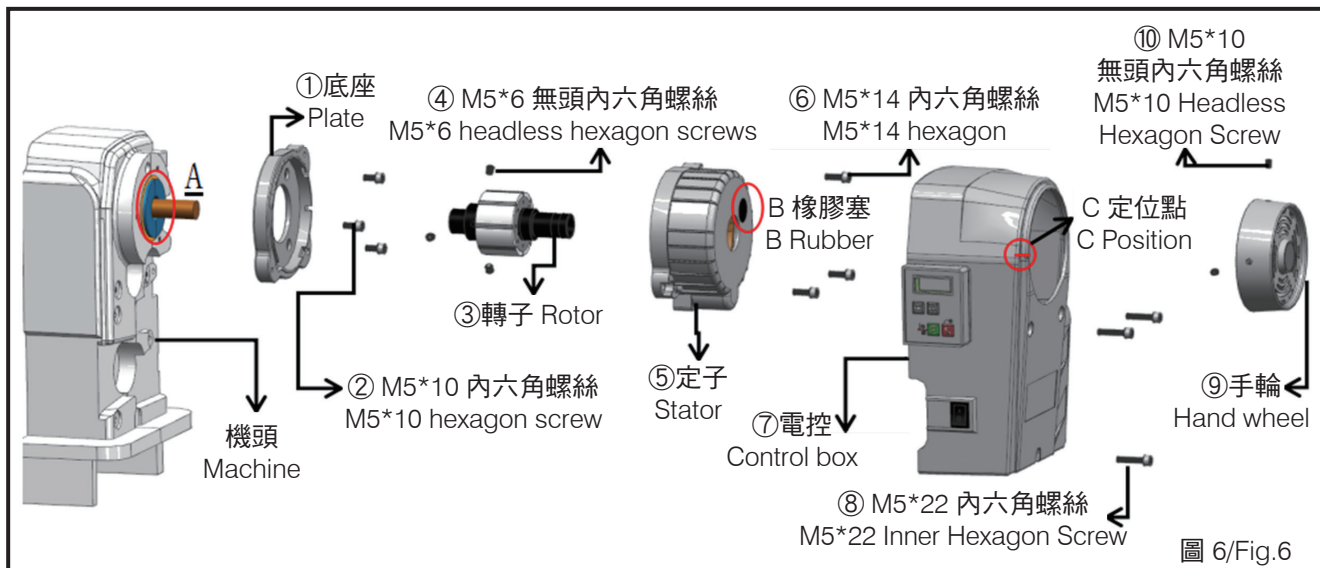


圖 6/Fig.6

- C. 將⑤定子裝入①底板上並用⑥ M5\*14 內六角螺絲鎖緊；拿出如圖 B 橡膠塞，目測轉子平面與定子平面是否相平，兩面相平度不得超過 1.5mm( 看如下剖視圖 )，( 注：定子裝入轉子要注意磁鐵吸力，小心夾到手，定子電機線信號線朝下 )。
- D. 將⑦電控裝入與機頭孔位對準並用⑧ M5\*22 內六角螺絲鎖緊 ( 注：鎖 M5\*22 內六角螺絲扭力不易過大，過大電控外殼變形，建議扭力 8kg-10kg )。
- E. 將機器機針旋轉到最高位，然後用⑨手輪裝入轉子軸尾端，手輪 P 點對準電控 C 定位點並用⑩ M5\*10 無頭內六角螺絲鎖緊。注：電機與手輪位置間隙 1-2mm。( 圖 7 )

- C. Install ⑤ stator on ① base plate and lock with ⑥ M5\*14 hexagon; take out the rubber as shown in picture B, and visually check whether the rotor plane is parallel to the stator plane. The flatness of the two surfaces should not exceed 1.5mm. (NOTE: Pay attention of the magnet suction when install the stator to the rotor, watch your hand, the motor wire and the signal wire should be down. )
- D. The ⑦ control box is put into the machine head hole position and locked with ⑧ M5\*22 Inner Hexagon Screw (Note: Locking M5\*22 Inner Hexagon Screw, the torque can not be overshoot, if too large, the control box cover will be deformation, recommended Torque 8 kg-10 kg) .
- E. Adjust the machine needle to the highest position, and then install ⑨ handwheel at the end of the rotor shaft. The handwheel p point is aligned to the control box C position and locked with ⑩ M5\*10 Headless Hexagon Screw. Note: The position clearance between the motor and the handwheel is 1-2 mm. (Fig.7)

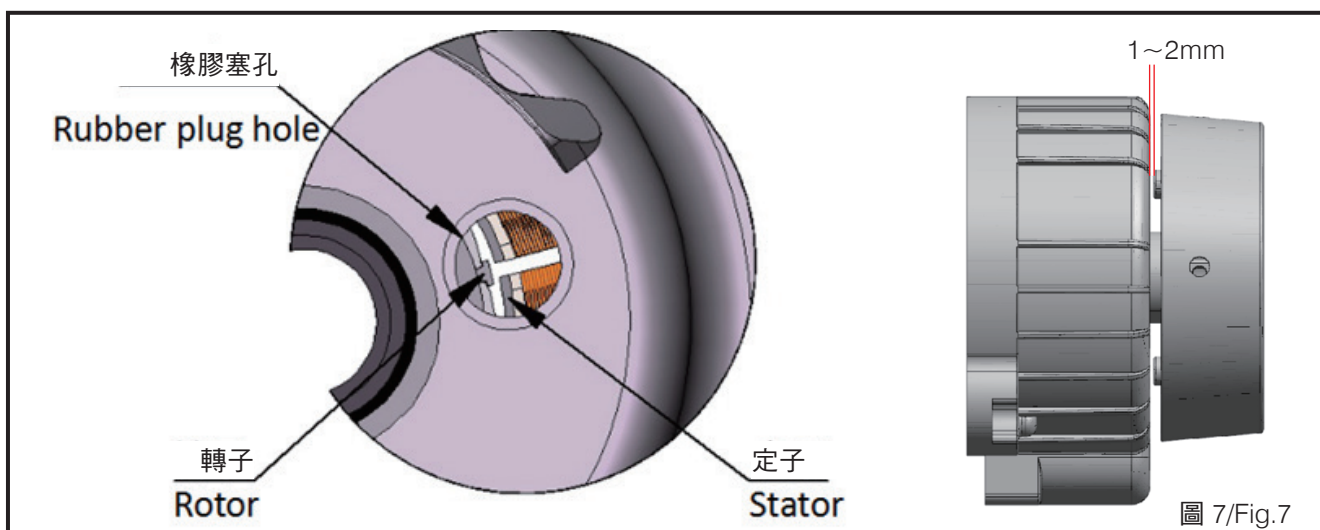


圖 7/Fig.7

## 線架安裝

## THREAD STAND INSTALLATION

1. 安裝線架 ①。(圖 8)
2. 線架安裝於桌板右方上角處。

1. Install the thread ①.(Fig. 8)
2. Install the thread stand on the up right side of the table.

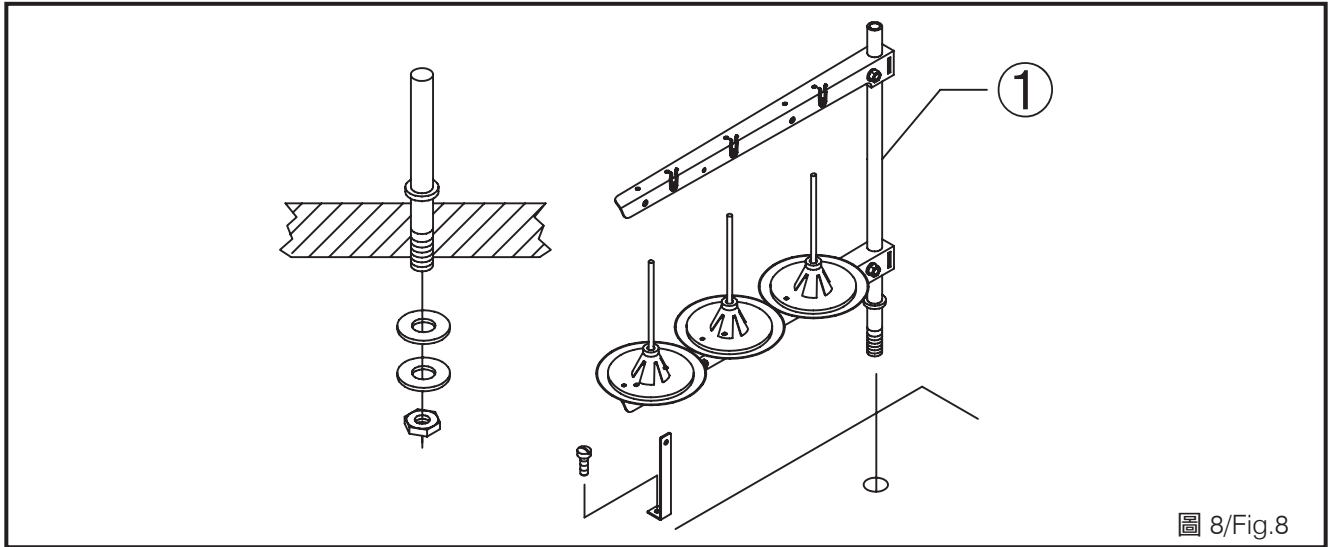


圖 8/Fig.8

## 潤滑

## LUBRICATION

### 注意事項

- (1) 潤滑油未完全加好前，不要連接電源線，不然當誤觸踏板時，機器會運轉，可能造成傷害。
  - (2) 當加潤滑油時，確定要戴保護鏡及手套，避免將油接觸到眼睛及皮膚，可能會導致灼傷，且在任何情況下，不可喝下潤滑油，如喝下將造成嘔吐及腹瀉，避免讓小孩拿到。
- \* 機器必須在使用前或第一次使用時，或長時間沒有使用需加足夠的潤滑油。(使用 MOBIL#10 或 ESS0#32 潤滑油)
1. 注入潤滑油 (圖 9)  
將油圈入油孔①中，直到油加滿到油鏡②上之油線。(採用油類為白礦油 #10 或錠子油 20W)

### ATTENTION

- (1) Do not connect the power wire before lubrication has done. Otherwise, if pressed the pedal mistakenly, the machine would operate and probably cause injury.
- (2) While lubricating, protective glasses and gloves are certainly needed to wear to avoid injuries of eyes and skin from oil splashing. This splashing might cause burns. Do not drink this lubrication oil under any situation, this may cause vomit and diarrhoea. Also, keep this oil where children cannot touch or get.

\* Before use this machine, the first time use, or use after long idling time, please oiled sufficiently. (Use MOBIL#10 or ESS0#32 oil)

1. Fill the lubrication oil (Fig. 9)

Pour the oil into the oil hole ① until it reaches the oil line of the oil sight window ②. (The adopted oil is white lubrication oil #10 or spindle oil 20W.)

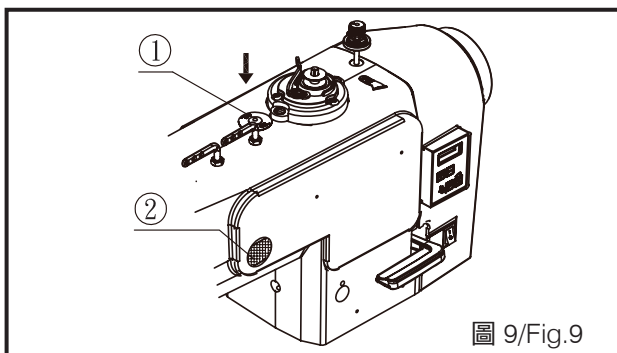


圖 9/Fig.9

2. 在此箭頭所指的地方滴油。(圖 10)

2. Lubricate where the arrows indicate. (Fig.10)

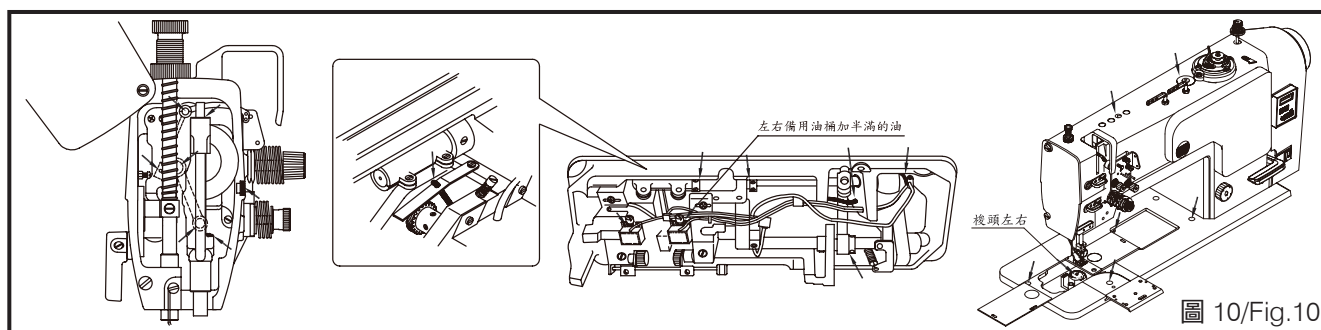


圖 10/Fig.10

## 針的安裝

## NEEDLE INSTALLATION

### 注意事項

在裝針動作之前，先將電源關掉，不然當誤觸踏板時，機器會運轉，可能會造成傷害。

- (1) 旋轉皮帶輪，將針鉗①轉至上死點。(圖 11)
- (2) 將螺絲③鬆開，將針②之長凹槽面向內，並確定針完全推入洞中，再鎖緊螺絲③。

### ATTENTION

Turn off the power before installing the needle. Otherwise, machine will cause injuries when press the pedal incautiously.

- (1) Rotate the pulley to make the needle holder ① to the up dead point. (Fig.11)
- (2) Loosen the screw ③ and insert the needle ②, so that the side with long flute can face inward, and push it to the needle holder completely. Then, tighten screws ③.

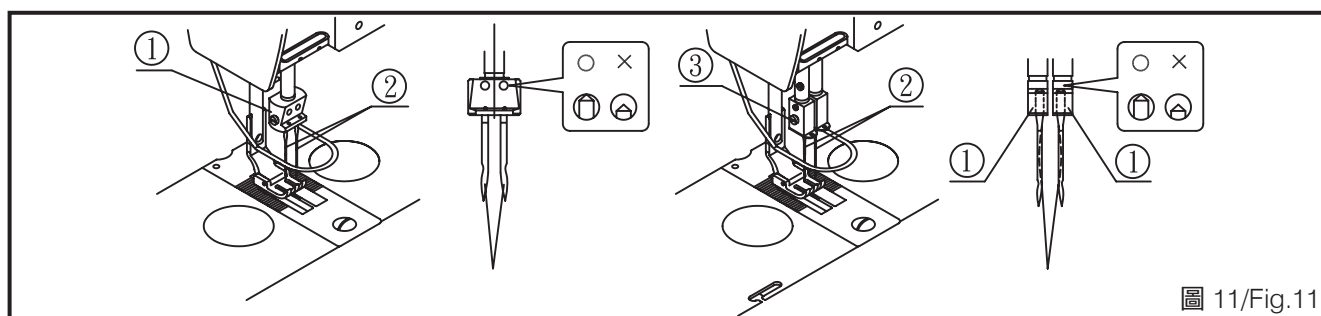


圖 11/Fig.11

### 1. 取出梭子或鞘 (圖 12)

- (1) 將針①轉至上死點，移開左右平台蓋②，將梭子把③向上拉起，然後取出梭子④。
- (2) 將針①轉至上死點，移開左右平台蓋②，將梭子把③向上拉起，轉動鞘④，然後取出鞘④。

### 1. Take the bobbin and sheath out (Fig.12)

- (1) Make the needle ① to upper dead point and remove the left and right slide plates ②, then pull the bobbin latches ③ and take the bobbin ④ out.
- (2) Make the needle ① to the upper dead point and remove the left and right slide plates ②, then pull the bobbin latches ③ and rotate sheath ④ and take the bobbin ④ out.

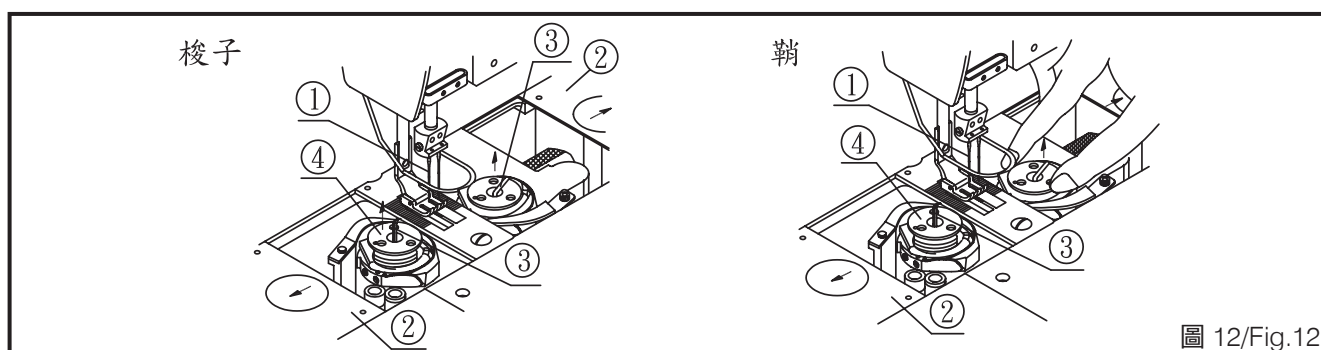


圖 12/Fig.12

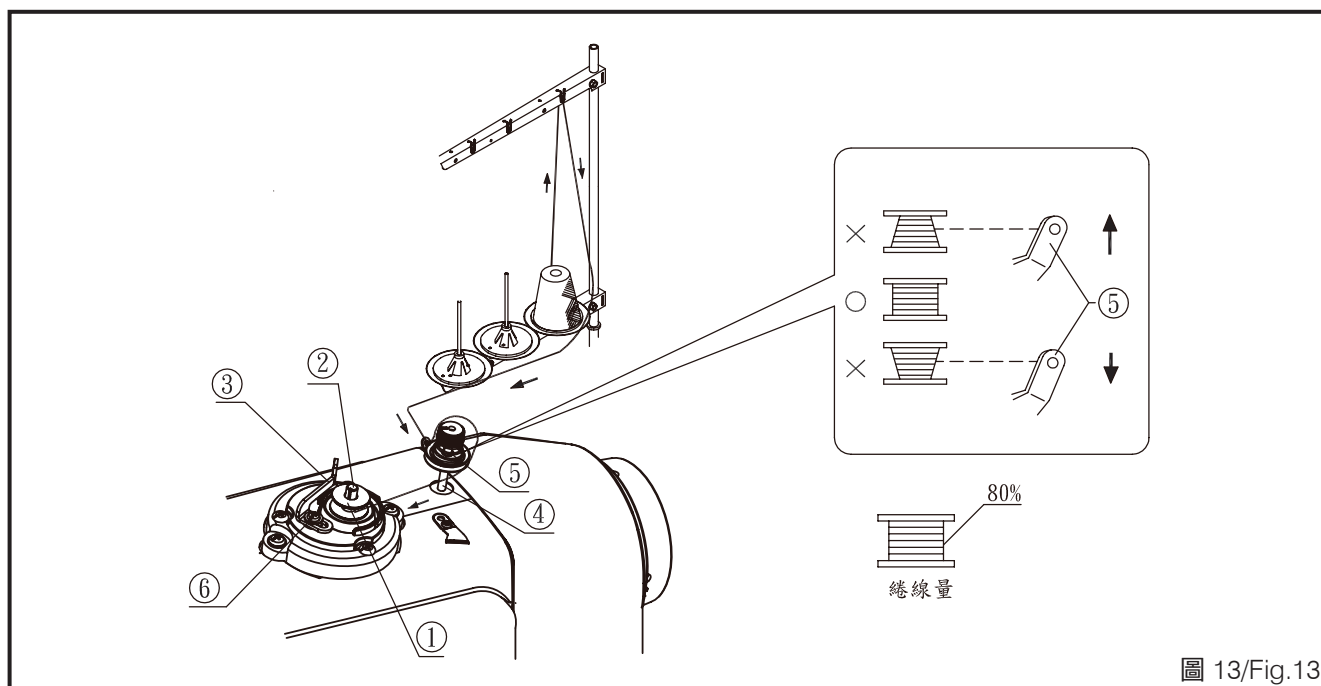


圖 13/Fig.13

## 2. 捲繞梭子之線 (圖 13)

- (1) 將開關打開。
- (2) 將梭子①穿入旋轉軸②中。
- (3) 將線依箭頭方向穿線，至梭子①多捲繞幾圈。
- (4) 將捲線器壓桿③壓下。
- (5) 拉起手動提升押腳桿，使押腳舉起。
- (6) 腳踏踏板，捲線器開始運轉。
- (7) 假如梭子線已安裝完成，捲線器壓桿③會自動回復。
  - A. 假如梭子線沒有被平順地捲繞，鬆開螺絲④，並移動線鈕座⑤，向線較少的地方移動。
  - B. 旋轉調整螺絲⑥來調整梭子捲繞線量。
    - a. 要增加捲繞線量：鎖緊螺絲⑥。
    - b. 要減少捲繞線量：鬆開螺絲⑥。
    - c. 標準梭子捲線量，達到梭子可容的 80%。

## 2. Wind the bobbin thread (Fig.13)

- (1) Turn on the switch.
- (2) Put the bobbin ① to the shaft ②.
- (3) Wind some thread to the bobbin ① according to the arrow direction.
- (4) Press down the winder press lever ③.
- (5) Pull the manual lifter to lift the presser foot.
- (6) Press the pedal, and the winder will start running.
- (7) If the bobbin thread is full, winder lever ③ will be back automatically.
  - A. If the thread is not wound smoothly, loosen the screw ④ and move the holder ⑤ to the less thread direction.
  - B. Adjust the bobbin thread volume by rotating adjusting screw ⑥.
    - a. Tighten screw ⑥ to increase the volume.
    - b. Loosen screw ⑥ to decrease the volume.
    - c. Standard bobbin thread volume reaches 80% of the bobbin capacity.

## 梭子之安裝

## BOBBIN INSTALLATION

### 1. 防止卡線彈簧 (圖 14)

防止卡線彈簧①是用來防止梭子卡線，請使用 SIRUBA 牌之輕合金梭子②。

### 2. 梭子安裝

- (1) 轉動皮帶輪，將針①轉至上死點。
- (2) 將梭子②放入梭頭③中，線捲繞之方向如圖所示。
- (3) 還原梭頭之梭子到原位。
- (4) 轉動皮帶輪，旋轉梭頭③直到緊度彈簧⑤可看見。
- (5) 將線拉入在梭頭上的缺口 "A"，然後再拉入緊度彈簧片⑤之內。
- (6) 將線拉出 50mm。
- (7) 將左右平台蓋⑥關上。

### 1. Anti-thread stuck spring (Fig.14)

Anti-thread stuck spring ① is used to prevent the thread stuck, please adopt SIRUBA light alloy bobbin ②.

### 2. Installation of the bobbin

- (1) Rotate the pulley and make the needle ① to the upper dead point.
- (2) Put the bobbin ② to the hook ③, and the winding direction is as the figure indicates.
- (3) Put the bobbin to the original position.
- (4) Rotate the pulley to spin the hook ③ until the tension spring ⑤ is visible.
- (5) Pull the thread to the gap A, and then pull thread ⑤ into the tension spring.
- (6) Pull out the thread for about 50mm.
- (7) Close the left and right slide plates ⑥.

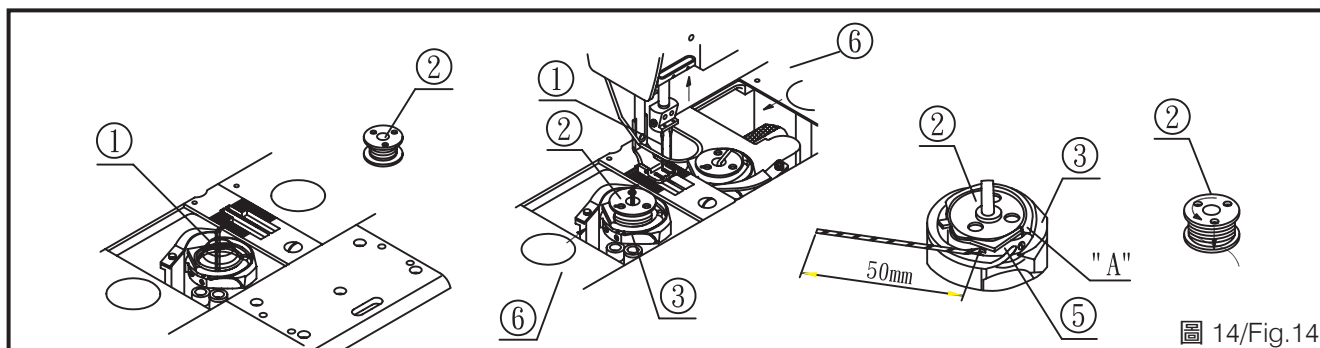


圖 14/ Fig.14

## 鞘的安裝

## SNEATH INSTALLATION

1. 將梭子①放入鞘②中，捲繞方向如圖 15 所示。
2. 轉動皮帶輪，將針⑥轉至上死點。(圖 16)
3. 將鞘②放入梭頭中。
4. 將梭子把⑦還原。
5. 將左右平台蓋⑧關上。

1. Put the bobbin ① into the sheath ②. The winding direction is as Fig. 15 shows.
2. Rotate the pulley and make the needle ⑥ to the upper dead point. (Fig.16)
3. Put the sheath ② in the hook.
4. Return the bobbin bar ⑦ to original position.
5. Close the left and right slide plates ⑧.

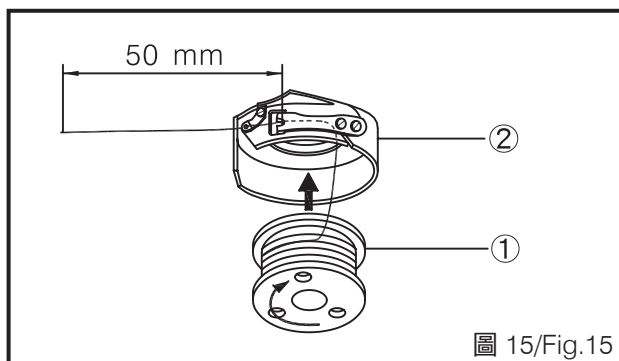


圖 15/ Fig.15

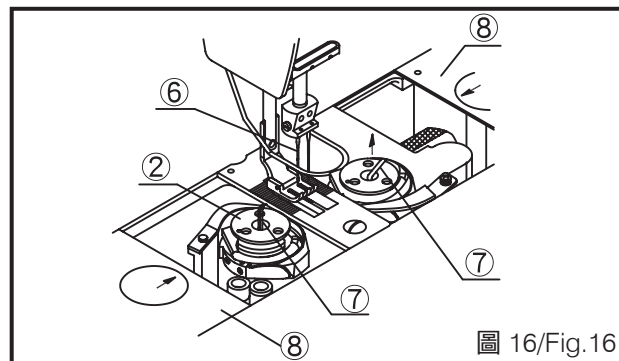


圖 16/ Fig.16



## 穿線

## THREADING

1. 在穿上線前先轉動皮帶輪，使天平①於最高位置，這會使穿線較簡單，且不會使線從針頭掉落。(圖 17)
2. 從左邊線先穿。
3. 保護手指裝置②之位置是可調整的，在車縫時要將其降低。
4. 將線正確地穿過緊度盤，線從針眼之內側穿到外側，並將線向左右拉開 50mm。

1. Rotate the pulley to make the take-up thread lever ① to upper dead point, this will be easier to thread the machine and the needle thread will not fall down. (Fig.17)
2. Thread the needle from the left side.
3. Finger guard device ② is adjustable, and the position should be lower when sewing.
4. Thread correctly from rigid plate, and thread through from inside to outside of the eyes of the needles and pull 50mm to left and right side separately.

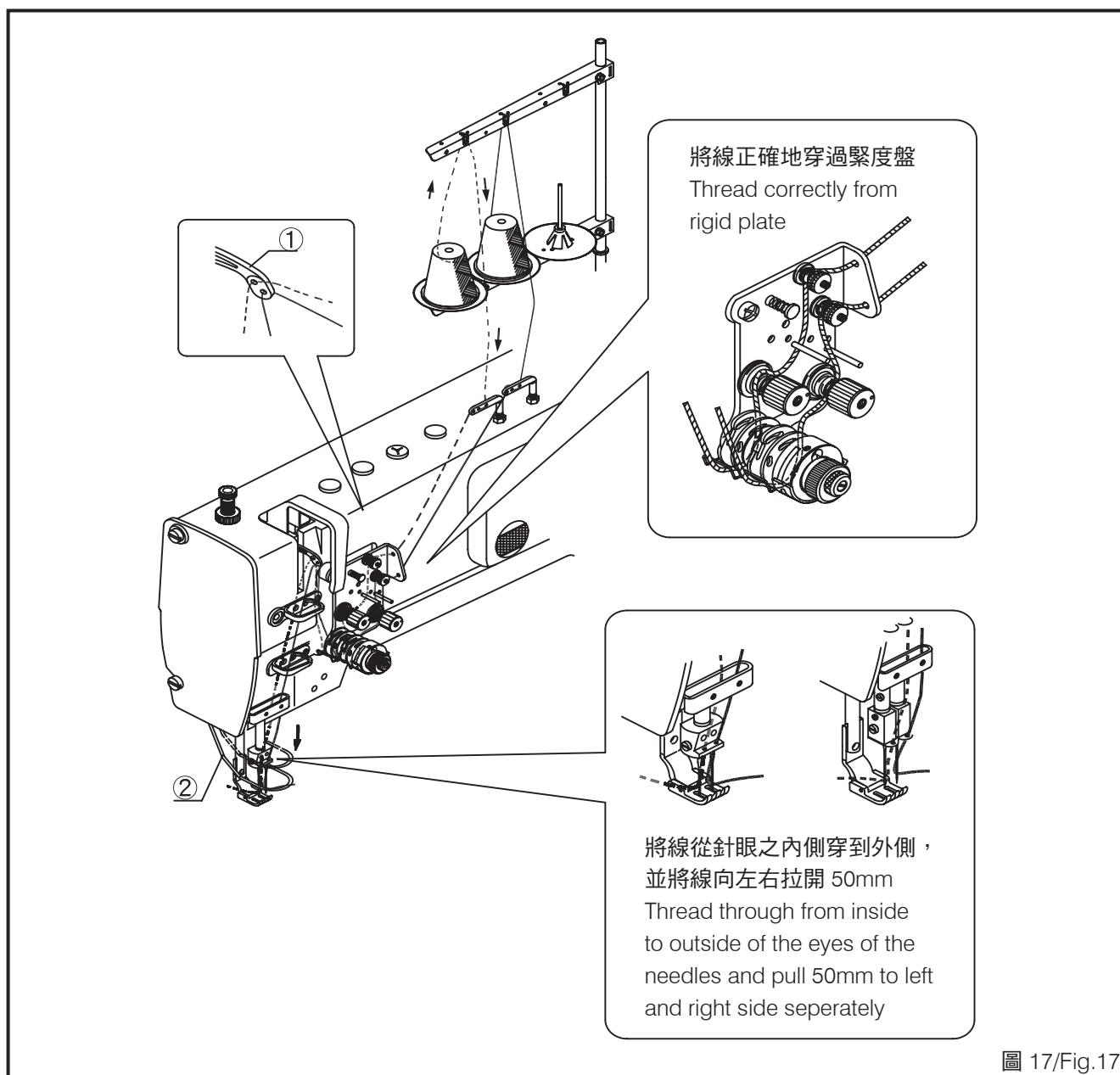


圖 17/Fig.17

## 調整縫紉之距離

## ADJUSTMENT OF THE STITCH LENGTH

轉動縫距控制鈕①，調整順時鐘方向或逆時鐘方向，可是縫距達到理想之程度。

\* 數字越大，縫距越長。(圖 18)

Turn the stitch length dial ①, and rotate it clockwise or counter clockwise to reach the ideal stitch length.

\* The larger the number, the longer the stitch length.  
(Fig. 18)

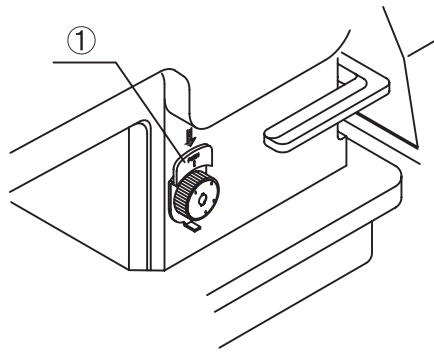


圖 18/Fig.18

## 邊角縫之方法

## METHOD OF CORNER SEWING

1. 停止針棒 (左和右)。操作停止槓桿，當針穿過布料，而且已經停止，當其中一針棒停止運作時，縫紉速度不要超過 1000 r.p.m.。

(1) 左針棒之停止操作，移動停止槓桿①到 L 之位置。(圖 19)

1. To stop the needle bars (left and right)  
Operate the stop lever after the needle has penetrated the fabric and has stopped moving.

The sewing speed should not be over 1000 r.p.m. while one the the needle bars has stopped.

(1) To stop the left needle bar operation, move the stop lever ① to the "L" position. (Fig.19)

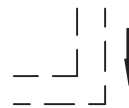
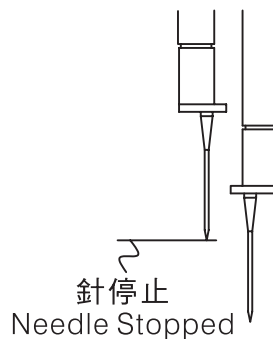
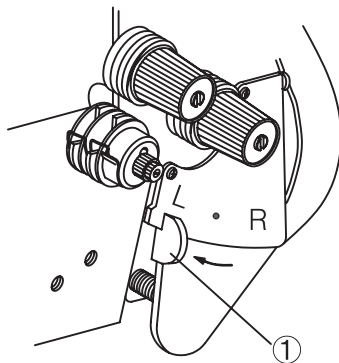
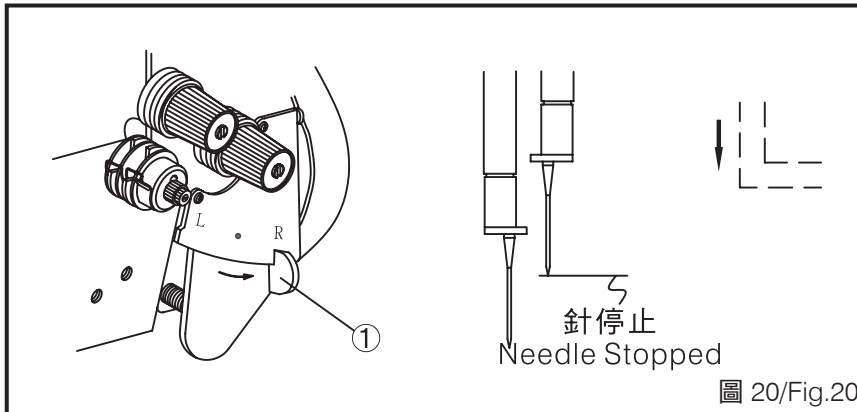


圖 19/Fig.19

(2) 右針棒之停止操作，移動停止槓桿①到 R 之位置。(圖 20)

(2) To stop the right need bar operation, move the stop lever ① to the "R" position. (Fig. 20)



(3) 重新開始雙針車縫時，按下槓桿②，停止槓桿①會自動回覆到原位。(圖 21)

(3) For restarting two needle stitching, press lever ②, and the stop lever ① will return to the original position (Fig. 21)

## 2. 縫針數 (圖 22)

做 1/4" 之距寬

從表 1 可決定距寬，來做到美麗之邊縫。外緣之針數變化，可依照縫紉角度之變化及投針處來變化。

例：

縫紉角度 40 頭針處 2.9mm, 針數變為 6 針，可由表 1 查出。

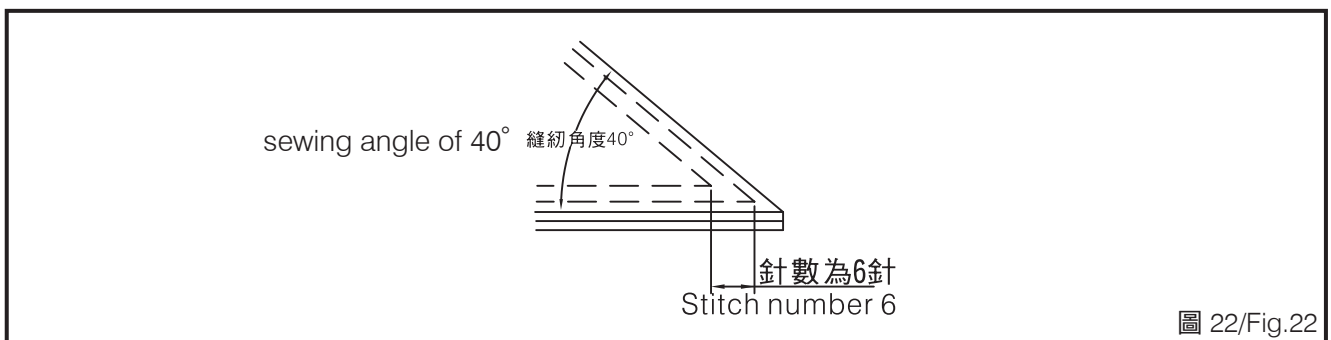
## 2. Stitch numbers. (Fig. 22)

For 1/4" needle width

From table 1, the fine side sewing and the fine edge stitching can be done by choosing the stitch length, the variations of the sewing angles, and the point where the stitch starts

Example:

We can find out that a sewing angle of 40 ° and the first stitching point is 2.9mm, the stitching number is indicated to 6 from the table 1.



縫紉角度 針數	30°	40°	50°	60°	70°	80°	90°	100°	110°	120°	130°	140°
2	—	—	—	—	4.6	3.8	3.2	2.7	2.2	1.8	1.5	1.1
3	—	—	—	3.5	3.0	2.5	2.1	1.8	1.5	1.2	—	—
4	—	4.4	4.4	2.8	2.3	1.9	1.6	1.3	—	—	—	—
5	4.8	3.5	3.5	2.2	1.8	1.5	1.3	—	—	—	—	—
6	4.0	2.9	2.9	1.9	1.5	1.3	—	—	—	—	—	—
7	3.7	2.5	2.5	1.6	—	—	—	—	—	—	—	—
8	3.0	2.2	2.2	—	—	—	—	—	—	—	—	—

表 1/Table.1

## 縫紉

## SEWING

### 注意事項

- (1) 在使用前先將安全注意標示貼上。假如沒有，可能會引起傷害。
  - (2) 如有下列之狀況，將電源關閉，否則碰到踏板時，機器會運作，而造成傷害。
    - a. 穿線時。
    - b. 換針或梭子時。
    - c. 當不使用機器或離開時。
  - (3) 在使用時，不要碰觸任何會動之物件或置放東西於機器上，這可能會引起個人之傷害及機器之損壞。
  - (4) 如機器配有自動抬腳裝置，不要碰到電磁閥。因其在運作中會相當熱，而且會引起嚴重灼傷。
1. 將保護手指裝置①壓低。(圖 23)
  2. 用手指捉緊兩條針線，轉動皮帶輪，直到下線浮上至送具之上。
  3. 將下線往自己方向拉出，並檢查是否平順。
  4. 打開開關。
  5. 踏下踏板，開始縫紉。

### ATTENTION

- (1) Sticking all the safety stickers on, it may cause injury without these cares.
  - (2) Please turn off the power for the situations listed below or accidents might happen while pressing the pedal incautiously.
    - a. Threading.
    - b. Replacing needle or hook.
    - c. Machine is not working.
  - (3) Do not touch any moving objects or place anything on the machine, which may cause injuries and machine damages.
  - (4) For machine with auto-lift device, do not touch the solenoid. It gets hot and may cause sever skin burn.
1. Pressing down the finger guard device ①.(Fig.23)
  2. Pulling the two needle threads with fingers, turn the hand wheel until the bobbin threads showing up above the feed dog.
  3. Pull the bobbin threads towards you and check if the threads coming out smoothly.
  4. Turn the power on.
  5. Press the pedal to start stitching.

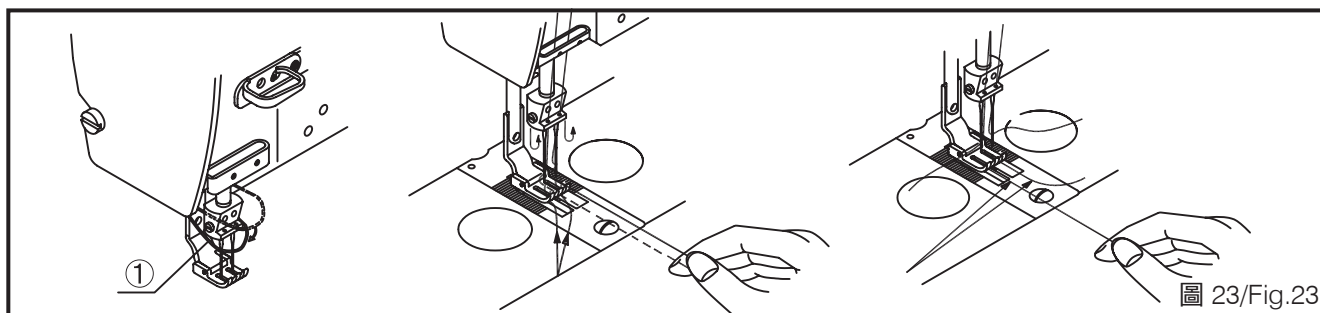


圖 23/Fig.23

## 倒縫

## BACKSTITCHING

當倒縫桿①在縫紉時被壓下，送具運動方向會相反，當被放開時，送具運動方向才會正常。(圖 24)

When the backstitch lever ① is pressed during sewing, the moving direction of the feed dog will be reversed. Once released, the moving direction of the feed dog will turn back to normal. (Fig. 24)

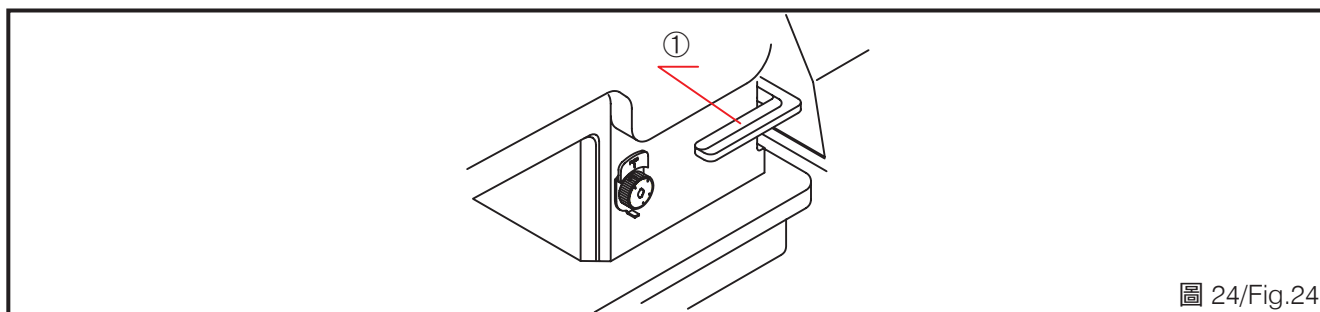
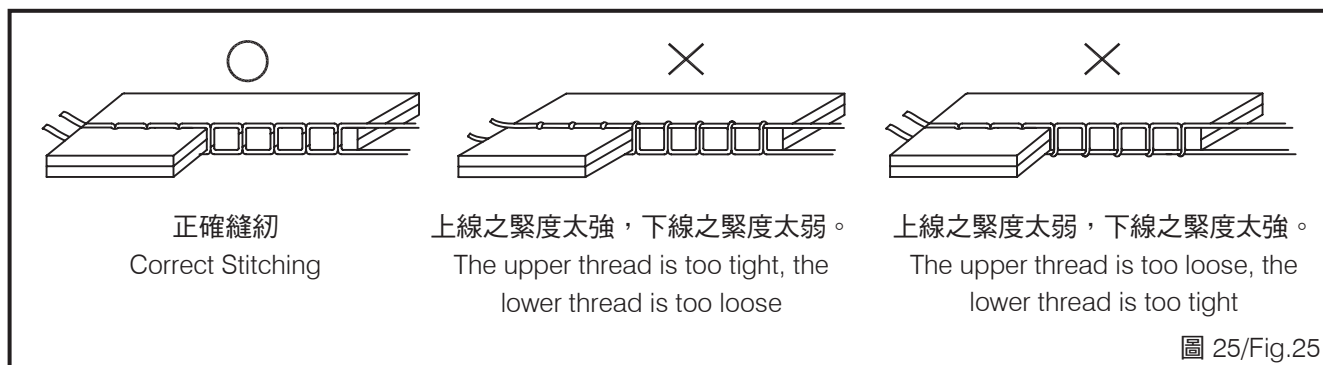


圖 24/Fig.24

## 線之緊度

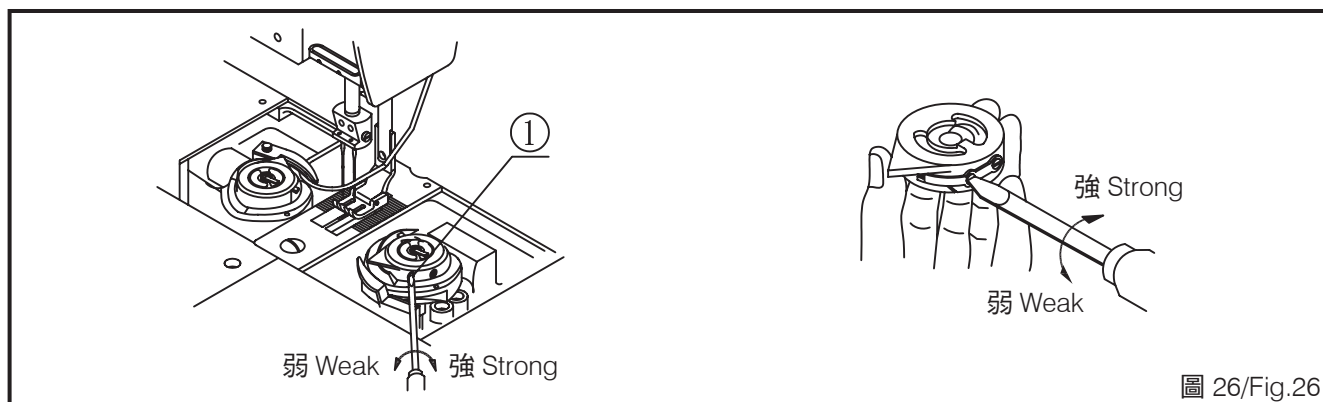
## THREAD TENSION



### 1. 下線之緊度 (圖 26)

可由梭子殼緊度彈簧片調整螺絲①來調整下線之緊度，但也要注意，因線及布料所產生的影響。

1. Tension of the lower thread (Fig. 26) The tension of the lower thread can be adjusted by adjusting the hook tension spring screw ①. However, the tension also will be affected because of the kinds of the thread and the variations of the materials.



### 2. 上線之緊度 (圖 27)

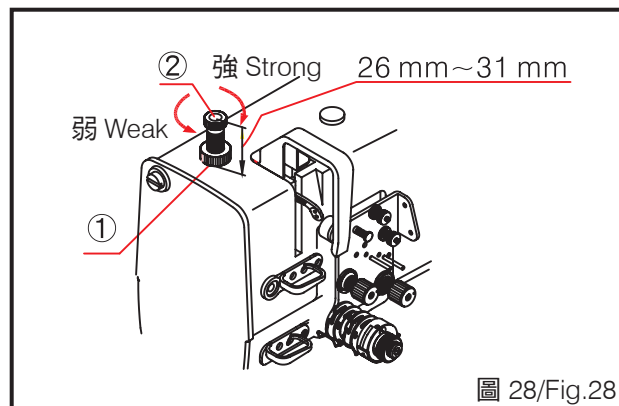
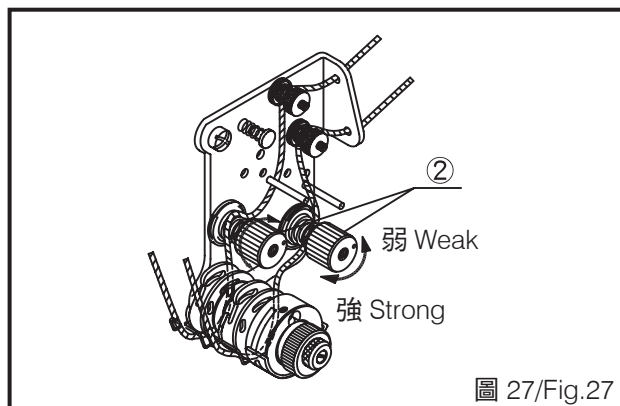
經過下線緊度調整，上線緊度之調整包含：

- (1) 押腳壓力減弱
- (2) 調整線鈕②

### 2. Tension of the upper thread (Fig. 27)

After adjusting the tension of the lower thread, the adjustments of the tension of the upper thread include.

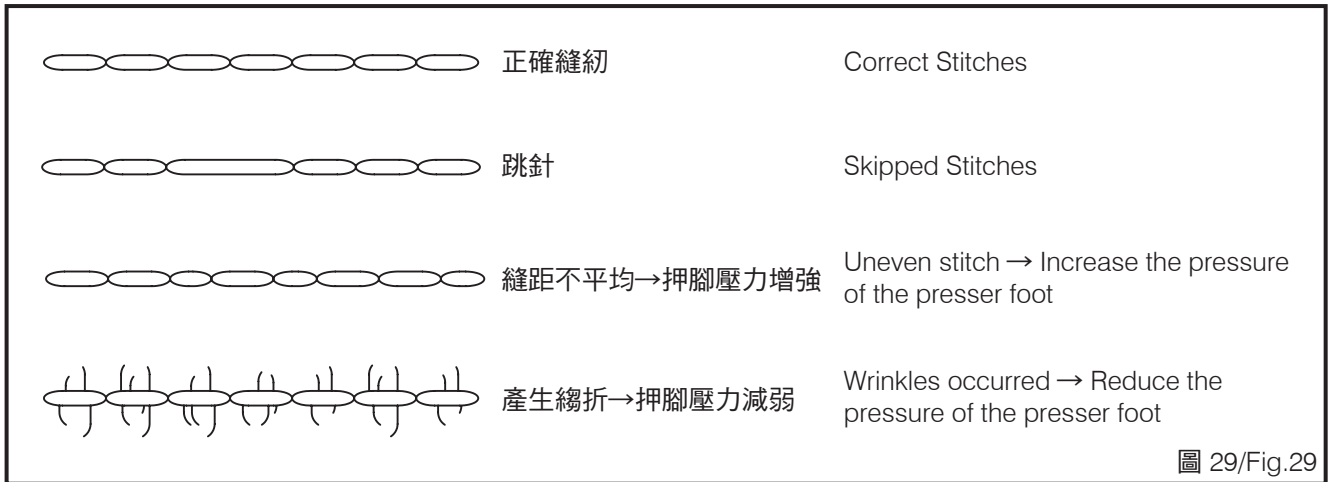
- (1) Reducing the pressure of the presser foot.
- (2) Winding the thread nut ②.





## 押腳壓力之調整

## ADJUSTMENT OF PRESSER FOOT TENSION



\* 押具壓力調整應儘量調弱，只要強到不會將布滑過即可。(圖 28)

1. 放鬆螺帽鈕①。
2. 轉動調整螺絲②來調整押具壓力。
3. 鎖緊螺帽鈕①。

\* The less pressure of the presser foot is better.

As long as the fabric will not skip away from the presser foot. (Fig. 28)

1. Loosen tension nut ①.
2. Wind the adjusting screw ② to adjust the pressure of the presser foot.
3. Tighten the tension nut ①.

	押具之壓力 PRESSURE OF PRESSER FOOT	調整螺絲之高度 ADJUSTMENT OF SCREW HEIGHT
薄布料 THIN MATERIAL	29.4N (3 kgf)	31mm
中厚布料 MID-THICK MATERIAL	39.2N (4 kgf)	28mm
厚布料 THICK MATERIAL	49.0N (5 kgf)	26mm

表 2/Table.2

## 切線後針線餘長度之調整

## ADJUST THE THREAD LENGTH AFTER TRIMMING

1. 切線後，針線的鬆緊度是由線鈕①控制。(圖 30)
2. 標準針線之餘線長度是 33 -37 mm。
3. 假如線鈕①強度增強，針線餘線長度減短；反之線鈕①強度減弱，針線餘線長度加長。

\* 針線餘線的長度是藉由線鈕①旋轉調整。

1. Needle thread tension after trimming is controlled by tension nut ①. (Fig.30)
2. The standard length of thread ended after trimming is 33 - 37mm.
3. Increase the tension nut ① tension to reduce needle thread length after trimming. Oppositely, reduce the tension nut ① tension to increase the needle thread length after trimming.

\* Needle thread length after trimming is adjusted by tension nut ①.

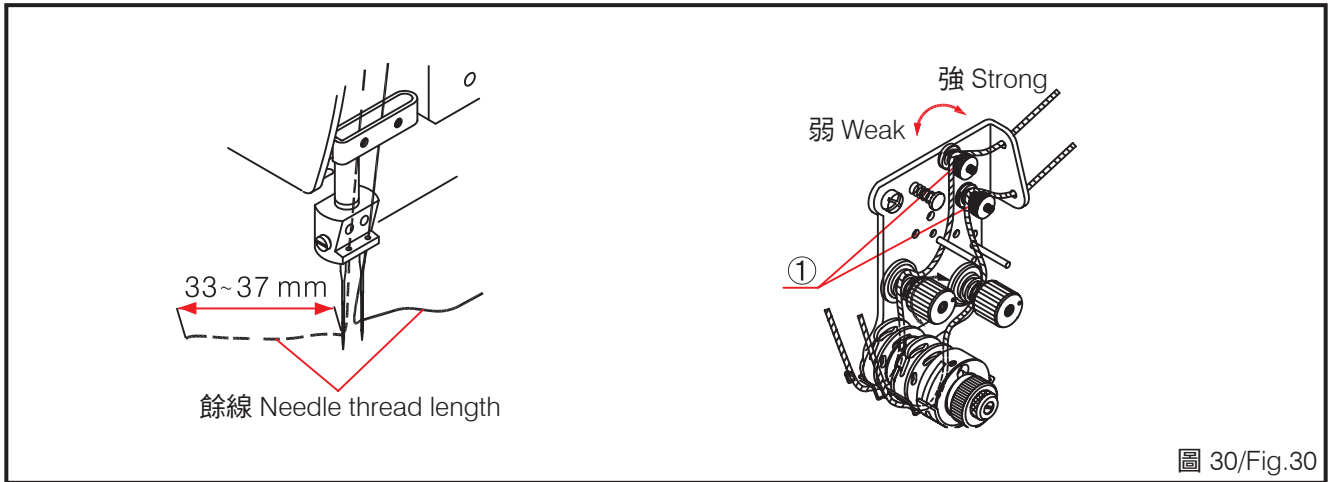


圖 30/Fig.30

## 清理

## CLEANING

以下之清理動作要每天進行，以保持機器良好，且延長機器壽命，除此之外，假如機器有一段時間沒使用，在使用前，亦應執行下列清理程序。

The following cleaning process needs to be done daily for maintaining machine at a good condition and for prolonging the machine life. Besides, before restarting the machine after an idling time, the following cleaning processes are needed also.

### 注意事項

- (1) 清理動作前，先關閉電源，否則機器之踏板誤碰時，會造成傷害。
- (2) 要確定戴上手套及護目鏡，當處理潤滑油時，才不會傷害眼睛或皮膚及火災之可能發生。
- (3) 除此之外，在任何情況下，不可喝下潤滑油。如喝下將造成嘔吐及腹瀉，避免讓小孩拿到。

### ATTENTION

- (1) Turn the power off before starting the cleaning processes. Otherwise, accidentally pushing the pedal may cause injuries.
- (2) Be sure to put on gloves and protective glasses for handling lubricant to avoid the eyes and the skin injury, or fire occurring.
- (3) In addition, do not drink the lubricant under any circumstances. Drinking it may cause vomit and diarrhea. Keep it away from children.

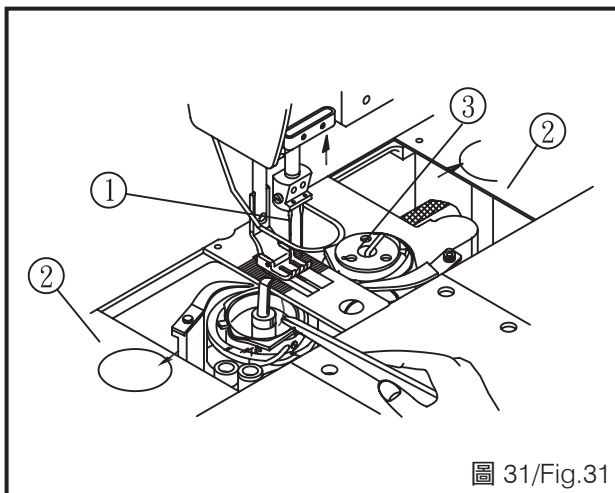


圖 31/Fig.31

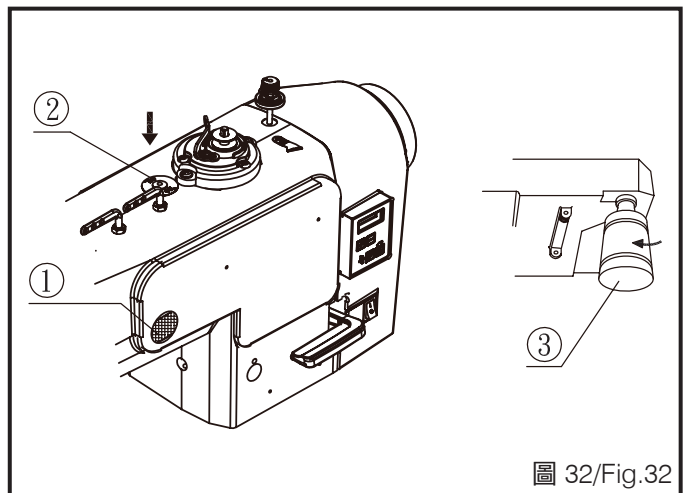


圖 32/Fig.32

#### 1. 梭頭清理 (圖 31)

- (1) 轉動皮帶輪，使針①提升到上始點
- (2) 打開左右平台蓋②。
- (3) 取出梭子③。
- (4) 清理梭頭內之線屑。
- (5) 重新安裝梭子③。

#### 2. 油的補充 (圖 32)

只能使用 SIRUBA 所使用之潤滑油 (MOBIL# 10)

- (1) 假如油量降到油視鏡①之低油量指標，將油從加油口②加油，直到高油量指標。

- (2) 假如油罐③油量已滿，鬆開油桶③把油倒掉。

- (3) 鎖緊油罐③。

#### 3. 潤滑

請參考 "潤滑" 部分的指示說明來潤滑縫紉機。

#### 1. Hook cleaning (Fig.31)

- (1) Wind the hand wheel to lift needles ① to the upper dead point.
- (2) Remove the hook covers ② .
- (3) Take the bobbins ③ out.
- (4) Clean the lints inside the hook.
- (5) Set the bobbins ③ back.

#### 2. Oil replenished (Fig.32)

Please use the specified lubricant (MOBIL# 10)

- (1) If the lubricant level is lower than the lower level on the indication glass ① , refill the lubricant into the lubricant hole ② until it reaches the higher lubricant level.
- (2) If the lubricant in the oil tank ③ is full, please loosen the oil pot ③ to pull some lubricant out.
- (3) Tighten the pot ③ .

#### 3. Lubrication

Please refer the indicates of the "LUBRICATION" section to lubricate the sewing machines.

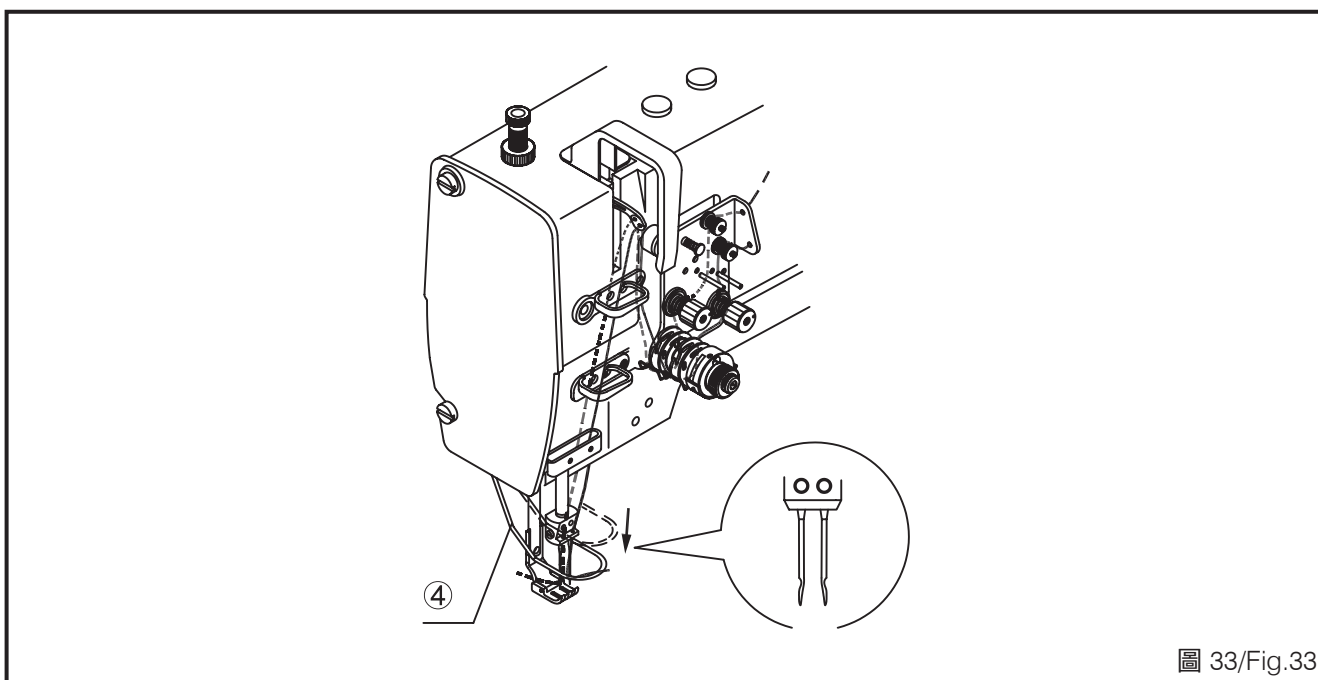


圖 33/Fig.33

#### 4. 檢查 (圖 33)

- (1) 檢查上線是否正確地安裝。
- (2) 檢查針頭有沒有毛邊或鈍，如果有即要更換。
- (3) 將保護手指裝置④拉低。
- (4) 開始測試車縫。

#### 4. Inspection (Fig.33)

- (1) Inspecting if the upper threads are threaded correctly.
- (2) Inspecting if the needles are clean and sharp, or needed to be replaced.
- (3) Lowering the finger guarding device ④ .
- (4) Starting stitches testing.

## SERVICE PARTS POLICY

To ensure the quality and safety of machine, all SIRUBA parts pass the highest quality inspection and test. For any case of adopting non-genuine SIRUBA parts for replacement and service, it may cause not only losing the warranty coverage, but also the unexpected damage to the operator and property.

In some cases, issues such as difficulty of obtaining parts might make it impossible for us to repair or replace malfunctioning items even if the service period has not yet ended. We ask for your understanding on this matter

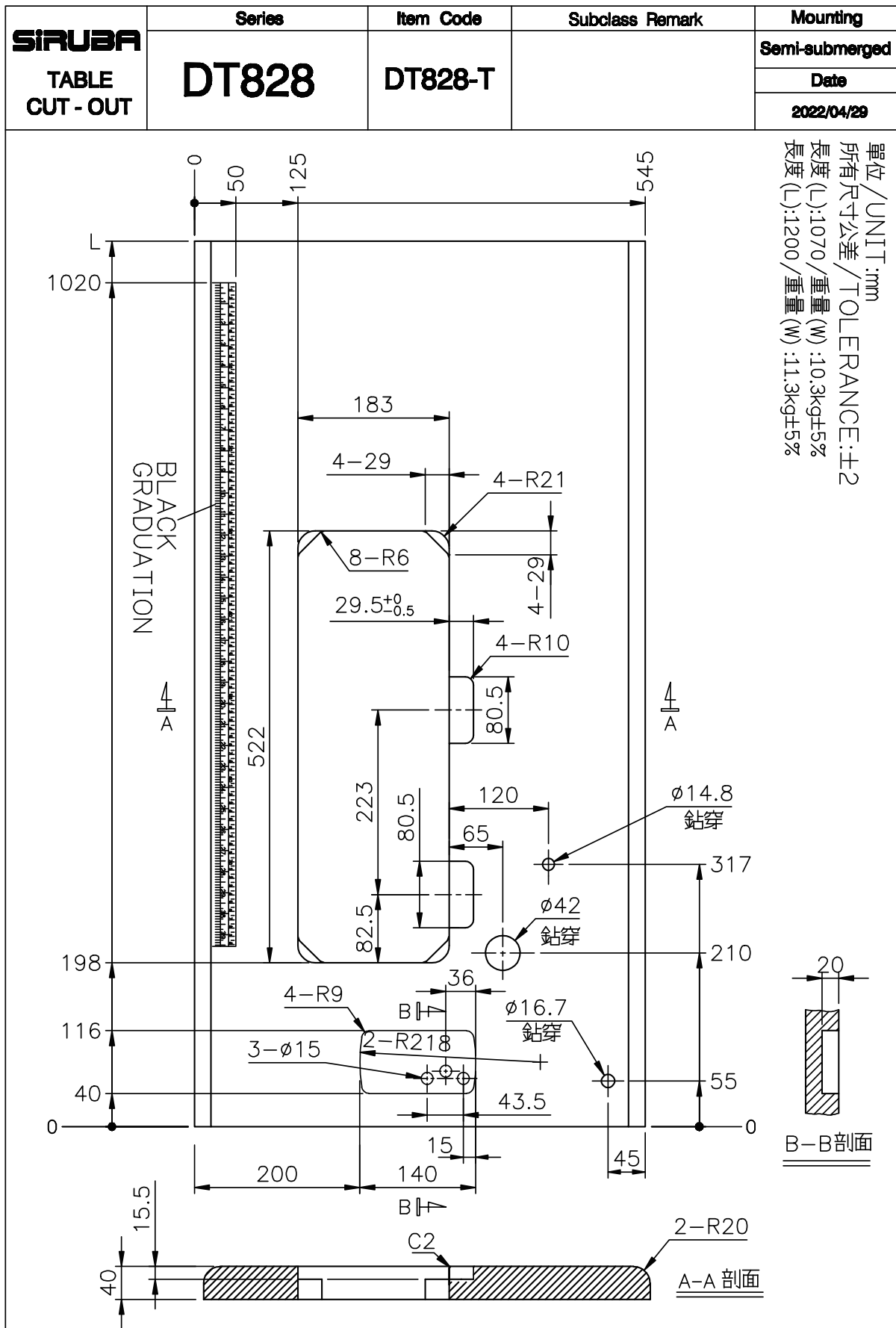
To continuously provide our customers the high quality machines and service, we do not guarantee the parts supply service for the discontinued models after 5 years since the production stops.

## 服務部分政策

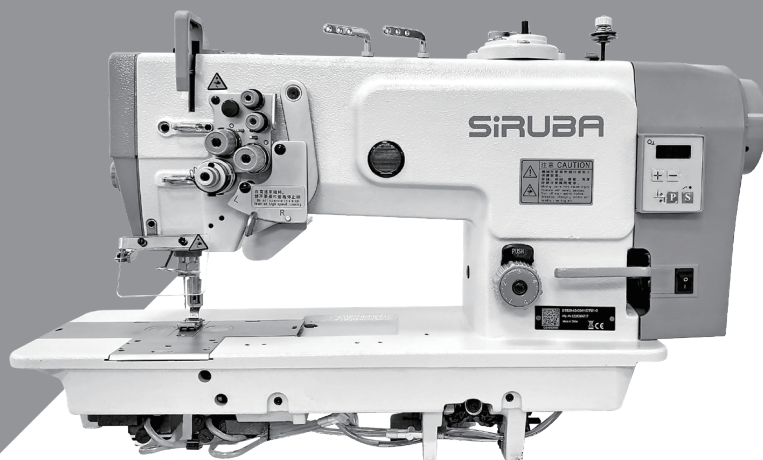
為確保機器的質量和安全，所有 SIRUBA 部件均通過了最高質量的檢驗和測試。對於任何採用非正品 SIRUBA 部件進行更換和維修的情況，不僅可能導致保修範圍的損失，還可能導致對操作員和財產的意外損壞。

在某些情況下，即使服務期尚未結束，諸如難以獲得零件等問題也可能使我們無法修理或更換故障物品。我們要求您就此事達成諒解

為了不斷為客戶提供高質量的機器和服務，我們不保證自生產停止 5 年後停產的型號的零件供應服務。







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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.  
DTY01.MAY.2022