

SIRUBA

使用説明書

INSTRUCTION BOOK

■VC008N



CE

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使用前安全注意事項

1. 為了使用的安全

為了工業用縫紉機以及裝置使用上的安全，請注意下列事項。

1-1 用途與目的

此工業用縫紉機是為了提昇縫製作業的生產性為目的而設計，請勿使用在其它的用途與目的。而所安裝的驅動裝置的安全措施，未獲得確認確實執行之前，請勿使用此針車。

1-2 在使用之前

在使用針車之前，應熟讀各相關使用說明書，按照使用說明書來正確使用，並且也應熟讀裝配的驅動裝置的使用說明書。

1-3 使用環境

在下列的環境之下請勿使用：

- 對於針車的性能會有不良影響的環境溫度與濕度的不良場所。
- 屋外或受到日光直射的場所。
- 在粉塵與腐蝕性氣體與可燃性氣體等的環境中。
- 電壓變動而不穩定，或是在超過規格電壓的 $\pm 10\%$ 的場所。
- 在不能達到使用的馬達的規格之必要電源容量的場所。
- 在會受到輸出功率較大的高周波發信機或是高周波熔接機的周邊等，發生強力電波及磁場的場所。

1-4 開箱與搬運

- (1) 由上開始按照順序開箱。
- (2) 把針車機頭從襯墊材料搬出的時候，絕對不要拉抬車針附近或過線相關零件。
- (3) 搬運針車頭部的時候，應和助手兩人共同作業。
- (4) 搬運車台移動的時候，注意不要有過度的撞擊或震動。

SAFETY INSTRUCTIONS

1. For your safety

To ensure your safety while using industrial sewing machine and devices, please follow the safety instructions below.

1-1 Usage and purpose

The sewing machine is designed to improve productive efficiency of sewing work. Do not use for other usage and purpose. Do not use the sewing machine before the installed drive device's safety measures have been confirmed being conducted.

1-2 Before use

Before using the machine, you should read the instruction manuals thoroughly and follow it. Hence, read the installed drive device instruction thoroughly, too.

1-3 Working environment

Do not work in the following environment:

- The environment which its temperature and humidity will cause bad influence to the machine.
- Outdoors or the place which the machine may exposed to sunlight directly.
- Environment contains dust, corrosive gases or flammable gases, etc.
- Place which voltage fluctuation causes unstable, or voltage exceeds $\pm 10\%$ of specification.
- Place where power capacity necessary for the used motor specifications cannot be secured.
- Place where strong electric or magnetic field are generated such as surrounding at large-output high frequency transmitters or high frequency welding machines.

1-4 Unpacking and transportation

- (1) Unpacking boxes from top and follows the sequences.
- (2) Never pull or lift the parts near the needle or threading parts while removing machine head from the washer.
- (3) Find an assistant when carrying machine head.
- (4) Be careful do not have overly impact or shock while moving the machine.

2. 安裝與準備

2-1 教育與訓練

裝置針車的操作人員，以及從事指導保全維修的幹部，必須要有正確知識和操作的技能。管理階層應在事前對於作業人員以及幹部的教育與訓練計畫，做好完整的籌劃以及執行。

2-2 教育與訓練

- (1) 採用能夠承受針車的自重，以及運轉時的反彈應力強度的檯板與腳架。
- (2) 應充分考量配置針車及作業區域的照明，以供能夠順利的從事作業的環境。
- (3) 配置裝置的針車在配裝控制箱以及相關件的時候，要注意到與作業人員作業姿勢的關係。
- (4) 安裝馬達時，應依照馬達廠商所提供的使用說明書正確安裝。

2-3 電路配線

- (1) 在裝設電路完成之前，請勿接上電源接頭。
- (2) 連接針車頭部和馬達以及電器裝置的電線接頭，務必確實固定。
- (3) 對於連接的電線電纜，勿施加超負荷的壓力。
- (4) 在會有動作的機械部份之附近，對於電線電纜的配置，應考安全距離，不可使其接觸或磨擦。
- (5) 在針車的頭部指定部位確實接妥接地線。

2-4 在針車運轉之前的注意事項

- (1) 在注入潤滑油、矽油、黃油的時候，注意不要接觸到眼睛皮膚等。在保管方面，要避開幼童所能取到的位置。
- (2) 針車務必先行注油之後才運轉。
- (3) 要切入電源的時候，勿把手伸入車針下方附近及有動作的機械部位。

2. Installation and preparation

2-1 Instruction and training

Operators who assemble the sewing machine and instructors who responsible for repair and maintenance, need to have correct knowledge and operation skills. The managers should prepare and execute the instructions and training plan for the operators and supervisors beforehand.

2-2 Sewing table and motor

- (1) Apply the table and foot stool which can withstand machine's weight and intensity of rebound stress while operating.
- (2) Should consider sewing machine working area's lighting to provide the environment which operators could work smoothly.
- (3) When installing the control box and the related parts of the sewing machine, pay attention the posture about the workers.
- (4) Please follow the instruction from motor manufacturer to install the motor.

2-3 Wiring

- (1) Before circuit assembly finished, do not connect the plug for power supply.
- (2) Must fix the wire of sewing machine head, motor, and electric device securely.
- (3) For connected electric cable, do not put excessive force on it.
- (4) For electric cord equipment, should keep the safe distance away from moveable mechanic parts to avoid connect or friction.
- (5) Connect the ground wire on assigned position of sewing machine head securely.

2-4 Instructions before operation

- (1) When pour into lubricant, silicone oil, and grease, be careful do not attach on your eyes and skin. And keep these where children cannot reach.
- (2) Before operation, the sewing machine must be lubricated.
- (3) Do not put your hand under the needle or near the moving parts of the machine when turn the power on.

- (4) 起初開始運轉針車的時候，需要確認針車飛輪的旋轉方向，和飛輪的迴轉標示是否一致。

2-5 針車運轉中的注意事項

- (1) 務必在裝妥馬達蓋、護指、護目等的安全保護狀態下運轉針車。
- (2) 針車運轉中，在車針下方附近以及有動作的機械部位附近，勿使手、頭髮接近，更不可把物品放置在旁。
- (3) 附有切刀裝置的針車，在針車運轉中絕不可把手指伸入切刀部位。
- (4) 在不使用針車或作業人員離開針車時，務必關閉電源。
- (5) 在使用中發現錯誤動作、異常的聲音或異味的時候，應即刻關閉電源。

2-6 拆卸

- (1) 拆卸任何零件或更換的時候，以及進行調整作業的時候，務必先關閉電源。
- (2) 要拔掉插頭的時候，不可直接拉扯電線、電纜。
- (3) 控制箱內配有高壓負荷，所以在關閉電源之後要等待 5 分鐘以上才可以開蓋。

2-7 保全、檢查與維修

- (1) 保全、檢查修理作業的時候，應依照使用說明書來作業。
- (2) 執行保全、檢查及維修的作業，應由經過特別訓練的人員來操作。
- (3) 在執行保全、檢查及維修的作業時，務必先關閉電源，在確認針車與馬達完全停止的時候才開始作業。
- (4) 請客戶勿根據獨自判斷來自行改造針車。
- (5) 避免用指定以外的保全維修零件。

- (4) When start to operate the sewing machine at first, make sure the rotating direction of pulley tallies with rotating-direction mark.

2-5 Instructions while operating

- (1) Be sure to operate the sewing machine with the safeguards such as motor cover, finger guard, and eyes guard, etc.
- (2) During operation, do not let your hands or hair near the machine; moreover, put an object beside under the needle or near the moving parts of machine.
- (3) Never puts your hand close to the knives part during operation which sewing machine has trimming device.
- (4) Must turn off the power without operators or using the sewing machine.
- (5) If the machine malfunctions, make abnormal sound or smelling unusual, turn off power immediately.

2-6 Removal

- (1) Must turn off power first if disassembling or removing any parts, or doing adjustment.
- (2) To pull the plug, do not pull or drag its cable or wire.
- (3) A high voltage is applied inside the control box, do not open the cover until wait for five minutes.

2-7 Maintenance, inspection, and repair

- (1) Follow the instruction manual to do maintenance, inspection, and repair.
- (2) Entrust the specially trained workers to do maintenance, inspection, and repair.
- (3) Must turn off the power first and make sure the motor and sewing machine are completely stop, then do the maintenance, inspection, and repair work.
- (4) Do not transform the sewing machine by customer's judgment.
- (5) Use original parts for maintenance and repair.

3. 警告標誌及警告圖示

為了防止對用戶造成危害，本使用說明書上，記載有下列的警告標誌及圖示。

3-1 危險水準的說明



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。



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。

3-2 警告圖案及標誌的說明



運動部位，謹防工傷事故。



高溫部位，謹防燙傷事故。

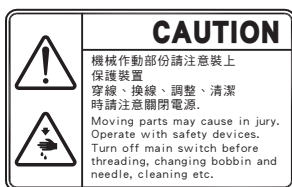


高壓部位，謹防觸電事故。



地線的接線表示。

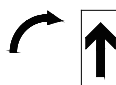
3-3 貼附在針車的警告標示



表示禁止拆卸安全護具，和禁止在投入電源中，另做縫製以外的作業。



貼附在安全護具，但是為了作業性的考量，護指和護目並沒有貼附，但是必要在指定的部位安裝護具備用。



請確認針車飛輪的迴轉方向和標示指向要一致。

3. Caution signs and alert pictorial markings

In order to prevent any danger to customers, this instruction manual contains following alert pictorial markings.

3-1 Illustration of caution signs



It must cause serious injury or death to operator or others, if do not pay attention to the sign and do the wrong operation.



It must cause injury to operator or others or machine damage, if do not pay attention to the sign and do the wrong operation.

3-2 Illustration of alert pictorial markings



Moving part. In case of industrial accident.



High-temperature part. In case of burn accident.

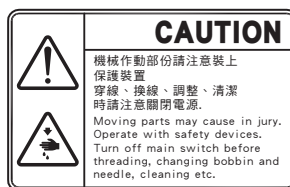


High-voltage part. In case of electric shock.



Indicated earth wire wiring.

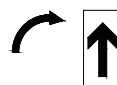
3-3 Warning label on sewing machine



Forbid to remove safeguards, and works except for sewing works while power switch on.



The label is affixed on safeguards. Considering the operation, it is not affixed on the finger guard and eyes guard.



Make sure pulley of sewing machine rotating direction is the same as the sign.

種類及規格說明

TYPES AND SPECIFICATIONS

1. 型號分類表示：

VC008N - 04 64 254 P / WL
 (1) (2) (3) (4) (5) (6)

(1) 高速多針雙重鏈式環縫車

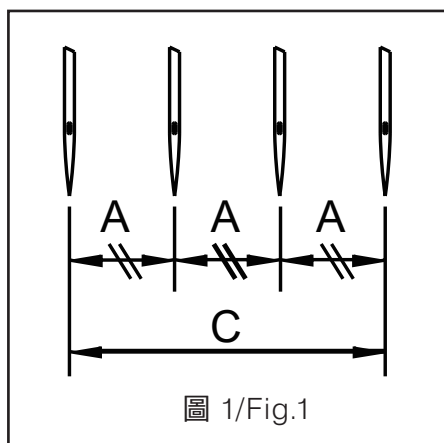
(1) High speed cylinder bed looper in line with feed multineedle double chainstitch machine with puler.

(2) 表示針數：04(針)、06(針)、08(針)、11(針)、12(針)、13(針)、17(針)、21(針)、23(針)

(2) Indicate the number of the needle: 04(4 needles), 06(6 needles), 08(8 needles), 11(11 needles), 12(12 needles), 13(13 needles), 17(17 needles), 21(21 needles), 23(23 needles).

(3) 針之針幅 (等距) (圖 1/ 表 1)

(3) Interspace of needles (equal space). (Fig.1 / Table.1)

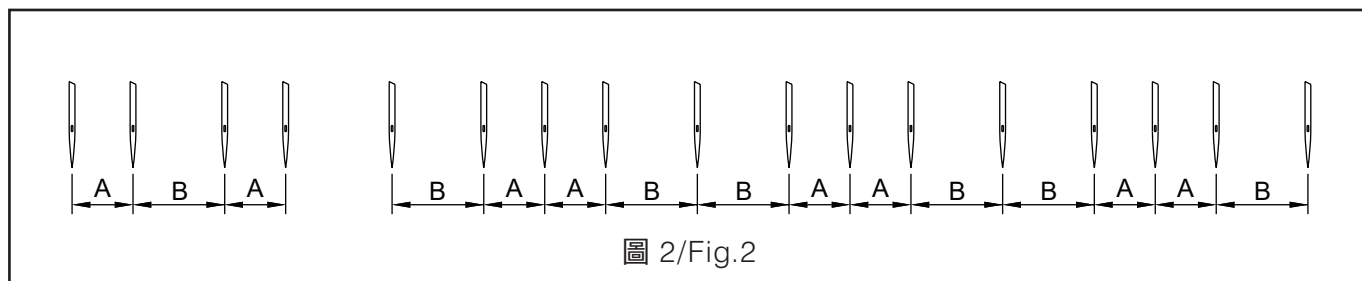


型式 Type	四針總針距 Total width of the four needles(C)
064P	3/4"
085P	1"
095P	1 1/8"
106P	1 1/4"
127P	1 1/2"

表 1/ Table.1

(4) 針之針幅 (不等距)(圖 2/ 表 2)

(4)Interspace of needles(unequal space)
(Fig.2 / Table.2)



形式 Types	A	B	A
0448 - 191P	3/16"	3/4"	3/16"
0448 - 222P	3/16"	7/8"	3/16"
0448 - 254P	3/16"	1"	3/16"
0464 - 191P	1/4"	3/4"	1/4"
0464 - 127P	1/4"	1/2"	1/4"
0464 - 254P	1/4"	1"	1/4"
1332-032P	1/4"	1/8"	—

表 2/ Table.2

[1] 最內兩針之針幅尺寸如表 2 之 B 欄位顯示。

[1]The interspace from center to center of the two center needles is shown as B in Table.2

[2] 若針幅為等距，則此欄不顯示。

[2]For equal distance of each needle the length will not show in this table.

[3] A 之尺寸，標示於表 2 之欄內。

[3]The length of A are shown in Table 2.

(5) 備有標準後拉滾輪機構。

(5) Equipped with standard rear pullers.

(6) 輔助配件：

(6)Indicates the accessory:

編號	用途	Application
WL	前拉滾輪	Front puller

表 3/ Table.3

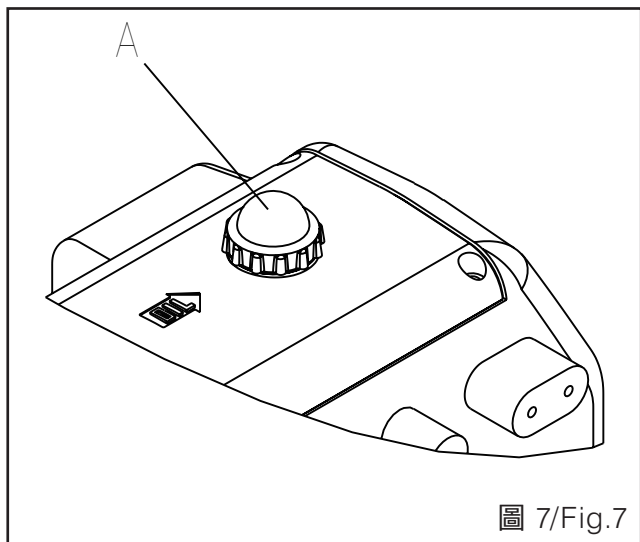


圖 7/Fig.7

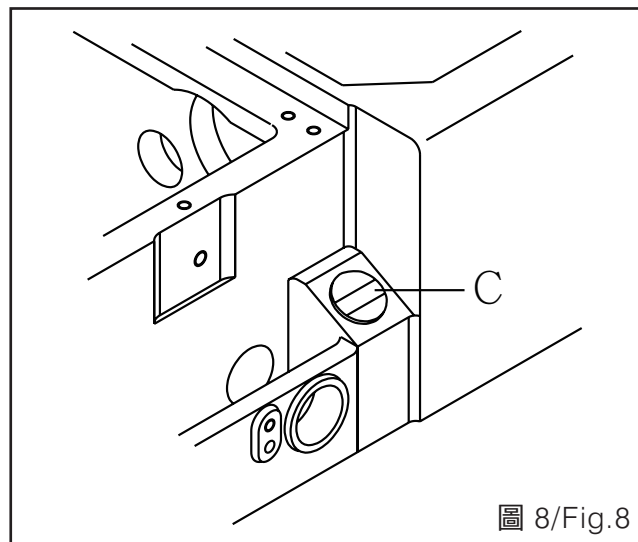


圖 8/Fig.8

2. 潤滑油之更換

- * 將螺絲 (A) 鬆開，使油槽之油完全排出後再鎖緊。
- * 為延長本機器之壽命，請於開始使用四個星期後更換新油，爾後約每四個月更換一次。

2.Change the lubrication oil (Fig.5)

- *Loosen oil screw(A) and re-lock it after the oil in the oil tank has emptied.
- *For extending the term of use,please change the oil after 4 weeks after first use.Then,change the lubrication oil every 4 months.

3. 濾油器之更換 (圖 9)

- * 本機器特別裝有濾油器，約每使用一個月後應卸下清洗，必要時得更換新品。

3.Change the oil filter (Fig.9)

- *This model has equiped an oil filter especially.This filter should be cleaned every one month,and should change a new one if necessary.

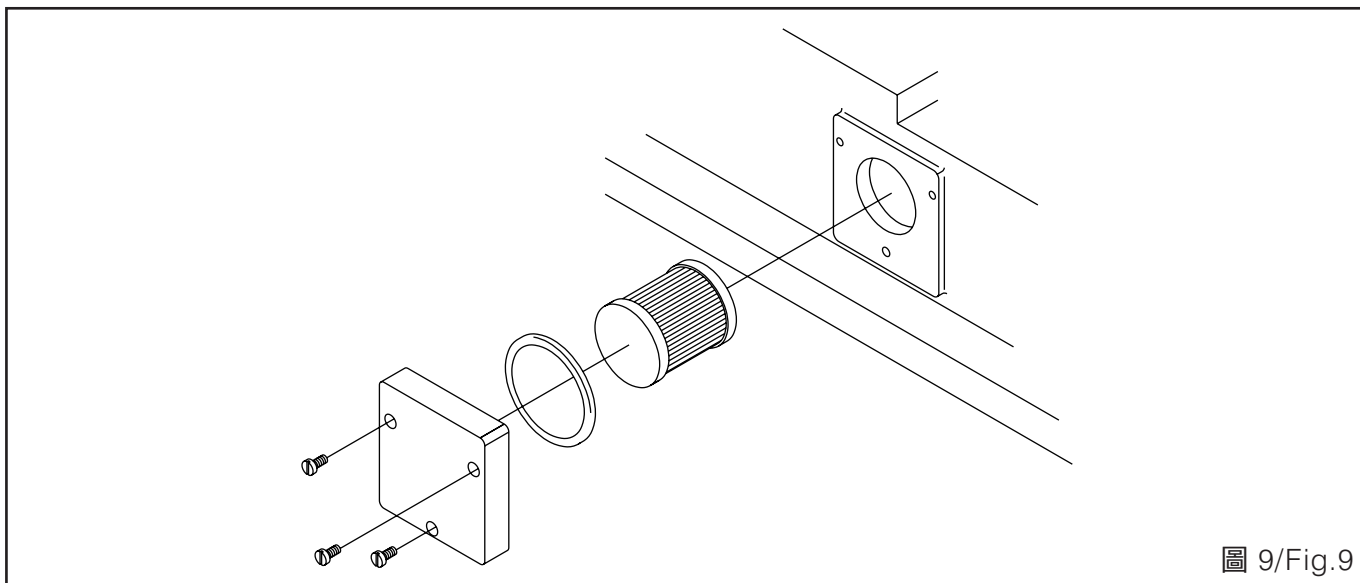


圖 9/Fig.9

針之更換

CHANGE THE NEEDLE

* 選用針之規格與尺寸請參照表6。

* Please refer Table.6 to know the specifications and the sizes of the needles.

針的規格系統 NEEDLE SYSTEM	針的尺寸 NEEDLE SIZE
Schmetz UY113GS	#70 ~ #160
Organ UOX113	#11 ~ #18
DVX57	#11 ~ #18
DV-K25	#18

表 6/Table.6

* 旋開螺絲 A 並取下針。(圖 10)

* Loosen screw A and take off the needle.(Fig.10)

* 將新針插入針座之針孔最底端，並使針之凹槽向著自己。

*Insert the new needle into the needle hole of the needle seat until the needle reaches to the bottom.In addition,turn the needle to have the groove on the needle facing you.

* 如果車針安裝不正確，不但會引起跳針、斷線，還會損壞勾針，務必注意。

*If installed the needle incorrectly,it will cause skipped stitches, broken threads,and will break the needle.Please be very careful about this.

* 重新鎖緊螺絲 A。

*Retighten the screw A.

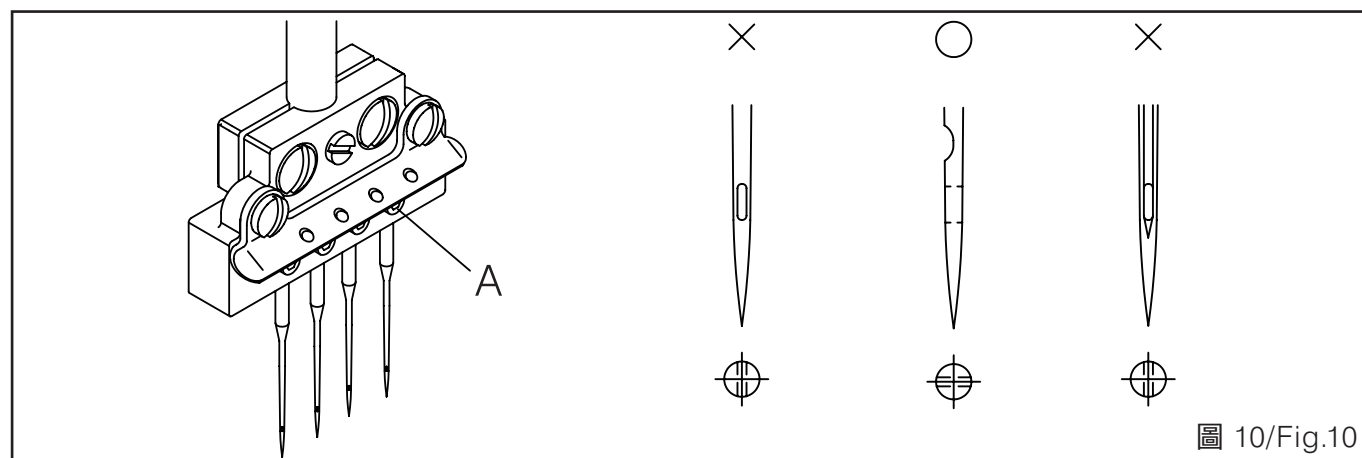


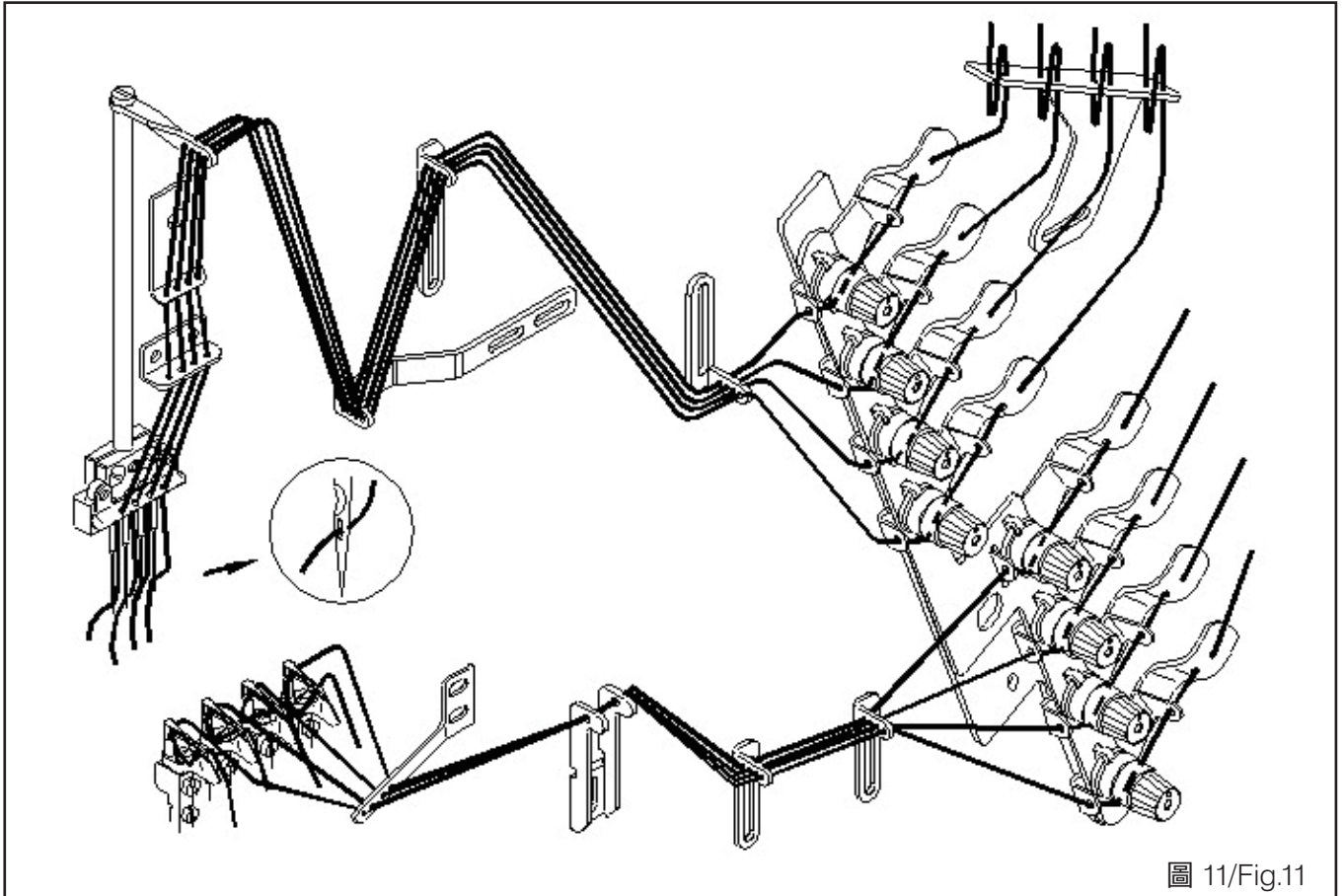
圖 10/Fig.10

穿線方法

THREADING

1. 請確實按照圖示作好針之穿線，錯誤之穿線將引起斷線，跳針或車縫不平坦等現象。(圖 11)

1. Please thread as the figure illustrated, otherwise, it may cause thread-broken, skipped stitches, or uneven stitches. (Fig. 11)



2. 在穿勾針線時，應將勾針座引出軸 P 沿箭頭方向拉出使勾針座向前彈出，然後進行穿線。(圖 12)

2. When threading, the leading shaft of the looper holder should be pulled out as the arrow direction, so that the looper holder will slightly move forward. Then, proceed threading. (Fig.12)

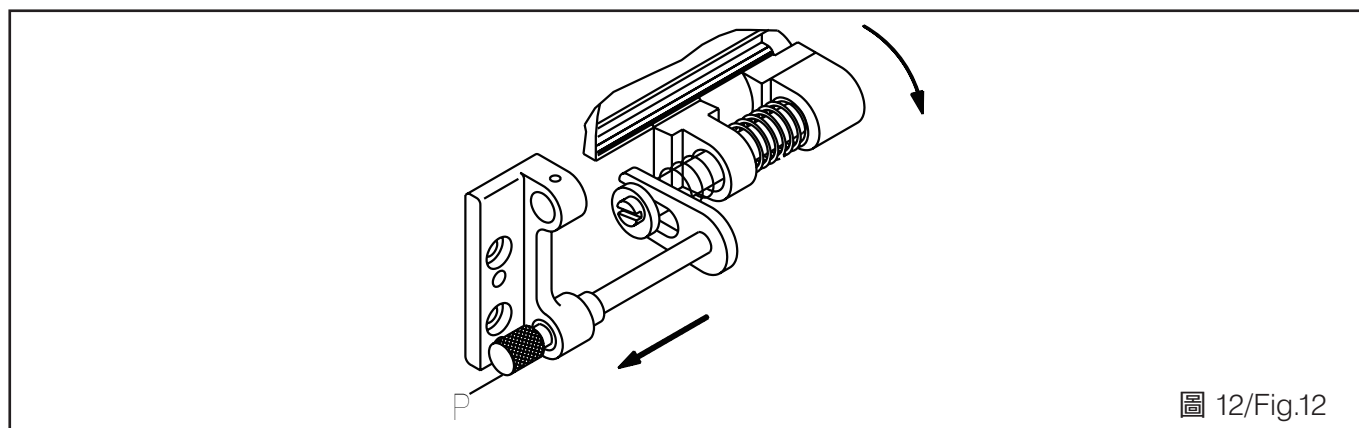


圖 12/Fig.12

控線調整

THREAD CONTROL ADJUSTMENT

控線強弱必須根據車縫布料層數線的種類與車縫的針距等不同而做不同之調整。(圖 11)

The thread tension strength should be adjusted differently according to the fabric, the layers amount of the sewing fabric, and the stitch length. (Fig.11)

* 將控線鈕順時針方向旋轉時，線越緊，反之則越鬆。

* Rotate the thread control knob clockwise, and the thread tension will be tighter. Otherwise, the tension will be looser.

針控線桿之調整 (圖 13)

* 針線控線桿 B 依縫線使用種類來選擇使用之狀態，放鬆螺絲 A 將 B 上下移動調整，在使用伸展性大的縫線時將 B 上移，反之下移。

Adjust the needle thread control rod (Fig.13)

* Based on thread types to adjust the needle thread control rod B to the best using status. Loosen screw A to move B up or down to adjust. Move B upward when using high extensibility thread. Otherwise, move B downward when using low extensibility thread.

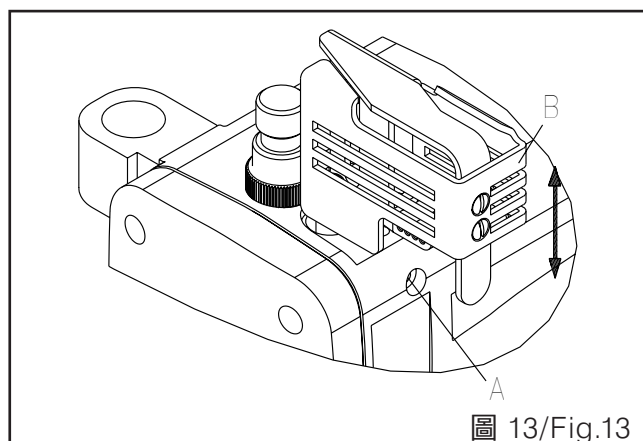
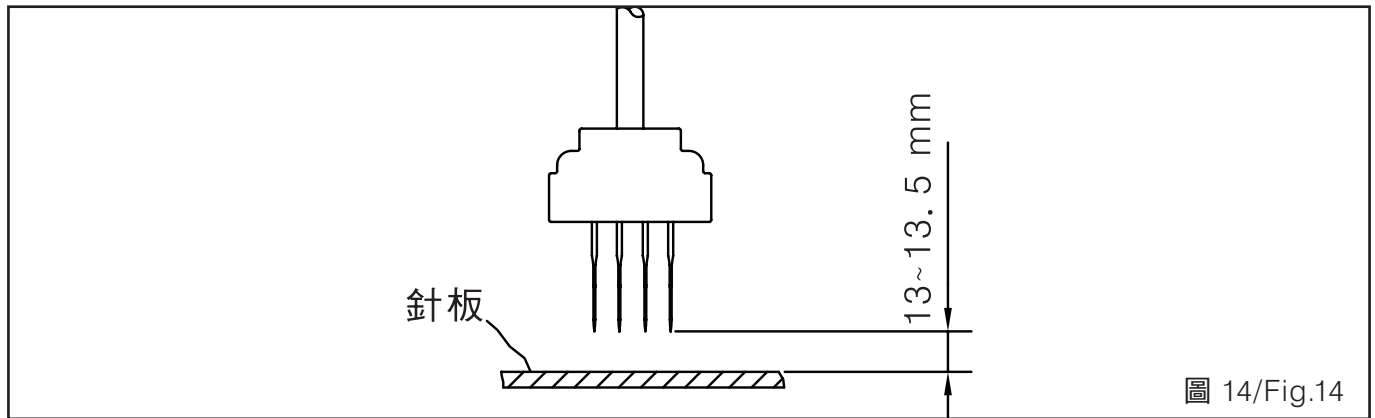


圖 13/Fig.13

針高度之調整

ADJUST THE NEEDLE HEIGHT



* 當針棒上升至上始點時，調整針尖與針板面之距離為 13~13.5mm(圖 14)

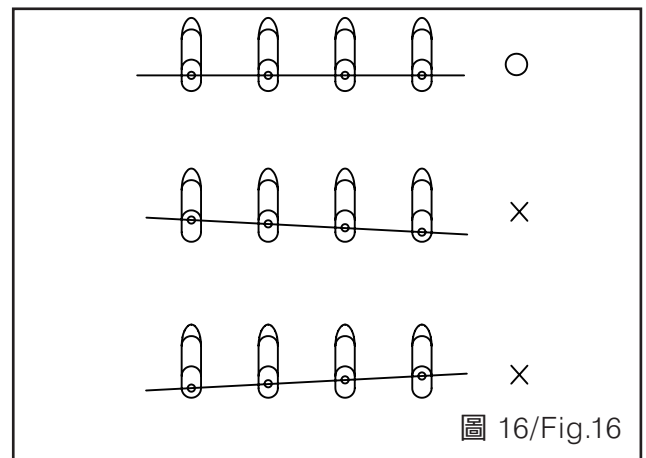
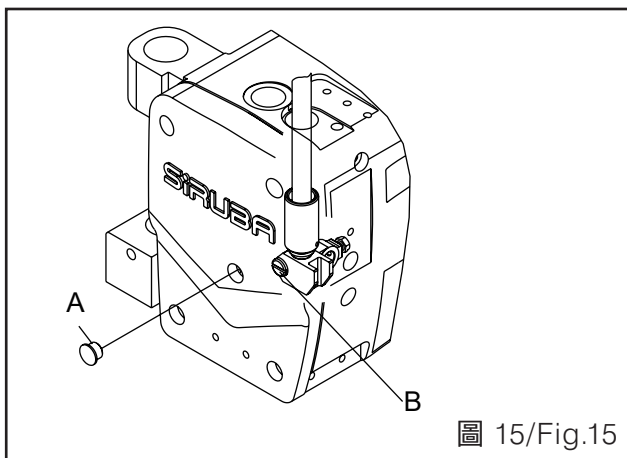
*When the needle bar rises to the upper dead point, adjust the distance from pinpoint to the surface of the needle plate to be 13~13.5mm.(Fig.14)

* 打開上方之側蓋橡膠塞A，並鬆開螺絲B，上下調整針棒之高度後再固定之。(圖 15)

* Open the rubber plug A of side cover on the top, and loosen screw B. Then fix it after adjust the height of the needle bar up and down. (Fig.15)

注意：經過調整後，必須確定每一根針是通過針板的針孔中央。(圖 16)

Note: Make sure that every needle is through the central of the needle hole of the needle plate after adjustment. (Fig.16)



護針片調整

ADJUST THE NEEDLE GUARD PLATE

放鬆螺絲A，調整護針片，使其與針之間隙為 0~0.1 mm (圖 17) 後，再鎖緊螺絲A。

Loosen screw A, and adjust the distance from the needle guard plate to the need to be 0~0.1 mm. Then, tighten the screw A. (Fig.17)

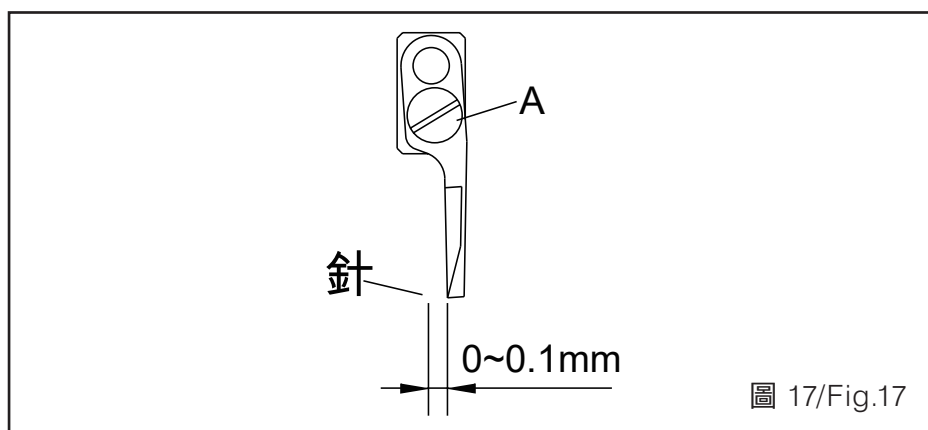


圖 17/Fig.17

針與勾針之調整

1. 將勾針完全插入勾針座內稍微鎖緊螺絲 A。
(圖 18)
2. 轉動皮帶輪使針上升，並使勾針前進至左側中心線。(圖 19)
3. 調整勾針尖與針側之間隙為 $0\sim0.05\text{mm}$ 。
4. 再鎖緊螺絲 A。

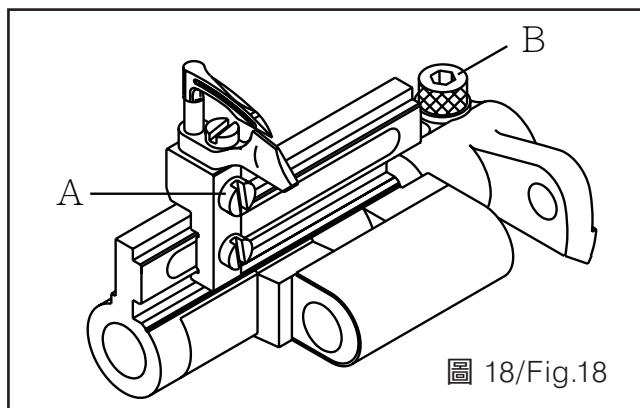


圖 18/Fig.18

ADJUST THE NEEDLE AND THE LOOPER

1. Insert the looper into the looper holder completely, and tighten the screw A a little. (Fig.18)
2. Turn the belt pulley to raise the needle and to move the looper forward to the left central line of the needle. (Fig.19)
3. Adjust the looper so that the distance between the looper top and the needle side is $0\sim0.05\text{ mm}$.
4. Retighten the screw A.

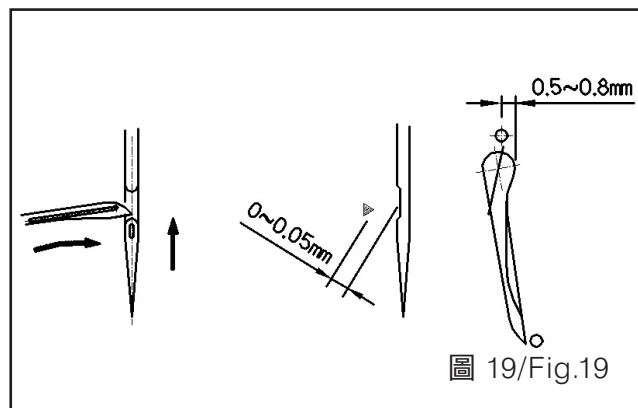


圖 19/Fig.19

勾針調整

當針位於下始點時，勾針尖端與針中心線之間隙為 2.8mm 。(圖 20)

調整時將勾針底座驅動桿固定螺絲 B 放鬆，前後調整勾針座後再鎖緊螺絲 B。(圖 18)

ADJUST THE LOOPER

When the needle locates at the lower dead point, the distance from the looper top to the central line of the needle is 2.8 mm . (Fig. 20)
For the adjustment, please loosen the fixed screw B of the drive rod of the looper seat, adjust the looper seat back and forth, and then retighten the screw B. (Fig. 18)

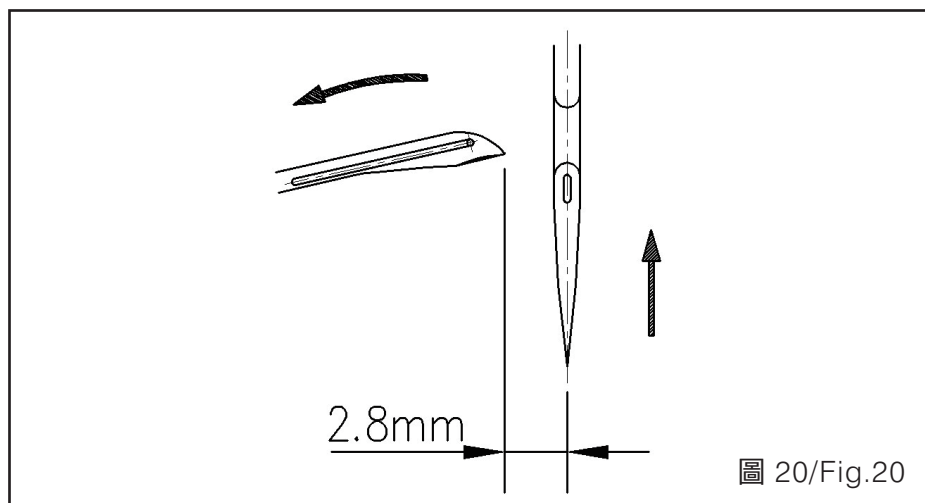


圖 20/Fig.20

針與勾針之時位關係

當針由下始點開始往上移，且勾針由後始點往前移至如 (圖 21)A 所示之位置時。勾針尖與針孔上方之距離為 1.5mm。

當針由上始點開始往下移，且勾針由前始點往後移至如 (圖 21)B 所示位置時，勾針尖與針孔上方之距離為 3mm，以上即為正確之關係位置，即勾針在針中心位置往回時，差 1.5mm。

調整時，將偏心凸輪 A 的固定螺絲 B 放鬆，前後調整即可調整期間之時位關係。(圖 22)

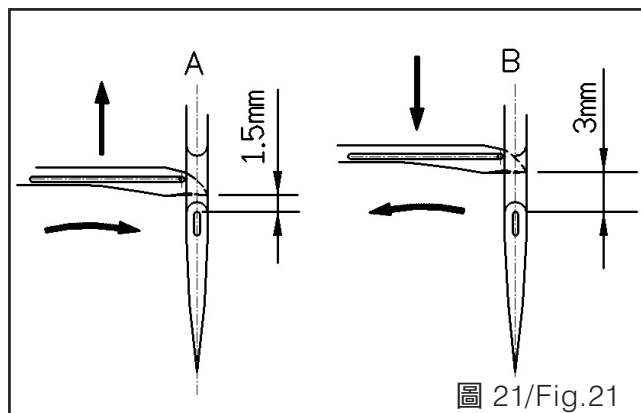


圖 21/Fig.21

TIMING POSITION OF THE NEEDLE AND THE LOOPER

When the needle starts moving up from the lower dead point, and the looper starts moving forward from the rear dead point to the position A shown as the Fig.21, the distance from the looper tip to the upper point of the needle hole is 1.5mm.

When the needle moves down, and the looper moves backward from the front to the position B shown as Fig.21, the distance from the looper to the upper point of the needle hole is 3 mm. That is the correct relationship position, which means the looper is 1.5 mm away from the needle central position.

While adjusting, loosen the fixed screw B of the eccentric A and move the eccentric A back and forth to adjust the time correlation position. (Fig.22)

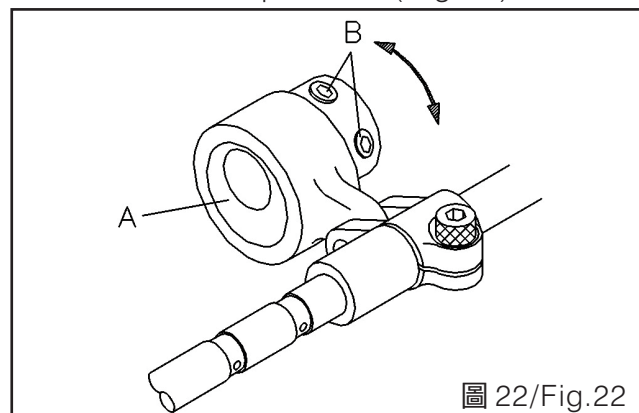


圖 22/Fig.22

撥線桿之固定

撥線桿 A 與車針之間隙如 (圖 23)。

當針棒於下方位置時，將撥線桿 A 固定螺絲 B (圖 24) 放鬆調整至 (圖 23) 所示之尺寸，並注意各桿之平行，再鎖緊。

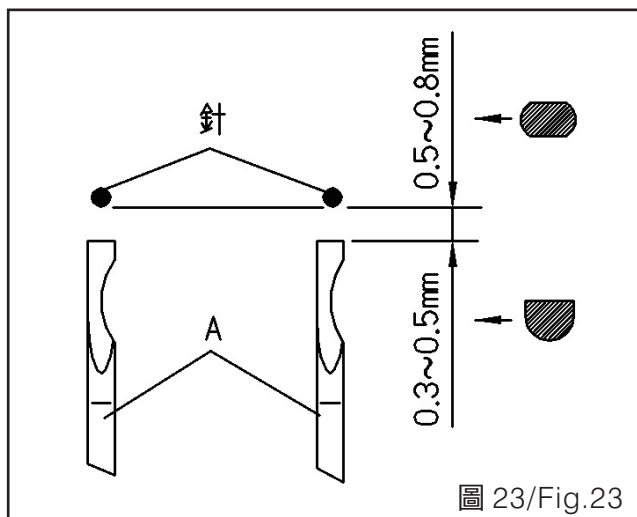


圖 23/ Fig.23

FASTEN THE THREAD WIPER

The distance between the thread wiper A and the needle refer to (Fig.23).

When the needle locates at lower position, loosen the fixed screw B on the thread wiper A (Fig.24), adjust the wiper to the size show as (Fig.23). Be careful of the parallel of each wiper, and then retighten the screw B.

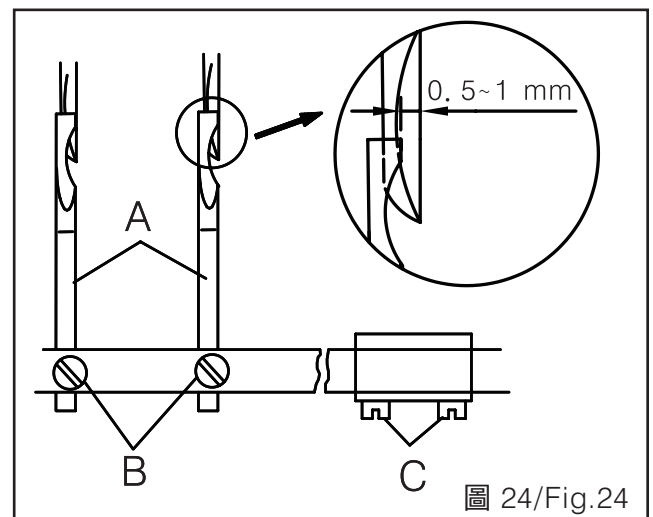


圖 24/ Fig.24

勾針與撥線桿之關係

當撥線桿 A 於左始點位置時，撥線桿 A 右端與勾針右端二者之間隙為 0.5~1mm。(圖 24) 而勾針與撥線桿 A 之間隙為 0~0.1mm。(圖 25)

調整時：

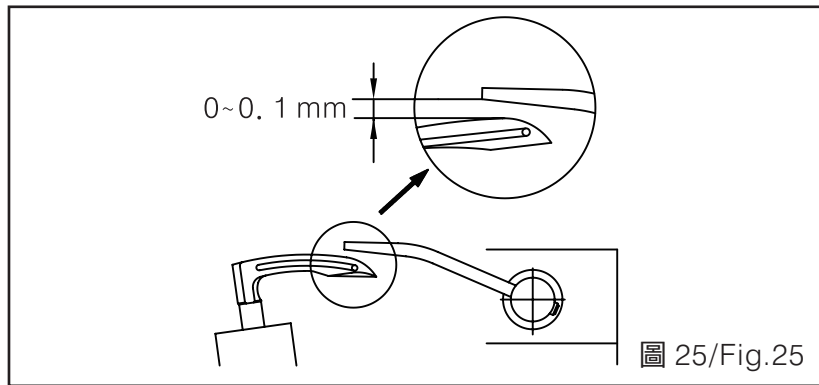
1. 先放鬆再稍鎖緊撥線桿心軸固定螺絲 C。(圖 24)
2. 旋轉皮帶輪使撥線桿心軸連桿移到左始點。
3. 調整使符合上述條件，再鎖緊螺絲 C。

THE RELATIONSHIP BETWEEN LOOPER AND THREAD WIPER

When the thread wiper A is at the left dead point, the distance from the right side of the thread wiper A to the right side of the looper is 0.5~1mm (Fig.24). As well as it is 0~0.1 mm from the looper to the thread wiper A (Fig.25).

When adjusting:

1. Loosen the fixed screw C of the thread wiper main shaft, and then retighten it a little. (Fig.24)
2. Turn the belt wheel to move the thread wiper main shaft connecting rod to the left dead point.
3. Adjust the device to match the conditions describing above and relock screw C.

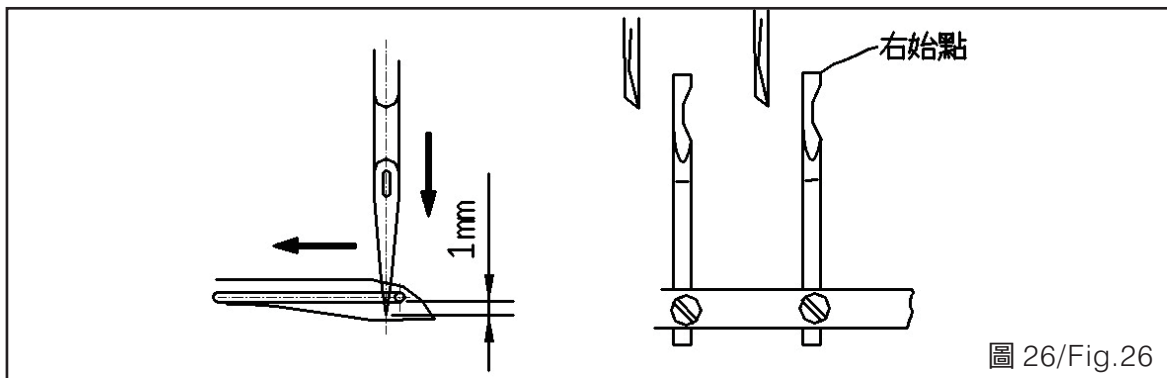


針、勾針與撥線桿之時位關係

當針尖下降至勾針間隙約 1mm，撥線桿 A 正好由右始點向左移。(圖 26)

TIMING POSITION AMONG NEEDLE, LOOPER, AND THE THREAD WIPER

When the needle top moves down to be 1 mm lower than the looper hole, the thread wiper A will right move to the left from the right dead point. (Fig. 26)



勾針線控線桿之調整

當針棒由上始點下降至車針位於勾針背面的中心位置時，勾針線控線 A 也正好由下始點往上抬起。(圖 27)

調整時：

1. 放鬆偏心凸輪 F 固定螺絲 C 前後調整至正確方位，再鎖緊螺絲 C，往前轉變快，往後轉變慢。

ADJUST THE LOOPER THREAD CONTROL ROD

When the needle bar goes down from the upper dead point and the needle locates at the central of the looper rear side, the looper thread control rod A just happens to move upward from the lower dead point. (Fig. 27)

Adjusting:

1. Loosen the fixed screw C of the eccentric F, and adjust it back and forth to the right position. Then, retighten the screw C. Turn the screw forward, the eccentric will be faster, where as turn it backward, the eccentric will be slower.

2. 微調整時，放鬆螺絲 E，將線導片 B 上下移動調整再鎖緊螺絲 E。

線的出線量因所使用的線而異，其出線量為：

棉線，S P 線：7~10mm (D) (圖 28)

伸縮尼龍線：10~15mm (D) (圖 28)

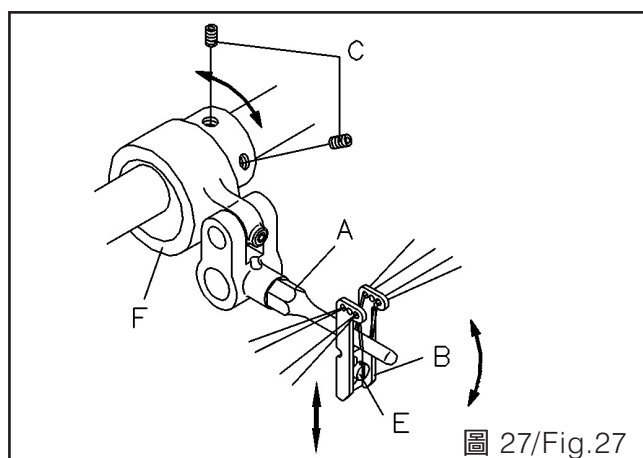


圖 27/Fig.27

2. For doing micro-adjustment, loosen screw E, and move the thread guide B up and down to adjust. Then retighten the screw E.

The threading amount will be different because of the thread used.

The amount is:

Cotton, SP thread: 7~10mm (D) (Fig. 28)

Elastic Nylon thread: 10~15mm (D) (Fig. 28)

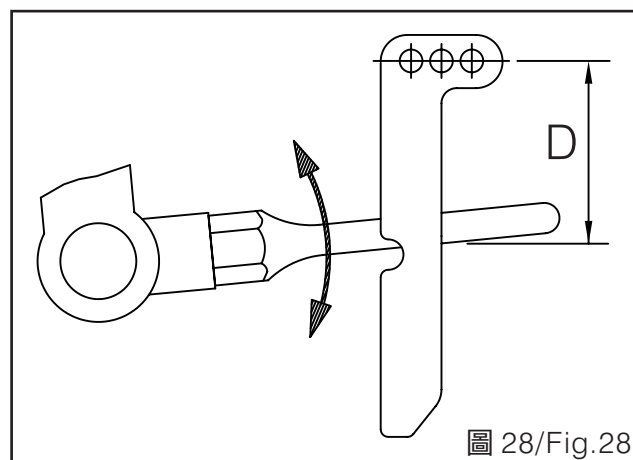


圖 28/Fig.28

送具調整

ADJUST THE FEED DOG

高度調整 (圖 29)

送具升至最高點時，送具齒尖面與針板面 A 之距離為 0.8~1.5mm，平均為 1.2mm。

Adjust the height (Fig. 29)

As the feed dog rise to the upmost, the distances from the gear top of feed dog to the face of needle plate A are 0.8-1.5mm. The average value is 1.2mm.

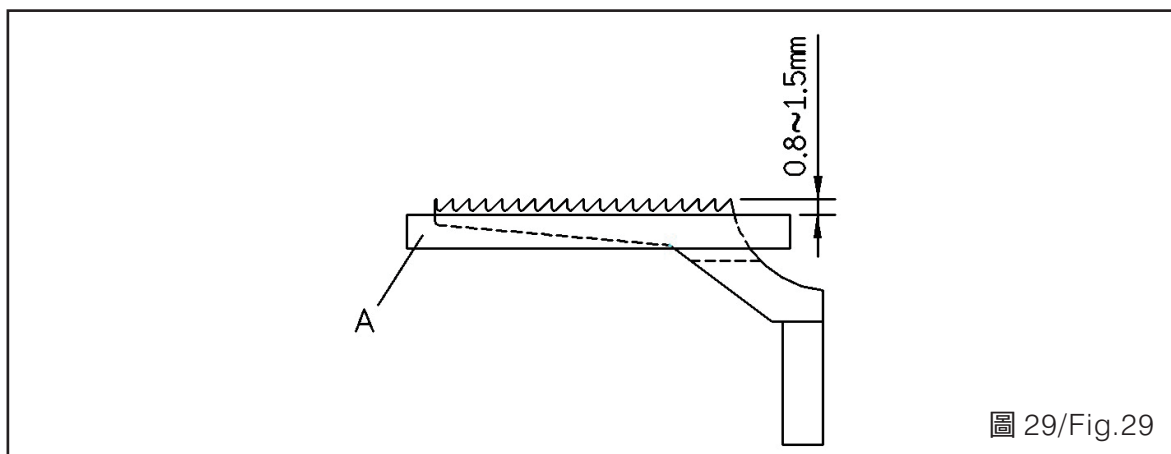


圖 29/Fig.29

調整時參照 (圖 30)

1. 放鬆送具 C 固定螺絲 A。
2. 上下移動送具 C 使符合上述條件時，再鎖緊螺絲 A。
3. 將高度固定銷 D 之固定螺絲 B 放鬆，調整固定銷至頂，直至送具 C 底部再鎖緊螺絲 B。
4. 此時亦應確認送具 C 左右方向的平行。

When doing adjustment, please refer to (Fig.30).

1. Loosen the fixed screw A of the feed dog C.
2. Move the feed dog C up and down to match the condition mentioned above, and then tighten the screw A.
3. Loosen the fixed screw B of the height fixed pin D, and move the fixed pin to top. Lock the screw B after the pin D reach the bottom of the feed dog C.
4. At this moment, please confirm the parallel between the left and the right side of the feed dog C.

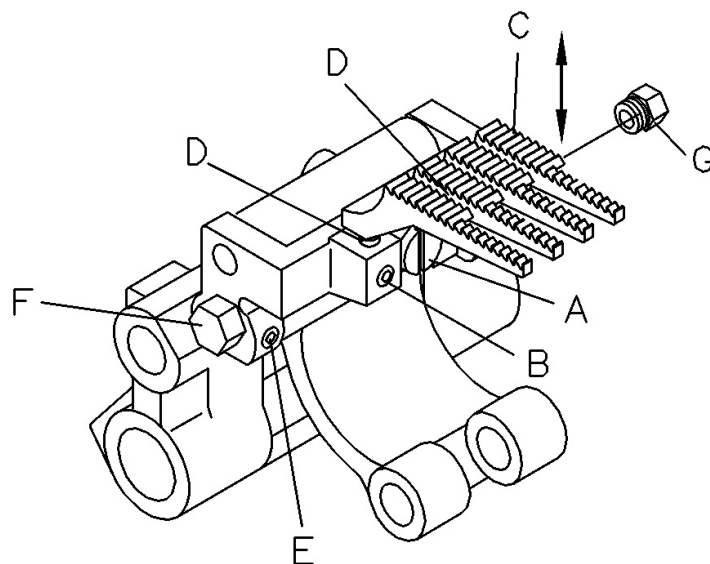


圖 30/Fig.30

送具平行調整

ADJUST THE FEED DOG'S PARALLEL

送具上升至上始點時應與針板平行。(圖 29)

When the feed dog moves to the upper dead point, it should parallel the needle plate. (Fig. 29)

調整時：

固定螺栓F，將螺帽G放鬆，調整送料具螺絲E，使送料具C與針板面平行，再鎖緊螺帽G。(圖 30)

For adjustments: (Fig. 30)

Fasten the bolt F, and loosen the screw nut G. Then, adjust the screw E of the feed dog, so that the feed dog C can parallel the needle plate. Tighten screw nut G after that.

縫目之調整

ADJUST THE STITCH

壓下按鈕A，並轉動皮帶輪，使按鈕卡住針具距調整組，再轉動皮帶輪至所需之縫目後，放開此按鈕。(圖 31)

Press the button A, and roll the belt wheel to make the button lock the needle distance adjustment set. After rotate the belt wheel to the desired stitch, release the button A. (Fig. 31)

調長縫目時，將皮帶輪往順時針方向旋轉，反之則小。

For longer stitch, rotate the belt wheel clockwise. Turn the wheel counter clockwise to have shorter stitch thereagainst.

調整縫目時，馬達需在停止狀態。

The motor must stay at dormant status while adjusting the stitch.

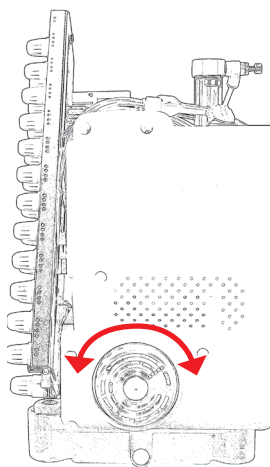


圖 31/Fig.31

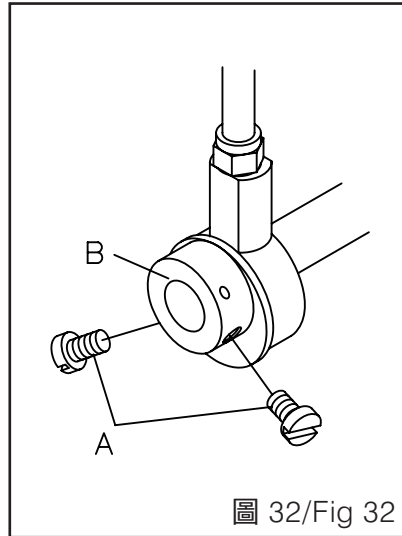
後拉引輪調整

REAR PULLER ADJUSTMENT

當針棒由下死點往上移 24 mm 時，後拉引輪開始轉動，即為正確之時位關係。

調整時：(圖 32)

1. 放鬆偏心凸輪 (B) 固定螺絲 (A) 後，再稍鎖緊。
2. 旋轉皮帶輪至上述條件後，再鎖緊螺絲 (A)，往前轉時間變快，往後轉則變慢。



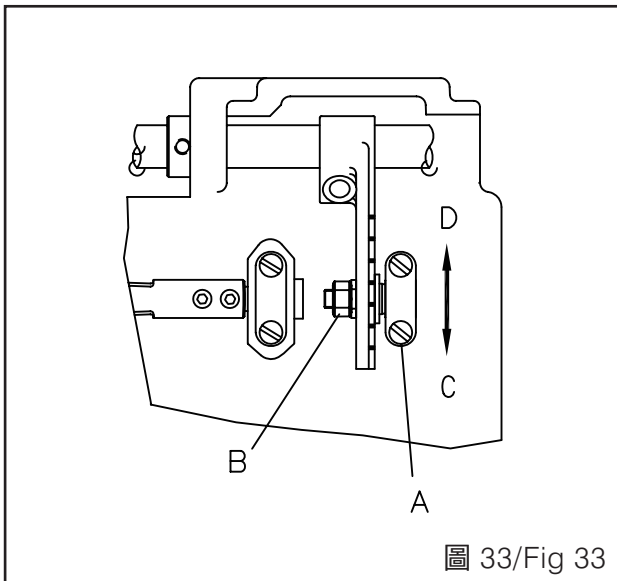
The right timing is when needle bar moves upward from bottom dead point about 24 mm, the rear puller starts running.

For adjustment : (Fig. 32)

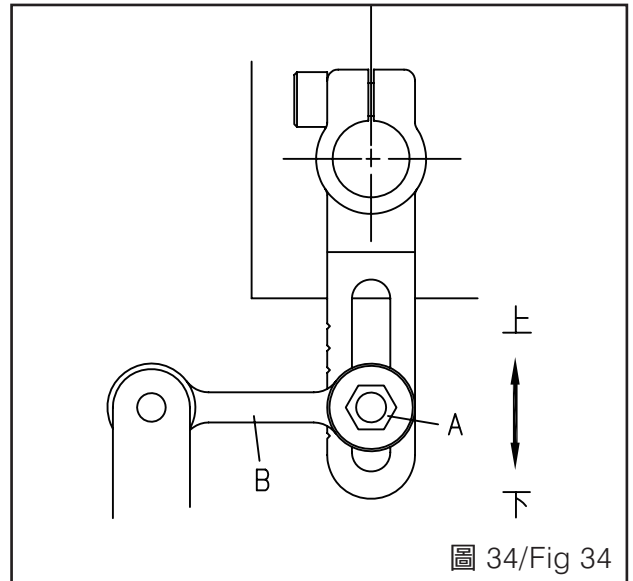
1. Loosen Screws (A) on Eccentric Cam (B) then slightly tighten them.
2. Turn pulley to have needle bar and rear puller reach their proper position. Then tighten Screws (A).

後拉滾輪供給量之調整

ADJUSTING OF REAR PULLER FOR FEEDING LENGTH



1. 取下上蓋。
2. 放鬆連桿 (A) 上之螺帽 (B) (圖 33)。
3. 將連桿 (A) 前後移動，往前移 (C 方向) 則拉引量小，往後移 (D 方向) 則拉引量大。
4. 微量調整時，放鬆螺帽 (A) 將連桿 (B) 上下移動，往上拉引量變多，往下拉引量變少 (圖 34)。



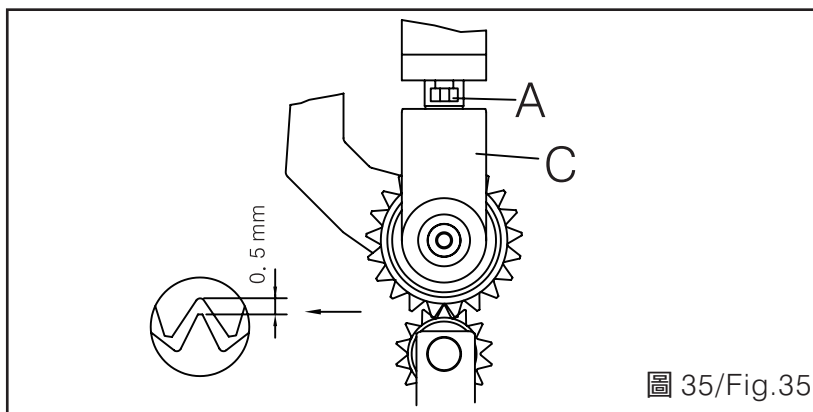
1. Take off top cover.
2. Loose Screw (B) of Connecting Rod (A). (Fig. 33)
3. Move Connecting Rod (A) forth for more and back for less feeding length.
4. For micro adjustment, loose Nut (A) and move Connecting Rod (B) upward for more and downward for less feeding length. (Fig. 34)

上下滾輪間隙調整

ADJUST THE DISTANCE BETWEEN UPPER AND LOWER GEAR

將上滾輪放至最低點，上滾輪與下滾輪之齒間隙為0.5 mm，且兩滾輪平行。(圖 35)

Place the upper gear down to the lower dead point. The distance between the teeth of the upper and lower gear is 0.5mm, as well as they are parallel. (Fig. 35)



調整時：

1. 兩滾輪平行之調整 ((圖 35)
將螺絲A放鬆，調整兩滾輪平行後，稍鎖緊螺絲A，上下移動固定座C，使上下滑動順暢，再鎖緊螺絲A。
2. 間隙0.5 mm之調整((圖 36)
如圖36所示，將螺帽D及螺絲H放鬆，調整螺絲H，使上下滾輪之間隙為0.5 mm再鎖緊螺帽D，稍放鬆螺絲K並調整連桿J，使螺絲L與連桿J之長圓孔下方間隙為0.5 mm，再鎖緊螺絲K。

When adjusting:

1. Adjust the parallel condition of the two gears. ((Fig. 35)
Loosen screw A to parallel the 2 gears, and then tighten the screw A a little. Move the fixed seat C up and down to make sure the movement is smooth, and retighten the screw A tightly.
2. Adjust the distance of 0.5 mm. ((Fig. 36)
As shown in Fig. 36 loosen the screw nut D and screw nut H to adjust screw H to make the distance between upper and lower gear is 0.5 mm. Then, tighten the screw D. Loosen screw K a little, and adjust the connecting rod J to keep a distance of 0.5 mm from the screw L to the bottom of the long round hole of the connecting rod J. Then, retighten screw K.

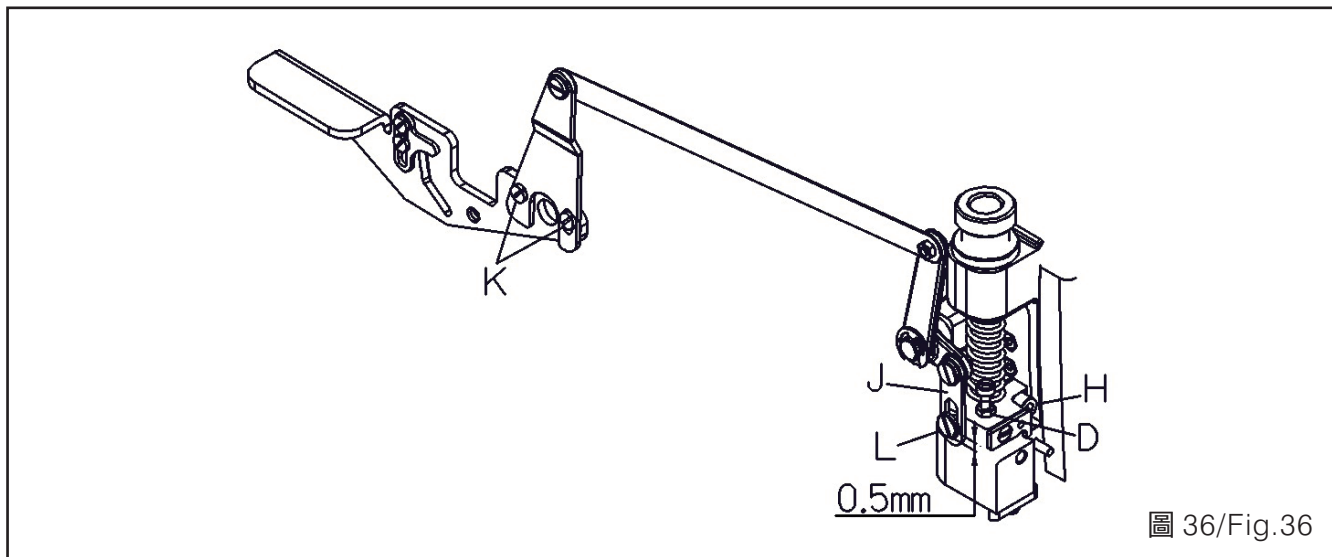


圖 36/Fig.36

3. 上滾輪壓力之調整(圖 37)

將壓力調整螺絲A往順時針方向轉動，則壓力加大，反之則減小。

3. Adjust the pressure of the upper gear.

(Fig. 37)

Rotate the pressure adjustment screw A clockwise, and the pressure will increase. Otherwise, the pressure will decrease.

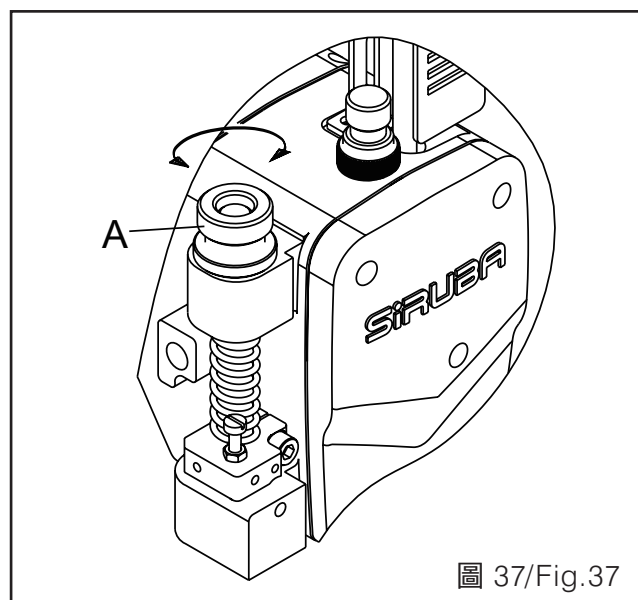


圖 37/Fig.37

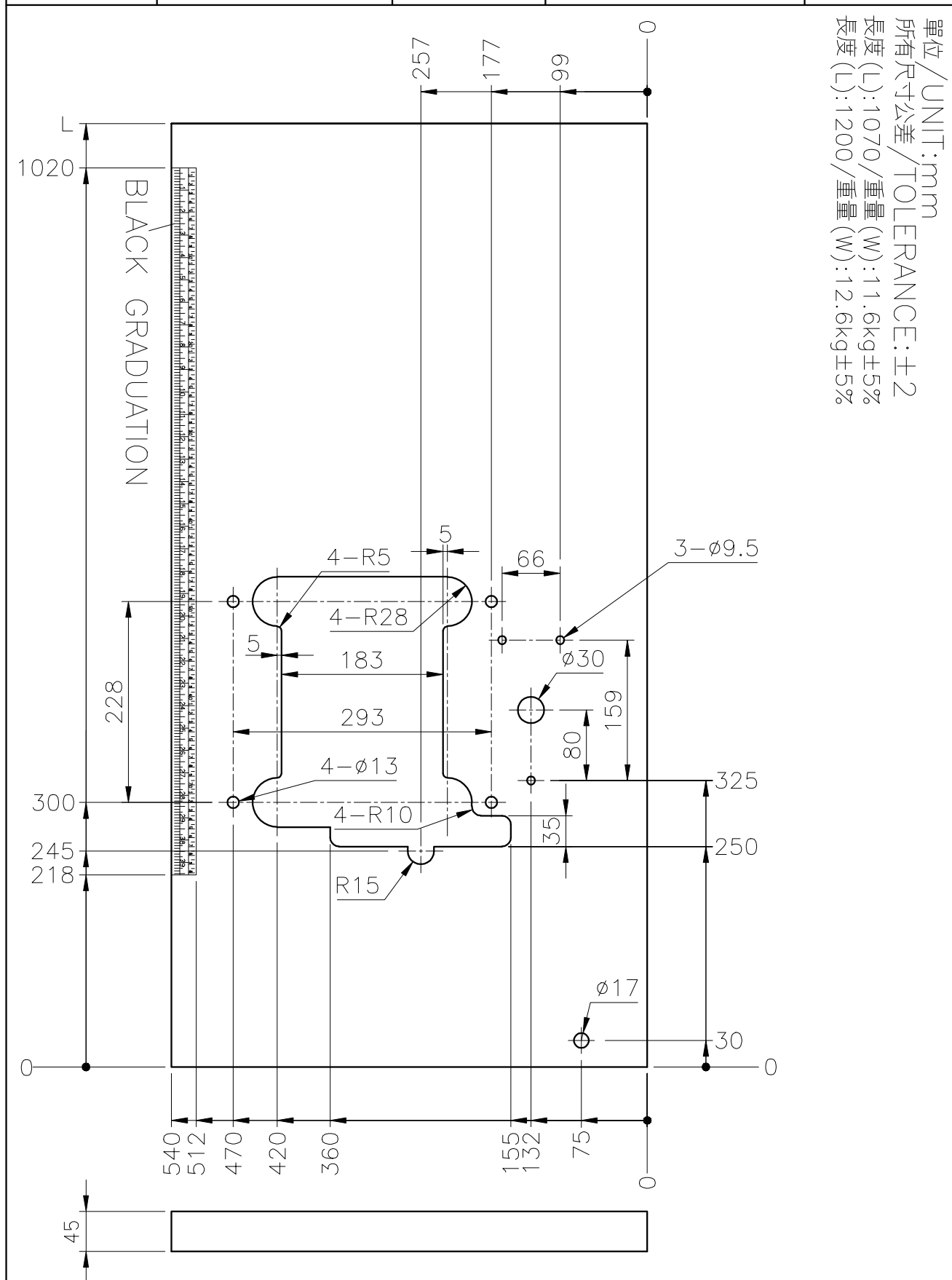
4. 上下滾輪之使用請參照表7

4. For the use of the upper and lower gear, please refer Table 7.

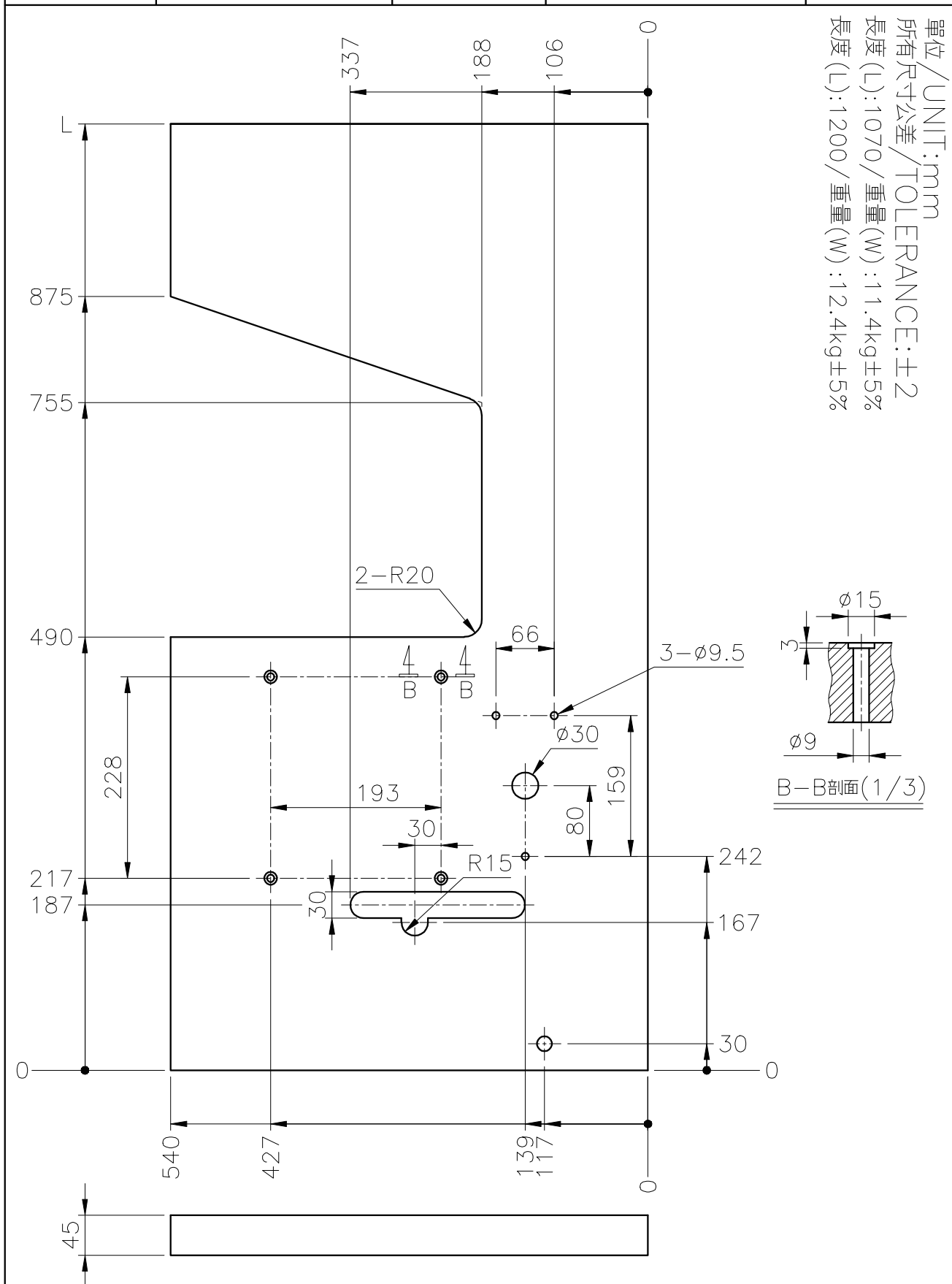
使用齒輪 Gear 布料 Fabric	上輪 Upper gear	下輪 Lower gear
平織布料 Woven fabric	平輪 Flat wheel	平輪 Flat gear
薄布料 Thin fabric	27 齒 27 teeth	16 齒 16 teeth
厚布料 Thick fabirc	22 齒 22 teeth	14 齒 14 teeth

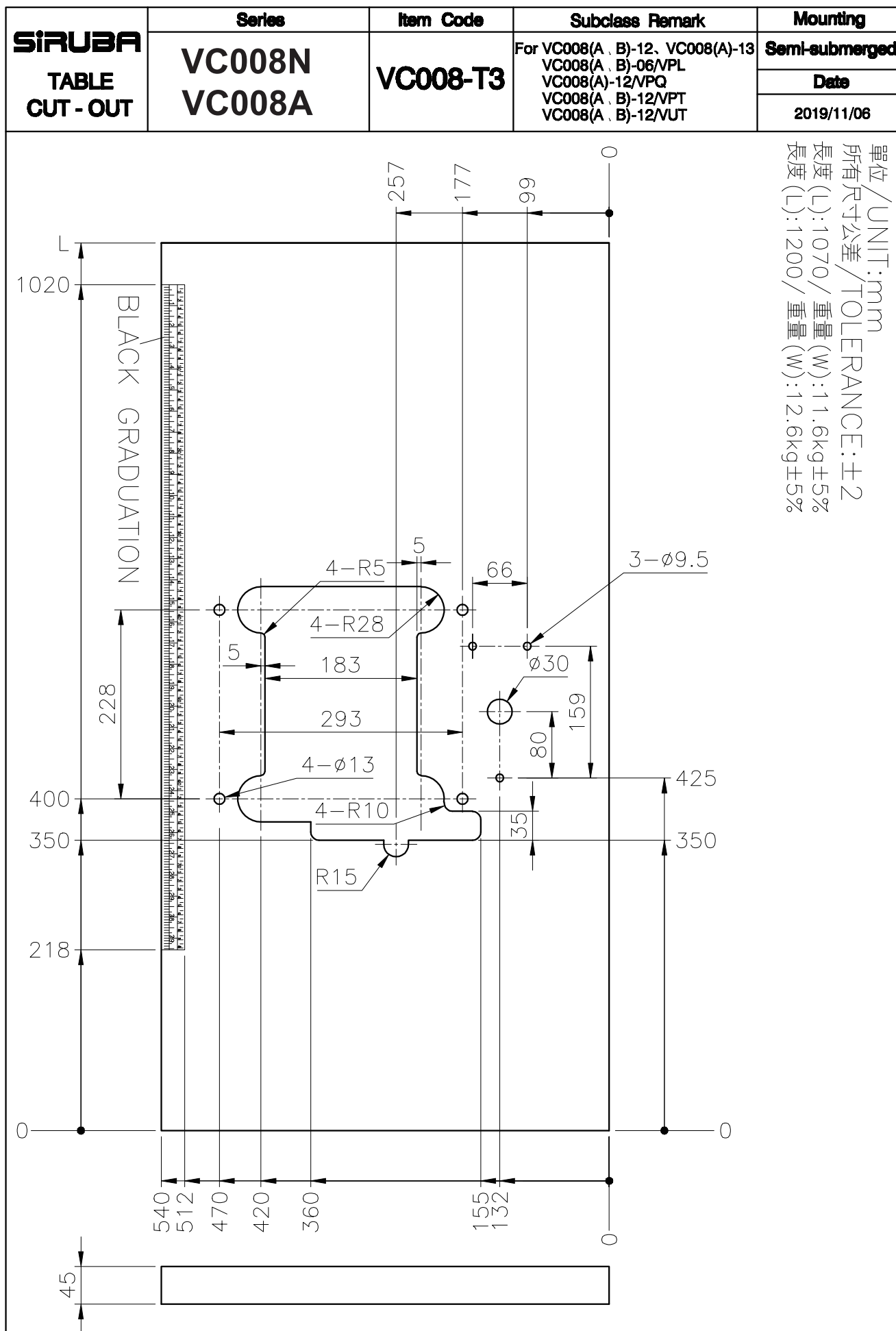
表 7/Table.7

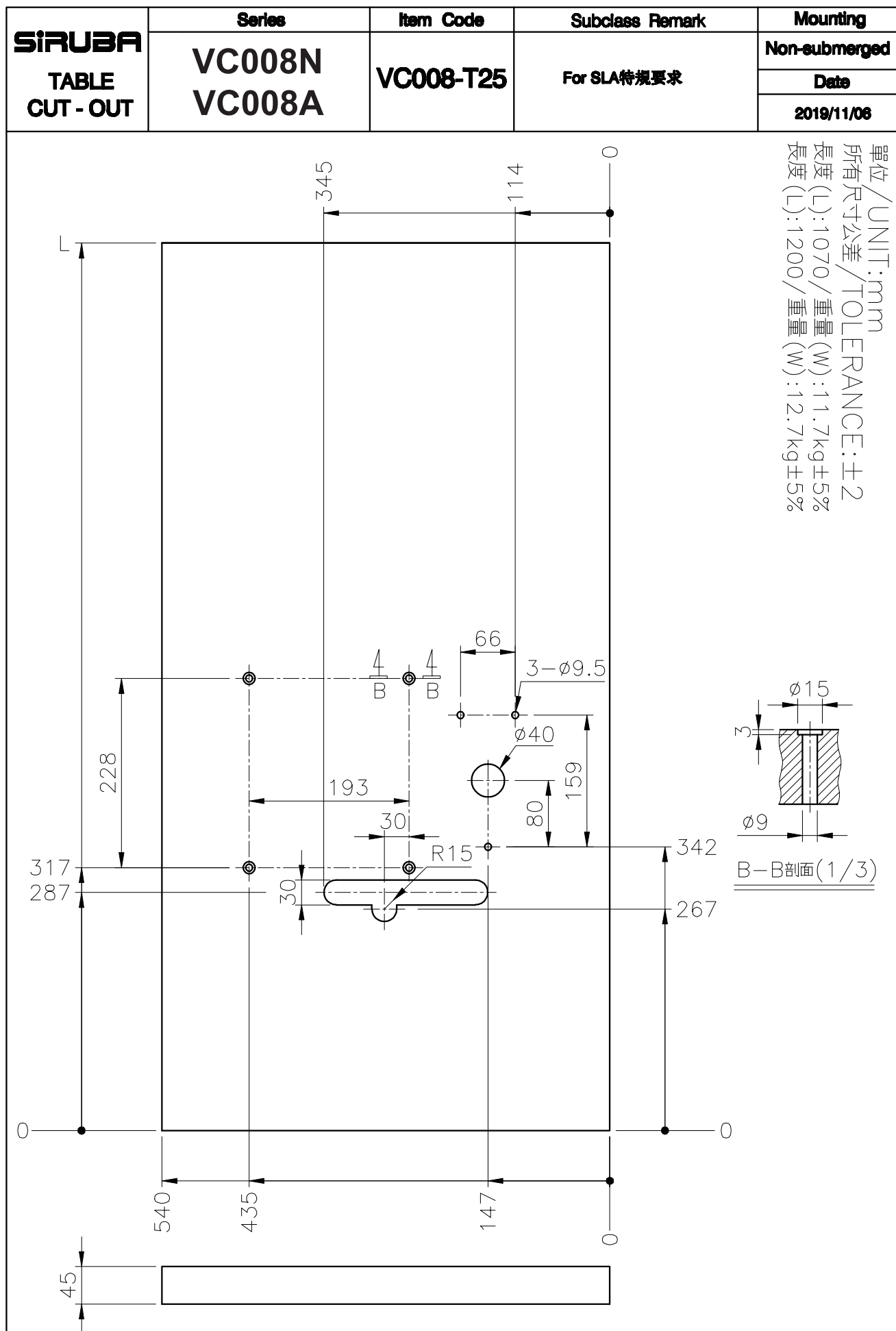
SIRUBA TABLE CUT - OUT	Series	Item Code	Subclass Remark	Mounting
	VC008N VC008A	VC008-T1	For VC008(A, B)-04 VC008(A, B)-04P/VCE VC008(A, B)-04P/VUT VC008(A, B)-04P/VSF	Semi-submerged
				Date
				2019/11/06



SIRUBA TABLE CUT - OUT	Series	Item Code	Subclass Remark	Mounting
	VC008N VC008A	VC008-T2	For VC008(A, B)-04 VC008(A, B)-04P/VCE VC008(A, B)-04P/VUT VC008(A, B)-04P/VSF	Non-submerged
				Date
				2019/11/06









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The specification and/or the equipment described in the instruction book and parts list
are subject to change because of modification with out previous notice
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