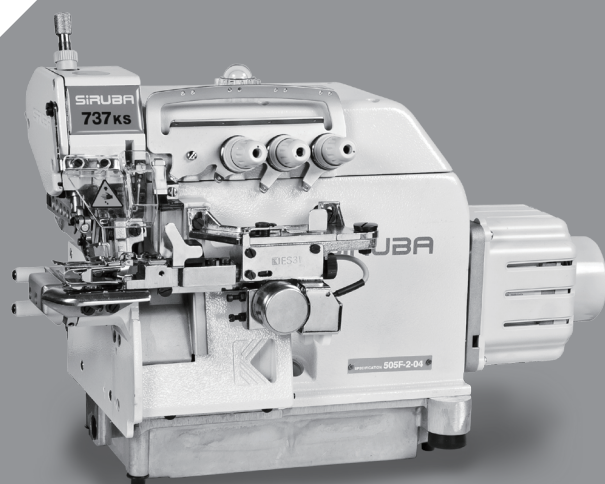


SIRUBA[®] Sew Reach



使用說明書與零件圖

INSTRUCTION BOOK & PARTS LIST

■ 700KS-ESK



危險水準的說明 Explanation of Dangerous Level

 危險 Dangerous	<p>如果忽視此標記而運行了錯誤的機械操作, 保養時肯定會引起當事者或第三者人員重傷或死亡</p> <p>Don't ignore the warning sign and don't proceed incorrect operation. Or it will cause the person or the third party seriously injured or dead during maintenance.</p>
 注意 Caution	<p>如果忽視此標記而運行了錯誤的機械操作, 保養時有可能會引起當事者或第三者人員受傷及造成設備損壞</p> <p>Ignoring this warning sign and proceed incorrect operation will cause the person involved or the third party wounded and equipment damaged during maintenance.</p>

警告圖案表示及表示標幟的說明 Explanation of Warning Signs and Labels

警告圖案表示 Warning Sign		<p>運動部位, 謹防工傷事故</p> <p>Moving part, beware of industrial accident</p>
		<p>高壓部位, 謹防觸電事故</p> <p>High voltage, beware of electric shock</p>
		<p>高溫部位, 謹防燙傷事故</p> <p>High temperature, beware of burns</p>
指示標誌 Instruction Label		<p>禁止 Prohibited</p>
		<p>地線的接線表示</p> <p>Indication of ground wiring</p>

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安裝衣襪尺寸指引

WELT GUIDE COMPLETE INSTALLATION

1. 將左邊的可撤式導板和落針處中心線對齊以左右調整。(圖 1)
2. 對齊可撤式導板尾端和切刀，以前後調節。(圖 1)

1. Align the left side of the retractable guide with the center line of the needle drop to make a left-to-right adjustment.(Fig. 1)
2. Align the end of the retractable guide with the knife to make a front-to-back adjustment. (Fig. 1)

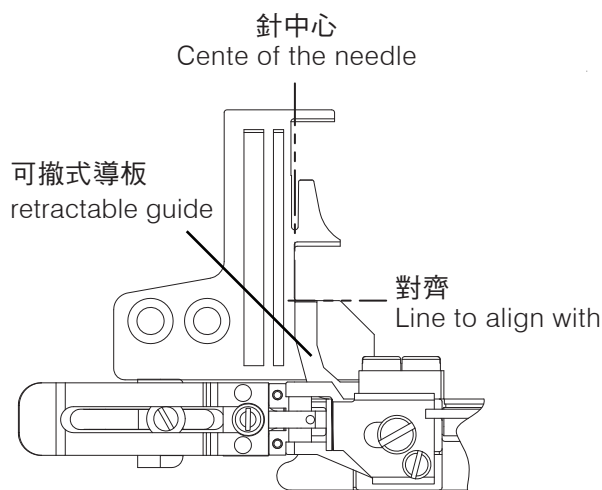


圖 1/ Fig. 1

3. 可撤式導板座高度調整
 - (1)如圖所示，放鬆螺絲以調整可撤式導板座。(圖 2)
 - (2)可撤式導板座應和針板平行並間隔 0.03mm。(圖 3)

3. Retractable guide base height adjustment
 - (1)Loosen the screw to adjust the retractable guide base as shown in the figure.(Fig. 2)
 - (2)The retractable guide base should be parallel with the needle plate with a 0.03mm clearance.(Fig. 3)

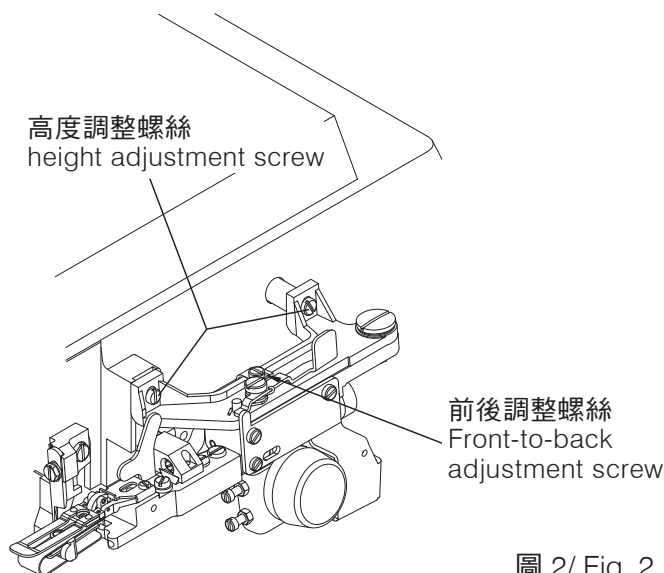


圖 2/ Fig. 2

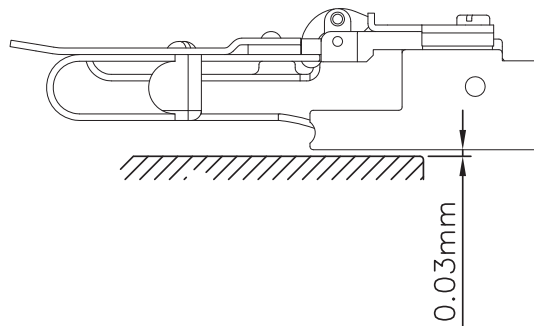


圖 3/ Fig. 3

段縫厚度檢測器功能檢測

CROSS SEAM THICKNESS DETECTOR FUNCTION DETECTING

1. 電源開啟。(圖 4)
2. 電源指示燈亮。(圖 4)

1. Turn the machine ON. (Fig. 4)
2. Power source indicator lamp is light up. (Fig. 4)

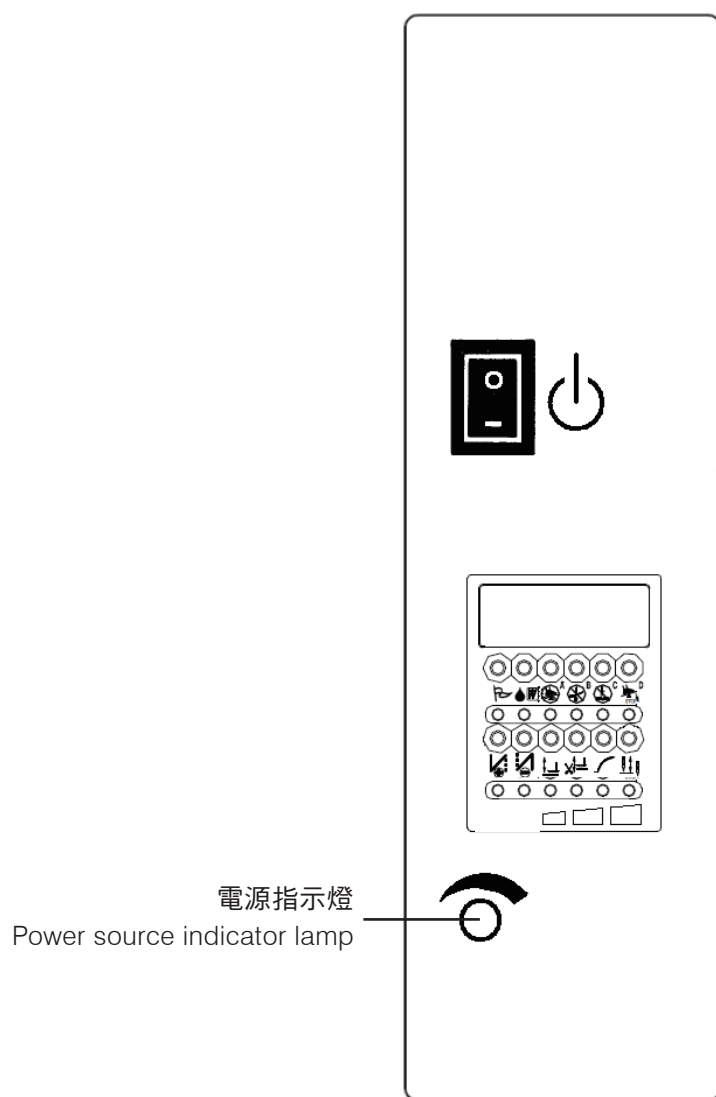
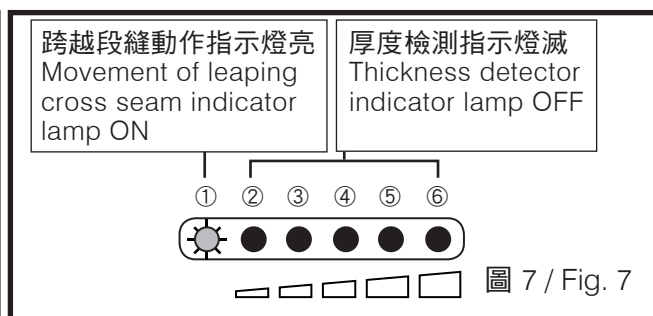
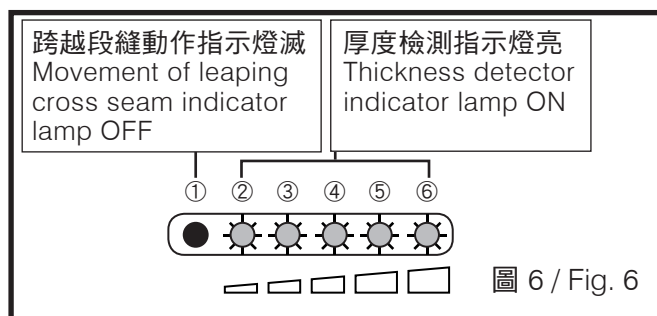
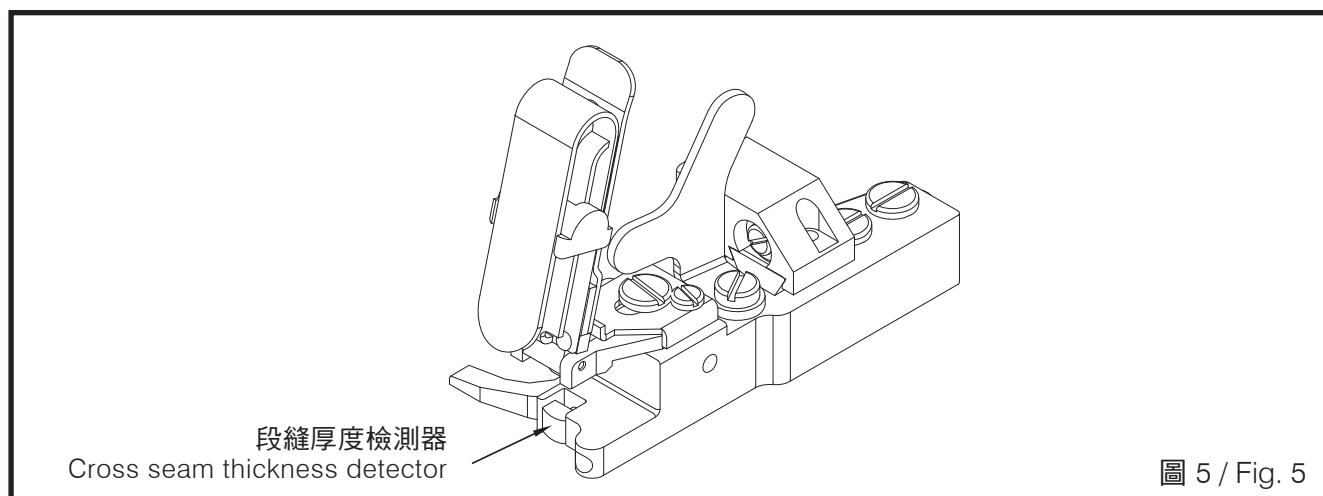


圖 4 / Fig. 4

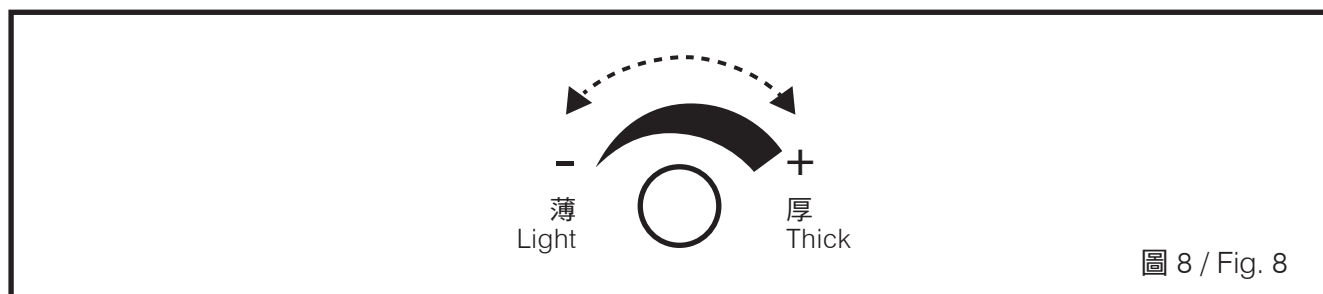
3. 輕壓段縫厚度檢測器改變其位置，確定厚度檢測指示燈動作是否正確。(圖 5)
- (1) 段縫厚度檢測器未碰觸時，跨越段縫動作指示燈① OFF，厚度檢測指示燈② ~ ⑥ ON。(圖 6)
- (2) 段縫厚度檢測器輕壓到底，跨越段縫動作指示燈① ON，厚度檢測指示燈② ~ ⑥ OFF。(圖 7)
- (3) 如動作異常，請參考 5「調整」，進行感測器位置調整。

3. Press cross seam thickness detector to change its position and make sure whether the movement of the thickness detector indicator lamp is correct or not. (Fig. 5)
- (1) (1) When cross seam thickness detector do not touch, movement of leaping cross seam indicator lamp ① OFF, thickness detector indicator lamp ②~⑥ ON. (Fig.6)
- (2) (2) Press cross seam thickness detector lightly, movement of leaping cross seam indicator lamp ① ON, thickness detector indicator lamp ②~⑥ OFF. (Fig.7)
- (3) If it malfunction, please refer to 5 "Adjustment" to adjust the position of sensor.



4. 依所需跨越的段縫處厚度，調整旋鈕位置。(圖 8)

4. Adjust the knob position according to the thickness of the cross seam which needed to leap. (Fig. 8)



5. 調整 (圖 9)

- (1) 確認檢測器安裝位置間隙為 3 mm。
(圖 1-1)
- (2) 確認磁鐵安裝位置間隙為 1.5 mm。
(圖 1-2)
- (3) 鬆開感測器固定座的固鎖螺絲。
- (4) 使用三用電表，量測感測器輸出電壓 (DC)。
- (5) 旋轉調節螺絲，調整感測器位置，使感測器輸出電壓介於 DC0.5~0.6V，此時鎖緊固鎖螺絲固定感測器固定座的位置。

P.S：鎖緊固鎖螺絲後，務必確認感測器輸出電壓仍然介於 DC0.5~0.6V 之間。

5.Adjustment (Fig. 9)

- (1) Make sure the gap of the detector's install position is 3mm.(Fig. 1-1)
- (2) Make sure the gap of magnet's install position is 1.5mm. (Fig. 1-2)
- (3) Loosen lock screw of sensor support.
- (4) Use multimeter to measure output voltage (DC) from sensor.
- (5) Turn the adjustment screw to adjust the position of sensor to make the output voltage of sensor within DC 0.5~0.6V, as the time,tighten lock screw to fix the sensor support's position.

P.S:After tightened lock screw, always assure that the output voltage of sensor is between DC0.5~0.6V.

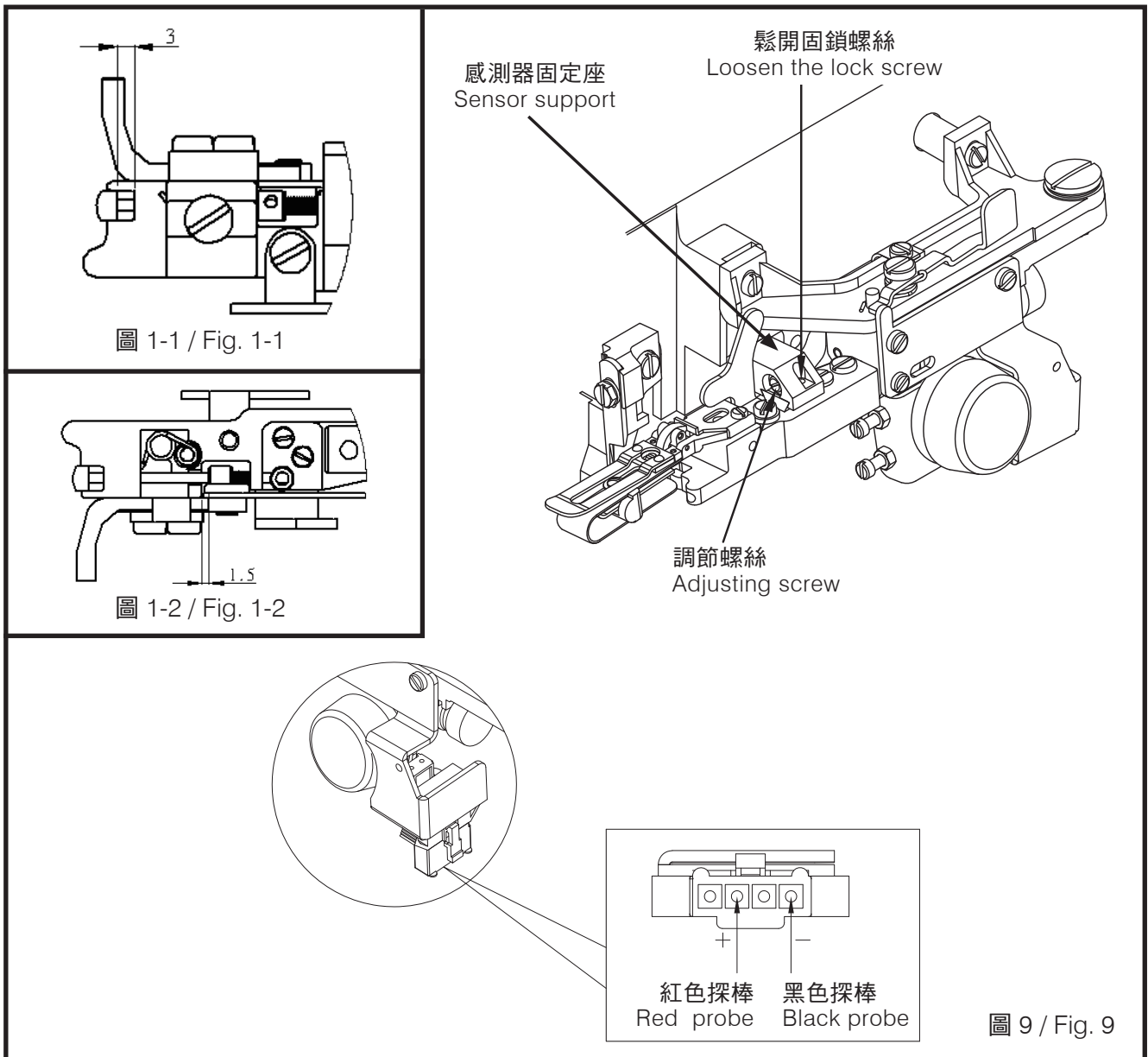


圖 9 / Fig. 9

校位並調節衣襠尺寸導引

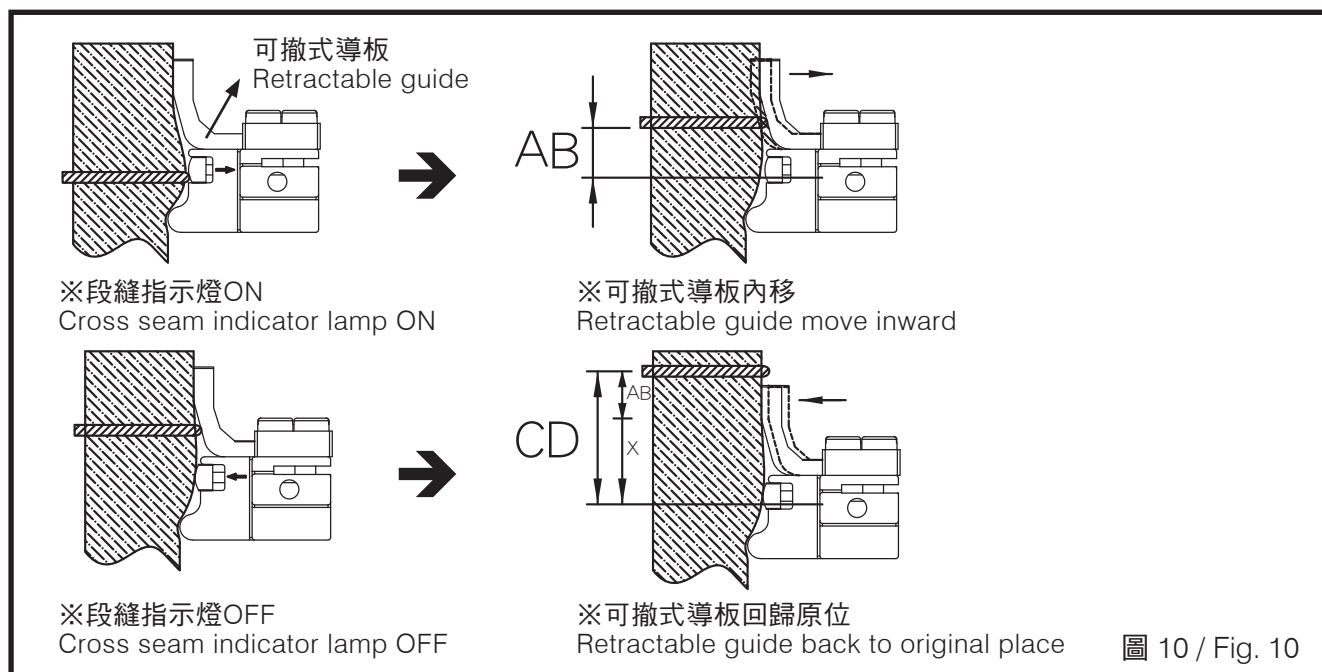
POSITIONING AND ADJUSTING THE WELT GUIDE

•可撤式導板動作

當段縫厚度檢測器檢測到段縫處的厚度符合設定條件，此時段縫指示燈 ON，控制器開始計算 N 針 (AB 值) 後，可撤式導板內移將布料往內移防止衣襠段縫處漏縫。當可撤式導板內移，控制器開始計算車縫 X 針 (CD 值減 AB 值) 後，可撤式導板回歸原位，使得得以正常操作衣襠車縫。(圖 10)

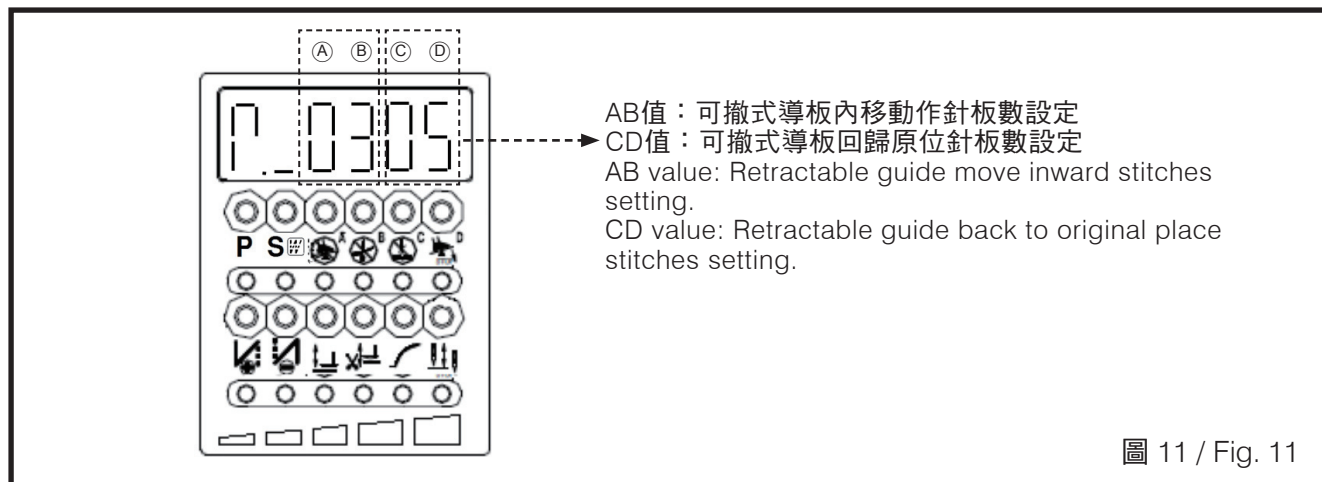
•Retractable guide action

While cross seam thickness detector detected thickness of cross seam matches condition setting, at the time, the cross seam indicator lamp is ON, after controller start counting sewing N stitches (AB value), the retractable guide gets inside to move the fabric inward to prevent cross seam of bottom hem skip stitching. While retractable guide move inward, after the controller start to count sewing X stitches (CD value minus AB value), retractable guide back to original place to make it operates bottom hem sewing.(Fig. 10)



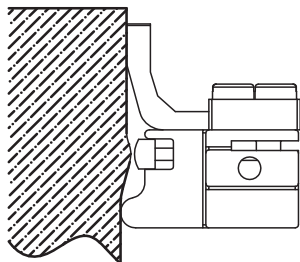
•AB 值與 CD 值的規則為：(圖 11)

•The rule of AB and CD values:(Fig. 11)

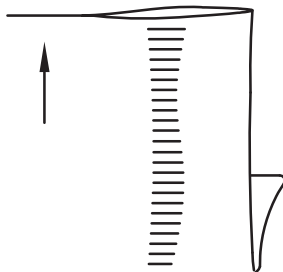


1. 衣襪車縫平縫區。(圖 12)

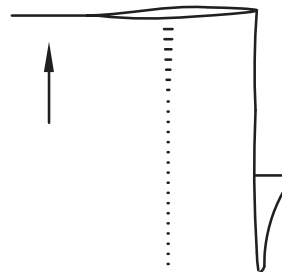
1.Hem stitch the flat seam section. (Fig.12)



平縫區
Flat seam section



如縫寬度過大，順時針
轉調節螺絲
If the seam width is too
big, turn the adjusting
screw clockwise



如縫寬過小，逆時針
轉調節螺絲
If the seam width
is too small, turn
the adjusting screw
counterclockwise

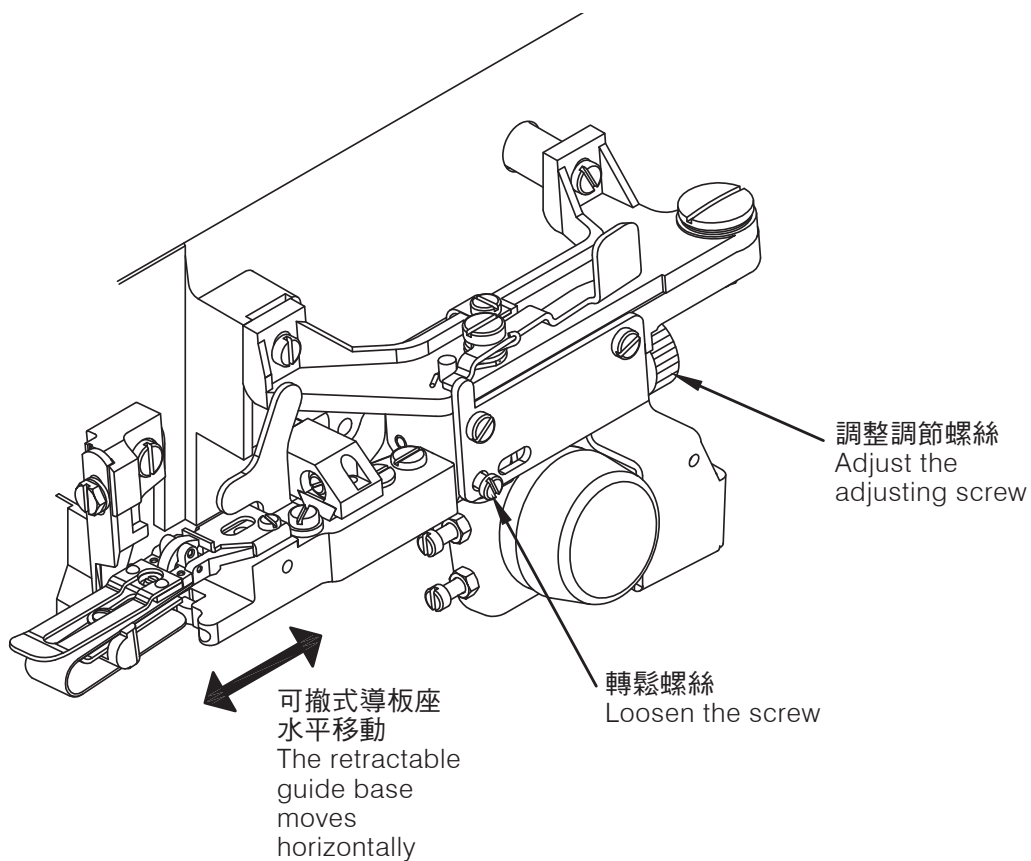
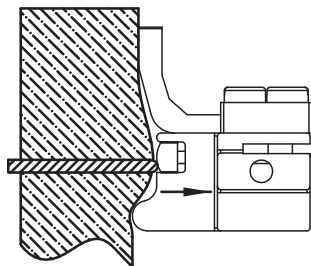


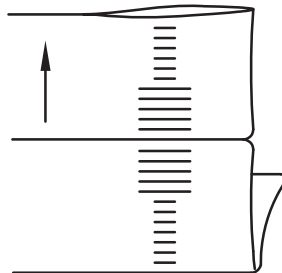
圖 12 / Fig. 12

2. 盲縫段縫部。(圖 13)

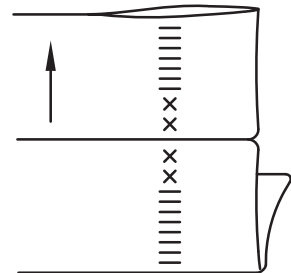
2. Blindstitch hem the cross seam section. (Fig. 13)



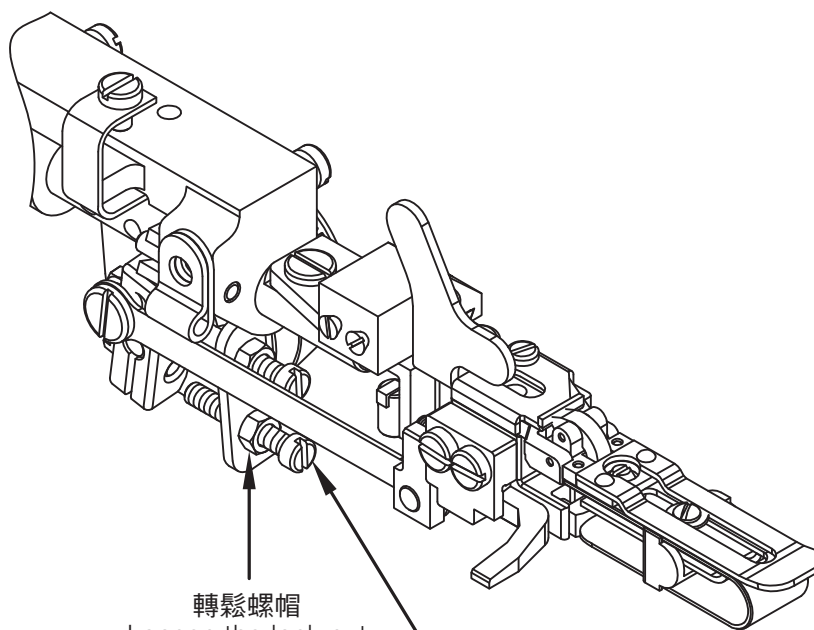
段縫部
Cross seam section



如段縫處前和後縫寬
過大，順時針轉螺帽
If the seam width is
too big before and
after the cross seam
section, turn the nut
clockwise



如在段縫處前後布料
漏縫，逆時針轉螺帽
If the stitches miss
the fabric before and
after the cross seam
section, turn the nut
counterclockwise



轉鬆螺帽
Loosen the lock nut

調整調節螺絲
Adjust the adjusting screw

圖 13 / Fig. 13

檢查並調整摺疊器

CHECKING AND ADJUSTING THE FOLDER

- 調整摺疊器前緣和段縫厚度檢測器的間隔成縫紉布料的厚度。(圖 14)

- Adjust the gap between the leading edge of the folder and the cross seam thickness detector to thickness of the fabric to be sewn. (Fig. 14)

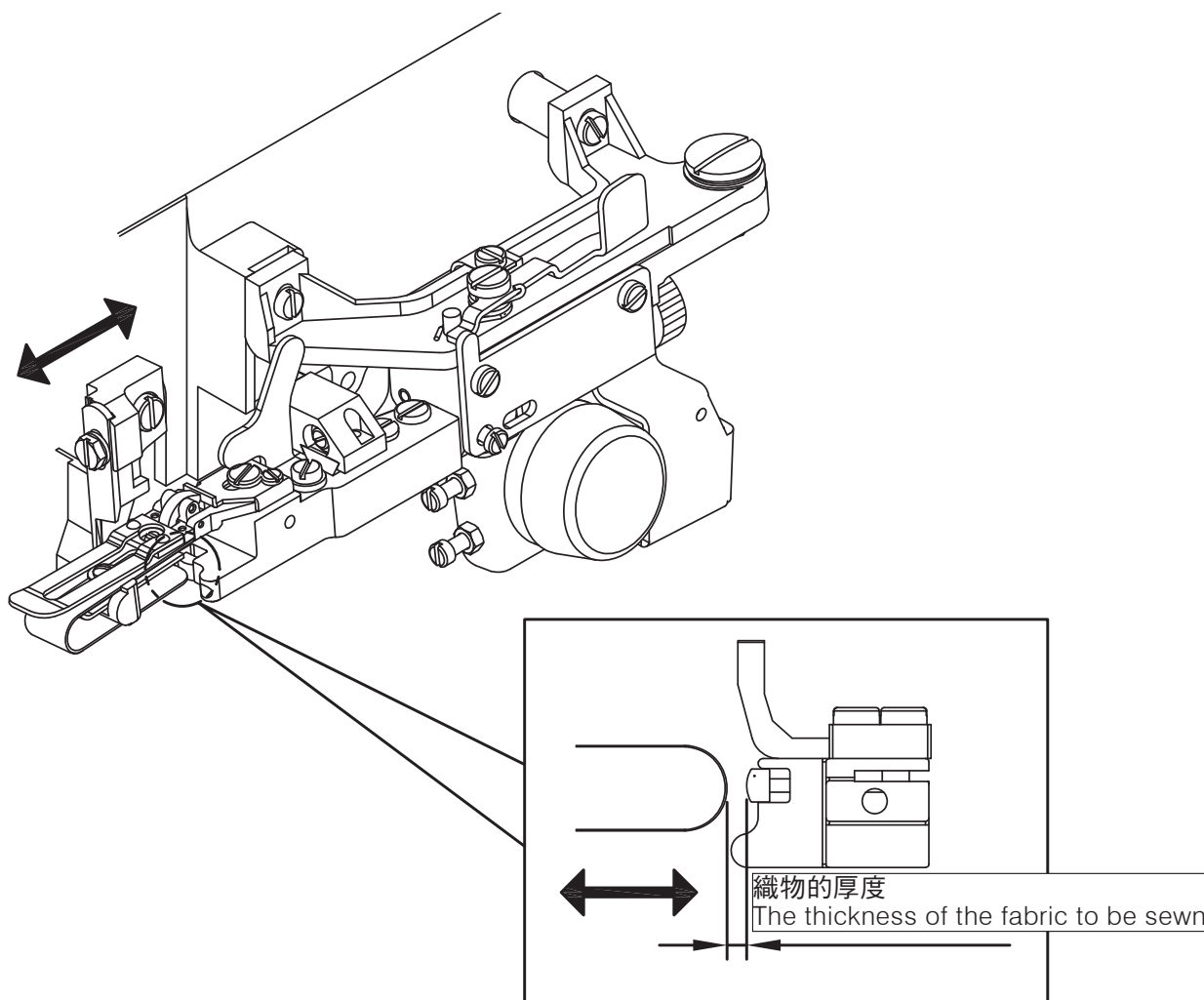


圖 14 / Fig. 14

安裝與調整

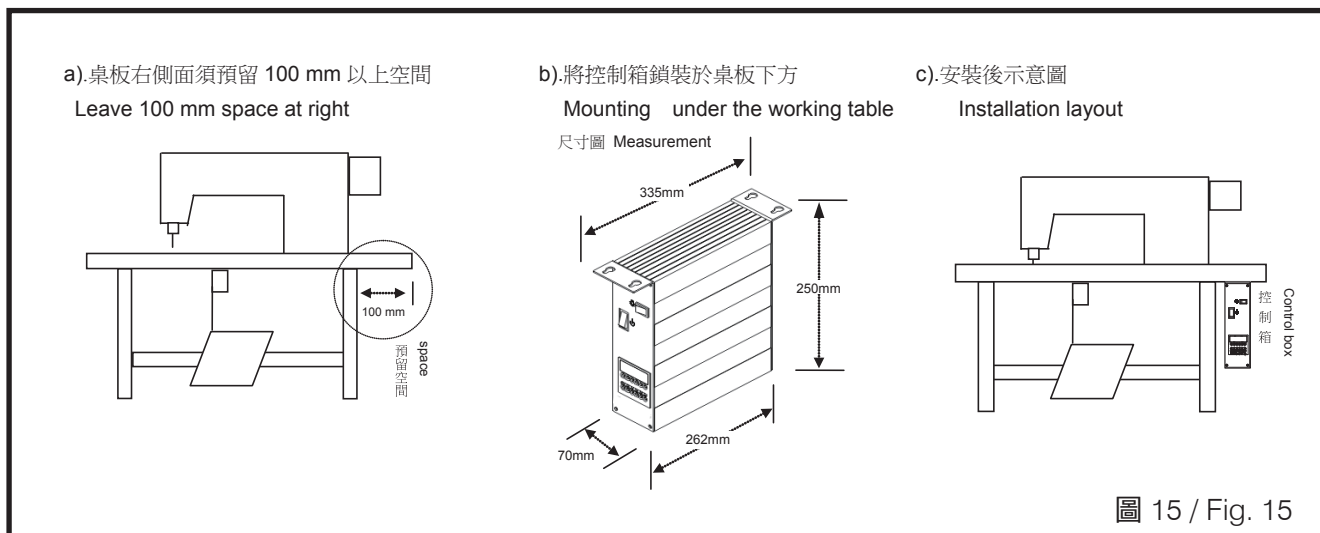
INSTALLATION AND ADJUSTMENT

1. 馬達的安裝
請參閱各車頭製造廠之說明書。

1. Motor installation
Please refer to the machine head's instruction.

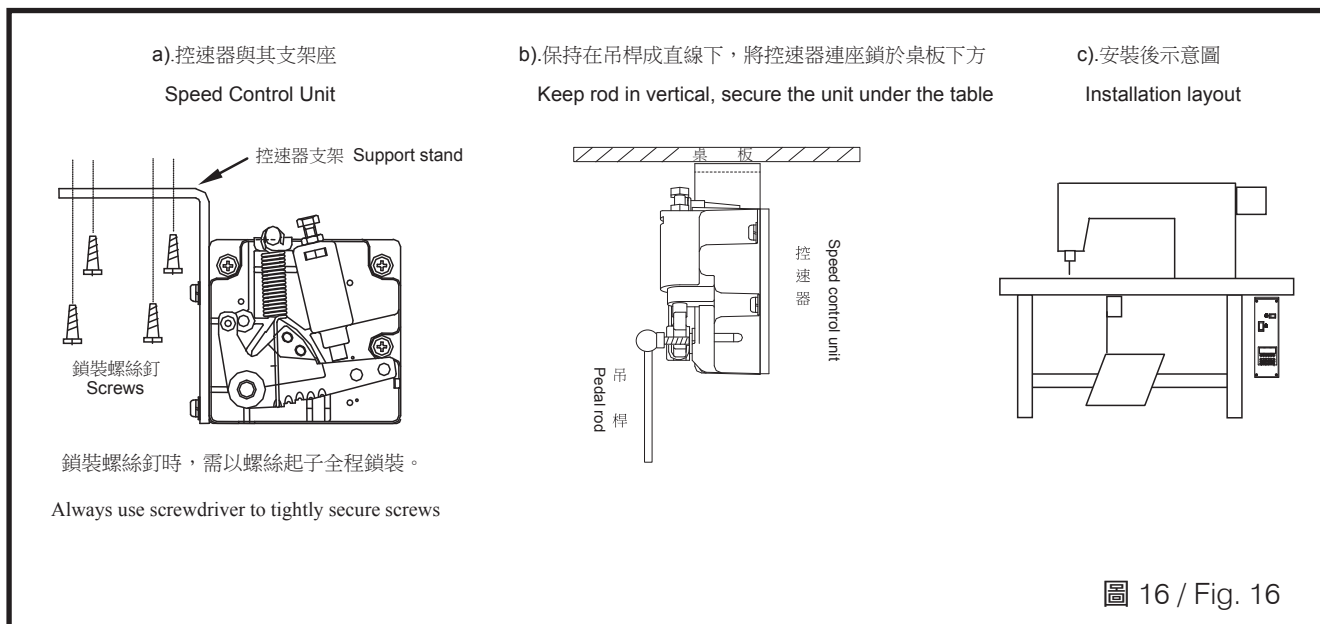
2. 控制箱的安裝。(圖 15)

2. Control Box Installation.(Fig. 15)



3. 控速器的安裝。(圖 16)

3. Speed Control Unit Installation.(Fig. 16)



4. 控速器前 / 後踏力量的調整 (圖 17)

• 控速器各部位名稱：

A: 前踏力量彈簧

B: 後踏力量的調整螺栓

C: 踏板旋臂

D: 腳踏板吊桿

4. Adjust the speed control unit.(Fig. 17)

• Components of the speed control unit :

A: Spring for toeing forward force adjustment

B: Bolt for heeling backward force adjustment

C: Treadle / Pedalarm

D: Pitman Rod for Treadle / Pedal

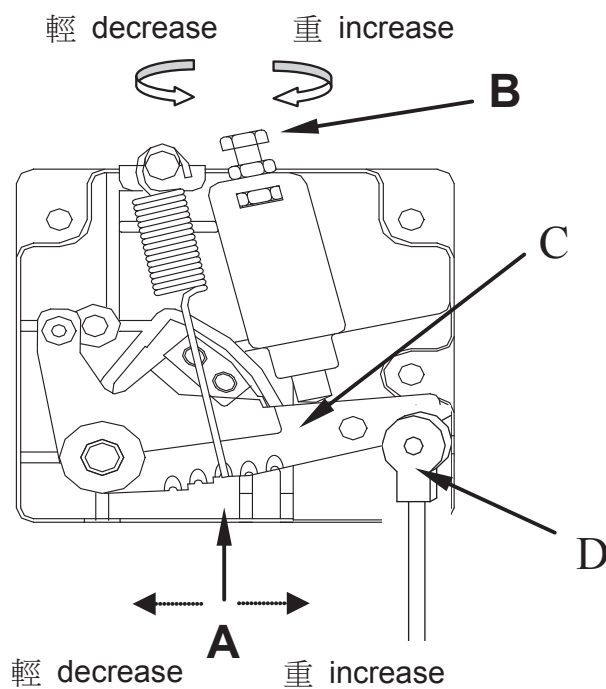


圖 17 / Fig.17

控制箱說明

DESCRIPTION OF THE CONTROL BOX

•前視圖 (圖 18)

•Front side.(Fig. 18)

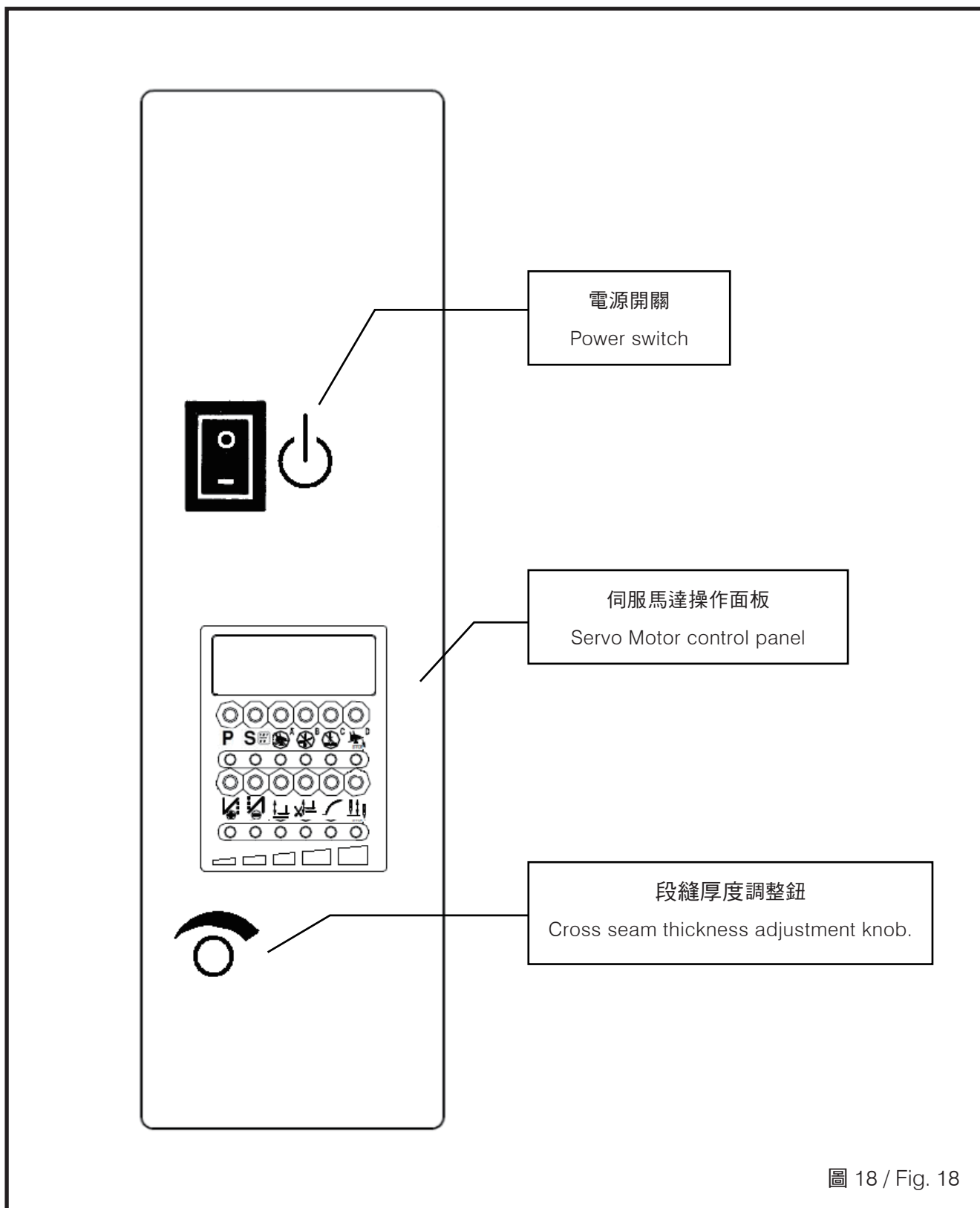


圖 18 / Fig. 18

•接線圖 (圖 19)

•Wiring (Fig. 19)

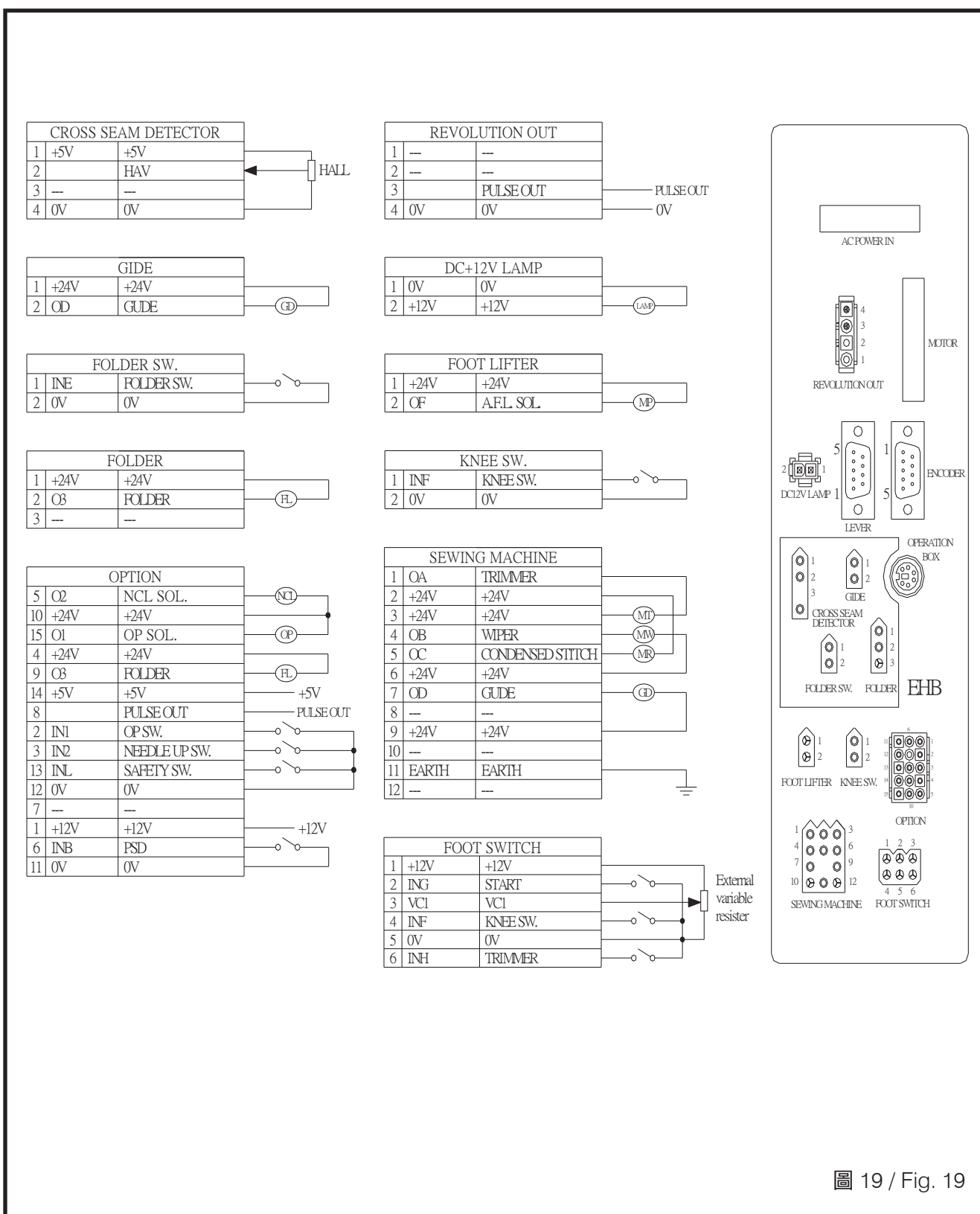


圖 19 / Fig. 19

跨越段縫功能調整

CROSS SEAM LEAPING FUNCTION ADJUSTMENT

1. 開啟電源 (圖 20)

1. Turn on the power (Fig. 20)

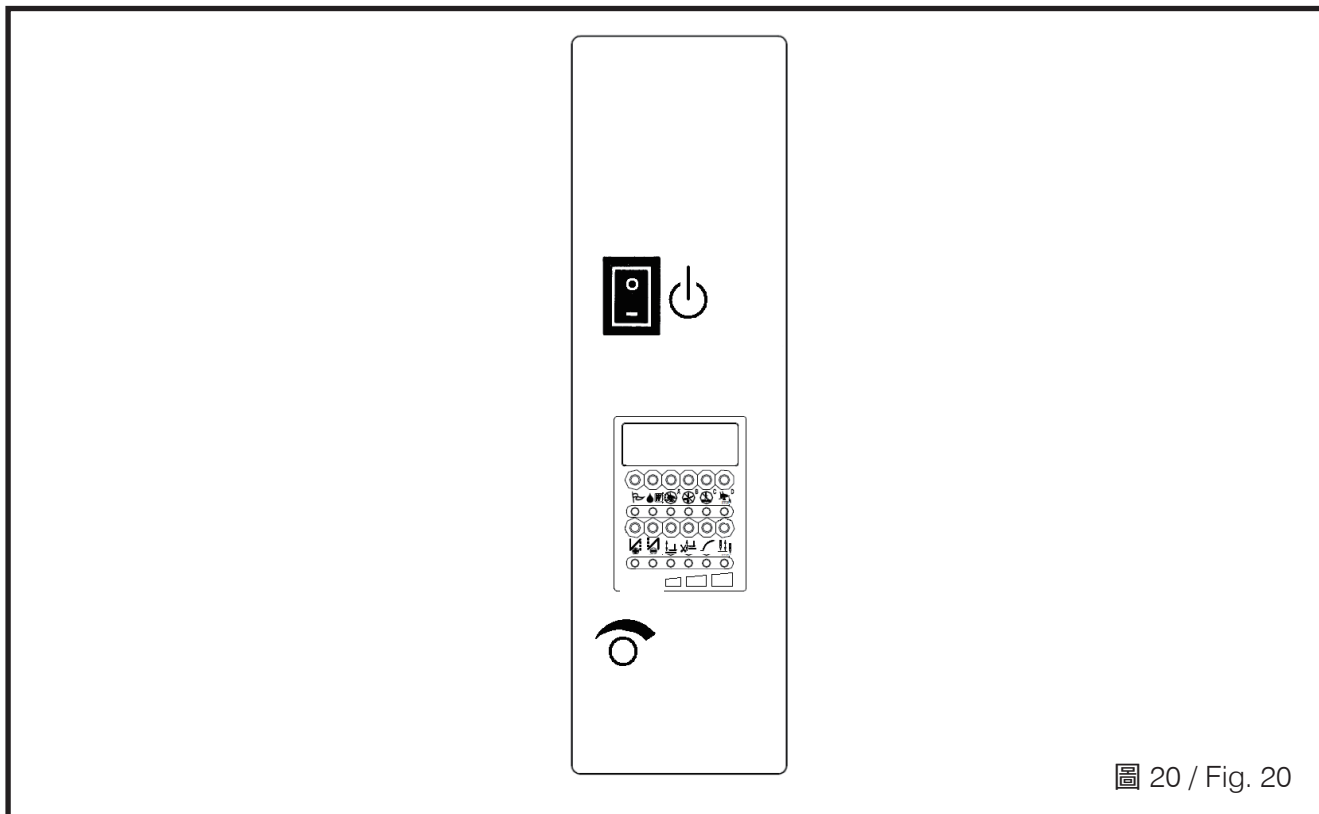


圖 20 / Fig. 20

2. 紅燈：跨越段縫檢測器位置顯示。(圖 21)
黃燈：燈亮代表啟動跨越段縫功能。

2. Red light: Cross seam leaping detector position displayed. (Fig. 21)
Yellow light: Start cross seam leaping function while yellow light lights up.

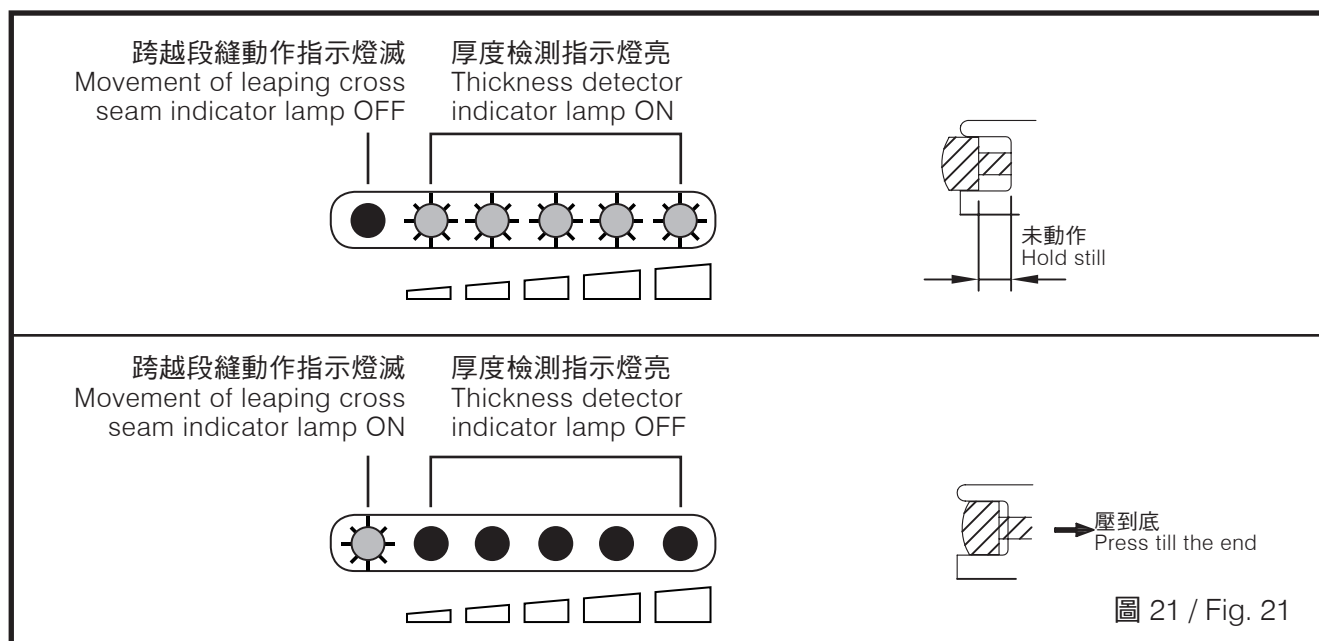
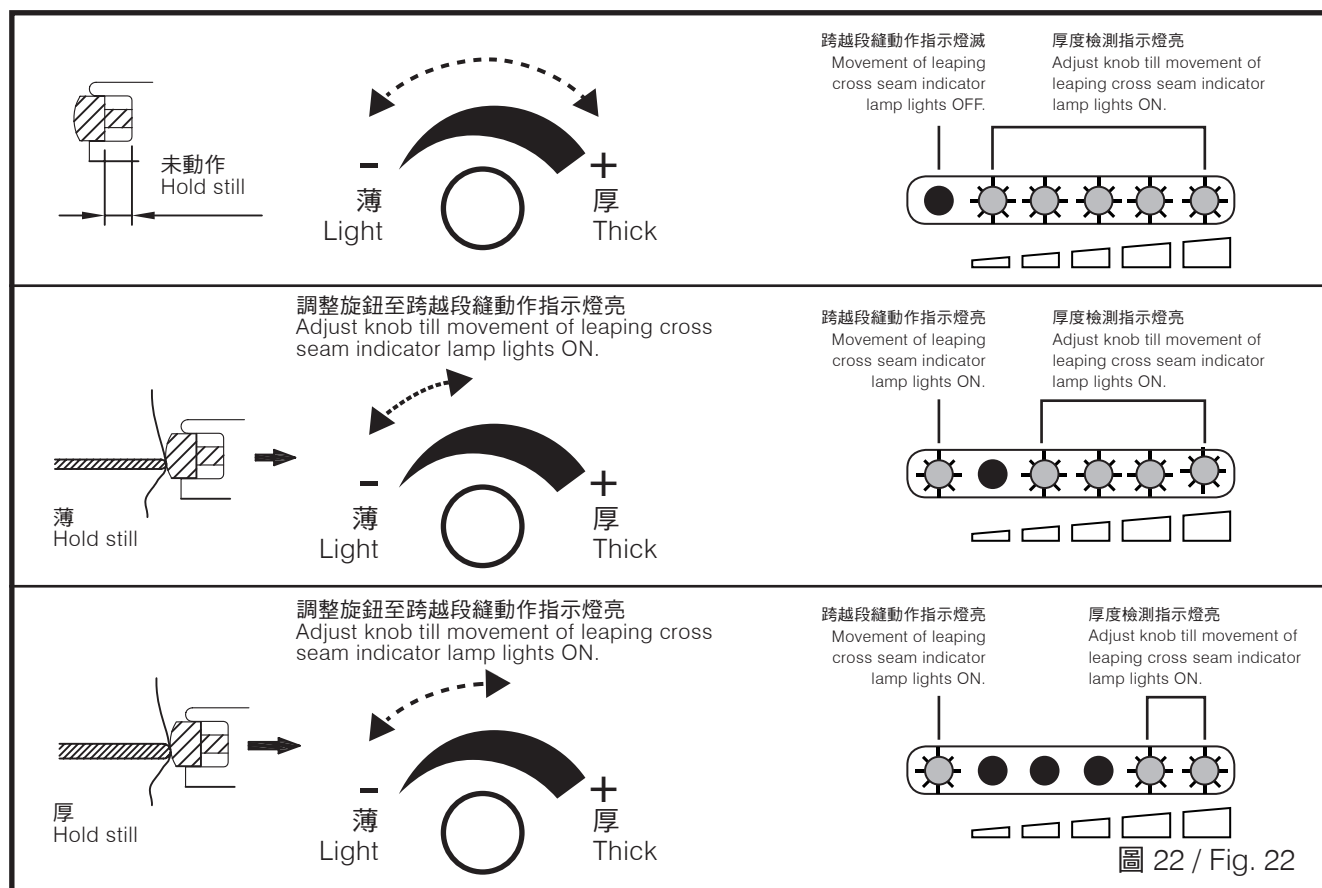


圖 21 / Fig. 21

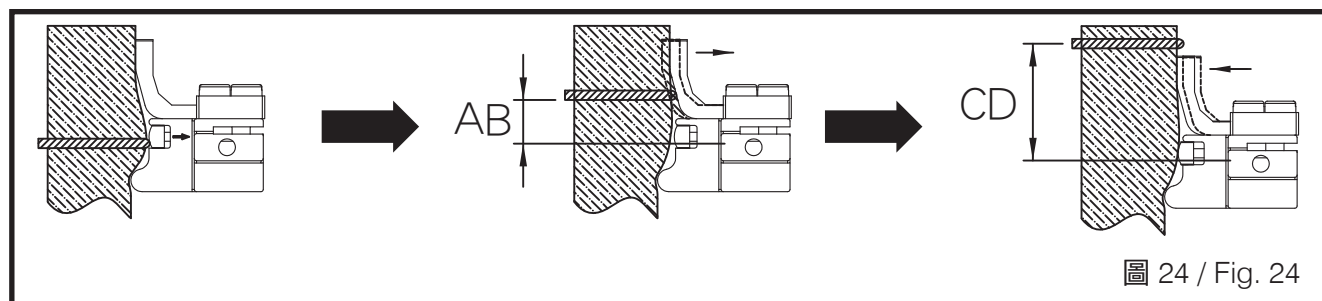
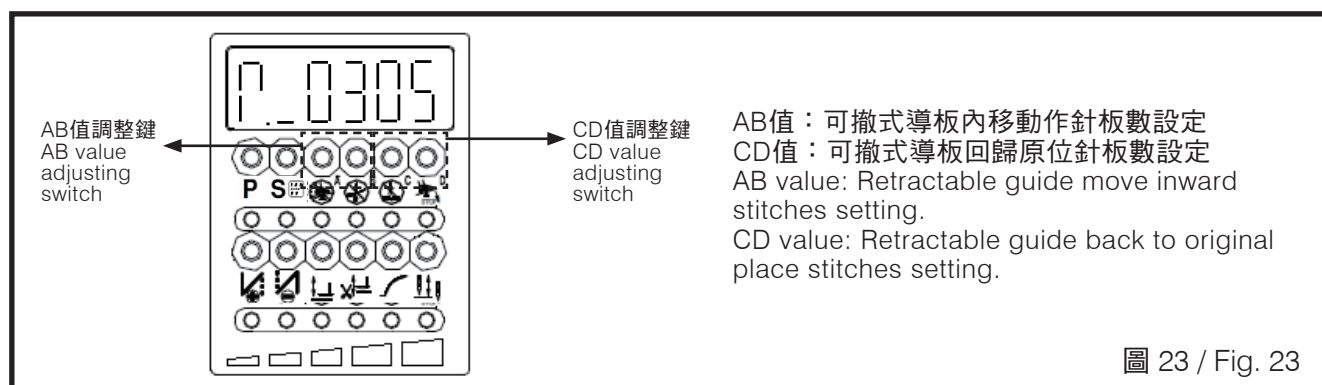
3. 依布料需要跨越段縫厚度，調整旋鈕至跨越段縫動作指示燈亮。(圖 22)

3. According to the cross seam leaping thickness of fabric, adjust knob to movement of leaping cross seam indicator lamp lights up.(Fig. 22)



自動拷下擺功能設定

AUTO-HEMMING FUNCTION



七段顯示器字體與實際數值對照表

7-SEGMENT DISPLAY CHARACTERS COMPARE TABLE

• 數值字體部份 (表 1)

• Arabic Numerals (Table 1)











實際數值 Actual	0	1	2	3	4	5	6	7	8	9
七段顯示器 Display										

表 1 / Table 1

• 英文字體部份 (表 2)

• English Alphabet (Table 2)



























英文數字 (Actual)	A	B	C	D	E	F	G	H	I	J
七段顯示器 (Display)										
英文數字 (Actual)	K	L	M	N	O	P	Q	R	S	T
七段顯示器 (Display)										
英文數字 (Actual)	U	V	W	X	Y	Z				
七段顯示器 (Display)										

表 2 / Table 2

操作環境照明

提供一個警示標誌，告知使用者：工業用縫紉品或是縫紉系統必須在該縫紉區域未啟動照明裝置前，禁止插電或通電；照明裝置的最大輸入功率應該能夠輕易辨識，當照明裝置被重置或移動的時候，警示標誌也應設置在照明裝置插座上或是附近。警示標示如圖所示。

(圖 24)

LIGHTENING OF THE OPERATION ENVIRONMENT

Provide a warning that an industrial sewing unit or sewing system must always be unplugged from the local lighting of the sewing area before relamping, the marking of maximum rated input of lamp shall be easily discernible while the lamp is being replaced indicated on or near the lamp socket as shown on. (Fig.24)



操作者條件

1. 熟讀並了解使用說明書內容。
2. 認識機器各部功能及注意事項。
3. 了解各警告標籤之意義。
4. 了解熟悉機器之操作方式。
5. 操作者須保持精神狀態良好。
6. 操作者須穿著合宜適當之工作服。
7. 視需要培養操作者使用機器之熟練度。

CONDITIONS OF ALL OPERATORS

1. Read and understand well the content of this instruction book.
2. Know the functions of major parts and understand the notices
3. Truly realize the meanings of all warning tags
4. Realize and be familiar with how to operate this machine.
5. Operators have to keep well mental status.
6. Operators shall wear appropriate and proper working suits.
7. Develop the familiarity of how to operate the machine if needed.

保養

MAINTENANCE



注意CAUTION



清潔作業前，請切斷電源。當誤觸啟動開關時，縫紉機動作易導致人員受傷。
Turn off the power switch before carrying out cleaning. The machine may operate if the treadle is pressed incautiously, which could result in injury.



加潤滑油和黃油時，務必戴好保護眼鏡和手套，以防潤滑油進入眼中或沾在皮膚上，易引起發炎。

Be sure to wear protective goggles and gloves when handling the lubricating oil and grease so that they do not get into your eyes or onto your skin, otherwise inflammation can be resulted.



潤滑油或黃油不能飲用，否則將會引起嘔吐和腹瀉，將油放在小孩拿不到的地方。

Furthermore, do not drink or eat the oil nor the grease for they can cause vomiting and diarrhea. Keep the oil away of the reach of children.

縫紉機頭倒下或豎起時，請以雙手進行操作。

Use both hands to hold the machine head when tilting or returning it to its original position.



單手操作時，因縫紉機的重量較重，萬一滑落易導致受傷。

If only using one hand to move the machine, the weight of the machine head may cause slipping and you may get hurt.

定期保養項目 (表 3)

Periodical Maintenance Items (Table3)

保養循環 Maintenance Cycle	保養項目 Maintenance Items
每天 Daily	1. 清潔送料具上之棉絮 1. Clean the lint on the feed dog.
	2. 檢查油盤是否有足夠之液態油。(油量在油鏡之上、下兩紅漆記號間) 2. Check if there has enough liquid oil inside the oil pan. (The amount should be between the red up and down paint mark of the oil level gauge.)
	3. 保持機器及操作台清潔 3. Keep the machine and the operation table clean.
	4. 清潔手輪濾網上之棉絮 4. Clean the fiber on the filter net of the hand wheel.
每週 Weekly	1. 保持電源外觀乾淨 1. Keep the power cords looking clean and neat.
	2. 保持操作面板乾淨 2. Keep the operational panel clean
	3. 檢查電源零件是否鬆脫或在正確位置 3. Check if the power parts is loosening or still at the right position
每三個月 Quarterly	1. 更換油盤內之液態油 1. Change the liquid oil inside the oil pan

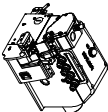











表 3 / Table3

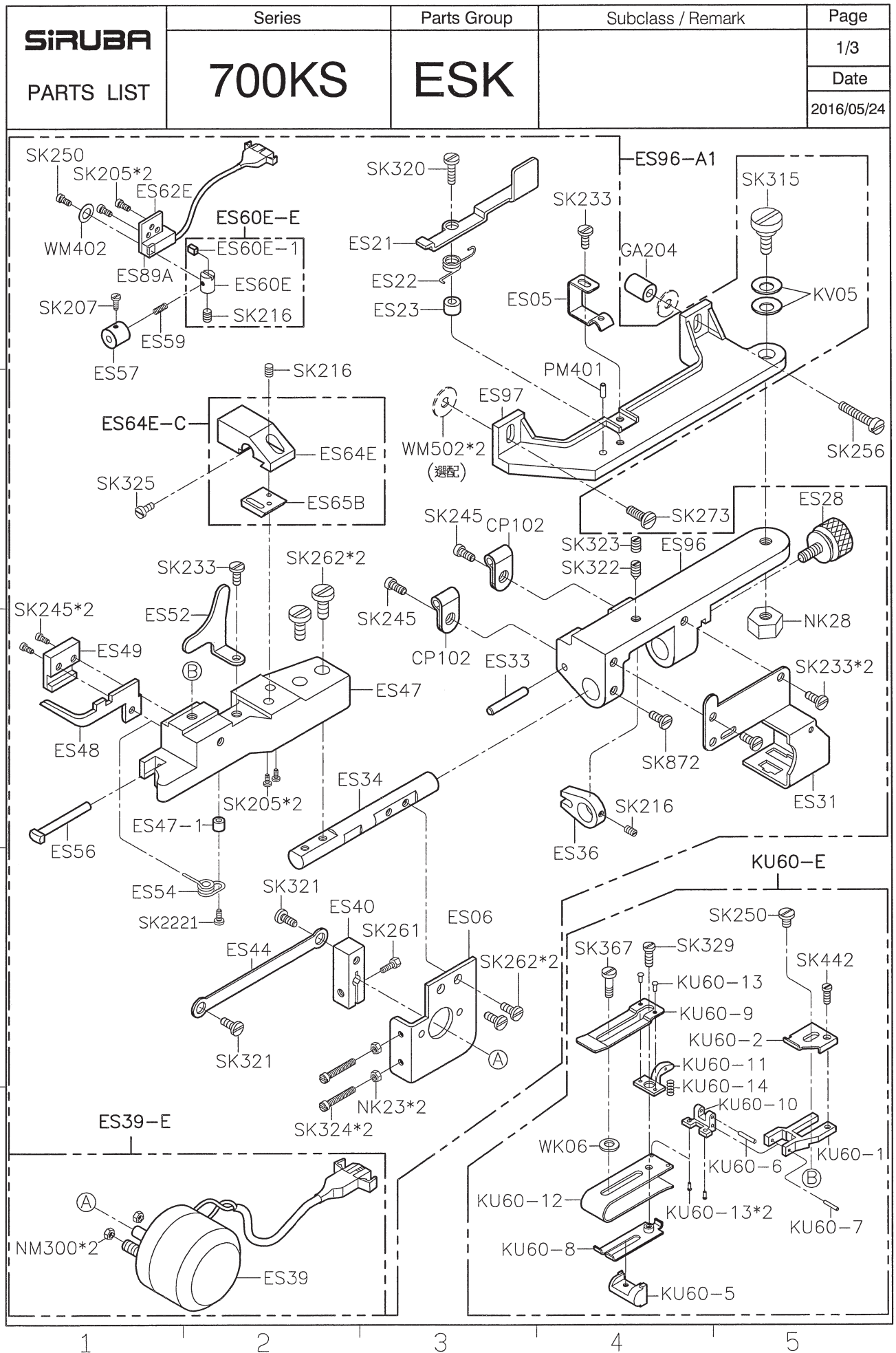
報廢流程

1. 當機器需要被淘汰與報廢時，有一些基本規則必須採納、遵守以保護環境及公眾健康。
2. 所有的機器零組件必須依照下列分類來區分開：
 - (1) 所有護套、可伸縮軟管及塑膠或非金屬零件。
 - (2) 電器零件：開關、照明器具等。
 - (3) 絕緣材料：石棉、彈性／可伸縮橡膠片。
 - (4) 金屬：含鐵金屬、銅、青銅與黃銅、其他各種金屬。
3. 以此方法，所有材質可以正確的淘汰，回收再利用或鎔解為可再使用或再處理而不至於危害環境。

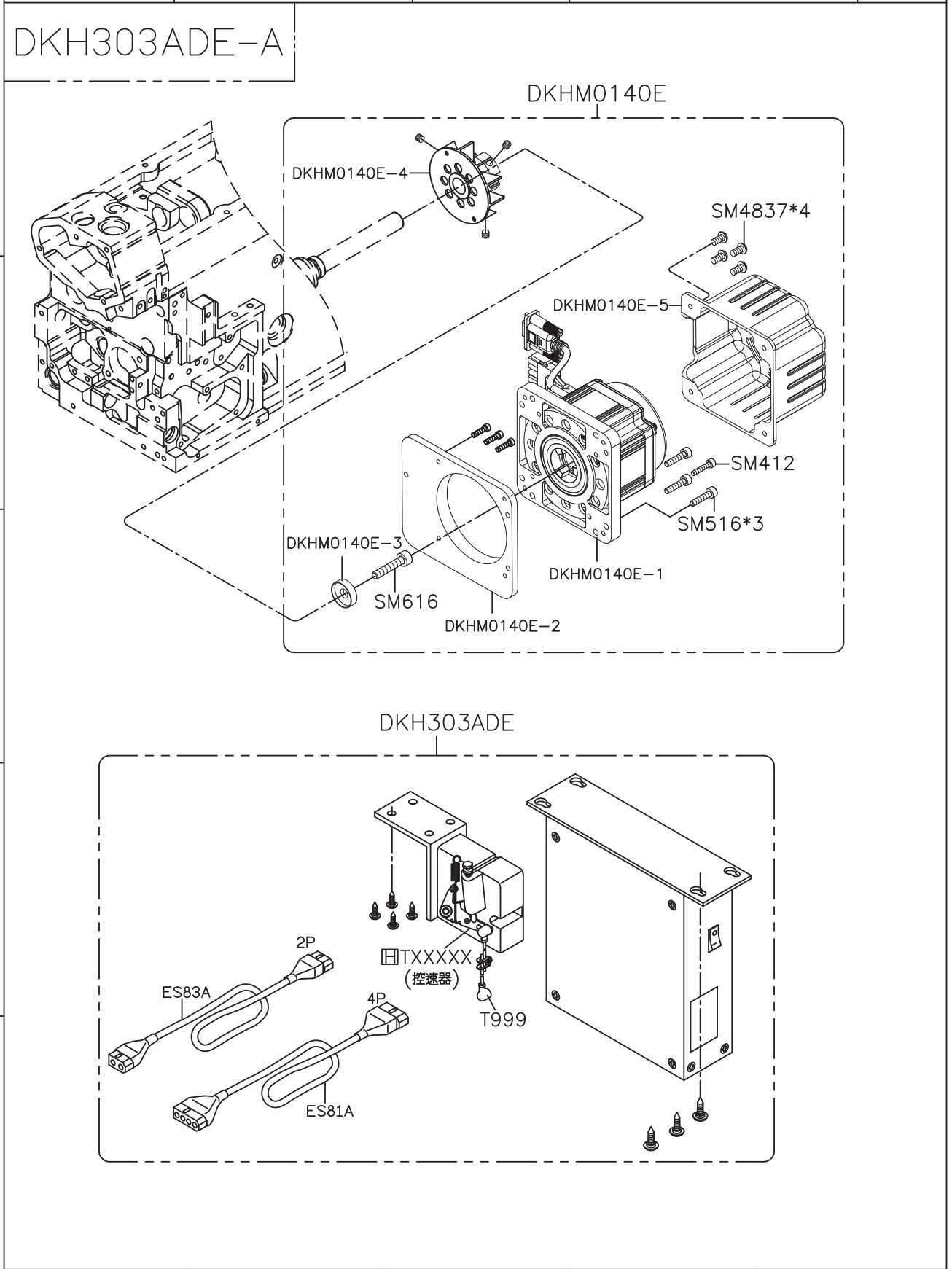
DEMOLITION PROCEDURE

1. When the machine needs to be eliminated and demolished, certain basic rules must be observed to protect the environment and public health.
2. All machine components must be divided according to categories as the followings:
 - (1) All sheathes, flexible hosing and plastic or non-metal components.
 - (2) Electricity components: switches, or lighting components.
 - (3) Insulation materials: rock wool, and flexible rubber strips.
 - (4) Metals: ferrous metals, copper, bronze and brass, various.
3. In this way, all materials can be eliminated correctly, recycled, or melted down for reuse or disposed of so that they do not harm the environment.

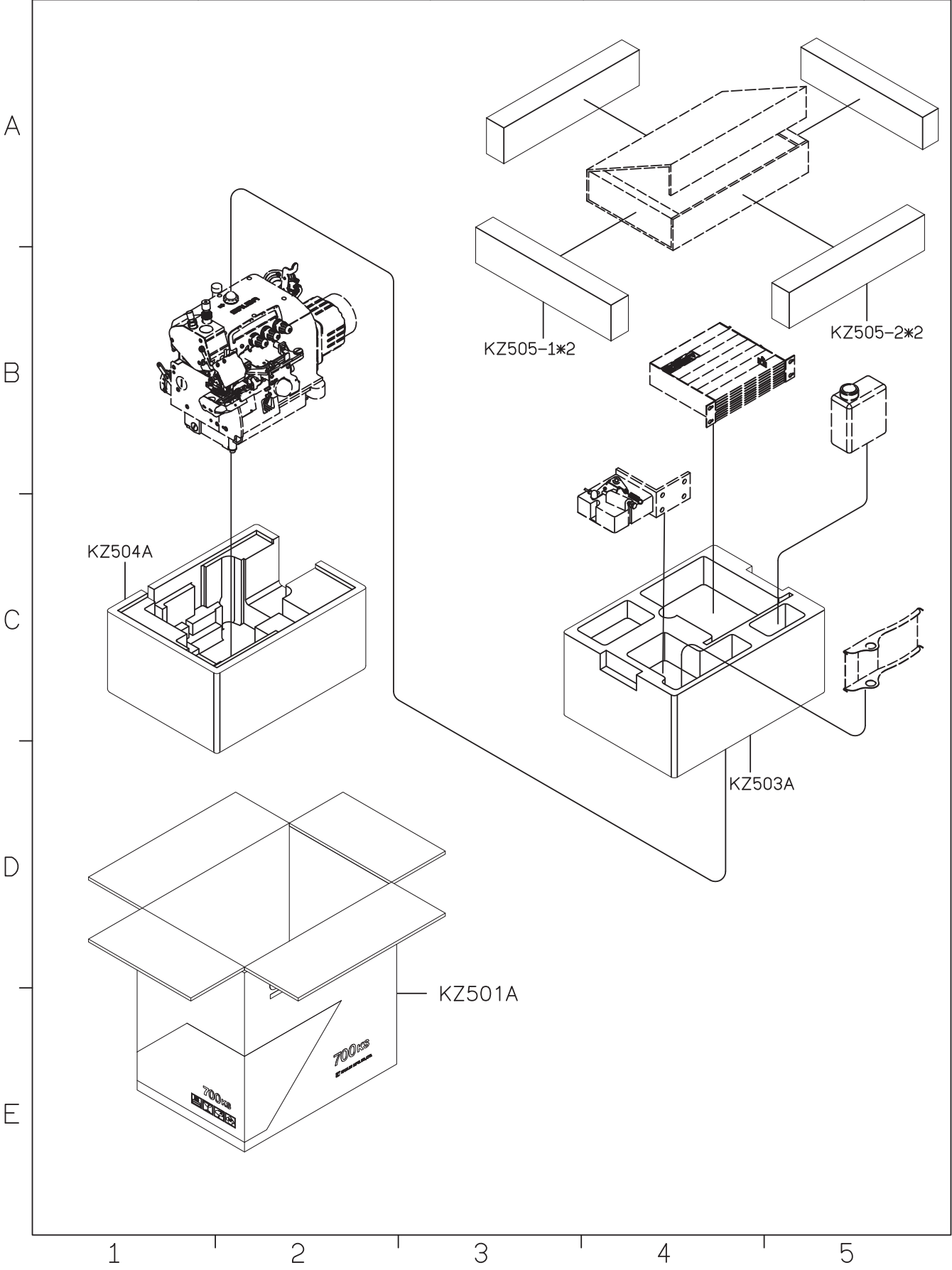
SIRUBA		Series		Remark		Page	Date						
GAGE PARTS LIST		700KS				1 / 1	2016/08/05						
													
機 型 Model	針板 Needle Plate	送具 Feed Dog	送具 Feed Dog	押具 Presser Foot	衝程 Crank	大心 Crank Shaft	針盤 Needle Clamp	勾針連桿座 Upper Looper Holder	上勾針 Upper Looper	下勾針 Lower Looper	針 Needle		
737KS	505F-2-04	E304	D517	D516	H516	P152D-3A	KJ516-E	KD501	KG231K-E	KJ508	LP526	KL502A	DCX27#11
	505F-2-04/ESK	E304	D517	D516	H516	P152D-3A	KJ516-E	KD501	KG231K-E	KJ508	LP526	KL502A	DCX27#11
	505F-2-04/ESK/VT	E304	D517	D516	H516	P152D-3A	KJ516-E	KD501	KG231K-E	KJ508	LP526	KL502A	DCX27#11
	504M-3-03	E503	D515	D516	H515	P987-3A	KJ516-E	KD501	KG231K-E	KJ508	LP526	KL502A	DCX27#11
	504M-3-04	E504	D515	D516	H515	P987-3A	KJ516-E	KD501	KG231K-E	KJ508	LP526	KL502A	DCX27#11
737KS	504M-3-04/LFD6-K	E324K	D515	D117K	H517	P212A-A1	KJ516-E	KD501	KG231K-E	KJ508	LP526	KL502A	DCX27#11
	504M-3-04/LFD6A-K	E324K	D515	D117K	H517	P212A-3A1	KJ516-E	KD501	KG231K-E	KJ508	LP526	KL502A	DCX27#11
	504M-3-05	E505	D515	D516	H515	P987-3A	KJ516-E	KD501	KG231K-E	KJ508	LP526	KL502A	DCX27#11
	504H-3-03	E513	D515	D117K	H517	P987-3A	KJ513-E	KD501B	KG231K-E	KJ528	LP519	KL502A	DCX27#11
	504H-3-04	E324K	D515	D117K	H517	P987-3A	KJ513-E	KD501B	KG231K-E	KJ528	LP519	KL502A	DCX27#11
747KS	504H-3-05	E515	D515	D117K	H517	P987-3A	KJ513-E	KD501B	KG231K-E	KJ528	LP519	KL502A	DCX27#11
	514M-3-23	E523	D515	D516	H515	P987-4A	KJ513-E	KD501	KG242K-E	KJ508	LP518	KL502	DCX27#11*2
	514M-3-24	E424	D515	D516	H515	P987-4A	KJ513-E	KD501	KG242K-E	KJ508	LP518	KL502	DCX27#11*2
	514M-3-24/LFD6-K	E434K	D515	D117K	H517	P212A-2A1	KJ513-E	KD501	KG242K-E	KJ508	LP518	KL502	DCX27#11*2
	514M-3-24/LFD6A-K	E434K	D515	D117K	H517	P212A-4A1	KJ513-E	KD501	KG242K-E	KJ508	LP518	KL502	DCX27#11*2
747KS	514M-3-25	E525	D515	D516	H515	P987-4A	KJ513-E	KD501	KG242K-E	KJ508	LP518	KL502	DCX27#11*2
	514H-3-23	E533	D515	D117K	H517	P987-4A	KJ513-E	KD501B	KG242K-E	KJ528	LP519	KL502A	DCX27#11*2
	514H-3-24	E434K	D515	D117K	H517	P987-4A	KJ513-E	KD501B	KG242K-E	KJ528	LP519	KL502A	DCX27#11*2
	514H-3-25	E535	D515	D117K	H517	P987-4A	KJ513-E	KD501B	KG242K-E	KJ528	LP519	KL502A	DCX27#11*2

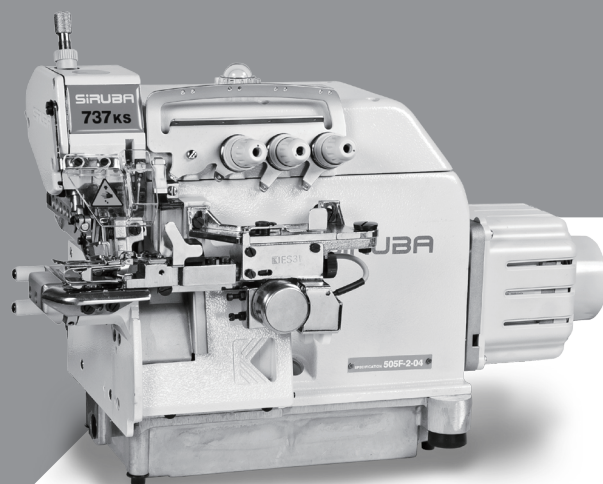


SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700KS	ESK		2/3
				Date
				2016/03/24



SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700KS	ESK		3/3
				Date
				2016/03/24





 **高林股份有限公司**
KAULIN MFG. CO., LTD.

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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.
KZ508S-1.JUL.2016