SiRUBA

使用説明書

INSTRUCTIONS BOOK

ASP-EBJ150

ENGLISH

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.

APP Apple Store

APP Google Play

安全警示 GENERAL SAFETY INSTRUCTION

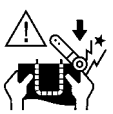
有關於縫紉機，自動化機構，以及其他輔助設備（以下統稱為機器），在工作中無可避免會接近機器移動區域，也就有伴隨著潛在風險。因此，我們強烈要求操作者，維修技師一定要先仔細閱讀並瞭解本操作手冊的內容。
安全指示係包含了某些未載於規格書上的加裝配件。
現場管理者有責任要求所有操作者要閱讀並瞭解機器的操作與注意事項。
未能確實遵守本手冊所記載的事項，將可能導致機器的損害，或是人員的傷亡。

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 injure or even death.

警告標示說明

Explanation of warning indications and labels.

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

標告標示說明 WARNING LABELS		標告標示說明 WARNING LABELS	
	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.		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.
	有電，危險。 A risk of electric shock. Stay away and keep clear.		小心被機械捲件受傷！ There is a risk of entanglement in the belt resulting in injury.
	高溫度區！危險，勿靠近。 A risk of burn from the high temperature area. Stay away and keep clear.		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.
	強光！勿直視，以避免眼睛受傷。 Avoid direct eye contact with the laser beam or other light source.	一般安全標示 GENERAL SAFETY INDICATIONS	
	小心頭部撞擊！ A risk of injury to head from upper contact. Apply proper protection (helmet) and keep clear.		機器運行方向 The correct direction is indicated.
			電氣接地位置標示 Grounding connection as indicated.

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有移動，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) 為了避免機器突然起動造成意外，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 pacer, 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 is 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

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) 所有接頭都必需要確實固定。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

PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

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，檢查所有螺絲是否銷固。

(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.

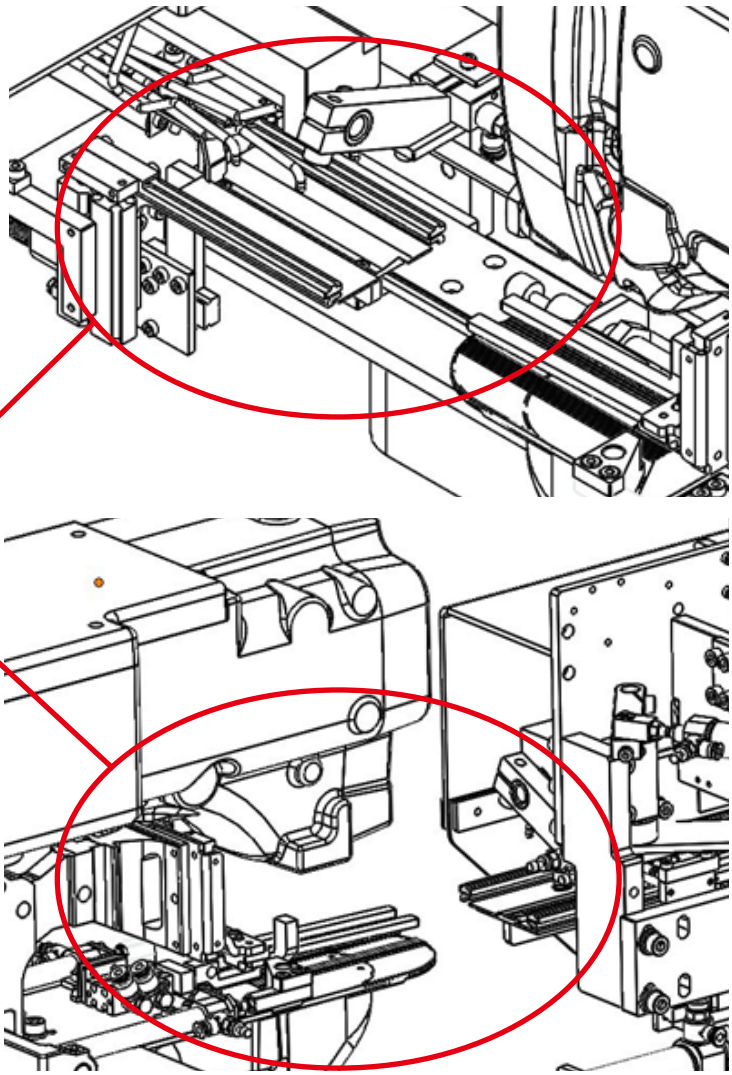
(9) For disposal of packages, lubricant, and product, please follow the applicable regulations set by local administration.

SAFETY INSTRUCTION FOR EBJ SERIES

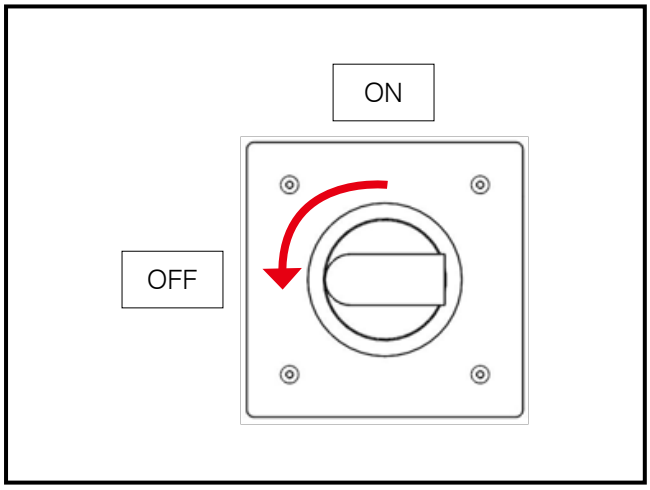
Parts moving area

Always keep the moving area clean and free from any object.

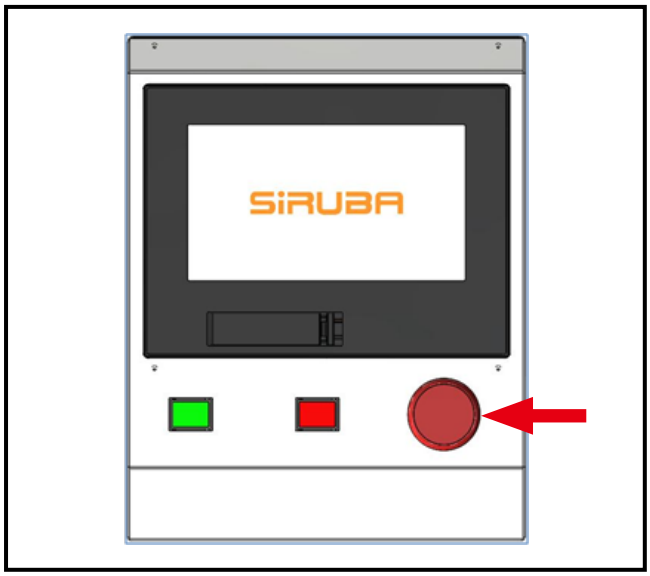
Area with moving parts



Power Switch
Always turn off the power when:
1. Performing service.
2. When the machine is left unattended between works.

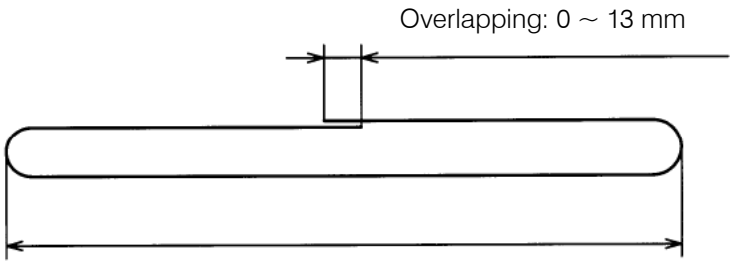


EMG Stop
When there is an emergency, press EMG Stop to stop the machine.
It is strongly advised to press EMG Stop before turning off the power.
Resume to work by turning on the power and release EMG Stop.
This is a precaution to insure the operator is paying enough attention to operation.



CONTENT PAGE

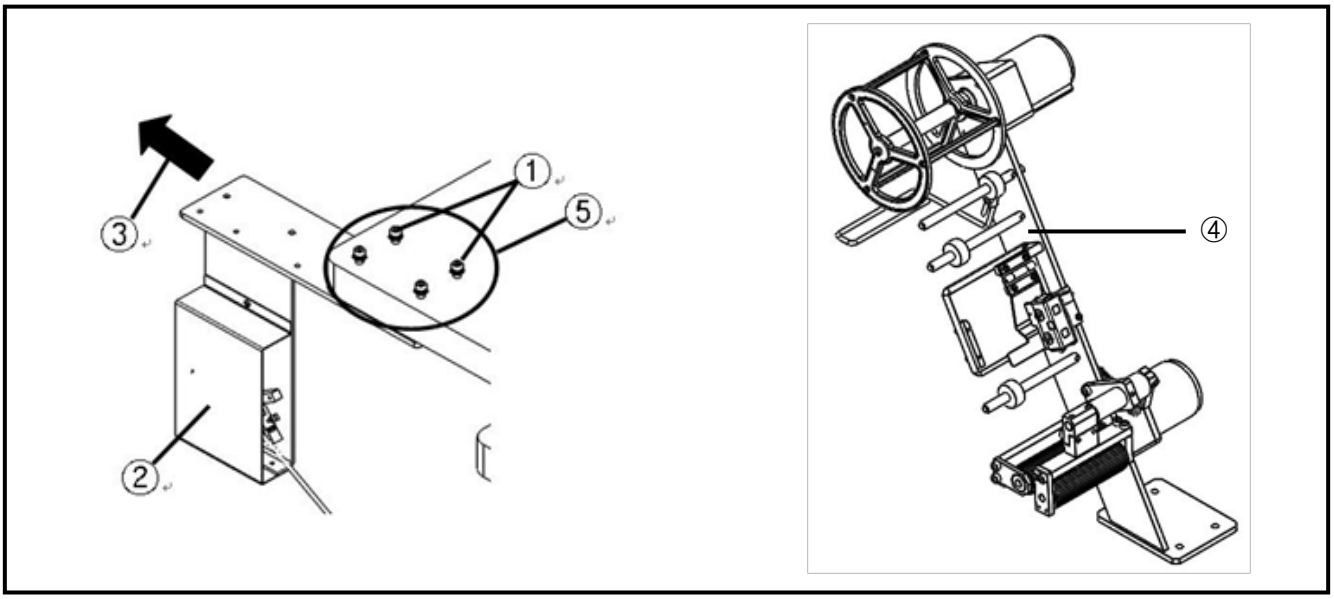
SPECIFICATION

Model	ASP-EBJ150
Type of Needle	DP x 5 # 14
Sewing Speed	2500 rpm (max)
Output Capacity	Varies per stitches i.e. thread patter 190 stitches : 8 sec/cycle
Band Width	20 ~ 50 mm
Power	Single Phase 1Φ AC200~240V 50/60Hz
Pneumatic	0.5 Mpa
Air Consumption	30 L/min
Sewing Size	 Folded length : 150 ~ 990 mm
Band Folding	Folded length: 150 ~ 990 mm (total length: 300 ~ 1980 mm) Overlapping: 0 ~ 13 mm

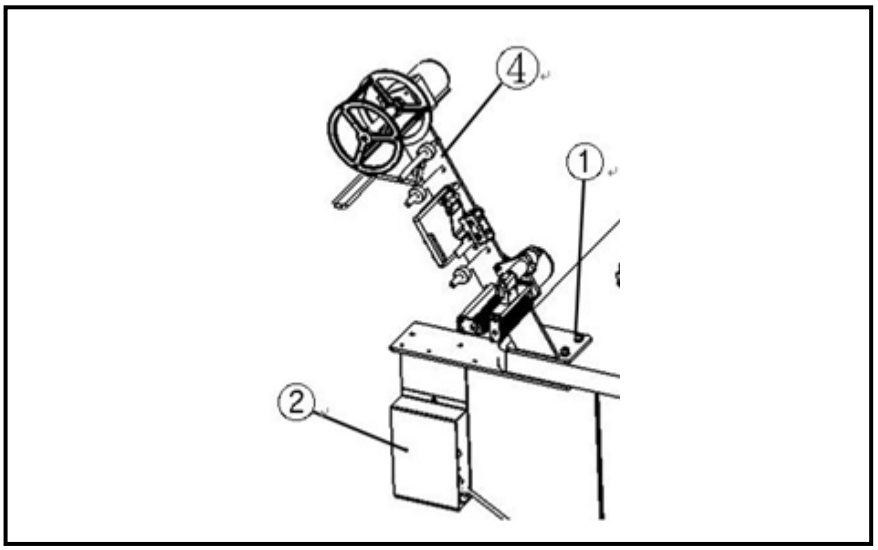
INSTALLATION

※ For safety issue, we strongly advise to have 2 technicians work together to install.

1. Unscrew screws ① , and move the Band Feeding Detector ② outward. (move with caution, do not damage the wire of the detector)
2. Install Band Feeder System ④ onto the table, matching to the position ⑤ .



3. Apply screws to join the Band Feeder System ④ and Band Feeding Detector ② .
4. Connect all plugs and make sure they are secured.

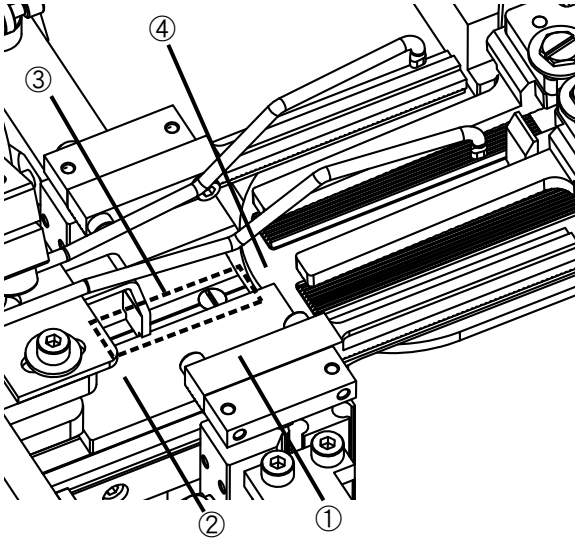


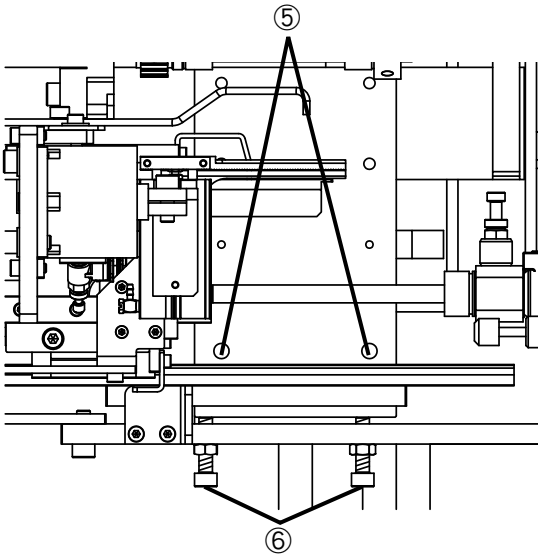
5. Before connecting the power and air, press the band clamper to avoid bumping into other parts ① .
6. Push the feeding plate ② toward the sewing machine until the surface ③ is even with the needle plate ④ . When ③ is lower than ④ (more than 0.3mm), or ③ is higher than ④ (more than 0.5mm), loosen the screw ⑤ , and adjust screw ⑥ for the proper height.

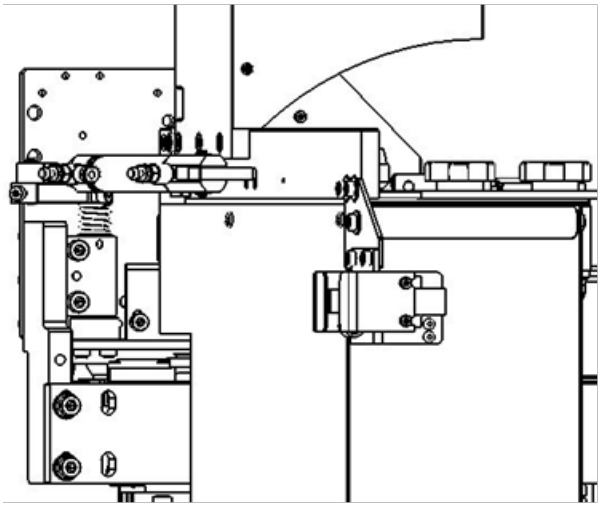
6. Pneumatic:
   Set the air pressure at 0.5Mpa.

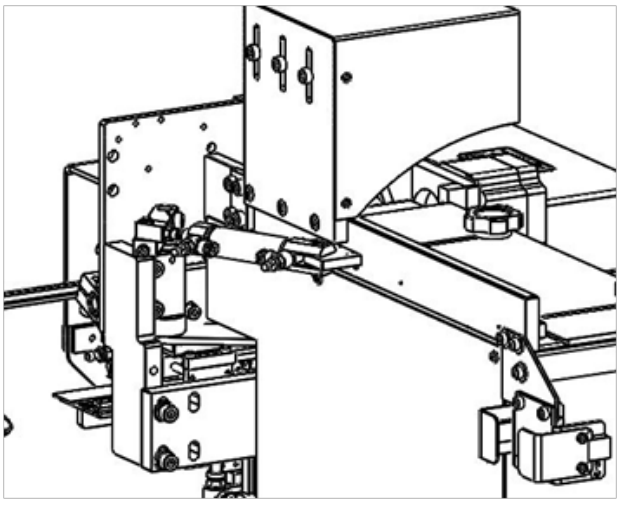
7. Power:
   The power input must be in good quality in less than 10% fluctuation. The grounding must be connected properly.

8. Lubrication:
   (1) For the lubrication of the sewing machine, please refer to the sewing machine manual.
   (2) For the cutter shaft (as shown below), please lightly apply oil regularly.



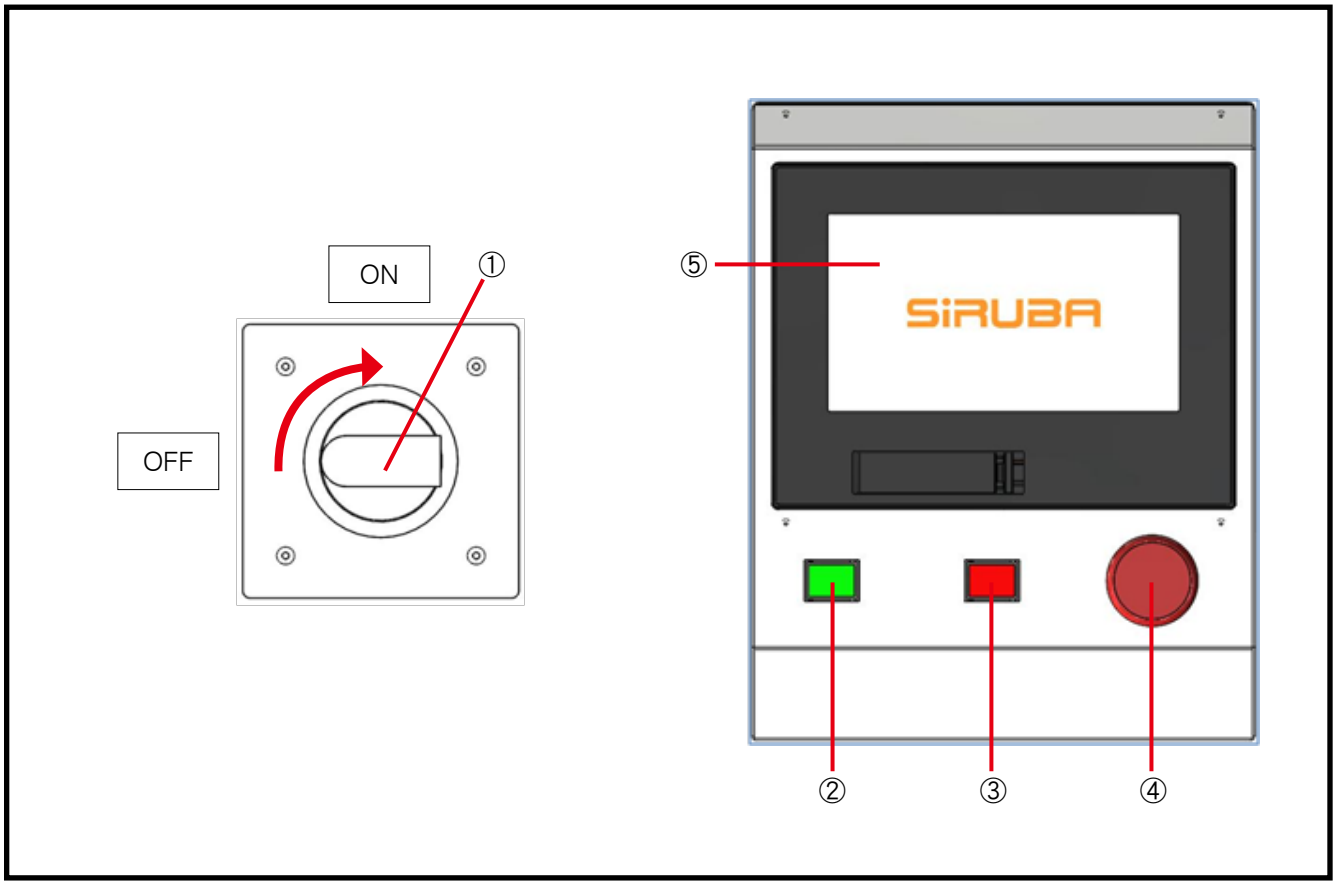






CONTROL PANEL

1. Setting Button



Item	Description
① Main Power Switch	Main power switch (ON/OFF)
② START (green)	1. To activate the machine。 2. To start continuous operation。 3. To start “One cycle only”
③「CYCLE STOP」(red)	1. To stop continuous operation。 2. To make one single band ring。
④「EMG STOP (red)	Press to stop machine immediately. Turn and pull to release.
⑤ Touch Panel	1. To set parameters 2. To set and test I/O.

FEEDING THE BAND

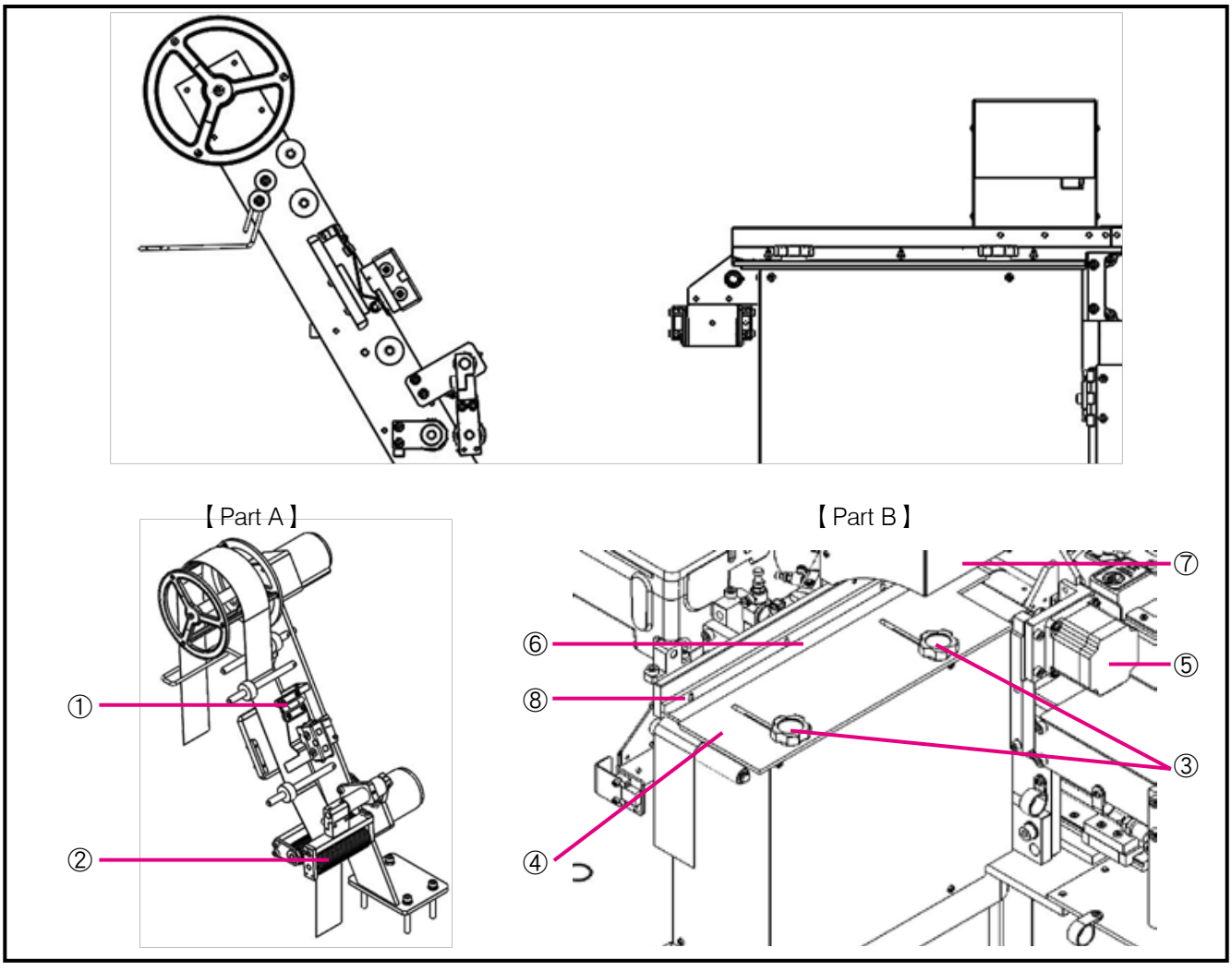
※ Caution: a band with wrinkle or rumple may cause quality issue or even damage to the machine.

Part A.

Open the induce plate ① and supporting roller ② . Insert the band through. (*1)

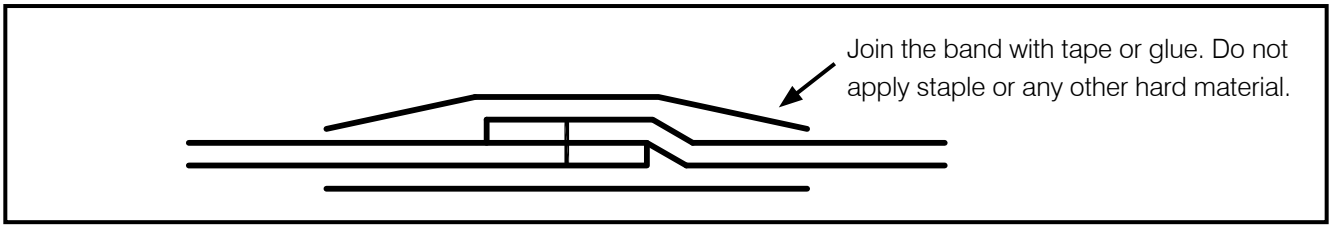
Part B.

1. Insert the band onto the table ④ and through the rail ⑥ , adjust the knobs ③ to set the band width.
2. Release the supporting roller ⑤ to allow the band going into the rollers ⑦ . (*2) Check if the band aligns with the wall ⑧ closely. Then turn on the power. (p.10)



Note: *1: To join bands for feeding, please refer to illustration as below.

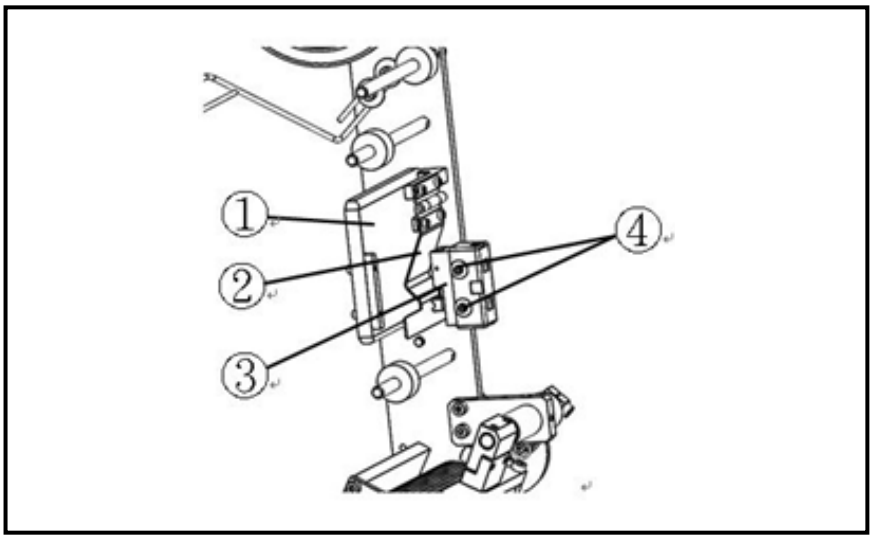
*2: It is good enough as long as the front end of the band is clamped. No need to force in.



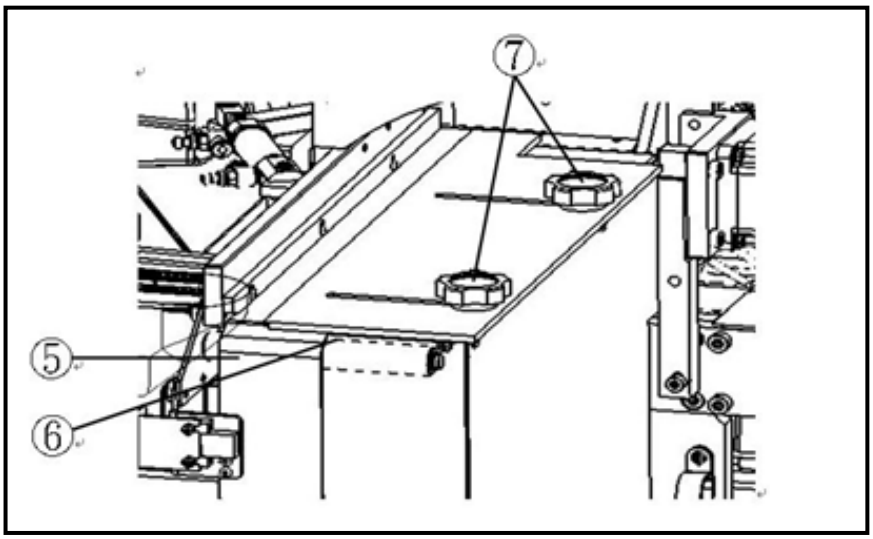
SETTING THE BAND

It is necessary to adjust for the 1st work or when working with bands with different width or thickness.

1. To adjust induce plate sensing range:
   When the band goes through the wall ① and the induce plate ② , you may need to change the limit switch sensing distance accordingly by adjusting the distance between the inducing plate ② and the limit switch ③ . Loosen the screws on the limit switch ④ , move the limit switch to adjust the limit switch active range. (about 2 times of the band thickness)

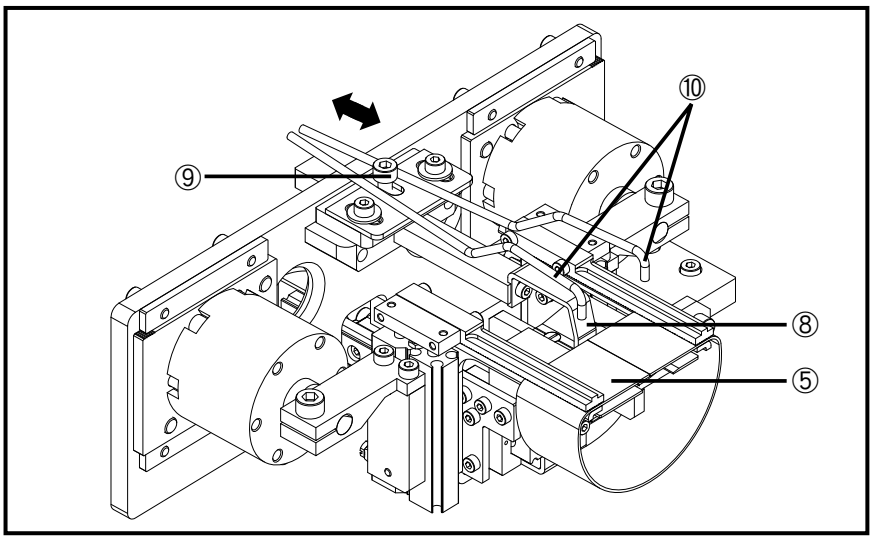


2. To adjust the rail:
   Loosen the 2 knobs ⑦ , the distance should be good enough for the band to go through (1mm wider than the band width). Tighten the knobs ⑦ when finish.



3. To adjust the ready for sewing position
   The edge of the band ⑤ should align with the push pin ⑧ . Loosen the screw ⑨ and adjust the push pin to the edge of the band. Tighten screw ⑨ .

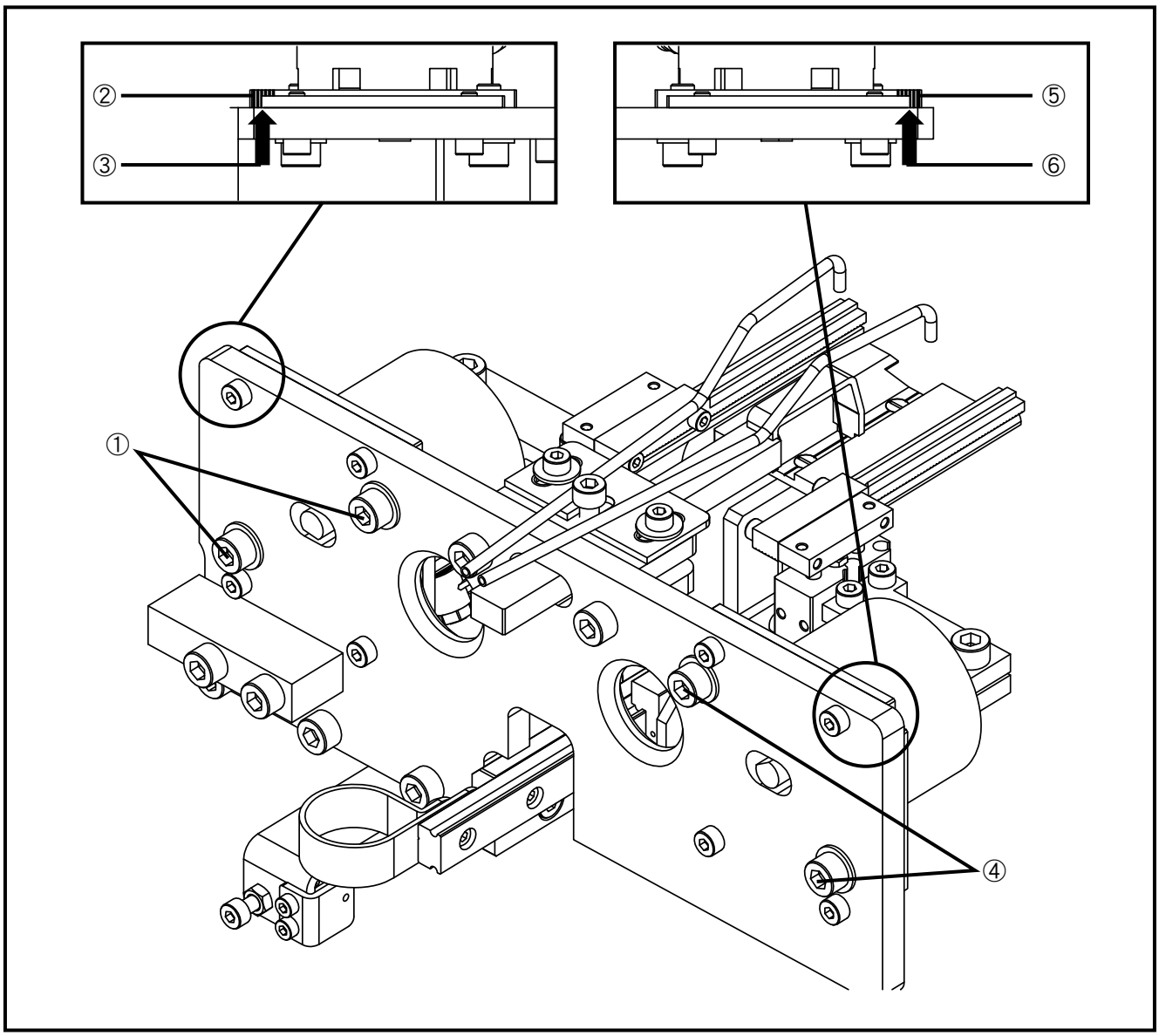
4. If you find the band curling, adjust the direction of air blower ⑩ until the band ⑤ is flat and even.



SETTING THE BUTTED SEAM AND OVERLAPPING AREA

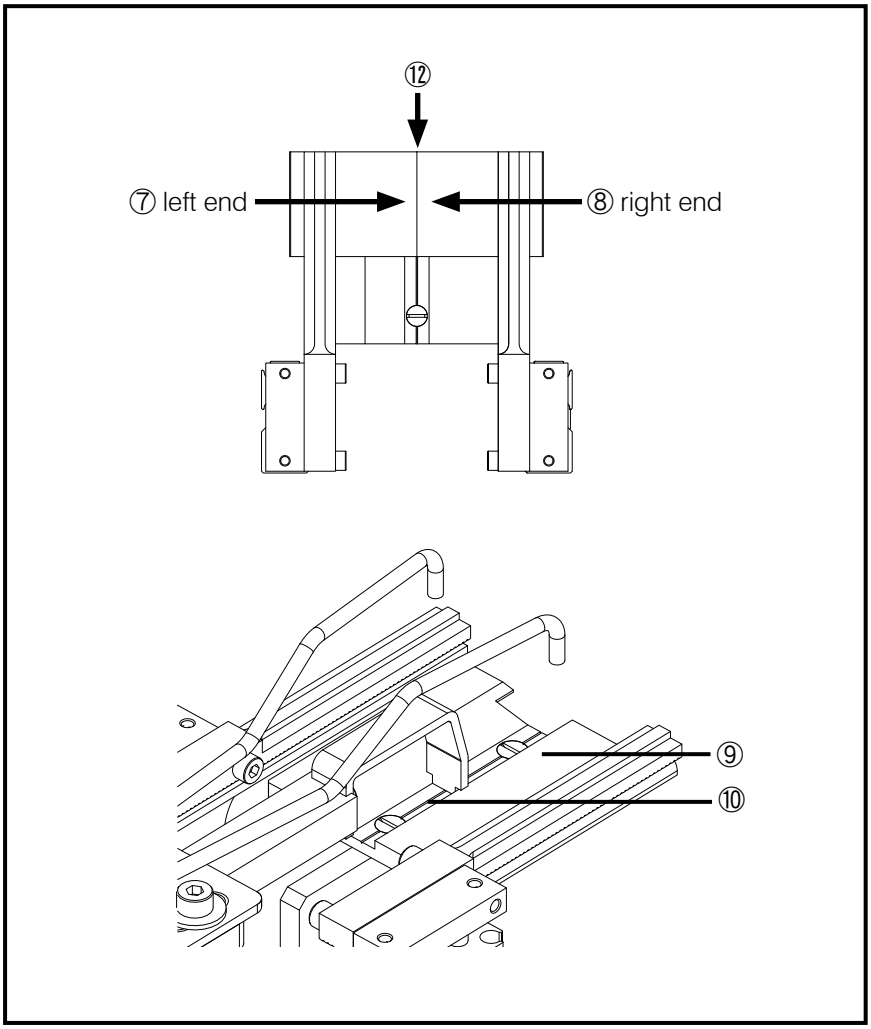
Part 1: Initial Mechanical Setting (Preset done by maker. No need to apply step 1~5 unless a significant overlapping difference, i.e. greater than 11mm).
For general operation setting, simply go to control panel setting (Part 2)

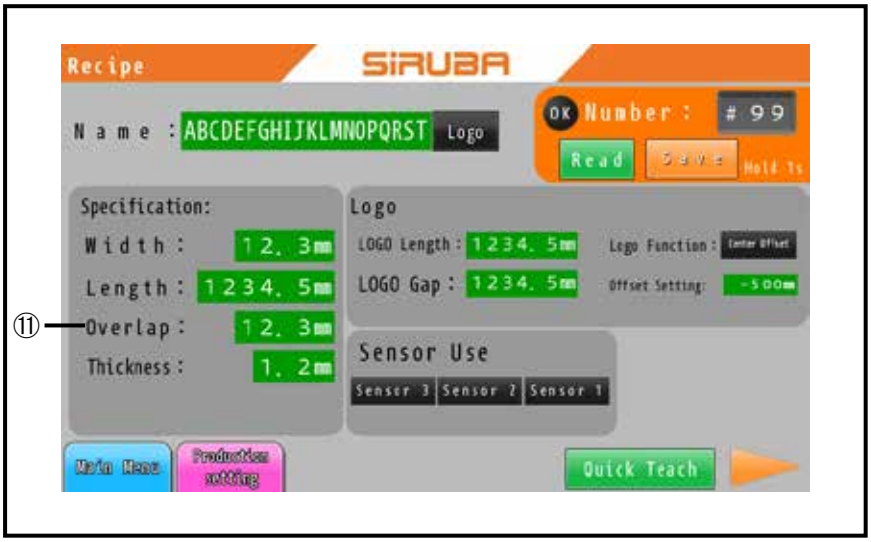
1. Loosen screw ① , move the left cylinder seat ② position to the desired position. (default value set to the 3rd red mark ③).
2. Loosen screw ① , move the right cylinder seat ⑤ position to the desired position. (default value set to the 3rd red mark ⑥).
3. Turn on the machine, and press START.
4. The 2 ends of the band (⑥ / ⑦) should meet at the center red line ⑨ of the feeding plate. If not, repeat step 1 and 2 to adjust accordingly.
5. All the mechanical parts are set and tested in our factory before delivery.



Part 2: Overlapping setting for operation.

6. When band circling is ready for sewing, the band’ s left end ⑦ and right end ⑧ should align with the red line ⑩ on the feeding plate ⑨ .
7. On the control panel, the OVERLAPPING setting ⑪ refers to how the 2 ends of the band join together. In general, the setting value “5” means 2 ends join even at the center red line ⑫ .
8. To increase the overlapping area, increase setting value of OVERLAPPING ⑪ (max 9).
   To decrease the overlapping area or to widen the gap between 2 ends, decrease the value (min 1).

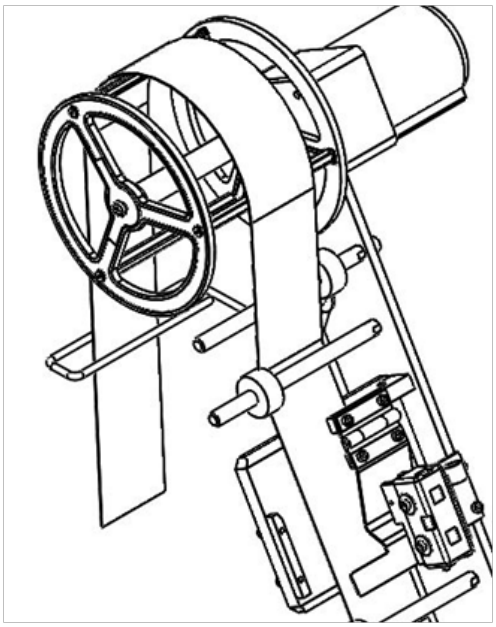




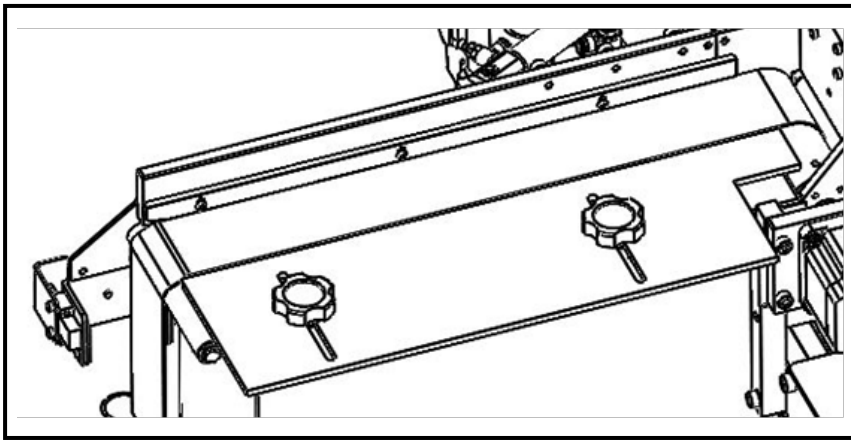
CHANGE A DIFFERENT ELASTIC BAND

When working with bands with different width or thickness, follow the procedures below：

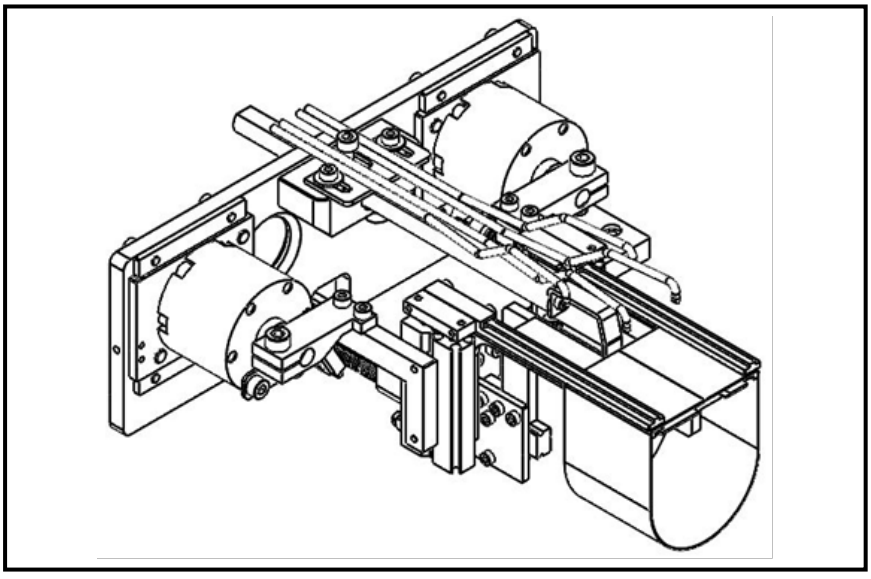
1. Adjust the induce plate：Place the band through the wall ① and induce plate ② . Adjust the limit switch according to the thickness. Loosen screws ④ and move left/right (about 2 times of the band thickness). Adjust the gap between ② and ③ .



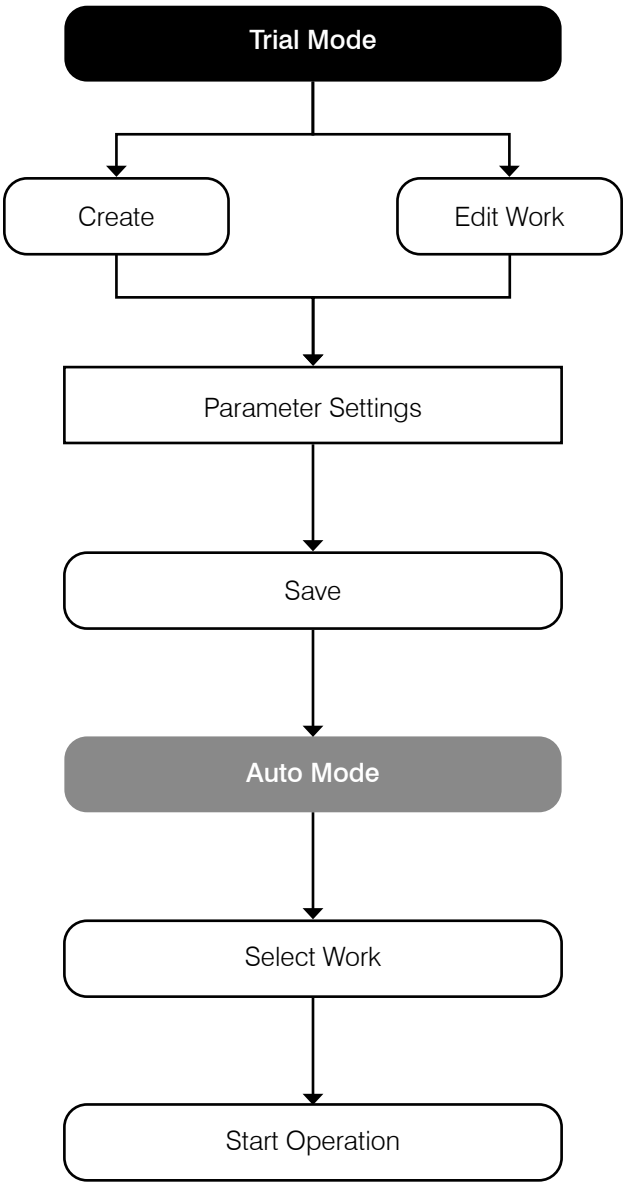
2. Adjust the band width：Loosen the knobs ⑦ , place the band ⑤ on the guide table ⑥ . Adjust the plate accordingly (allow 1mm space for a smooth feeding). Tighten knobs ⑦ .



3. Adjust the band position plate: Release the knobs⑨ and adjust. The edge of band ⑤ should align against the upper of the table rail ⑧ .
4. When there is a band curling, adjust the direction of air blower ⑩ until the band ⑤ is flat.



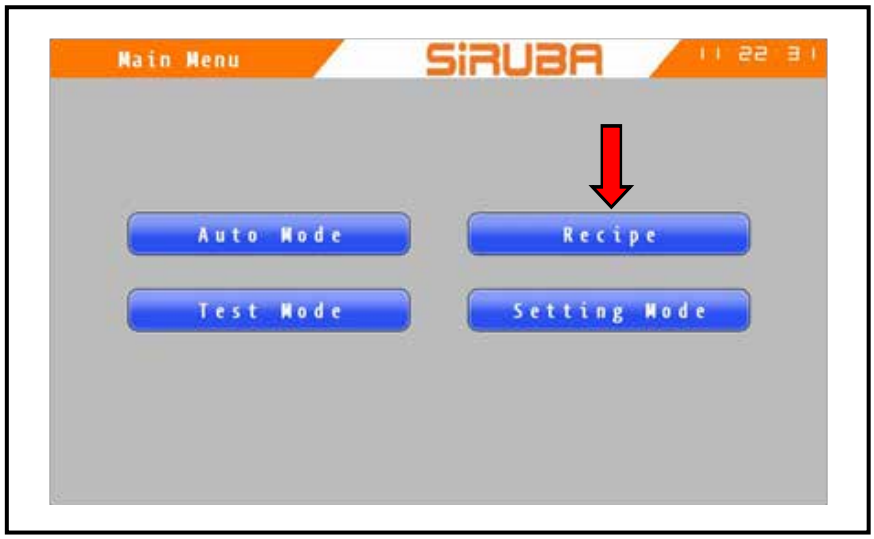
OPERATION FLOW



TRIAL MODE

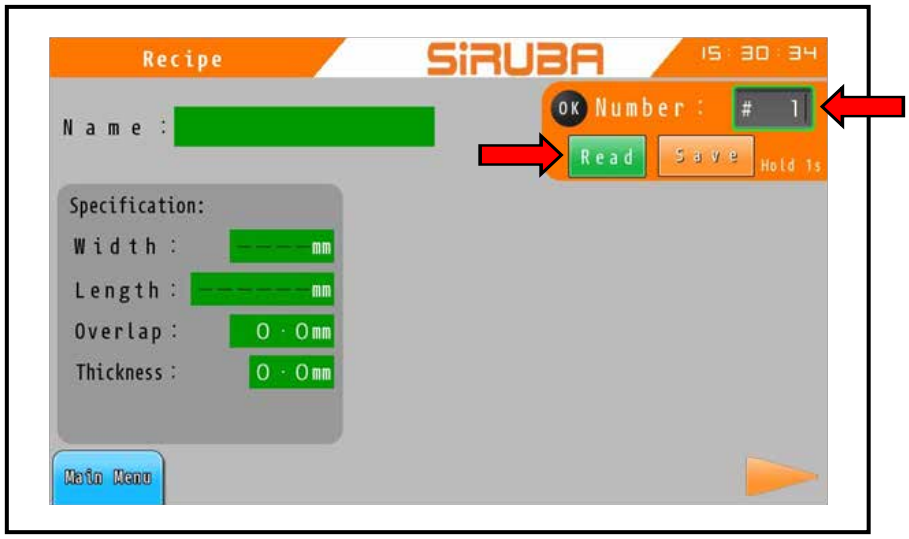
1. Tap the monitor once to enter the Main Menu

2. Click Trial Mode to enter



A. To edit an already existing Work:

1. Press NUMBER #. Input the work #, and press READ to retrieve the work parameters.
2. Follow the procedures in B and C, as shown below, to edit the parameters. Long press SAVE for 2 seconds until the OK is on.
3. Press Main Menu to exit. Go to Auto Mode to check if the parameters are changed accordingly.

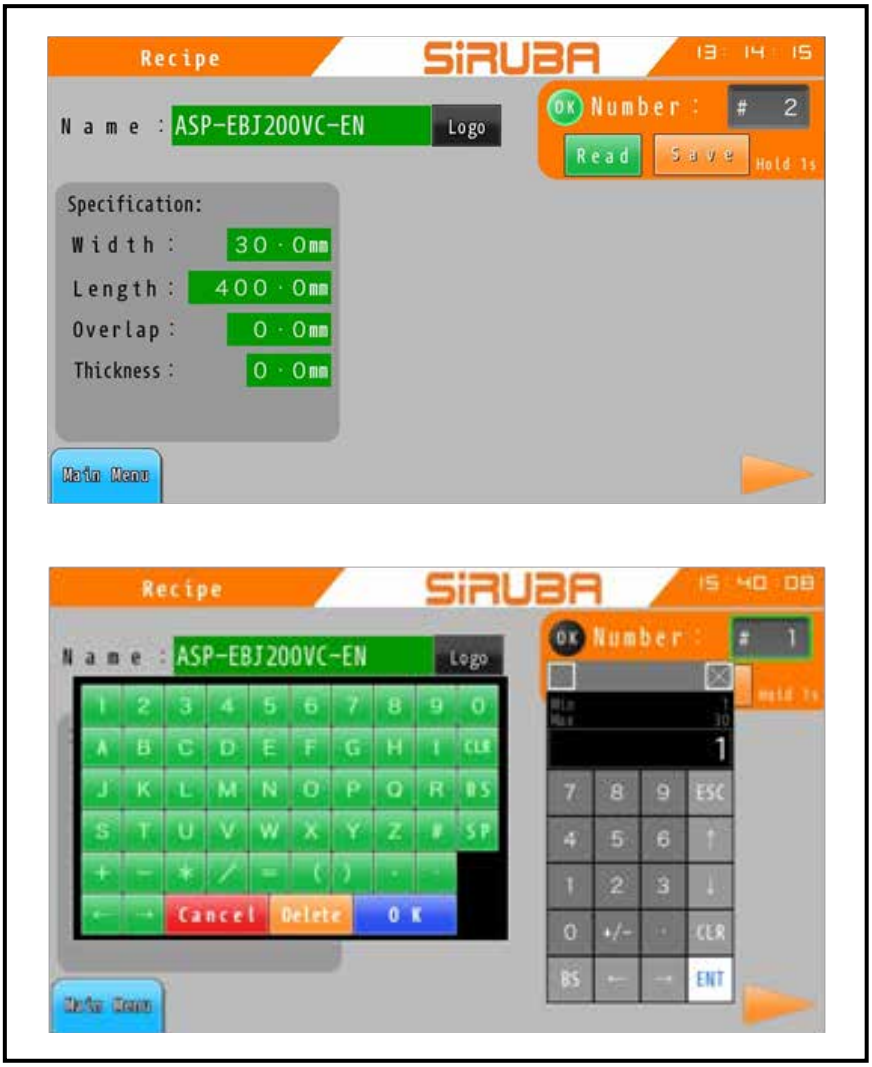


B. To create a new work without Logo Detection Function:

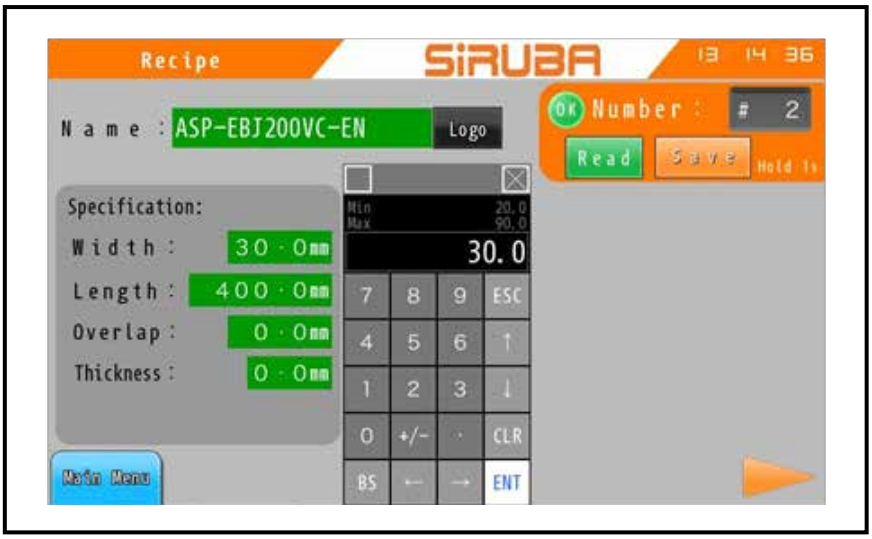
1. Press NAME, input to edit the name of the work.

2. Press LOGO to deactivate the Logo Detection Function (LOGO should be off)

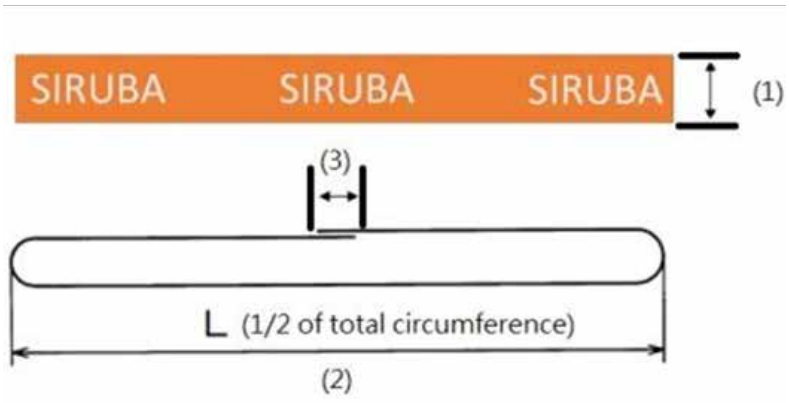
3. Press NUMBER # to edit the number of the work. Do not repeat the number with any existing work saved in the HMI.



4. Press the columns in Specification area. Enter the value accordingly. You may use the meter on the feeding table for a quick reference.
   (1) Width: 20 ~ 50 (for Juki LK1920) ; 20 ~ 90 (for Juki AMS)
   (2) Length: 150 ~ 990 (waistband circumferences 300~1980mm).
   (3) Overlapping: 0 ~ 13 (result may vary due to the band material quality. Please check the final result and modify accordingly if needed.)
   (4) Thickness: input the value of elastic band thickness.



5. Long press SAVE for 2 seconds until the OK is on.
6. Press Main Menu to exit.
7. Go to the Auto Mode and call out the work. Execute a single cycle run to verify the work result. Go back to Trial Mode to edit the parameters if needed.



C. To create a work with Logo Detection function.

1. Press NAME, input to edit the name of the work.

2. Press LOGO to activate the Logo Detection Function (LOGO should be on)

3. Press NUMBER # to edit the number of the work. Do not repeat the number with any existing work saved in the HMI.

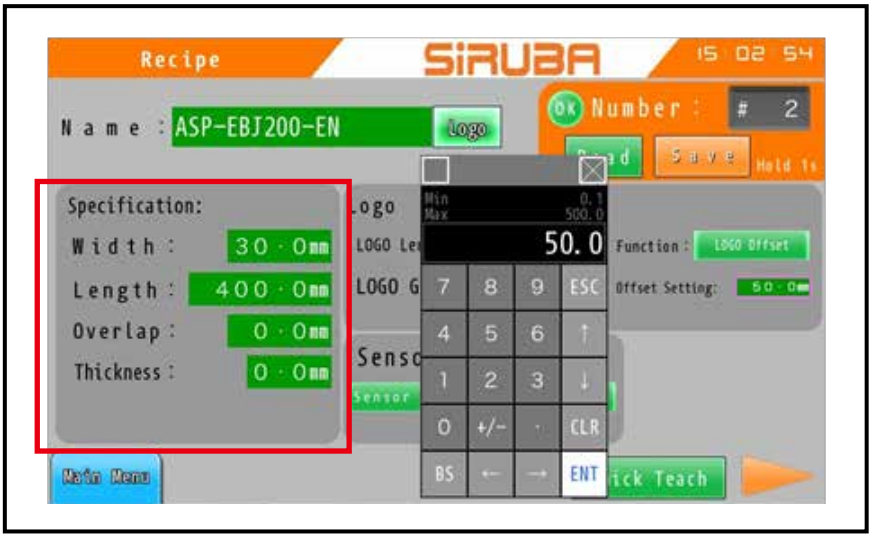
4. Press the columns in Specification area. Enter the values accordingly. You may use the meter on the feeding table for a quick reference.

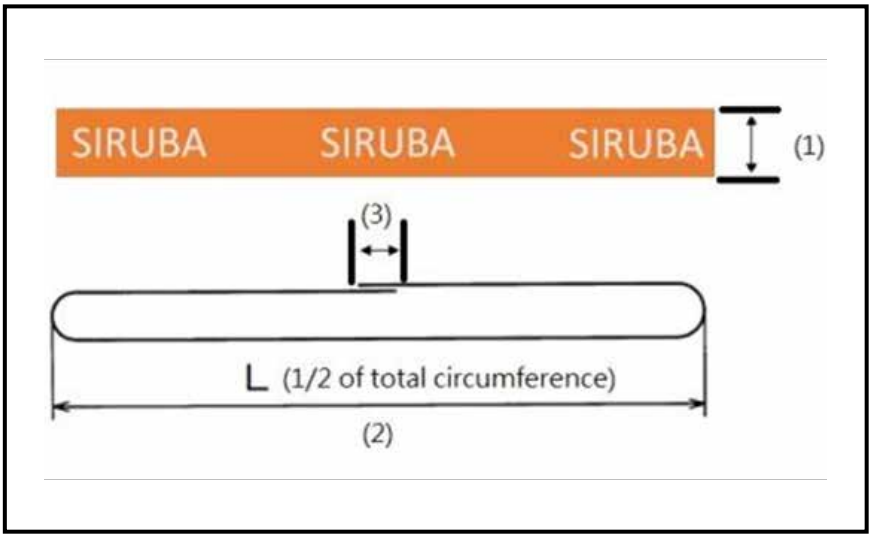
   (1) Width: 20 ~ 50 (for Juki LK1920) ; 20 ~ 90 (for Juki AMS)

   (2) Length: 150 ~ 990 (waistband circumferences 300~1980mm).

   (3) Overlapping: 0 ~ 13 (result may vary due to the band material quality. Please check the final result and modify accordingly if needed.)

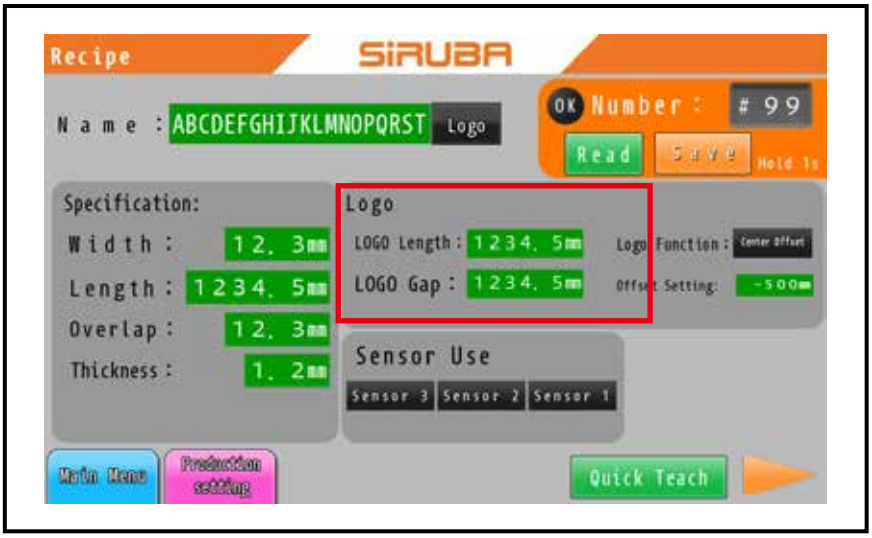
   (4) Thickness: input the value of elastic band thickness.





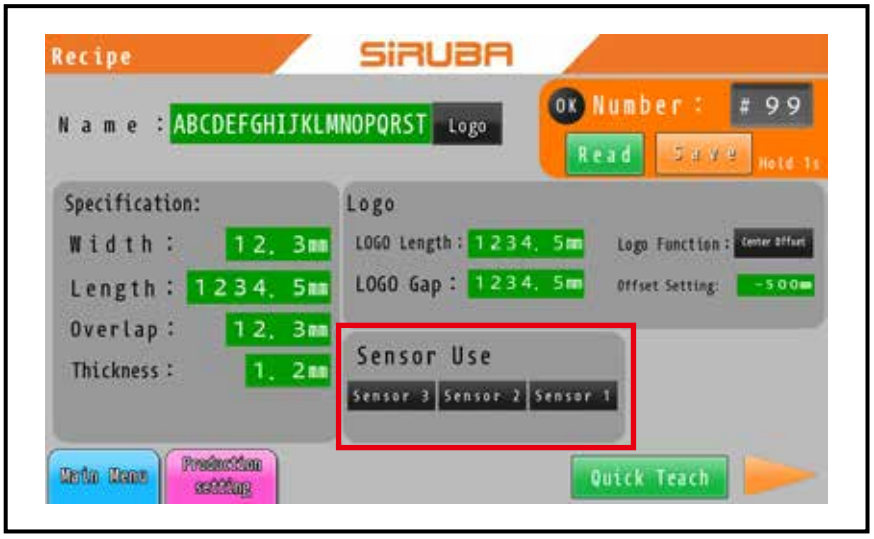
5. Press the columns in Logo area. Enter the values accordingly. You may use the meter on the feeding table for a quick reference.

   (1) Logo Length: the actual length of total logo.
   (2) Logo Gap: the interval between each logo.

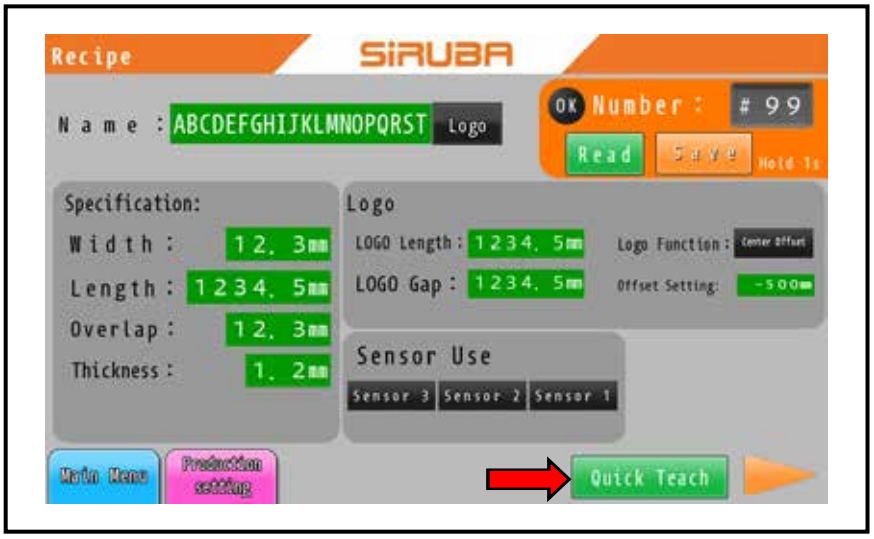


6. Sensor Use:
   All 3 sensors will be activated as default setting. We strongly advise you not to change the default setting.

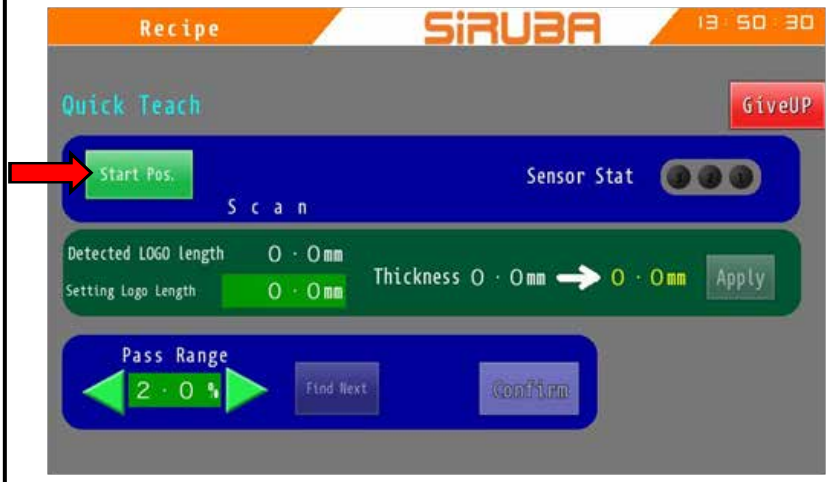
※ In case there is a sensor failure, deactivate the sensor while you are waiting for the service parts arrival. But the 1st sensor (Sensor 1) should always be in good condition.

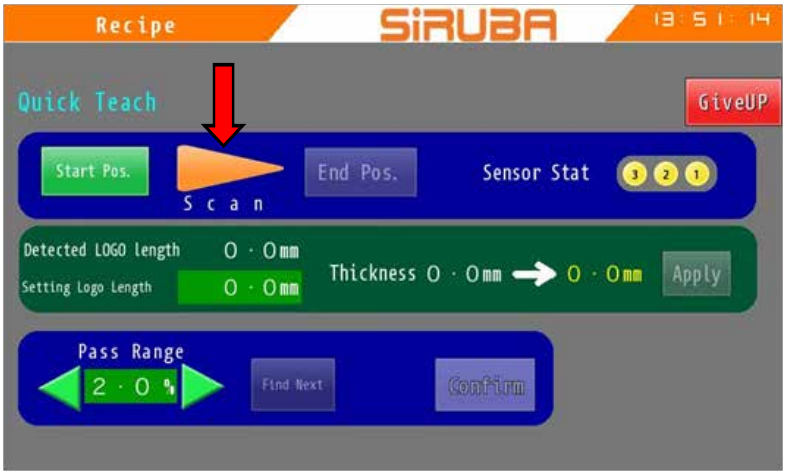


7. Press QUICK TEACH to enter the Logo Scanning process.

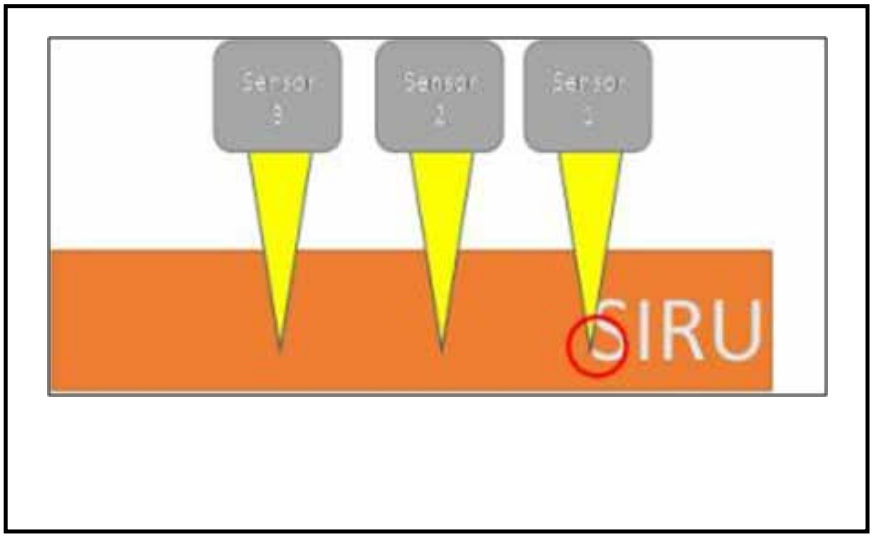


8. Pull the elastic band on the table. Pull when the 1st sensor meets the starting position of the logo, press START POS. Wait until the yellow arrow shows.

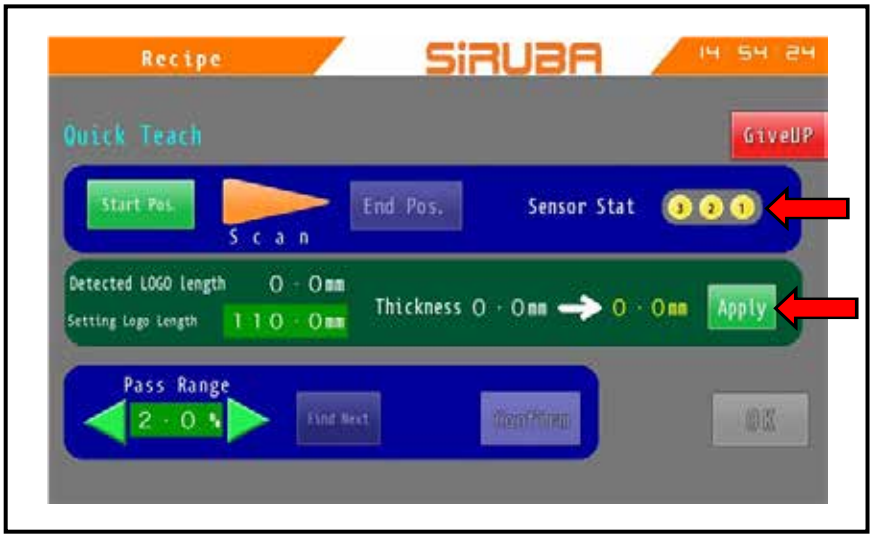




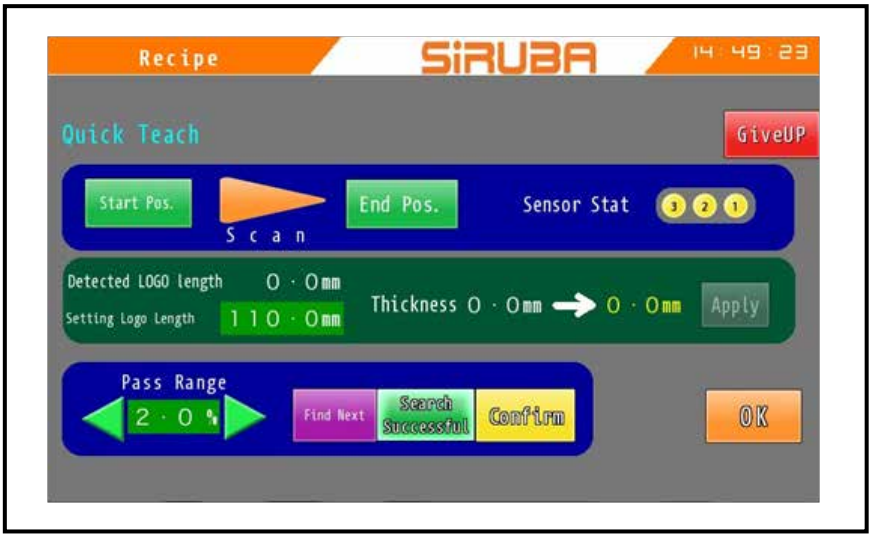
9. When SCAN (yellow arrow) is ON, press SCAN, the motor will start feeding the elastic band forward. Stop and release the SCAN when the finishing position of the logo meet the 1st sensor. Press End Pos to finish the scanning. ◦



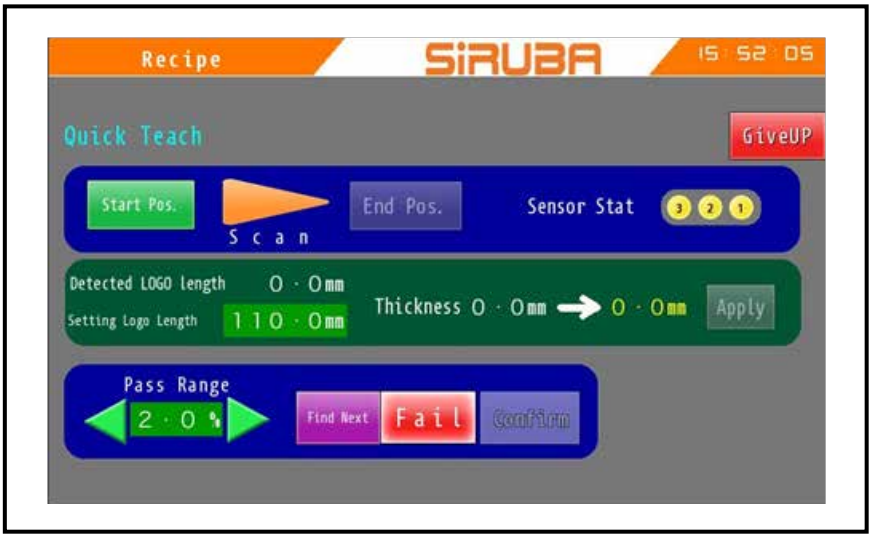
10.If everything is ok, press APPLY. If not, press GIVE UP to restart the logo scanning.



11.After press APPLY, the icon FIND NEXT will appear in the bottom. Press FIND NEXT to see if the elastic band runs to the scanning program.



12.If the sensors cannot detect the logo, the icon FAIL will show. Press FIND NEXT again to see it works. If it shows FAIL again, there should be a difference between the Setting Logo Length and Detected Logo Length, due to the factors of thickness and elastic band quality. Change the PASS RANGE value to see if it works. Or repeat the logo detection process again.

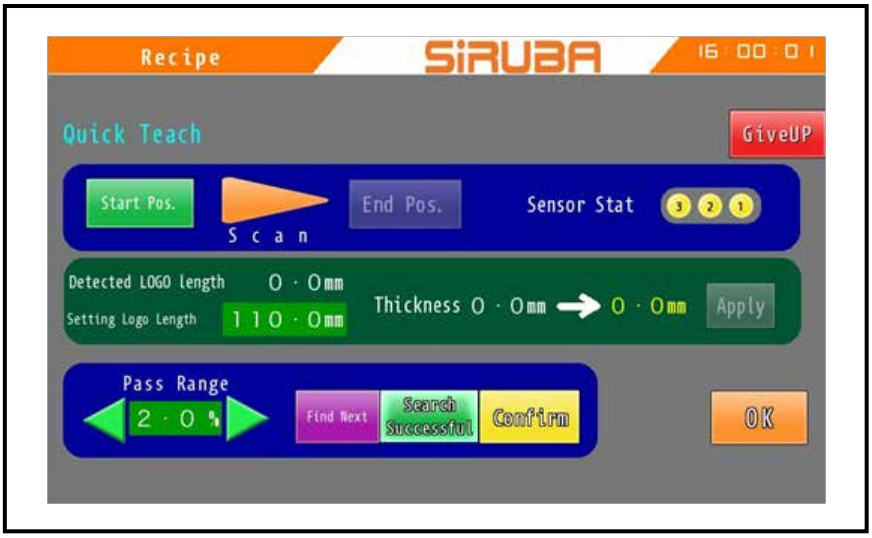


13.If the logo detection functions well, the icon Search Successful and CONFIRM will show. Press CONFIRM to check if the starting position goes to meet the 1st sensor.

14.Long press OK to save and exit.

15.Press Main Menu to exit.

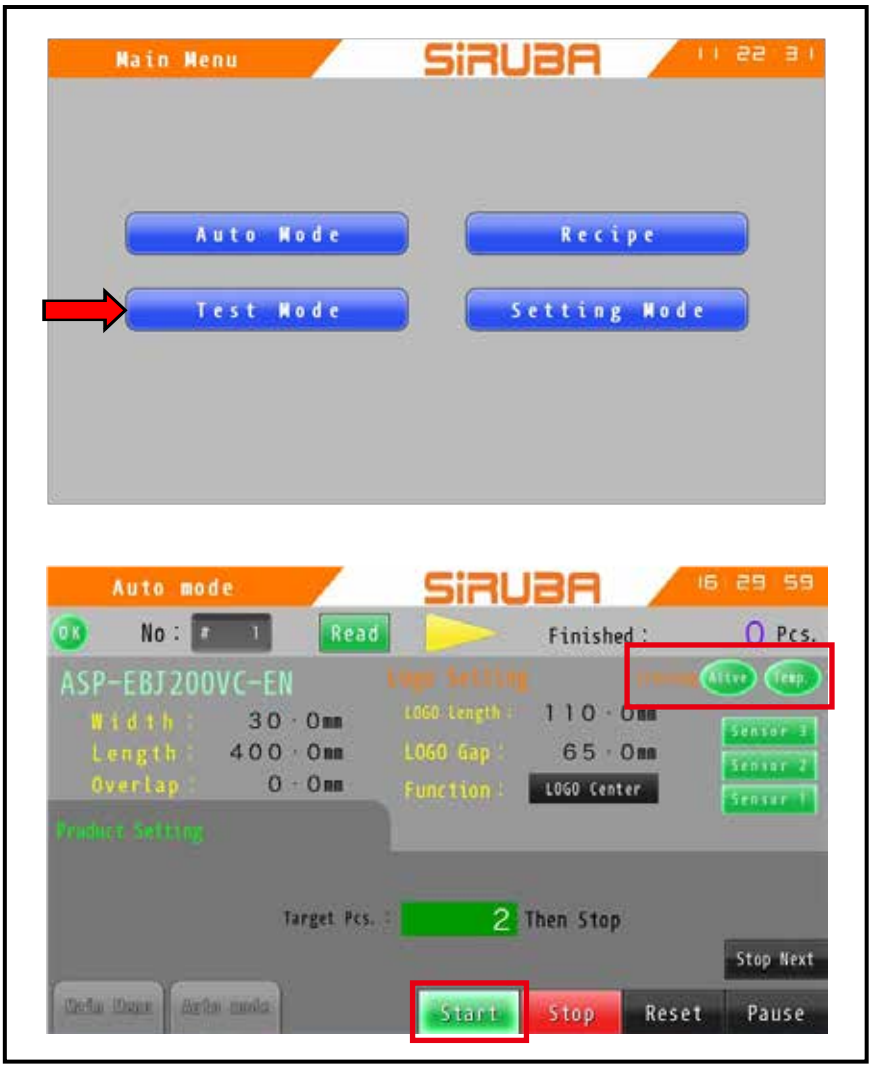
16.Go to the Auto Mode and call out the work. Execute a single cycle run to verify the work result. Go back to Trial Mode to edit the parameters if needed.



AUTO MODE

In Main Menu, press AUTO MODE to enter Auto Mode.

※Status of Siruba Ironing Machine (EBI-100), if there is one. Press START HEATING to activate the heating function when first turn on the machine.



1. Press NO: #. Enter the work # , and press READ to call out the work parameters.

2. Press Target Pcs. Enter the value of target amount.

3. Press START to start operation. The machine will not stop unless the target amount is met or there is an error.

4. To continue the operation from a stop or an interruption, press PAUSE/RESET (if the icon is/are on) to offset. Press RELEASE if there is a band held. Then press START to resume the operation.

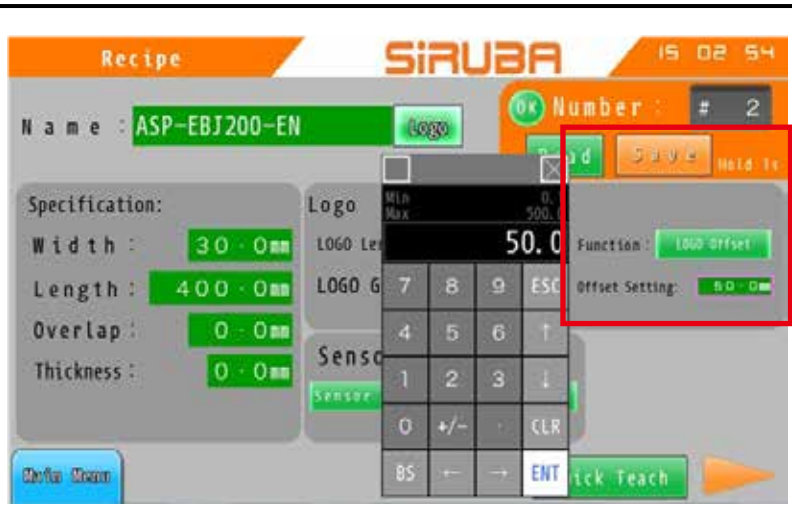
5. After production process, please manually click “Clear the quantity” to clear current quantity.

LOGO OFFSET

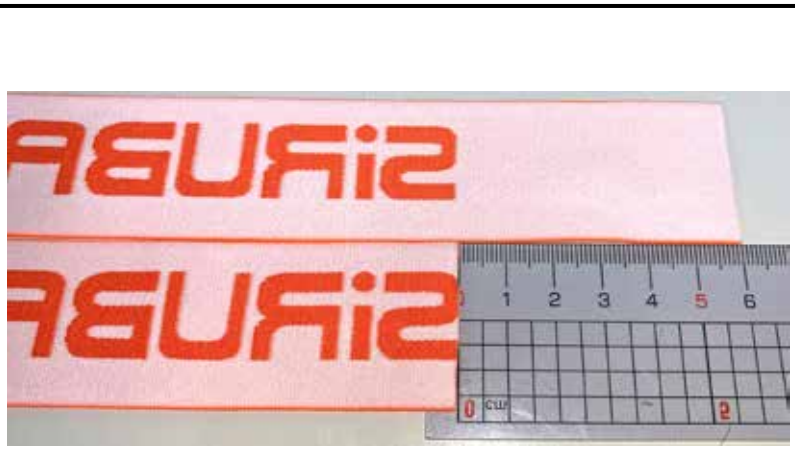
TWO FUNCTIONS ARE AVAILABLE IN LOGO FUNCTION

Click the green block in the Logo Function to select the function (Edge Offset / Center Offset).
Click the green block in the XXX setting to input the setting value.

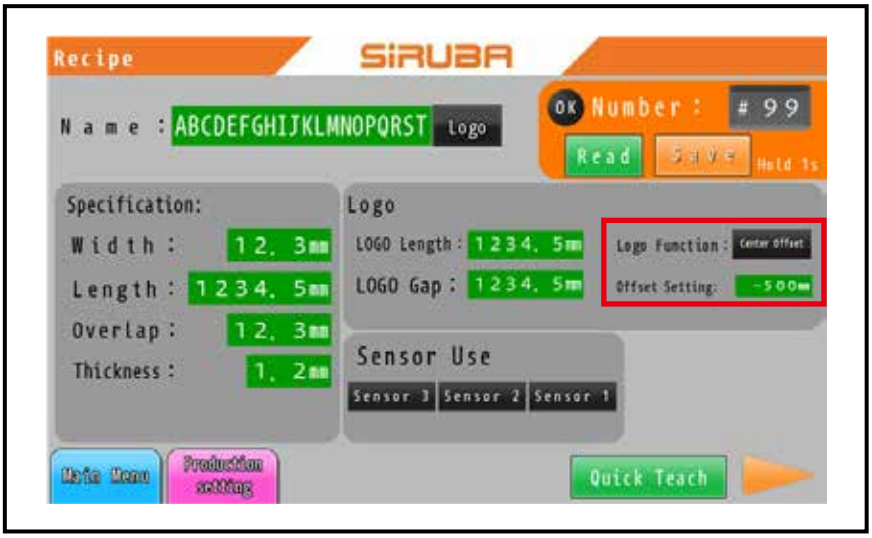
1. Edge Offset
   The off-edge setting range is from 0 to 140 mm.



As photo shown below:
When you set OffSet Setting as “60mm”，the cutting position will be at the distance of 60mm from the LOGO starting point. (Upper one in the below)
When you set OffSet Setting as “0mm”，the cutting position will be at the distance of 0mm from the LOGO, or precisely at the LOGO starting point (Lower on in the below photo)



2. Center Offset
   The off center setting range is from -500 to 140 mm.

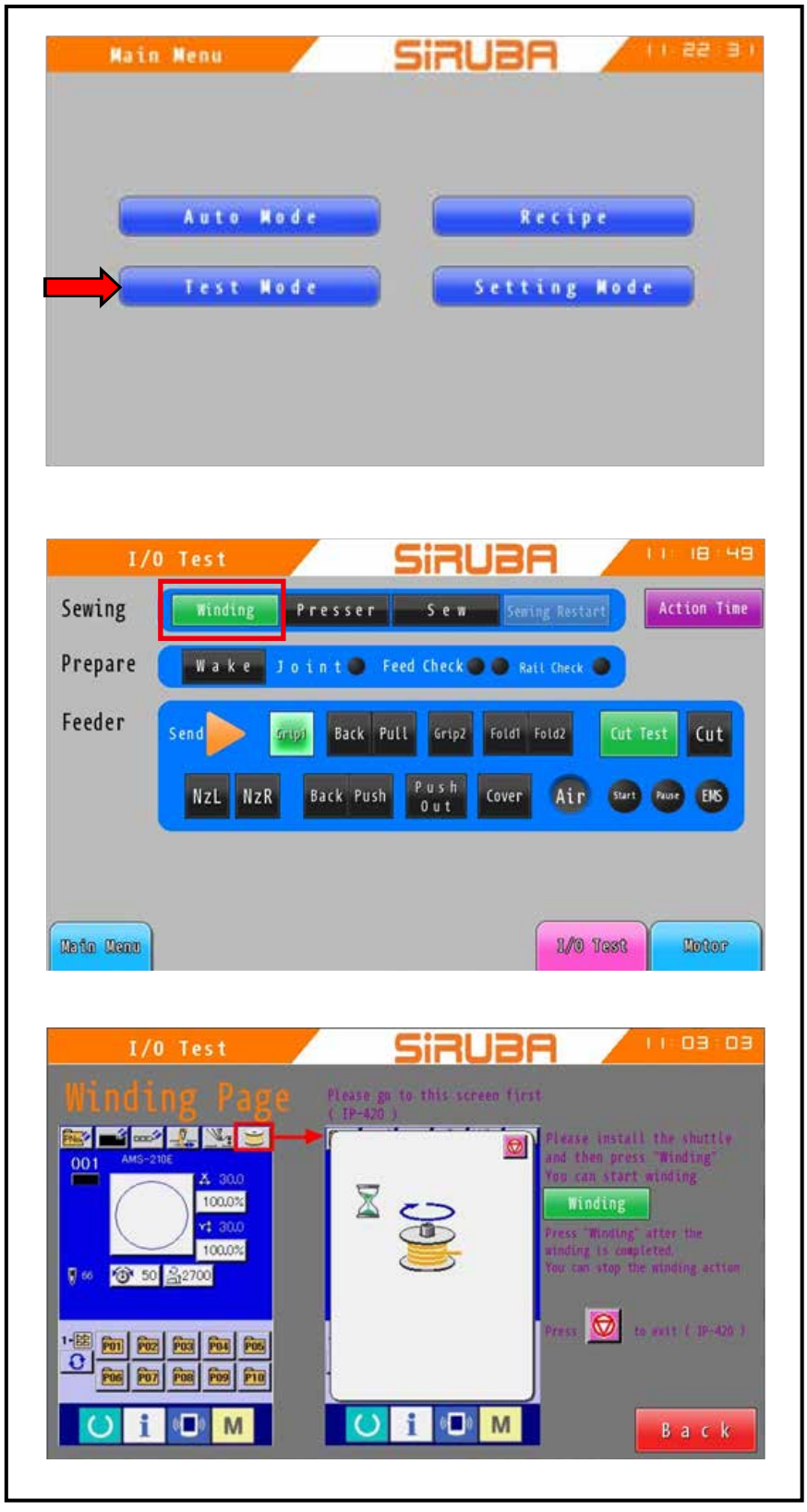


As photo show below:
When Offset Setting is “+50mm”, LOGO will be 50mm to the right from the center point (Upper one in the below photo)
When Offset Setting is “0mm”, LOGO will be at the center point(Lower one)

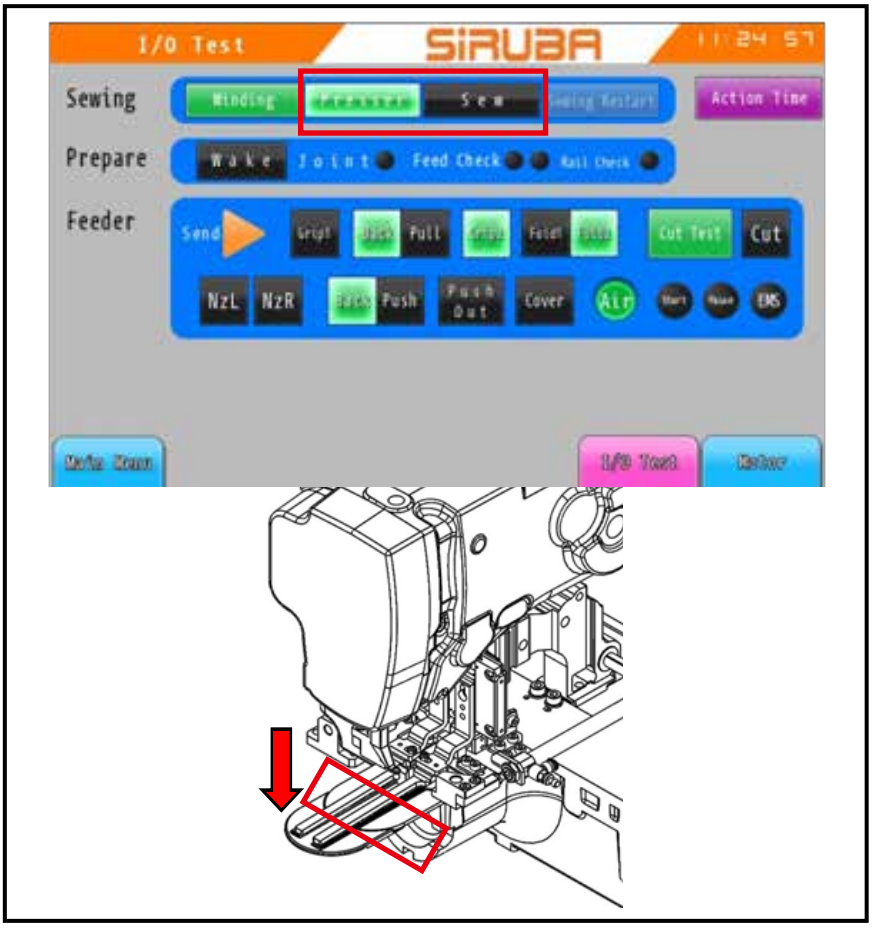
As photo show below:
When Offset Setting is -60mm，LOGO will be 60mm to the left from the center point (Upper one in the below photo)
When Offset Setting is 0mm，LOGO will be at the center (Lower one in the below photo)

TEST MODE

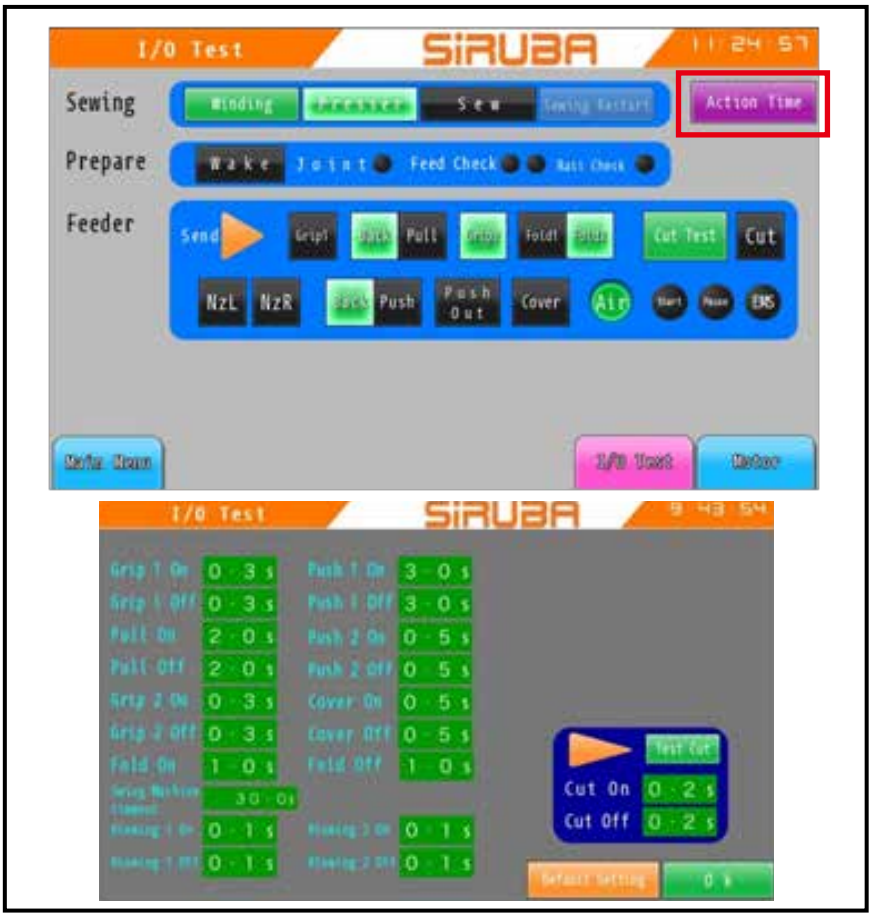
1. Winding
   Press “ Winding “



2. Trial Sewing (Select sewing pattern). Feeding the fabric, press “presser “presser foot down and press “sew “to start sewing.

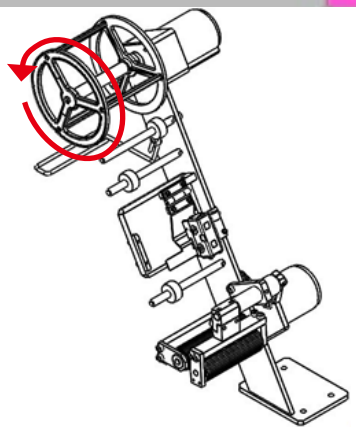


3. Action Time
Air cylinders delay time setting up (Default settings as the picture on the right side.

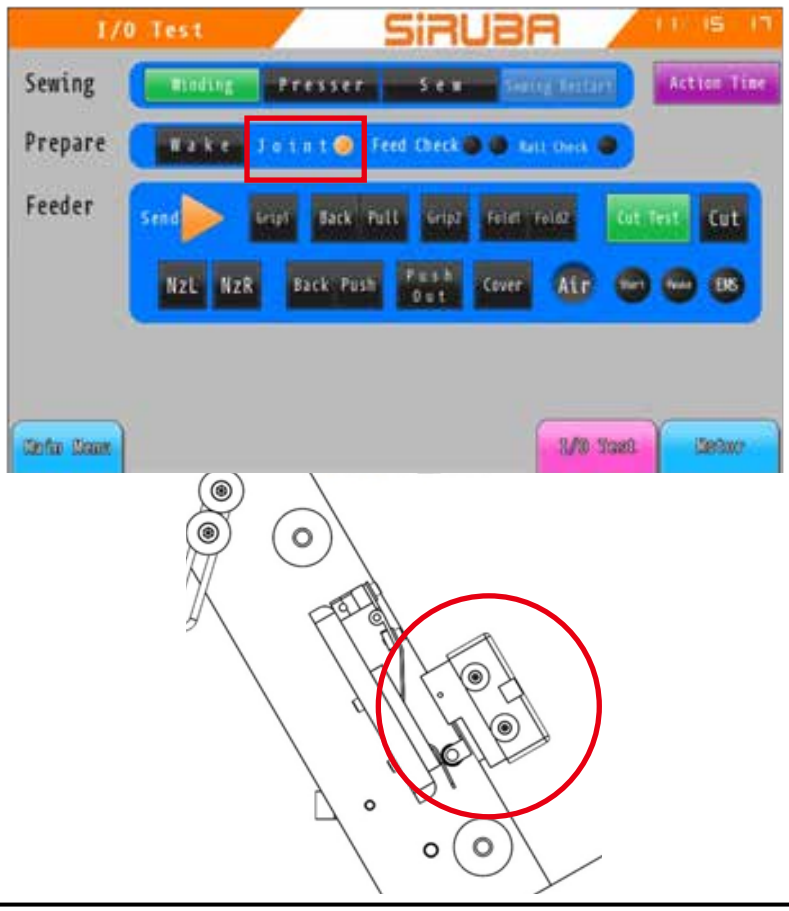


4. Feeding testing

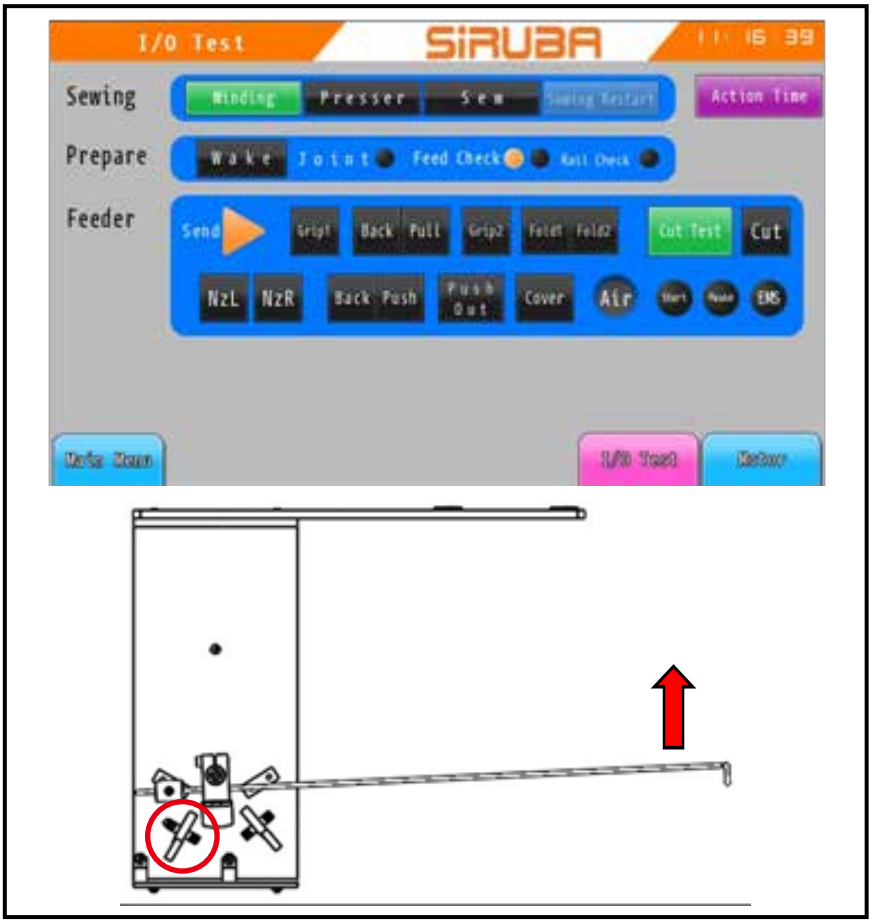
(1) Press “ Wake “ to test the motor of tangling wheel



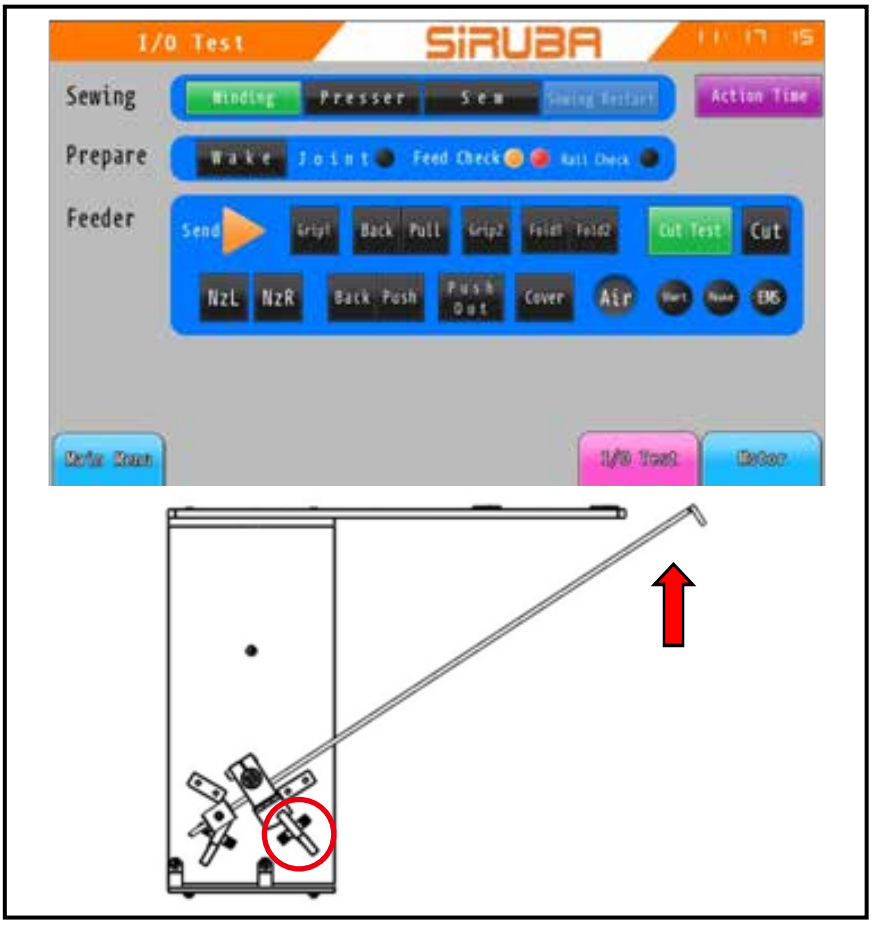
(2) Joint sensor check



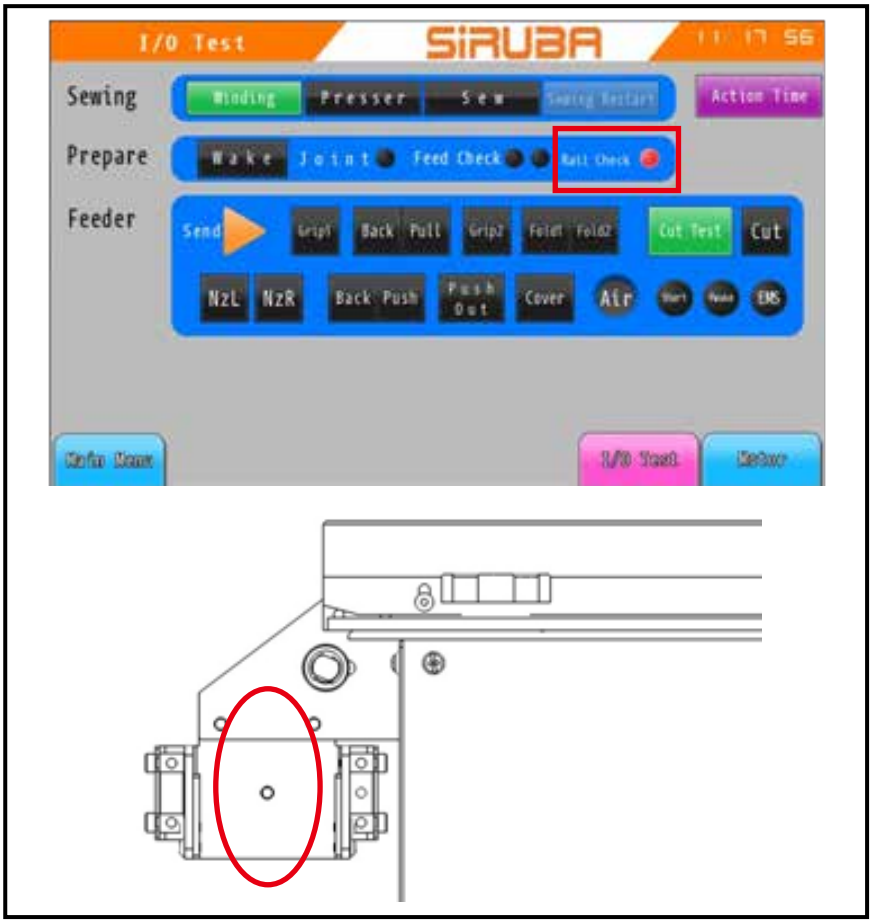
(3) Feed Check Sensor
Sensor 1 off the shutter, the indication light turns “yellow “.



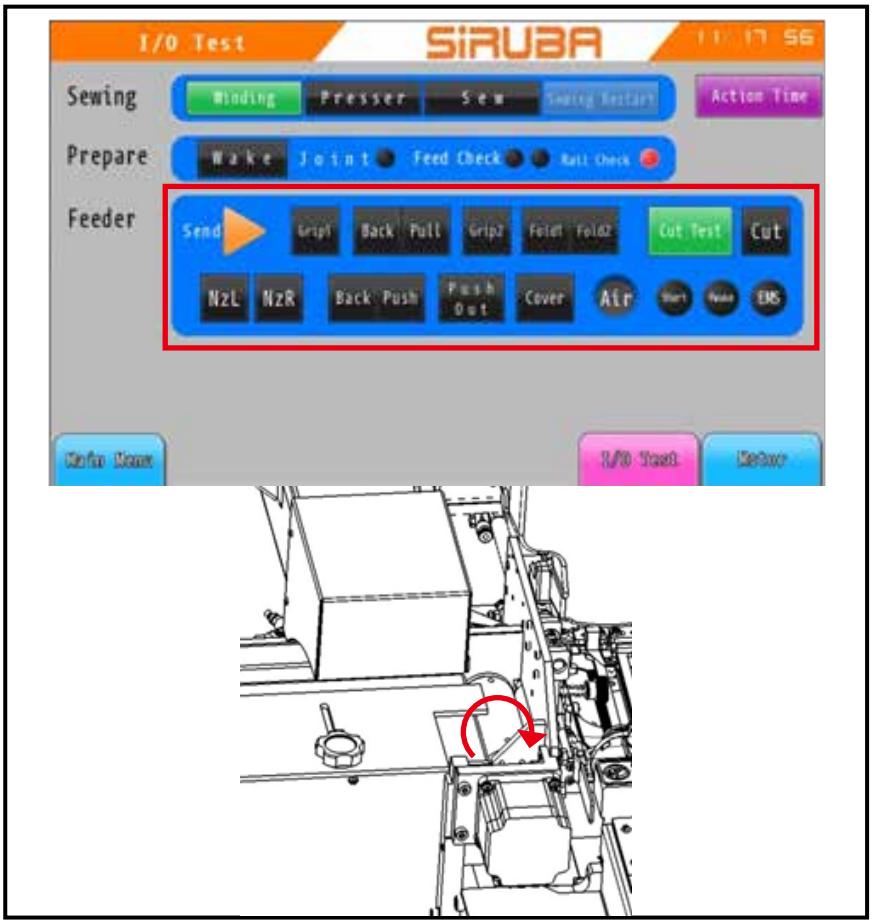
Sensor 2 monitor shutter, the indication light turns “red “.



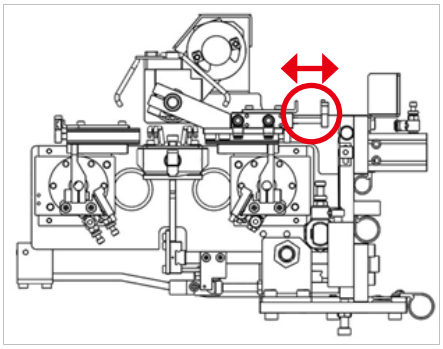
(4) Rail Check
Without fabrics, through bean sensor light on



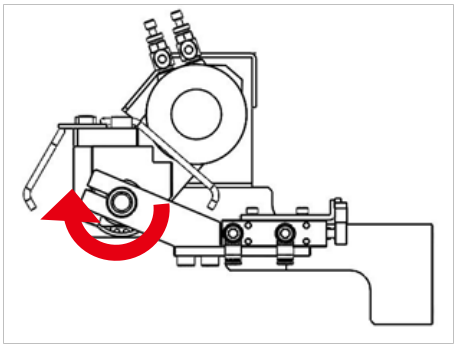
5. Feeder
(1) Feeding motor testing



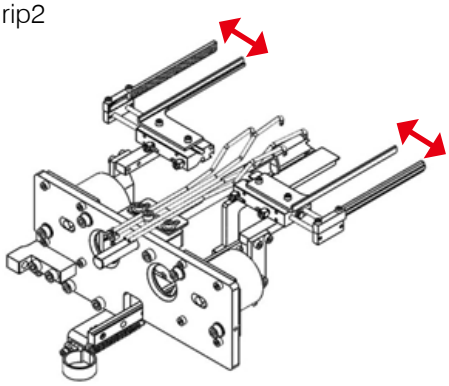
(2) Grip 1



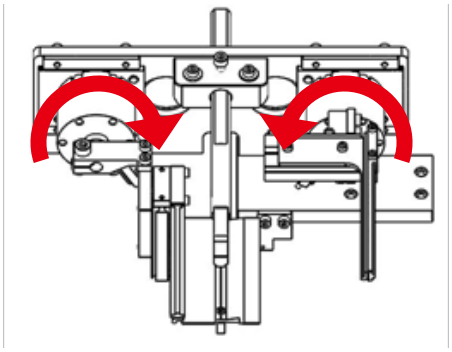
(3) PULL



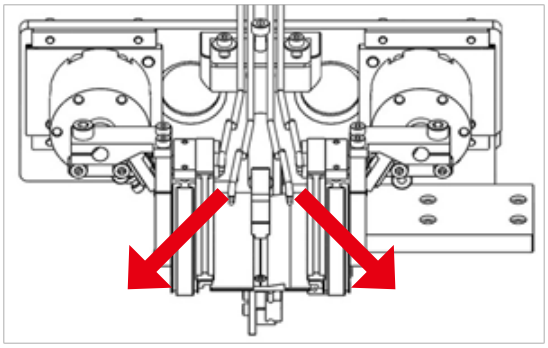
(4) Grip2



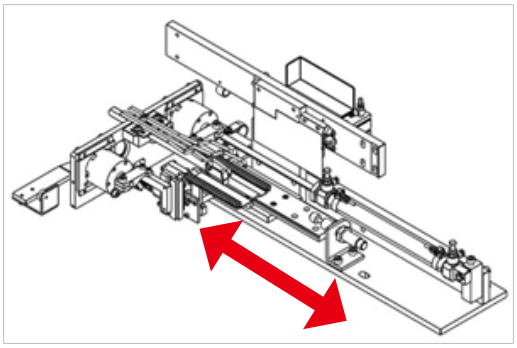
(5) Fold 2



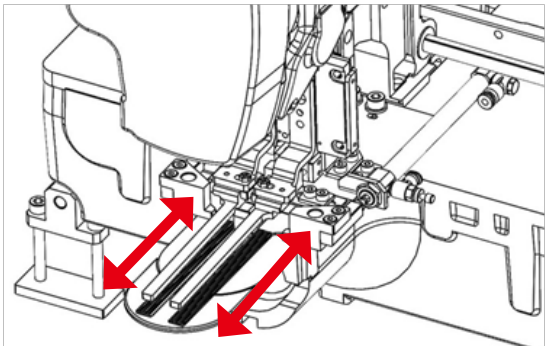
(6) NzL & NzR



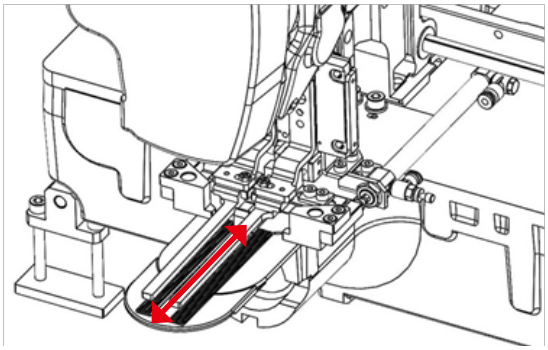
(7) Push



(8) Push Out

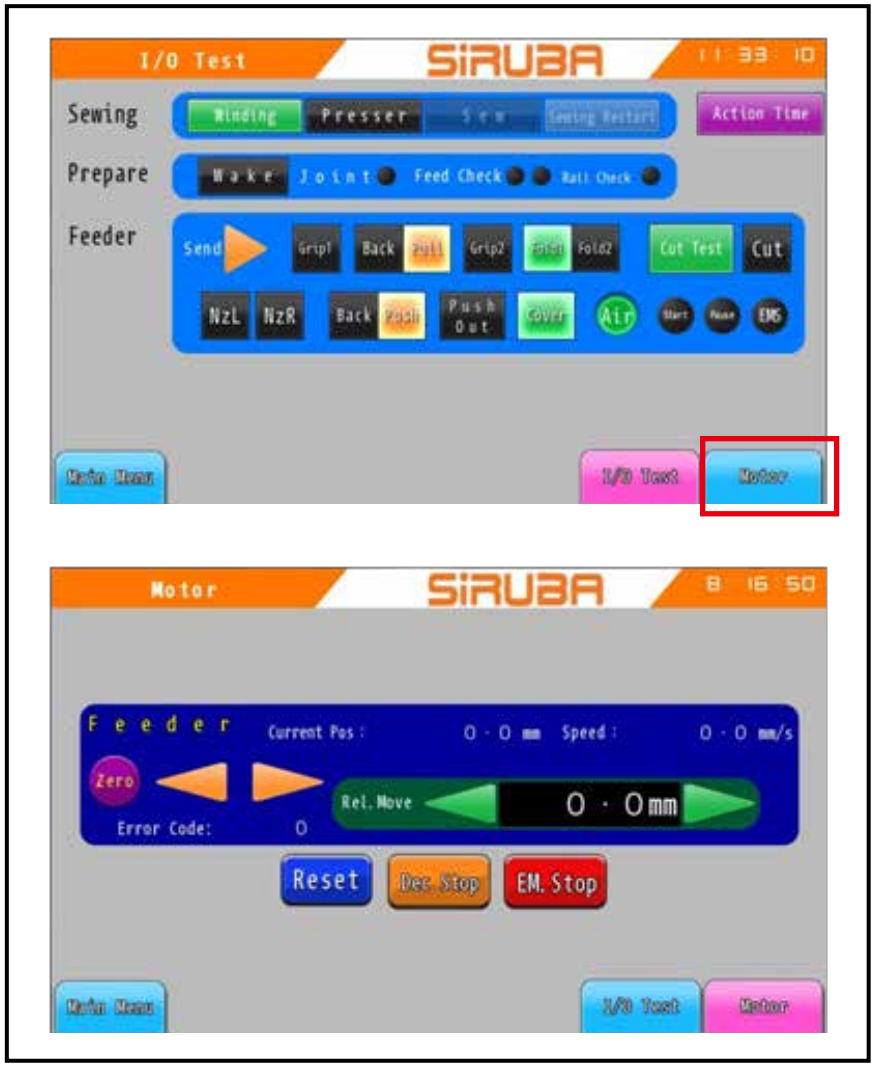


(9) Cover



6. Motor

Press “motor “– single action mode.

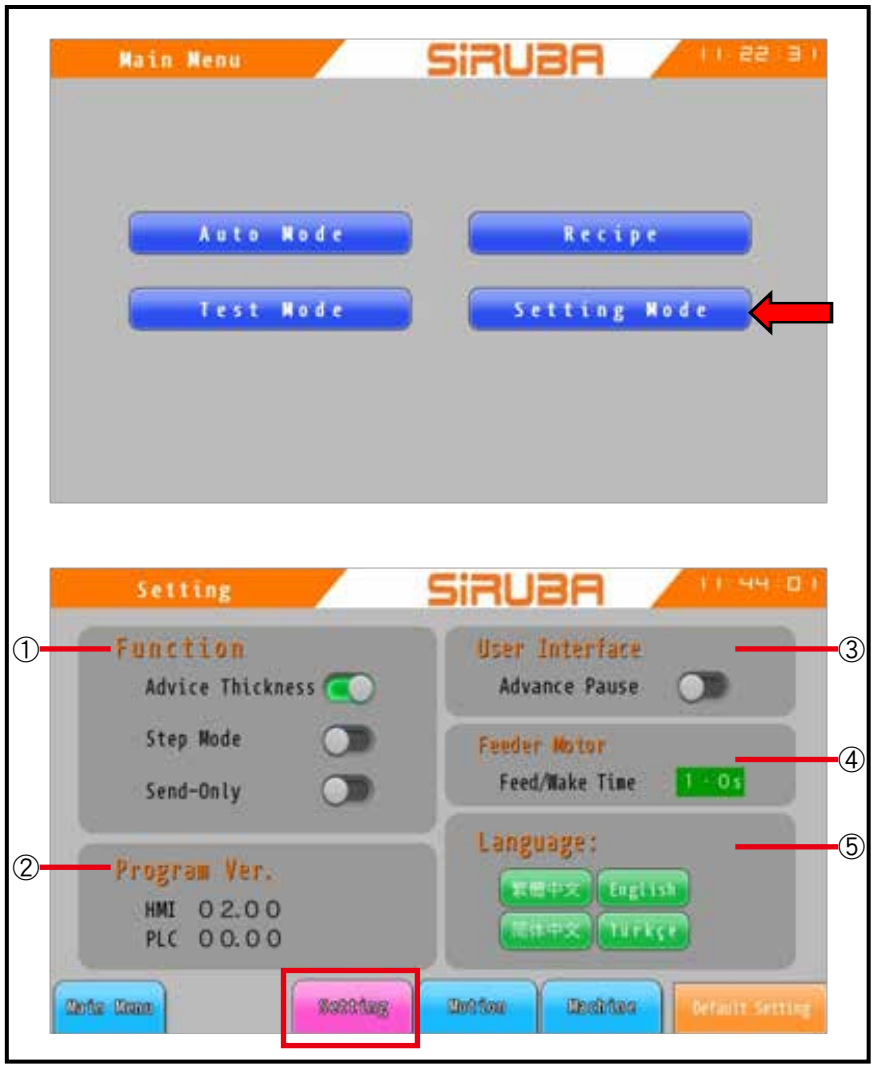


SYSTEM SETTING

Setting

1. Function
   (1)Thickness Advice
   Machine will give user optimal elastic thickness after scan.
   (2)Step mode
   " On " Auto mode will become step mode (for maintenance).
   (3)Send-only
   " On " feeding and cutting only, no sewing.

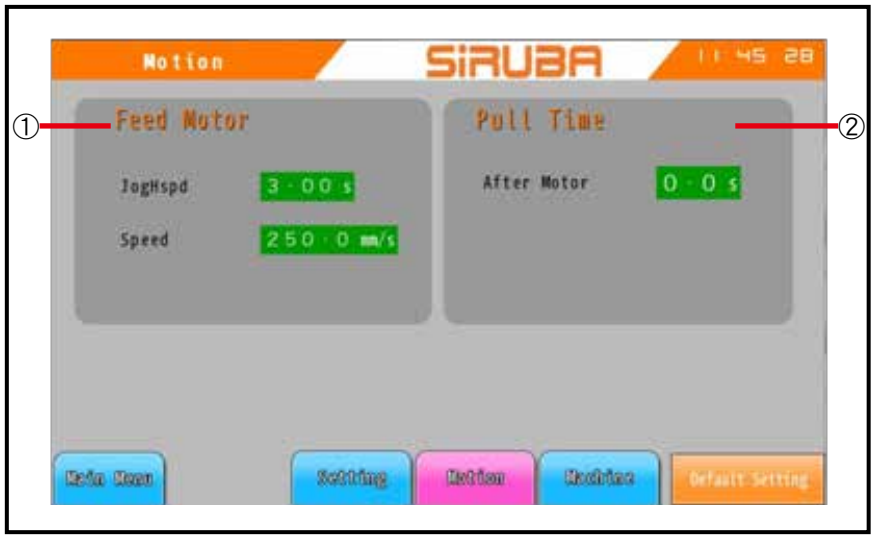
2. Program Ver. Display the ver. Of HMI and PLC program.
3. Stup up.
4. Feeder motor: Adjust the lasting time.
5. Language: select language



Motion

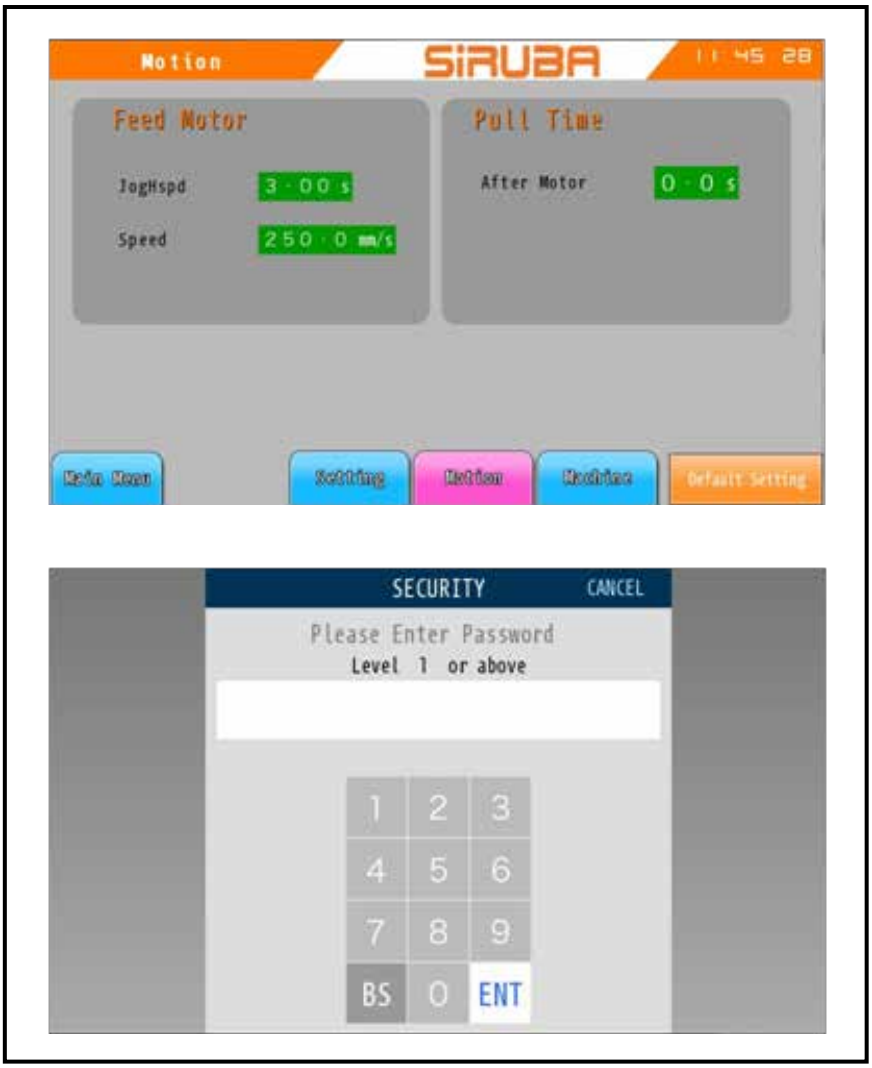
1. Feed Motor
   (1) Set up the timing to activate the step motor after press " send "
   (2) Set up the speed of stepper motor (Max 250mm / s)

2. Pull Time
   Set up delay time to start pulling the elastic after feeding.

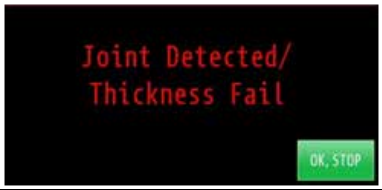


MACHINE

※ Need password to access factory mode (for engineer only).



TROUBLE SHOOTING

Error Message	Description	Solution
	The EMG STOP button is pressed.	A1
	1. Air press valve is abnormal. 2. Pneumatic cylinder is not in the origin position. Could be more than one.	A2
	No elastic band.	A3
	A bad joint of the elastic band is detected. (1)there is a bad joint (by tape or others) (2)there is a twist in the band feeding. (3)There is a bad quality of band.	A4
	Logo Detection is abnormal。	A5
	Ironing Device (EBI-100) is not ON. ※Optional item.	A6
	Sewing machine head not get ready.	A7
	Longer Machine idle-time	A8
	Counter do not achieve the setting number.	A9

A 1 · EMG STOP

(1) Press and rotate the EMG STOP ⑤ counterclockwise to release.

(2) If there is an elastic band on the sewing machine, press RELEASE ⑥ to free the sewing platform.

(3) Press RESET ③。

(4) Press START ① to resume. (※) (Cut and back to default)。

Note ※：When machine is in either situation A or B, press EMG STOP ⑤。Resume the operation after off the EMG STOP.

a. Turn on the main power (ON) and stay in standby position.

b. Circling ready before sewing: During operation，pressing EMG STOP ⑤ will interrupt the sewing. Follow the instructions above to resume the operation. Error Code E5 will shown on sewing machine panel. Follow the instructions below：

(5) Press R(RESET) ⑨→ to cut thread.

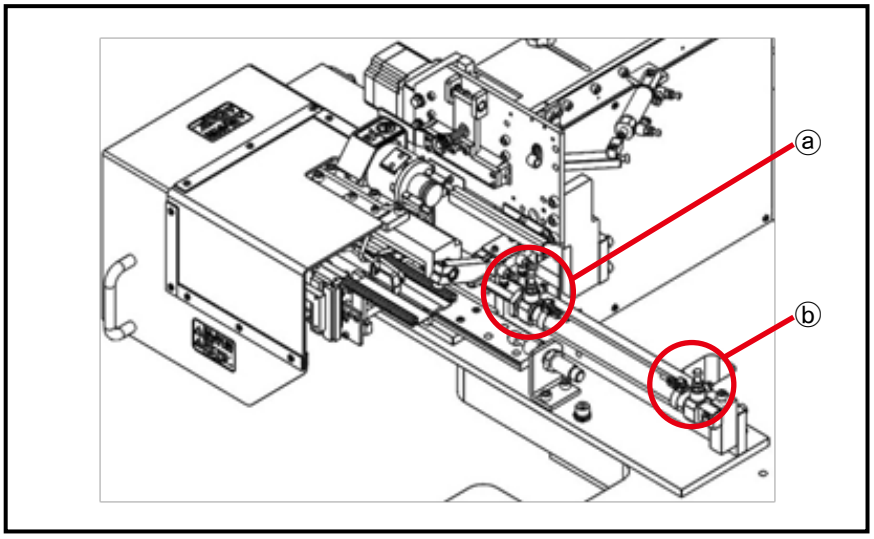
(6) Press R(RESET) ⑨ again → to eliminate the bad work and refer to the above※ instructions.

A 2 · Air Press Fails

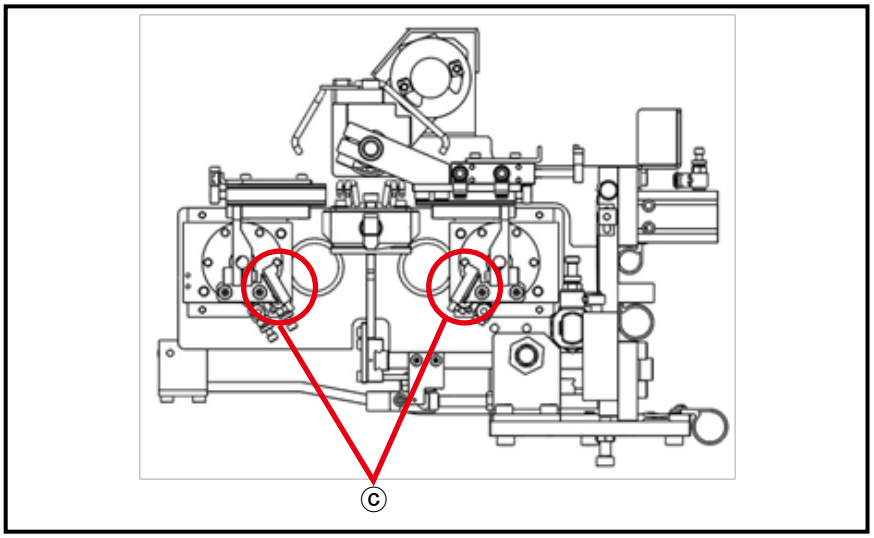
(1) Check the value of the pneumatic valve. It should be greater than 0.3Mpa。

(2) Check the cylinder sensors as listed below:

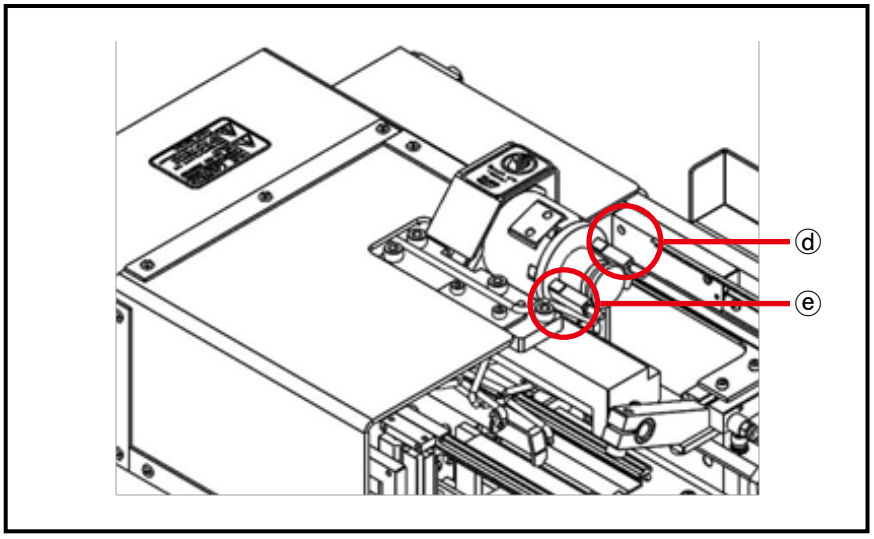
1. Feeding cylinder sensor
   (Initial status: ⓐ ON, ⓑ OFF)



2. 90° Clamper sensor
   (Initial status: ⓒ OFF)



3. 180° Clamper sensor
   (Initial status: ⓓ ON, ⓔ OFF)



(3) After the checking, press ⑦ to close the error window。
(4) Press RESET ③。
(5) Press START ① to resume the operation. (※The machine will execute cutting once and go to the initial status).

A 3 ・No Elastic Band

(1) Remove the remaining elastic band. DO NOT press RESET ③ now or it will make it very hard to remove the elastic band.
(2) Press ⑦ to close the warning window。
(3) Press RESET ③ .
(4) Reload the elastic band。
(5) Press START ① to resume the operation. （※）(the machine will execute cutting once and go to the initial status).

A 4 ・Bad Joint

(1) Use scissors to cut off the joint.
(2) Sort out the twist/wrinkle of the band. Apply ironing if needed.
(3) Press ⑦ to close the error window。
(4) Press RESET ③ .
(5) To work on the material before the joint, press START ① .
(6)To resume the continuous operation:
→ after 1 ～ 2 sewings，the machine will stop automatically because of running out of band due to the joint cut. Follow the procedures in A3.

A 5 ・Logo Detection fails.

(1) Check if there is a band feeding error. Correct if there is one.

(2) Press ⑦ to turn off the error window。

(3) Press RESET ③ .

(4) Go to the TRIAL mode, go into the QUICK TEACHING, check the value of PASS RANGE . Decrease the value or re-do the logo detection setting.

(5) Press START ① to resume the operation. （※）(the machine will execute cutting once and go to the initial status).

A 6 ・Ironing Device fails (When connected with Siruba EBI-100)

(1) The ironing device is off. Turn on the machine.

(2) Switch the Motor/Heater control switch to 2 for signal connection.

A 7 ・Sewing Machine Not Ready

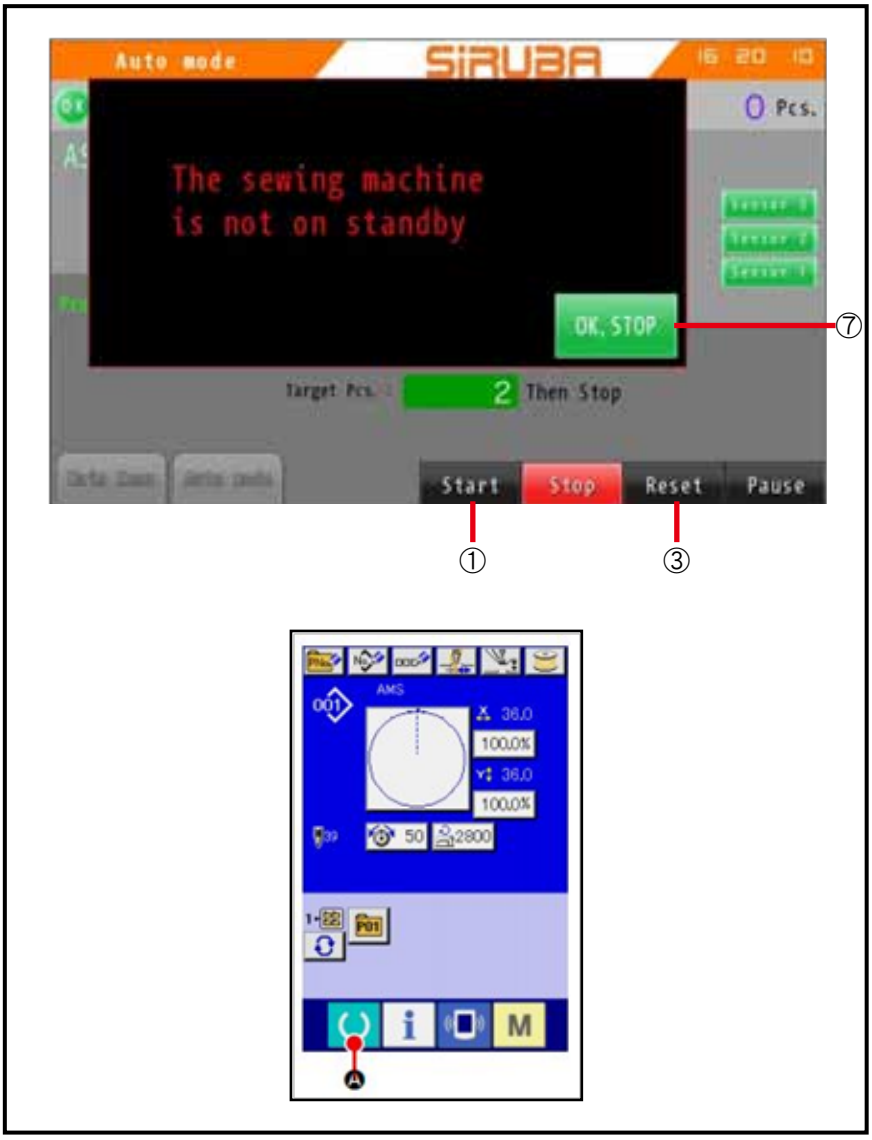
(1) After completing the setting of the sewing machine, press READY to get the sewing machine into the ready status.

(2) Press ⑦ to close the warning window.

(3) Press JUKI panel A .

(4) Press RESET ③ .

(5) Press START ① to start → RESTART（※）(the machine will execute cutting once and go to the initial status).



A 8 ・Sewing machine timeout

(1) Check if the JUKI error sorted. If not, press (A).

(2) Press ⑦ to close the warning window.

(3) (3) Press RESET ③ .

(4) (4) Press START ① to start → RESTART（※）(the machine will execute cutting once and go to the initial status).

A 8

A 9 ・Counter Reset

(1) When the target quantity is met, there will be a window popping out and the machine stops.

(2) Press ⑦ to close the window and to reset the FINISHED PCS.

(3) Press START ① to reset the operation. (※) (the machine will execute cutting once and go to the initial status).

Interruption of broken thread during the operation:

(1) Rethread，then press RESET ③.

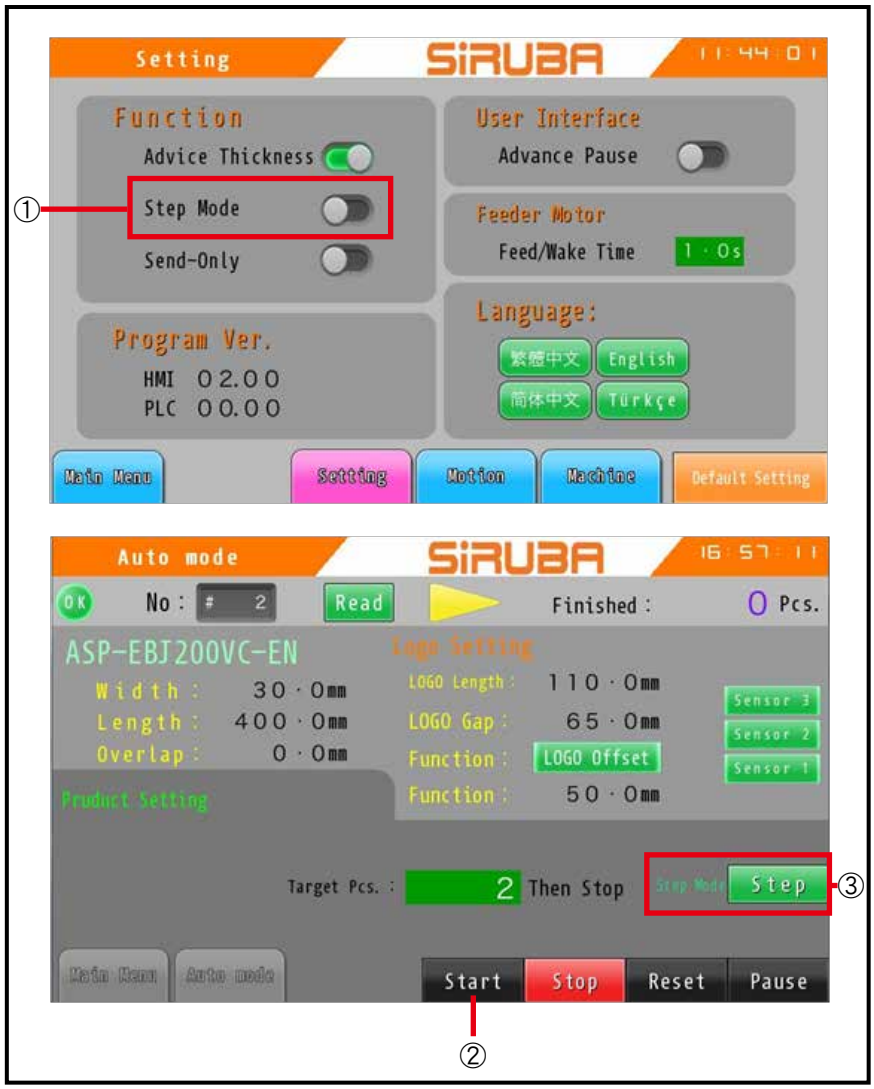
(2) According to the interruption point of the previous work, move the machine to the situation A or B below, and follow the instruction.

A. Main power is ON, the machine is in standby position.

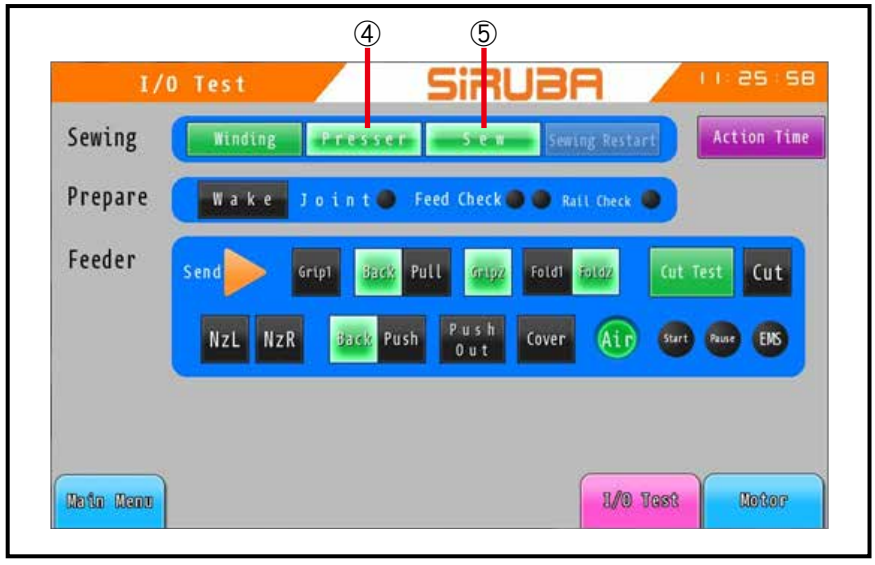
b. Machine pauses after the elastic band setting.
Note ※1 Refer to the sewing machine manual for threading.

SERVICE MODE

1. Single Move for service
   To check the machine functions step by step, and to verify the mechanical position.
   (1)Press SETTING MODE to enter，activate Single Move ① .
   (2)Enter AUTO MODE，press START ②→ restart（※）
   (Cut the band once and go to default position.).
   (3)Press START ②，and press NEXT ③ to confirm each move.
   (4)After finishing, return to SETTING MODE, turn off the Single Move ① .



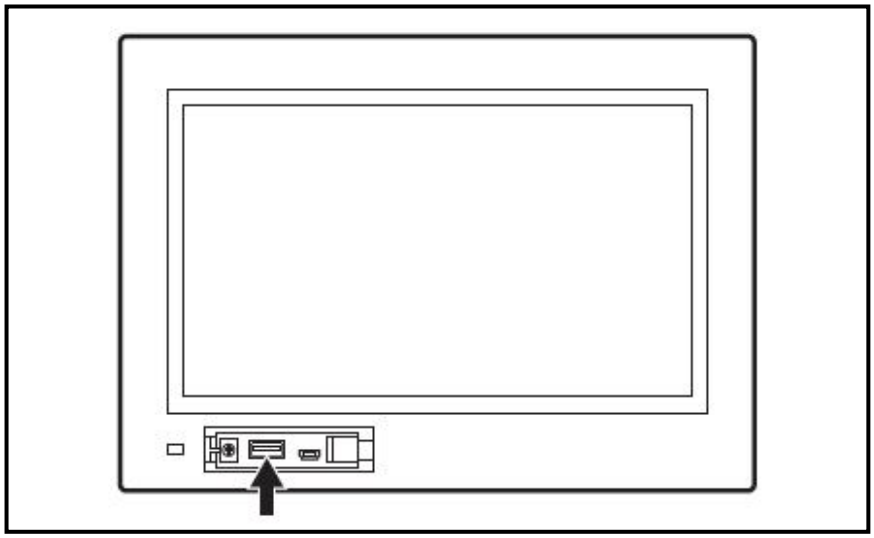
2. Sewing Machine Running
   Only sewing machine runs independently.
   (1)Enter TEST MODE, and press I/O Test.
   (2)Place the band manually under the presser foot, press Presser Foot Down ④ to hold the band.
   (3)Press Start Sewing on the sewing machine panel to complete the sewing once.



USB PORT

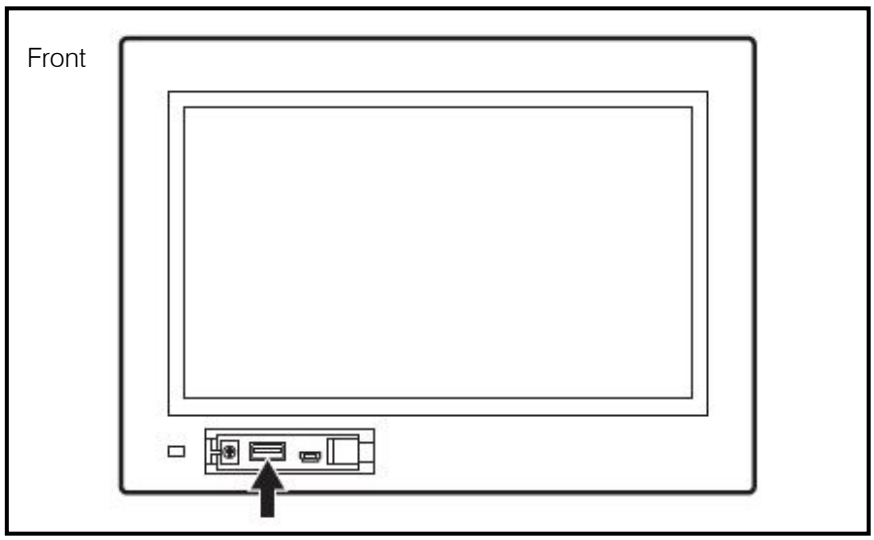
The working parameters/data are stored in the SD card of the HMI unit. Engineer/Operator may be able to import/export the parameter/data through USB port to/from the HMI unit.

HMI unit only accepts a memory stick no bigger than 32GB, USB2.0.



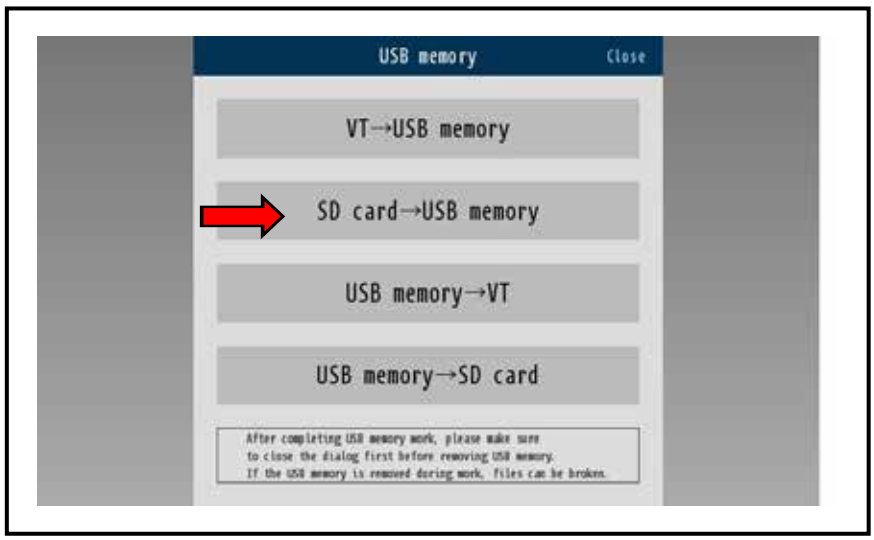
1. To export data from HMI unit.

(1) Plug USB memory stick to the USB port.

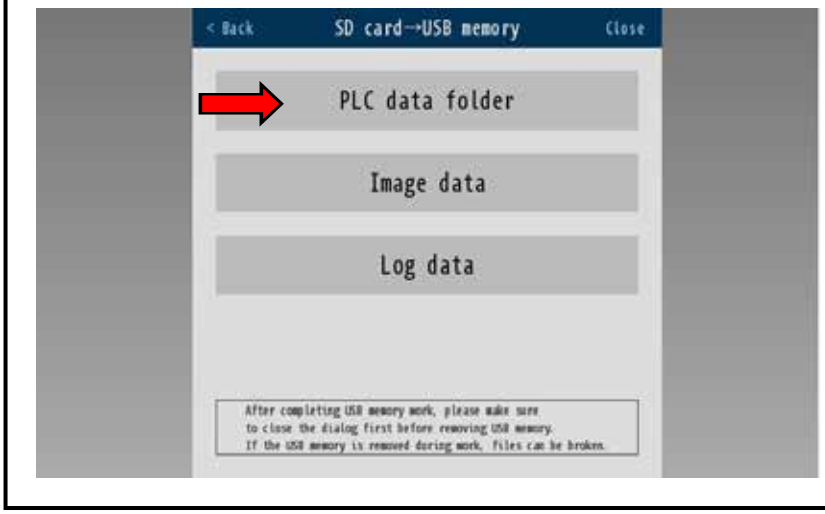


(1) When the power is ON, you shall see the screen as below.

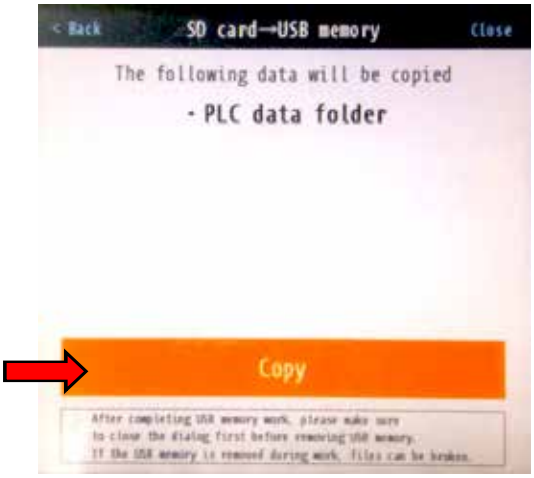
(2) Click “SD card -> USB memory”.



(3) Click “PLC data folder”

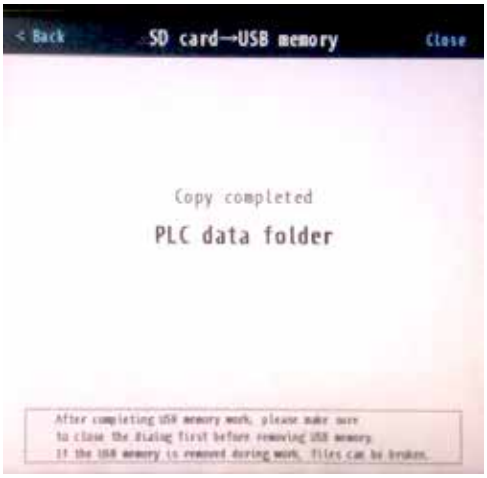


(4) Click “Copy” to export data from HMI to USB memory stick.
Do not remove the memory stick during the data transmission.



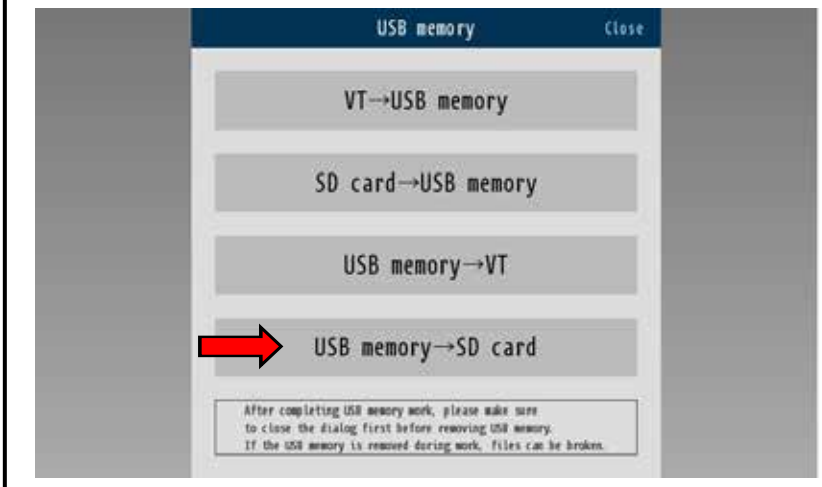
(5) The data transmission completes and shows as below. Click “Close” to return to the main menu. Unplug USB memory stick.

(6) Check the USB memory stick. The data you just downloaded is saved in a folder named “VTDVC”.

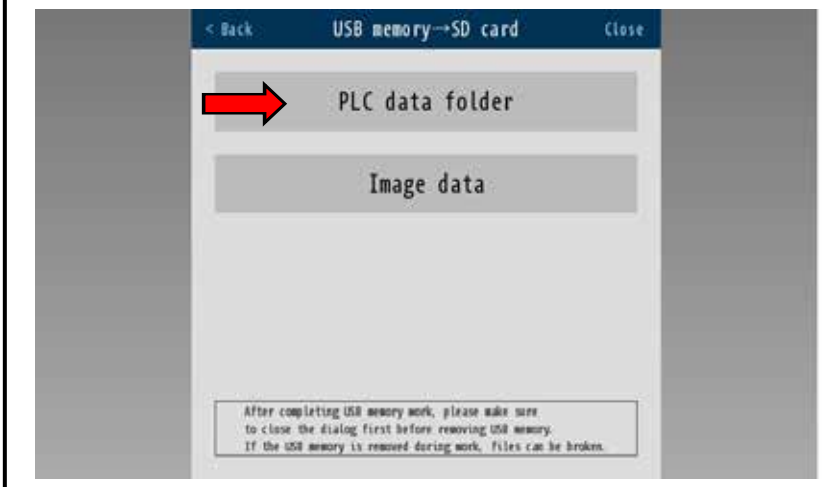


2. To import data to HMI unit.

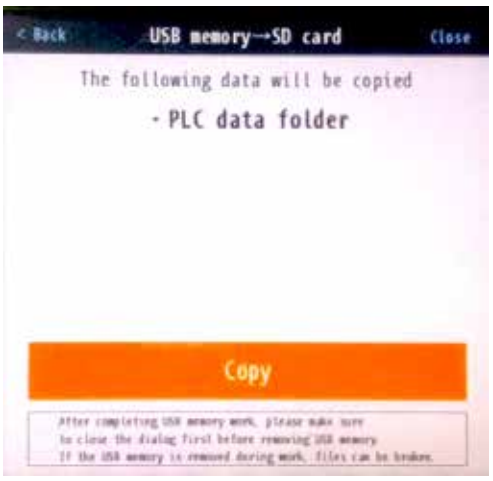
(1) Plug the USB memory stick to the USB port on the HMI. Click “USB memory ->SD card”.



(2) Click “PLC data folder”

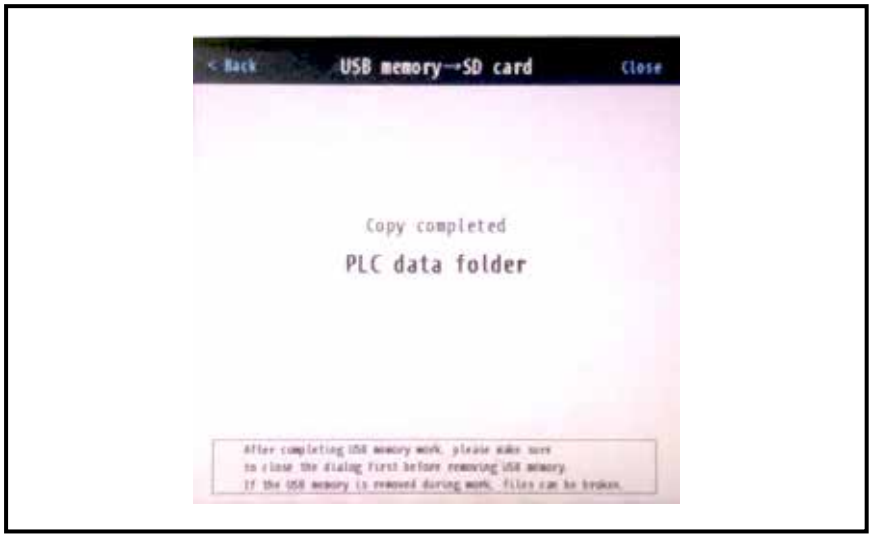


(3) Click “Copy” to transfer data to HMI SD card.

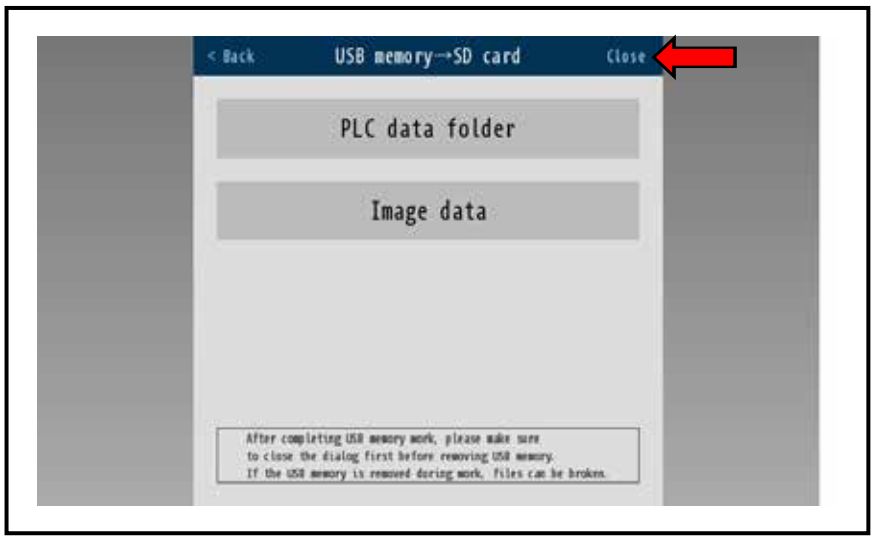


(4) Click “Close” to return to the main menu. Unplug USB memory stick.

(5) Go to Trial Mode to check the parameter importation.



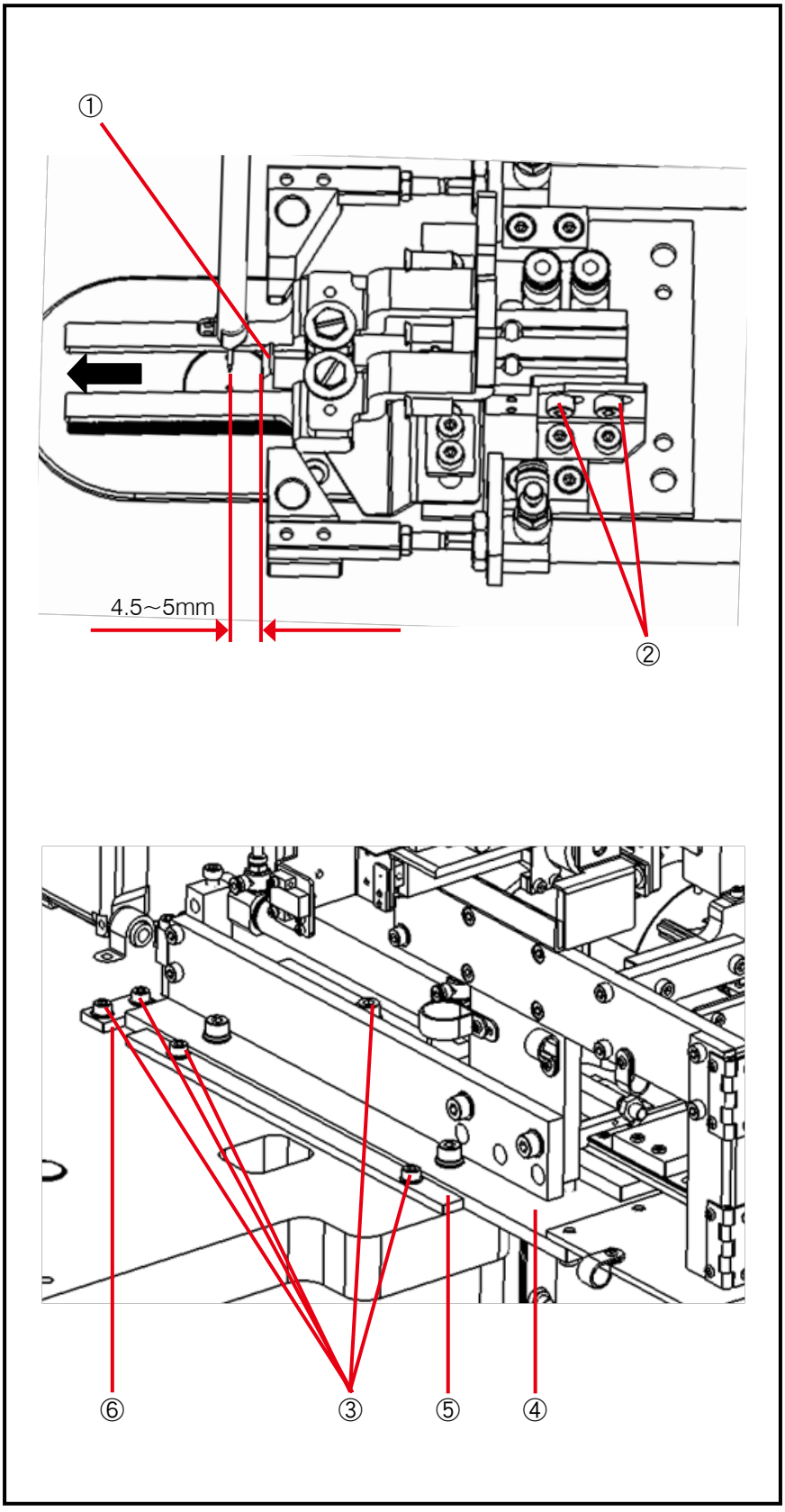
(6) Press the "close" button to return to the run mode.



SERVICE & MAINTENANCE

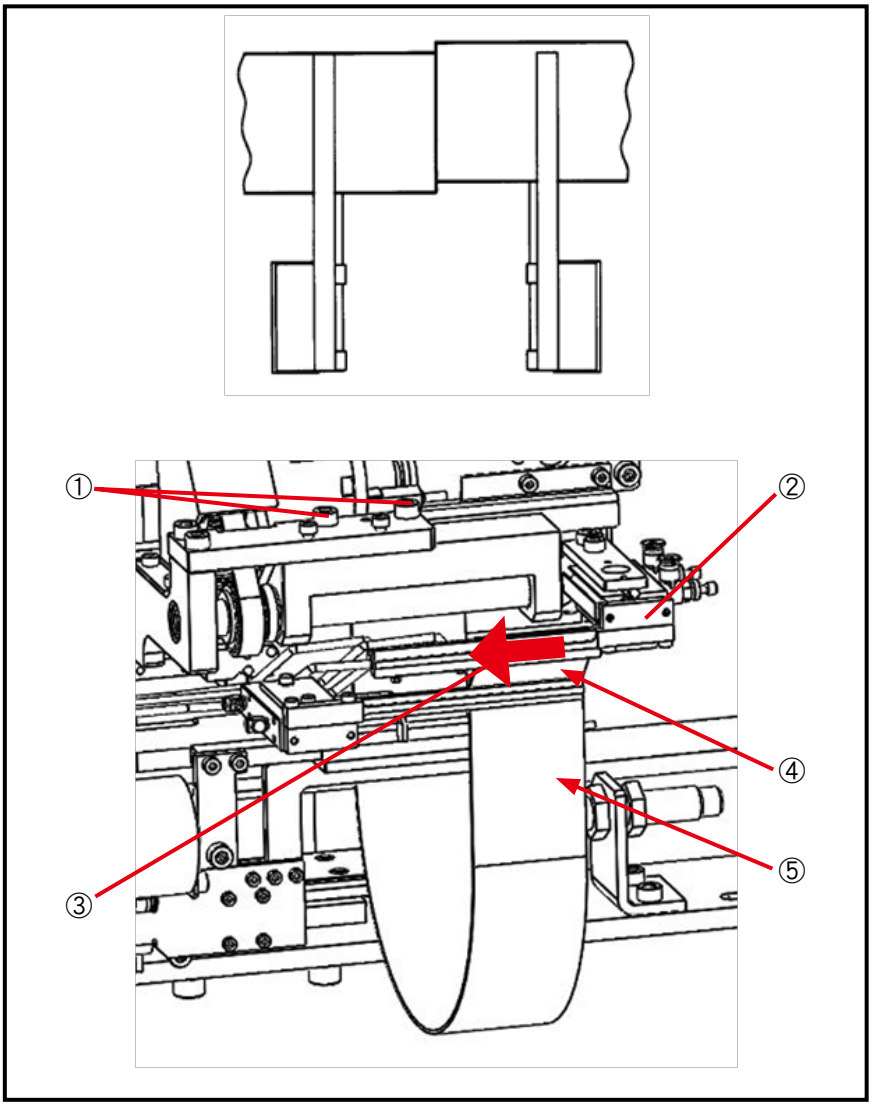
A. Band & Band Feeder Position

1. Disconnect the air supply. Loosen the Screw ② to adjust the distance between Band Locator ① and Needle Holder to be 4.5 ~ 5mm.
2. When the band reaches the presser foot, the inner side of the band should align with the Locator ① . Refer to Testing Mode to verify the position. Check if there is a gap (less than 0.5mm) between the circled band and locator ① .
3. When the Locator ① pressed and holds the band, the work will be pulled up, causing a breaking thread or poor sewing. You may need to adjust the Band Feeder position.
4. To adjust the Band Feeder: Loosen 5 screws ③ . Move the Base ④ along with the Inductor ⑤ . After the adjustment, tighten the 3 screws on the Base ④ . Fix the Rear Board ⑥ of the Band Feeder onto the Base ④



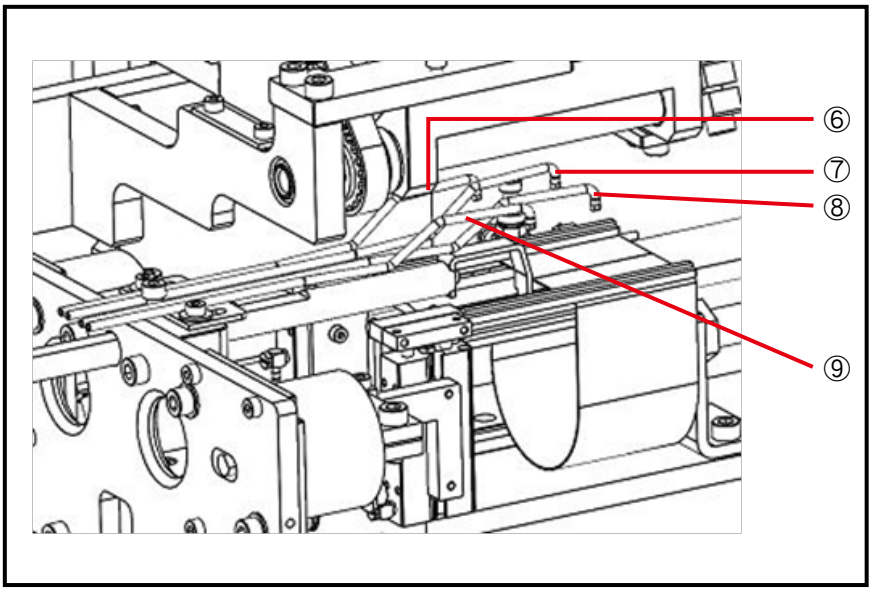
B.Correct the variance of band joining.

1. When the right end of the circled band strays inward. (as shown below in the left):
   Loosen screw ① . Move the Band Clipper ② outward (direction 3).
2. When the right end of the circled band strays outward :
   Loosen screw ① . Move the Band Clipper ② inward.
3. As shown below in the right, adjust the clipper position according to the deformation of the band joint ④ , ⑤ . Check from the side of the band.



C.Intensity of air blow

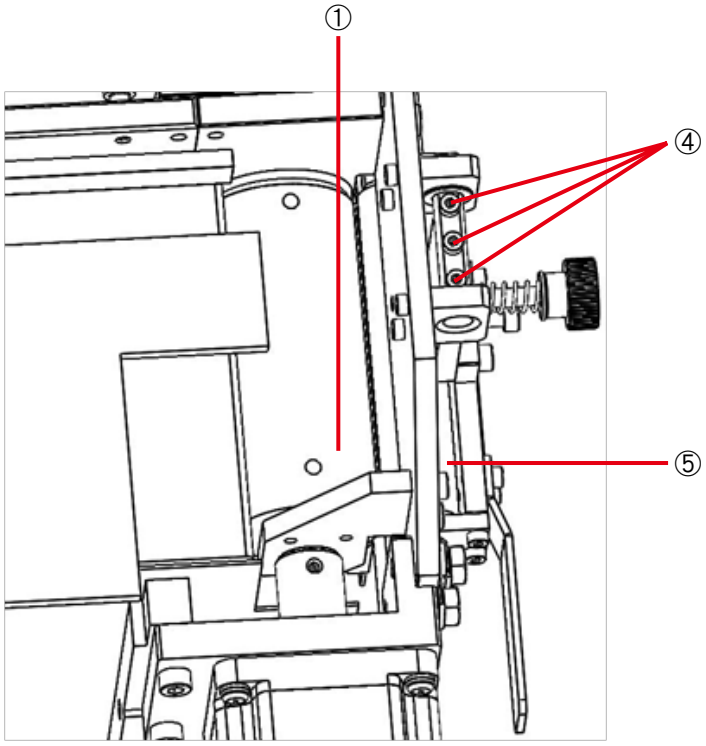
The intensity of air blower ⑥ ~ ⑨ varies according to the work request. Adjust the throttle valve individually if needed.

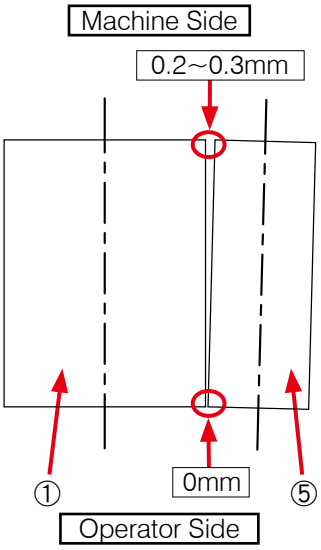


D.Feeding Roller

You need to adjust the Feeding Roller ① when the band on the feeding roller moves outward.

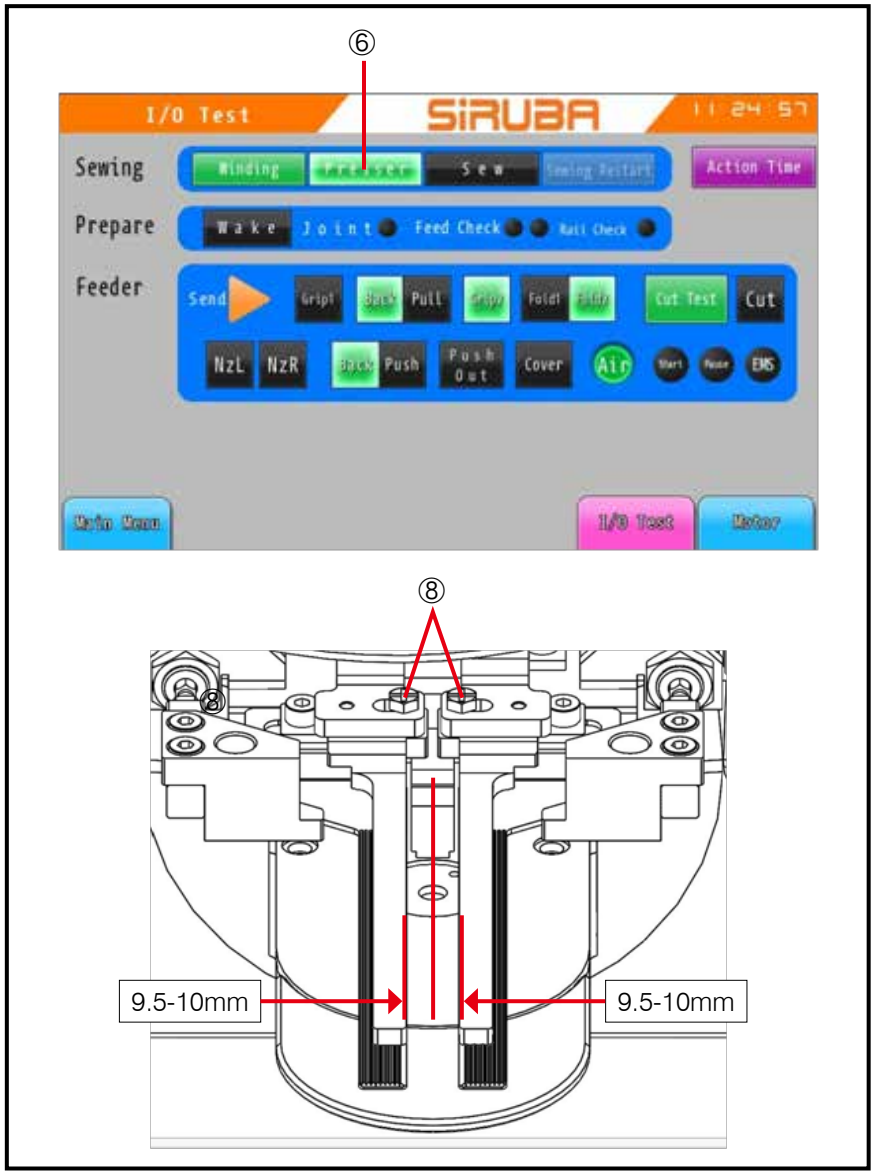
1. Loosen screws ④
2. Adjust the Aux Roller ⑤ . Refer to the illustration as shown in the right below.





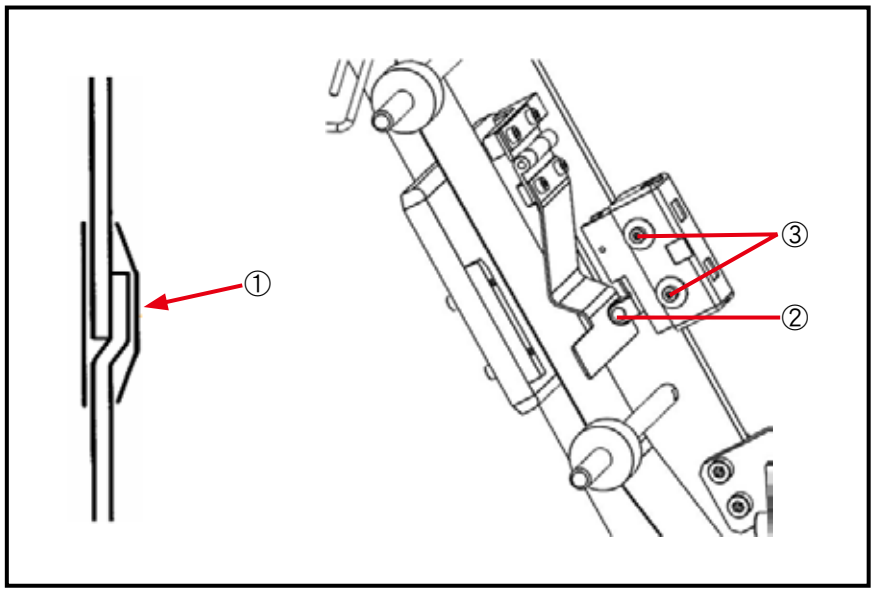
E.To adjust the Presser Foot and Plate

1. Remove the needle, enter I/0 TEST mode，。
2. Press Presser Foot Down ⑥ to lower the presser foot.
3. The width of presser foot is 9.5-10 mm (left/right)。
4. Loosen the screws on the plate and presser foot for adjustment.



F. Joint Seam Sensor

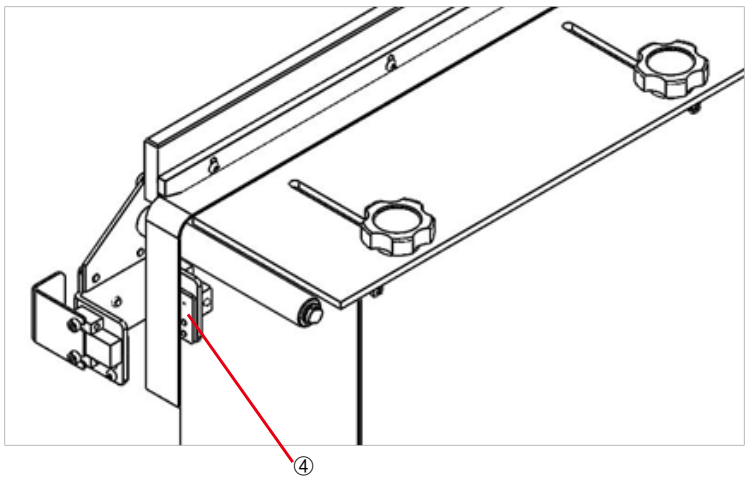
1. Loosen screws ③
2. When ① passes the joint seam sensor, adjust the switch ② horizontally until the sensor activated.



G.Band Remaining Sensor

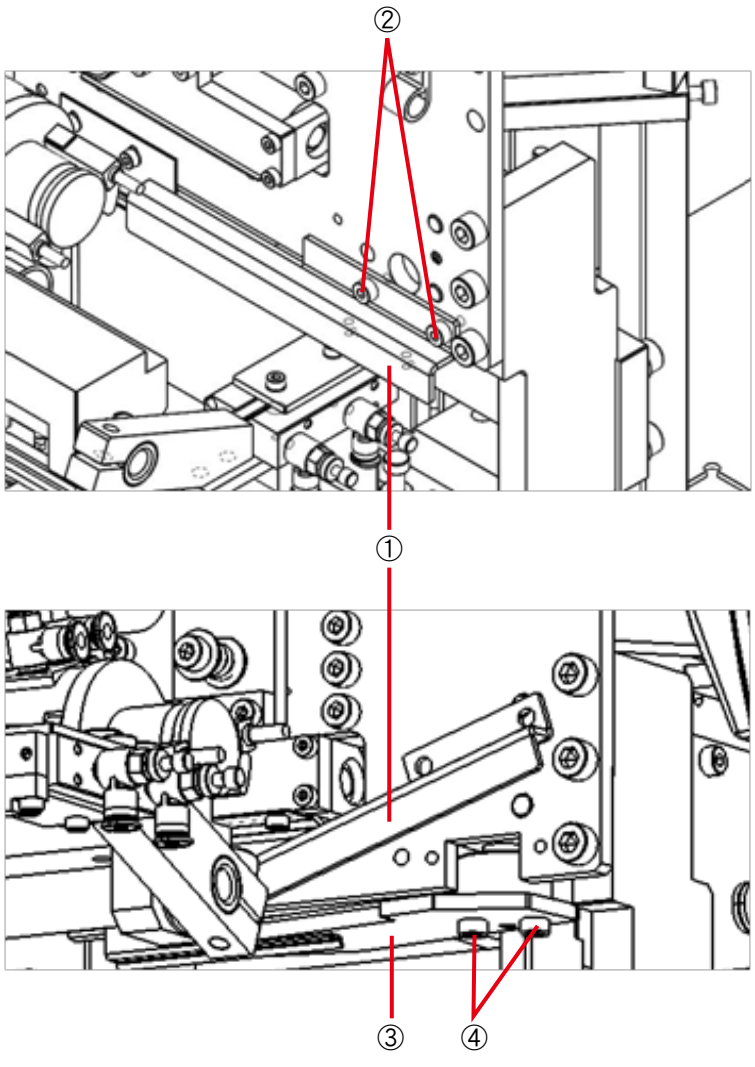
When the band material is white or thin enough to allow the light going through, there might be a mis-reading. Then you need to adjust the sensor accordingly.

1. Turn on the power.
2. Insert the test band into the sensor.
3. Relocate the sensor ④ (tilting) to lower the sensitivity.
4. Check the indicator of sensor (on the right of the sensor). The indicator goes ON when there is no band.

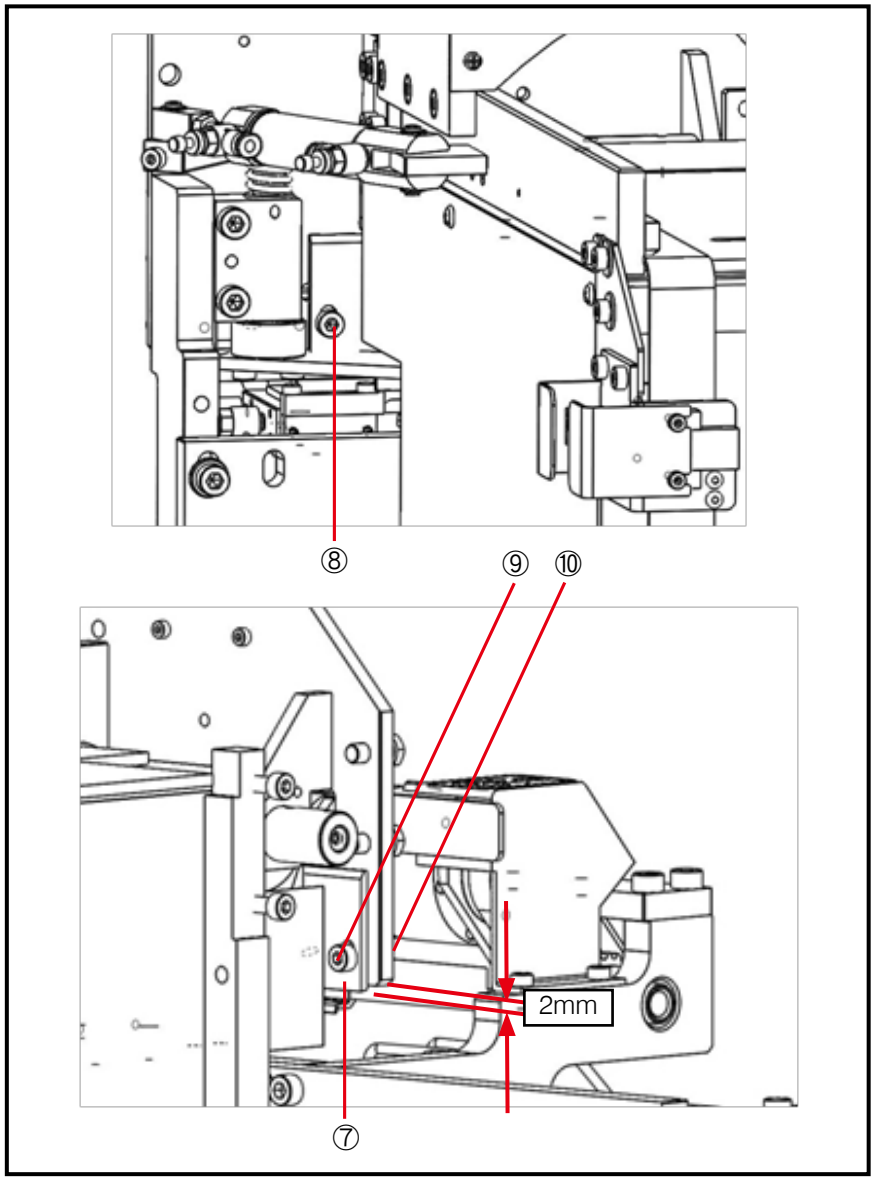


H.Cutter

1. Uninstall the cover ① and ② .
2. Loosen screw ④ to remove the cover ③ .
3. Remove the screws ⑥ to change the Moving Cutter ⑤ .

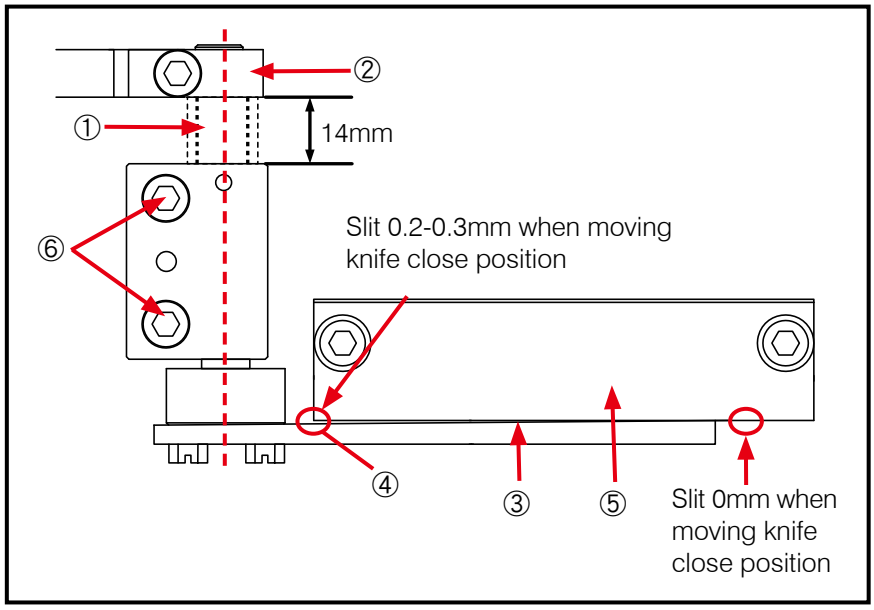


4. Remove the screws ⑧ , ⑨ to change the Fixed Cutter ⑦ .
5. The blade of Fixed Cutter ⑦ should be 2mm lower than BASE ⑩ .



To adjust the cutters:

6. As shown below, the Steel Rod ① is 14mm. (loosen screw ② to adjust the meshing pressure.
7. Loosen screw ⑥ to adjust the Gap ④ between the Moving Cutter ③ and the Fixed Cutter to be 0.2 ~ 0.3mm.
8. If the Gap ④ is too big, it will cause poor cutting and damage the cutters.



SEWING PATTERN

To select the sewing pattern.

(1) Turn on the main power。
Go to the sewing machine control panel.

(2) Press ○ A to enter the patter selection。

(3) Press ○ J to select the elastic band width pattern. Then press ○ I to confirm the selection. (press ○ K to preview the pattern)。

(4) Press ○ B to enter the sewing ready.

Note：Please refer the sewing pattern chart listed below. For example, when the elastic band width (Y) is 5mm, if there is no responding width available, you may apply ZOOM +/- to change the ratio。

(5) Press ○ C to change the X/Y ratio. The setting value need to be adjusted according to the final sewing result.

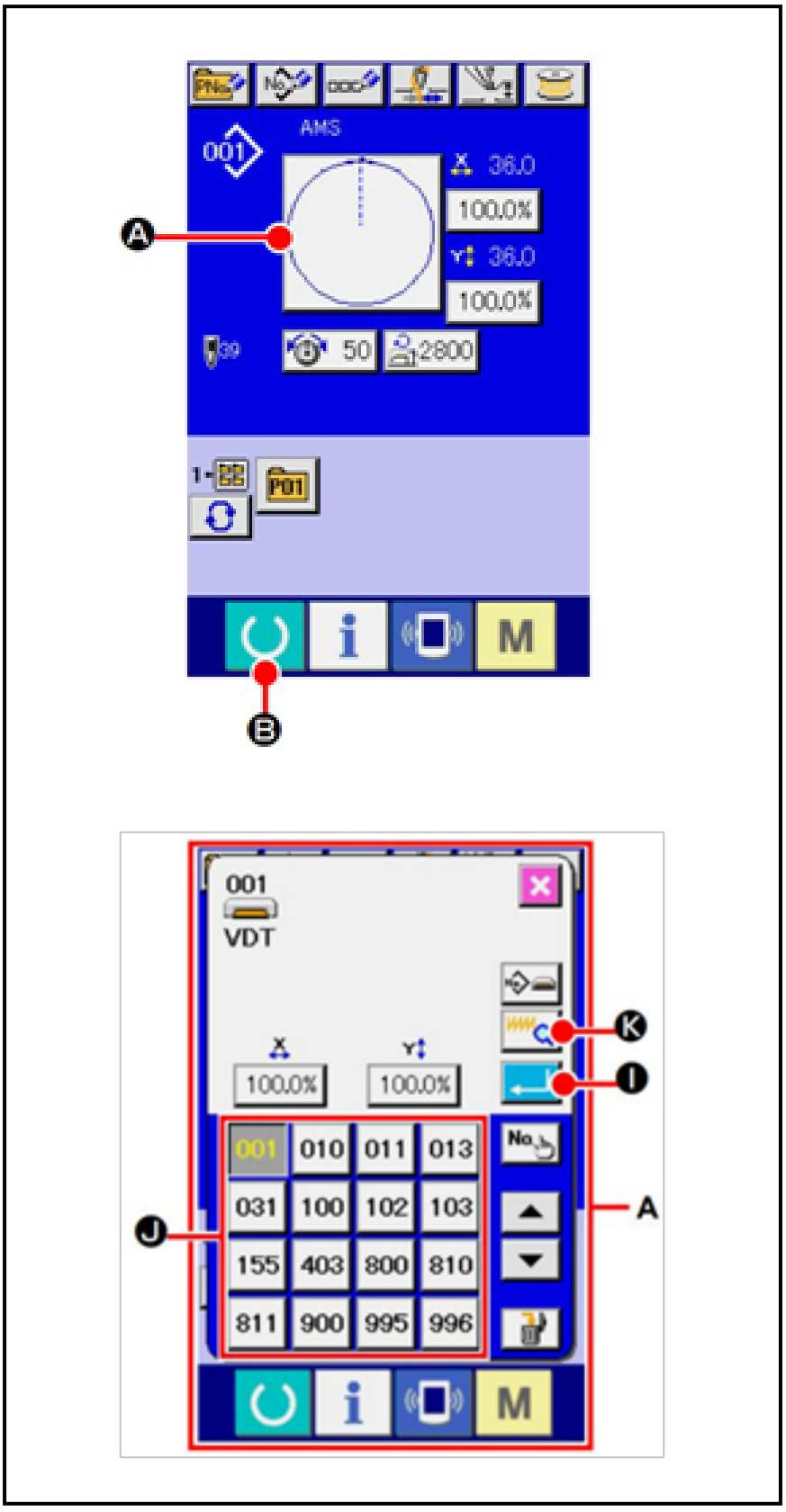
Example of Sewing Pattern Ratio change.

Elastic band width: 34 mm ,

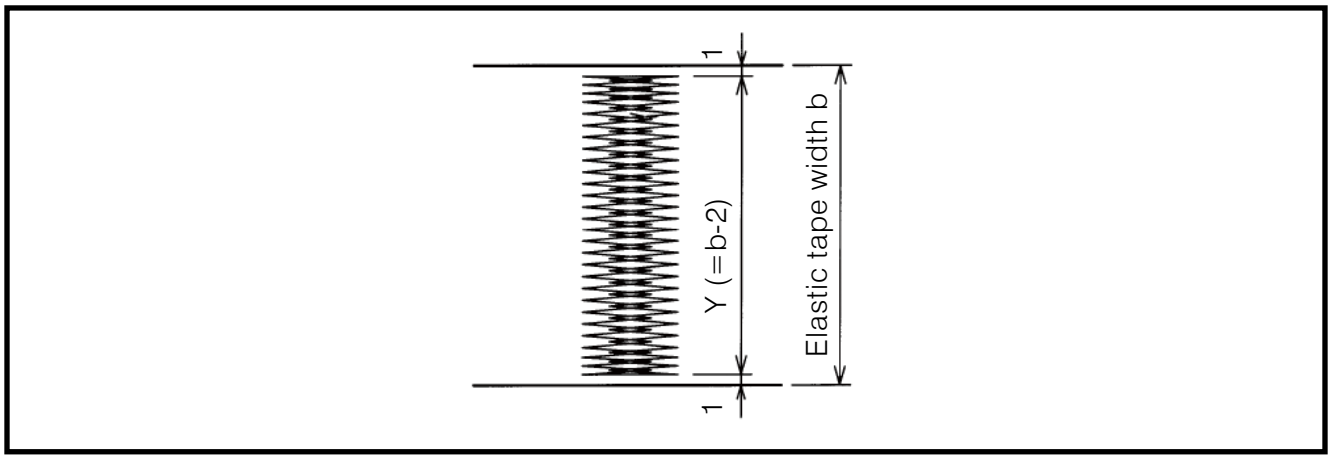
Pattern is same as previous.

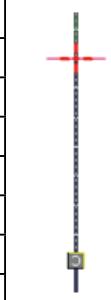
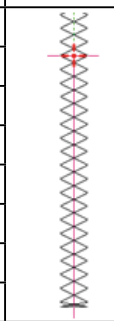
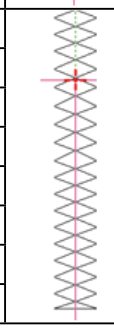
(1) Pattern No.：Set to be No.35

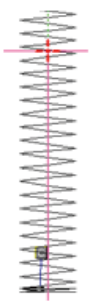
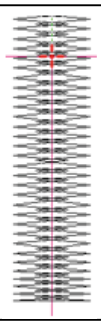
(2) Ratio Change：Change the setting of Y-SCALE to 96～97%（according to the final result.）



•Sewing Pattern List



No.	Stitch diagram	Number of stitches	Sewing size	
			Length width	Cross width
1		33	0	20
2		39	0	25
3		45	0	30
4		51	0	35
5		57	0	40
6		63	0	45
7		69	0	50
8		75	0	55
11		38	3	20
12		46	3	25
13		52	3	30
14		60	3	35
15		66	3	40
16		72	3	45
17		80	3	50
18		86	3	55
21		57	5.2	20
22		69	5.2	25
23		77	5.2	30
24		88	5.2	35
25		96	5.2	40
26		109	5.2	45
27		113	5.2	50
28		125	5.2	55

No.	Stitch diagram	Number of stitches	Sewing size	
			Length width	Cross width
31		71	6.4	20
32		87	6.4	25
33		98	6.4	30
34		111	6.4	35
35		127	6.4	40
36		139	6.4	45
37		151	6.4	50
38		163	6.4	55
41		172	9	20
42		212	9	25
43		252	9	30
44		284	9	35
45		324	9	40
46		356	9	45
47		396	9	50
48		428	9	55

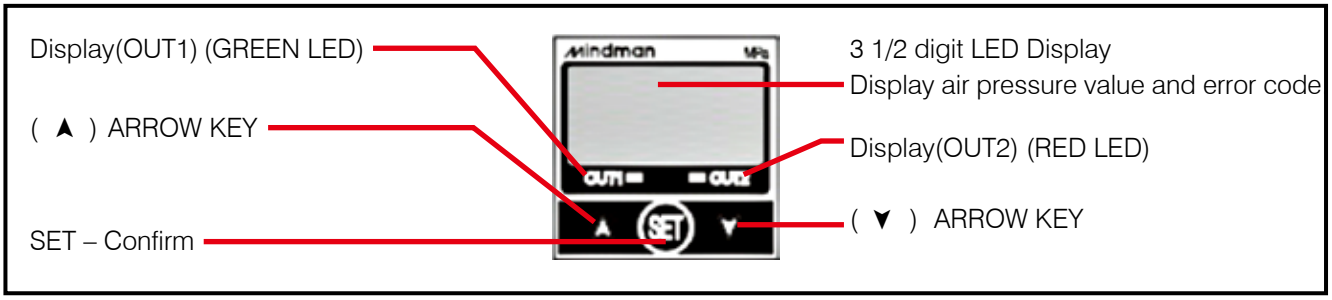
•Setup example of expand/reduce ratio

If 34mm wide of elastic tape was using the same sewing pattern above：

(1)Pattern No.： No.35 setup.

(2)Expand/Reduce ratio：Setup 96～97%Y-SCALE（Please decide the ratio from sewing results.）

DIGITAL PRESSURE WATCH PANEL BUTTON DESCRIPTION



Measurement mode (default value is " 0 " without air supply, if not return to " 0 " manually)

Long press " SET "

Press arrow key to select GF (kgf/cm2)

Press " SET "

Press arrow key to select 1no

Press " SET "

Press arrow key to select 2no

Press " SET "

Press arrow key to select 2.5

Press " SET "

Press arrow key to select MAN

Long press " SET "

Measurement mode - assume the value is 5

Long press " SET "

Press arrow key to select as 3.5 as lower limit for P1

Long press " SET "

Press arrow key to select as 6 as upper limit for P2

Long press " SET "

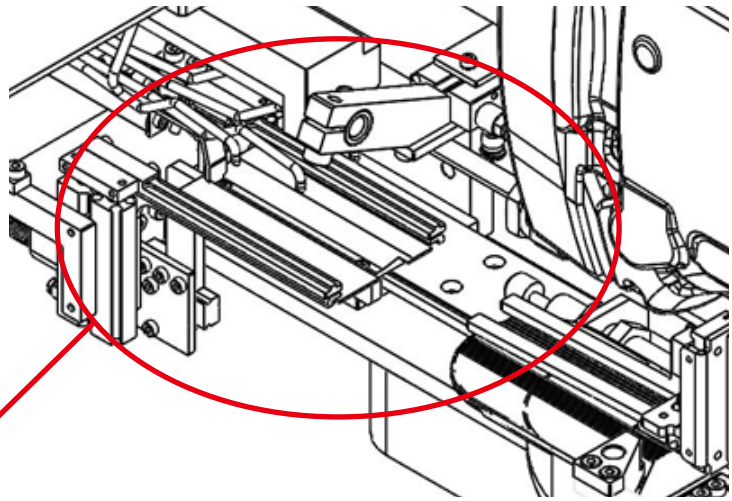
Measurement mode - assume the value is 5

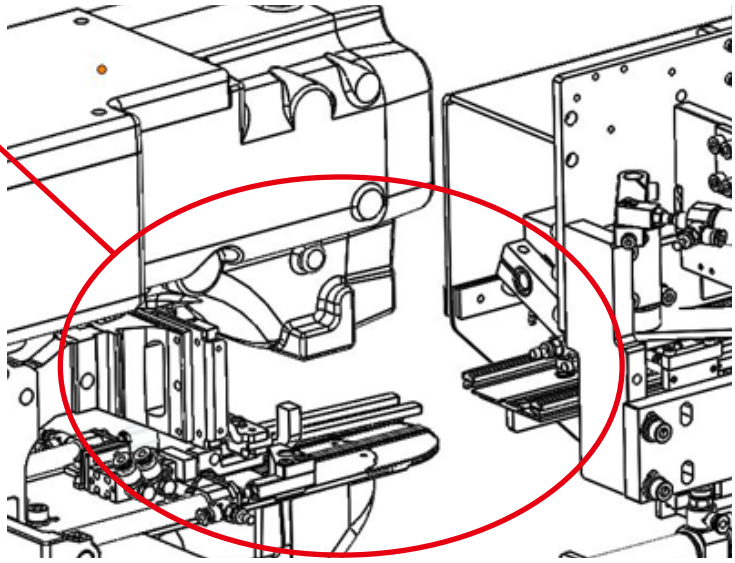
中 文

EBJ 系列安全守則

活動部件區域：
請隨時保持活動部件區域的淨空，沒有外部物品的干擾。

零件活動區域

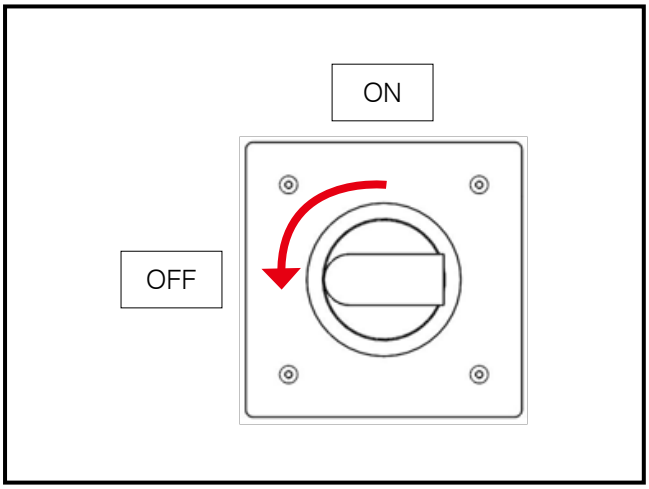




電源開關

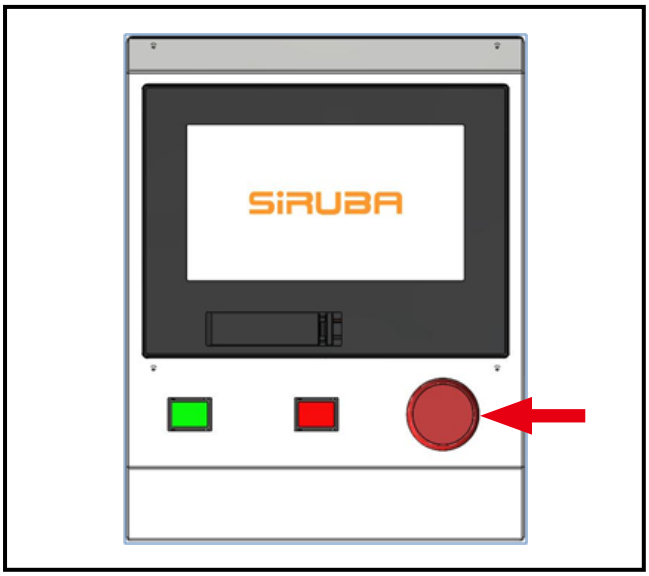
在以下情況請保持電源關閉： ON

1. 維修服務。
2. 操作人員於暫時離開機器。



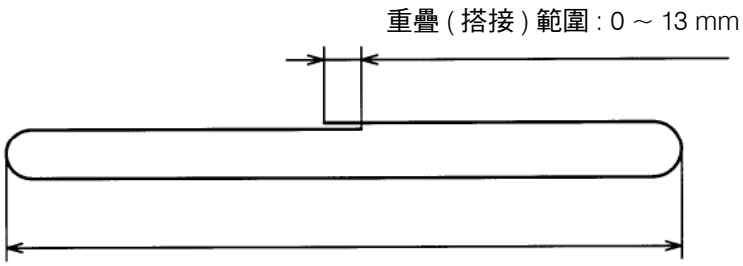
緊急停止開關

出現緊急情況時，點選緊急停止開關以停止機器。
我們強烈建議在關閉電源前先按下緊急停止開關。
恢復工作時請開啟電源並鬆開緊急停止開關。
這可確保操作人員對機台的操作有足夠的重視。



內容	頁

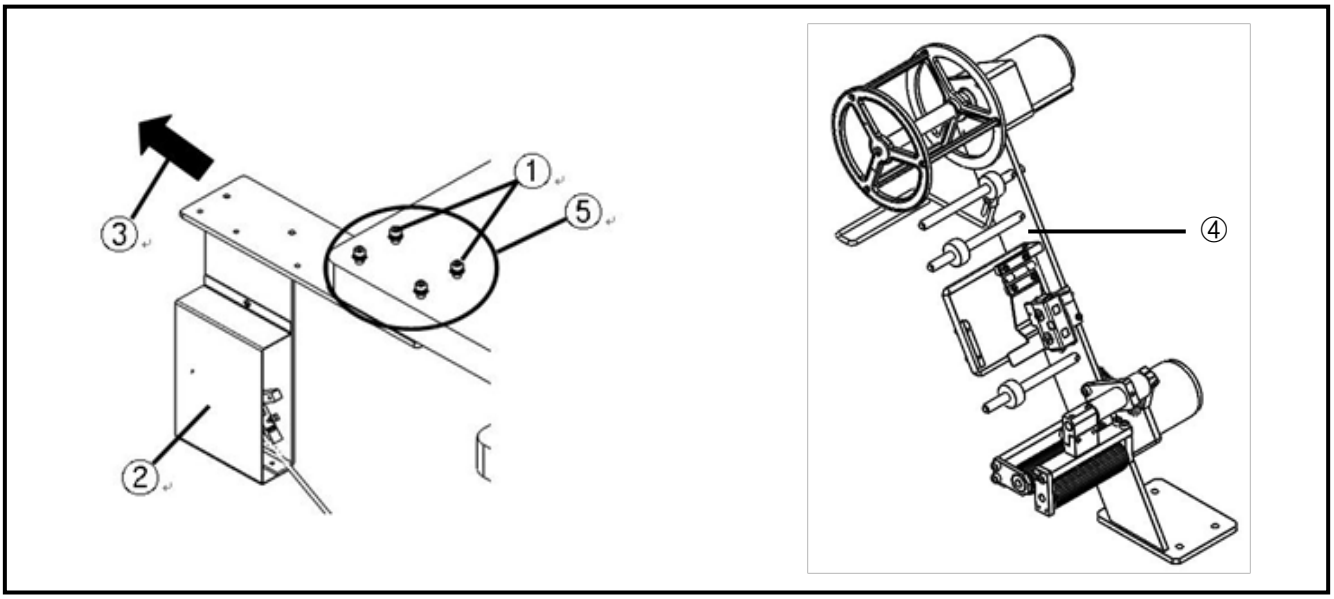
規格表

機型	ASP-EBJ150
機針規格	DP x 5 # 14
縫紉機轉速	2500 rpm (max)
產出效率	取決於縫製針數 如使用 190 針的圖形下，每 8 秒可完成一件。
鬆緊帶寬範圍	20 ～ 50 mm
電源	單向 1Φ AC200~240V 50/60Hz
氣壓設定	0.5 Mpa
空氣消耗	30 升 / 分鐘
成品範圍	 對折尺寸 : 150 ～ 990 mm
鬆緊帶摺疊尺寸	鬆緊帶對折尺寸 : 150 ～ 990 mm (整圈尺寸 : 300 ～ 1980 mm) 重疊 (搭接) 範圍 : 0 ～ 13 mm

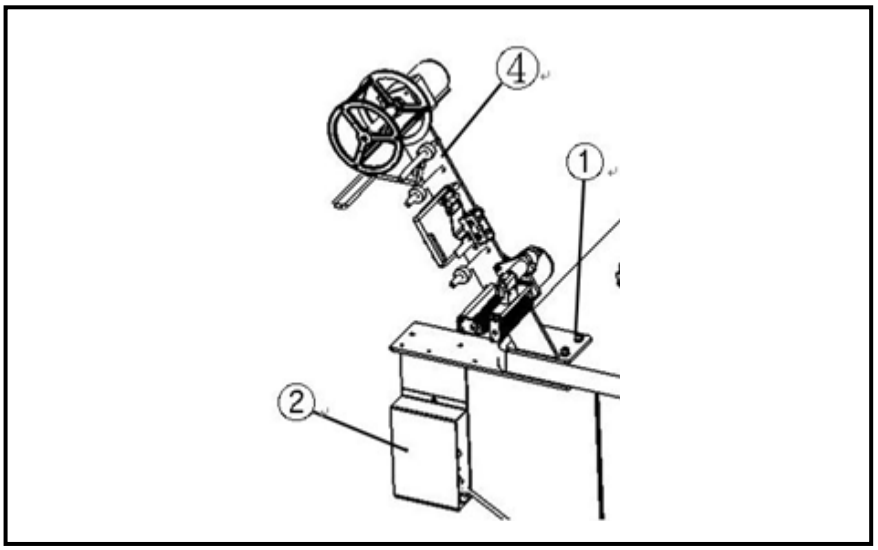
設備安裝

※ 安全起見，強烈建議由兩名以上的技術人員合力組裝。

1. 鬆開螺絲①後，將鬆緊帶張力感應器②往外移動。(請小心搬動以免損壞或導致感應器的鐵桿變形)
2. 將輔助裝置④安裝到桌板上預留的螺絲孔位置⑤。



3. 用螺絲將輔助裝置④和張力感應器②鎖固。
4. 確保每一條電線的插頭都和對應的插座穩固連接。

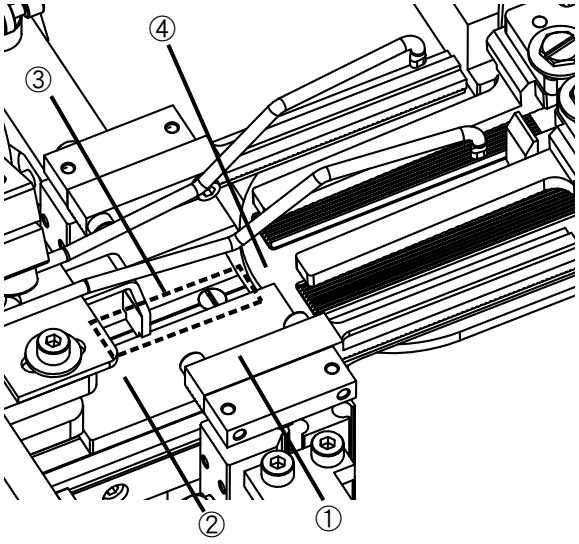


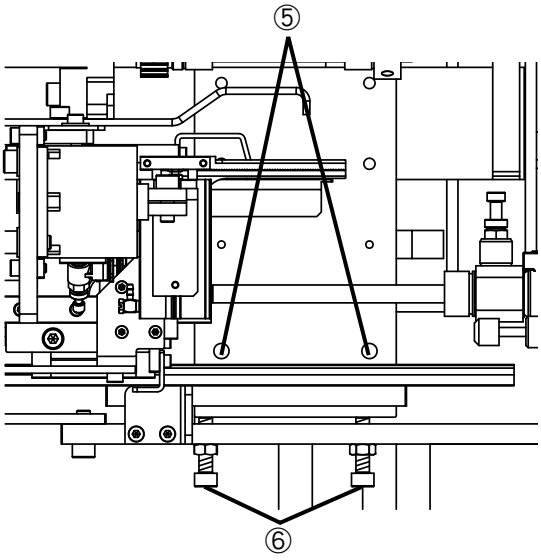
5. 連接上電源和空氣之前，請將夾爪①下推至極限以避免撞擊其他零組件。
6. 將送帶盤②往縫紉機方向推動，確保送帶盤面③與縫紉機針板④保持平行、沒有撞擊或摩擦。當送帶盤③比縫紉機針板④低 (0.3mm 以上)，或送帶盤③高於紉機針板④ (0.5mm 以上)，鬆開螺絲⑤，並藉由螺絲⑥以調整到適當高度。

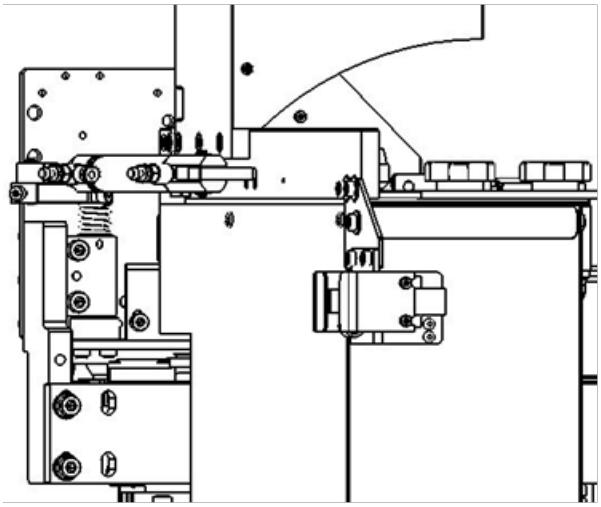
6. 氣壓：
將氣壓閥壓力設定為 0.5Mpa。

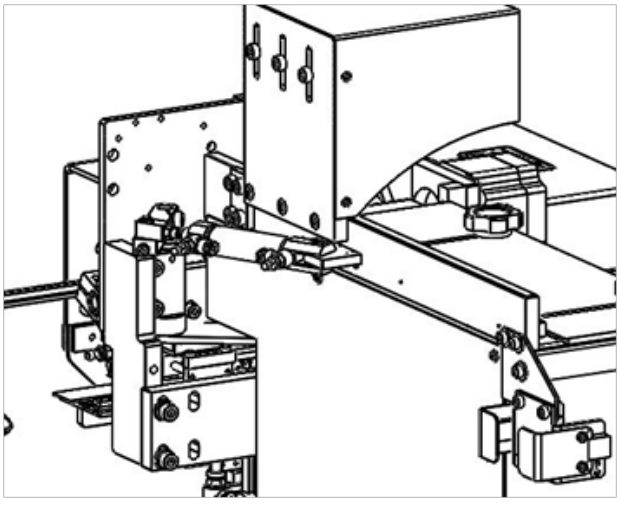
7. 電源：
電力供應品質需穩定，且變動小於 10%。接地也必須確實。

8. 潤滑措施：
(1) 縫紉機部分請參考縫紉機內附的操作說明書。
(2) 切帶刀部分 (如下頁圖所示 ②①) 請定期且少量的使用潤滑油。



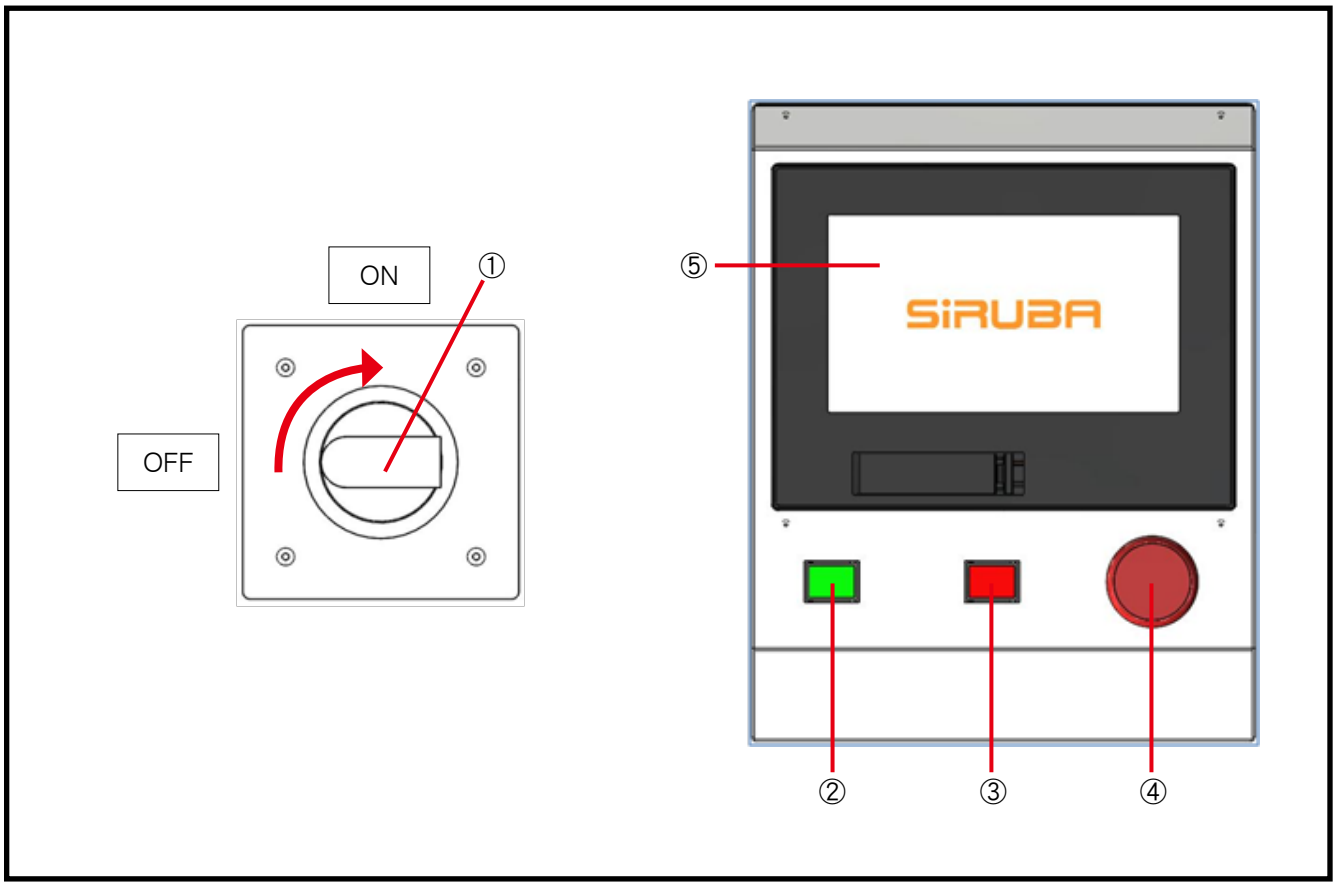






控制面板

1. 按鈕說明



按鈕	功能說明
① 主電源開關	主電源開關 (ON/OFF)
② 啟動鍵 (綠色)	1. 啟動機器運轉。 2. 機器連續運轉。 3. 啟動單動模式。
③「循環停止」鍵（紅色）	1. 停止連續運轉。 2. 製作一件成品。
④「緊急停止」鍵（紅色）	點選後機器立即停止。旋轉按鈕可解除。
⑤ 觸控面板	1. 參數設定 2. 設定或測試 I/O。

送帶輪裝置

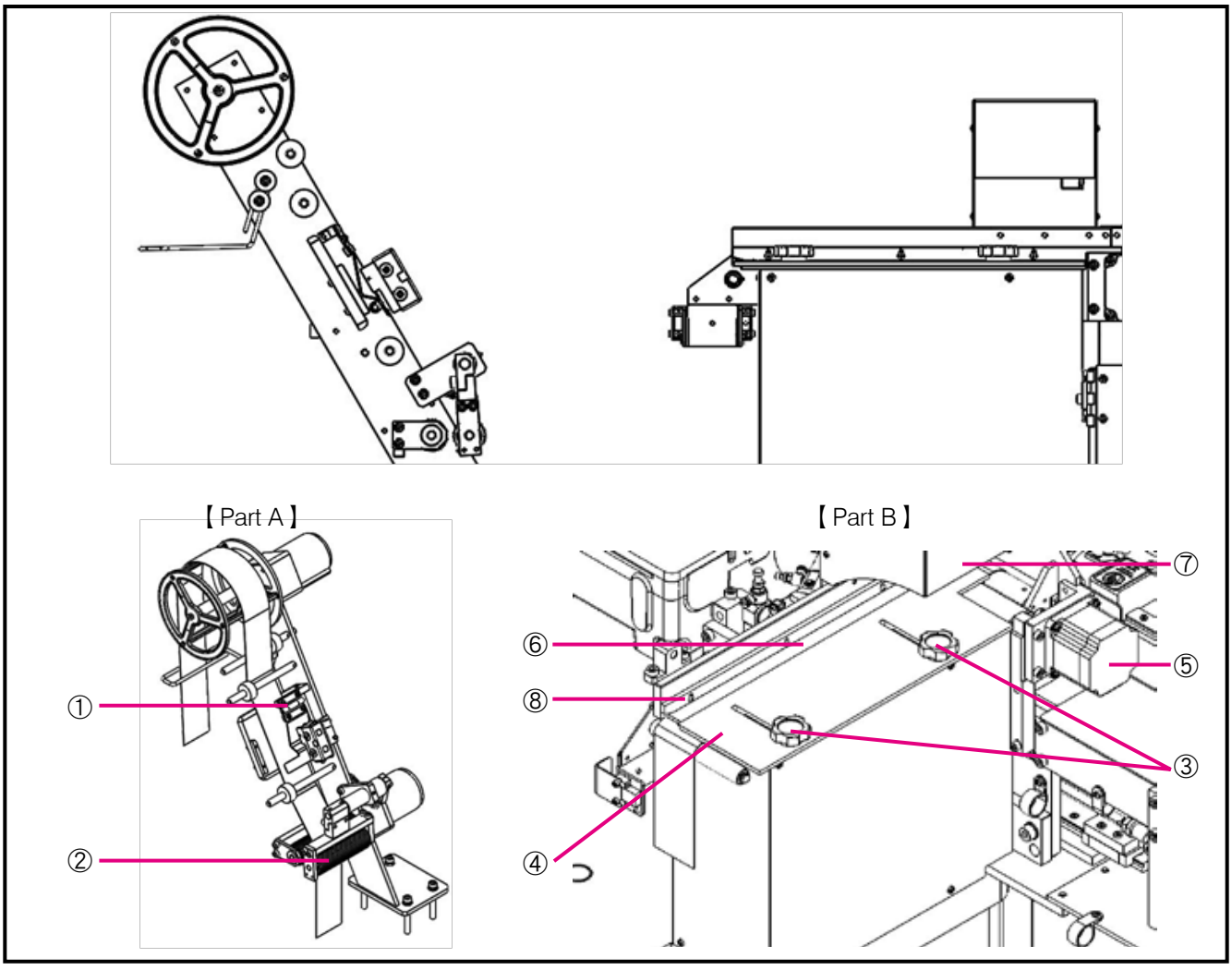
※ 請注意：鬆緊帶有扭曲或皺褶可能影響品質甚至導致機器受損。

A 區部分：

掀開鐵片①和輔助滾輪 ②。讓鬆緊帶依序穿繞而過 (*1)

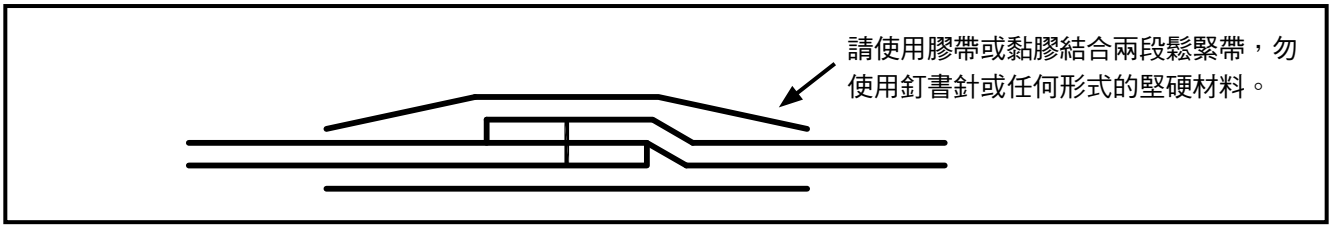
B 區部分：

1. 將鬆緊帶拉至平台 ④上方，並沿著軌道⑥平放，鬆開螺絲③配合鬆緊帶的寬度做調整。
2. 扳開送帶滾輪⑤並讓鬆緊帶垂降進入送帶滾輪⑦內。 (*2) 確認鬆緊帶有緊貼壁面⑧。接著打開電源開關。(P.10)



備註：*1：鬆緊帶穿繞過送料裝置的方法，請參考下頁說明。

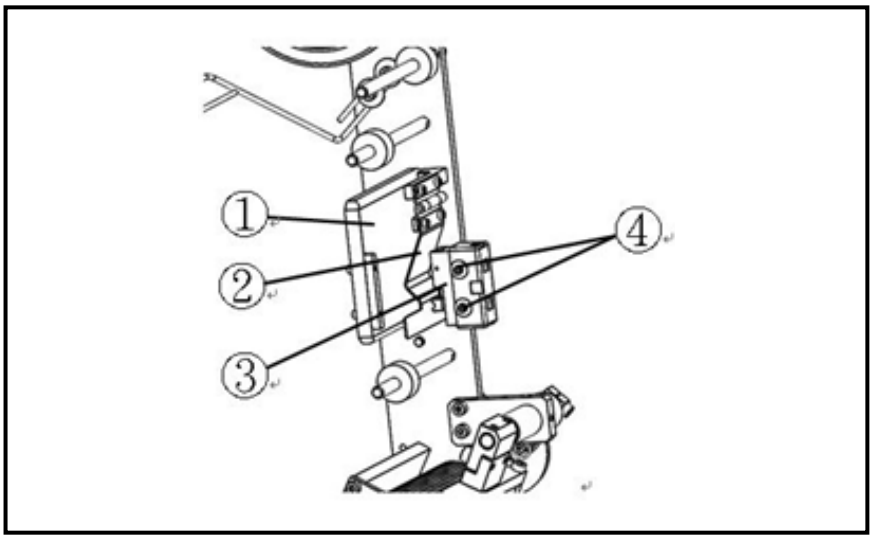
*2：鬆緊帶只需稍微被滾輪夾住即可，毋須用力推擠。



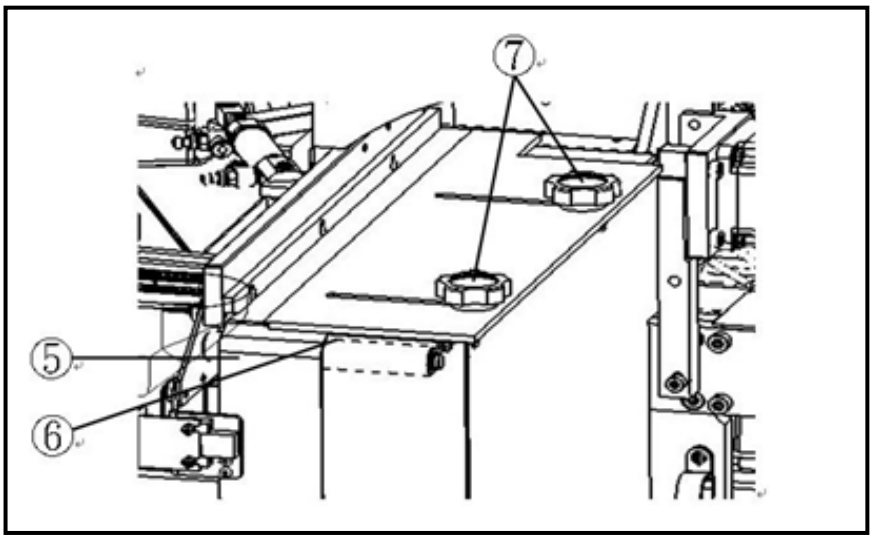
鬆緊帶的設置和安裝

使用不同寬度或厚度的鬆緊帶，以及首次使用機器時請依以下步驟調整。

1. 接縫感應器的調整：
鬆緊帶會經過金屬板①和壓板②中間，操作者可能需要調整壓板②和感應器③之間的距離。 鬆開感應器上的螺絲④，並移動感應器以設定感應啟動的時機。(約為使用鬆緊帶的兩倍厚度)

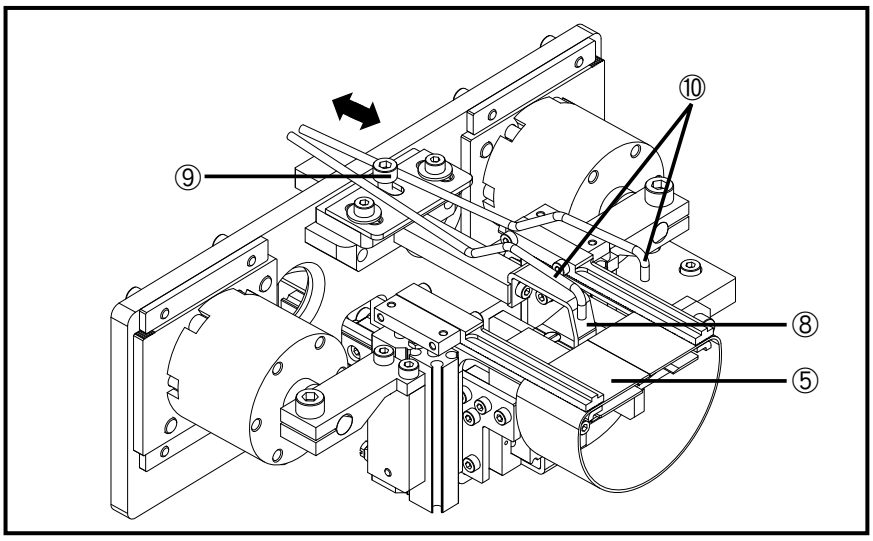


2. 進帶軌道調整：
鬆開側擋片上的兩顆旋鈕⑦，並依據鬆緊帶的寬度往內推，且鬆緊帶能順暢移動 (可保留大於鬆緊帶 1mm 寬的間隙)。設定完成後請鎖緊旋鈕⑦。



3. 調整鬆緊帶預備車縫的零件：
鬆緊帶兩端的邊緣⑤必須與後方的輔助推桿⑧呈一直線。
鬆開螺絲⑨並移動輔助推桿緊靠鬆緊帶邊緣。最後將螺絲 ⑨ 鎖緊。

4. 假如鬆緊帶會甩動或抖動，調整吹氣管⑩的氣流量，直到鬆緊帶⑤不會抖動。

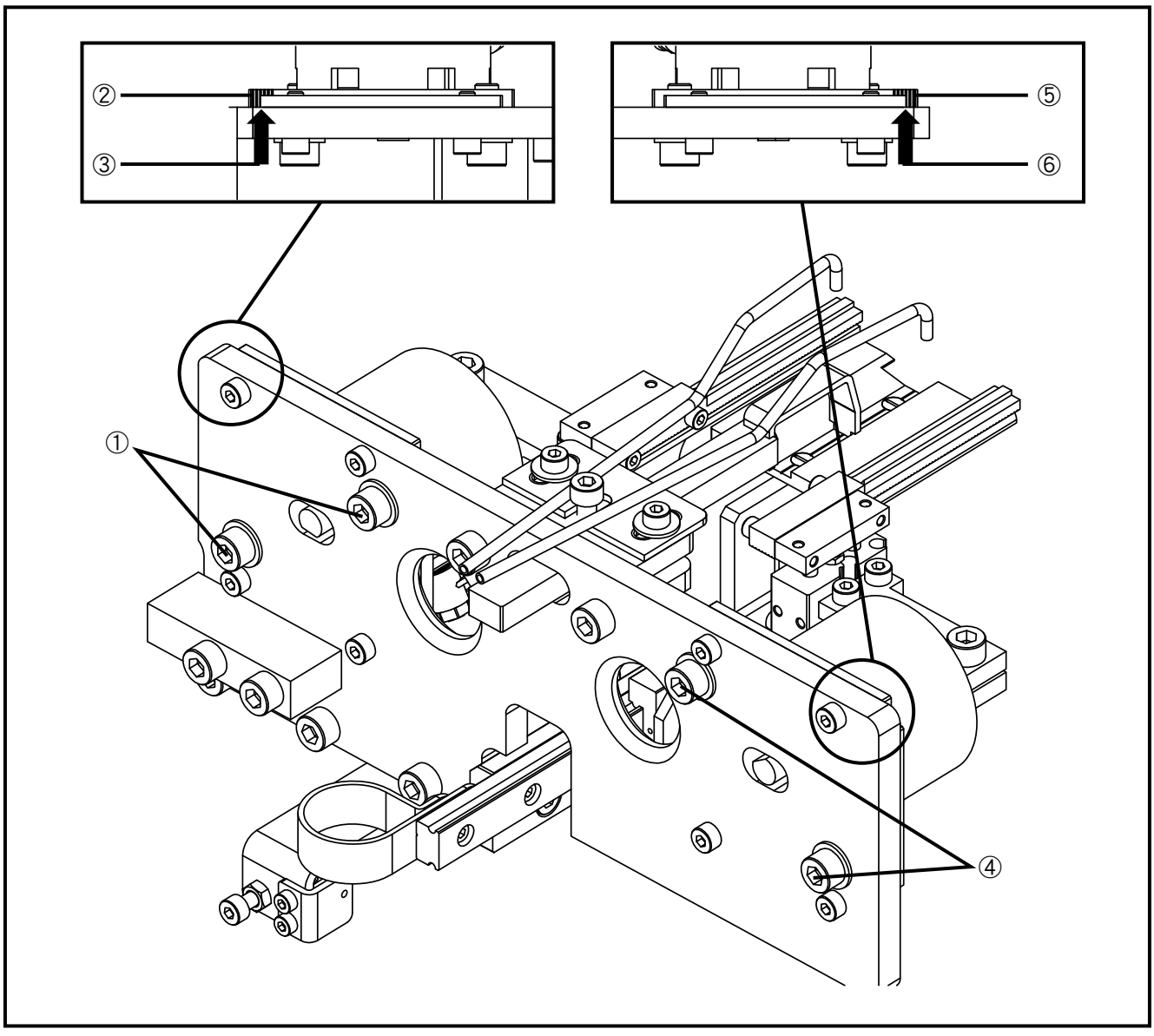


鬆緊帶的重疊範圍設定

第一部分：初始化機械設定 (出廠已預先調校好。除非重疊量需大於 11mm 以上，否則無需執行以下一到五的步驟)。

一般操作設定，請參考控制面板的說明頁面。

1. 鬆開螺絲 ① , 移動左側汽缸座 ②的位置至需求的位置。 (預設位置為第三條紅線處 ③).
2. 鬆開螺絲 ① , 移動右側汽缸座 ⑤的位置至需求的位置。 (預設位置為第三條紅線處 ⑥).
3. 請在「測試模式」中進行確認 (操作方式請參考「測試模式」的說明頁面)。
4. 裁切後的鬆緊帶兩端 (⑥ / ⑦) 必須對齊進帶托盤中央的紅色記號線⑨。若未對齊，重複步驟一和二的調整以確保鬆緊帶能對齊紅線。
5. 所有機械部分的調校已在出廠前測試完畢。

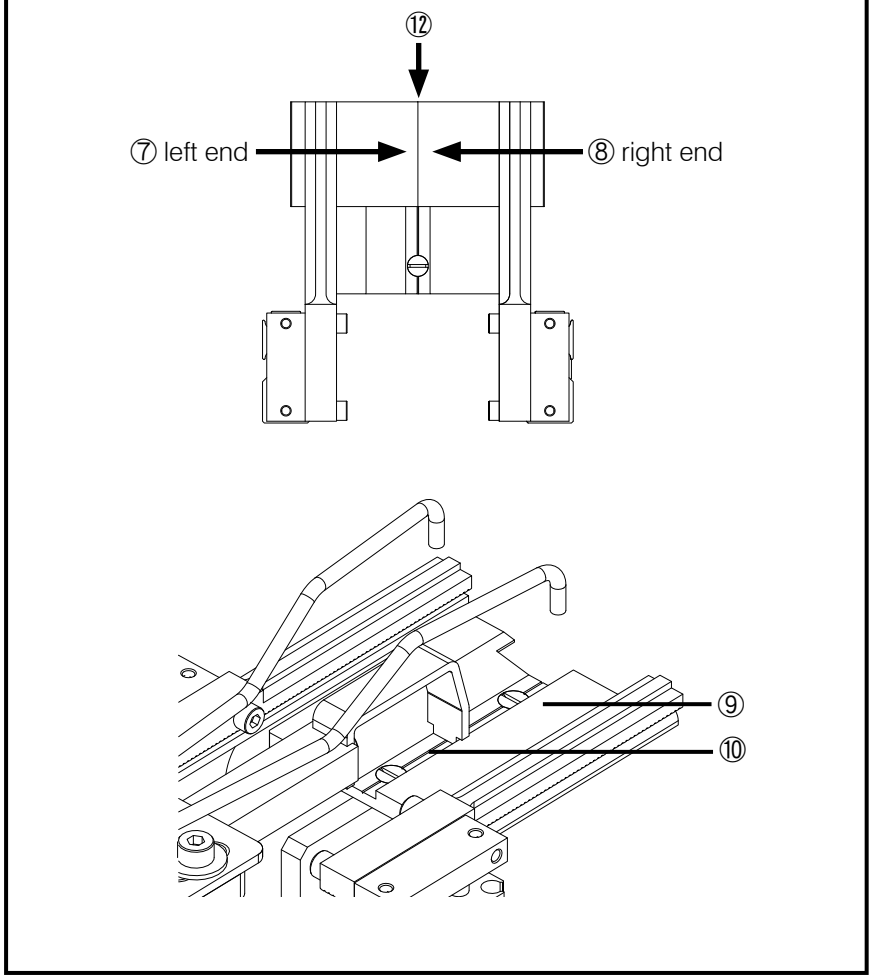


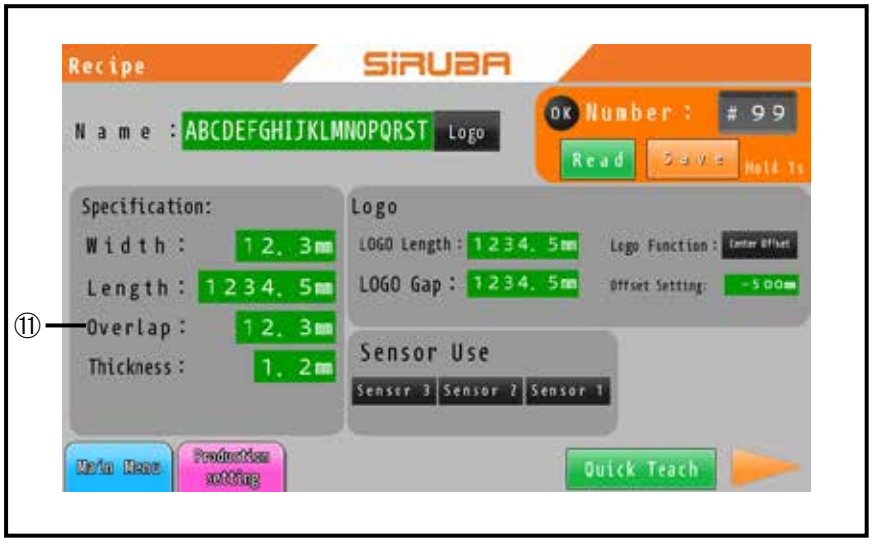
第二部分：重疊設定的操作方式。

6. 當鬆緊帶準備送上縫紉機縫製時，鬆緊帶的左側切口⑦和右側切口⑧ 必須與進帶托盤⑨紅線呈一直線⑩。

7. 在控制面板上，重疊量的設定影響鬆緊帶兩端切口的結合狀況。 通常設為 0，兩端會平整接合在紅線中央處　。

8. 要增加重疊的範圍，請調大數值 (最大可到 30mm)；反之亦然。

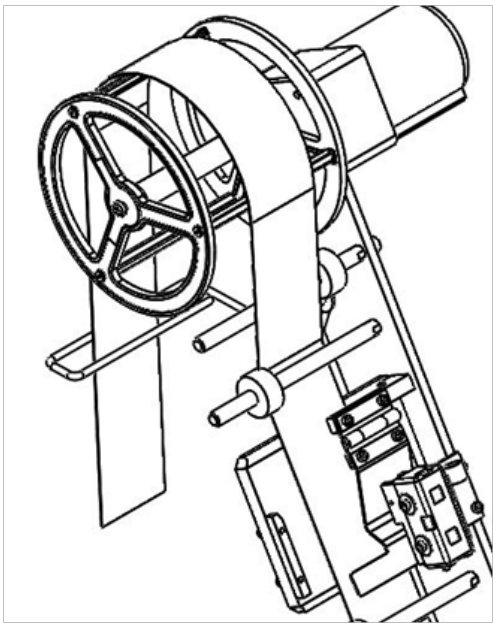




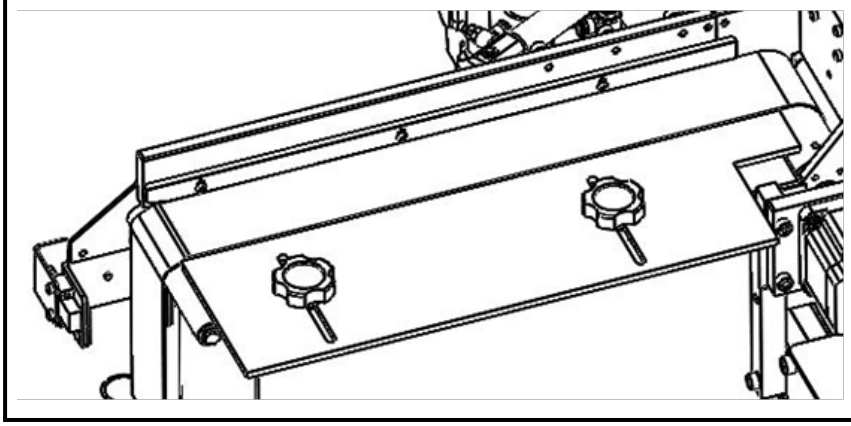
更換不同尺寸的鬆緊帶

要變更不同寬度或厚度的鬆緊帶時，請遵循以下步驟：

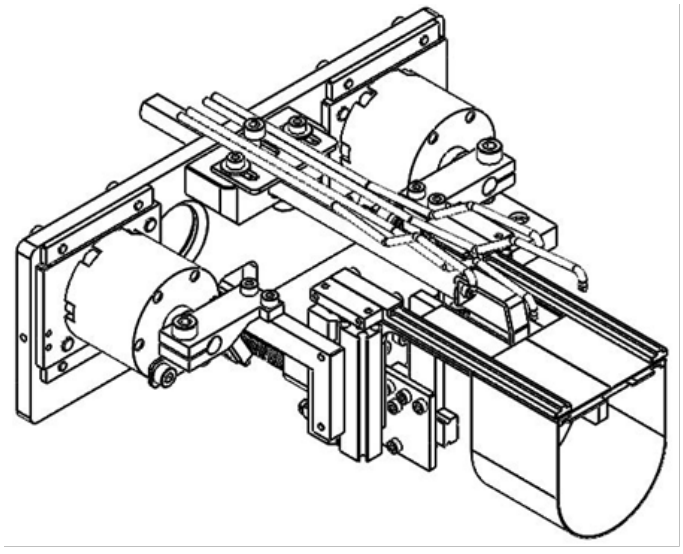
1. 調整接縫感應器：將鬆緊帶放入金屬板①和壓板②。根據鬆緊帶的厚度調整感應器的啟動範圍。鬆開螺絲④接著往左或右移動感應器，將金屬板②和感應器③之間的間隙設為鬆緊帶厚度的兩倍。



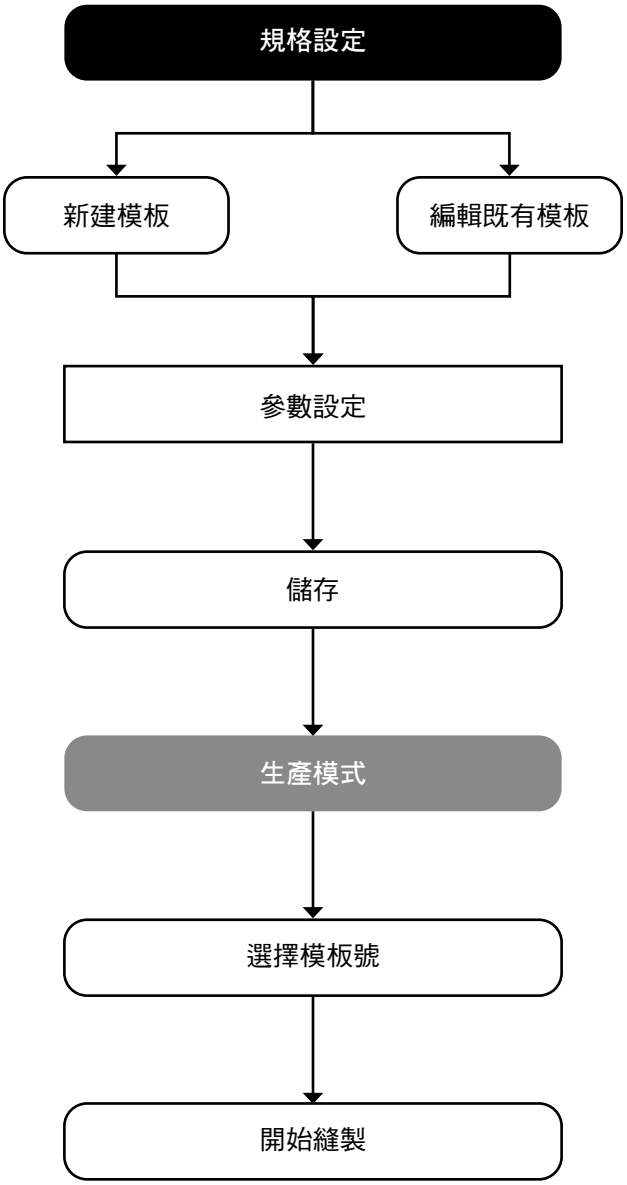
2. 配合鬆緊帶的寬度調整：鬆開旋鈕 ⑦ ，將鬆緊帶 ⑤ 放在軌道⑥上，並依據寬度設定軌道寬度 (建議留有 1mm 的間隙以確保帶子移動順暢) 鎖緊旋鈕 ⑦。



3. 送帶托盤的調整 : 鬆開螺絲⑨ 進行調整，鬆緊帶的邊緣 ⑤ 必須緊貼軌道壁面 ⑧。
4. 若鬆緊帶無法平貼於托盤，調節吹氣量 ⑩ 直到鬆緊帶 ⑤ 保持平整。



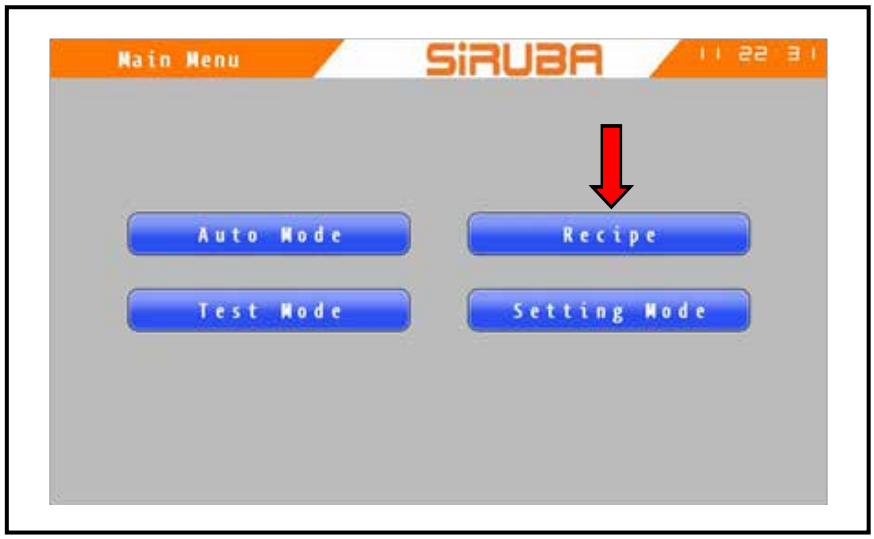
運轉流程



規格設定

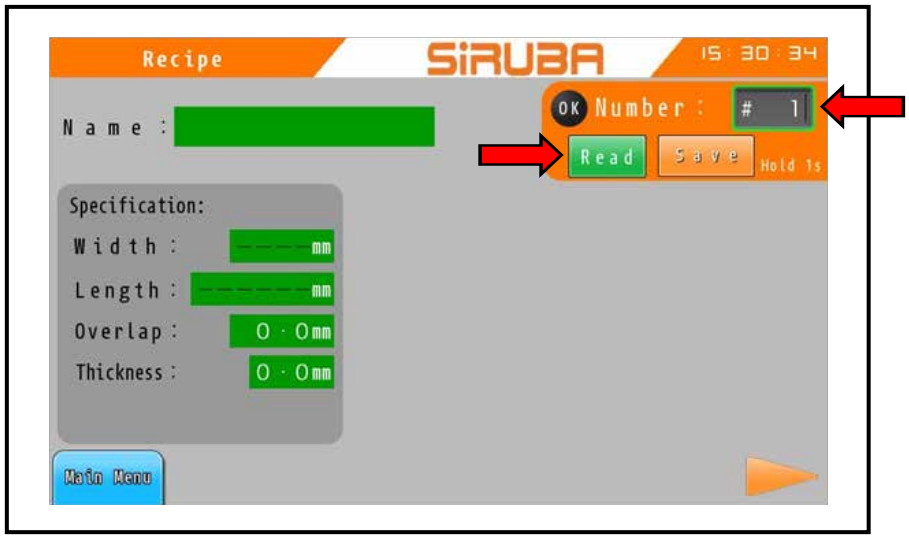
1. 觸控螢幕任何地方以進入主畫面。

2. 選擇「規格設定」。



A. 編輯既有的模板 :

1. 點選「編號」旁的數字欄 。輸入要修改的模板編號，並點選「讀取」鍵載入參數。
2. 依照下頁流程 B 和 C 的步驟編輯參數，並長按「儲存」鍵兩秒以上，且「OK」鍵亮綠燈。
3. 點選「主畫面」鍵離開本頁。. 進入「生產模式」頁面確認相關參數是否為更正後資料。

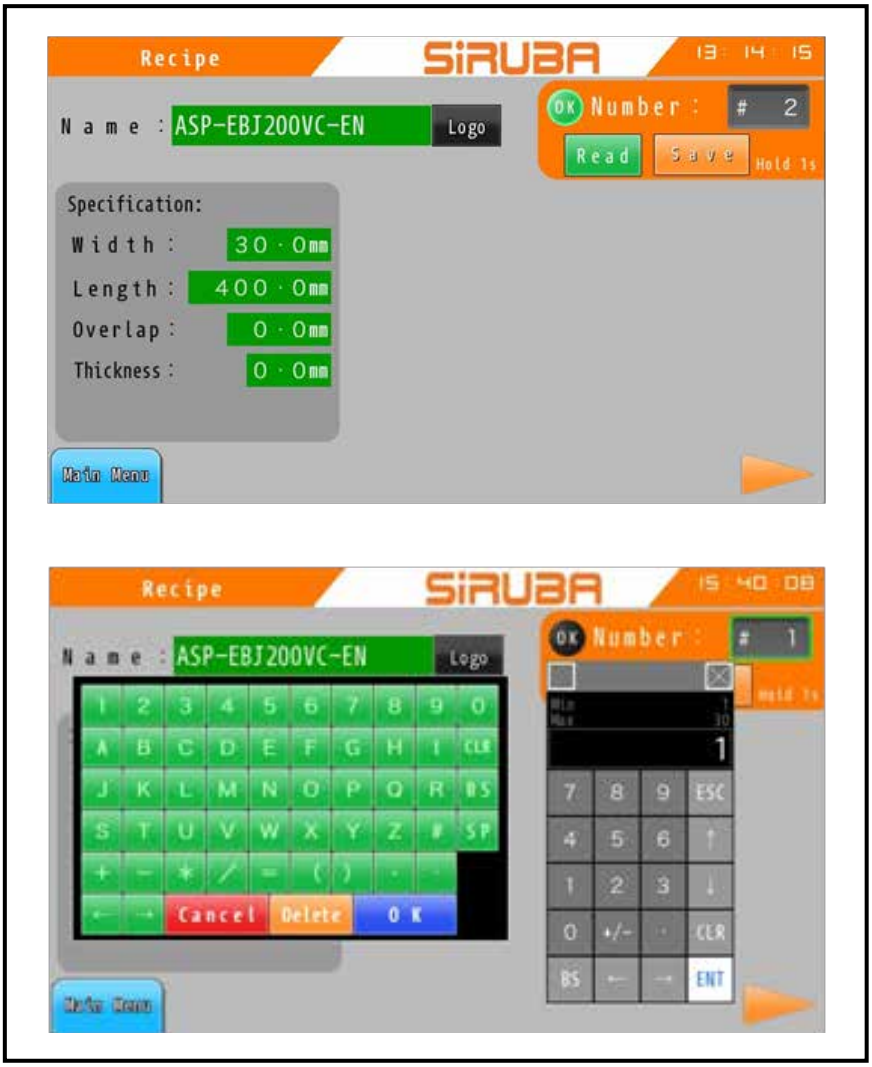


B. 建立沒有 LOGO 辨識功能的模板 :

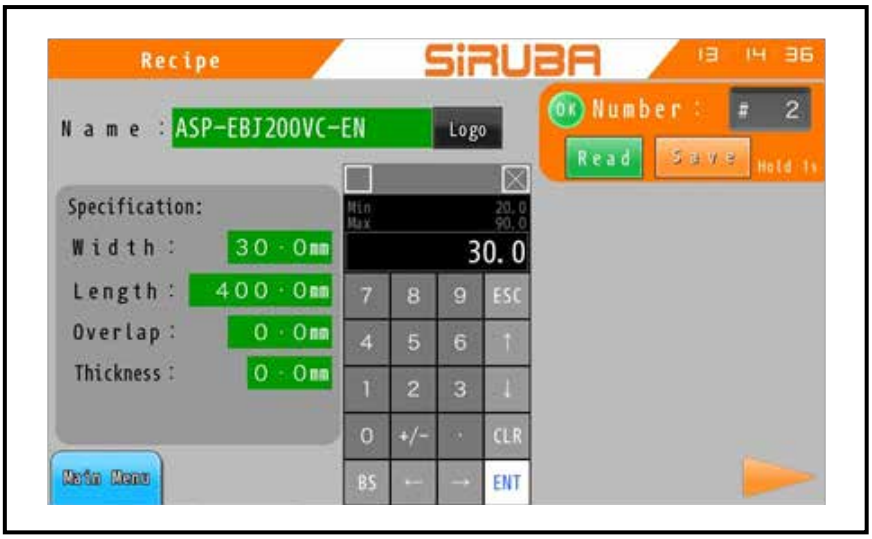
1. 點選「產品名稱」旁的綠色欄位進行當前模板的命名。.

2. 點選「LOGO」鍵關閉 LOGO 辨識功能 (燈號必須熄滅)

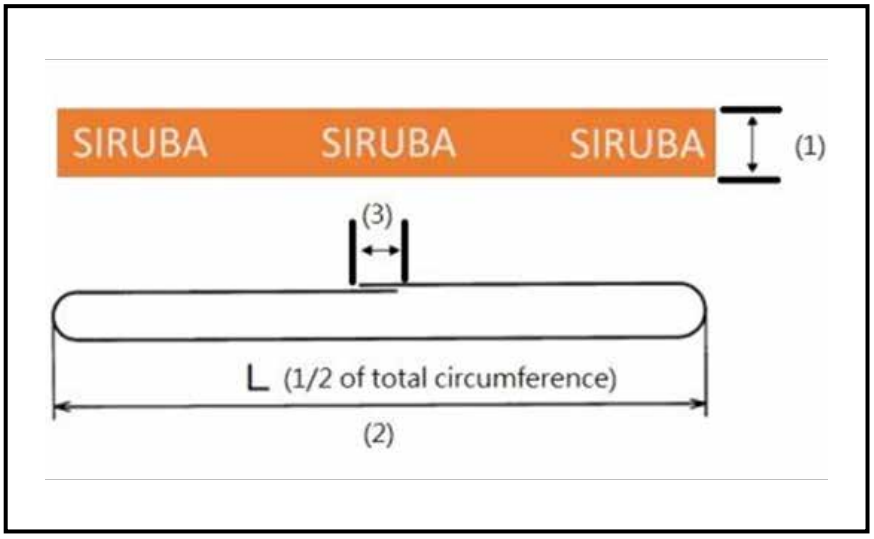
3. 點選「編號」旁的數字欄，。修改選擇的模板。並請勿與系統既存的模板編號重複，以免覆蓋其他編號的內容。



4. 點選綠色欄位，逐筆輸入「產品規格」區 的數值。 可使用送帶軌道上的尺標協助測量。.
   (1) 寬度 : 20 ～ 50mm (使用 Juki LK1920 縫紉機時) ; 20 ～ 90mm (使用 Juki AMS 縫紉機時)
   (2) 對折長度 : 150 ～ 990mm (帶圈成品周長為 300～1980mm)。
   (3) 重疊量 : 0 ～ 13 (效果取決於鬆緊帶的品質，請依據成品的狀況依需要微調。)
   (4) 厚度補償 : 依使用鬆緊帶的厚度設定，亦可由系統自行估算 (教導前設為 0 即可)。



5. 長按「儲存」鍵兩秒以上，直到「OK」鍵亮綠燈。.
6. 點選「主畫面」鍵離開本頁。
7. 前往「生產模式」並讀取該模板資料。試做一件樣品確認成品效果。若有需要，可回到「規格設定」頁面重新調整參數。

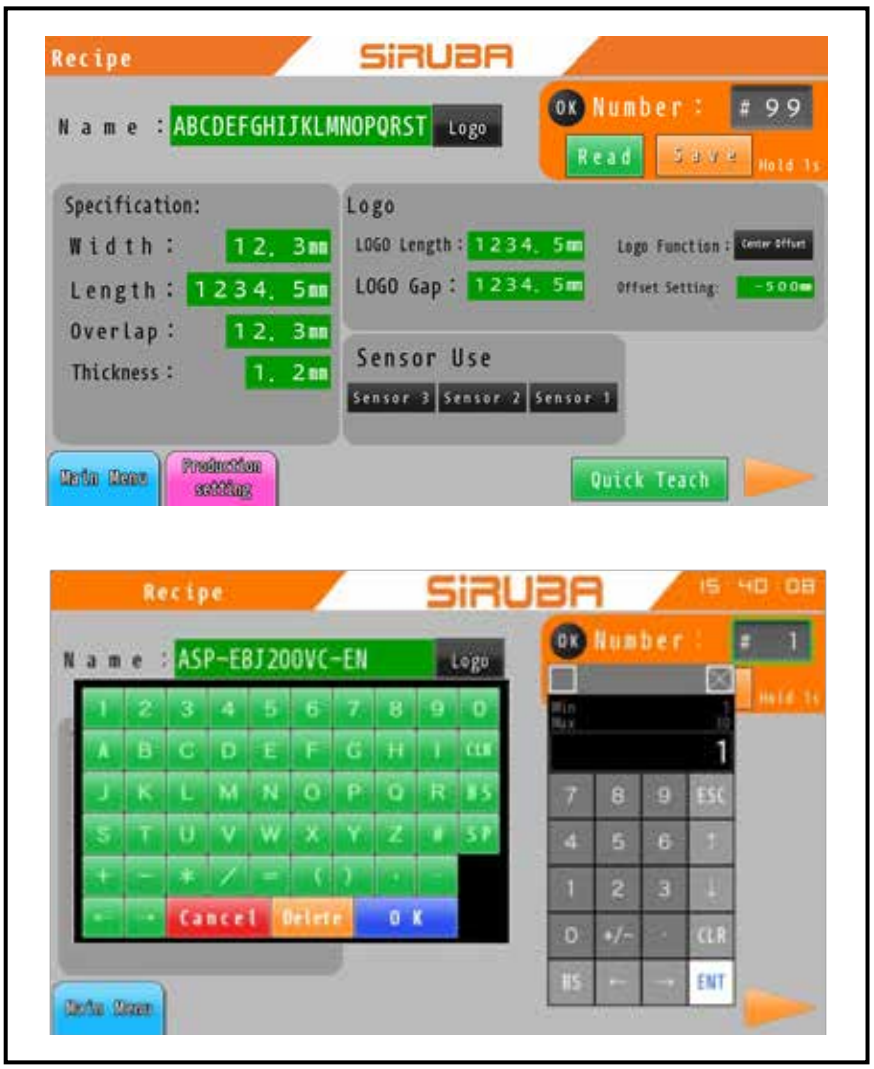


C. 建立有 LOGO 辨識功能的模板

1. 點選「產品名稱」旁的綠色欄位進行當前模板的命名。.

2. 點選「LOGO」鍵啟用 LOGO 辨識功能 (必須亮綠燈)

3. 點選「編號」旁的數字欄，修改選擇的模板。並請勿與系統既存的模板編號重複，以免覆蓋其他編號的內容。



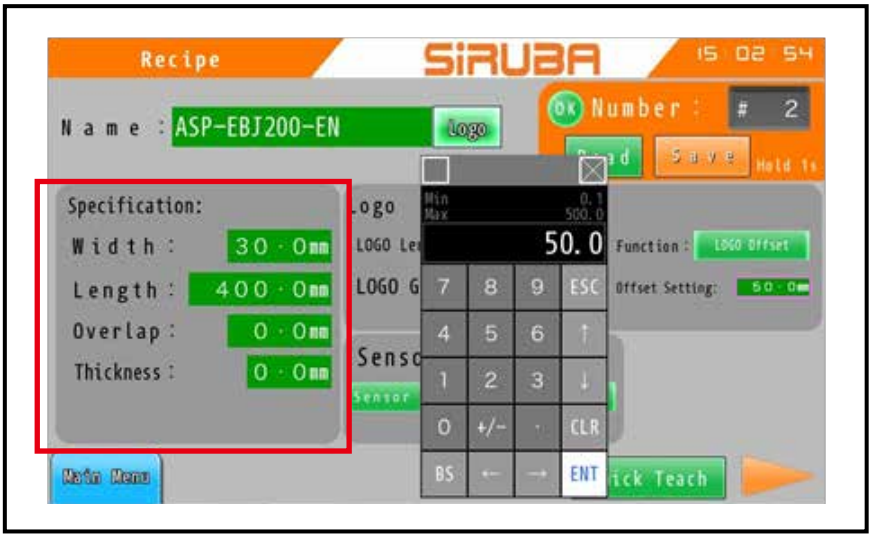
4. 點選綠色欄位，逐筆輸入「產品設定」區 的數值。 可使用送帶軌道上的尺標協助測量。

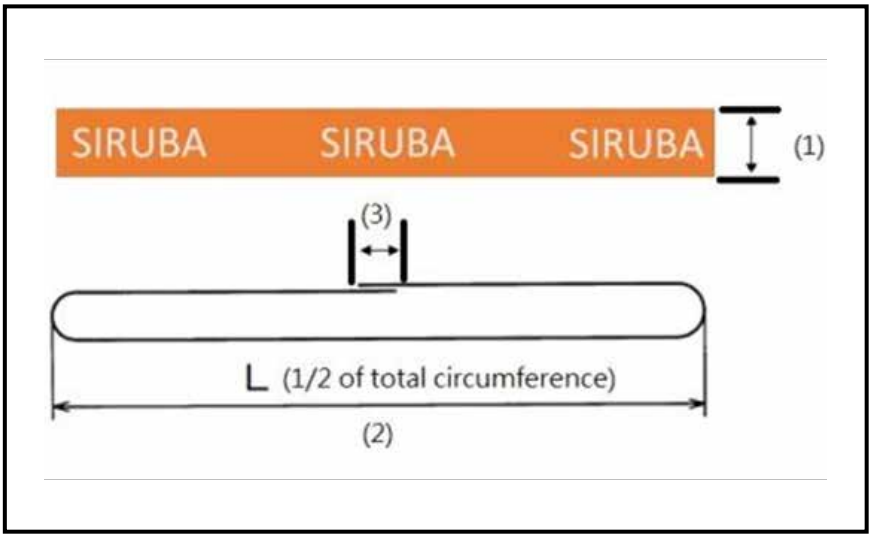
(1) 寬度 : 20 ～ 50mm(使用 Juki LK1920 縫紉機時) ; 20 ～ 90mm (使用 Juki AMS 縫紉機時)。

(2) 長度 : 150 ～ 990 (帶圈成品周長為 300~1980mm)。

(3) 重疊量 : 0 ～ 13 (效果取決於鬆緊帶的品質，請依據成品的狀況依需要微調。)

(4) 厚度補償 : 依使用鬆緊帶的厚度設定，亦可由系統自行估算 (教導前設為 0 即可)。

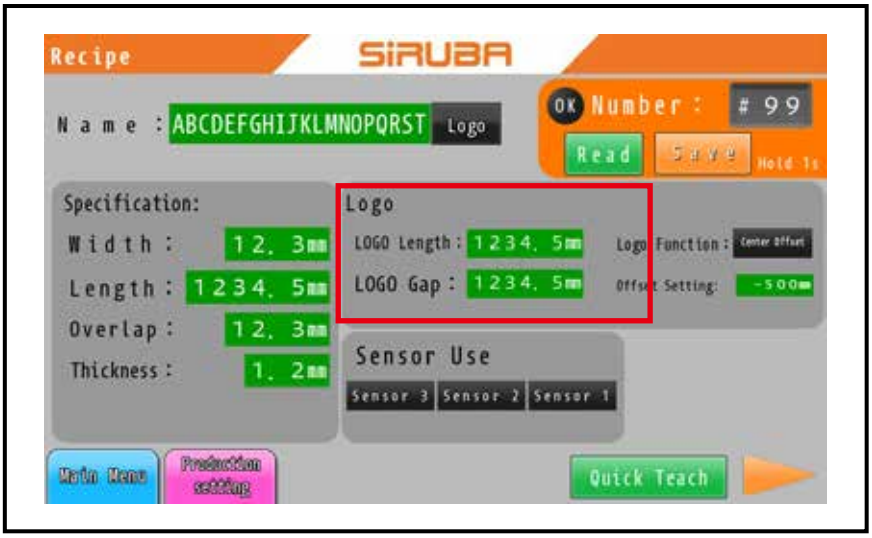




5. 點選綠色欄位，逐筆輸入「排版設定」區 的數值。 可使用送帶軌道上的尺標協助測量。.

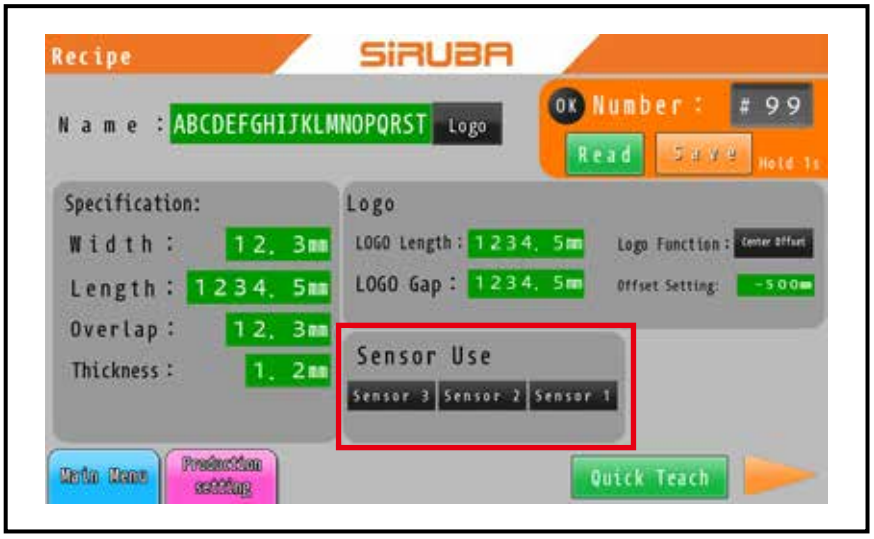
(1) Logo 長度 : LOGO 的實際總長度。

(2) Logo 間距 : LOGO 彼此之間的間距。

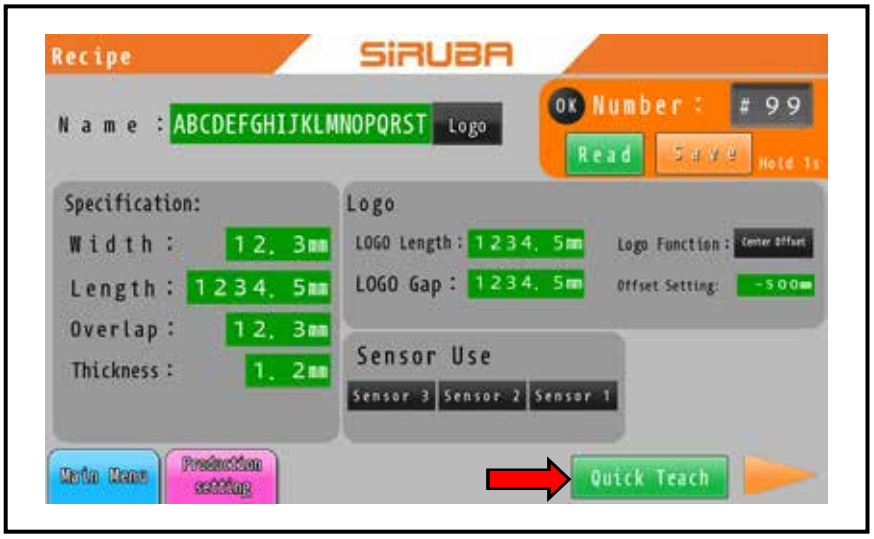


6. 電眼使用：
預設為三個電眼全部啟動。 我們強烈建議不要關閉任何電眼。

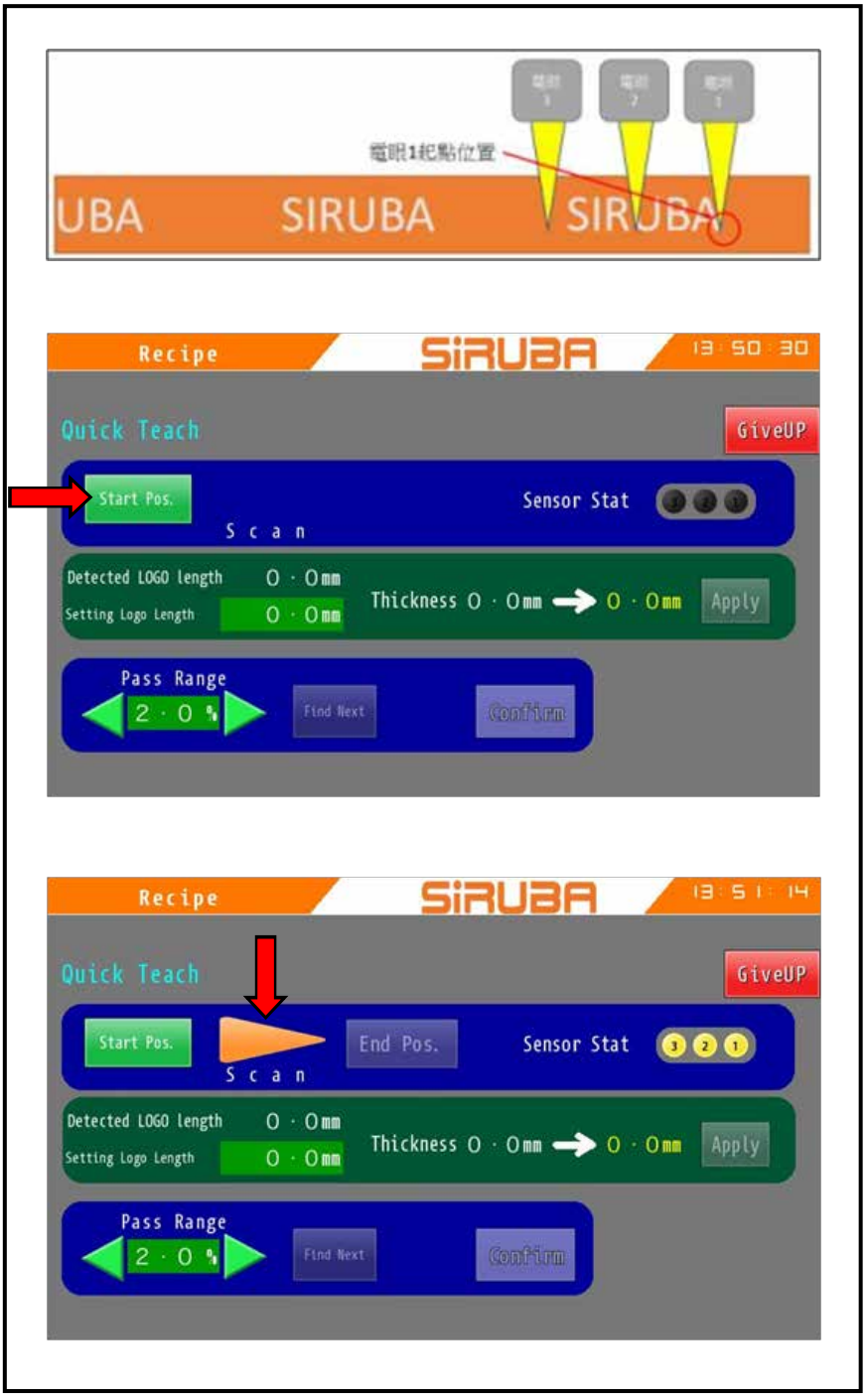
※ 假如電眼有故障，在你等待替換零件時，請先關閉該電眼。 但一號電眼必須保持功能正常。



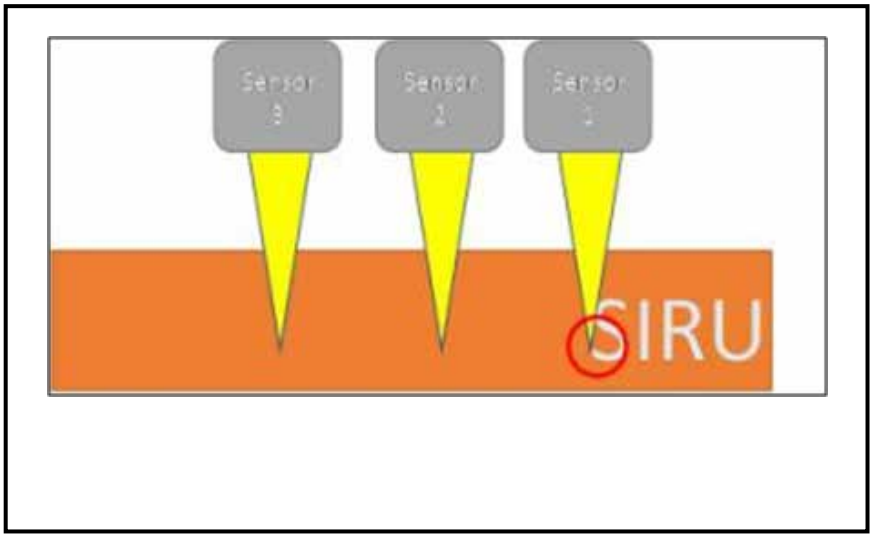
7. 點選「快速教導」鍵進入 LOGO 掃描流程。



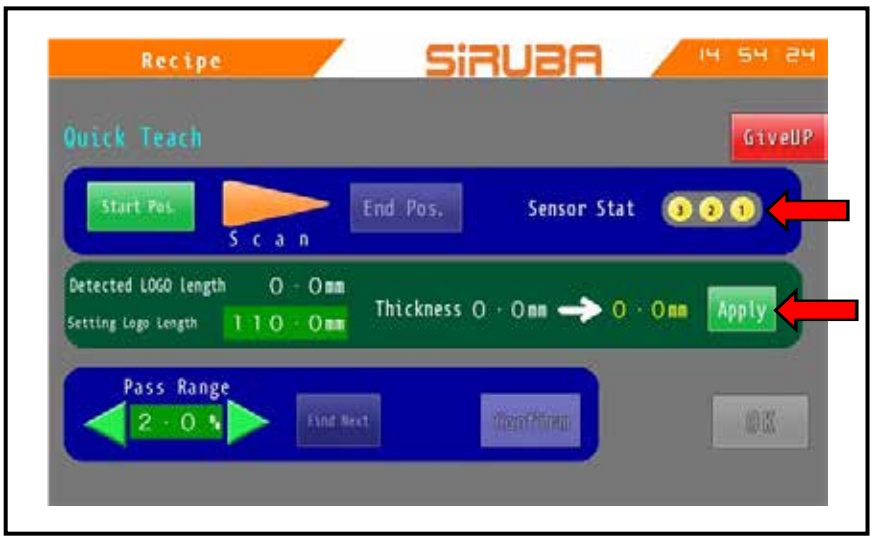
8. 拉動軌道上的鬆緊帶。使 LOGO 的起點移至一號電眼光點下，點選「設為起點」鍵，並等待「黃色箭頭」按鍵出現在右側。



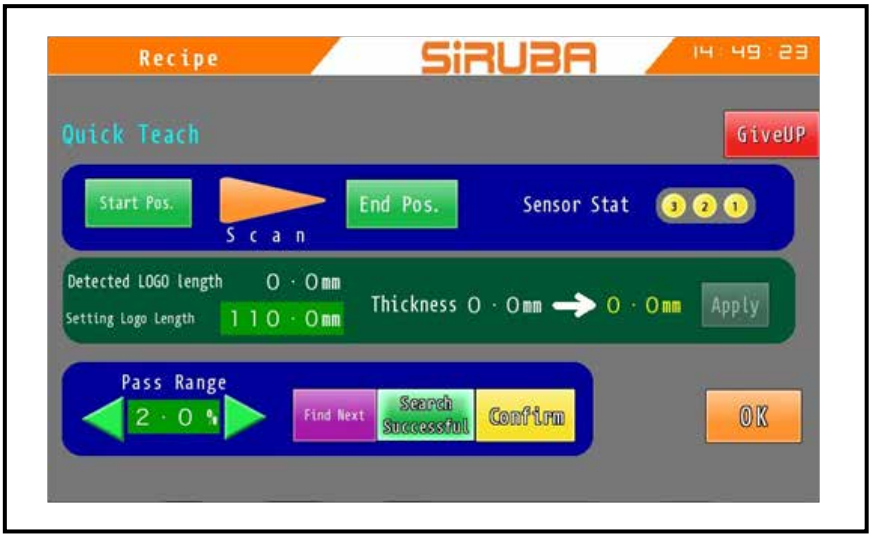
9. 當 「掃描」鍵 (黃色箭頭) 出現後，點選不放，送帶馬達會拉動鬆緊帶前進。
當鬆緊帶的結尾處通過一號電眼亮點下即可放手。 點選「設為終點」鍵完成掃描。



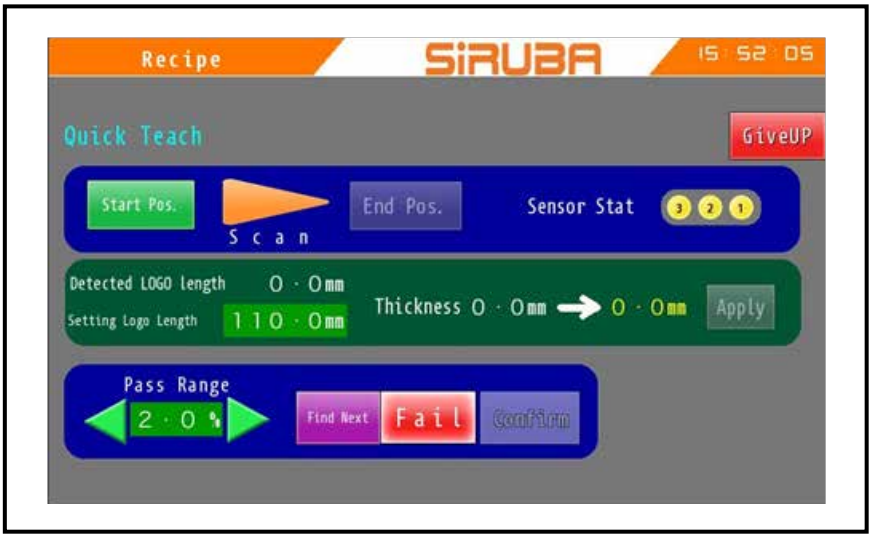
10. 若無任何異常，點選「採用」鍵。
反之， 點選「放棄」鍵重做 LOGO 掃描。



11. 接著點選「採用」鍵 ，「找下一個」鍵會出現在螢幕上。 點選「找下一個」鍵 驗證能否找到 LOGO。



12. 假如電眼無法偵測到 LOGO，「失敗」會顯示在右側。再次點選「找下一個」鍵驗證。
若仍失敗，可能是鬆緊帶的厚度和品質，導致設定值和實際掃描值落差太大。調整「容許相異」值並驗證是否能辨識 LOGO，或是重做一次 LOGO 掃描流程。

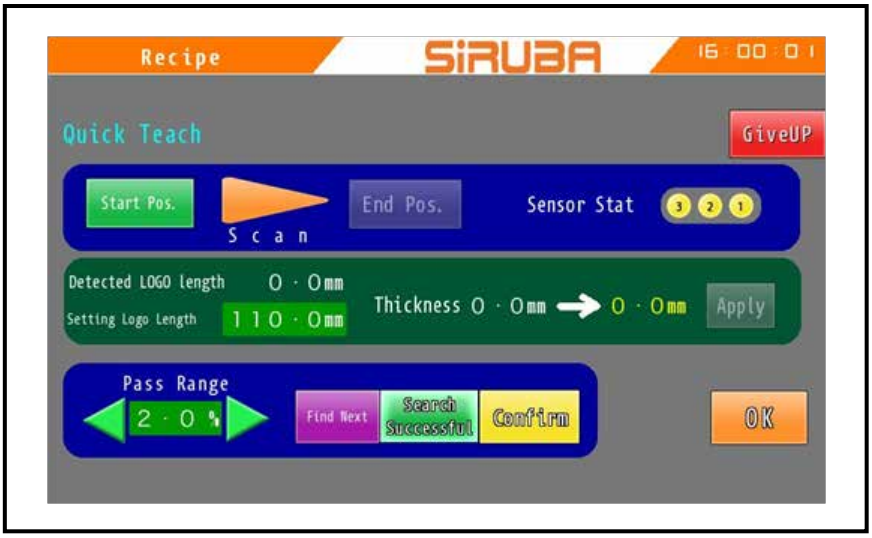


13. 若能順利偵測到 LOGO，則會顯示「搜尋成功」和「驗證」鍵。點選「驗證」鍵 確認原本設定的 LOGO 起點是否會在一號感應器的亮點下方。

14.Long 點選「OK」鍵儲存並離開。

15. 點選「主畫面」鍵離開本頁。

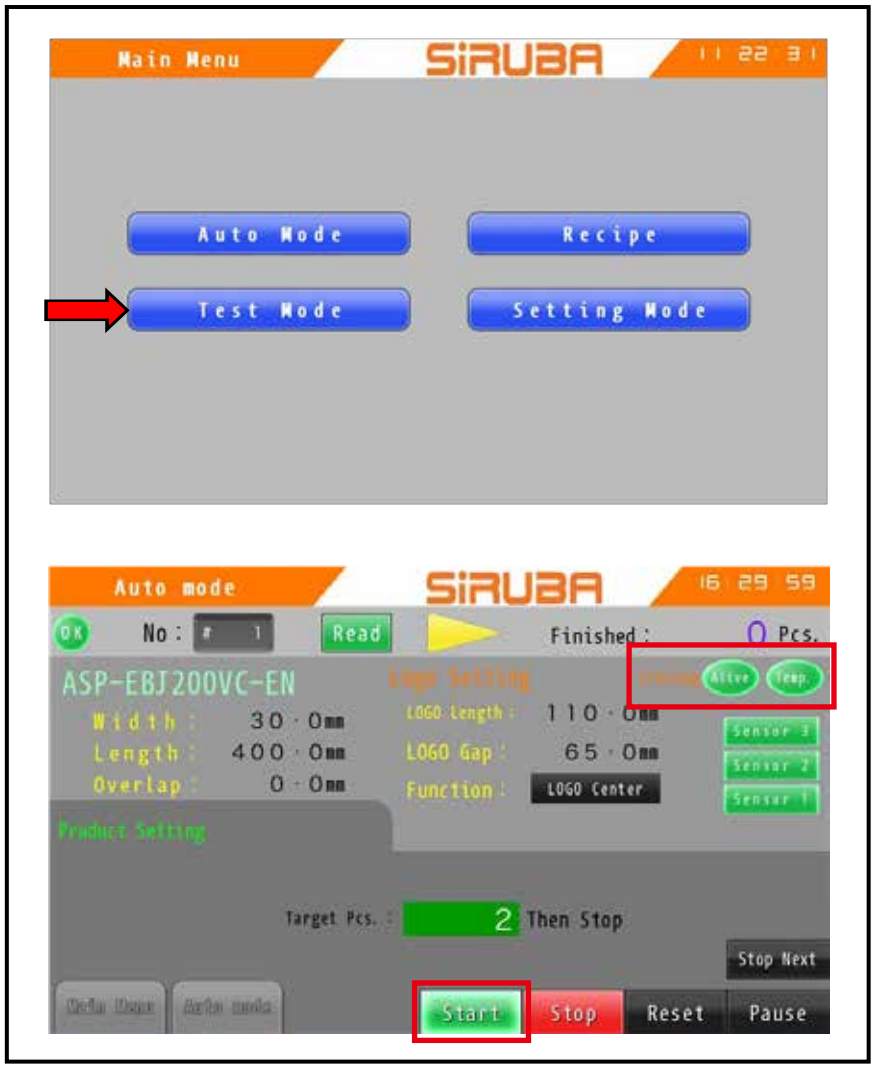
16. 前往「生產模式」並讀取該模板資料。 試做一件樣品確認成品效果。若有需要，可回到「規格設定」頁面重新調整參數。



生產模式

In Main Menu, 點選「生產模式」鍵進入頁面。

※ 假如有連接 Siruba 的整燙機 (EBI-100)，頁面將會顯示相關訊息。 每次重新執行縫製循環時，點選「開始加熱」鍵啟動整燙功能。



1. 點選「編號」旁的欄位，輸入欲使用的模板編號 ，接著點選「讀取」鍵載入該編號的參數設定。

2. 點選「連續生產」旁的欄位，輸入本批次需生產的數量。

3. 點選「開始」鍵進行縫製。
機器將會持續運轉直到目標數量生產完成或有異常發生導致暫停。

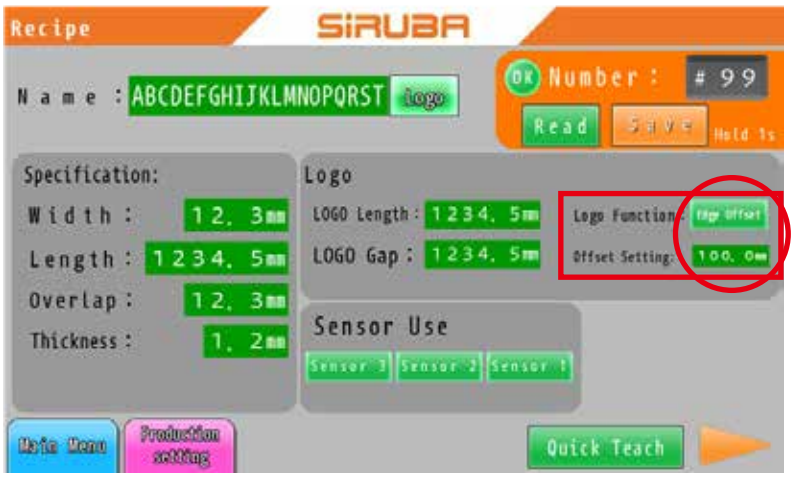
4. 要恢復停止或被中斷的工作，點選「暫停/重置鍵」(假如有出現)解除鎖定。 若鬆緊帶仍在夾爪上，點選「放開鬆緊帶」鍵即可取下。 接著點選「開始」鍵恢復運轉。

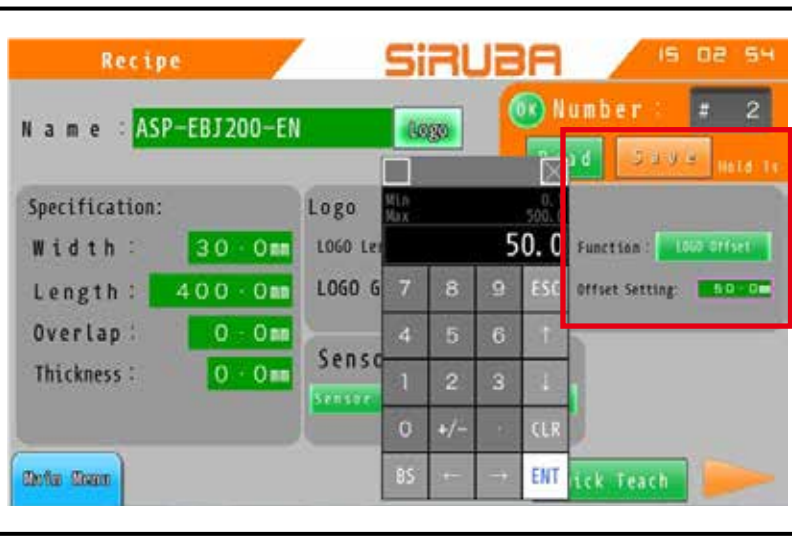
5. 生產完成後須手動將計數器清零，點選「清除已生產數量」。

LOGO 偏移

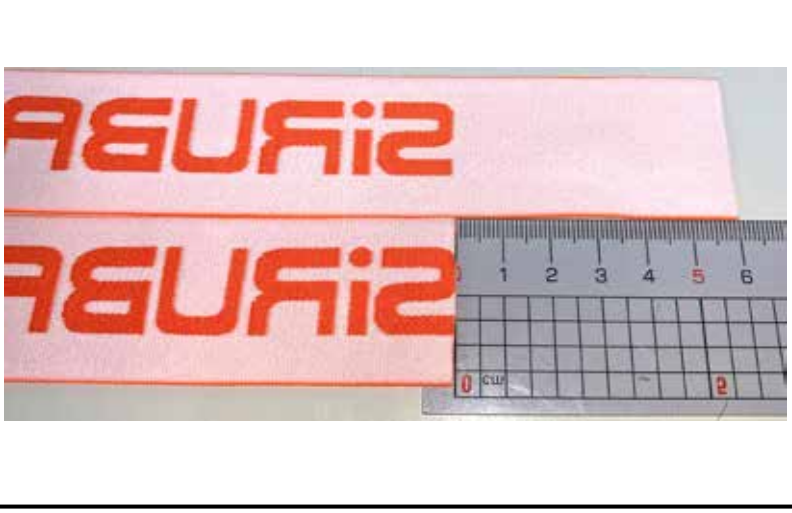
LOGO 功能 (LOGO Function) 中有以下兩個模式可以設定

1. 邊緣偏移 (Edge Offset)
   邊緣偏移可設定數值為 0 至 140 mm

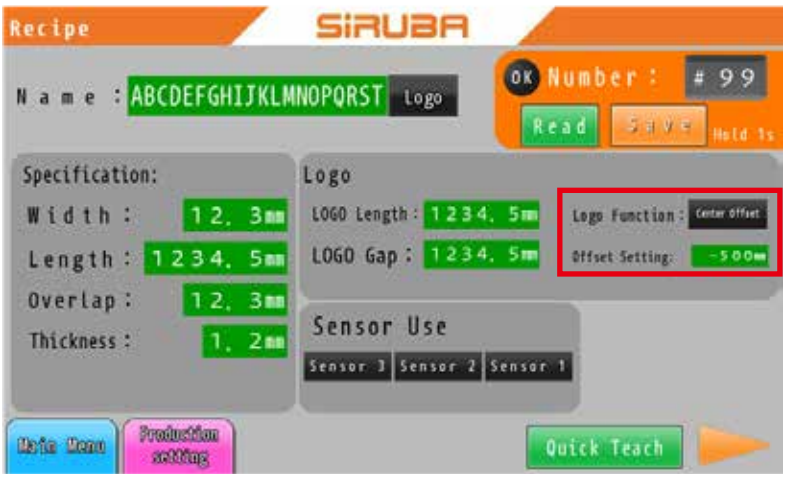




依右圖所示
OffSet Setting 設置為 60mm 時，切刀位置會切在距離 LOGO 頭 60mm 的地方。 (上面那條)
OffSet Setting 設置為 0mm 時，切刀位置會切在 LOGO 頭。(下面那條)



2. 置中偏移 (Center Offset)
置中偏移可設定數值為 -500 至 140 mm

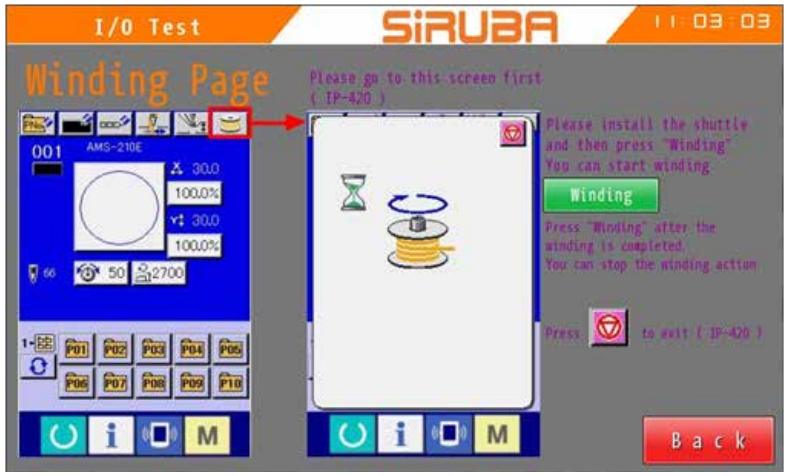


依右圖所示
OffSet Setting 設置為 +50mm 時，LOGO 會向右偏移 50mm (上面)
OffSet Setting 設置為 0mm 時，LOGO 在正中間 (下面)

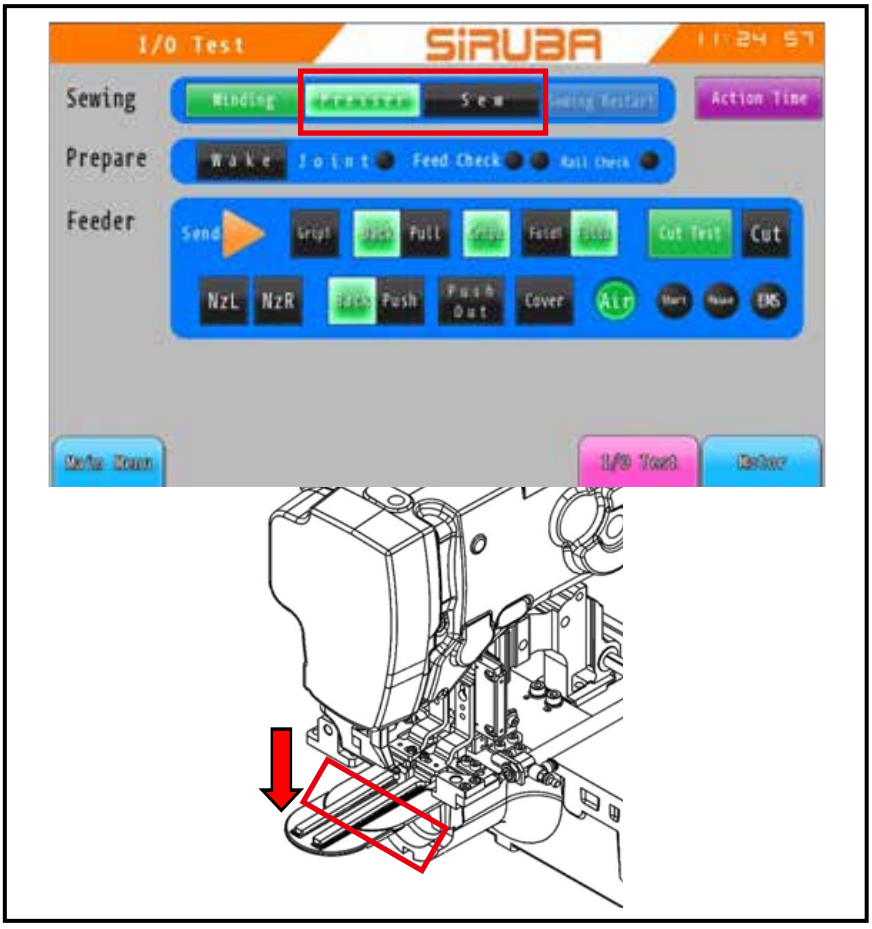
依右圖所示
OffSet Setting 設置為 -60mm 時，LOGO 會向左偏移 60mm (上面)
OffSet Setting 設置為 0mm 時，LOGO 在正中間 (下面)

「測試模式」

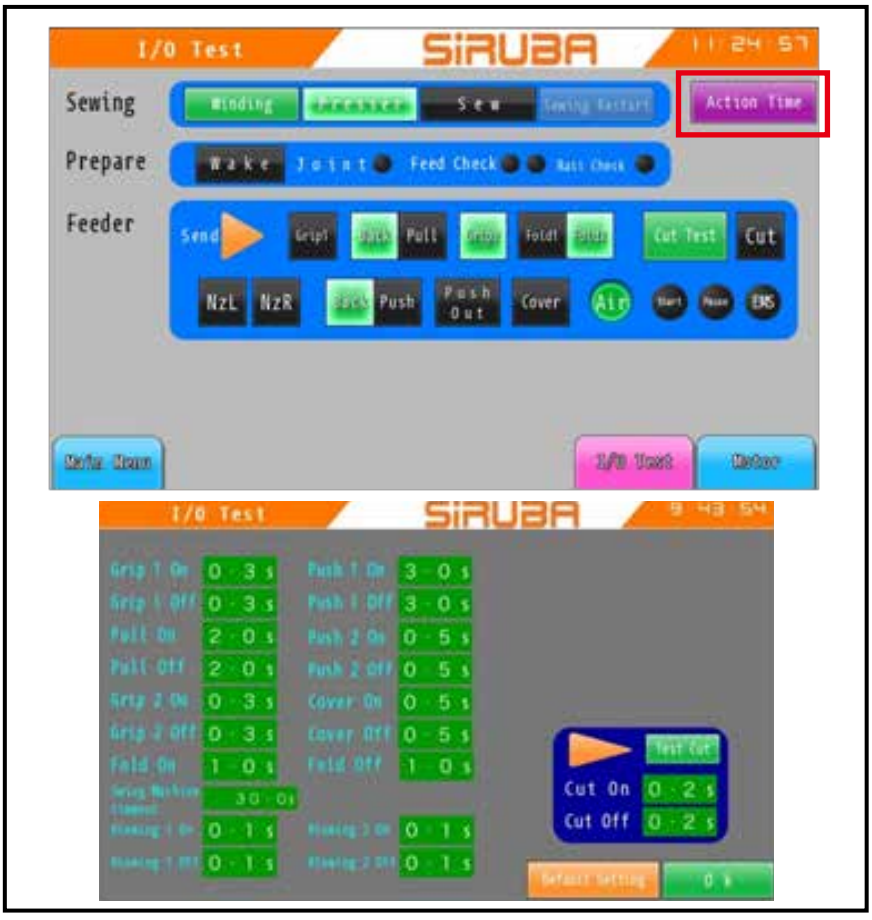
1. 捲線功能
   點選「捲線」鍵並配合縫紉機操控面板的指示即可進行捲線。



2. 縫紉測試 (需先選擇欲使用的花樣圖型)。 放入布料 (鬆緊帶)，點選「壓腳」鍵控制其升降，再點選「起縫」鍵開始縫製。

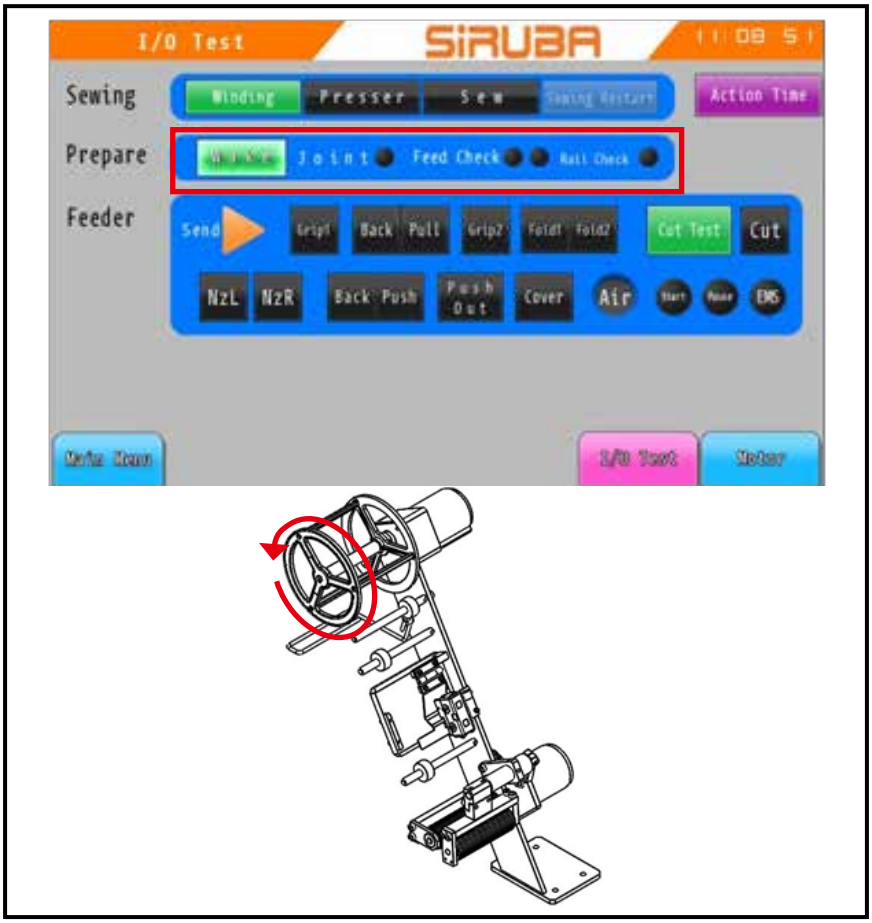


3. 參數設定
設置各個汽缸的動作時間 (預設值如圖面所示)。

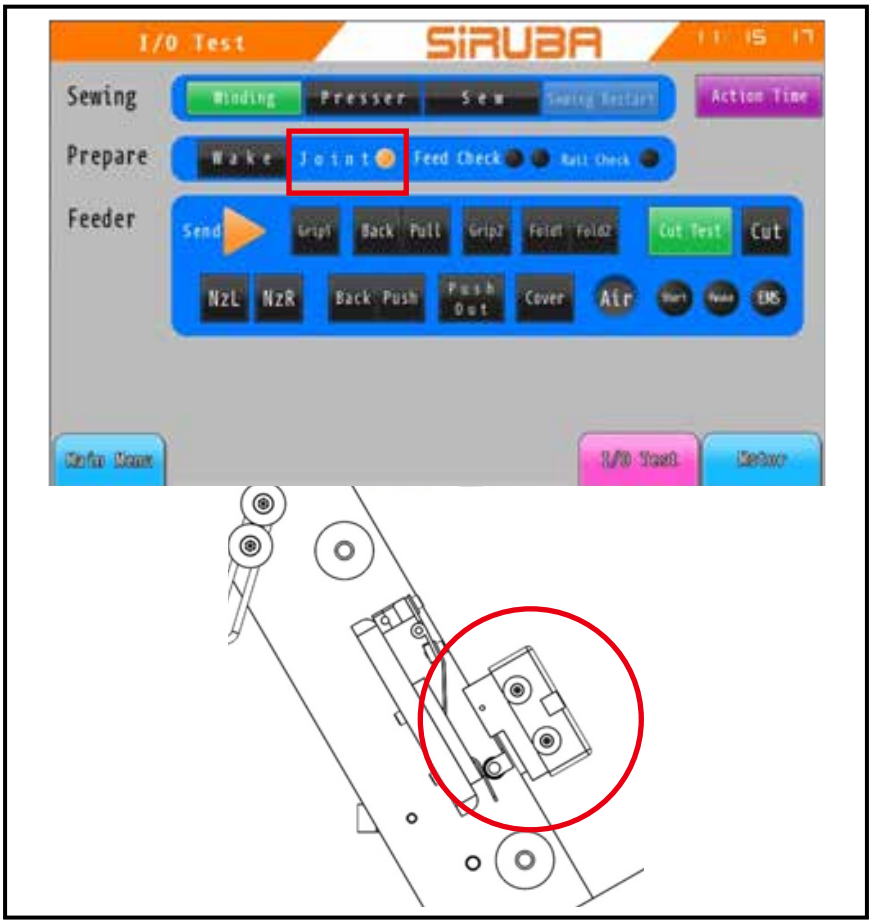


4. 送料測試

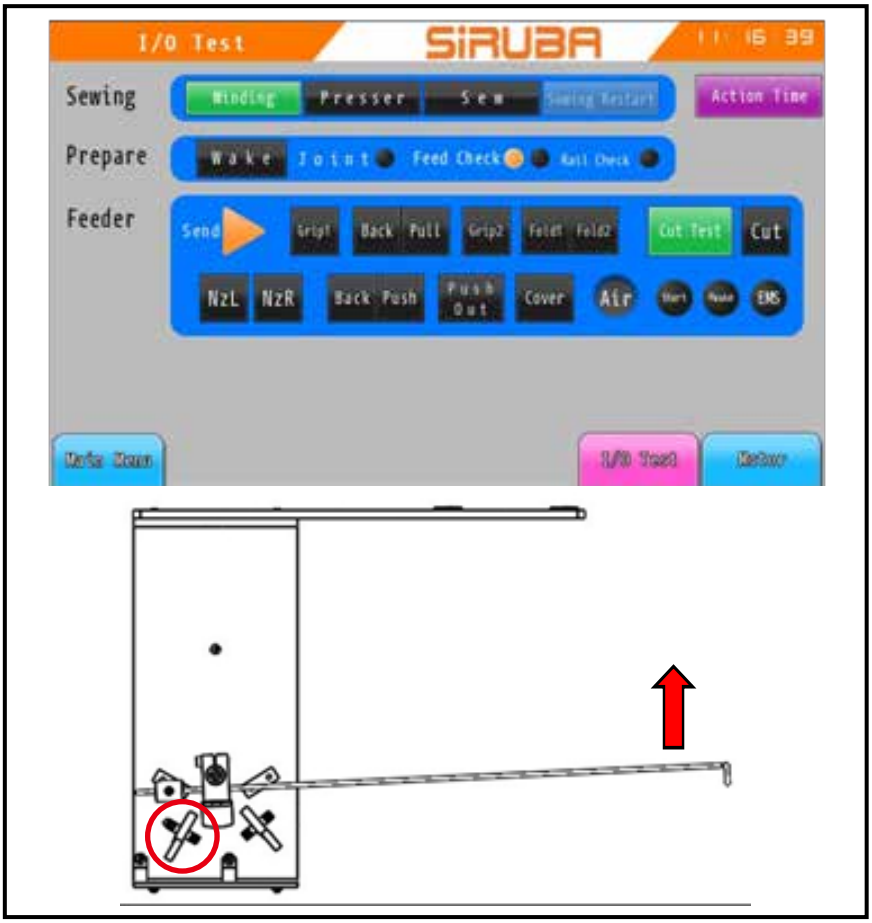
(1) 點選「醒帶」鍵測試馬達運轉情況。



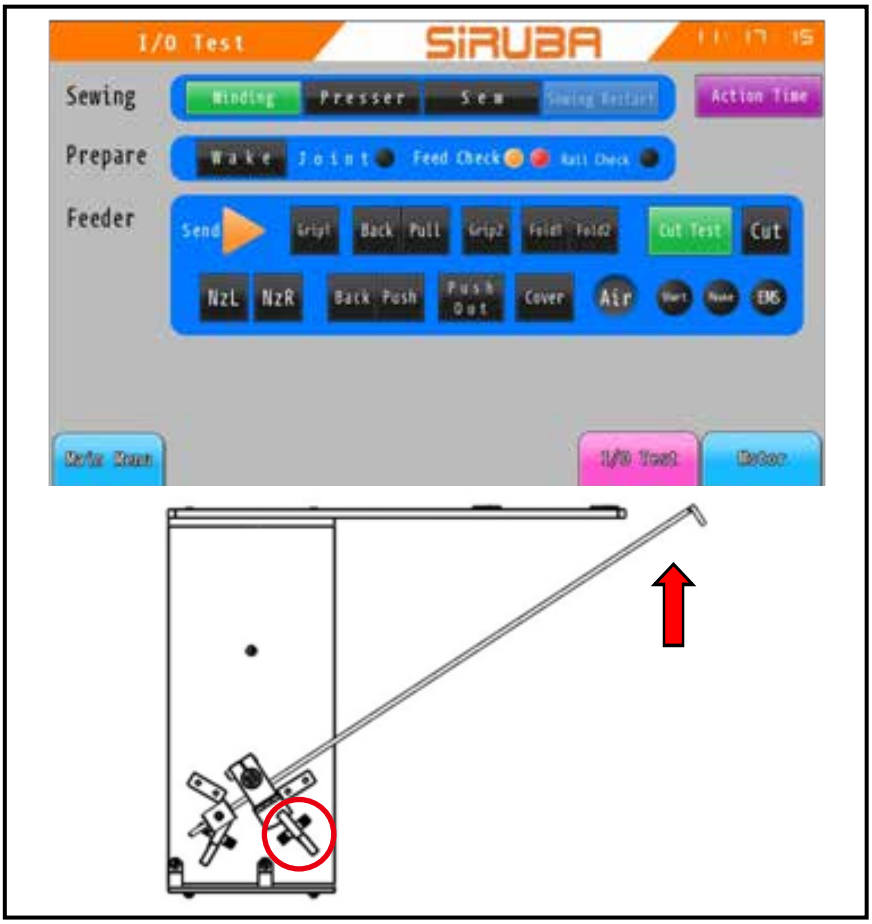
(2) 「接縫檢查」指示燈。



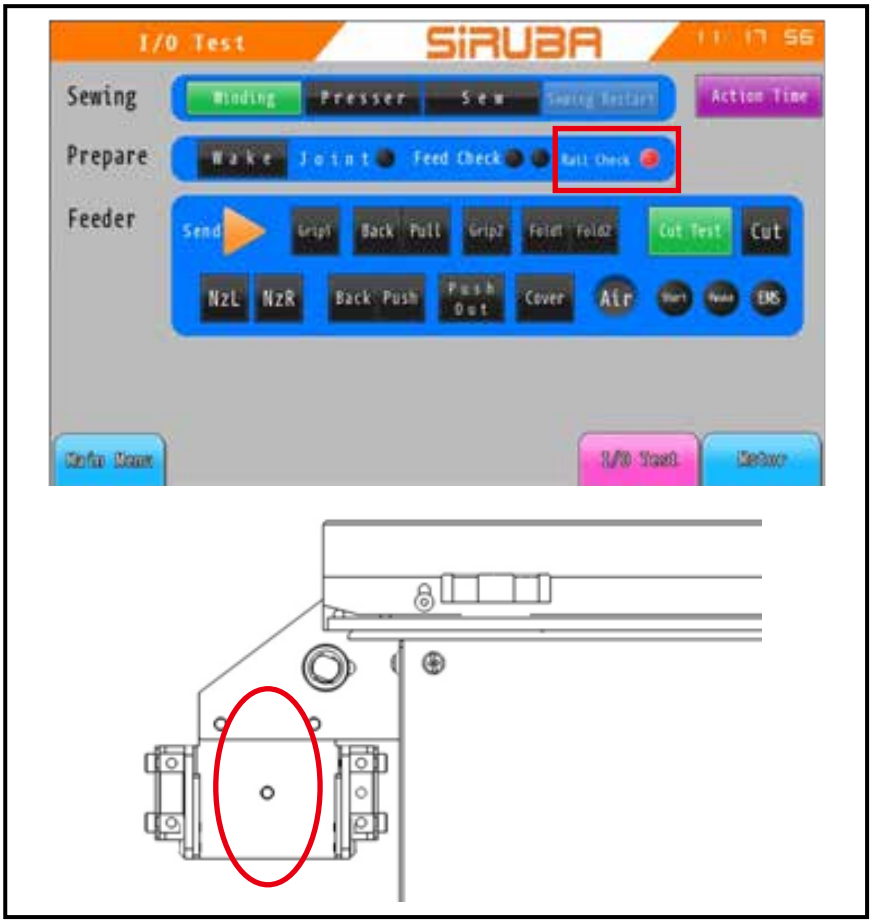
(3)「餵帶檢查」指示燈
當鐵桿上的遮光片進入一號感應器的範圍，指示燈會亮黃色。



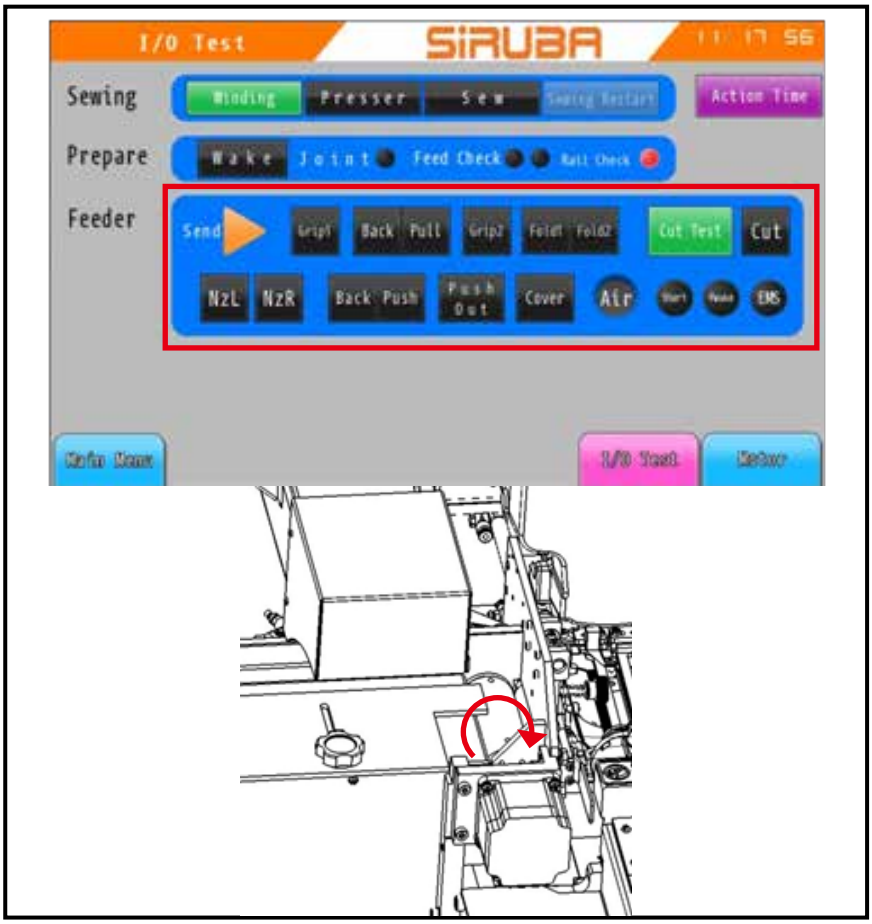
當鐵桿上的遮光片進入二號感應器的範圍指示燈會亮紅色。



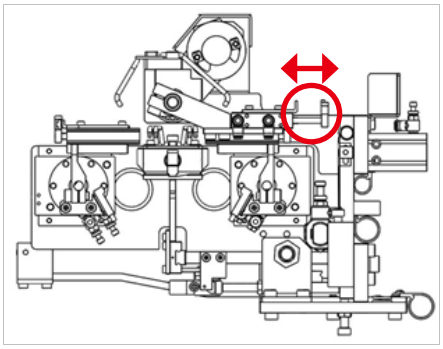
(4)「軌道有無」指示燈
若偵測到物料即將用盡，會亮紅燈。



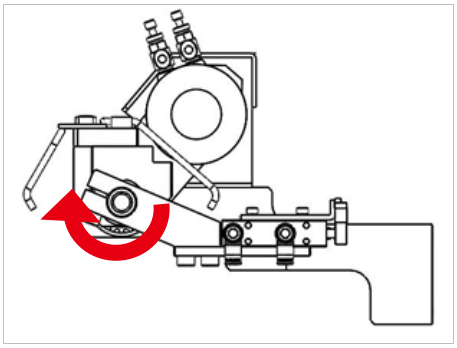
5.「餵帶模組」區
(1) 餵帶馬達測試



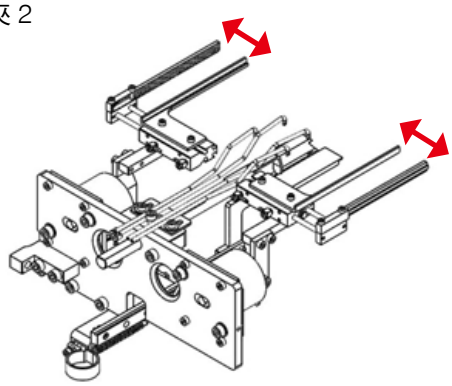
(2) 夹 1



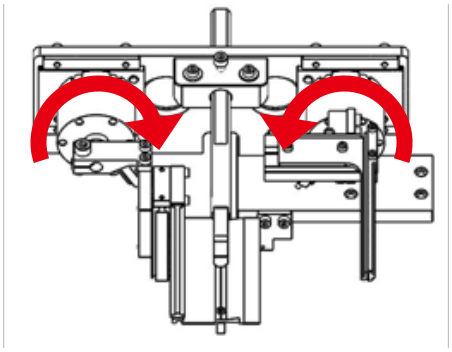
(3) 拉



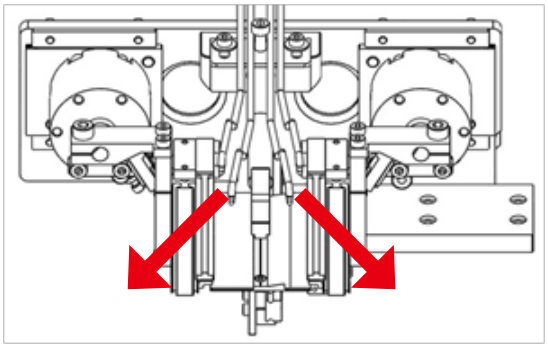
(4) 夹 2



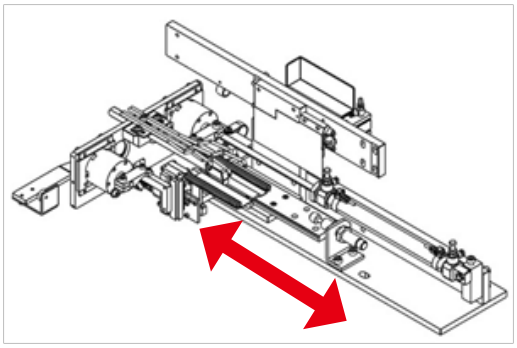
(5) 摺 2



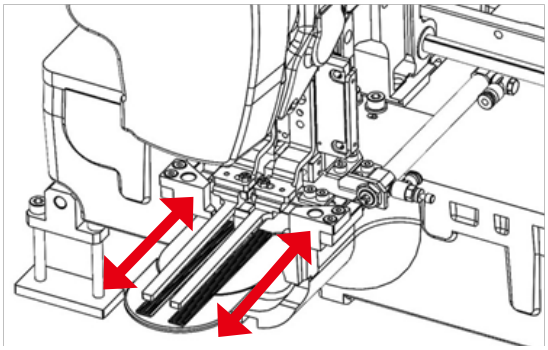
(6) 吹左 & 吹右



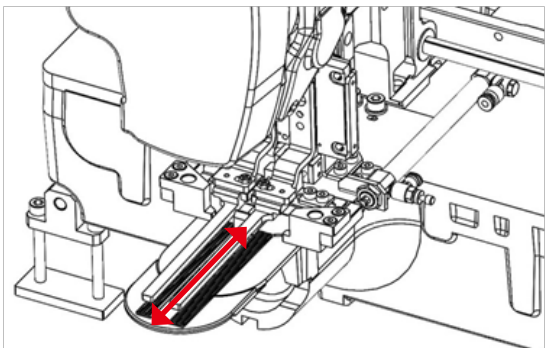
(7) 推



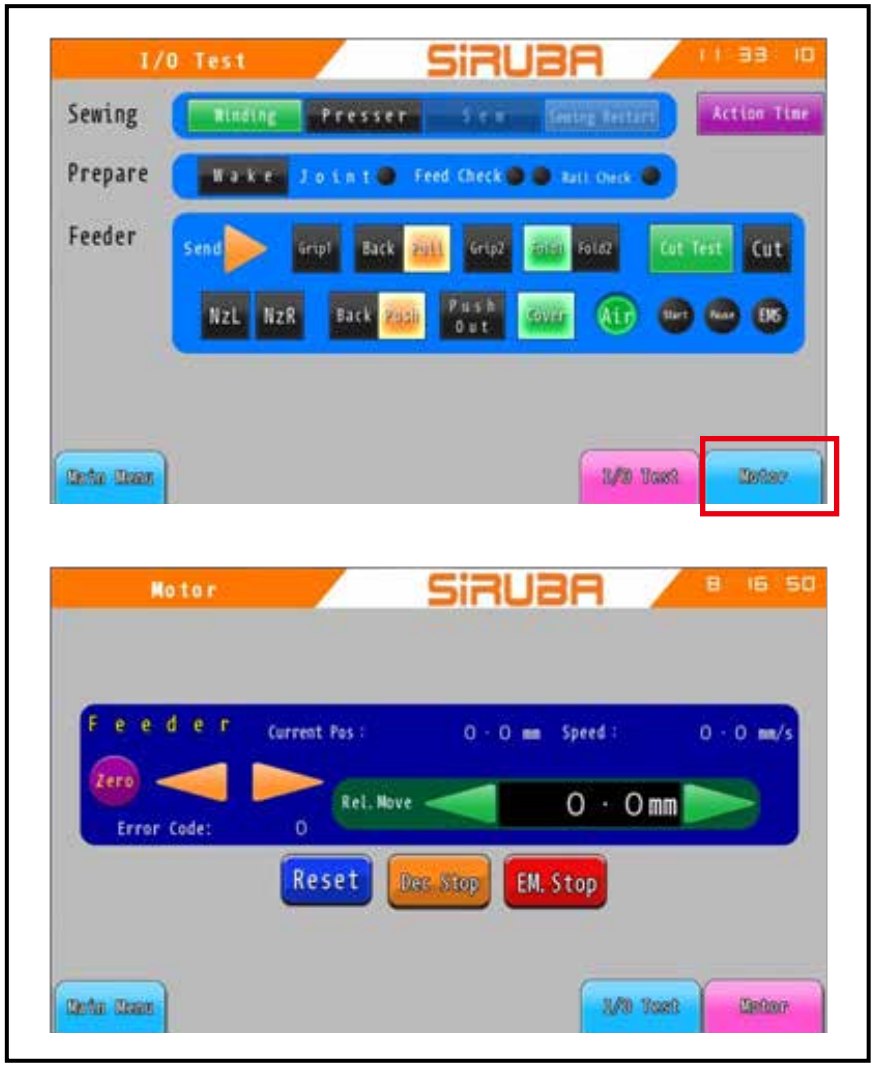
(8) 退帶



(9) 擋料



6.「馬達測試」
點選「馬達測試」頁進入，可單獨設定送帶馬達的相關參數和進行測試。

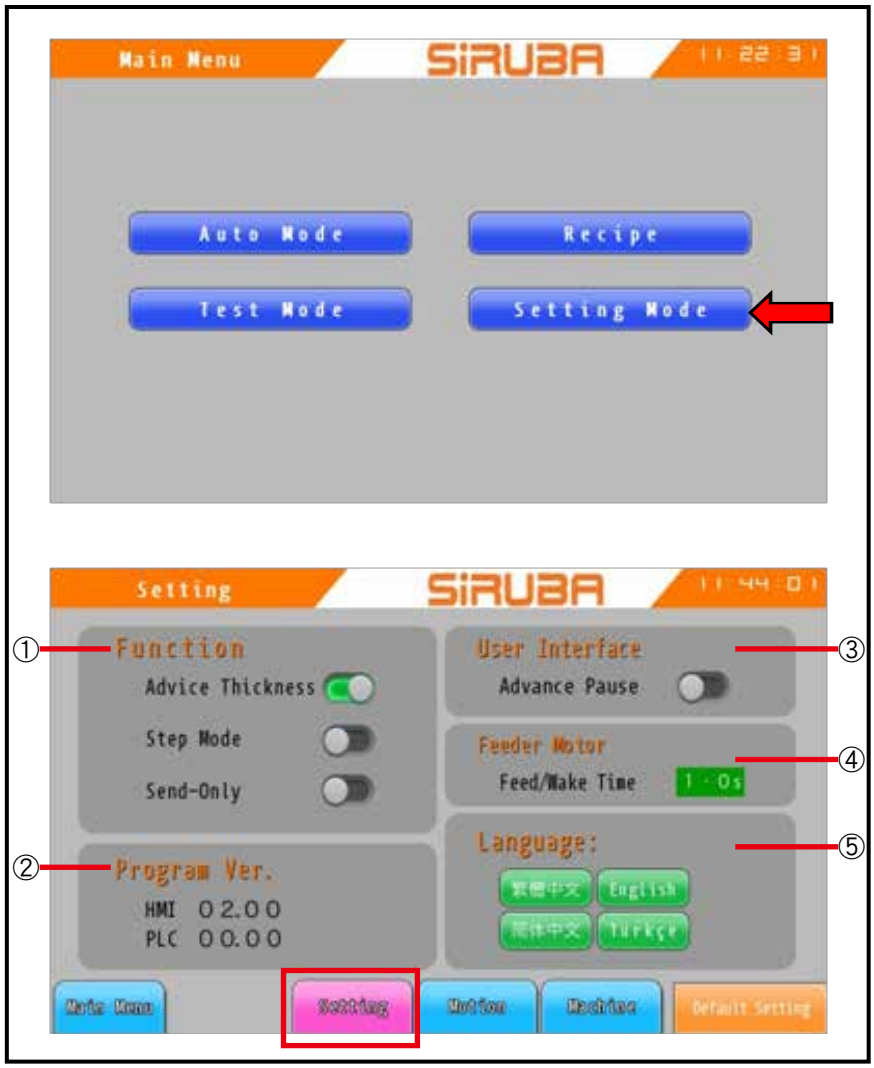


設定模式

「系統設定」頁

1.「功能開關」區
   (1)「自動建議厚度」
   掃描鬆緊帶後，系統是否自動估算補償值。
   (2)「單動模式」
   啟用後，在「生產模式」頁將出現單動模式的按鍵 (供技師維護設備使用)。
   (3)「不縫紉只送帶」
   啟用後，只會送帶、裁切，但不會車縫。

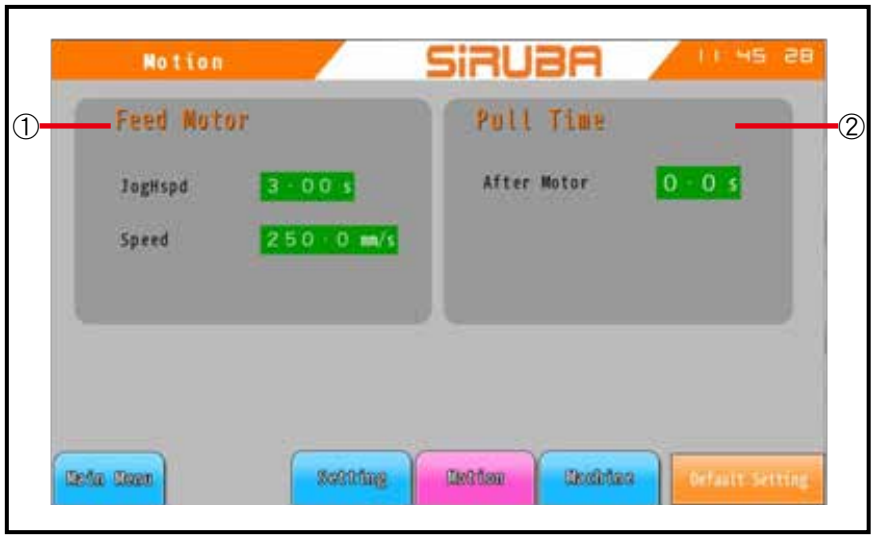
2. 程式版本編號
   顯示人機系統和 PLC 版本號。
3. 操作介面，是否開啟「顯示循環暫停」。
4.「送帶馬達」: 設定送帶 / 醒帶配合時間。
5. 語言 : 變更介面的語言。



「運動參數」

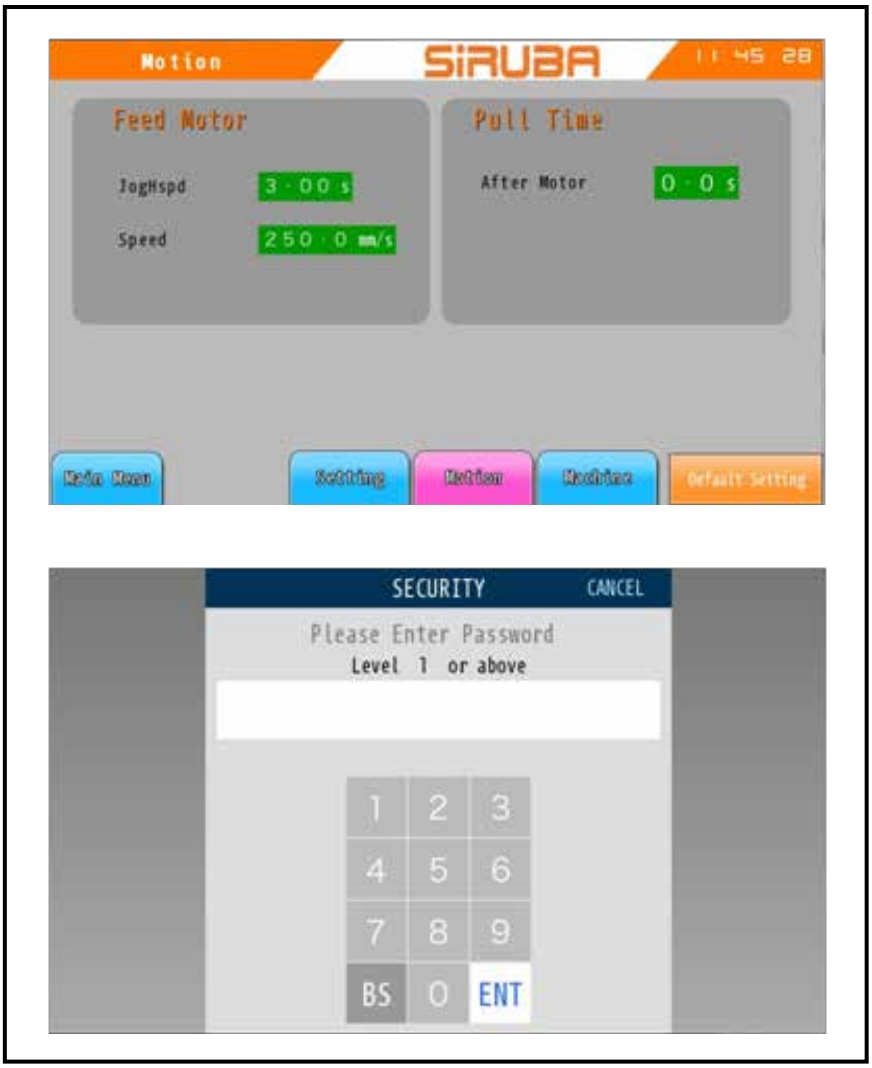
1.「送帶馬達」
   (1) 設定點選「送帶」鍵 (黃色箭頭) 後步進馬達的啟動時間。
   (2) 設定送帶馬達的速度 (最大值為 250mm / s)

2.「拉帶時機」
   設定送帶馬達送帶後開始拉帶的時機。

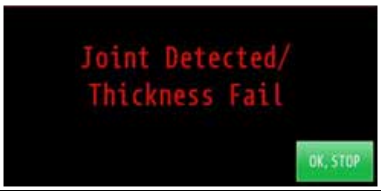


硬體設定

※ 需要密碼方可進入頁面 (工程師測試和調校專用)。



故障排除

錯誤訊息	問題描述	解決方法
	「急停按壓中」按鈕被壓下。	A1
	1. 氣壓動作異常 . 2. 汽缸未處於原點。該問題可能同時出現在多個汽缸位置。	A2
	沒有鬆緊帶了。	A3
	檢查到鬆緊帶接縫、厚度異常。 (1) 有接縫處 (可能用膠帶或其他方式接合) (2) 鬆緊帶有纏捲現象。 (3) 鬆緊帶品質異常。	A4
	沒有找到 LOGO。	A5
	整燙模組未啟動 (EBI-100)。 ※ 選購項目。	A6
	縫紉機未待機。	A7
	縫紉機超時。	A8
	計數器目標達成。	A9

「急停按壓中」

(1) 按下並以逆時針方向旋開「緊急停止」旋鈕 ⑤。

(2) 假如縫紉機上仍有鬆緊帶， 點選「放開鬆緊帶」鍵⑥使送帶托盤退回原點。

(3) 點選「重置」鍵 ③。

(4) 點選「開始」鍵 ① 恢復運轉 (※) (縫紉機會切線且各部位會返回原點)。

請注意 ※：當機器發生 A 或 B 情況時，立即壓下「緊急停止」旋鈕 ⑤。 解除 緊急停止後即可恢復運轉。

a. 開啟電源 (ON)
且機器處於待機狀態。

b. 帶圈準備送入車縫前 :
運轉途中點選「緊急停止」旋鈕 ⑤將中斷縫製。請依照上述說明恢復運轉。
縫紉機的操作面板會顯示錯誤代碼 E5。

請依照下述流程排除：

(5) 點選「重置」鍵⑨→進行剪線。

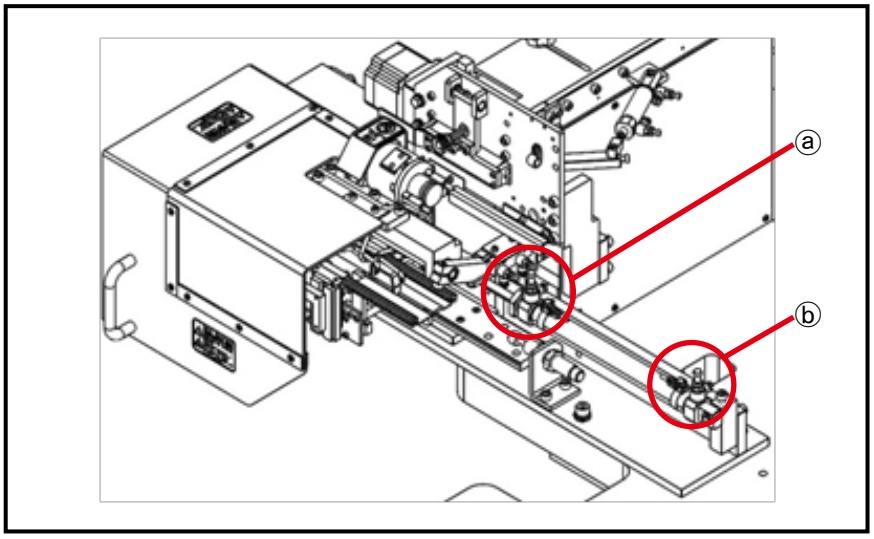
(6) 再次點選「重置」鍵⑨→排除不良製品並參考上述 ※ 說明恢復機器運轉。

A 2 ・「氣壓動作異常」

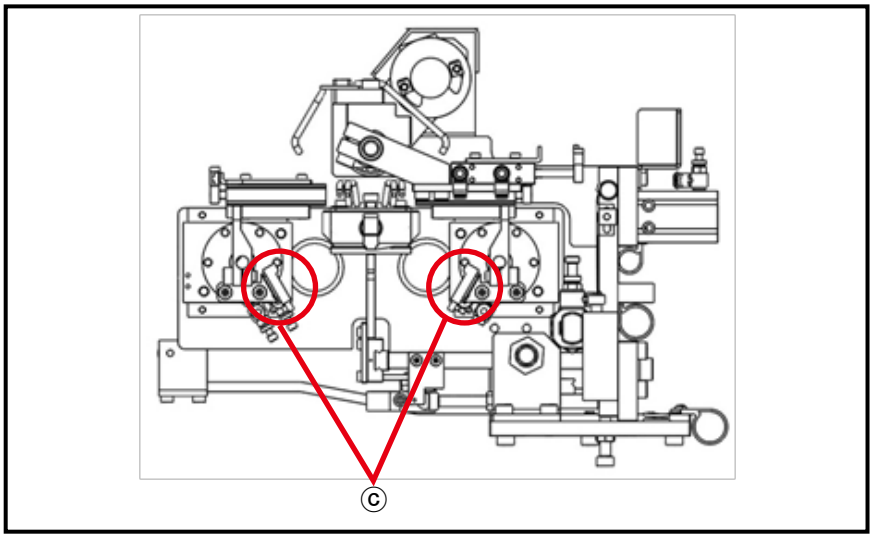
(1) 檢查氣壓表，氣壓值須大於 0.3Mpa。

(2) 檢查下列汽缸的感應器 :

1. 送帶汽缸感應器
(初始狀態應為: 亮燈, 熄滅)

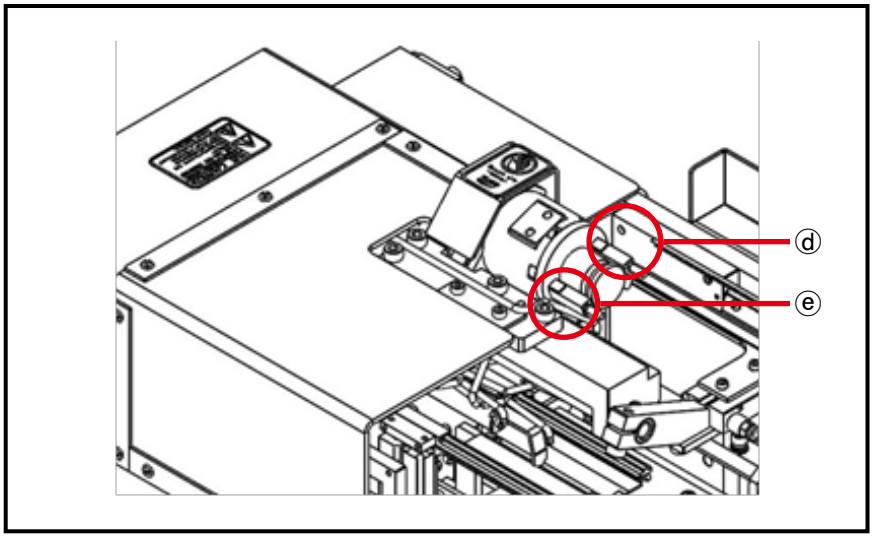


2. 夾爪感應器
(初始狀態應為 : 熄滅)



3. 拉帶懸臂感應器
(初始狀態應為: 亮燈, 熄滅)

(3) 檢查完後請點選⑦關閉錯誤訊息視窗。
(4) 點選「重置」鍵 ③。
(5) 點選 「開始」鍵 ①恢復機器運轉 (※ 機器將裁切鬆緊帶一次以重設正確的鬆緊帶起點並等待下一指示)。



A 3 ・「沒有鬆緊帶了」

(1) 移除殘餘的鬆緊帶。現在請勿 點選「重置」鍵③，否則帶圈會難以排除。
(2) 點選 ⑦關閉緊告視窗。
(3) 點選「重置」鍵 ③。
(4) 補充新的鬆緊帶。
(5) 點選「開始」鍵①恢復運轉。（※）(機器將裁切鬆緊帶一次以重設正確的鬆緊帶起點並等待下一指示)。

A 4 ・「檢查到鬆緊帶接縫、厚度異常」

(1) 剪除鬆緊帶上的接縫處。
(2) 排除起皺或不平整的鬆緊帶，或使用整燙設備。
(3) 點選⑦ 關閉緊告視窗。
(4) 點選「重置」鍵 ③ .
(5) 繼續使用接縫前的鬆緊帶，點選 「開始」鍵 ① .
(6) 恢復繼續運轉 :
→ 縫製 1 ～ 2 條後，鬆緊帶用盡導致機器自動停止，並出現錯誤警訊，請參照 A3 的方式操作即可恢復運轉。

A 5 ·「沒有找到 LOGO」.

(1) 檢查鬆緊帶輸送過程有無異常。假如有，請排除。

(2) 點選⑦關閉警告視窗。

(3) 點選「重置」鍵 ③。

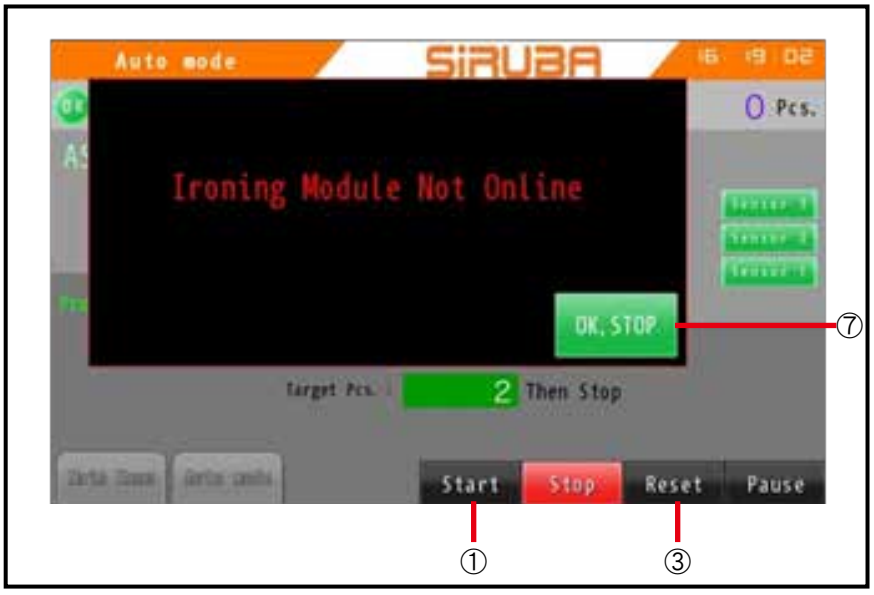
(4) 到「規格設定」頁，進入「快速教導」，檢查「容許相異」的數值。 加大容許值或重新掃描。

(5) 點選「開始」鍵 ①恢復運轉。（※）(機器將裁切鬆緊帶一次以重設正確的鬆緊帶起點並等待下一指示)。

A 6 ·「整燙模組未啟動」(在有連接 Siruba EBI-100 整燙設備的狀態下)

(1) 啟動整燙設備。

(2) 將整燙設備上的馬達和加熱開關切換至模式「2」，系統才能讀取相關訊號並進行配合。



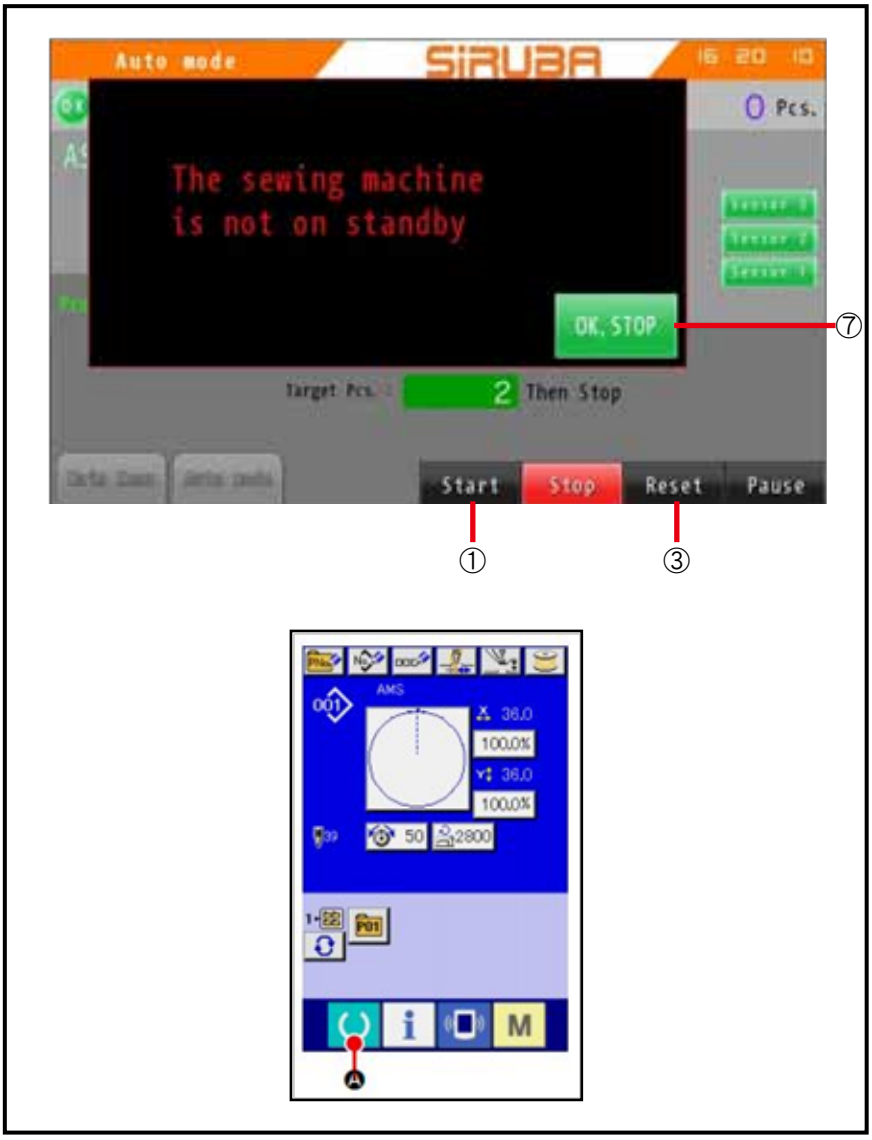
A 7 ・「縫紉機未待機」

(1) 縫紉機設置完成後
點選「準備」鍵使縫紉機進入待機狀態。

(2) 點選⑦關閉警告視窗。

(3) 點選「JUKI panel A」。.

(4) 點選「重置」鍵 ③ (5) 點選「開始」鍵 ① 啟動
→並重新開始（※）
(機器將裁切鬆緊帶一次以重設正確的鬆緊帶起點並等待下一指示)



A 8 ・「縫紉機超時」

(1) 檢查縫紉機是否有異常訊息。
若沒有，點選「A」。

(2) 點選 ⑦ 關閉警告視窗。

(3) 點選「重置」鍵 ③ .

(4) 點選「開始」鍵 ① 啟動
→並重新開始（※）
(機器將裁切鬆緊帶一次以重設正確的鬆緊帶起點並等待下一指示)

A 8

A 9 ・「計數器目標達成」

(1) 達成設定的數量後，將跳出訊息視窗且機器會暫停。

(2) 點選⑦ 關閉警告視窗並重置計數器。.

(3) 點選「開始」鍵①重置系統 (※) (機器將裁切鬆緊帶一次以重設正確的鬆緊帶起點並等待下一指示).

斷線重新車縫的方法 :

(1) 重新穿線後，接著點選「重置」鍵 ③ .

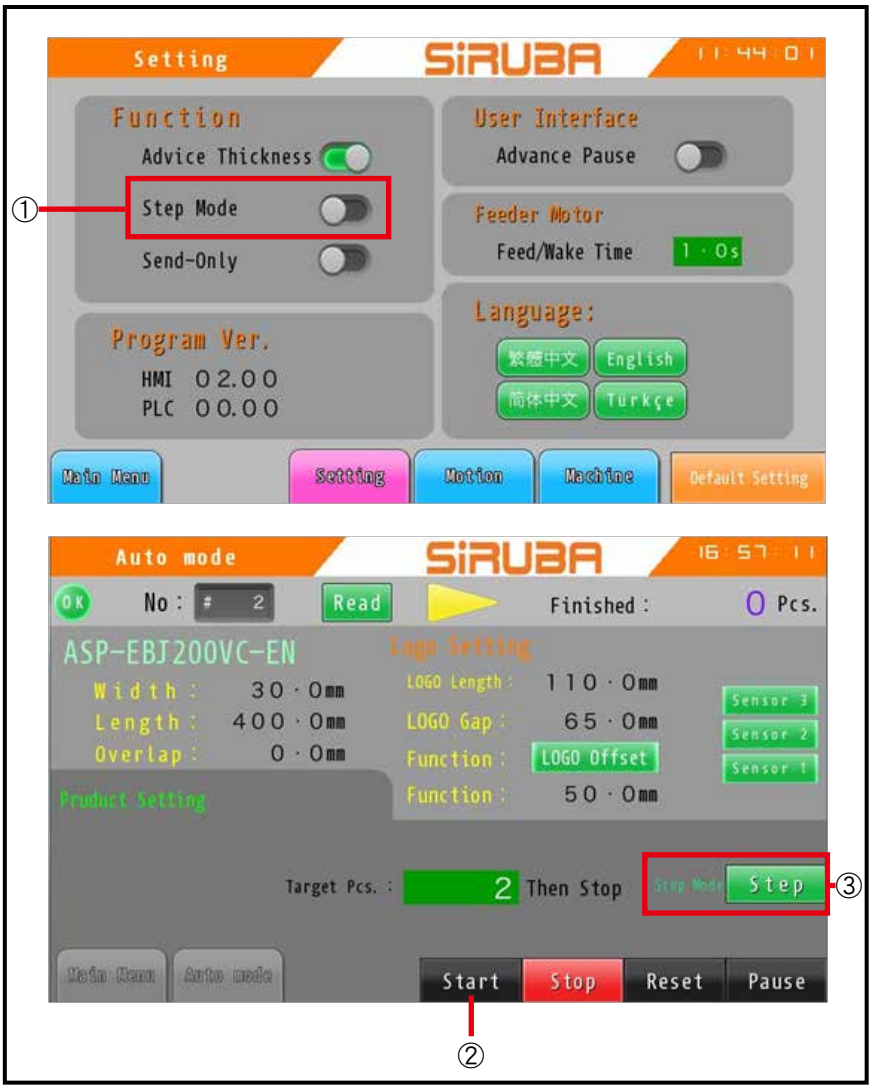
(2) 根據斷線前的狀態，使機器處於下述 A 或 B 的情況並依照指示排除故障。

A. 電源啟動時，機器處於待機狀態。

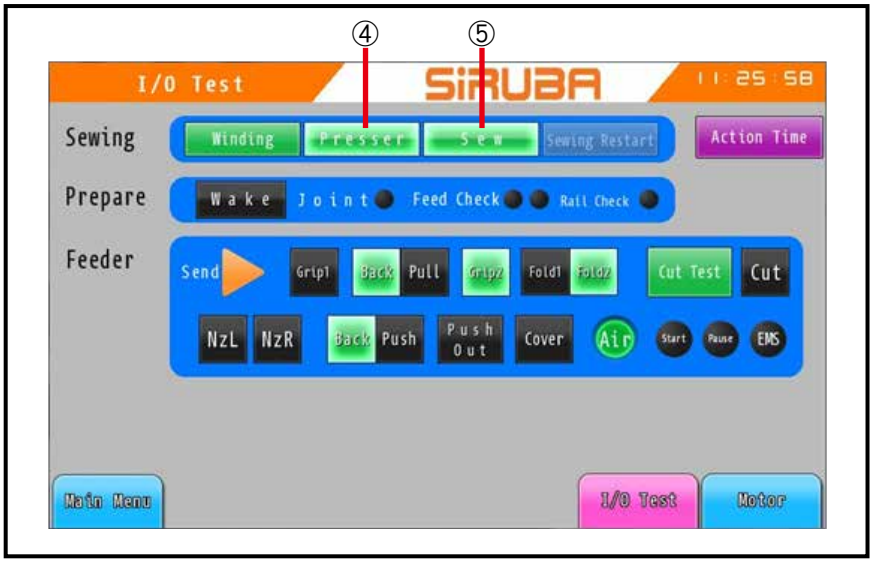
b. 鬆緊帶設置好後，機器將暫停。
請注意 ※1 詳情請參閱縫紉機操作手冊。

維護模式

1.「單動模式」
機器將一步步運轉，可確認機械結構、零件的位置是否正確。
(1) 點選「設定模式」進入，啟動「單動模式」①.
(2) 進入「生產模式」頁，點選「開始」鍵 ②→ 重新啟動（※）(機器將裁切鬆緊帶一次以重設正確的起點並等待下一指示).
(3) 點選「開始」鍵 ②，並點選「下一步」③確認每一步的動作。
(4) 測試完請回到「設定模式」，關閉「單動模式」①



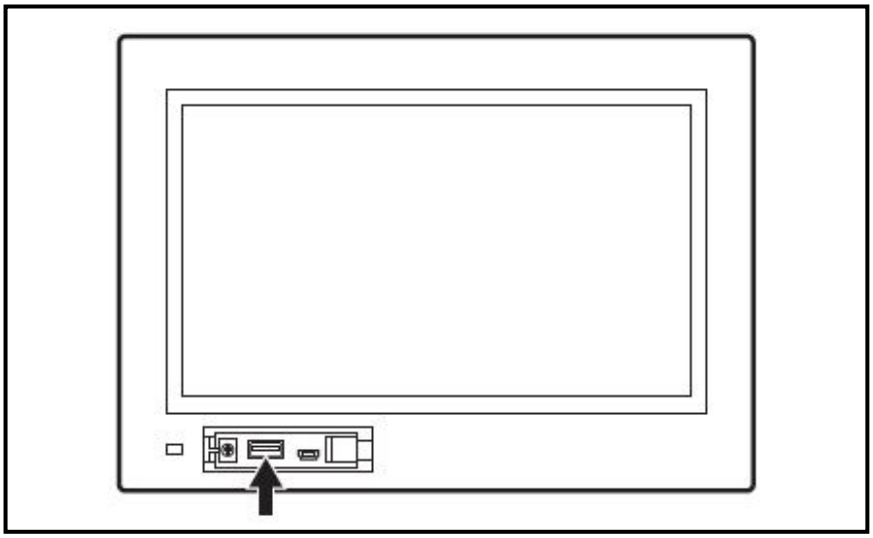
2.「縫紉機運轉測試」
只有縫紉機獨自運轉。
(1) 進入「測試模式」，並點選「I/O 測試」鍵。
(2) 將鬆緊帶放在壓腳下，點選「壓腳」鍵④降下壓腳以免鬆緊帶滑動。
(3) 點選「起縫」鍵。



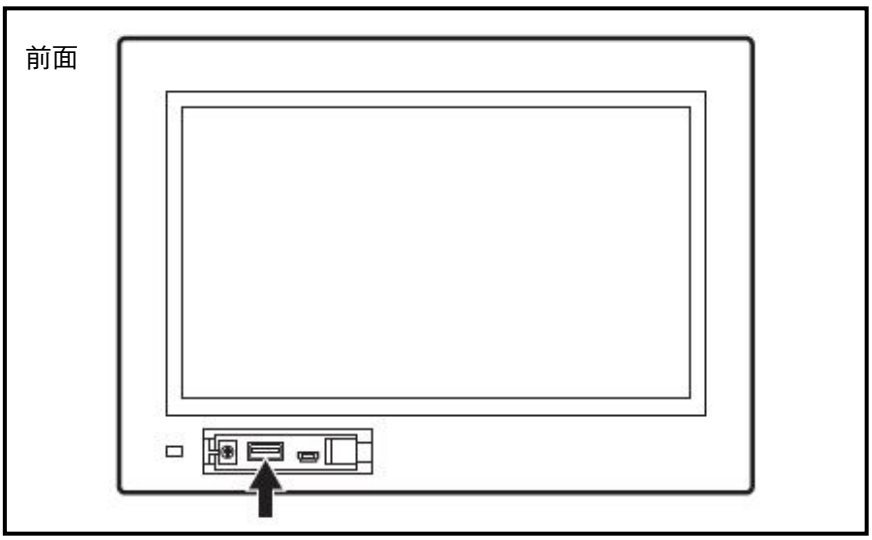
隨身碟插槽

工作參數和資料都儲存在 SD 卡中，工程師或操作人員
可以透過人機介面的隨身碟插槽存取參數和資料。

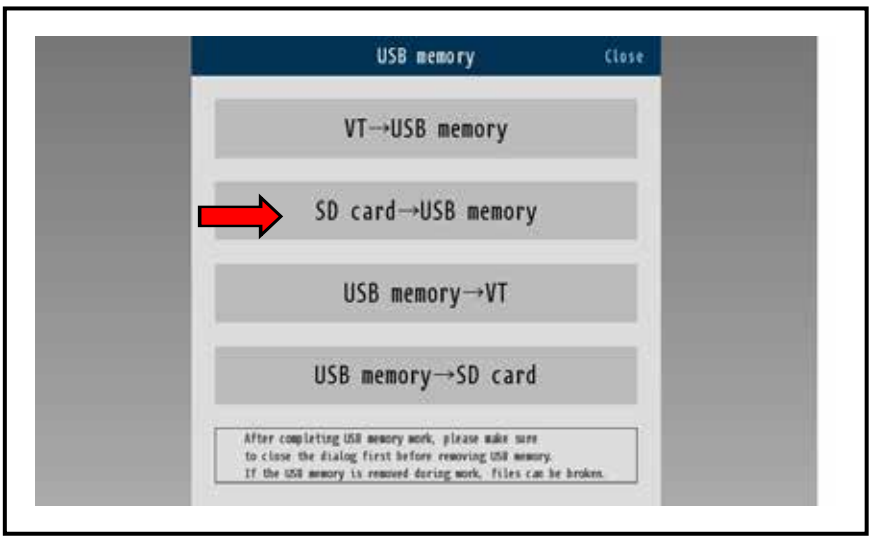
人機介面只支援小於 32GB 容量以及 USB2.0。



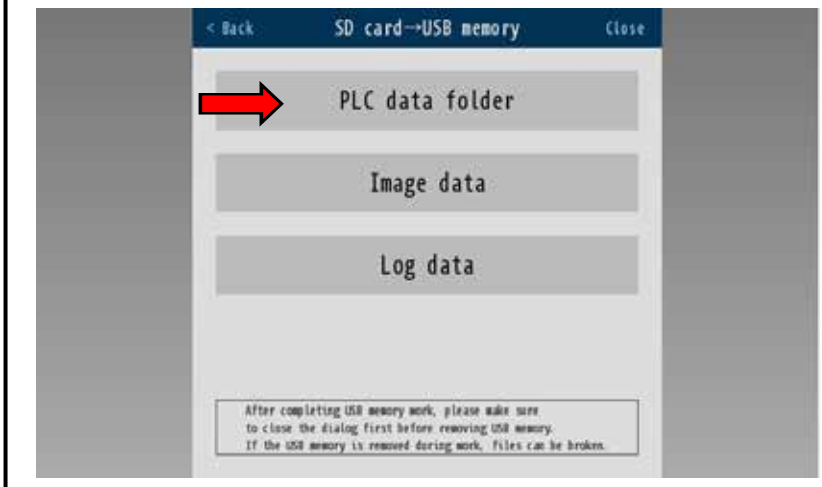
1. 匯出人機介面的資料 .
(1) 將隨身碟插上。



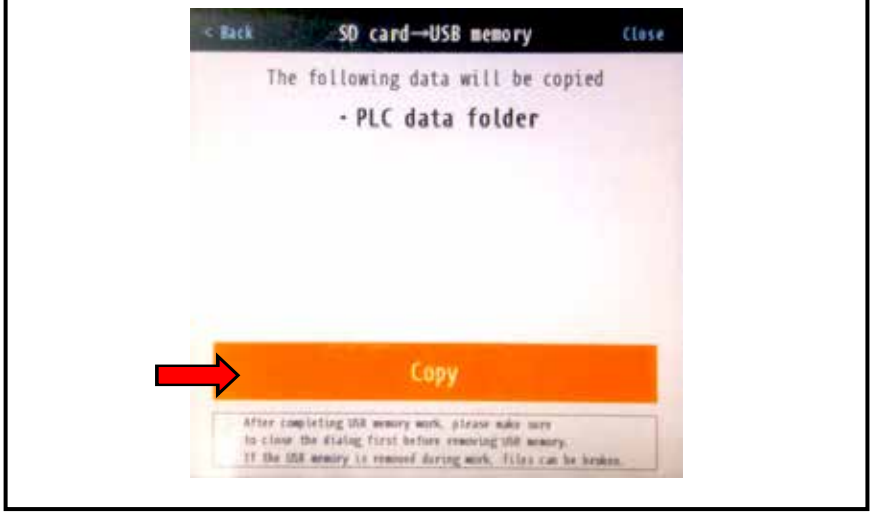
(1) 電源開啟後，將看到如右側的畫面。
(2) 點選「SD card-> USB memory」。



(3) 點選 「PLC data folder」

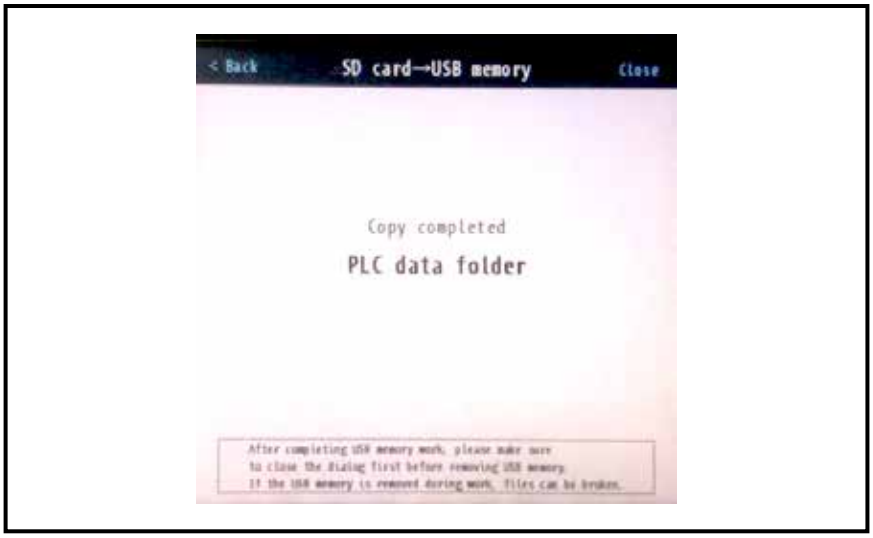


(4) 點選 「Copy」 從人機介面匯出資料至隨身碟內。.
資料傳輸時請勿移除隨身碟。



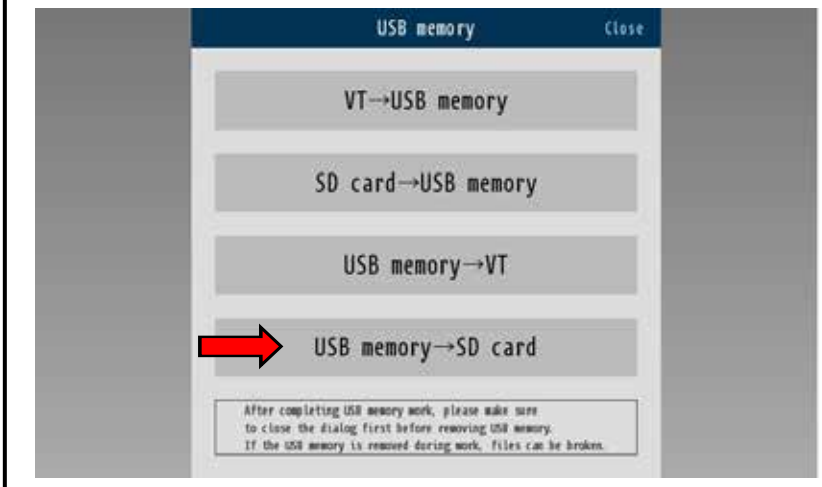
(5) 傳輸完成後，螢幕將顯示如右圖。 點選 「Close」回到「主畫面」。再取下隨身碟即可。

(6) 檢查隨身碟內的資料。
你剛下載的資料將儲存在名為「VTDVC」. 的資料夾內。

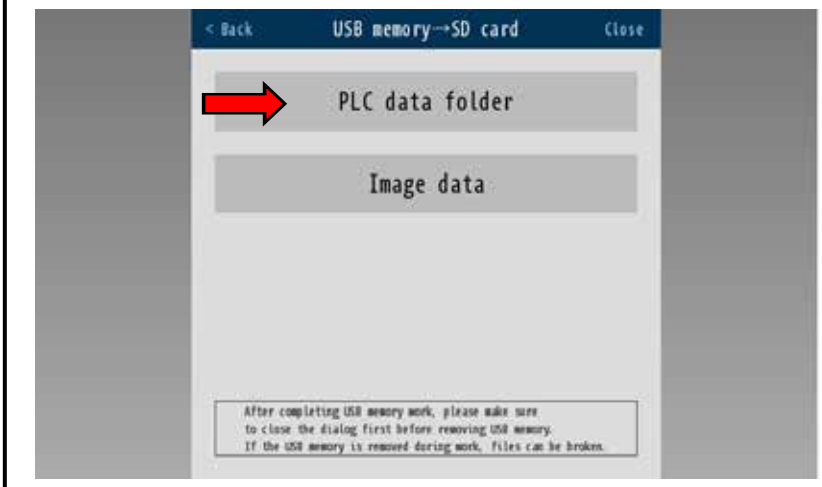


2. 匯入資料至人機介面內。

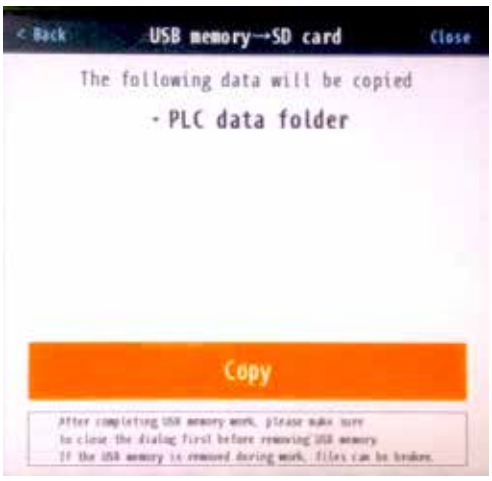
(1) 將隨身碟插入人機介面。點選「USB memory ->SD card



(2) 點選“PLC data folder”

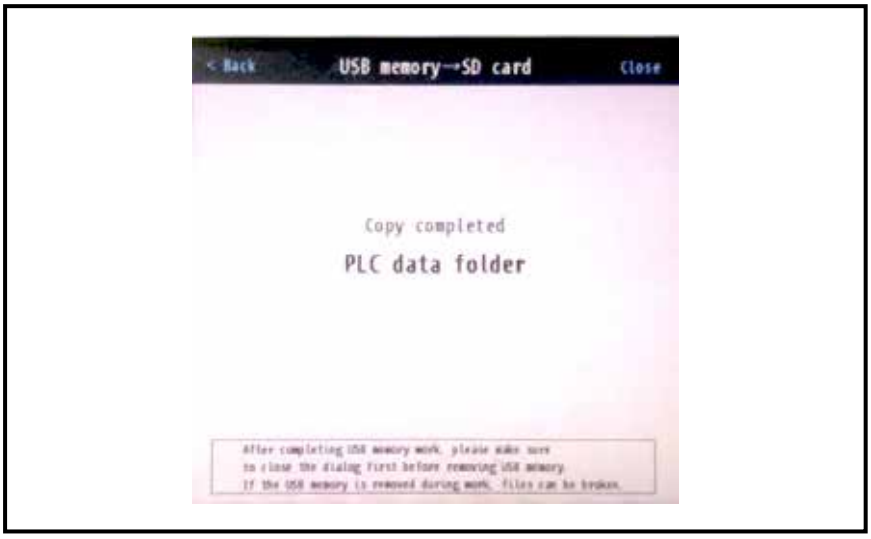


(3) 點選 「Copy」將資料傳輸至人機介面的 SD 卡內。

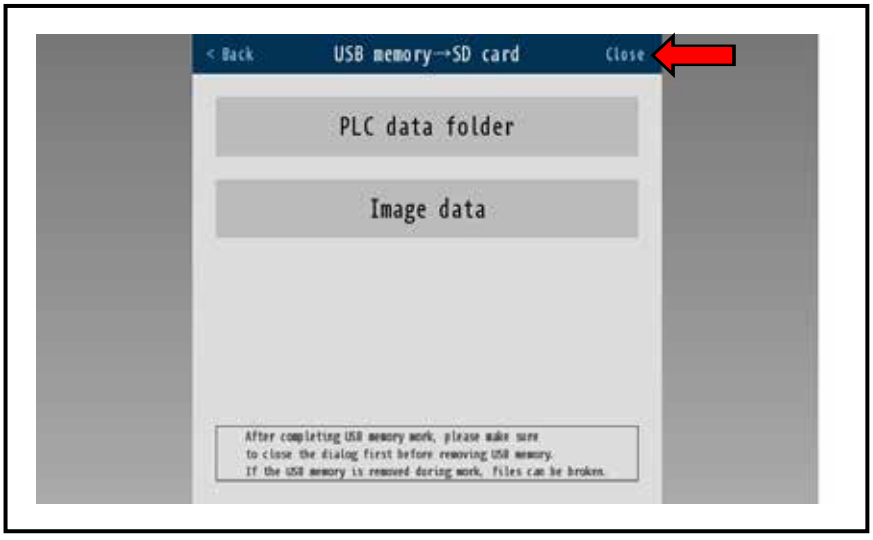


(4) 點選 「Close」回到 「主畫面」。再取下隨身碟即可。

(5) 到「規格設定」頁內檢查匯入的資料。



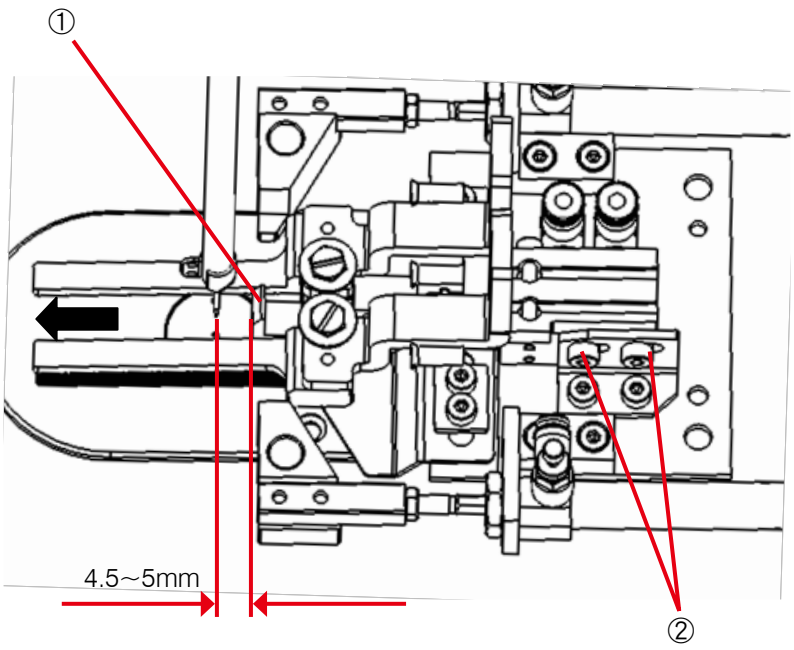
(6) 點選「close」 鍵離開本頁。

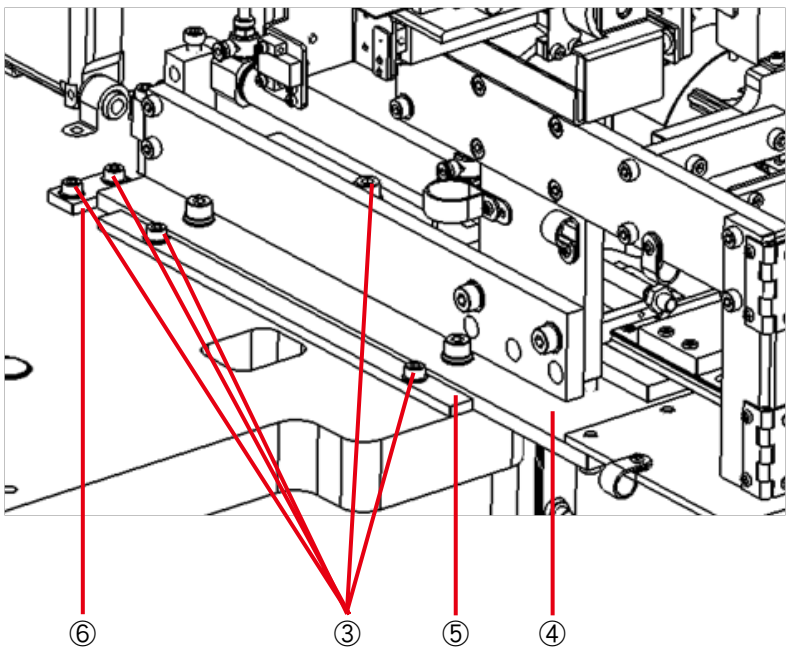


維護與保養

A. 鬆緊帶與送帶裝置的位置

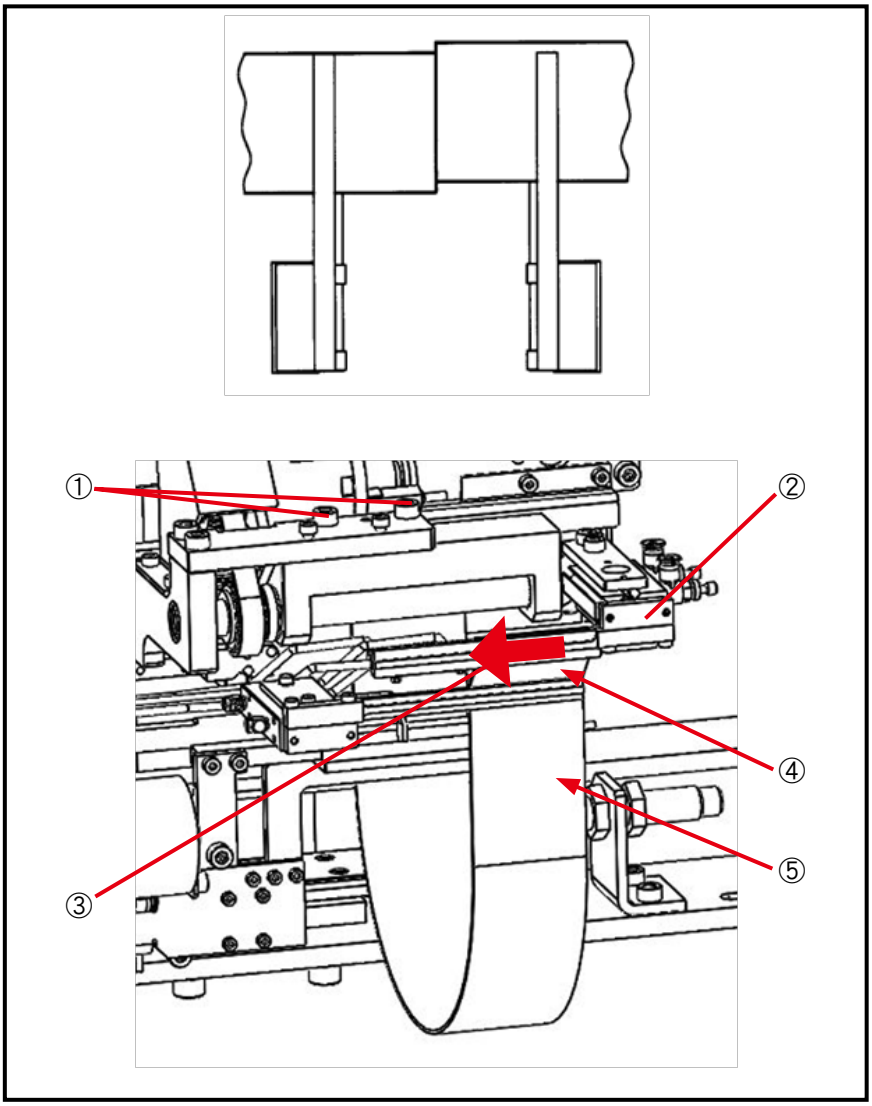
1. 關閉氣源。鬆開螺絲②設定擋料① 和機針的距離，約 4.5 ～ 5mm。
2. 當鬆緊帶送入壓腳下，內側應與擋料 ①貼齊。可使用「測試模式」進行相對位置的測試。檢查鬆緊帶和擋料①之間是否有間隙 (需小於 0.5mm)。
3. 當擋料 ①移動並碰撞到鬆緊帶，帶圈將會偏移且導致斷線或車縫效果不佳。可能需要調整送帶托盤。
4. 送帶托盤的調整方式 : 鬆開五顆螺絲③。配合擋塊⑤移動整個送帶座④。
   調整後，鎖固送帶座上的三顆螺絲④。再固定送帶座④後側的擋塊⑥。





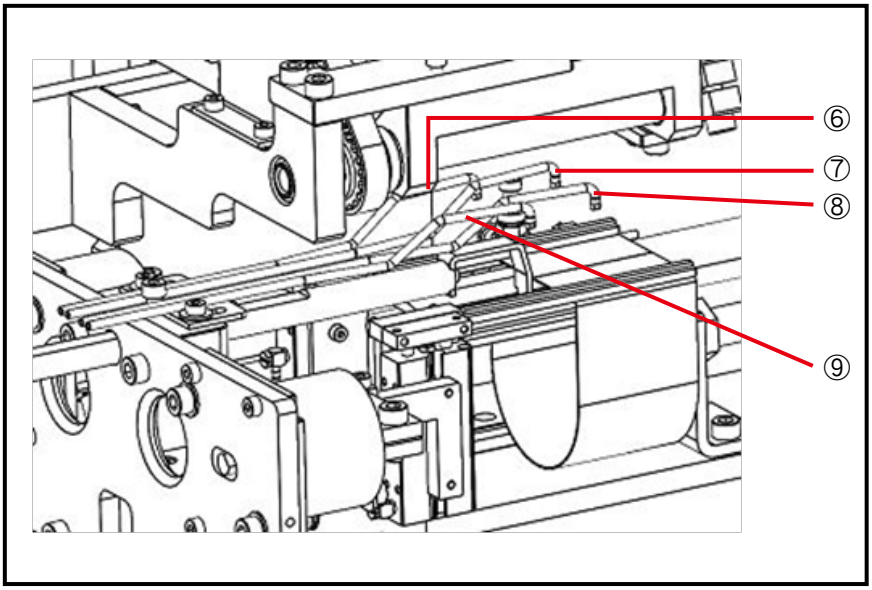
B. 鬆緊帶結合處錯位的調整方式 .

1. 當鬆緊帶的結合處發生錯位 (如右圖所示):
   鬆開螺絲① 。移動拉帶懸臂②
   (往箭頭方向移動).
2. 當鬆緊帶的結合處發生逆向的錯位 :
   鬆開螺絲 ①。反方向移動拉帶懸臂②。
3. 如右下圖所示，拉帶懸臂的調整必須依據鬆緊帶的錯位方式 ④ , ⑤進行。可從鬆緊帶的邊緣確認結合處是否平整。



C. 吹氣強度的調整

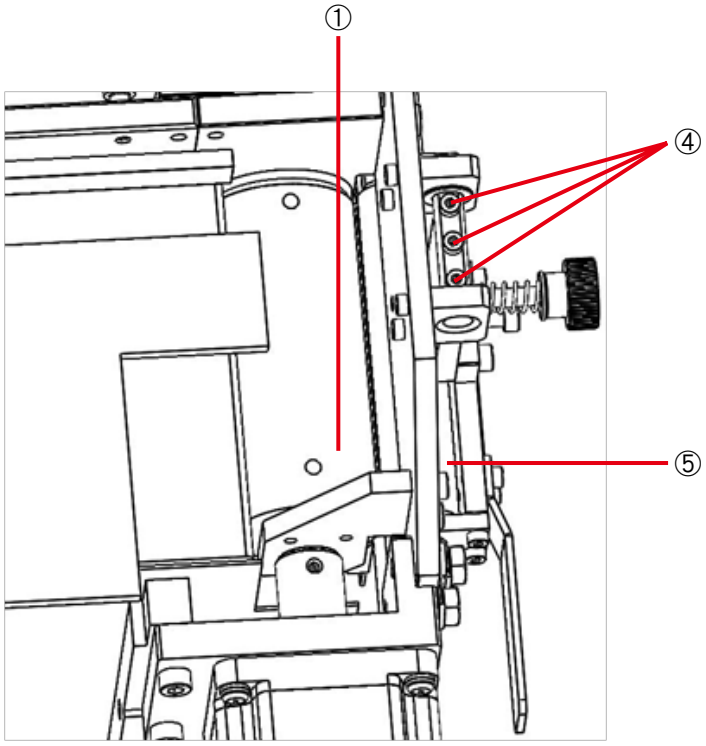
調整氣管⑥ ~ ⑨吹出的空氣強度需依鬆緊帶的狀態而定。
若有需要請調整氣閥的旋鈕

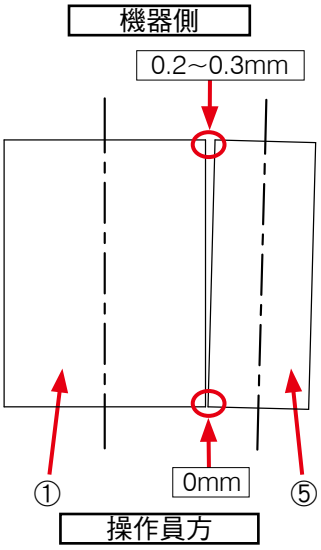


D. 送帶滾輪

調整滾輪① 的偏移角度以控制鬆緊帶的前進。

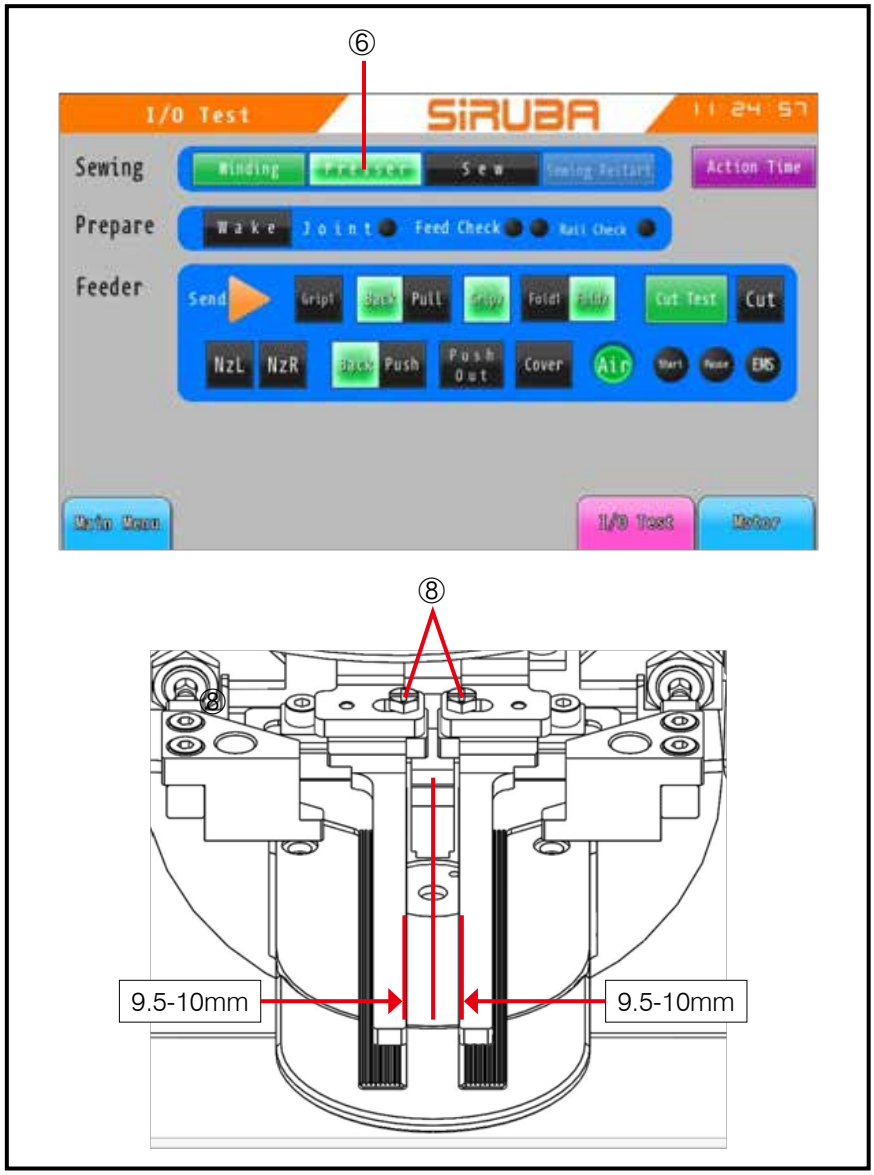
1. 鬆開螺絲④
2. 調整輔助滾輪⑤。請參考右下圖示進行。





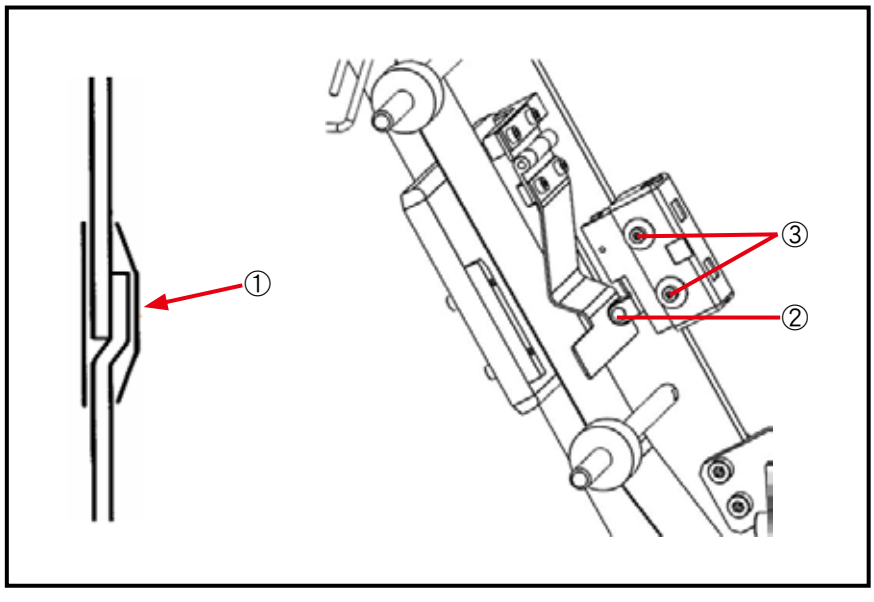
E. 壓腳和固定夾片的調整

1. 移除機針，進入「測試模式」的「I/0 測試」頁面。
2. 點選「壓腳」⑥降下壓腳。
3. 左右兩支壓腳與針孔中心線的寬度約 9.5-10 mm。
4. 鬆開螺絲進行調整。.



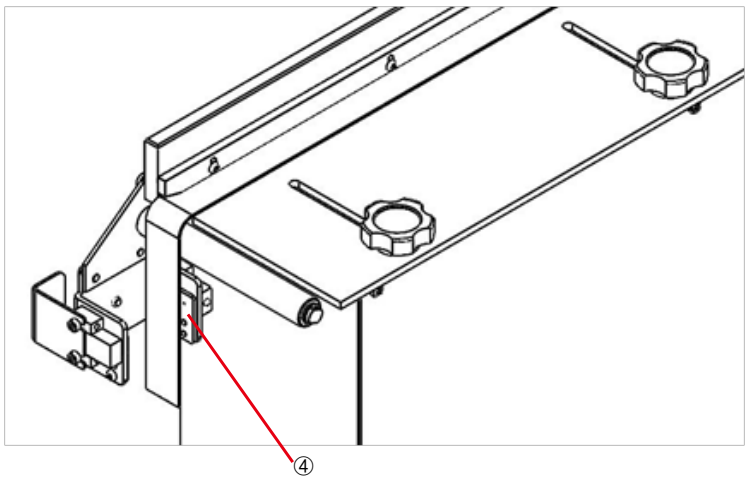
F. 接縫檢查感應器的調整

1. 鬆開螺絲 ③
2. 若出現①的鬆緊帶通過感應器，水平的移動感應器②進行調整，直到聽到觸發的聲響。



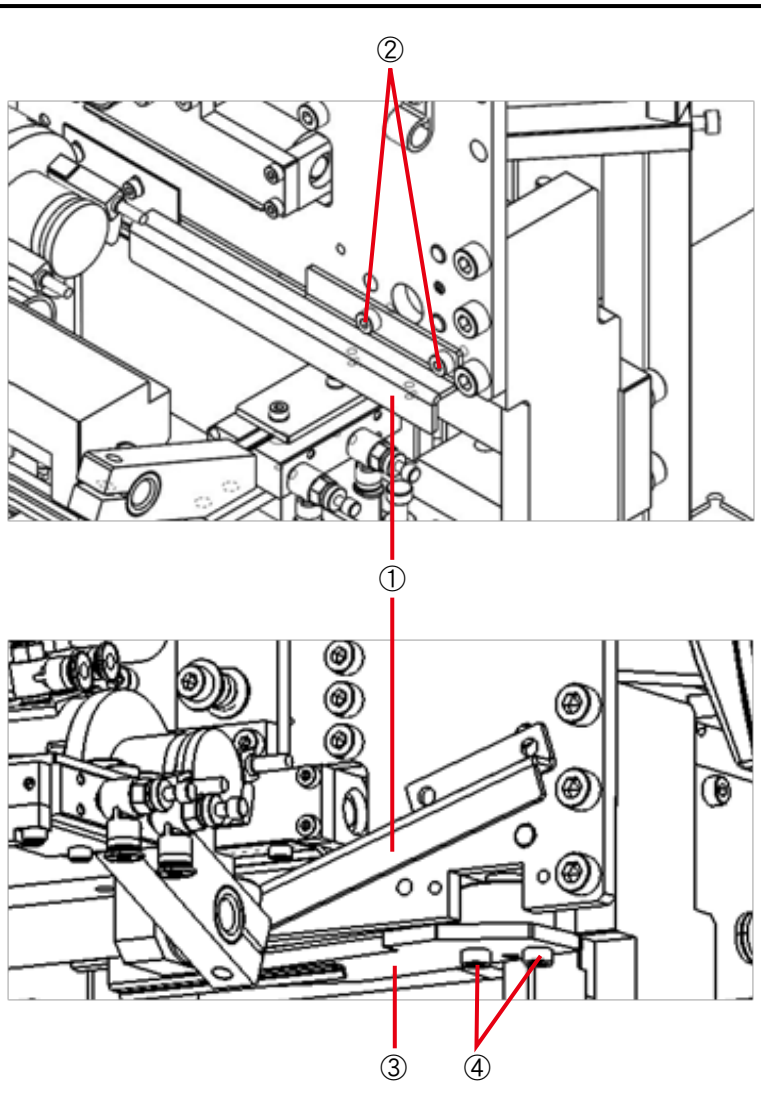
G. 軌道有無感應器的調整
若物料為白色或太薄將導致感應器無法偵測。需進行調整。.

1. 開啟電源。
2. 在兩個感應器間放入會誤判的鬆緊帶。
3. 調整感應器④的位置 (使它傾斜) 以降低敏感度。
4. 檢查指示燈 (在感應器的右側)，沒有鬆緊帶時指示燈應亮紅燈。

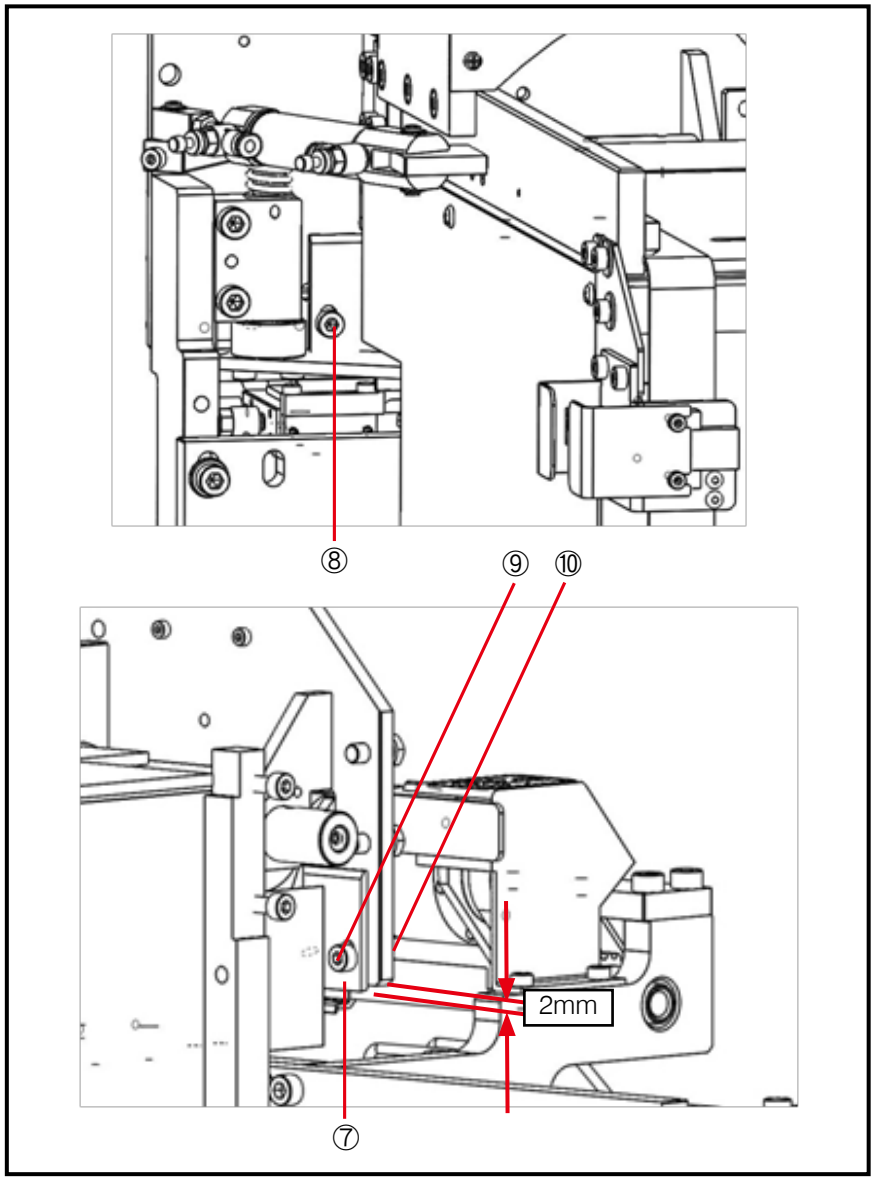


H. 切刀更換

1. 卸除保護蓋①和②
2. 鬆開螺絲 ④並移除保護片③。
3. 卸下螺絲⑥替換活動刀片⑤。

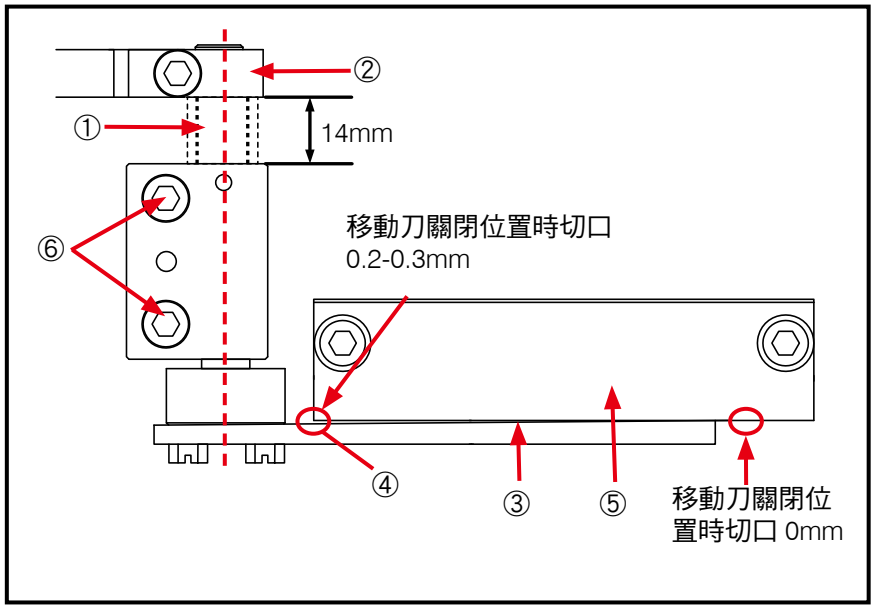


4. 卸下螺絲⑧ , ⑨更換固定刀片⑦。
5. 固定刀片的刀口⑦需低於刀座⑩ 2mm。



切刀的設定 :

6. 如右圖所示，切刀推動軸①間隙為 14mm(鬆開螺絲②調整彈簧壓力。
7. 鬆開螺絲⑥設定活動刀③和固定刀的間隙④約為 0.2 ~ 0.3mm.
8. 假如間隙④太大，將導致裁切品質不佳和刀刃的損壞。



縫製花樣

選擇縫紉花樣的方法：

(1) 開啟電源。在縫紉機的操作面板上，

(2) 點選「A」進入花樣圖庫。

(3) 點選「 J」區的圖號。接著點選「I」確認選擇的花樣 (點選「K」可預覽圖型)。

(4) 點選「B」使縫紉機進入待機狀態。
請注意：請參考下頁的花樣圖表。例如當鬆緊帶的寬度 (Y) 為 5mm 時，假如沒有對應寬度的圖型，可以使用 ZOOM +/- 功能放大或縮小圖型。

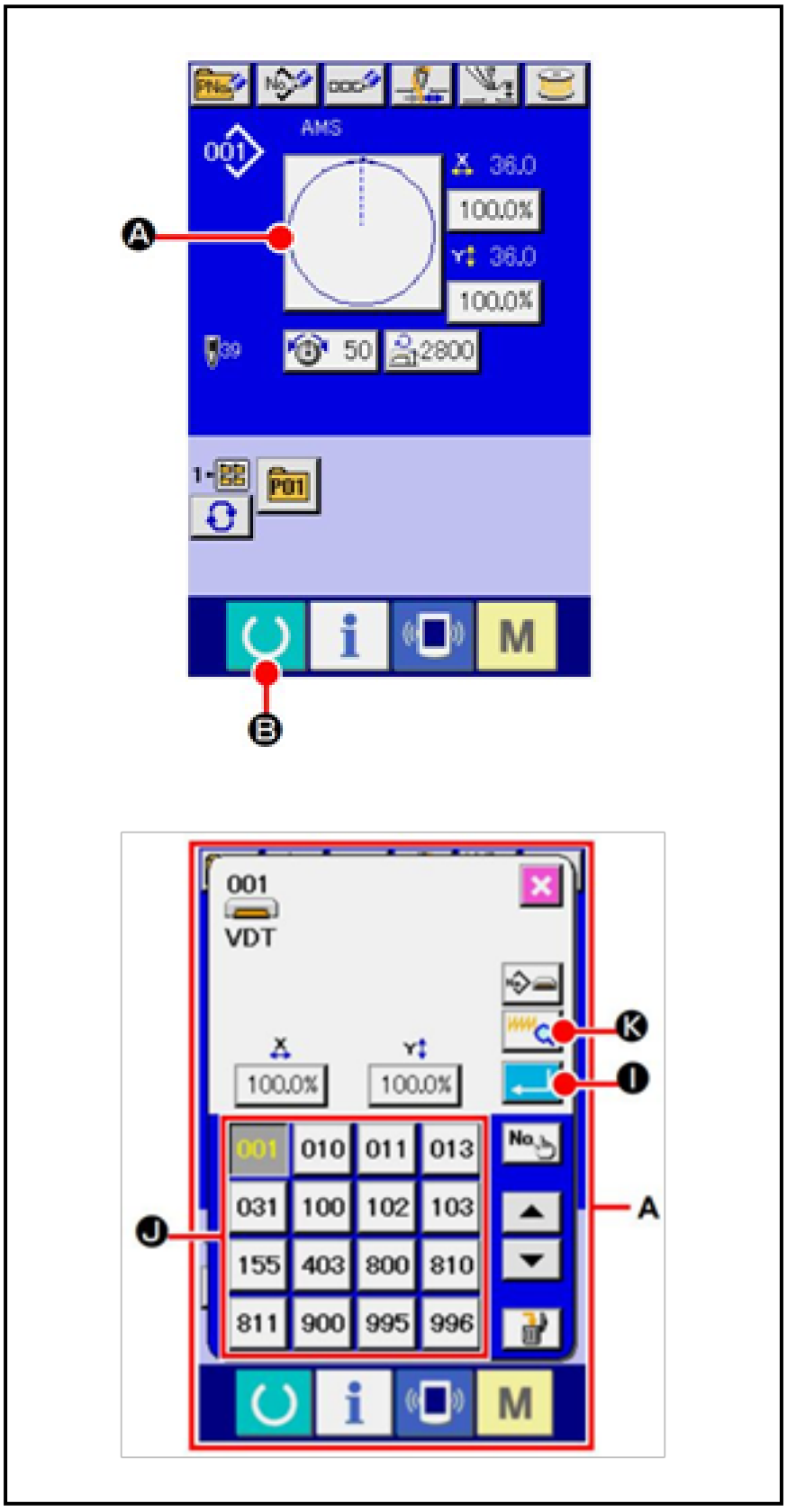
(5) 點選「C」變更 X/Y 的比例，請依據實際車縫的效果作設定。

變更花樣比例的實例：

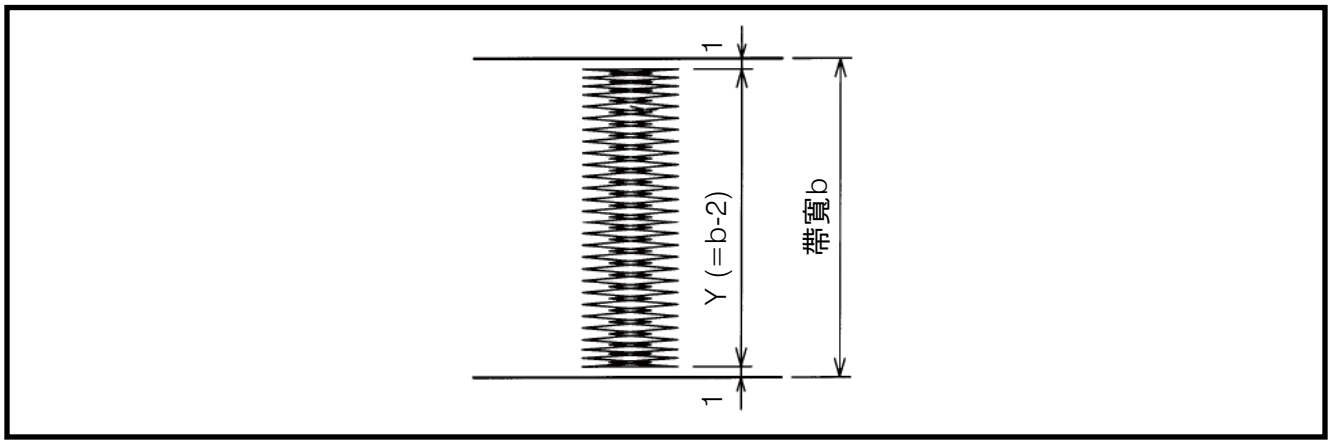
鬆緊帶寬 : 34 ｍｍ , 車縫造型與鄉前一致。

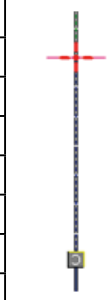
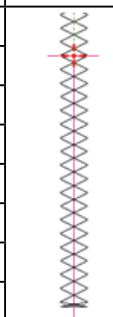
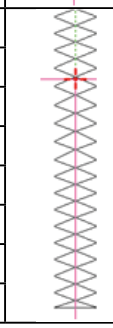
(1) 花樣編號：選擇 35 號

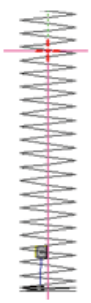
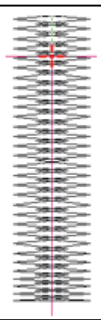
(2) 變更比率：將 Y 軸的比率設為 96 ～ 97%（須依實際效果而定）



•縫製花樣圖形列表



No.	Stitch diagram	Number of stitches	Sewing size	
			Length width	Cross width
1		33	0	20
2		39	0	25
3		45	0	30
4		51	0	35
5		57	0	40
6		63	0	45
7		69	0	50
8		75	0	55
11		38	3	20
12		46	3	25
13		52	3	30
14		60	3	35
15		66	3	40
16		72	3	45
17		80	3	50
18		86	3	55
21		57	5.2	20
22		69	5.2	25
23		77	5.2	30
24		88	5.2	35
25		96	5.2	40
26		109	5.2	45
27		113	5.2	50
28		125	5.2	55

No.	Stitch diagram	Number of stitches	Sewing size	
			Length width	Cross width
31		71	6.4	20
32		87	6.4	25
33		98	6.4	30
34		111	6.4	35
35		127	6.4	40
36		139	6.4	45
37		151	6.4	50
38		163	6.4	55
41		172	9	20
42		212	9	25
43		252	9	30
44		284	9	35
45		324	9	40
46		356	9	45
47		396	9	50
48		428	9	55

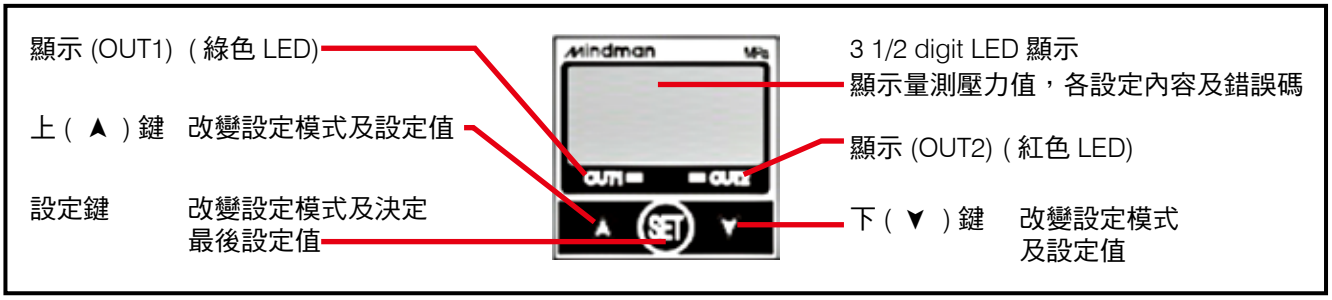
•放大縮小比例的設定範例

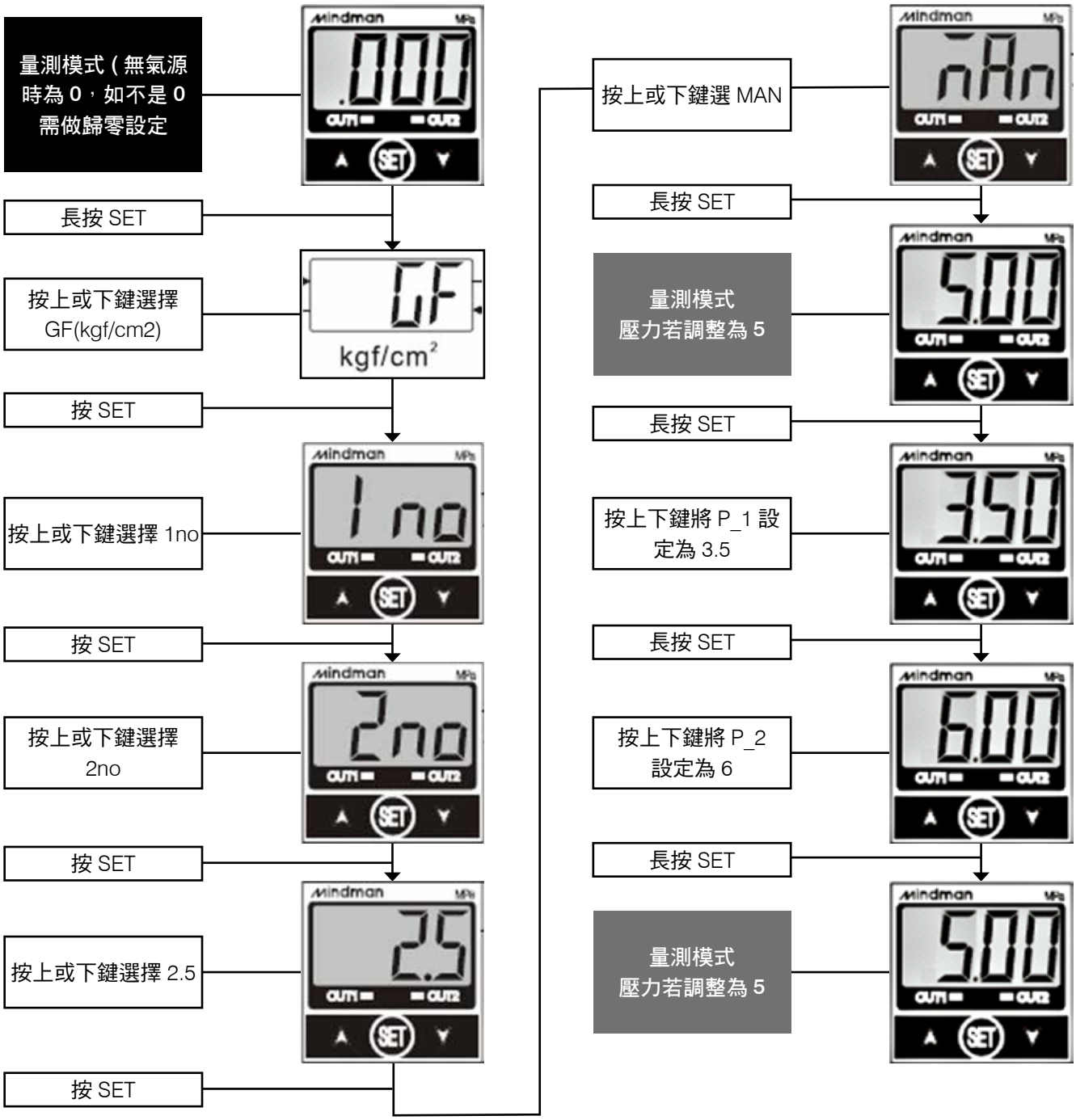
34mm 寬的鬆緊帶，使用與上圖相同的縫製花樣時：

(1) 圖形序號 No.：設定為 No.35。

(2) 放大縮小比例：把 Y-SCALE 設定為 96 ～ 97%（請依實際縫製的結果決定數值）。

數位氣壓表操作說明


顯示 (OUT1) (綠色 LED)
上 (▲) 鍵 改變設定模式及設定值
設定鍵 改變設定模式及決定最後設定值
3 1/2 digit LED 顯示
顯示量測壓力值，各設定內容及錯誤碼
顯示 (OUT2) (紅色 LED)
下 (▼) 鍵 改變設定模式及設定值
Mindman
MPa
OUT1
OUT2
SET


量測模式 (無氣源時為 0，如不是 0 需做歸零設定
長按 SET
按上或下鍵選擇 GF(kgf/cm2)
kgf/cm²
按 SET
按上或下鍵選擇 1no
按 SET
按上或下鍵選擇 2no
按 SET
按上或下鍵選擇 2.5
按 SET
按上或下鍵選 MAN
長按 SET
量測模式 壓力若調整為 5
長按 SET
按上下鍵將 P_1 設定為 3.5
長按 SET
按上下鍵將 P_2 設定為 6
長按 SET
量測模式 壓力若調整為 5

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。

高林股份有限公司
KAULIN MFG. CO., LTD.

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