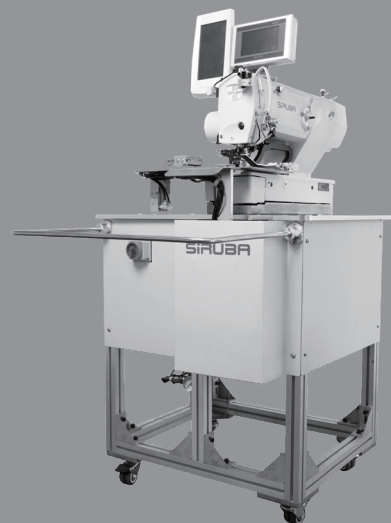


# SIRUBA

使用說明書與零件圖

INSTRUCTIONS BOOK & PARTS LIST

■ ASP-CBH100



## 啟動準備

開機點擊縫紉機復位後等待裝置復位，完成後如無需調節參數即可開始工作。

### 調節鎖眼數，角度與鎖眼距離

操作屏工作介面設置鎖眼孔數以及鎖眼間距，鎖眼距離設置：圖示 2 號鎖眼與 3 號鎖眼距離

### 斷線操作

斷線重啟：斷線後穿好線，點擊縫紉機觸控式螢幕返回鍵後再點擊倒退回到斷線位置再次按下腳踏板啟動。

斷線取消縫製：斷線後點擊縫紉機觸控式螢幕返回鍵後再點擊右上角取消按鈕，然後點擊裝置觸控式螢幕解除鍵，後續如需繼續車縫需重新點擊自動模式復位裝置。

### 基本設置

旋轉角度設置：調節如圖示調節 1 號鎖眼與 2 號鎖眼角度

門襟位置偏移：設置 1 號鎖眼左右位置偏移

豎孔距離偏移：圖示 2 號鎖眼與 1 號鎖眼距離偏移（因 1 號鎖眼設置左右偏移後旋轉中心點改變使得 2 號鎖眼與 1 號鎖眼距離產生變化，所以需設置偏移量）

設置完成後點擊原點復位後退出即可開始工作。

### 資料存儲

保存：設置好參數後打開使用者存儲介面，選擇對應的款號後點擊保存

讀取：打開使用者存儲介面，選擇所需對應款號點擊讀取款號名稱可點擊修改

## Startup Preparations

- Upon powering on, click the reset button on the sewing machine and the reset button on the automatic buttonhole device. Wait for the device to complete its reset, and you can begin working if parameter adjustments are not required.

## Adjusting the Number of Buttonholes and Distance

- On the operation screen interface, set the number of buttonholes and the distance between them. The buttonhole distance is configured between buttonholes number 2 and number 3 in the diagram.

## Broken Thread Operation

- **Resetting for a Broken Thread:** After repairing the broken thread, click the back button on the sewing machine's touchscreen, then press the pedal to return to the broken thread position and press the pedal again to restart.
- **Canceling the Stitch for a Broken Thread:** After repairing the broken thread, click the back button on the sewing machine's touchscreen, then click the cancel button in the top-right corner, and then click the unlock button on the device's touchscreen. If you need to resume sewing afterward, click the automatic mode button to restart the device.

## Basic Settings

- **Adjusting the Rotation Angle:** Set the angle between buttonholes number 1 and number 2 in the diagram.
- **Buttonhole Position Offset:** Adjust the left or right offset of buttonhole number 1.
- **Vertical Hole Distance Offset:** Configure the offset distance between buttonholes number 2 and number 1. (Since adjusting the offset for buttonhole number 1 changes the pivot point, which affects the distance between buttonholes number 2 and number 1, you must set the offset value accordingly.)

## Data Storage

- **Save:** After configuring the parameters, open the user storage interface, select the corresponding model number, and click save.
- **Load:** Open the user storage interface, select the desired model number, and click read. You can modify the model number name by clicking on it.

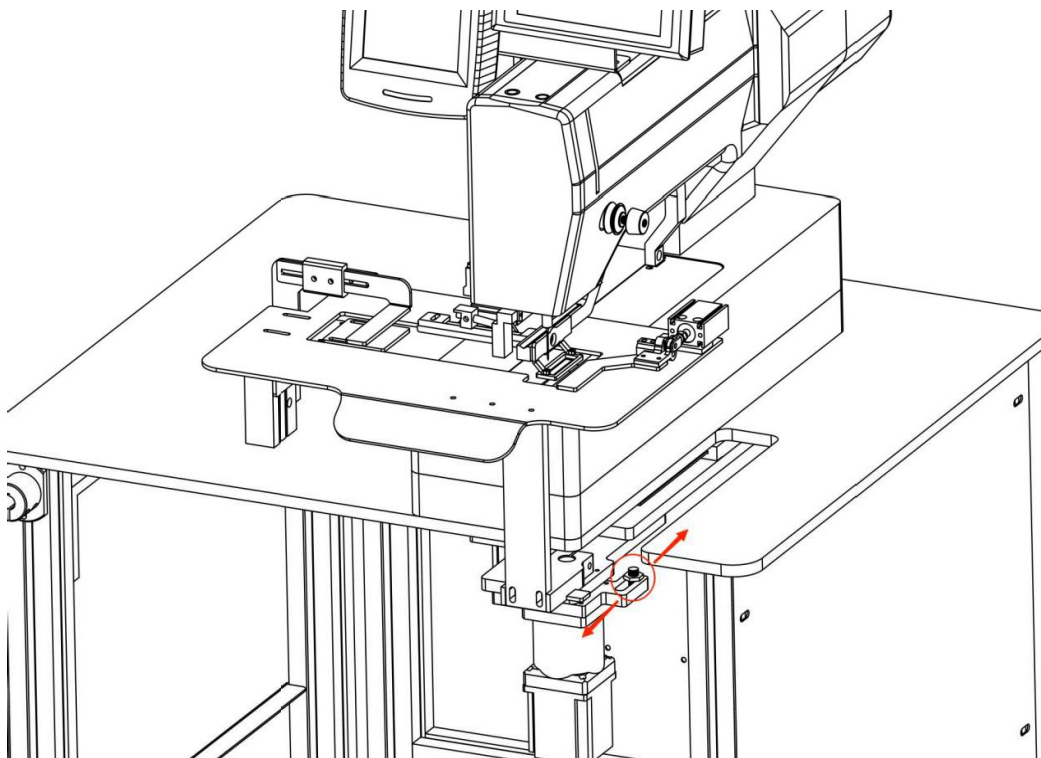


## 角度調節

開機復位後角度與預設角度存在偏差時可微調圖示感測器前後位置。

### Angle Adjustment

- After restarting, if the angle deviates from the preset angle, you can slightly adjust the sensor's position forward or backward as shown in the diagram.



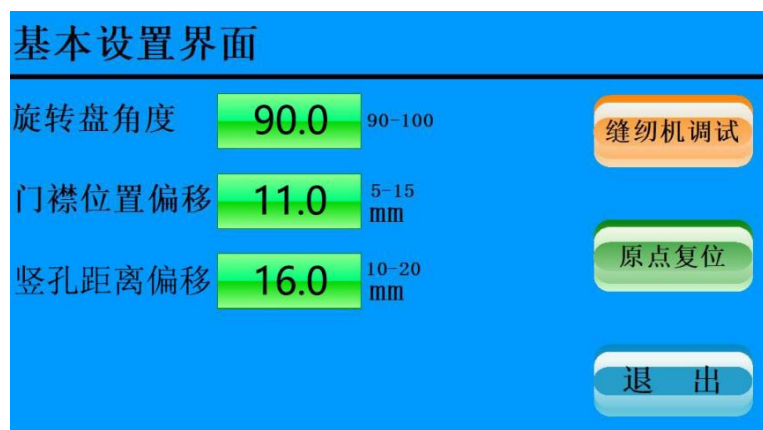
## 電控參數設置 Electric Control Parameter Settings

工作介面 Work Interface	預設值 default value	參考範圍 Reference Range	注釋 Comment
底線計數 Bottom Thread Count			左邊為底線計數設置的報警值，右邊為完成數量 The alarm value set for the bottom thread count is displayed on the left, while the completed quantity is shown on the right
鎖眼孔數 Number of Buttonholes	3	2-4	自動鎖眼的個數 Automatic Buttonhole Count
鎖眼距離 Buttonhole Distance	50		距離總長不超過當前裝置壓腳範圍 The total length of the buttonhole distance should not exceed the range of the current presser foot.
繞線 Bobbin Winding			需先點擊縫紉機操作屏繞線模式然後點擊繞線 鍵縫紉機啟動（繞線時針不可穿線）再次點擊結束繞線。 First, click on the bobbin winding mode on the sewing machine's operation screen. Then, click the winding button to start the sewing machine (ensure the needle is not threaded during the winding process). Afterward, click the button again to finish the winding.

更換底線 Bottom Thread Replacement			點擊後裝置旋轉至合適位置便於更換底線 Click to rotate the device to an appropriate position for replacing the bottom thread.
自動模式 Automatic Mode			點擊後裝置復位即可開始車縫 Click to reset the device and begin sewing.
復位/解除 Reset/Unlock			點擊後解除自動模式 Click to deactivate the automatic mode.



基本設置 Basic Settings	預設值 default value	參考範圍 Reference Range	注釋 Comment
旋轉盤角度 Rotary Disk Angle	90	90-100	第一個鎖眼角度 Angle of the First Buttonhole
門襟位置偏移 Buttonhole Position Offse	11	5-15	第一個鎖眼位置左右偏移 Left or Right Offset of the First Buttonhole
豎孔距離偏移 Vertical Hole Distance Offset	15	10-20	因改變第一孔鎖眼偏移量後旋轉位置改變，第二孔位置會發生變化，所以需設置偏移量 Due to the change in the rotation position after modifying the offset of the first buttonhole, the position of the second buttonhole will shift. Therefore, it is necessary to set the offset for the second buttonhole to maintain accurate spacing and alignment.
原點復位Reset to Origin			如更改角度、位置偏移、鎖眼長度需點擊復位 If the angle, position offset, or buttonhole length is changed, click reset to restore the settings to their default values.
縫紉機調試 Sewing Machine Adjustment			點擊後進入調試介面，按下腳踏板縫紉機啟動 Click to enter the adjustment interface. Press the pedal to start the sewing machine.



啟動設置 Launch Settings	預設值 default value	參考範圍 Reference Range	注釋 Comment
延時壓腳踏板 Delayed Foot Pedal	2	1-3	延時啟動踏板設置（一般情況無需修改） Delayed Start Pedal Setting (Generally no need to modify)
壓腳踏板復位 Foot Pedal Reset	3	3-5	延時復位踏板設置（一般情況無需修改） Delayed Reset Pedal Setting (Generally no need to modify)
車縫延時啟動 Sewing Delay Start	1	1-3	車縫延時啟動設置（一般情況無需修改） Sewing Delay Start Setting (Generally no need to modify)
啟動踏板復位 Pedal Reset Start	4	3-5	啟動踏板復位時間設置（一般情況無需修改） Pedal Reset Time Setting (Generally no need to modify)
延時啟動旋轉 Delayed Start Rotation	2	2-5	延時啟動旋轉設置 Delayed Start Rotation Setting
延時旋轉偏移 Delayed Rotation Offset	2	2-5	旋轉完成後延時啟動偏移 Delayed Start Rotation Offset After Completion
延時夾料復位 Delayed Material Clamping Reset	2	2-5	車縫完成夾料延時復位 Sewing Completion Material Clamping Delayed Reset
延時旋轉復位 Delayed Rotation Reset	2	2-5	車縫完成延時旋轉復位 Sewing Completion Delayed Rotation Reset

## 启动参数设置

退 出

延时压脚踏板	2	ms (1-3)	延时旋转偏移	2	ms (3-5)
压脚踏板复位	3	ms (3-5)	延时夹具复位	2	ms (3-5)
车缝延时启动	1	ms (1-3)	延时旋转复位	2	ms (3-5)
启动踏板复位	4	ms (3-5)			
延时启动旋转	2	ms (3-5)			

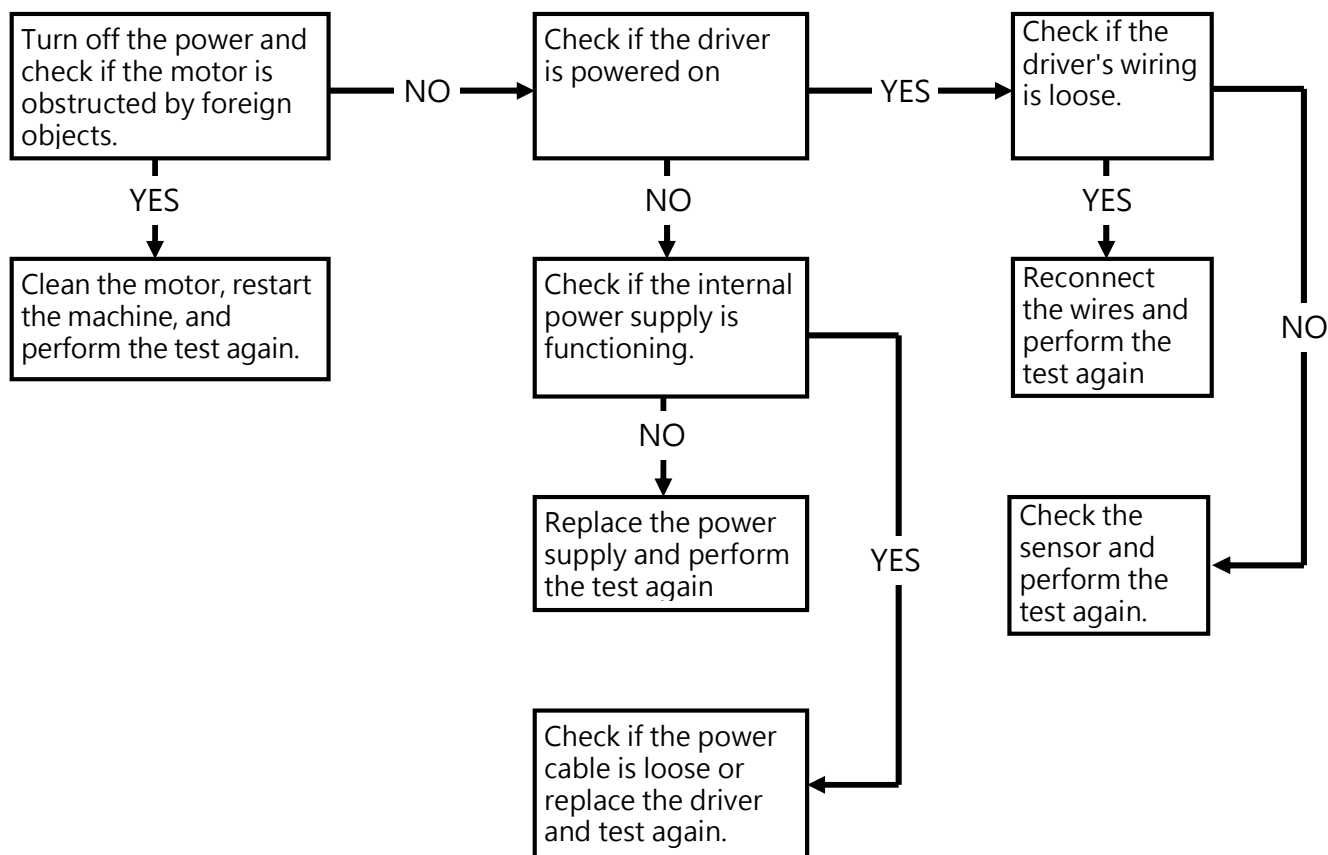
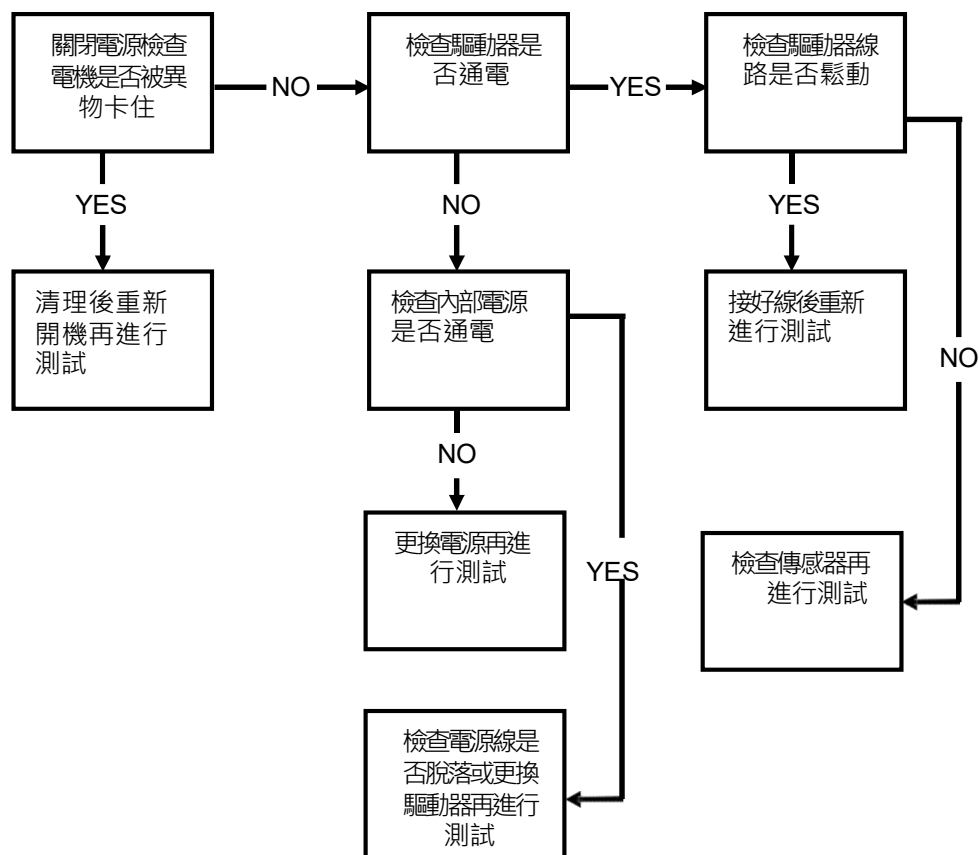
旋轉電機 Rotating Motor	預設值 default value	參考範圍 Reference Range	注釋 Comment
每圈脈衝 Pulse per Rotation	3200	3200	驅動器脈衝設置（需與驅動器撥片設置一致） Driver Pulse Setting (Must be consistent with the driver dip switch settings)
旋轉角度 Rotation Angle	90	90-100	第一鎖眼角度設置 First Buttonhole Angle Setting
旋轉速度 Rotation Speed	140	120-150	電機旋轉速度 Motor Rotation Speed
加減速 Acceleration/Decel eration	30	20-30	電機加減速 Motor Acceleration/Deceleration
原點速度 Origin Speed	80	50-100	電機返回原點速度 Motor Return to Origin Speed
原點加減速 Origin Acceleration/Decel eration	10	10-20	電機加減速 Motor Acceleration/Deceleration

送料電機 Feeding Motor	預設值 default value	參考範圍 Reference Range	注釋 Comment
每圈脈衝 Pulse per Rotation	3200	3200	驅動器脈衝設置（需與驅動器撥片設置一致） Driver Pulse Setting (Must be consistent with the driver dip switch settings)
每圈長度 Length per Rotation	62	62	同步輪尺寸（無需修改） Synchronization Wheel Size (No need to modify)
扣眼距離 Buttonhole Distance	50		距離總長不超過當前裝置壓腳範圍 Total Distance Should Not Exceed the Current Presser Foot Range
移動速度 Movement Speed	180	150-200	電機移動速度 Motor Movement Speed
加減速 Acceleration/Deceleration	30	20-30	電機加減速 Motor Acceleration/Deceleration
原點位置 Origin Position	70	70	車縫位置（無需修改） Sewing Position (No need to modify)
原點速度 Origin Speed	70	50-100	電機返回原點速度 Motor Return to Origin Speed
原點加減速 Origin Acceleration/Deceleration	30	20-30	電機加減速 Motor Acceleration/Deceleration
次原點位置 Secondary Origin Position	40	40	放料位置（無需修改） Unloading Position (No need to modify)

送料电机设置		退出	
每圈脉冲	3200 PCS	原点位置	70.0 mm
每圈长度	62.0 mm	原点速度	70 HZ
扣眼间距	50.0 mm	原点加减速	30 ms
移动速度	180 HZ	次原点位置	40.0 mm
加减速	30 ms	原点复位	

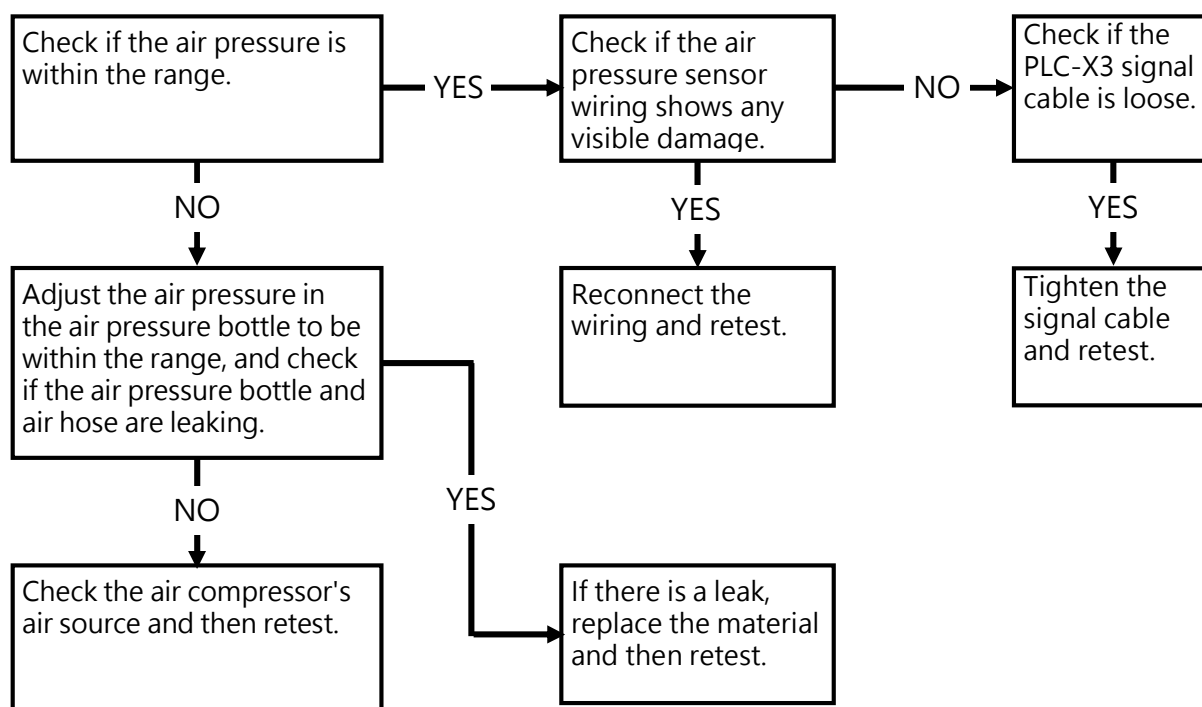
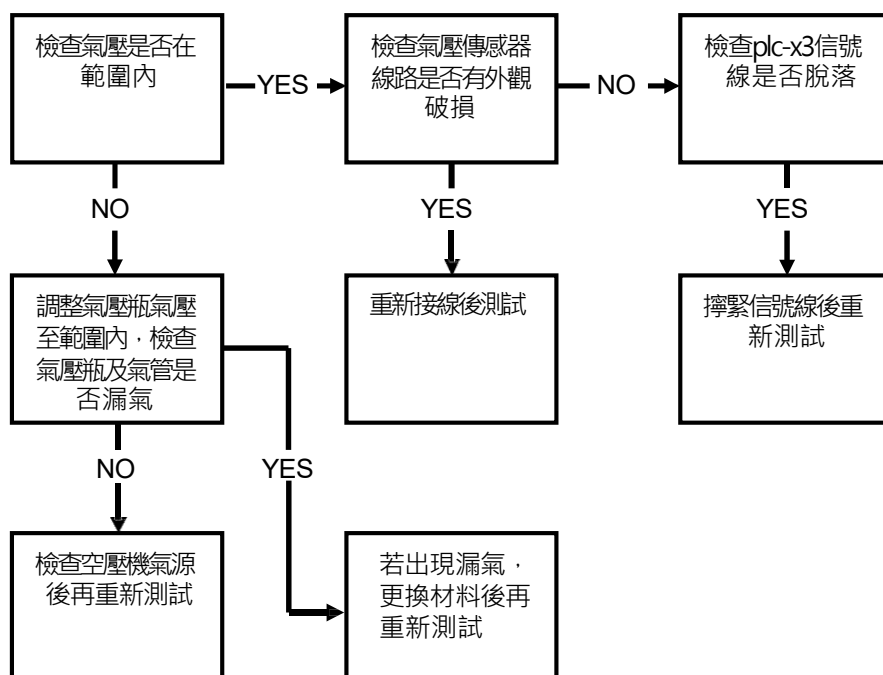
## 故障排除 Troubleshooting

出現故障提示：電機堵轉 Error Message: Motor Lock

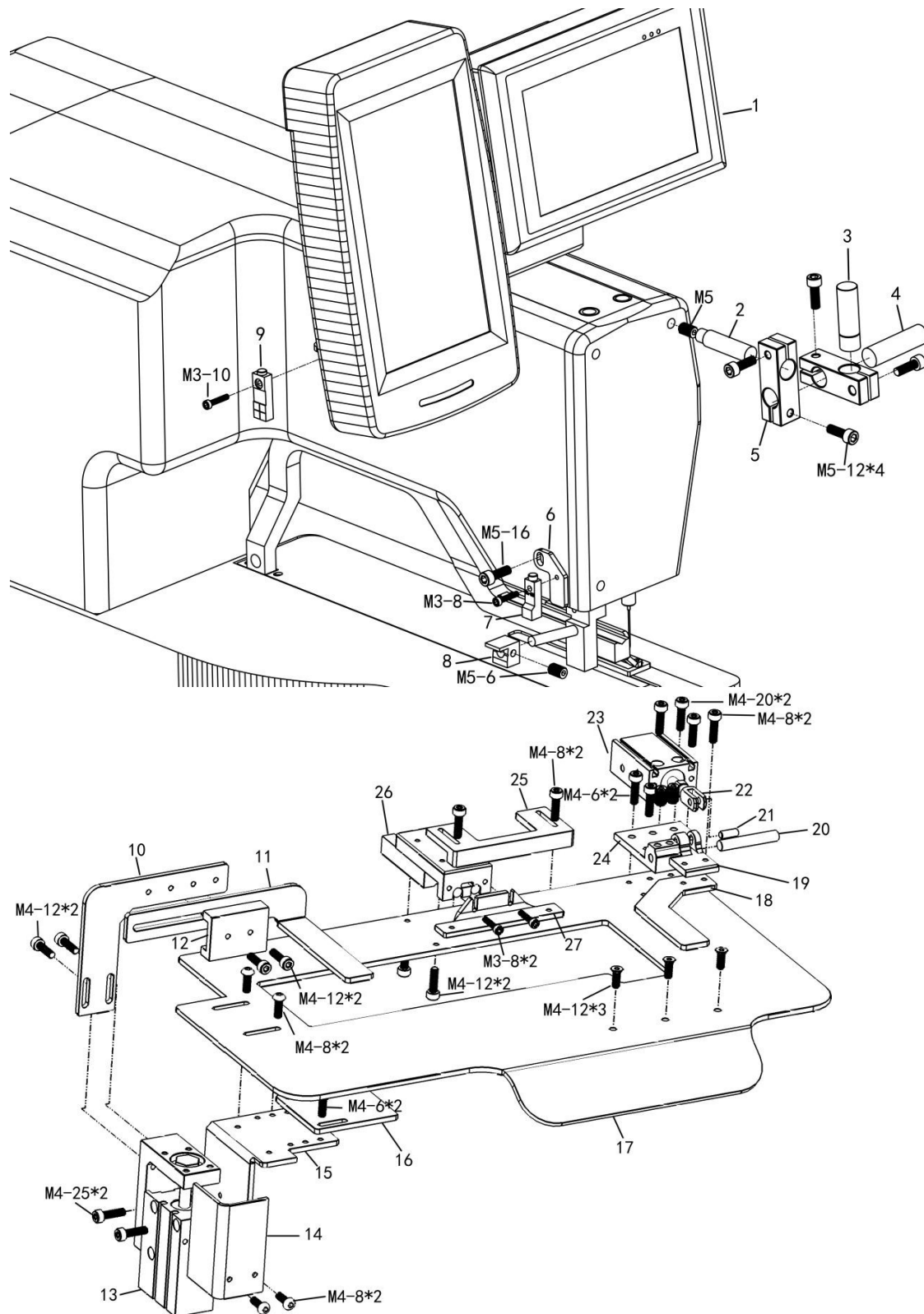


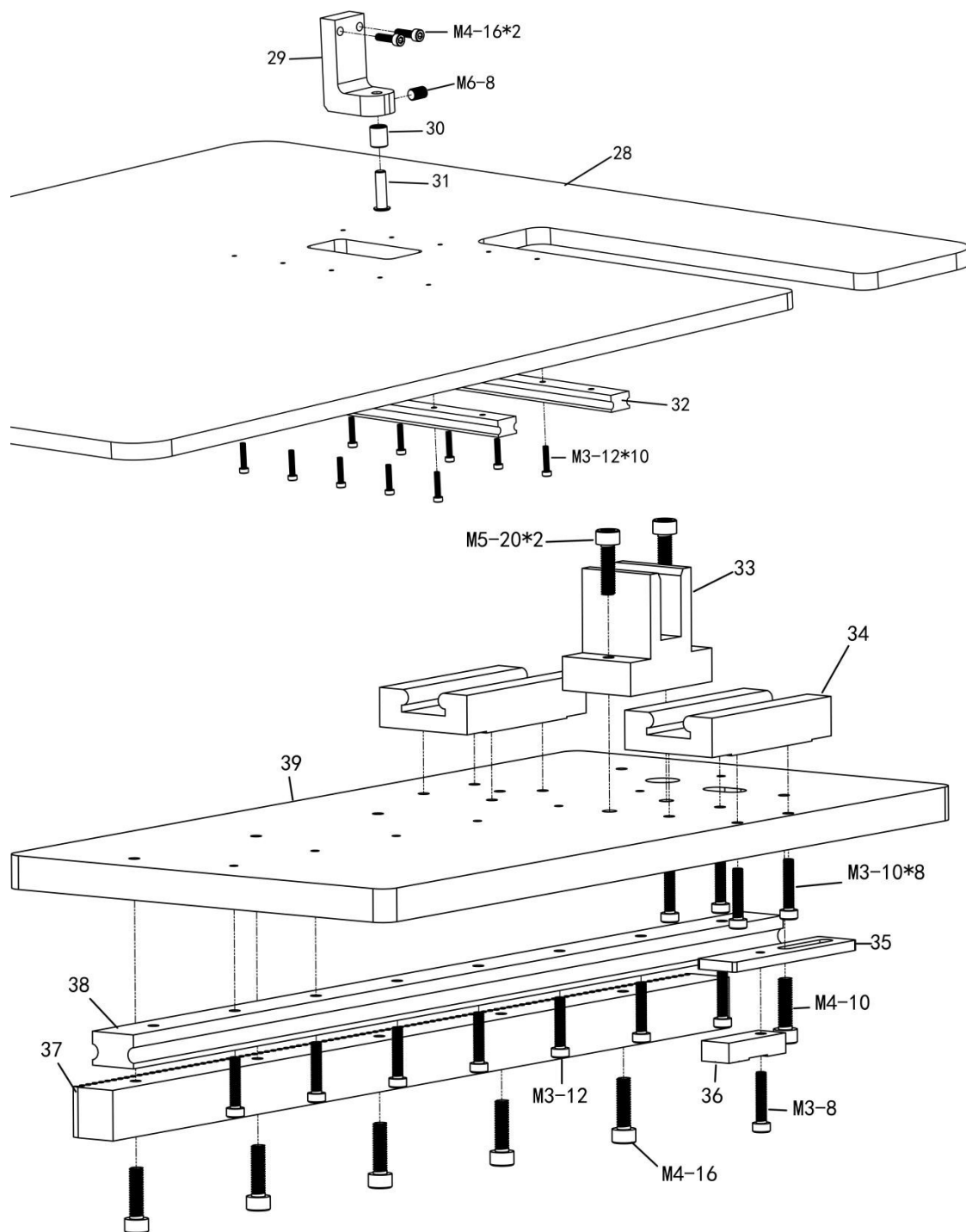


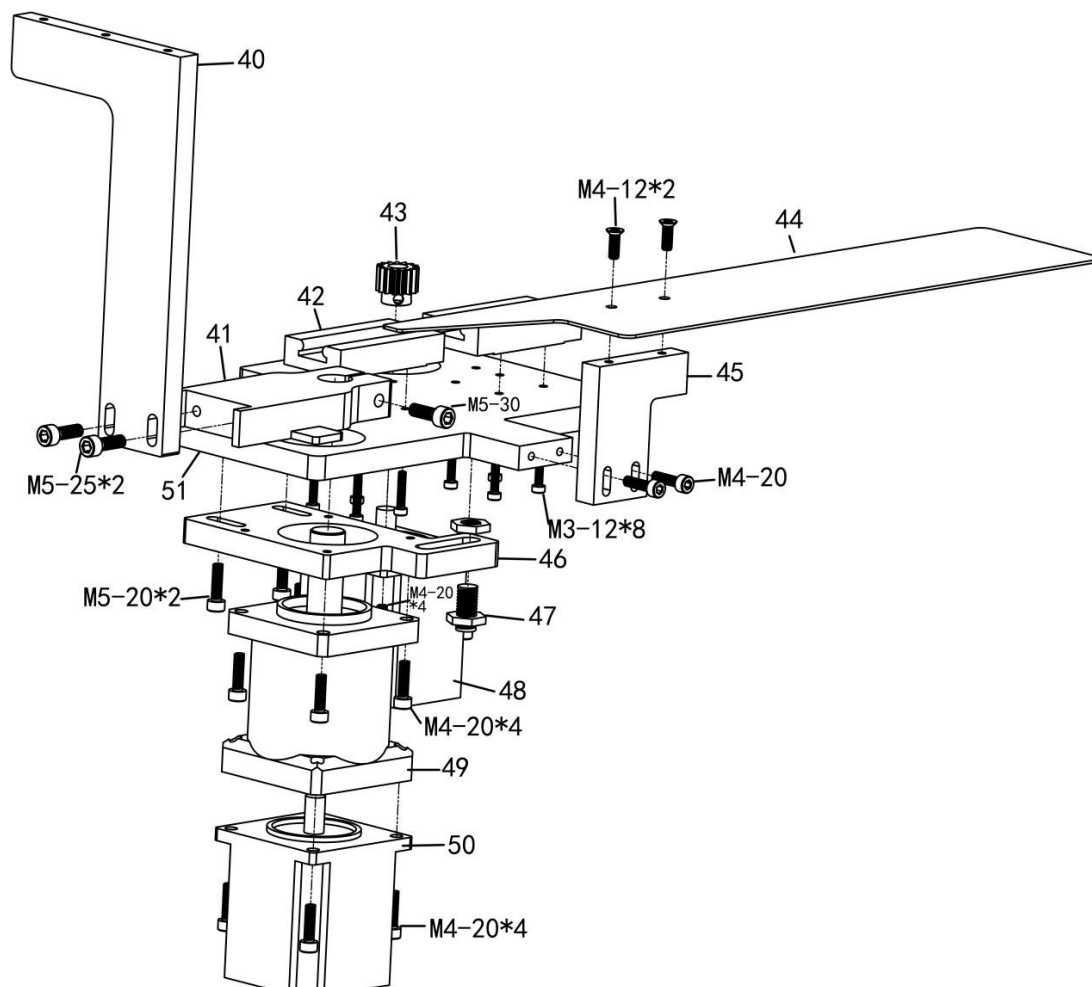
出現故障提示：檢出氣壓異常 Error Message: Abnormal Air Pressure Detected



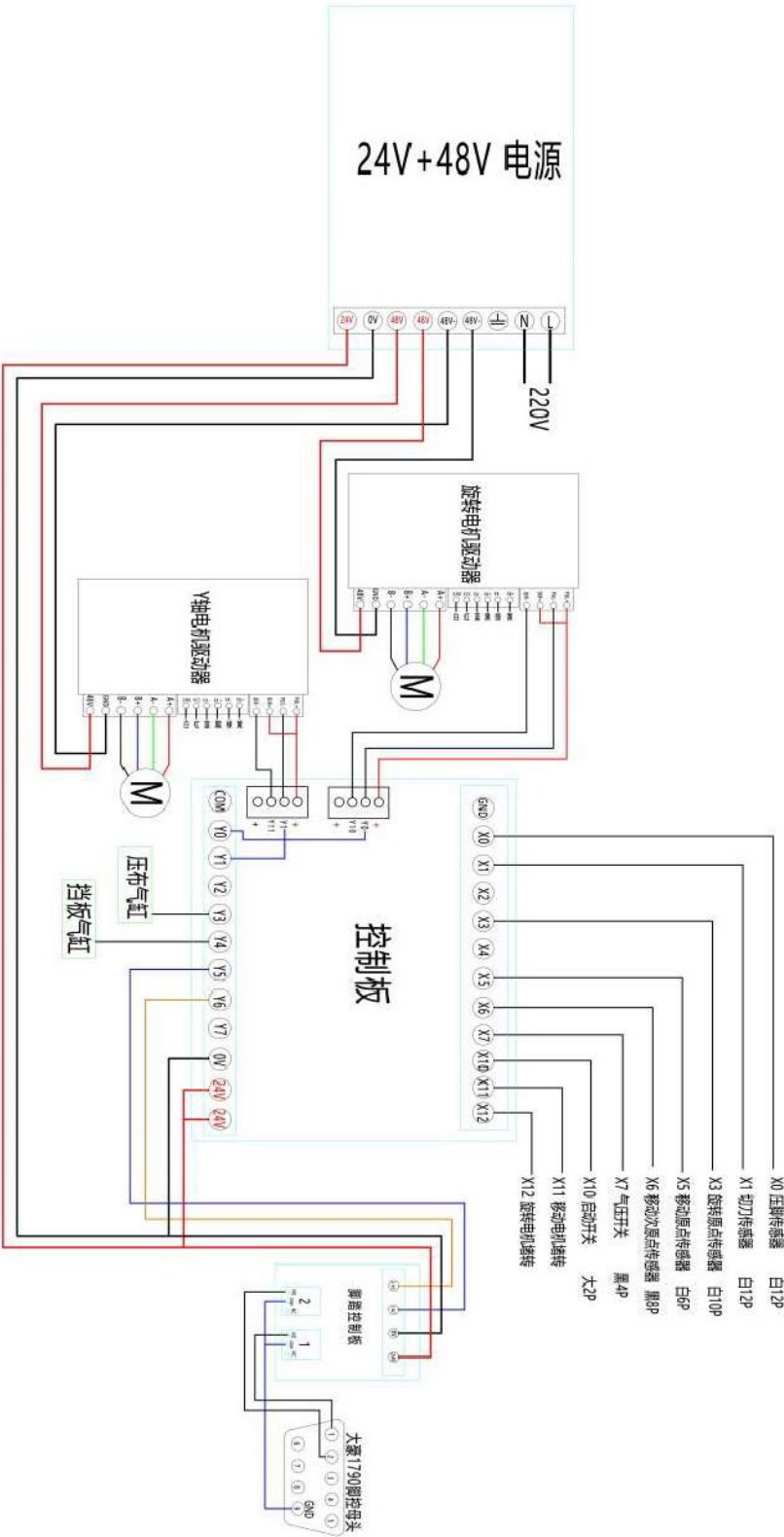
# 零件圖 Part List



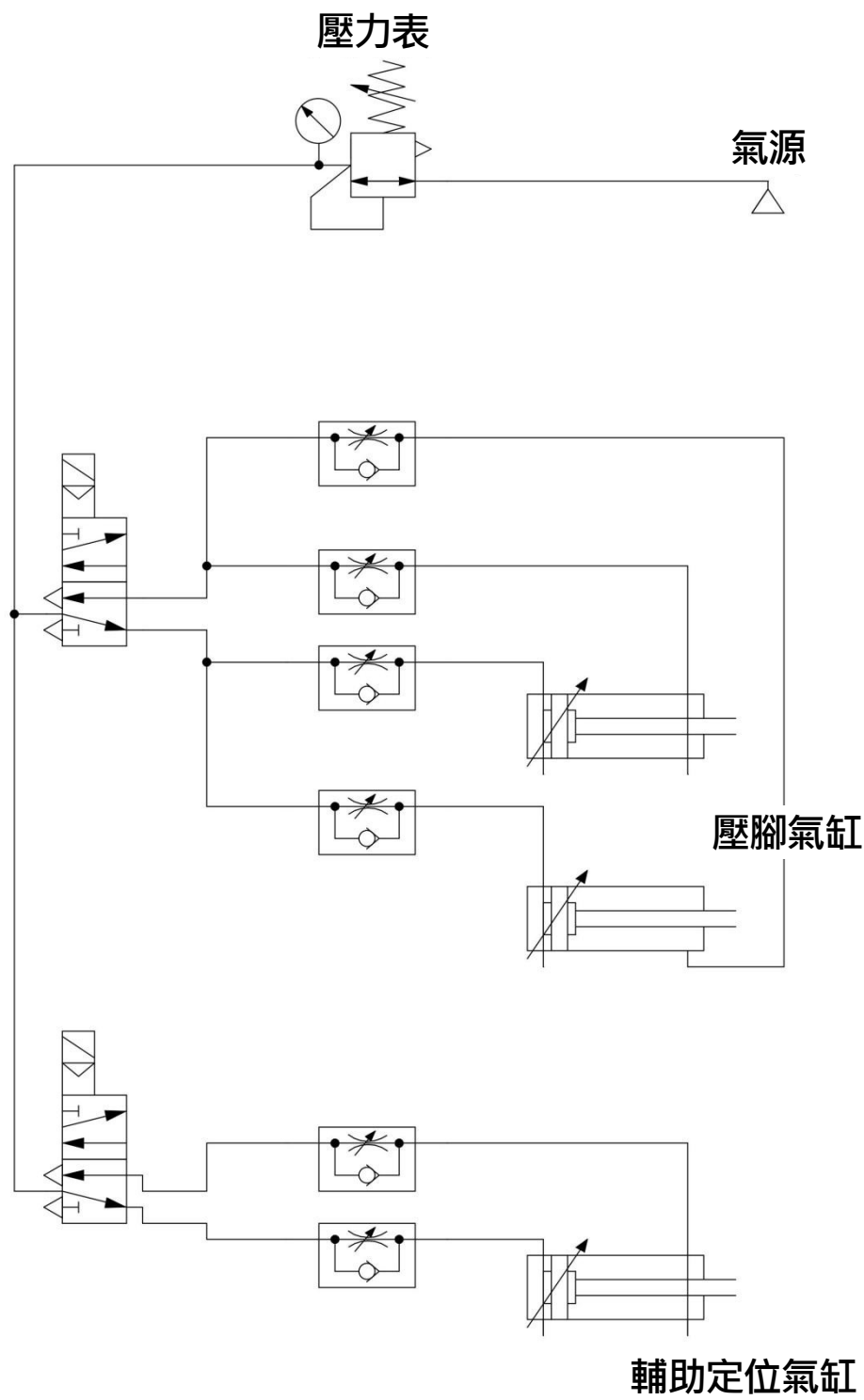




電路圖 Circuit Diagram



氣壓流程圖 Air Pressure Flow Diagram





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