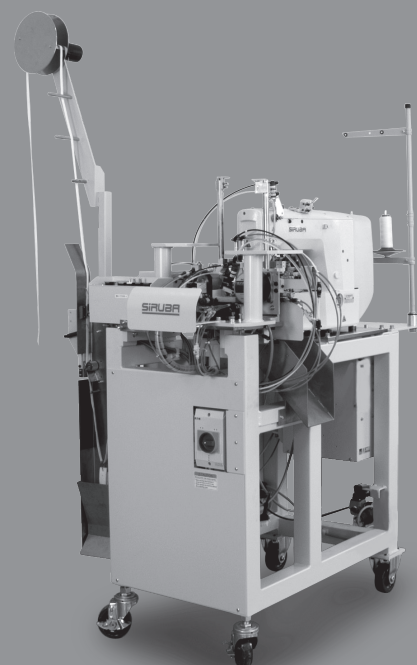


SIRUBA[®] Sew Reach

使用說明書與零件圖

INSTRUCTION BOOK & PARTS LIST

■ ASP-BST100



CE

重要安全聲明

•感謝客戶您購買本公司產品

為安全且正確地使用本產品 ASP-BST100，請詳細閱讀以下注意事項後再實施操作。

1. 在使用本機器前，請先詳讀說明書內容，必須遵守說明書的指示與規定。
2. 此設備的使用，由經過適當訓練的操作人員實行。
3. 在使用本機器時，若發現異常或故障，應立即停止使用，並切除電源，以進行妥善修理。
4. 嚴格禁止對本機器進行改造和變更。本公司對改造或變更過的機器不予保固，若因此造成危害，本公司將不負任何賠償責任。

•危險

為杜絕觸電事故必須遵守以下安全措施。

1. 安裝本機器時，必須確實做好接地動作。
2. 對本機器的電氣做定檢與維修，都必須由具有資格的電氣技術人員執行，或專家的監督指導下進行。

•警告

為了杜絕觸電、火災、燒損或對人的傷害，必須遵守以下安全措施。

1. 本機器在有電壓的狀態下，絕對禁止人員接觸通電之機件。
2. 本機器若需要做零件更換或進行維修時，應將電源切換至 OFF 狀態。

SAFETY INSTRUCTIONS

•Thank you for purchasing our company's products.

For your safety and using our product ASP-BST100 properly, please read the instructions below deliberately, then start operating the machine.

1. Before using the machine, you must follow the instructions and rules.
2. The operators must be well trained.
3. If you found some abnormal phenomena or the machine malfunction, you should stop using the machine at the moment and cut the power off, in order to do the proper repair.
4. Strictly forbid to do the extra transformation or alteration. We do not have the warranty to the machine which had been transformed or altered. Therefore, our company will be irresponsible for any compensation if the machine has caused any danger.

•Hazards

In order to prevent from the electric shock, you must to obey the safety measure below.

1. While install the machine, make sure you have do the grounding.
2. The electric routine inspection and maintenance of the machine have to be done by the electric technical personnel who qualified or under the expert's supervision.

•Alert

You must to obey the safety measure below, in order to prevent from the electric shock, fire accident, burning loss, or human body injured.

1. Absolute forbid workers to touch the machine's parts while the machine is in a voltage state.
2. If the machine's parts need to be changed or do the maintenance, you should switch the power off.

3. 當本機器不能正確工作時，應立即停止操作機器。該機器有必要進行修理、電氣或機器方面的調整時，需要和本公司的代理商或直接與本公司聯繫商談，採取合適的解決措施。
 4. 本機器的的維修、調整須經由適當訓練的技術員或專業人員進行。維修時，需使用本公司所指定的更換零件。
 5. 一般的保修檢查，要由經過適當訓練的人來進行。
 6. 在維修或保養各式氣缸或氣壓相關連動機構時，務必將供應氣源的接頭拔下，在氣壓完全切斷的狀態方可進行。不過，只限於受過適當訓練的技術人員或專業人員進行調整和運行確認時例外。
 7. 該機器準備啟動前，所有的保護蓋必須安裝定位至機器上。
 8. 本機器的內部裝置和控制箱裡不能殘積金屬粉末和灰塵，要定期打掃。
 9. 本機器在運行當中，所有可動部分都絕對不可用手觸碰，或身體（包括頭髮、衣服類）靠近。
 10. 絕對不可用濕手操作，可能造成觸電等重大傷害發生。
 11. 警告提示如次頁圖案，請務必遵守。
3. While the machine cannot operate properly, you should stop operating it immediately. If the machine has the necessity to repair, or do the electric and machine adjustment, you should contact with our factors, or contact us directly, then take the proper resolution.
 4. The machine's maintenance and adjustment need to be done by well- trained technician or professional. You need to use the specific parts from our company while under maintenance.
 5. The repair within the warranty need to be repair by the worker who well trained.
 6. While doing the repair or maintain variety of cylinders and pneumatic actuator associated, you must unplug the supply air source connector before you do the repair and maintenance. However, it could be only done by the well- trained technician or professional.
 7. Before ready to start the machine, all of the protective covers need to be on the position of the machine.
 8. The inner device and the control box of the machine need to be regularly cleaned, in case of any dust or metal filings remains in the machine.
 9. While operating the machine, do not use your hands to touch or let your body to close (including hair or clothes) all of the movable parts.
 10. Do not use the wet hands to operate the machine, it might cause electric shock or other major injured.
 11. Please be sure to follow the alert pictorial markings by next page.

警告圖案表示

INDICATED THE ALERT PICTORIAL MARKINGS

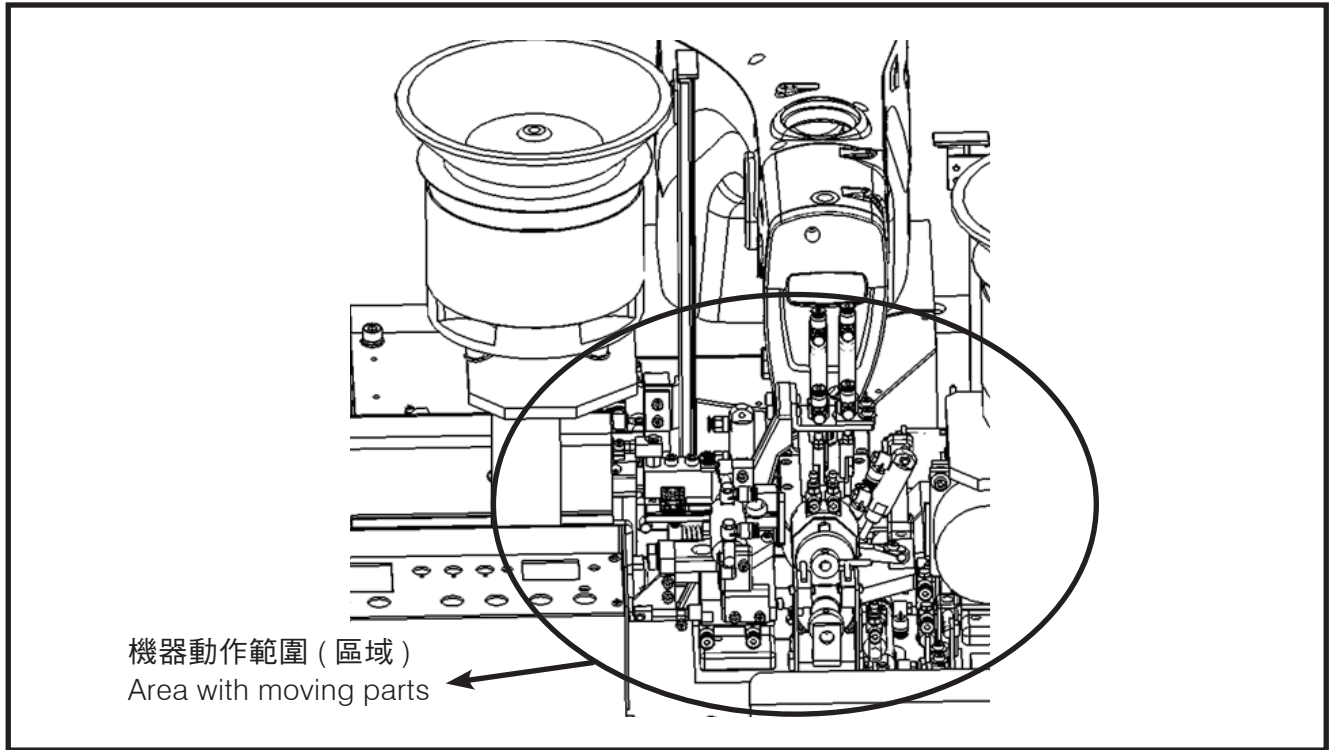
<p>高壓部位 HIGH-VOLTAGE POSITION</p>	 <p>高壓電危險 DANGER</p> <p>注意-請關閉電源10分鐘後始可打開此蓋 TO OPEN THIS COVER: TURN OFF POWER SUPPLYING AND WAIT MORE THAN 10 MINUTES BEFORE OPENING.</p>	<p>務必關閉電源 10 分鐘後始打開電控箱蓋子 Be sure to turn off the power and wait till 10 minutes before opening the control box's cover.</p>
<p>高速運動部位 HIGH SPEED MOTION POSITION</p>	 <p>CAUTION</p> <p>機械作動部份請注意裝上保護裝置 穿線、換線、調整、清潔時請注意關閉電源。 Moving parts may cause in jury. Operate with safety devices. Turn off main switch before threading, changing bobbin and needle, cleaning etc.</p>	<p>謹防工傷事故 In case of industrial accident</p>
<p>高速運動部位 HIGH SPEED MOTION POSITION</p>	 <p>Be careful of its movement. 移動快速 敬請小心</p>	<p>謹防工傷事故 In case of industrial accident</p>
<p>高速運動部位 HIGH SPEED MOTION POSITION</p>		<p>謹防工傷事故 In case of industrial accident</p>

安全注意事項

SAFETY INSTRUCTIONS

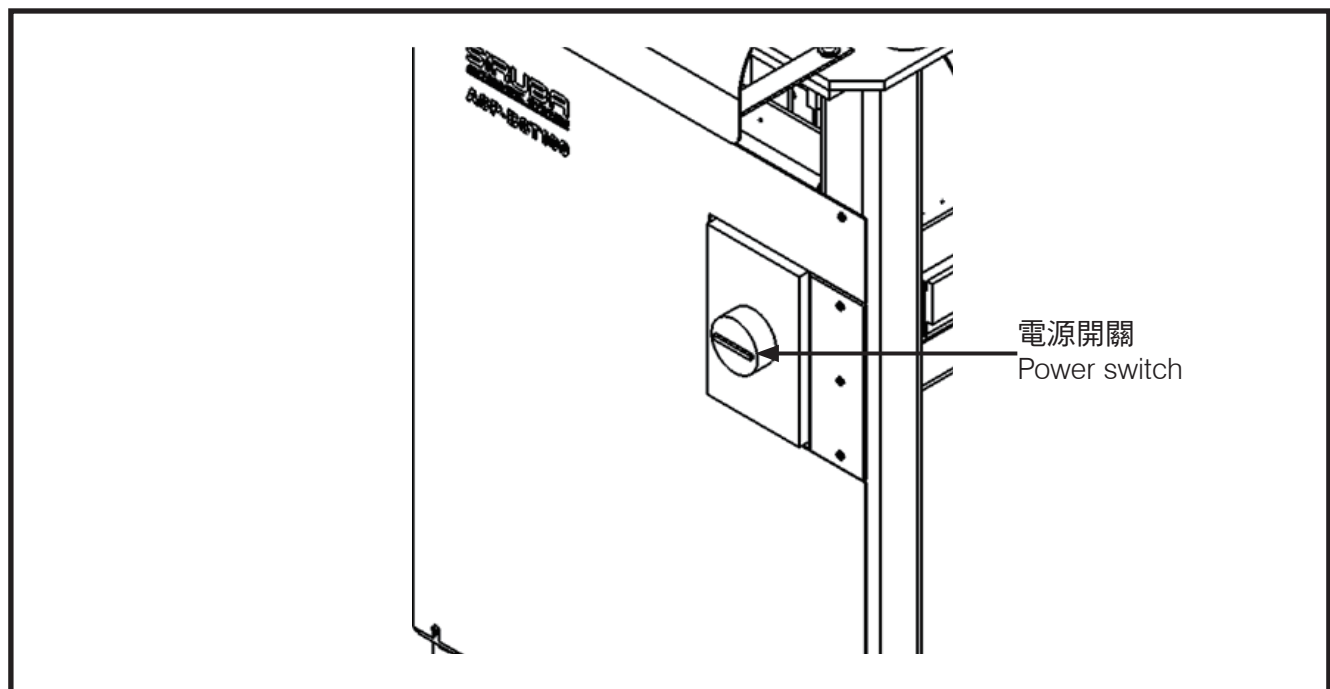
1. 當機器運作中時，請勿將手指等放入機器動作範圍內。

1. Do not put a finger or any other object in the area where there are moving parts while the machine is working.



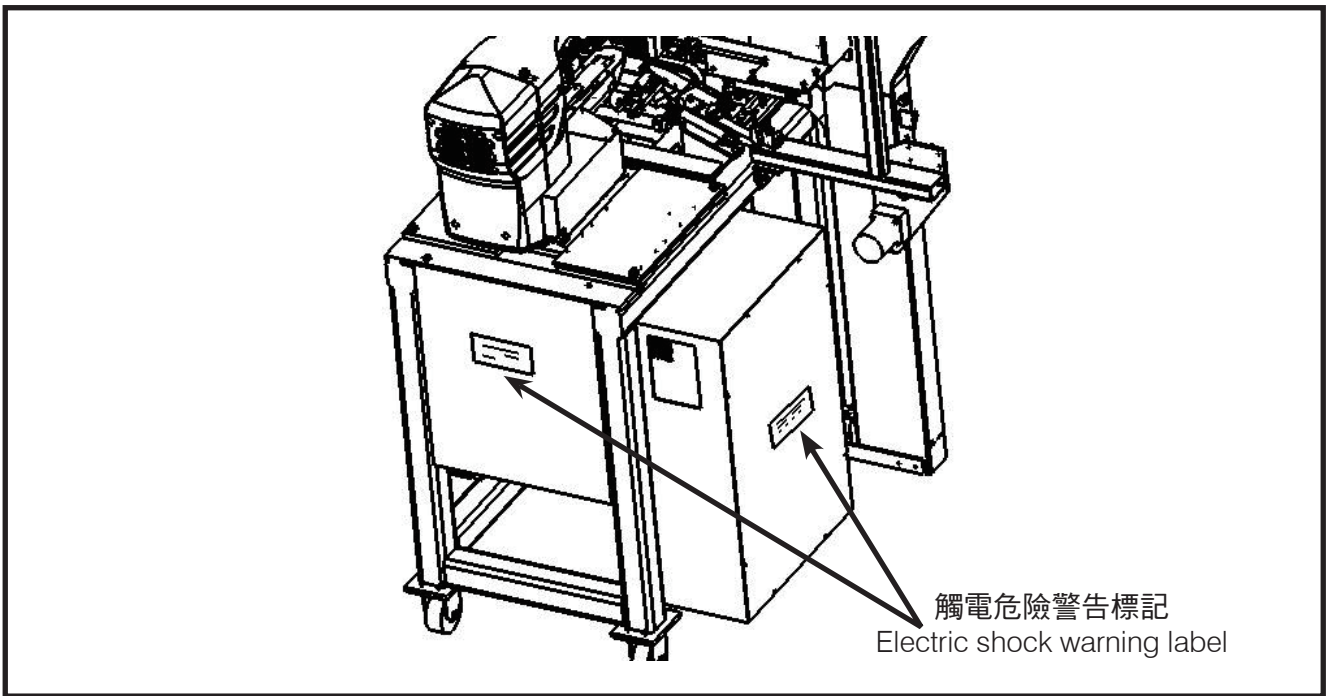
2. 為了保修檢修卸掉罩蓋時，必須將電源切到 OFF。

2. Be sure to turn off the power switch when the cover is removed for an inspection.



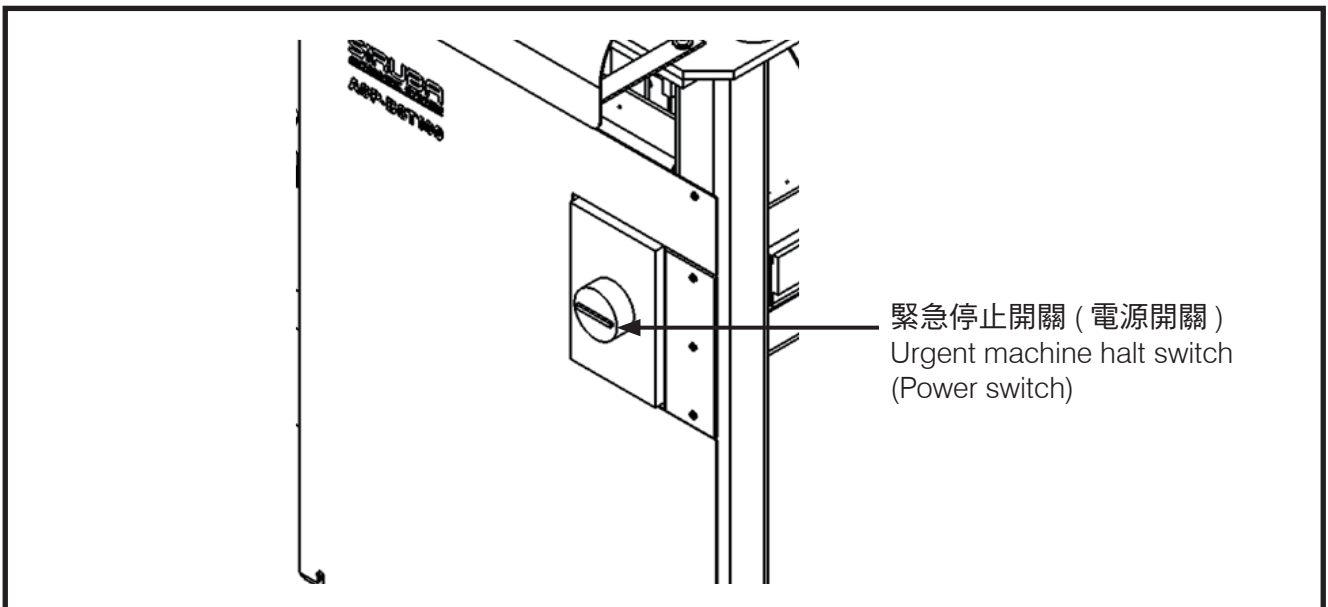
3. 對危及人體的高壓電處，貼有觸電危險警告標記。在貼有本警告的電器控制部位而需要保修、檢修時，打開罩蓋僅能由專業的電氣技術人員進行。

3. An electric shock warning label is affixed where there is high voltage electric terminal which is dangerous to the human body. Nobody except a special electrician should open the cover to inspect a control box with a warning label.



4. 機器運轉時，有必要馬上停止機器的時候，請將緊急停止開關轉到 OFF。

4. If there's a necessity to stop the machine right away while machine operating, you could press the urgent machine halt switch to switch the power off.



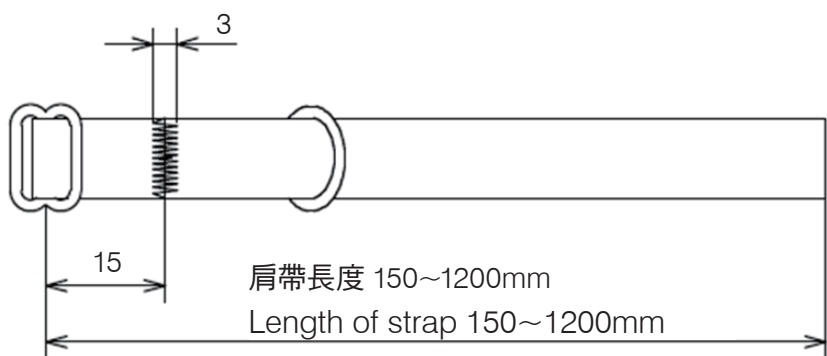
5. 電源線、氣壓管線需確實固定安置，不可散落在地面，以免人員絆倒而發生危險。
6. 為了生命安全，在任何情況下，不可將電源地線拔掉運轉機器。
7. 打雷時，為了安全要停止作業，切斷電源。
8. 離開機器工作地點時或工作結束後一定要將電源開關轉到 OFF。
9. 機器運轉下，不可卸下罩蓋類。

5. Power cord and pneumatic cord should be settled, in order to prevent people from stumbling.
6. For safety do not operate the machine when it is not earthed.
7. When there is lightning, stop the machine and pull out the plug for safety.
8. Turn off the power switch when you are not near the machine or after the operation is finished.
9. Do not operate the machine with the covers off.

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規格

SPECIFICATION

型號 Model	ASP-BST100
使用針型 Needle Type	DP x 5 SERV7 75 (藍獅) DP x 5 SERV7 75 (Schmetz)
縫製速度 Sewing speed	2000 RPM (最高 /Maximum)
生產能力 Productive capability	五秒 / 約肩帶一條 (當肩帶製作尺寸為 400 mm 時) Approximately 5 sec. / 1 product (As product sewing size is 400 mm)
寬度 Width	7mm ~ 18mm
電源 Power source	單相 / 3相 200~240V 50/60Hz 3.5A(最大) (視客戶需求) Single-phase / 3-phase 200~240V 50/60Hz 3.5A(Maximum) (Depend on customer's need)
氣壓 Air pressure	0.5MPa
空氣消耗量 Air consumption	30L / 分 30L/min
機器尺寸 Machine size	寬 1200× 深度 1050× 高 1900 mm Width 1200×Depth 1050×Height 1900 mm
縫紉尺寸 Sewing size	 <p>肩帶長度 150~1200mm Length of strap 150~1200mm</p>
完成尺寸 Finish product size	150 ~ 1200 mm

安裝

INSTALLATION

※ 注意：安裝作業需兩人以上執行。

1. 八字扣保持器①

(1)將座板②用螺絲③ (2 顆) 固定。

(2)安裝標準

八字扣保持器①與扣環供給底板④的縫隙為 0.2mm。

扣環供給底板④倒退到最後時，讓八字扣保持器①底部⑤的內側面和扣環供給下④的槽一致。

※Caution※ The installation work need two or more people to proceed.

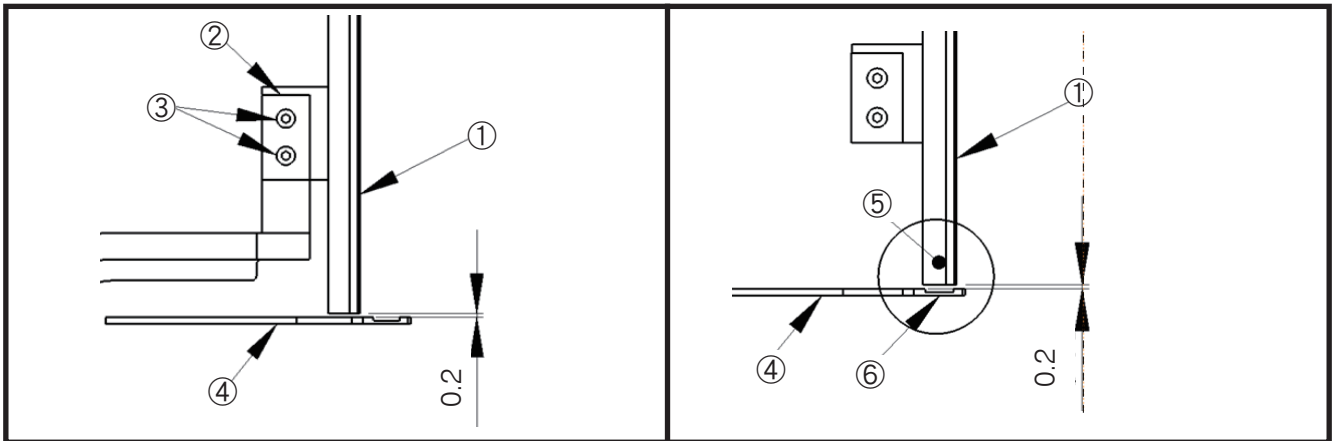
1. 8-shaped buckle feeding stand ①

(1)Use two screws③ to fix plate② .

(2)Install standard

The gap of 8-shaped buckle feeding stand ①and buckle feeding bed④ are 0.2mm.

As buckle feeding bed④ go backward at the end, let the inner side of 8-shaped buckle feeding stand①'s bottom⑤ and the notch④under the buckle feeding stand at the same position.



2. 圓扣保持器⑦

(1)將圓扣保持器⑦用螺絲⑧ (2 顆) 固定。

(2)安裝標準

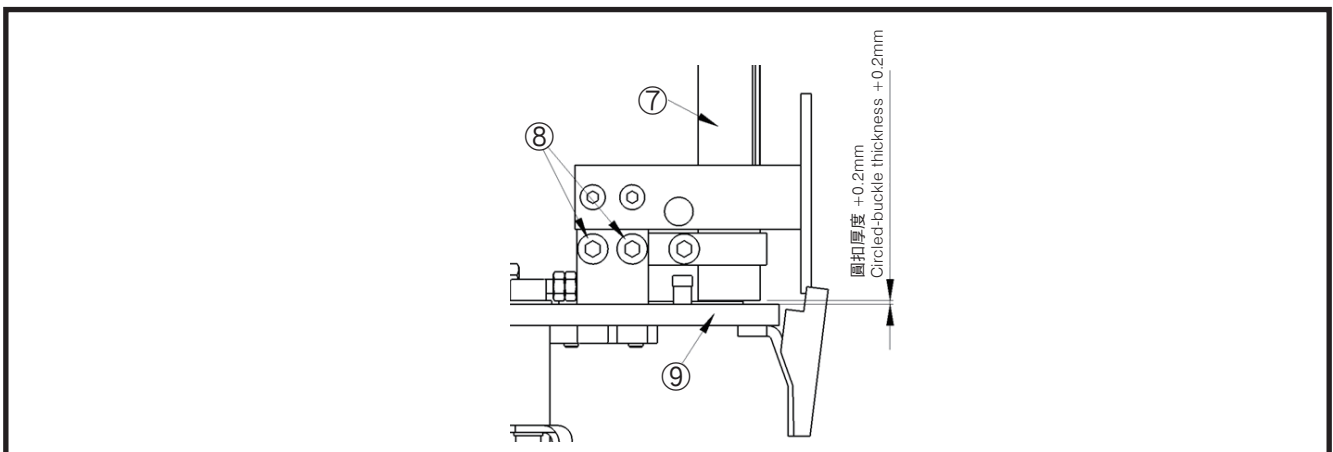
圓扣保持器⑦與圓扣供給底板⑨的縫隙為圓扣厚度的 +0.2mm。

2. Circled-buckle feeding stand ⑦

(1)Use two screws⑧ to fix circled-buckle feeding stand ⑦.

(2)Install standard

The gap between circled-buckle feeding stand⑦ and circled-buckle feeding bed⑨ are the thickness of circled-buckle +0.2mm.



運轉準備

PREPARATION FOR OPERATING

1. 電源電壓

- (1) 在限定電壓的 $\pm 10\%$ 以內使用。
- (2) 必須接地線。

2. 氣壓

- (1) 設定為 0.5MPa

3. 加油

- (1) 縫紉機頭部依照 LK-1900A 的使用指南加油。
- (2) 定期在紅漆標記的給油處為裝置加油。

4. 穿線

- (1) 在斷線檢測器①穿線。
- (2) 依照 LK-1900A 的使用指南穿線。

1. Power voltage

- (1) Limited voltage uses within $\pm 10\%$.
- (2) Need to be earthed.

2. Air pressure

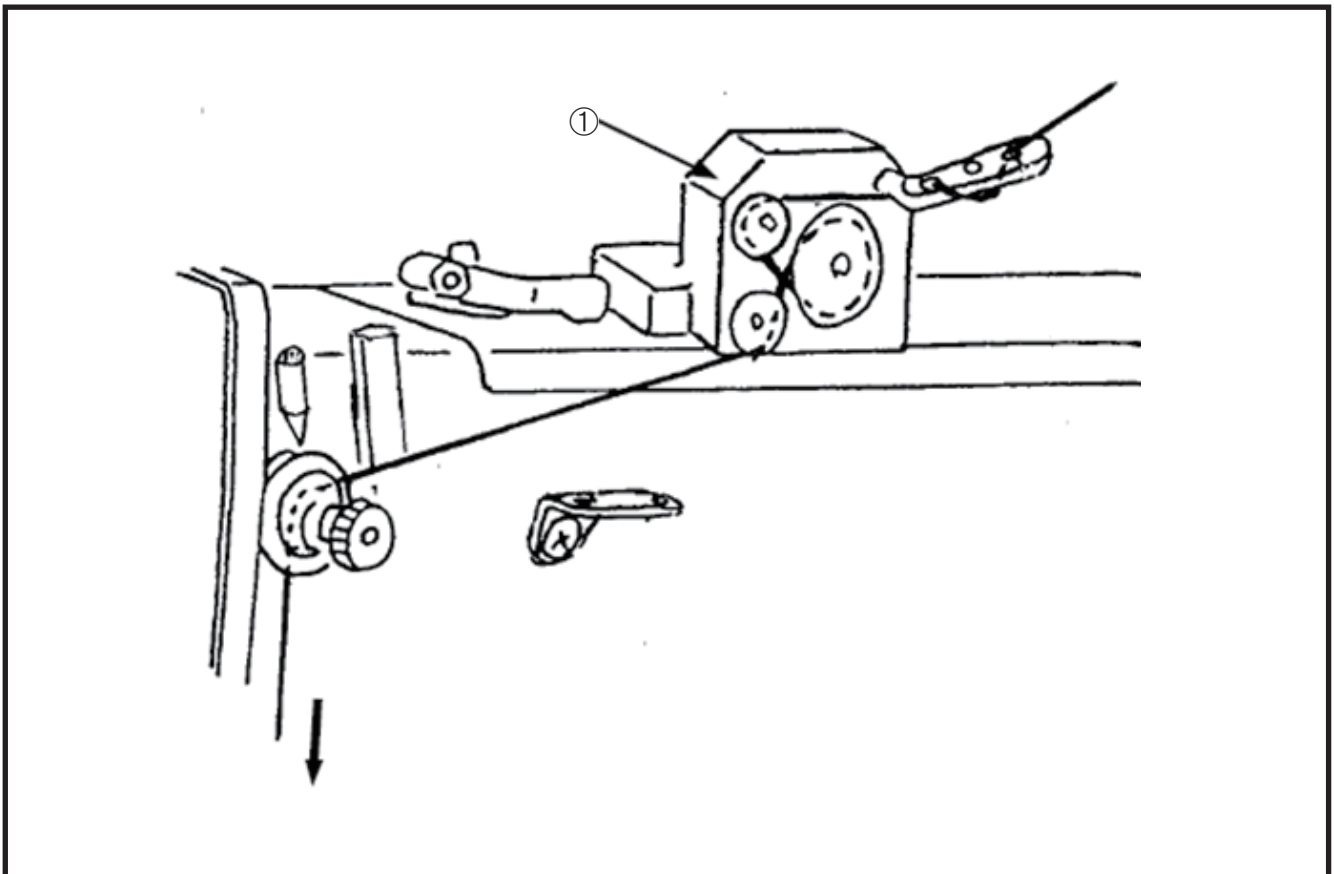
- (1) Set at 0.5MPa

3. Lubrication

- (1) Lubricate to sewing head according to LK-1900A instruction manual.
- (2) Regularly lubricate to the device on the red marking places.

4. Threading

- (1) Thread at disconnecting detector①.
- (2) Thread according to LK-1900A instruction manual.

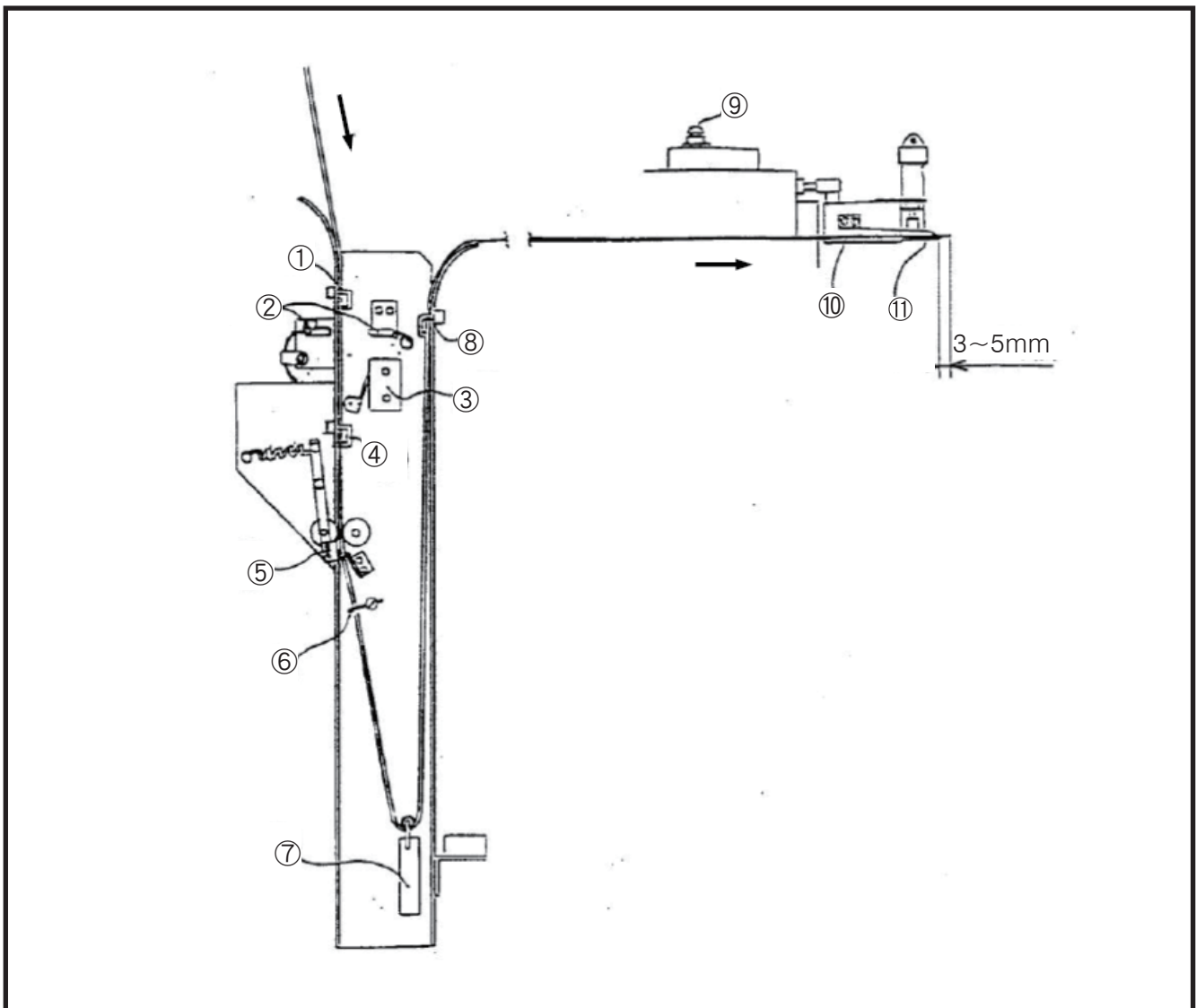


肩帶裝置方向

STRAP INSTALL METHOD

- (1) 通過送帶導柱①。
- (2) 通過肩帶結束開關②的中間。
- (3) 提起肩帶接縫開關③柄桿通過。
- (4) 通過送帶導柱④。
- (5) 提起送帶滾輪⑤的柄桿通過。
- (6) 從導帶線⑥的圈中通過。
- (7) 通過帶墜⑦。
- (8) 通過送帶導柱⑧。
- (9) 按夾帶開關⑨，將帶子放入夾帶盒⑩的槽部，從夾帶盒⑪露出約 3~5mm。

- (1) Through tape feeding guide part①.
- (2) Through the middle of strap sensor②.
- (3) Lift the shaft of seam strap sensor③ and make through.
- (4) Through tape feeding guide part④.
- (5) Lift shaft of tape feeding roller⑤ to make through.
- (6) Through the antistatic coil⑥.
- (7) Through the counterweight⑦.
- (8) Through tape feeding guide part⑧.
- (9) Press strap-fixed switch⑨, put the strap in the notch⑩ of strap-fixed device and reveal 3~5mm from the strap-fixed device⑪.

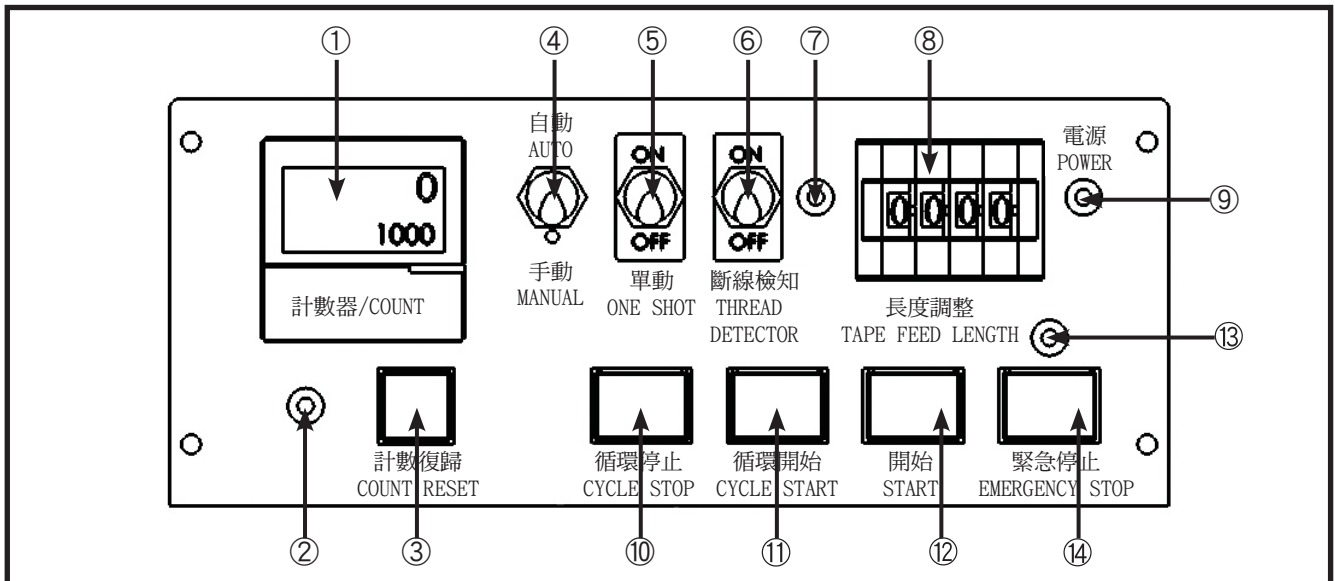


操作

OPERATION

1. 操作面板

1. Operation panel



開關名稱 Name	功能 Function
① 計量下線 Count	下線消費量計算的設定。(以 1 鎖針 1 計算) 當其計算與設定值一致時將自動停止。(MANUAL 時則不進行計算) Setting of counting lower thread consumption. (one stitch one count) Automatically stop as the counting is the same as setting value. (Will not counting as MANUAL.)
② 累計器燈 Counter Lamp	下線消費自動停止燈。(P9) Lower thread consuming automatically stop lamp. (P9)
③ 下線累計重新設定開關 Count Reset	將下線計算重新設為「0」。(P9) Reset lower thread counting as 「0」(P9)
④ AUTO/MANUAL 切換開關 AUTO/MANUAL Switch	自動：切換成自動運轉模式。(P7) 手動：切換成縫紉機單獨運轉模式。(P12) Auto : Change to auto-operation mode. (P7) Manual : Change to sewing machine isolated operate mode. (P12)
⑤ 單步操作切換開關 One Shot Operation Switch	切換成單步操作模式。(P11) Change to one shot operation mode. (P11)
⑥ 斷線切換開關 Thread Detector	將斷線自動停止狀態調至 ON/OFF 狀態。 Adjust the thread break auto-stop status to ON/OFF.
⑦ 斷線燈 Thread Detector Lamp	斷線自動停止燈 (燈亮) → 恢復操作順序為 (P9) 斷線不良自動停止燈 (燈滅) → 復歸操作順序為 (P9) Thread break auto-stop lamp (Light up) → Sequence of return to operation (P9) Defective thread break auto-stop lamp (Light off) → Sequence of return to operation (P9)
⑧ 送量設定開關 Tape Feed Length Switch	帶子長度的設定。(單位：約 1 mm) Setting of tape's length (Unit : About 1 mm)

開關名稱 Name	功能 Function
⑨電源燈 Power Lamp	電源開關ON時燈亮。 Light up when power switch ON.
⑩單次循環停止開關 Cycle Stop Switch	1. 自動運轉的停止。 2. 單次循環運轉。(只想製作一個作品時) 3. 定時運轉的最初啟動。(只想制作一個作品時) 1. Auto-operation stop. 2. One cycle operation. (Make one product only.) 3. The initial start of time operation. (Make one product only.)
⑪循環啟動開關 Cycle Start Switch	1. 自動運轉的啟動。 2. 單次循環運轉的最初動作啟動。 1. Start of auto-operation. 2. Initial start of single-cycle operation.
⑫啟動開關 START Switch	1. 扣環用完，帶子用完以及檢測出接頭而自動停止後的再啟動。 2. 八字扣固定器中重新設定扣環。 3. 緊急停止後的再啟動。 4. 斷線不良自動停止後的再啟動。 5. 下線計算後的再啟動。 6. 單步操作之後的動作啟動。 7. MANUAL 模式時的縫紉機啟動。 8. (任選) 圓扣裝置不良時，圓扣重新設定。 1. Auto-stop when run out of buckles, tape, and detected piecing then start all over. 2. Reset buckles in 8-shaped buckle holder. 3. Start again after emergency stop. 4. Start again after defective thread break auto-stop. 5. Start again after counting lower thread. 6. Motion start after single-operation. 7. Sewing machine start in MANUAL mode. 8. (Optional) Reset circled-buckle as circled-buckle device defective.
⑬停止燈 Stop Lamp	1. 扣環用完後自動停止燈。(燈亮)(P8) 2. 肩帶用完時自動停止燈。(燈亮)(P8) 3. 檢測出接頭時自動停止燈。(燈亮)(P8) 4. 八字扣固定器中的裝置不良燈。(燈亮)(P8) 5. 緊急停止燈。(燈亮) 6. (任選) 圓扣裝置不良燈(燈滅)→恢復操作順序為(P8) 1. Auto-stop lamp after run out of buckle. (Lights up) (P8) 2. Auto-stop lamp after run out of strap. (Lights up) (P8) 3. Auto-stop lamp while detecting strap. (Lights up) (P8) 4. 8-shaped buckle holder defective lamp (Lights up) (P8) 5. Emergency stop lamp (Lights up) 6. (Optional) Circled-buckle device defective lamp (Lights off) → Sequence of return to operation (P8)
⑭緊急停止開關 Emergency Stop Lamp	全部動作停止。 Whole motions stop.

2. 自動運轉的啟動以及停止

將 AUTO/MANUAL 切換開關①轉換成 AUTO。

(1)連續運轉

- 啟動：按開關②「循環啟動（白）」。
- 停止：按開關③「單次循環停止（黃）」。

(2) 1 循環運轉

- 啟動：按開關③「單次循環停止（黃）」。
- （只製作一個作品後，停止）

2.Auto-operation Start & Stop

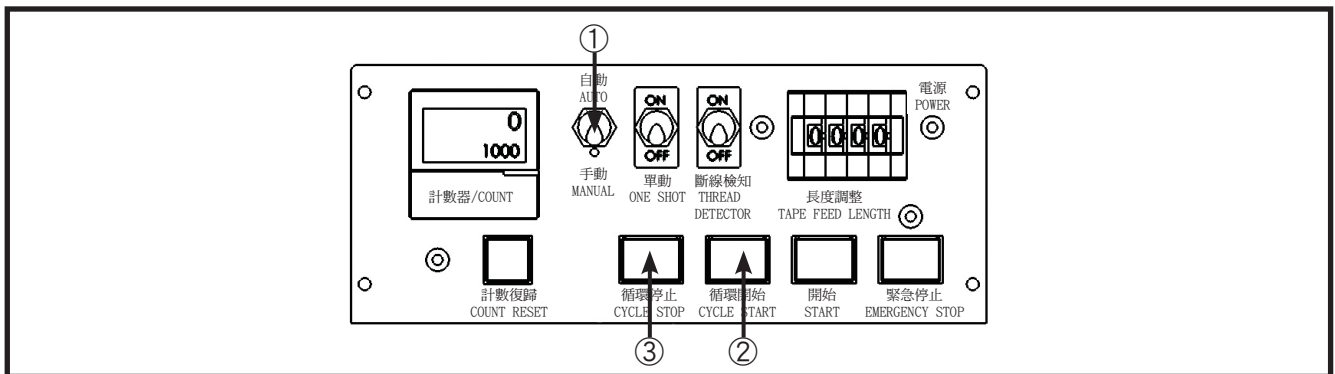
AUTO/MANUAL switch① turn on AUTO.

(1)Continuous operation

- Start : Press switch② 「Cycle-Start (White) 」 .
- Stop : Press switch③ 「 Single-cycle stop (Yellow) 」 .

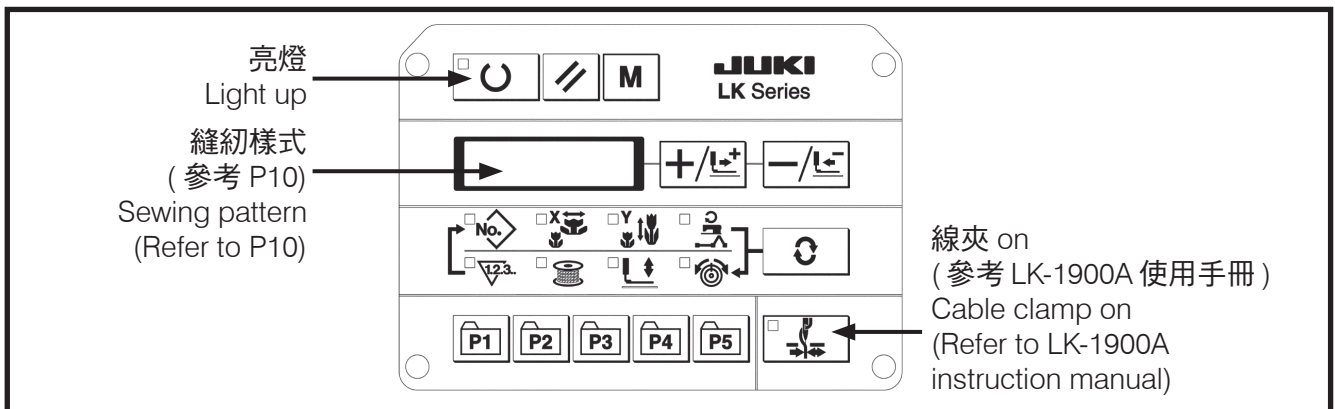
(2)Cycle operation

- Start : Press switch③ 「 Single-cycle stop (Yellow) 」 . (Make one product only then stop.)



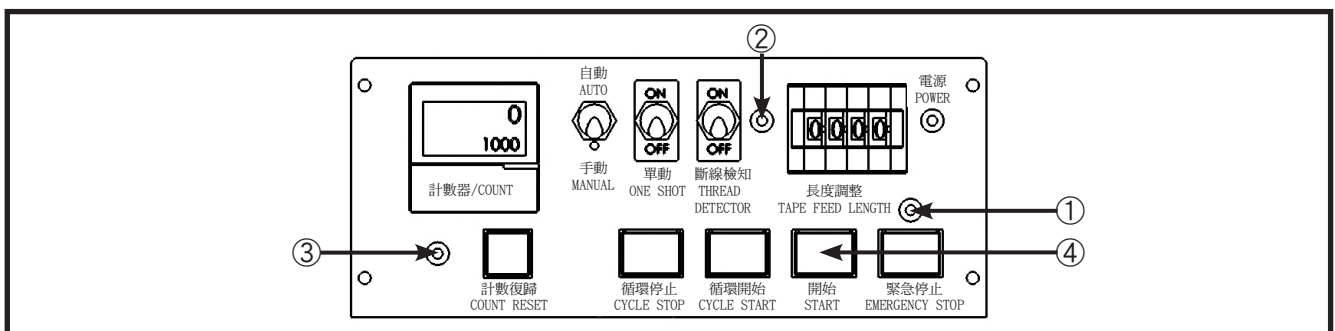
※ 當電源開關調至 ON 時，LK-1900A 操作面板表示。（有關 LK-1900A 操作板的詳細程序，請參照 LK-1900A 使用指南）

※ LK-1900A operation panel will show, when power switch ON. (Please refer to LK-1900A instruction manual for LK-1900A operation panel detailed procedure.)



3. 自動停止燈燈亮、燈滅時的復原操作。

3.Auto-stop lamp's lamp signal, operation again as light off.



- (1) 當停止燈①燈亮時
- 八字扣保持器裡的八字扣剩下一點時
補充八字扣，按開關④「啟動（綠）」後重新啟動。
 - 圓扣保持器裡的圓扣剩下一點時
補充圓扣，按開關④「啟動（綠）」後重新啟動。
 - 肩帶用完時
重新裝置肩帶，按開關④「啟動（綠）」後重新啟動。
 - 檢測出肩帶接口
除去接口後，重新裝置肩帶，按開關④「啟動（綠）」後重新啟動。
 - 八字扣固定器裡的八字扣沒裝置完整
按開關④「啟動（綠）」→八字扣重新設置後繼續進行作業。

- (2) 停止燈①燈滅時「當附有圓扣檢測裝置（任選）時」※1
- 圓扣沒補給足夠
 - 檢查圓扣供給裝置，確認圓扣裝置沒被阻塞。（如有阻塞物請將阻塞物除去）
 - 按開關④「啟動（綠）」→圓扣重新設置後繼續進行作業。

【注】就算電源開關為 ON 狀態，停止燈①為燈滅時仍可按開關④「啟動（綠）」→圓扣重新被設置，等待啟動（待機狀態）。

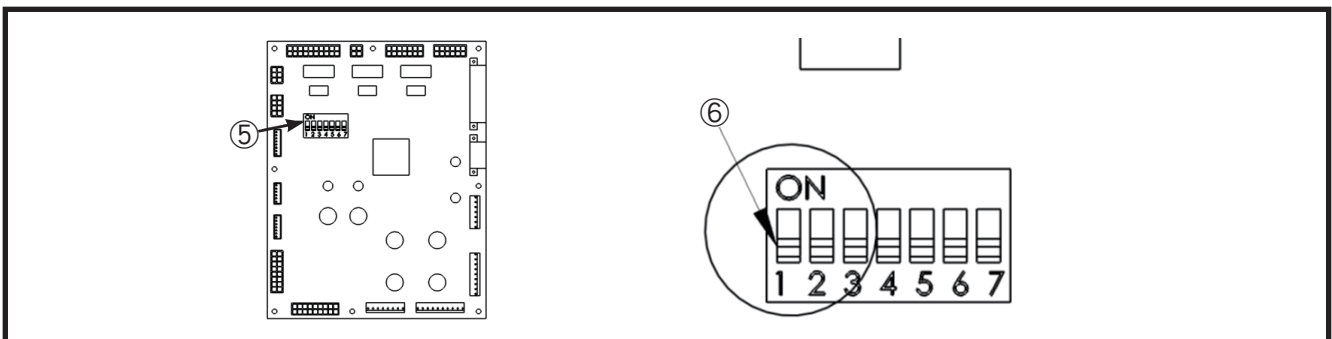
※1：當圓扣檢測器為無效狀態時，拆卸基板⑤雙列開關 DS1 的 NO.1（⑥）為 ON。

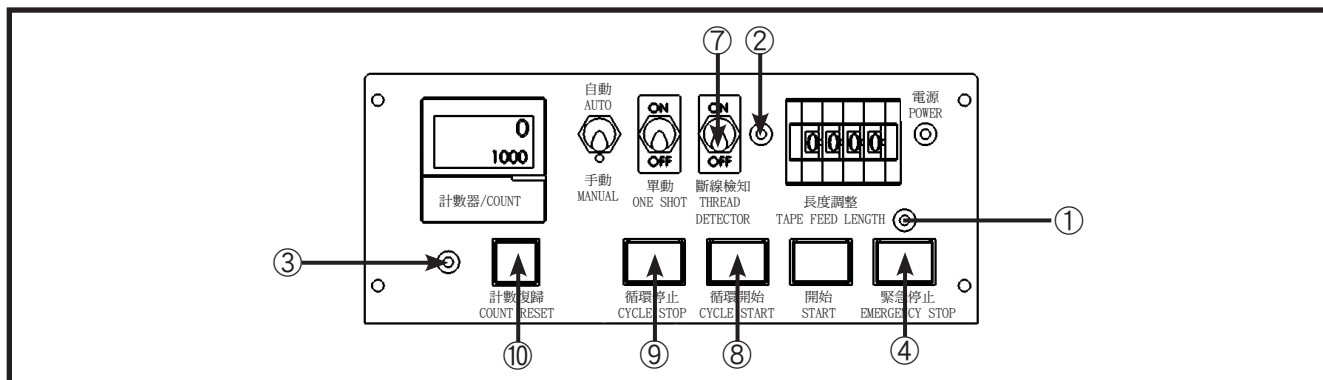
- (1) When Stop lamp① lights up.
- 8-shaped buckle remains a little in the 8-shaped buckle feeding stand. Resupply 8-shaped buckles, press switch④「START（green）」 then restart.
 - Circled-buckle remains a little in the circled-buckle feeding stand. Resupply circled-buckles, press switch④「START（green）」 then restart.
 - Run out of strap.
Reset strap, press switch④「START（green）」 then restart.
 - Detect the seam of strap.
After detach the seam, reset the strap, then press switch④「START（green）」 then restart.
 - The 8-shaped buckles in the 8-shaped buckle holder do not set completely.
Press switch④「START（green）」→ Redo operation after reset 8-shaped buckles.

- (2) Stop lamp① lights off 「With circled-buckle detecting device（Optional）」
- Circled-buckle insufficient.
 - Check circled-buckle feeding device, make sure that circled-buckle device do not be jammed.（Remove the jam if there have any.）
 - Press switch④「START（green）」→Redo operation after reset circled-buckles.

【Note.】You still could press witch④「START（green）」 even power on and the stop lamp① lights off.→ Reset circled-buckle and wait for starting（Standby status）.

※1：When circled-buckle detecting device is invalid, switch board⑤dual lines DS1's NO.1（⑥）is ON.





(3) 斷線燈②燈亮時（當斷線開關⑦）為 ON 狀態時。

a. 切斷上線

- 將電源開關調至 OFF。
- 邊按肩帶固定器開關「參照 P4 的（肩帶裝置方法）」，將下個肩帶的先端以手動方式調回開始的位置。
- 穿線。
- 將電源開關調至 ON。
- 將縫紉機下殘餘的肩帶除去後，按開關⑧「循環啟動（白）」重新啟動。

(3) When thread break lamp② lights up, the thread detector⑦ is ON.

a. Cut off upper thread

- Switch OFF power switch
- Press strap-fixed device switch 「Refer to P4 (Installation of strap)」, and adjust the front end of the next strap to the beginning position in manual way.
- Threading.
- Turn power switch ON.
- After detached the remaining strap under the sewing machine, press the switch⑧「Cycle Start (white)」 and restart.

• 想要重新縫製發生斷線的肩帶時，可依下列步驟重新啟動。

- 在不變動縫紉機下肩帶的狀態下穿線。
- 同時按下「單次循環停止（黃）」⑨、「循環啟動（白）」⑧、「啟動（綠）」④三個開關。→當肩帶被重新縫製後，繼續進行作業。

(4) 斷線燈②燈滅時（就算斷線切換開關⑦為 OFF 狀態也可進行動作）。

a. 斷線不良

- 用剪刀等工具剪去剩餘的線。
- 按開關④「啟動（綠）」→將堆垛機歸回縫紉機旁，繼續進行作業。

(5) 計算燈③燈亮

a. 下線計算計算完畢

- 按開關⑩「下線計算重新設定（藍）」。
- （連續運轉中狀態時）按下「啟動（綠）」開關。→繼續進行動作（循環停止時）按開關⑧「循環啟動（白）」→再次啟動

• If you want to re-sew the strap which thread break, you could restart according to the procedure below.

- Thread strap without moving the sewing machine.
- Press three switches 「Single-cycle Stop (yellow)」⑨, 「Cycle Start (white)」⑧, 「Start (green)」④ simultaneously. → After re-sew the strap, proceed operation.

(4) Thread break lamp② lights off. (Even the thread break switch⑦ is OFF, it could be operated.)

a. Thread break defective.

- Cut off remaining thread with scissors or other tools.
- Press switch④「START (green)」→ let the unloading part back to sewing machine and keep the operation.

(5) Counting lamp③ lights up

a. Lower thread counting finish

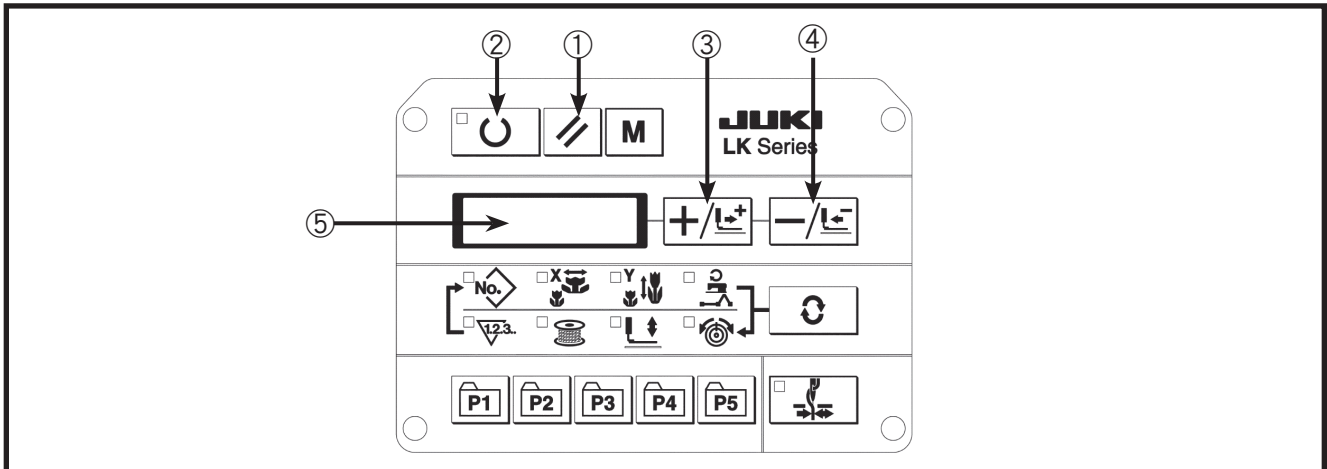
- Press switch⑩「Reset lower thread counting (blue)」
- (Continuous operation) Press 「START (green)」 switch. →Continuous operation (Cycle Stop) Press switch⑧「Cycle Start (white)」→Restart

4. 縫製樣式 NO. 的變更方法

- (1) 按準備鍵①，使縫製②燈滅。
- (2) 利用+按鍵③或是-按鍵④來選擇 NO.5 (參照下表)。
- (3) 按準備鍵①，使縫製 LED ②燈亮。

4. Method of changing sewing pattern NO.

- (1) Press Ready switch① to let the sewing switch② lights off.
- (2) Use + switch③ or - switch④ to choose NO.5 (Reference table below).
- (3) Press Ready switch① to let the sewing switch LED② lights up.

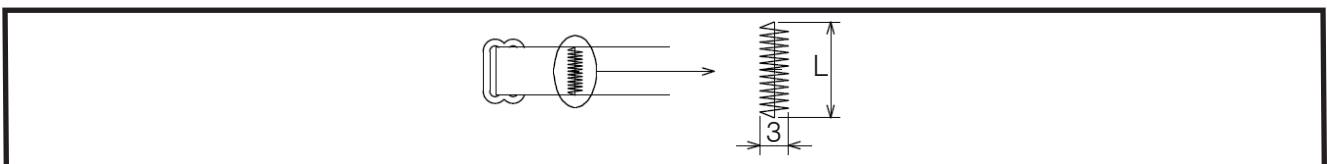


• 標準縫製樣式

1. 縫製尺寸為擴大縮小率 100% 的尺寸。
2. 以標準樣式 NO. 縫製，當縫線位置如下圖偏離時，可使用縫線位置修正用樣式進行修正。修正量為 0.4mm。

• Standard Sewing Pattern

1. Sewing size is to expand the size of the reduction ratio of 100%.
2. Use standard pattern NO. to sew, as the sewing position deviate like below, use sewing position correctional pattern to correct. Correction size are 0.4mm.



L 尺寸 L Size	標準樣式 NO. Standard Pattern NO.	針數 Stitches	縱向縫製位置修正用樣式 Vertical sewing position correctional pattern	
			A: 縫線偏離位置在前側時 A: Sewing deviate position forward side	B: 縫線偏離位置在後側時 B: Sewing deviate position backward side
7mm	2	30	1	3
8mm	12	31	11	13
10mm	22	39	21	23
13mm	32	45	31	33
16mm	42	56	41	43
18mm	52	64	51	53

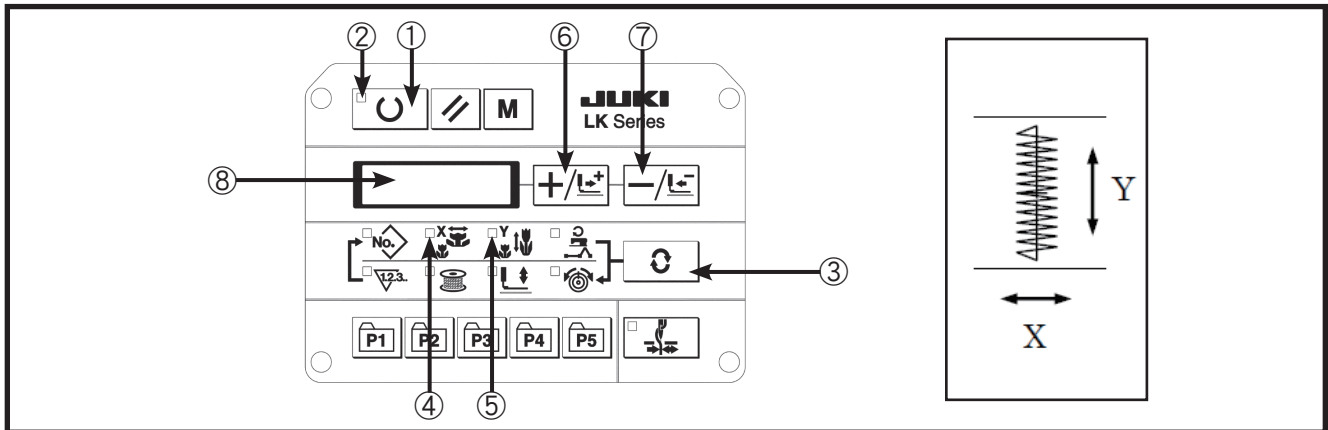


5. 縫製尺寸的放大、縮小方法

- (1) 按準備鍵①，使縫製 LED 燈②熄滅。
- (2) 按選擇鍵③，使 X 放大縮小率燈④或是 Y 放大縮小率燈⑤點亮。
- (3) 利用 + 鍵⑥或是 - 鍵⑦來設定放大縮小率⑧。
- (4) 按準備鍵①，使縫製 LED 燈②燈亮。

5. Method of sewing size magnify and minify

- (1) Press Ready switch① to let sewing LED lamp② lights off.
- (2) Press Selection switch③ to let X scale rate lamp④ or Y scale rate lamp light up.
- (3) Use + switch⑥ or - switch⑦ to set the scale rate ⑧.
- (4) Press Ready switch① to let sewing LED lamp② lights up.

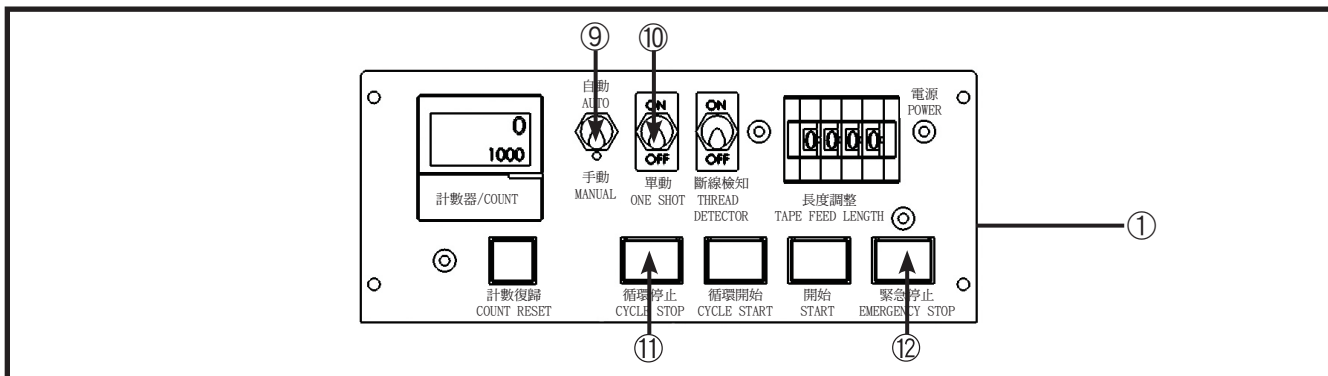


6. 單步操作的運轉

將機械一連貫動作的主要部份一時停止，確認機械動作時機以及裝置位置。

6. One shot operation

Let the main parts of the machine which the connecting action temporary stop, to check the timing of the machine action and position of the device.



- (1) 將 AUTO / MANUAL 切換開關⑨調至 AUTO，單步操作切換開關⑩調至 ON。
- (2) 按開關⑪「單次循環停止（黃）」→停止肩帶被拉出。
- (3) 按開關⑫「啟動（綠）」，進行接下來的動作。之後按開關⑫「啟動（綠）」，進行動作。
- (4) 肩帶的縫製及排出結束後，動作完成。「欲再次重複動作，重新返回 (2)」。

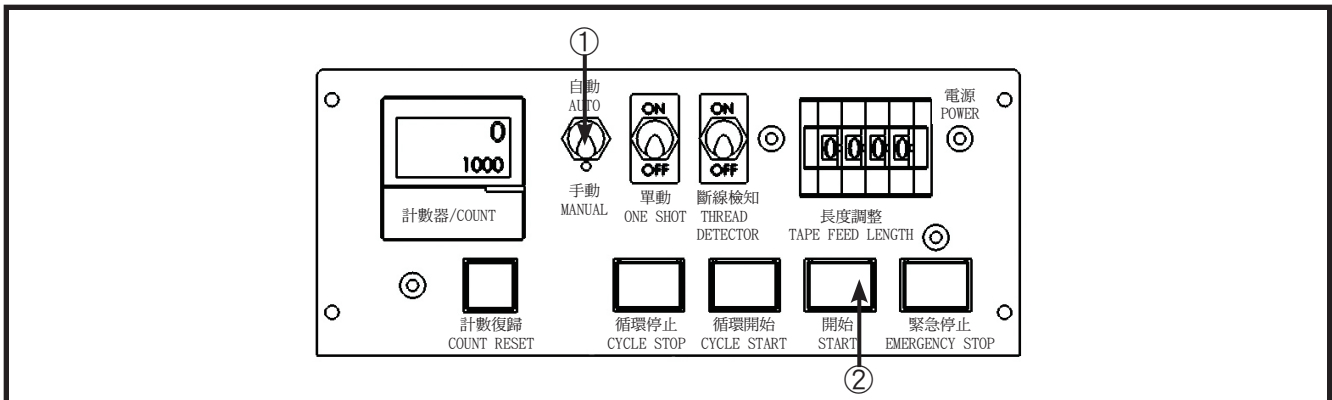
- (1) AUTO / MANUAL switch⑨ turn to AUTO, and ONE SHOT operation switch⑩ turn ON.
- (2) Press switch⑪「Single-cycle stop (yellow)」→ Stop the strap to be pull out.
- (3) Press switch⑫「START (green)」, and proceed to the next action. After, press the switch⑫「START (green)」 to proceed action.
- (4) After strap sewing end and strap out the machine, the action finish. 「Redo the same action, back to (2)」.

7. MANUAL 操作

不更動裝置，只有縫紉機單動作。

7. MANUAL operation

Do not move the device, only the sewing machine single action.



(1) 縫紉機單獨運轉

- 將 AUTO / MANUAL 切換開關①調至 \ MANUAL 。
- 將欲試縫的布料放入縫紉機壓板下，按開關②「啟動（綠）」。

(2) 下線卷

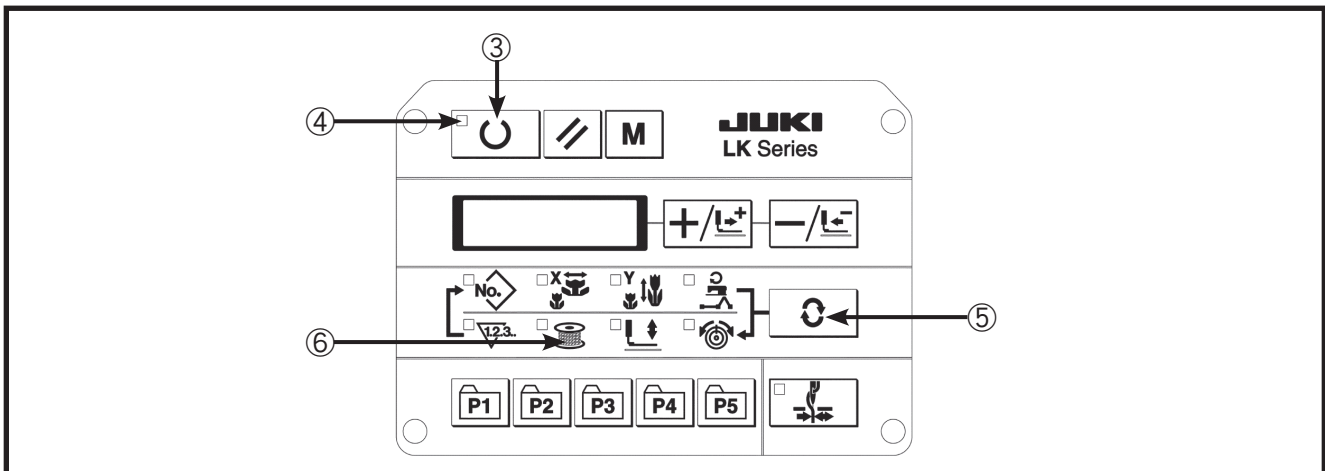
在筒管中下線尚未準備時進行動作。

(1) Sewing machine isolated operation

- AUTO / MANUAL switch① turn to MANUAL.
- Put the sewing fabric under the presser bar of sewing machine, press switch② 「START (green)」

(2) Lower thread reel

Proceed action while the reel of lower thread unready.



a. 將 AUTO / MANUAL 切換開關①調至 MANUAL 。

- 按準備鍵③，使縫制 LED 燈④熄滅。
- 按選擇鍵⑤，選擇線圈⑥。
- 按準備鍵③，使縫製 LED 燈④點亮。
- 按下開關②「啟動（綠）」後下線圈開始動作。（注意針棒此時也會動作，請先將上線從針頭上拔除）
- 再次按下「啟動（綠）」開關②後停止動作。（緊急停止開關也可使其停止動作）

a. AUTO / MANUAL switch① turn to MANUAL.

- Press Ready switch③, to light off sewing LED lamp④.
- Press Selection switch⑤, choose the reel⑥.
- Press Ready switch③, to light up sewing LED lamp④.
- After press switch② 「START (green)」, reel of lower thread start action. (Be careful the needle will be action, too. Please pull out the upper thread from needle first.)
- Press 「START (green)」 switch② again then stop action. (The Emergency stop switch could stop the action, too.)

裝置的標準位置

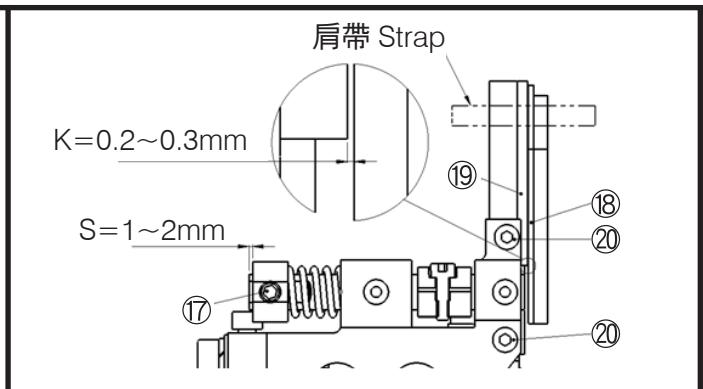
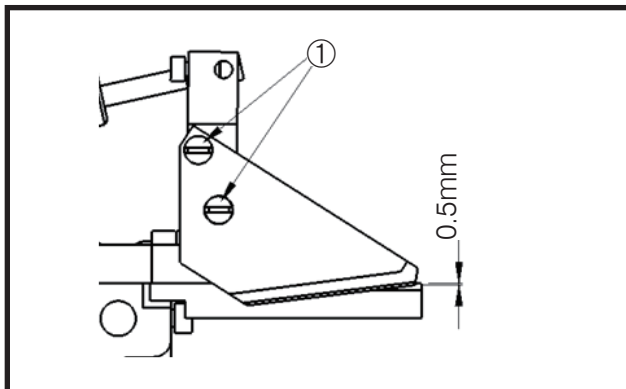
PRECISE POSITION OF DEVICES

1. 切刀

- (1)切刀的咬合為 0.5mm。
【調整】將螺絲①轉鬆調整。
- (2)切刀壓板：尺寸 1~2mm。（如將 S 尺寸調整至必要以上的大小，將會加快切刀的消耗速度）
【調整】將螺絲⑰轉鬆調整。
- (3)可動式切刀⑱降下時，將其就空隙與固定刀具⑲的前端部份保持 $K = 0.2 \sim 0.3\text{mm}$ 的距離。（如將 K 尺寸調整至必要以上的大小，將會加快切刀的消耗速度）
【調整】將螺絲⑳轉鬆調整。

1. Trimmer

- (1)The occlusion of the trimmer is 0.5mm.
【Adjustment】Loosen the screw① to adjust.
- (2)Trimmer presser bar : size 1~2mm. (If adjust the S size larger for necessity, it would accelerate the consumption speed of the trimmer.)
【Adjustment】Loosen the screw ⑰ to adjust.
- (3)Keep the distance $K = 0.2 \sim 0.3\text{mm}$ between movable trimmer ⑱ and the front end of the fixed trimmer ⑲ as the movable trimmer ⑱ lower down. (If adjust the k size larger for necessity, it would accelerate the consumption speed of the trimmer.)
【Adjustment】Loosen the screw ⑳ to adjust.

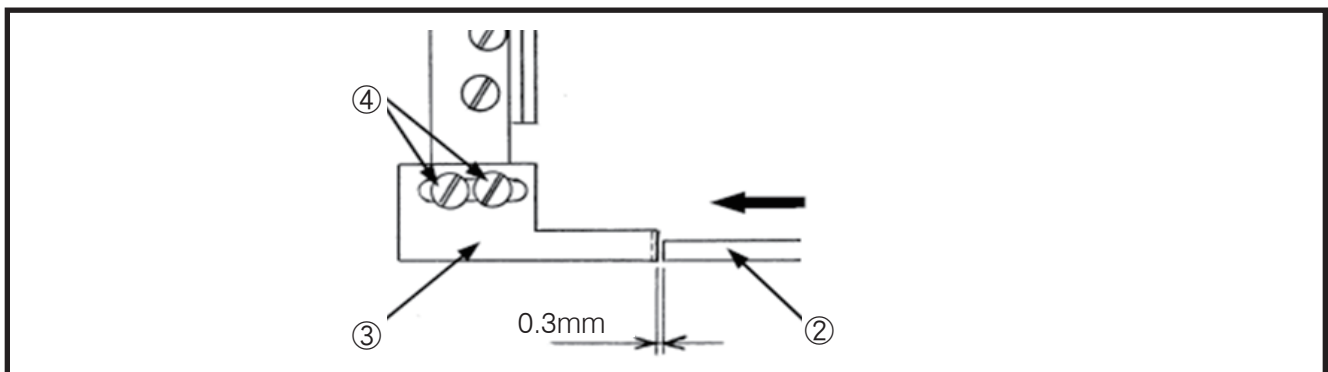


2. 八字扣的標準尺

- 當八字扣固定器②移動到縫紉機旁時，八字扣固定器②與八字扣標準尺③的縫隙為 0.3mm。
【調整】將螺絲④轉鬆調整。

2. Standard ruler of 8-shaped buckle

- When 8-shaped buckle holder② move aside to the sewing machine, the gap between 8-shaped buckle holder②and 8-shaped buckle standard ruler③are 0.3mm.
【Adjustment】Loosen screw④ for adjustment.



3. 扣環供給底板及扣環供給端頭

(1)供給底板⑤的先端與八字扣固定器②之間的縫隙為 0.5mm。

【調整】將螺絲⑥轉鬆，以調整螺絲⑦來調整。

(2)從扣環供給端頭⑧到扣環供給底板⑤的先端距離為 0.2mm。

【調整】將螺絲⑨轉鬆調整。

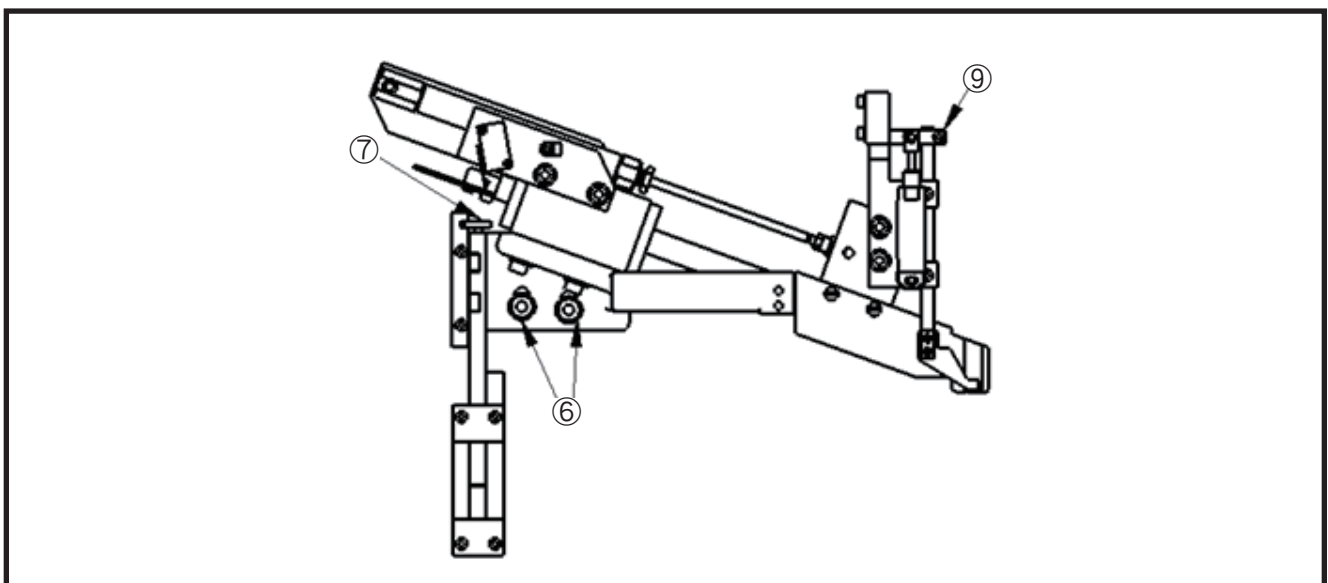
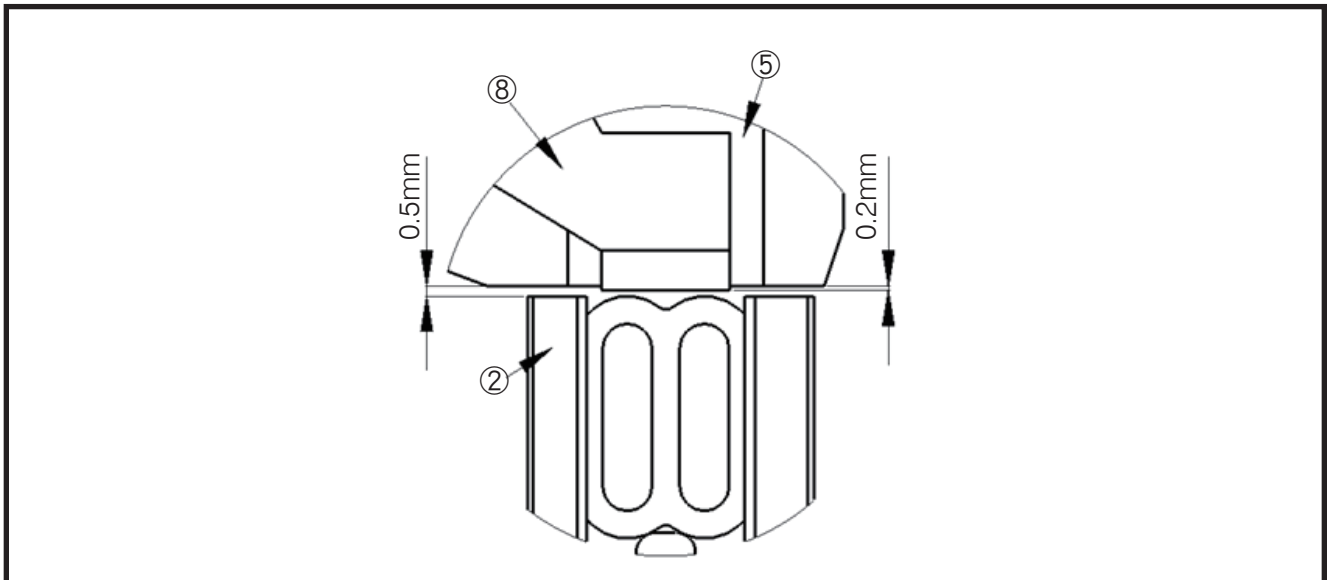
3. Buckle feeding bed and upper end

(1)The gap between the front end of feeding bed⑤ and 8-shaped buckle holder② are 0.5mm.

【 Adjustment 】 Loosen screw⑥ in order to use screw ⑦to adjust.

(2)The distance between the buckle feeding front end⑧ with buckle feeding bed front end ⑤ are 0.2mm.

【 Adjustment 】 Loosen screw⑨ to adjust.



4. 裝置台

當肩帶⑦放入縫紉機壓板⑧的下方時，針頭⑨的中心與縫紉機壓板⑧的記號⑩，肩帶⑦的中心線⑪成為一致狀態。

【調整】將螺絲⑫（3處）轉鬆，並將裝置台⑬以前後方向（箭頭⑭）移動進行調整。

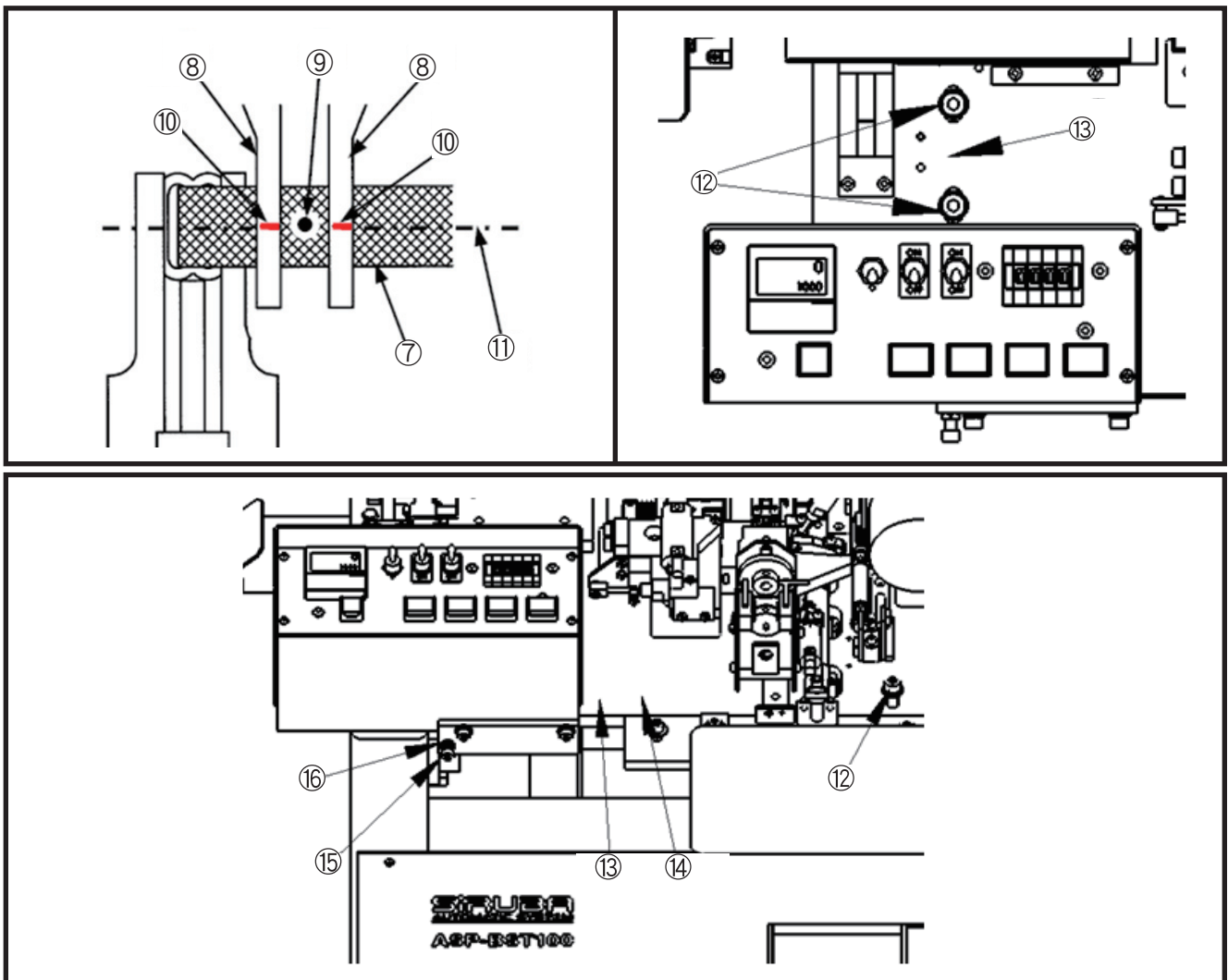
【注】螺絲⑮為決定裝置台⑬位置的螺絲。當裝置台⑬在縫紉機旁動作時，轉鬆自鎖螺帽⑯，將螺絲⑮以逆時針方向轉動後進行動作。欲前後調整裝置台⑬時，將螺絲⑮以順時針方向轉動，用自鎖螺帽⑯固定其停止位置。

4. Device bed

While putting strap ⑦ under the presser bar ⑧ of sewing machine, the marking of the center of the needle end ⑨ and the presser bar ⑧ of sewing machine would align with the center line ⑪ of strap ⑦.

【Adjustment】 Loosen screw ⑫ (three of them), and move the device desk ⑬ backward and forward to adjust (Arrow ⑭).

【Note】 Screw ⑮ is the screw which decide the position of the device desk ⑬. When device desk ⑬ has action aside to sewing machine, loosen self-locking nut ⑯, and do action after turn the screw ⑮ counterclockwise. To adjust the deice desk ⑬ back and forward, turn the screw ⑮ clockwise, then use self-locking nut ⑯ to fix it on the position.



測量器的交換與調整

MEASURER'S CHANGING AND ADJUSTMENT

(一) 測量器的種類

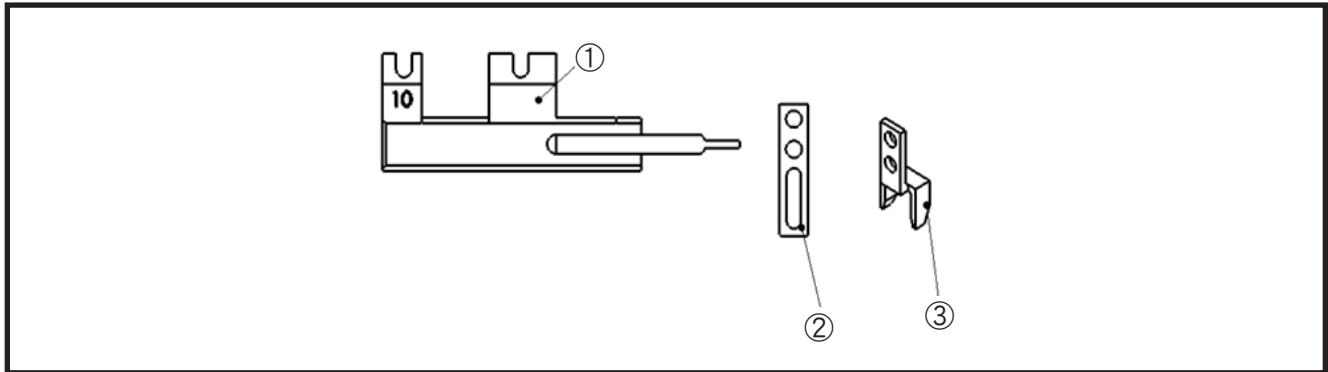
(1) 肩帶寬度變更時

- ① 夾帶盒
- ② 穿板
- ③ 導帶

(一) Type of measurers

(1) Change the width of strap

- ① Strap-fixed device
- ② Strap thread plate
- ③ Strap guide



(2) 八字扣變更時

① 八字扣保持器

(3) 圓扣變更時

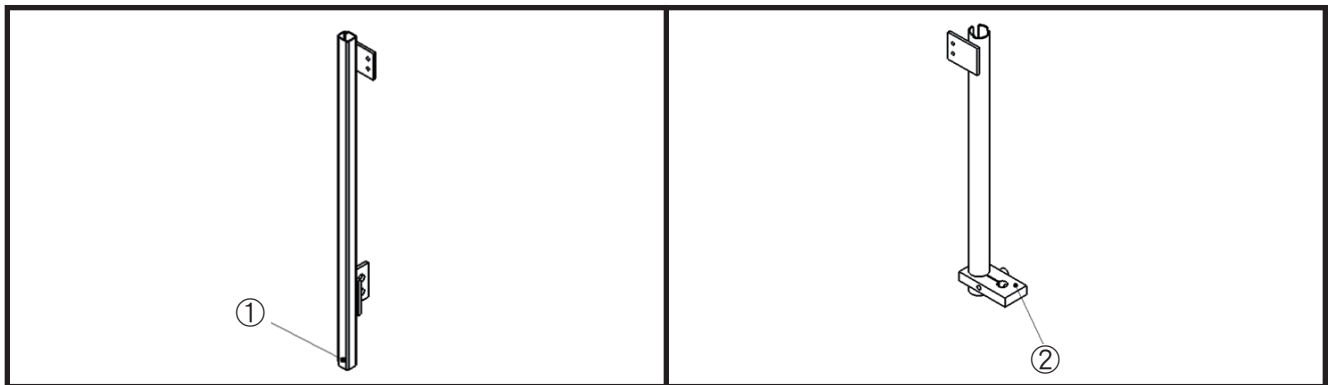
② 圓扣保持器 (組)

(2) Change of 8-shaped buckles

① 8-shaped buckle feeding stand

(3) Change the circled-buckle

② Circled-buckle feeding stand (set)



更換零件 參數值 Value						
7mm	ASP-1254	ASP-1259	ASP-1264	ASP-1269	ASP-1274	ASP-1279
8mm	ASP-1255	ASP-1260	ASP-1265	ASP-1270	ASP-1275	ASP-1279
10mm	ASP-1133	ASP-1135	ASP-1096	ASP-1076	ASP-1199	ASP-1198
13mm	ASP-1256	ASP-1261	ASP-1266	ASP-1271	ASP-1276	ASP-1280
16mm	ASP-1257	ASP-1262	ASP-1267	ASP-1272	ASP-1277	ASP-1281
18mm	ASP-1258	ASP-1263	ASP-1268	ASP-1273	ASP-1278	ASP-1281

(二) 測量器的交換與調整

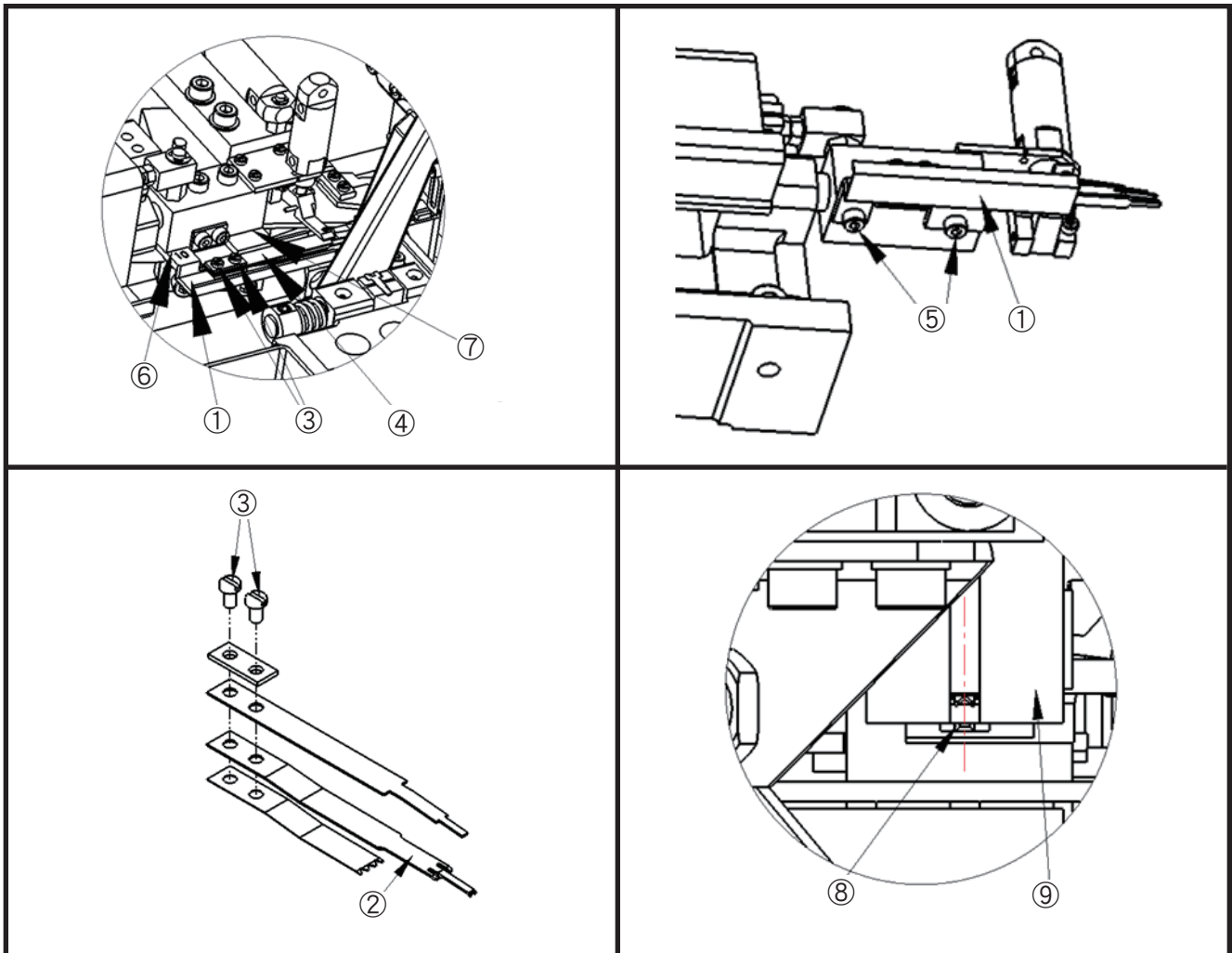
1. 夾帶盒①與上彈簧板②的交換

- (1) 將螺絲③轉開，並將包括上彈簧板②的彈簧板組④拆開。
- (2) 將螺絲⑤轉鬆，交換夾帶盒①這時，⑥與⑦的部份為緊密狀態。
- (3) 上彈簧板②拆除更換，以螺絲③組裝固定彈簧板組④。
- (4) 用手將夾帶盒①移動側最右側，確認夾帶盒①的先端⑧是否通過了滾軸⑨中槽的中心線。如果位置有偏差的話，其原因為⑥、⑦部份中產生的間隙需修正。

(二) Measurer's changing and adjustment

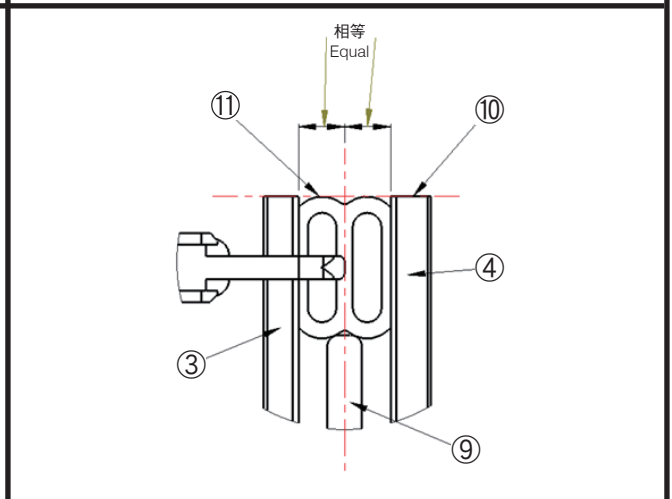
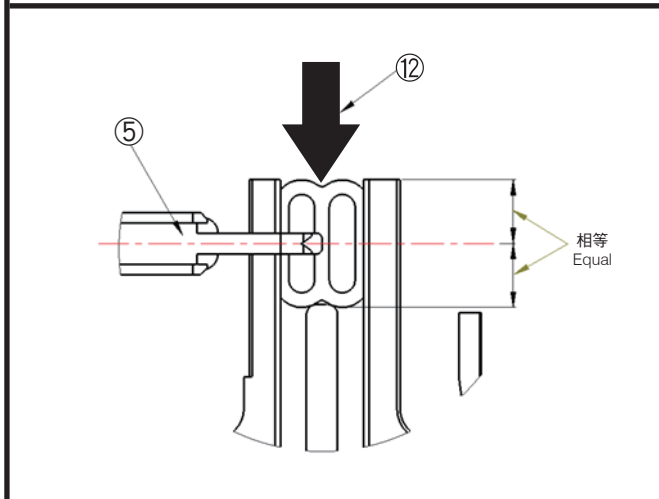
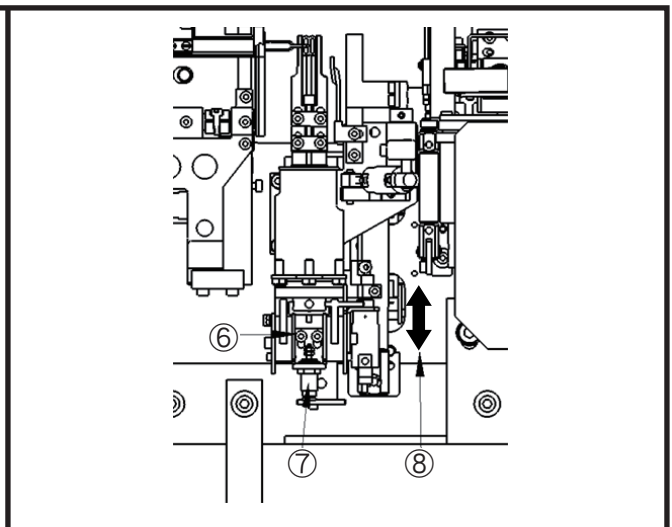
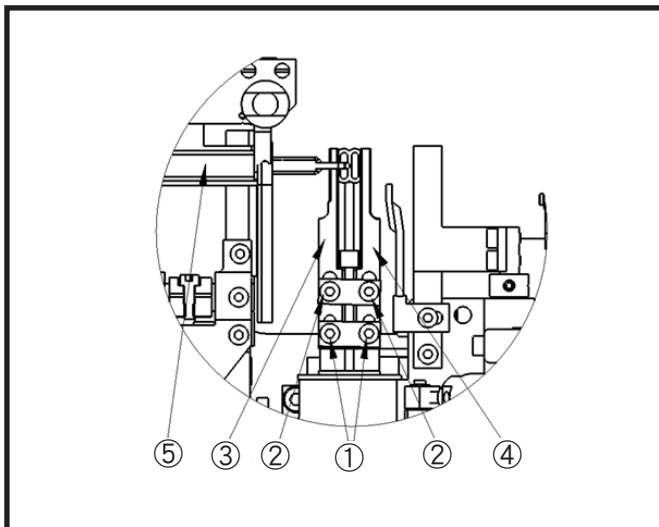
1. Change of strap-fixed device① and upper spring plate②.

- (1) Loosen screw③, and take apart the set of spring plate④ including upper spring plate②.
- (2) Loosen screw⑤, parts ⑥ and ⑦ are tightly close when change the strap-fixed device①.
- (3) Take apart the upper spring plate② and use screw③ to assemble and fix the set of spring plate④.
- (4) Use hands to move the strap-fixed device① to the most right side, and make sure the front end of the strap-fixed device① has make through the center line of the middle notch of the roller⑨. If the position has deviation, the reason would be the gap between parts ⑥ and ⑦ which needs correction.



2. 調整式八字扣固定器③、④的調整
- (1) 將 2 顆螺絲①與 2 顆螺絲②轉鬆。
 - (2) 將八字扣放入調整式八字扣固定器③、④中，以 2 顆螺絲①與 2 顆螺絲②暫時固定。
 - (3) 用手移動帶夾帶盒⑤，將其先端移至八字扣中心附近。
 - (4) 將 2 顆螺絲⑥轉鬆，並把氣缸⑦往箭頭⑧的方向移動，當從箭頭⑫的方向推入八字扣時，讓夾帶盒⑤的先端從八字扣的正中央通過。
 - (5) 將 2 顆螺絲①與 2 顆螺絲②轉鬆，軸⑨的中心線與八字扣固定器③、④之間保留 0.2mm 左右的空隙。

2. Adjustment of adjustable 8-shape feeding holder ③,④
- (1) Loosen two screws① and two screws②.
 - (2) Put 8-shaped buckles into adjustable 8-shaped buckle feeding stand③,④ and use two screws① and two screws② to fix it temporary.
 - (3) Move the strap-fixed device⑤with hands, and moves its front end around the 8-shaped buckle center.
 - (4) Loosen two screws⑥, and move the cylinder⑦ toward arrow⑧ direction. When push the 8-shaped buckle to the direction as arrow⑫, let the front end of the strap-fixed device⑤ make through the center of 8-shaped buckle.
 - (5) Loosen two screws① and two screws②, align the the center line of shaft⑨ and center line of 8-shaped buckle. Keep around 0.2mm gap between 8-shaped buckle holder③,④ .

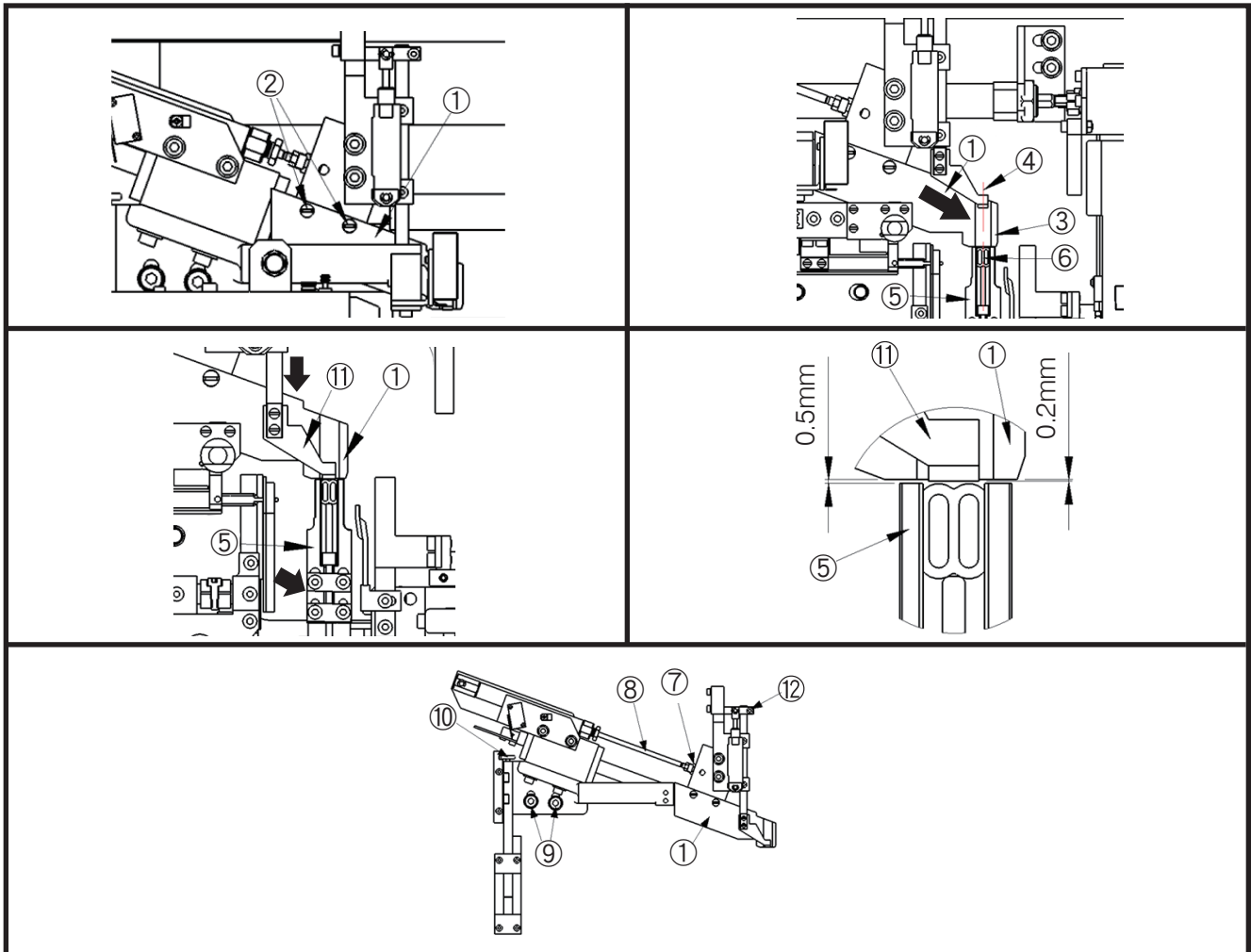


3. 扣環供給底板①的交換及調整

- (1) 將螺絲②轉開，交換扣環供給底板①。
- (2) 當扣環供給底板①移至最右邊時，溝③的中心線④與八字扣固定器的中心線⑥保持一致。
- 【調整】轉鬆自鎖螺帽⑦，以轉動氣壓缸桿⑧來調整。
- (3) 當扣環供給底板①移動至最右邊時，扣環供給底板①與八字扣固定器⑤之間的縫隙為 0.5mm。
- 【調整】將螺絲⑨轉鬆，以轉動調整螺絲⑩來調整。
- (4) 扣環供給端頭⑪出來時，使其先端比供給底板②多 0.2mm。
- 【調整】轉鬆⑫來調整。

3. Change and adjustment of buckle feeding bed①

- (1) Loosen screw②, and change the buckle feeding bed①.
- (2) When the buckle feeding bed① move to the right most, align the center line④ of the notch③ and center line⑥ of 8-shaped buckle holder.
- 【Adjustment】Loosen self-locking nut⑦ in order to turn the cylinder shaft for adjustment.
- (3) When the buckle feeding bed① move to the right most, the gap between buckle feeding bed① and 8-shaped buckle holder⑤ are 0.5mm.
- 【Adjustment】Loosen screw⑨ in order to turn the adjustable screw⑩ for adjustment.
- (4) While the buckle feeding front end⑪ out, make it more 0.2mm than the feeding bed②.
- 【Adjustment】Loosen⑫ for adjustment.

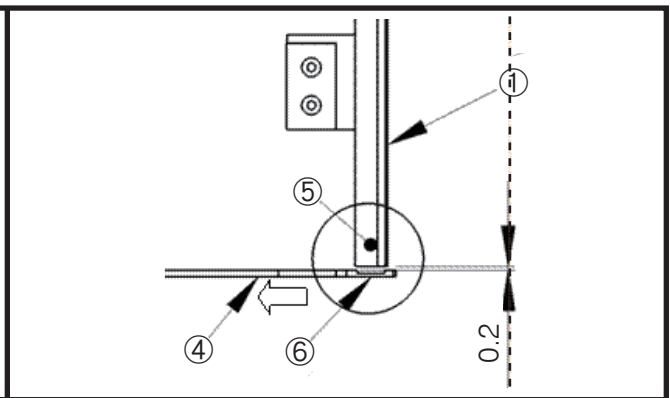
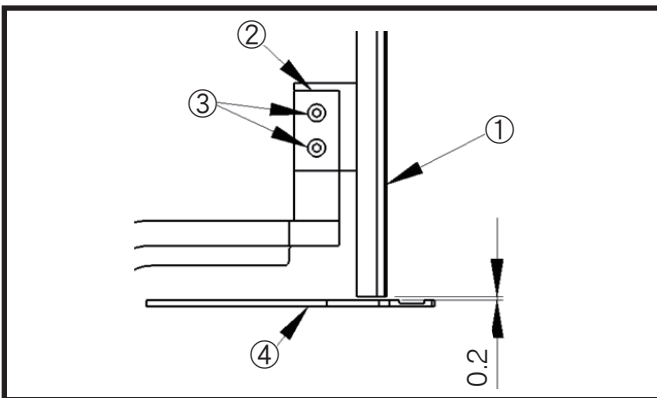


4. 八字扣保持器①的交換

- (1) 將座板②與螺絲③轉開，交換八字扣保持器①。
- (2) 八字扣保持器①與扣環供給底板④的縫隙為 0.2mm。
【調整】以轉鬆螺絲③來調整。
- (3) 當扣環供給底板退後到最後側時，使八字扣保持器①的底部⑤的內側面與扣環供給底板④的溝⑥成一致。
【調整】以轉鬆螺絲③來調整。

4. Change of 8-shape buckle feeding stand①

- (1) Loosen screw③ and bed② to change 8-shape buckle feeding stand①.
- (2) The gap between 8-shape buckle feeding stand① and buckle feeding bed④ are 0.2mm.
【Adjustment】 Loosen screw③ for adjustment.
- (3) While buckle feeding bed back to the most, make the bed inner side⑤ of the 8-shape buckle feeding stand① and the notch⑥ of the buckle feeding bed④ at the same position.
【Adjustment】 Loosen screw③ for adjustment.

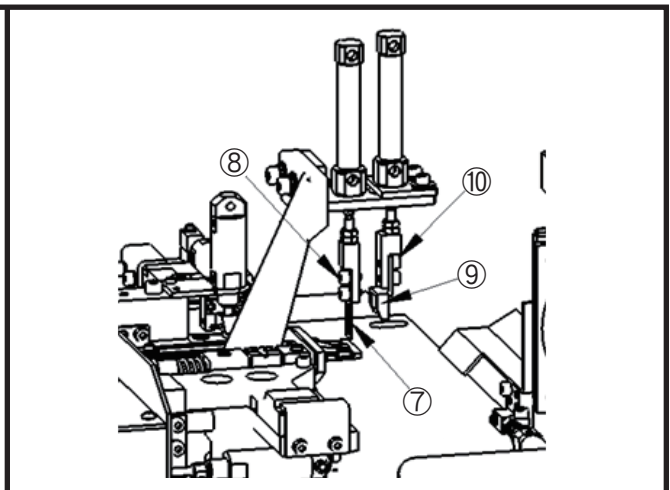
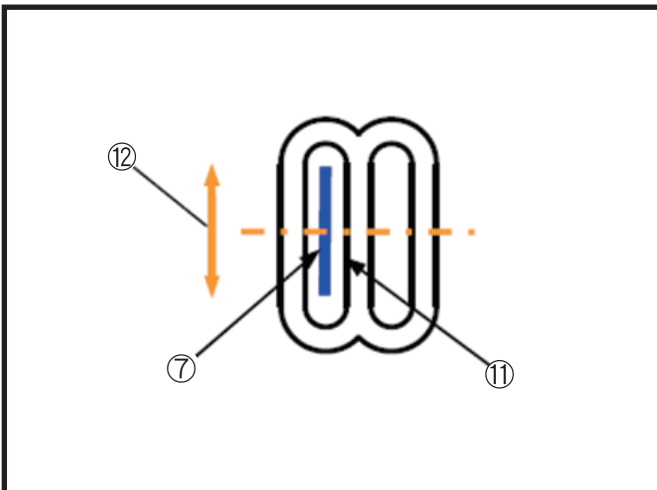


5. 穿板⑦及導帶⑨的交換

- (1) 將 2 顆螺絲⑧轉開，交換穿板⑦。安裝時，要使穿板⑦往箭頭⑫的方向均勻的進入八字扣長孔⑪中。
- (2) 將 2 顆螺絲⑩轉開，交換導帶⑨。

5. Change of strap thread plate⑦ and strap guide⑨

- (1) Loosen two screws⑧, and change strap thread plate⑦. While installing, make sure to let strap thread plate⑦ through the 8-shaped buckle hole⑪ toward arrow direction even.
- (2) Loosen two screws⑩ to change the strap guide⑨.

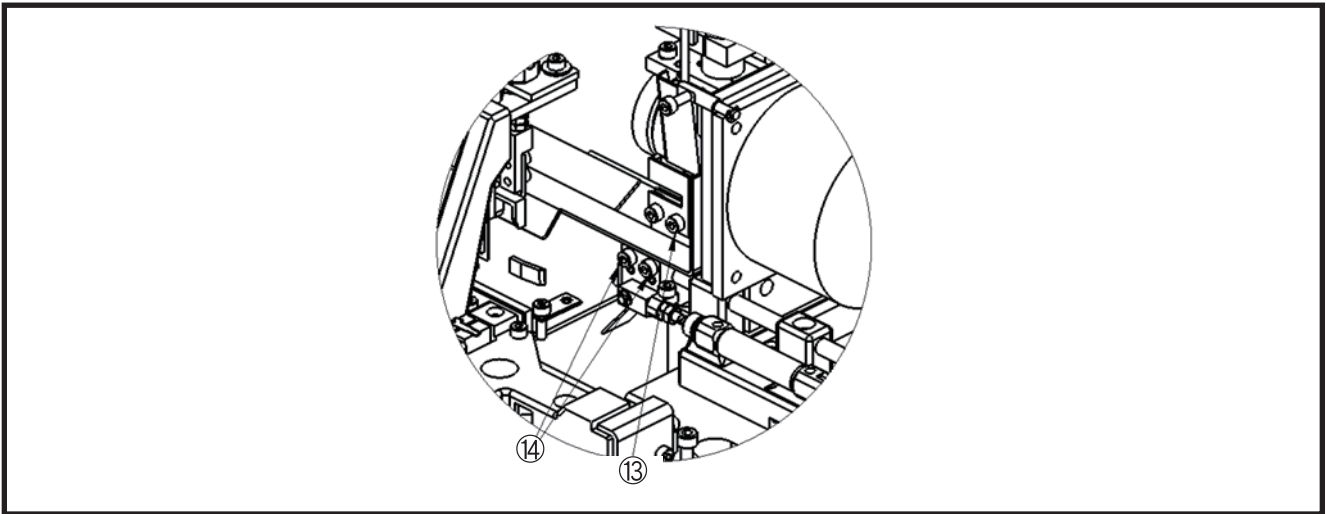


6. 圓扣供給端頭⑬的交換

- (1) 轉鬆螺絲⑭，交換圓扣供給端頭⑬。轉開螺絲時，將螺絲⑭轉鬆把圓扣供給端頭⑬從上方撥開。組裝時將圓扣供給端頭⑬由上方插入，並以螺絲⑭固定于其停止位置。

6. Change of circled-buckle feeding upper end⑬

- (1) Loosen screw⑭, change circled-buckle feeding upper end⑬. Loosen screw ⑭, and push circled-buckle feeding upper end⑬ aside. Assemble circled-buckle feeding upper end⑬ from up, and fixed it in the position by screw⑭.

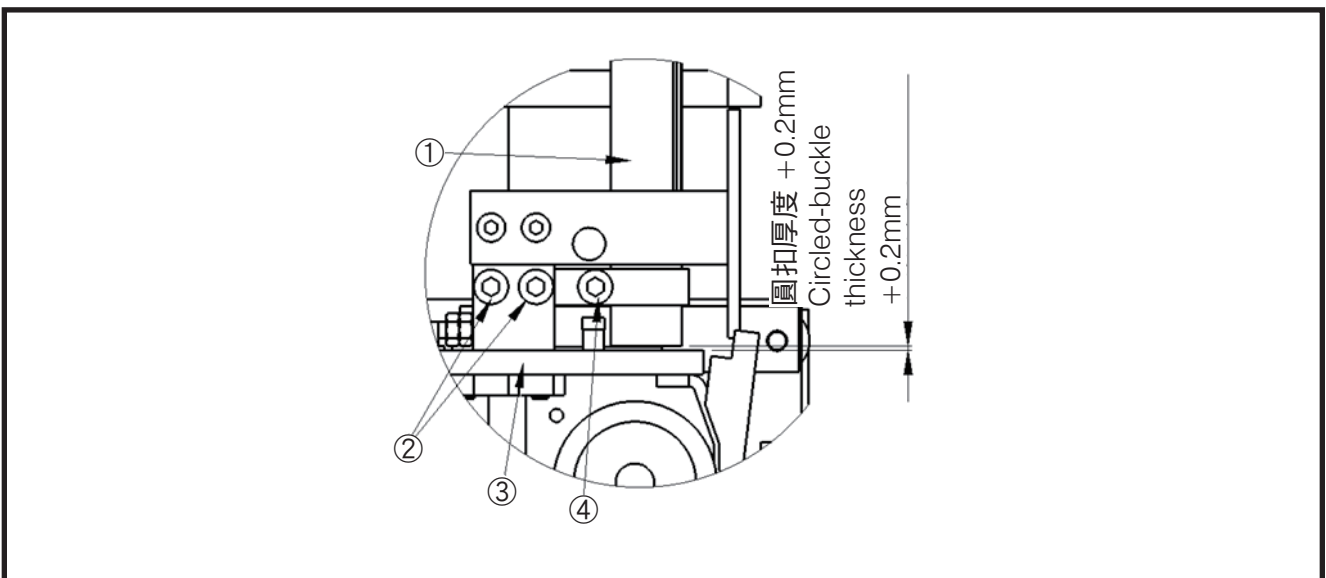


7. 圓扣保持器①的交換

- (1) 將螺絲②轉開，交換圓扣盒①。
 - (2) 圓扣保持器①與圓扣投放盤③的縫隙為圓扣厚度的 + 0.2mm。
- 【調整】以轉鬆螺絲④來調整。

7. Change of circled-buckle feeding stand①

- (1) Loosen screw② and change the circled-buckle feeding stand①.
 - (2) The gap between circled-buckle feeding stand① and circled-buckle putting plate are the circled-buckle thickness + 0.2mm.
- 【Adjustment】 Loosen screw④ for adjustment.



8. 八字扣標準尺⑤的調整

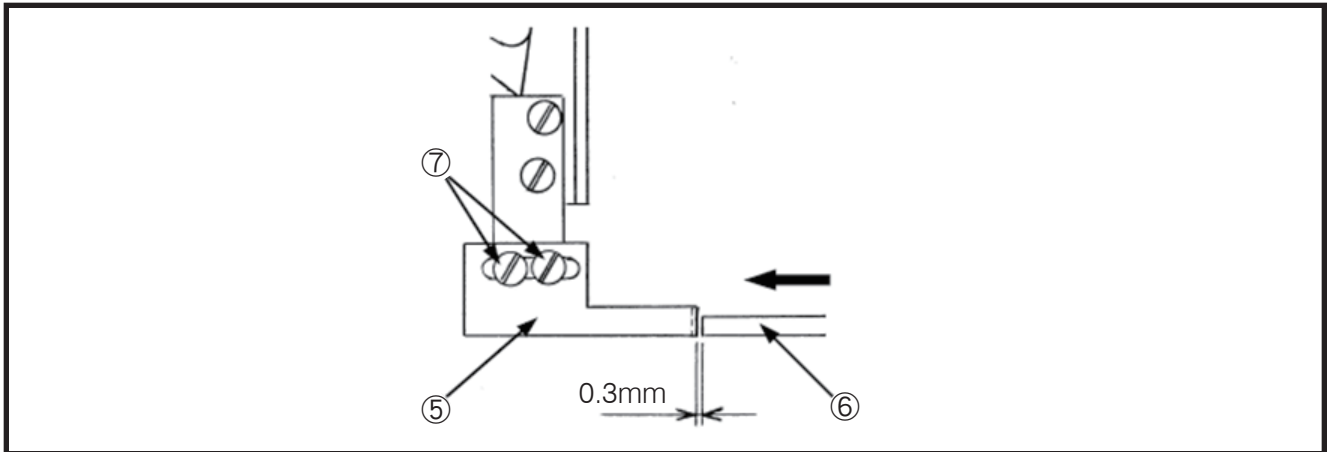
- (1) 當八字扣固定器⑥往縫紉機旁側移動時，八字扣固定器⑥的先端與八字扣標準尺⑤之間的縫隙為 0.3mm。

【調整】以轉鬆螺絲⑦來調整。

8.Adjustment of 8-shaped buckle standard ruler⑤

- (1) While 8-shaped buckle holder⑥ move to the sewing machine side, the gap between 8-shaped buckle holder⑥ front end and 8-shaped buckle standard ruler⑤ are 0.3mm.

【Adjustment】Loosen screw⑦ for adjustment.



9. 反摺導帶的調整

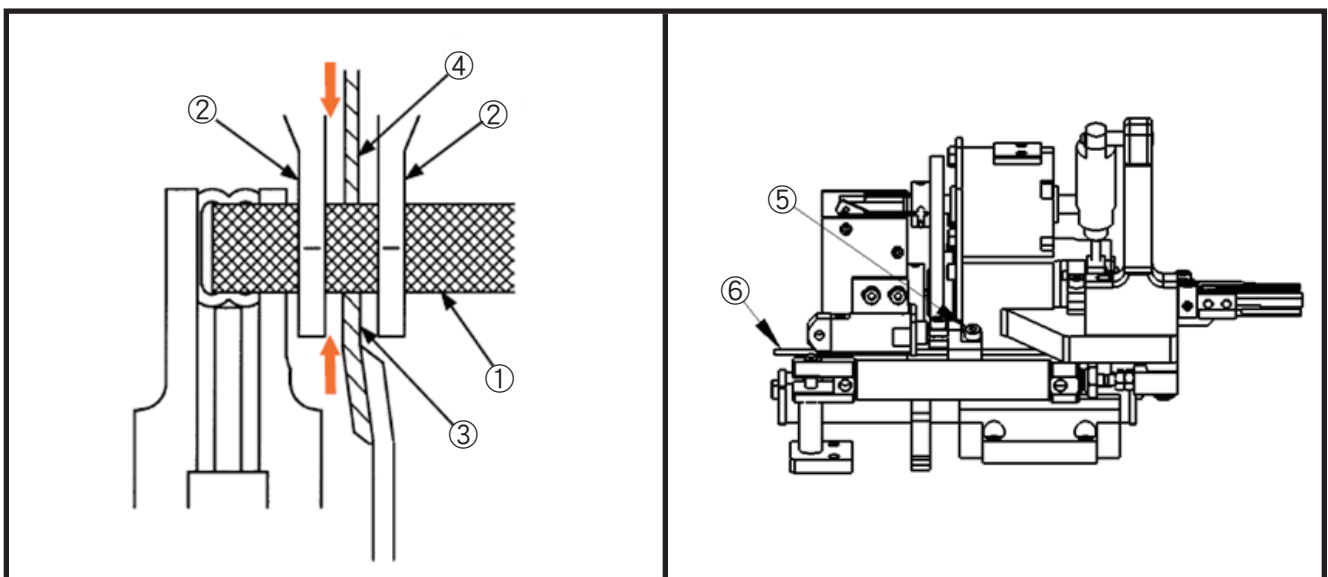
- (1) 當肩帶①進入於縫紉機壓板②的下方時，讓前擋板③與後擋板④的各自先端碰到肩帶①的側面。

【調整】將前擋板③的螺絲⑤轉鬆，移動量桿⑥進行調整。轉鬆螺絲⑦調整後擋板④。

9. Adjustment of counter-folded strap guide

- (1) When strap① get under sewing machine presser bar②, let each front end of the front strap holder③ and rear strap holder④ touch the side of strap①.

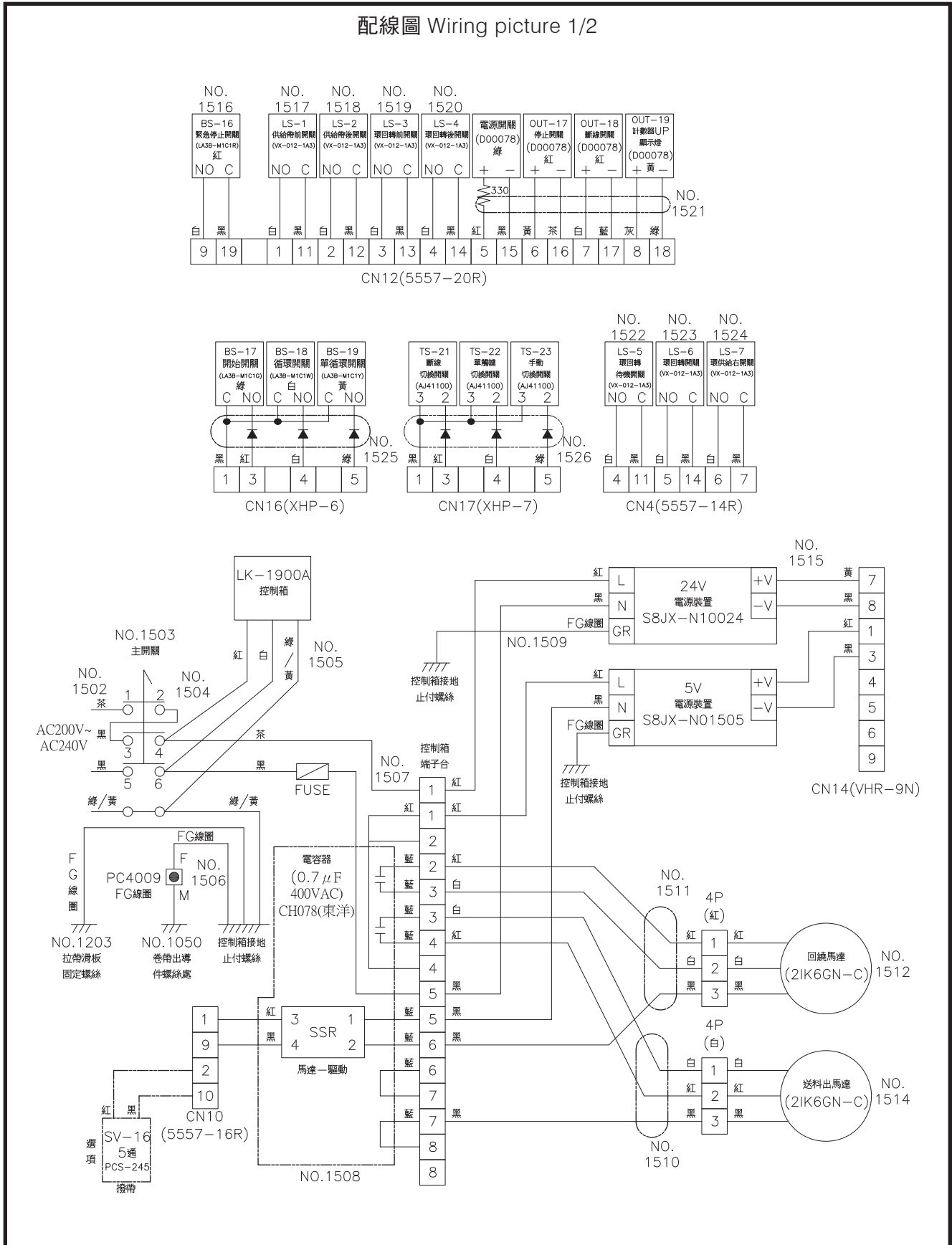
【Adjustment】Loosen the screw⑤ of the front strap holder③, move the shaft of the front strap holder⑥ for adjustment. Loosen screw⑦ to adjust rear strap holder④.



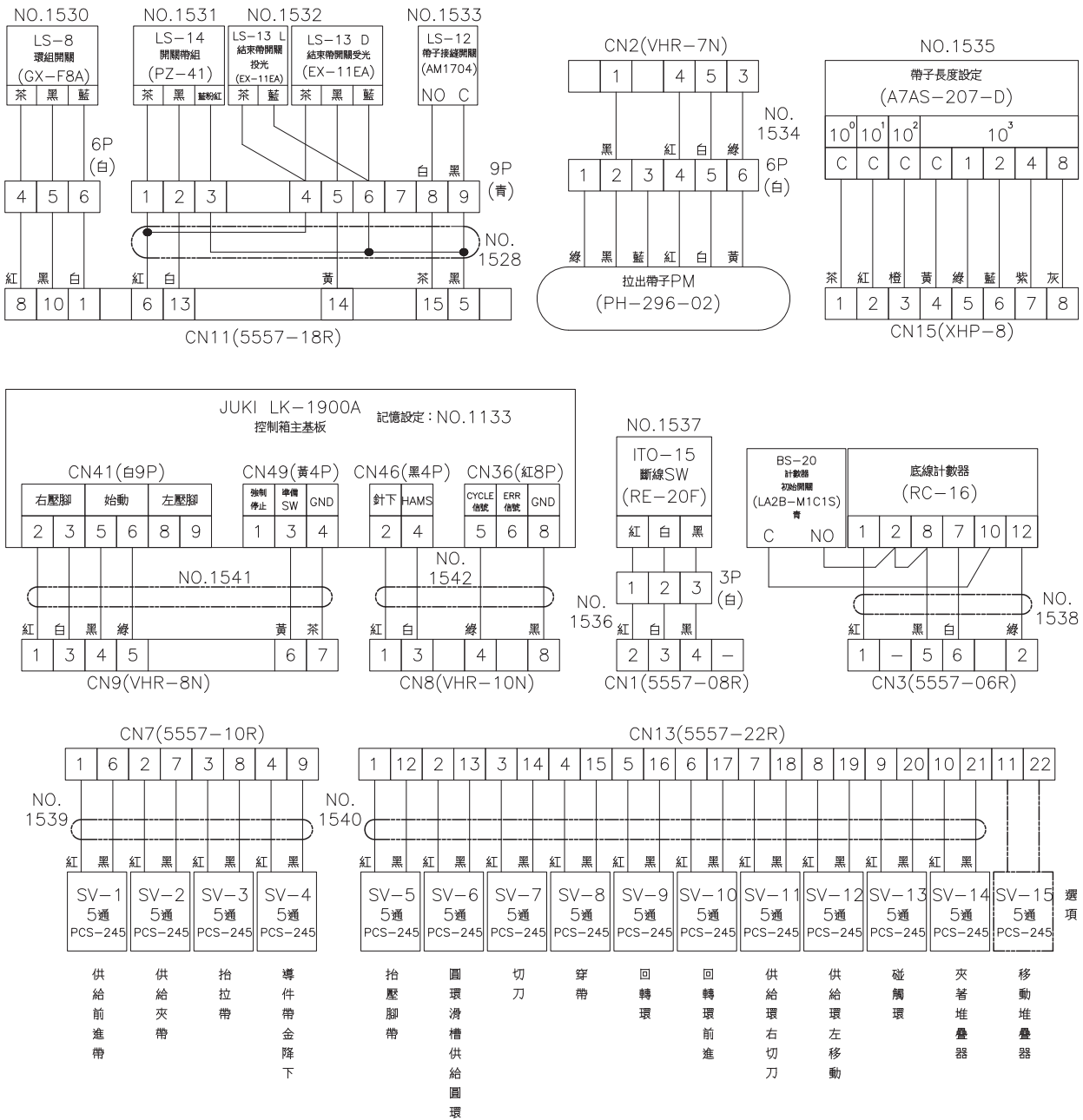
配線圖

WIRING PICTURE

配線圖 Wiring picture 1/2



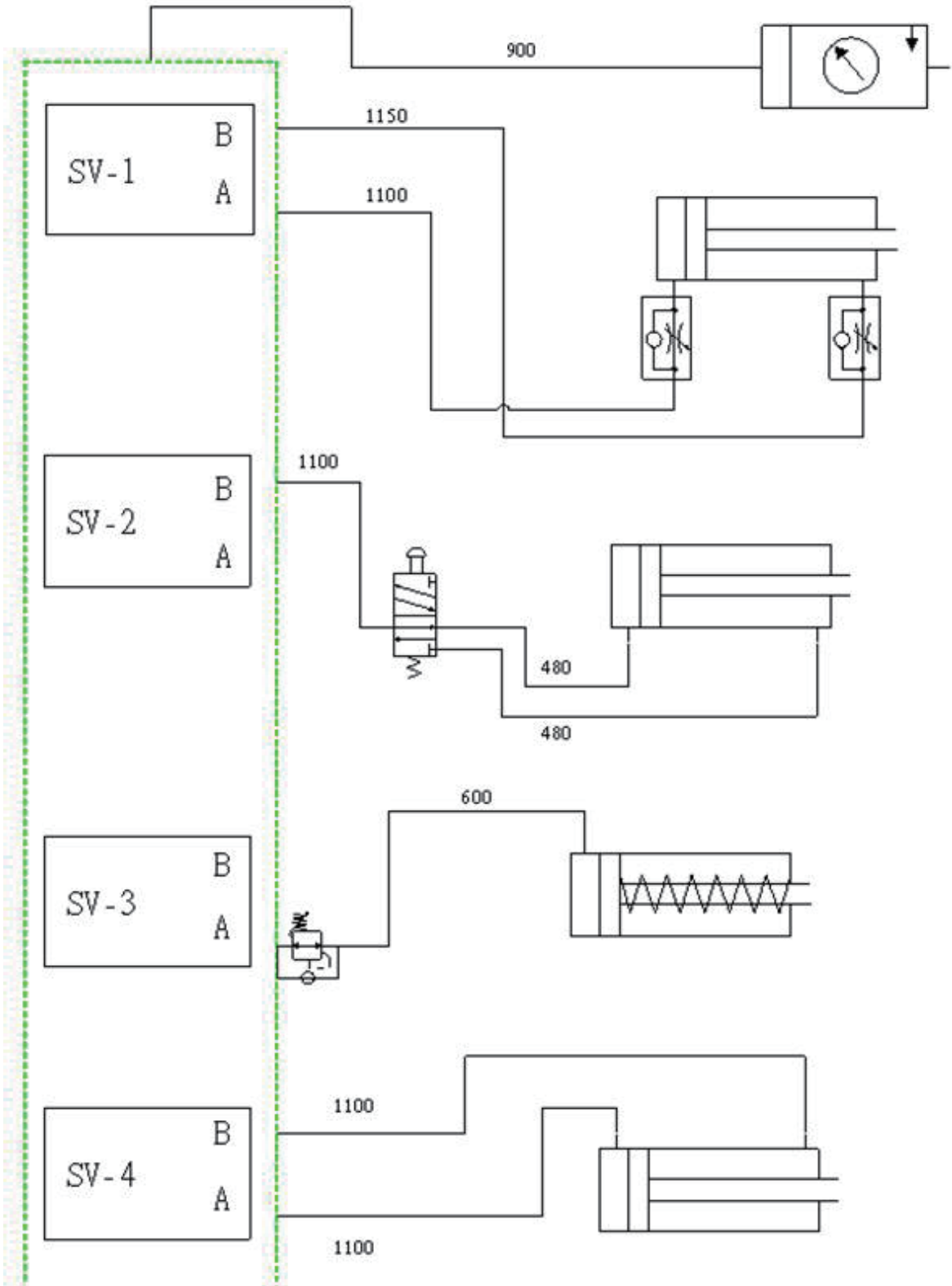
配線圖 Wiring picture 2/2



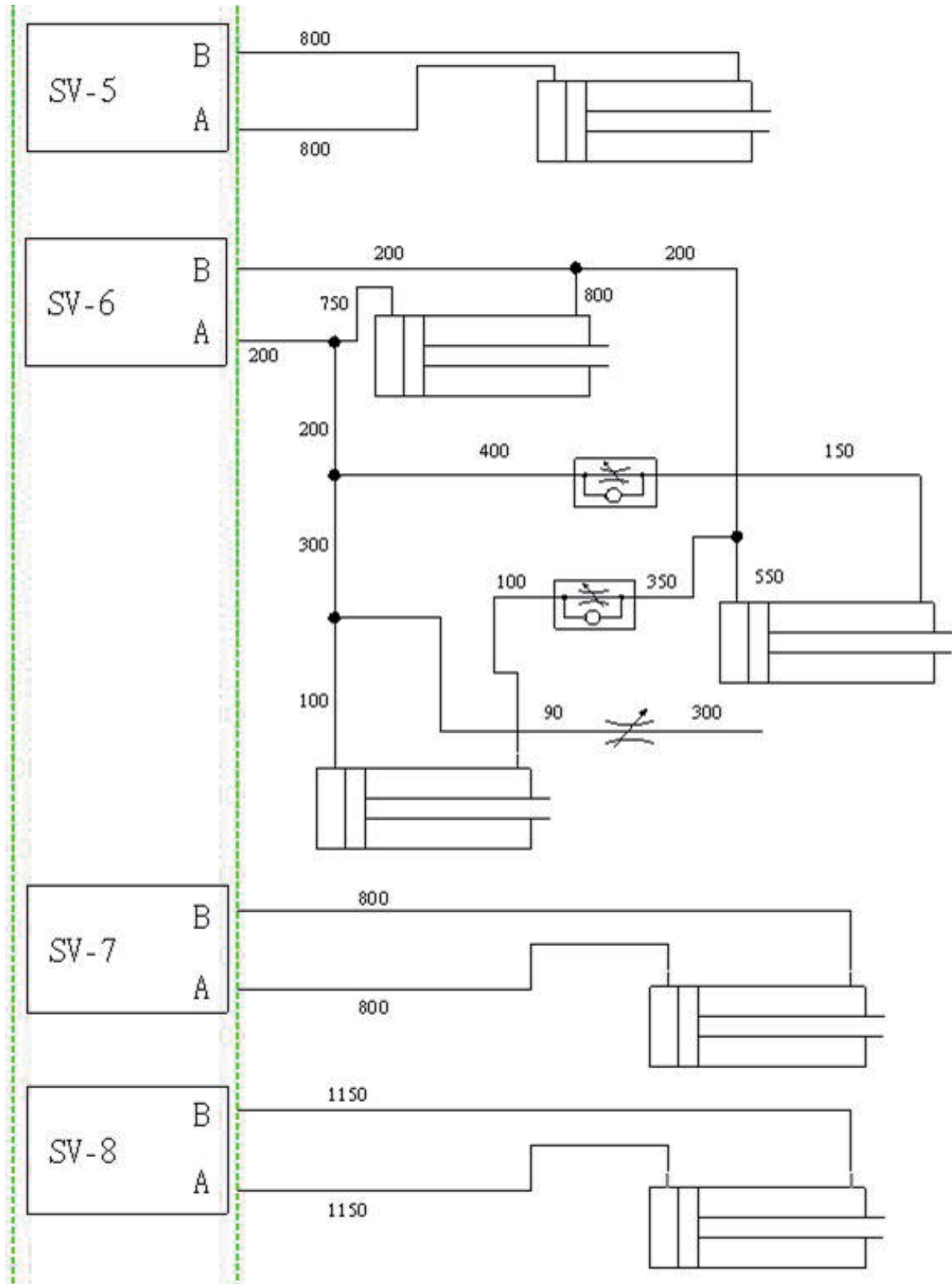
配管圖

PIPING PICTURE

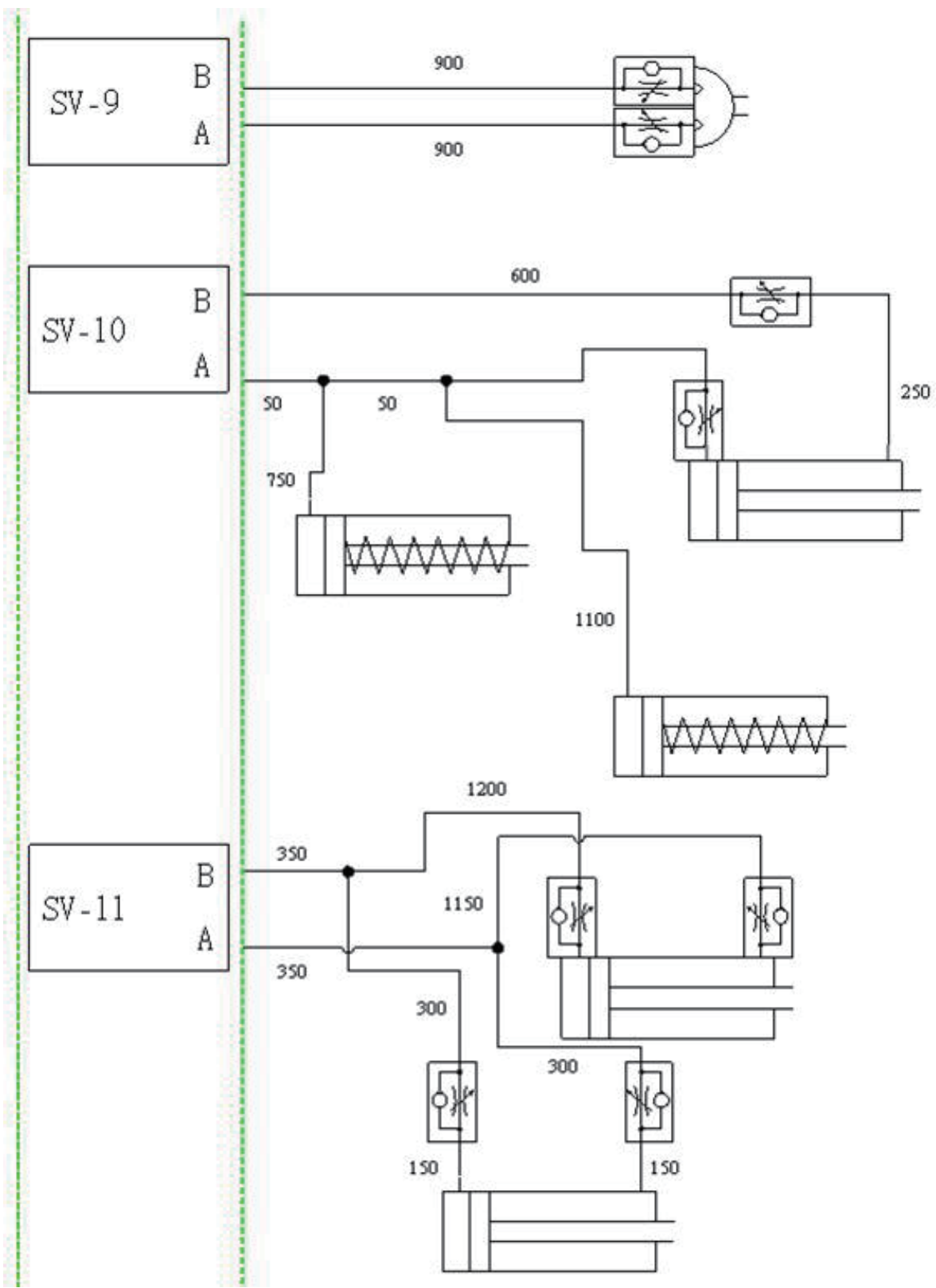
Piping picture 1/4



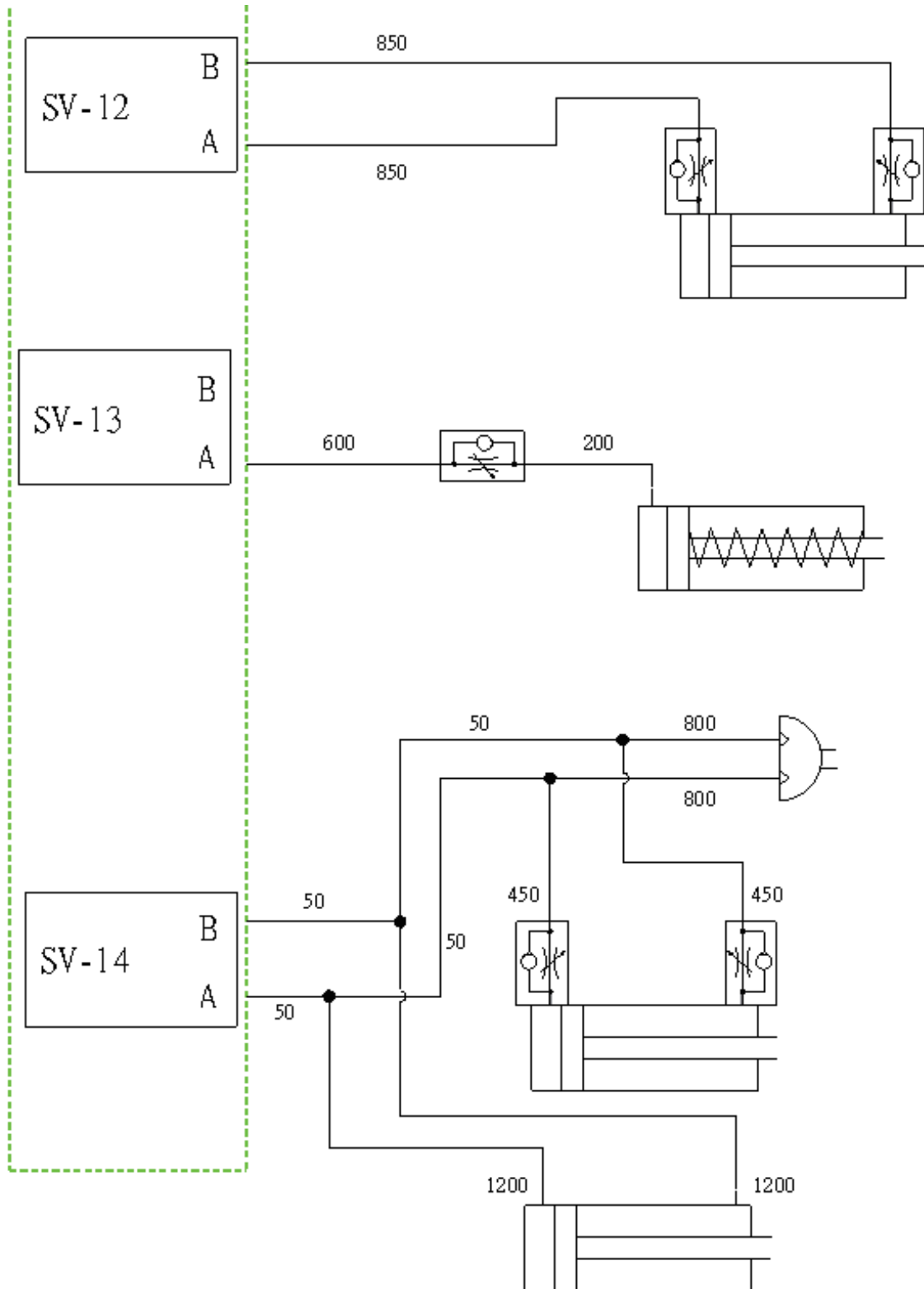
Piping picture 2/4



Piping picture 3/4



Piping picture 4/4

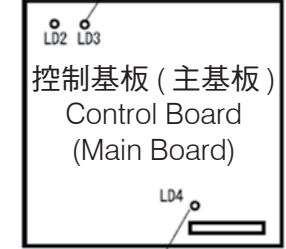


不良現象，其原因以及解決方法


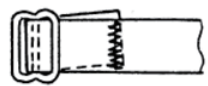
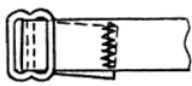
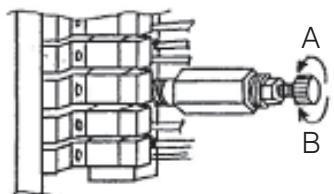
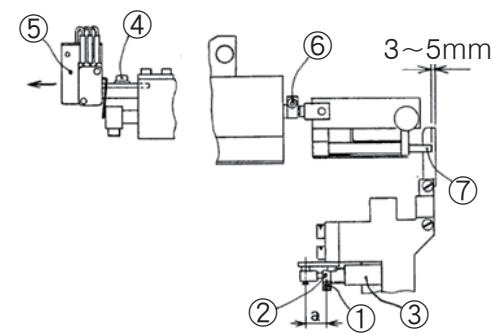
DEFECTIVE PHENOMENA'S REASON AND SOLUTIONS

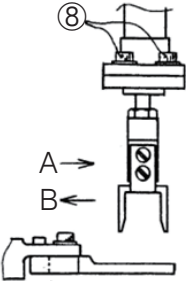
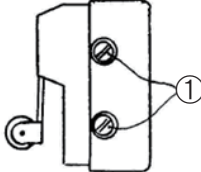
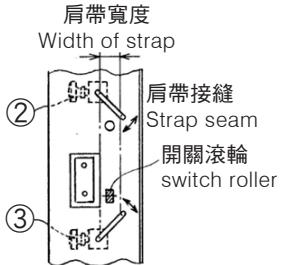
現象 Phenomenon	原因 Reasons	對策 Strategies
1. 切刀刀刃不良 1. Blade of the trimmer defective	a. 固定切刀的裝置不良 P13 「1. 切刀」的項目中，S 與 K 的尺寸過小 b. 切刀彈簧壓力不足 c. 刀刃耗損 a. Device which fixed trimmer defective. P13 In item 「1. Trimmer」, size of S and K too small. b. Pressure of trimmer's spring not enough. c. Blade consumes.	a. 參照 P13 中「1. 切刀」的 S 項目，調整固定刀具，將 K 的尺寸調整適當 b. 參照 P13 中「1. 切刀」的 b 項目，將刀具的束環調整適當 c. 研磨切刀，或是更換新品 a. Refer to P13 item S 「1. Trimmer」, adjust the fixed knife, adjust the size of K properly. b. Refer to P13 item b 「1. Trimmer」, adjust the ring of knife properly. c. Grind the trimmer or replace the new one.
2. 斷線檢測不良 (1) 線沒被切斷機械卻停止 (控制板表示燈燈亮) (2) 線斷了卻不停機 (操作面板表示燈燈滅) 2. Thread detector defective (1) Machine stops without cutting the thread. (Control board indicator lamp lights up.) (2) Machine wouldn't stop even thread break. (Control board indicator lamp lights off.)	(用手慢慢的轉動斷線檢測器中的編碼器的皮帶輪，當基板一的確認燈 LD3 燈滅時) a. 線的穿線方法錯誤 b. 縫製時發生斷線 (用手慢慢的轉動斷線檢測器中編碼器的皮帶輪，當基板上的確認燈 LD3 燈滅時) c. 編碼器不良 (縫紉機動作中，基板上的確認燈 LD4 燈滅時) LK-1900A 的感線線斷線 (參照 P23 配線圖) (Use hands to roll the belt roller of the encoder in the thread device slowly while the checking lamp LD3 of the board 1 lights off.) a. Wrong threading method. b. Thread break while sewing. (Use hands to roll the belt roller of the encoder in the thread device slowly while the checking lamp LD3 of the board 1 lights off.) c. Encoder defective. (The checking lamp LD4 of the board lights off while sewing machine operating.) Thread detector of LK-1900A thread break. (Refer to P23 Wiring picture.)	a. 參照 P3 「4. 穿線」 b. 調整縫紉機穿線 c. 交換編碼器 a. Refer to P3 「4. Threading」 b. Adjust the sewing machine threading c. Change the encoder

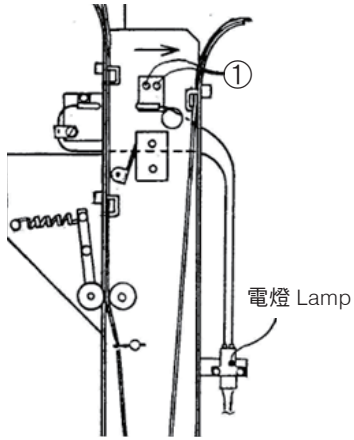
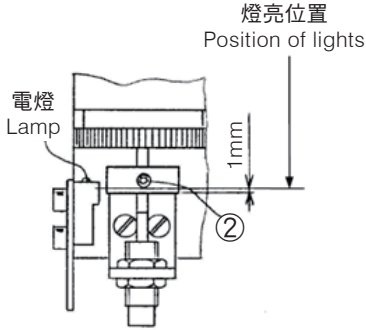
斷線檢測確認燈
Thread break detect checking lamp



針下信號確認燈
Under needle checking lamp

現象 Phenomenon	原因 Reasons	對策 Strategies
<p>3. 製品的不良</p> <p>(1) 肩帶縫製不良</p> <p>(2) 肩帶完成時長度脫落</p> <p>(3) 帶端不能縫入</p> <p>3. Product defective</p> <p>(1) Strap sewing defective</p> <p>(2) Strap falls off</p> <p>(3) Strap can not sew properly</p>  <p>(4) 縫合部份錯開</p> <p>a. 向上錯開</p> <p>(4) Stitched part stagger</p> <p>a. Stagger up</p>  <p>b. 向下錯開</p> <p>b. Stagger down</p> 	<ul style="list-style-type: none"> • 導帶滾輪的壓力力道過強 • 導帶滾輪的壓力力道過弱 • 肩帶反摺部份長度不足 • 導帶板位置錯開 • Feeding strap roller force of pressure too strong. • Feeding strap roller force of pressure too weak. • Length of strap counter folded part insufficient. • Feeding strap plate position different. 	<ul style="list-style-type: none"> • 壓力力道轉弱 (將螺絲往左轉, 箭頭 A 方向) • 壓力力道轉強 (將螺絲往右轉, 箭頭 B 方向) • Make the force weak. (Left turn the screw, arrow A direction.) • Make the force strong. (Right turn the screw, arrow B direction.)  <ul style="list-style-type: none"> • 將肩帶反摺長度放長。 <p>【調整】</p> <ol style="list-style-type: none"> 1. 轉鬆螺絲①, 將刀具調整沿②向著使氣缸③行程減短 (a 尺寸增長) 方向移動 2. 轉鬆螺絲④, 將極限開關安裝板⑤, 向←方向移動。 3. 轉鬆輸帶滾筒調整沿停止螺絲⑥, 將刀具到夾帶盒夾子⑦前端設定為 3 ~ 5mm <p>• Lengthen the strap folded part.</p> <p>【Adjustment】</p> <ol style="list-style-type: none"> 1. Loosen screw ① adjust knife toward direction ② to make cylinder ③ stroke shorter (size a longer.) 2. Loosen screw ④, to let limited switch install plate ⑤ move toward ← direction. 3. Loosen feeding strap roller and adjust stop screw ⑥, to make the distance between knife and front end of strap-fixed device clamp ⑦ 3-5mm. 

現象 Phenomenon	原因 Reasons	對策 Strategies
<p>4. 肩帶接縫檢測不良 (1) 到了肩帶接縫口不停 (2) 肩帶從肩帶接縫開關滾輪上脫落</p> <p>4. Strap seam detect defective. (1) Wouldn't stop even till the strap seam end. (2) Strap fall off from strap seam sensor roller.</p>	<ul style="list-style-type: none"> • 肩帶接縫檢測調整不良 • 肩帶輸送引導針的調整不良 • Strap seam detect adjust defective. • Strap feeding guide needle adjust defective. 	<p>a. 導帶板往 A 的方向移動 b. 導帶板往 B 的方向移動</p> <p>【調整】 將螺絲⑧轉鬆後進行</p> <p>a. Feeding strap plate move toward A direction. b. Feeding strap plate move toward B direction.</p> <p>【Adjustment】 Proceed after loosen screw ⑧</p>  <ul style="list-style-type: none"> • 調整到接縫處，將肩帶接縫開關調至 ON，通過後調至 OFF。 【調整】 將螺絲①轉鬆後進行。 • Adjust to the seam part, turn ON strap seam sensor, turn OFF after getting through. 【Adjustment】 Proceed after loosen screw ①.  <ul style="list-style-type: none"> • 將肩帶輸送引導針往箭頭方向移動，使其和肩帶寬度對齊。 【調整】 將螺絲②、③轉鬆後進行。 • Move the strap feeding guide needle toward arrow direction in order to align with the strap's width. 【Adjustment】 Proceed after loosen screw ②、③. 

現象 Phenomenon	原因 Reasons	對策 Strategies
<p>5. 按了啟動開關機械沒有開始動作。(停止燈燈亮)</p> <p>5. Machine without action after turn ON. (Stop lamp lights up.)</p>	<p>a. 八字扣、圓扣用完</p> <p>b. 肩帶有接縫</p> <p>c. 肩帶用完</p> <p>d. 肩帶接縫開關在打開狀態</p> <p>e. 肩帶確認燈燈亮(當使用薄肩帶的時候)</p> <p>a. Run out of 8-shaped buckle and circled-buckle.</p> <p>b. Strap has seam.</p> <p>c. Run out of strap.</p> <p>d. Strap seam sensor ON.</p> <p>e. Strap checking lamp lights up. (When use thin strap.)</p>	<p>a. 補充八字扣、圓扣。(不要忘記墜子)</p> <p>b. 去掉接縫。</p> <p>c. 安裝上新的肩帶。</p> <p>d. 參照「(4) 肩帶接縫檢測不良」的解決方法。到燈滅為止感應器往→方向移動。</p> <p>【調整】</p> <p>將螺絲①轉鬆進行</p> <p>a. Supply 8-shaped buckle and circled-buckle. (Don't forget counterweight.)</p> <p>b. Take off seam.</p> <p>c. Install new strap.</p> <p>d. Refer 「(4) Strap seam detect defective」 solution until lamp lights off, the sensor move toward → direction.</p> <p>【Adjustment】</p> <p>Proceed after loosen screw ① .</p> 
<p>6. 八字扣被安裝至八字扣固定器後機械沒有反應。(燈滅)</p> <p>6. Machine didn't react after install 8-shaped buckle at 8-shaped buckle holder. (Lights off)</p>	<p>•八字扣穿棒沿調整不良</p> <p>•The shaft which push 8-shaped buckle adjust defective.</p>	<p>•從燈亮處到沿邊調整到 1mm</p> <p>【調整】</p> <p>將螺絲②轉鬆後進行</p> <p>•Adjust from the light about 1mm.</p> <p>【Adjustment】</p> <p>Proceed after loosen screw ② .</p> 

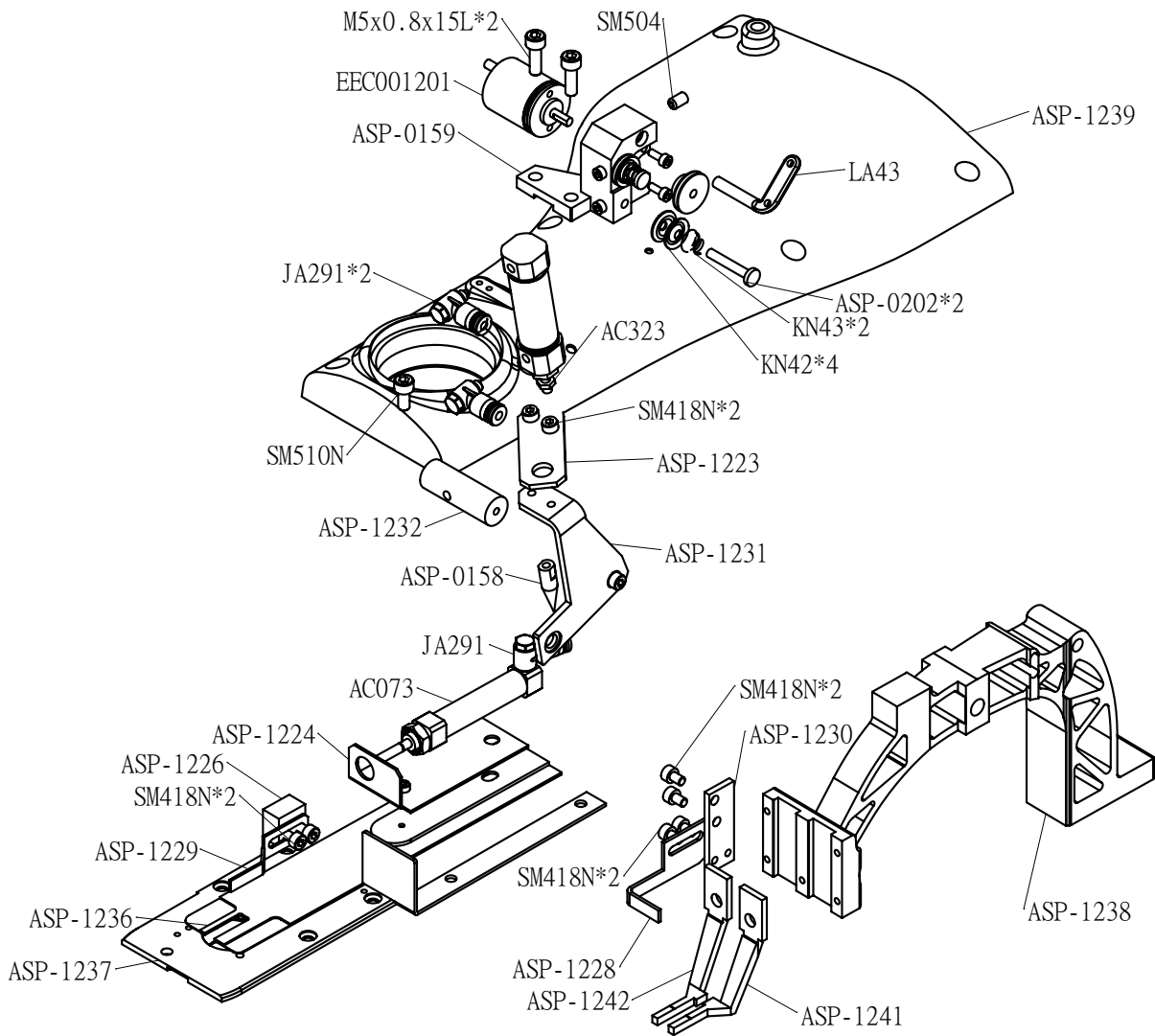
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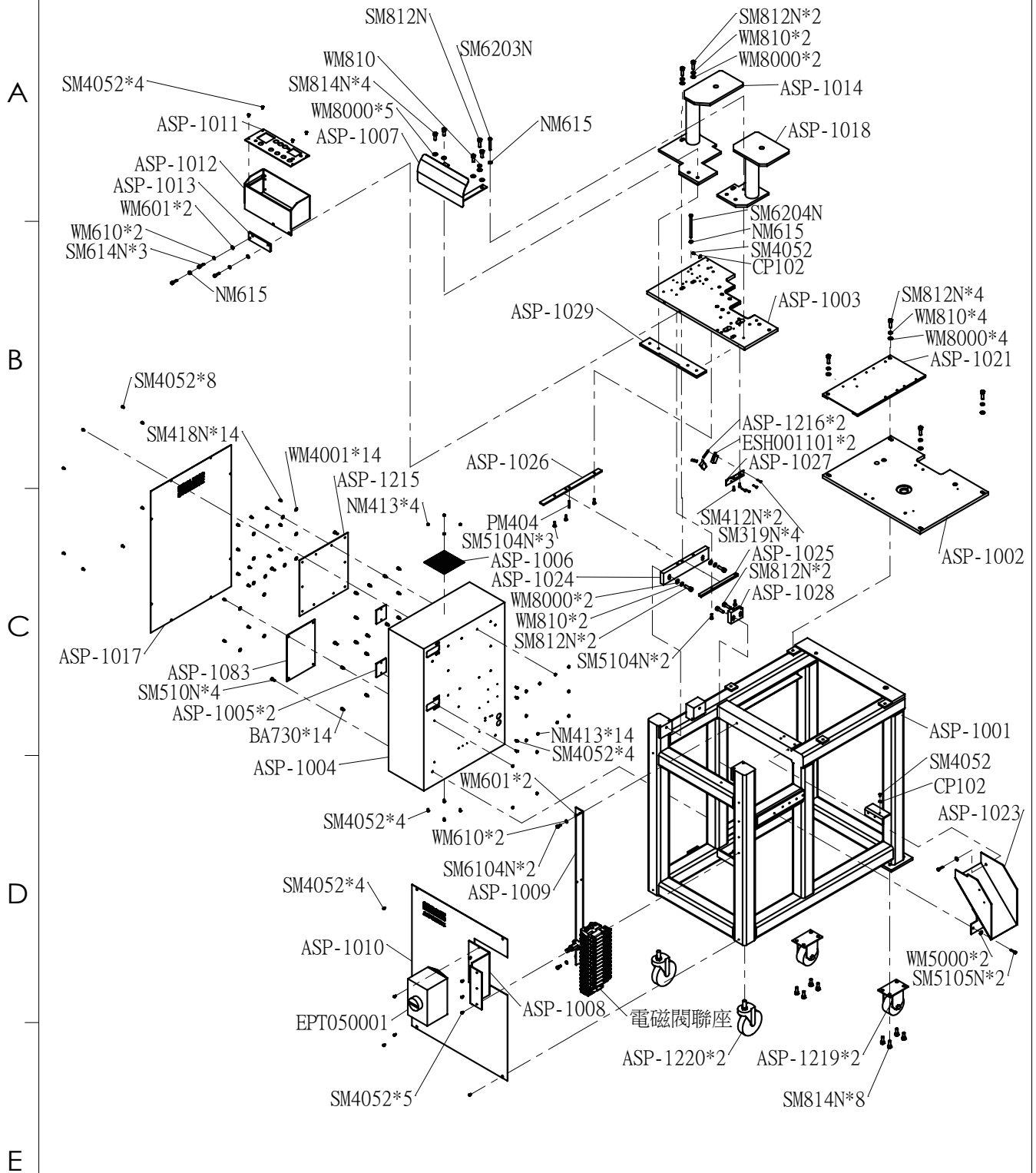
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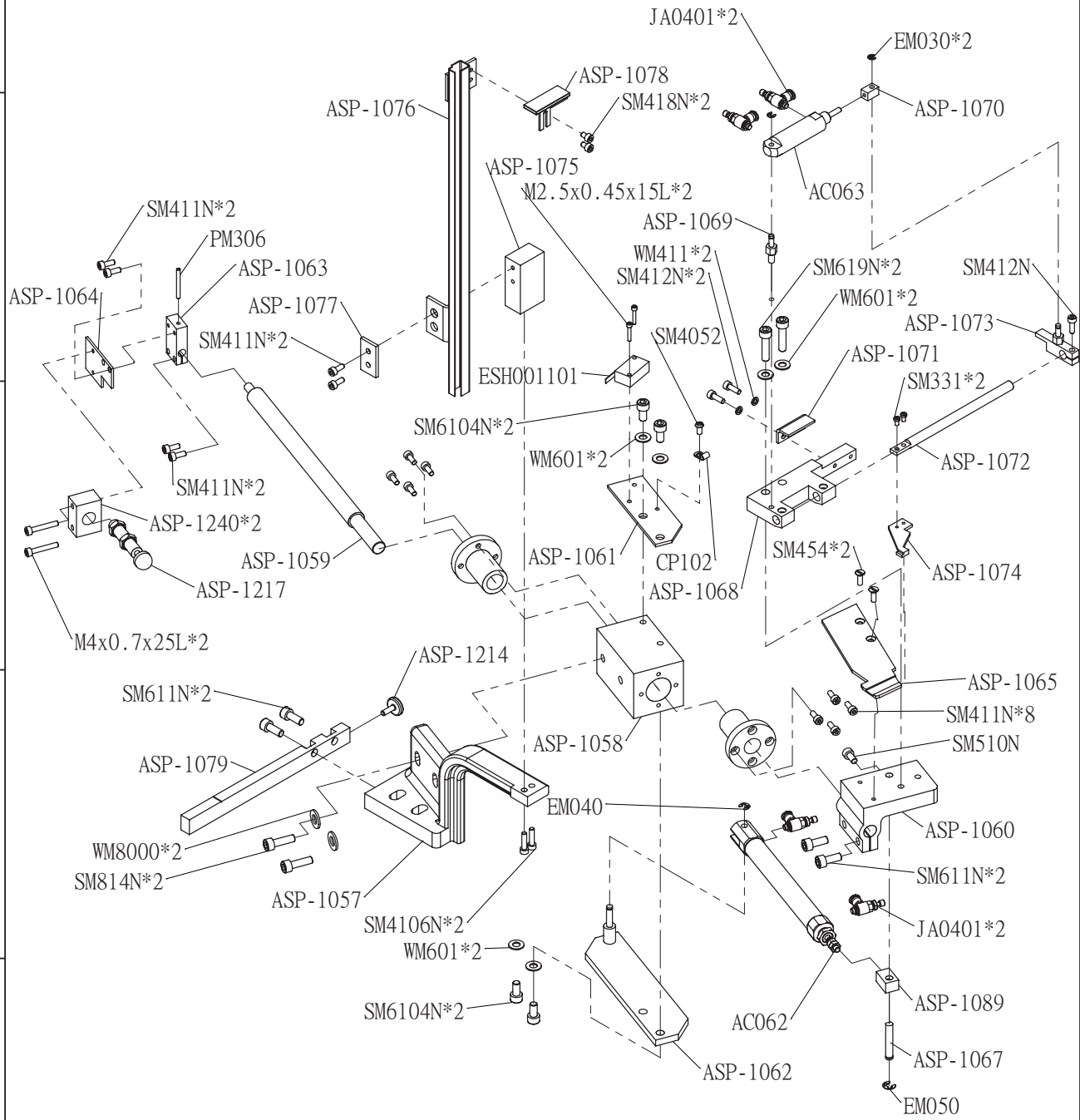
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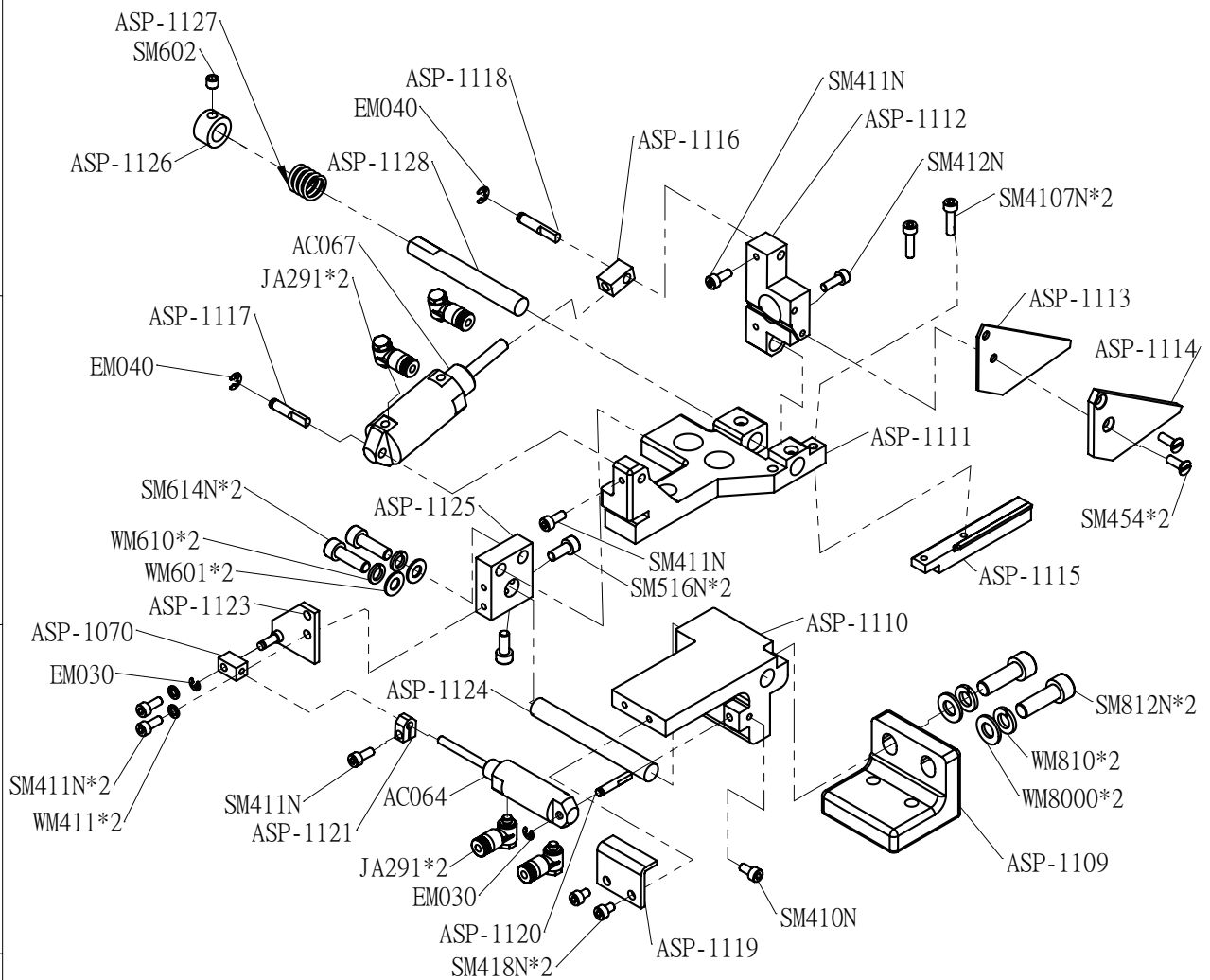
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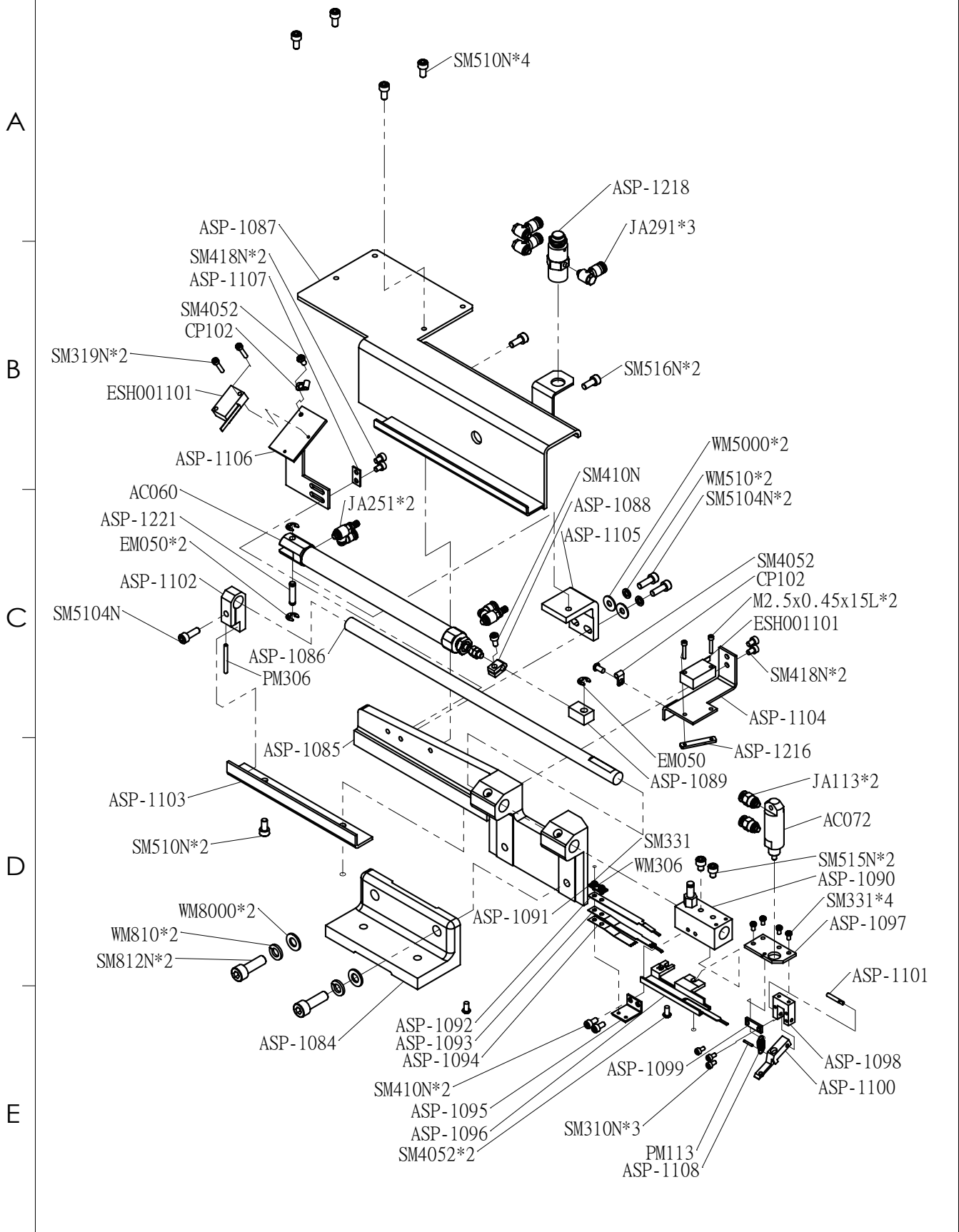
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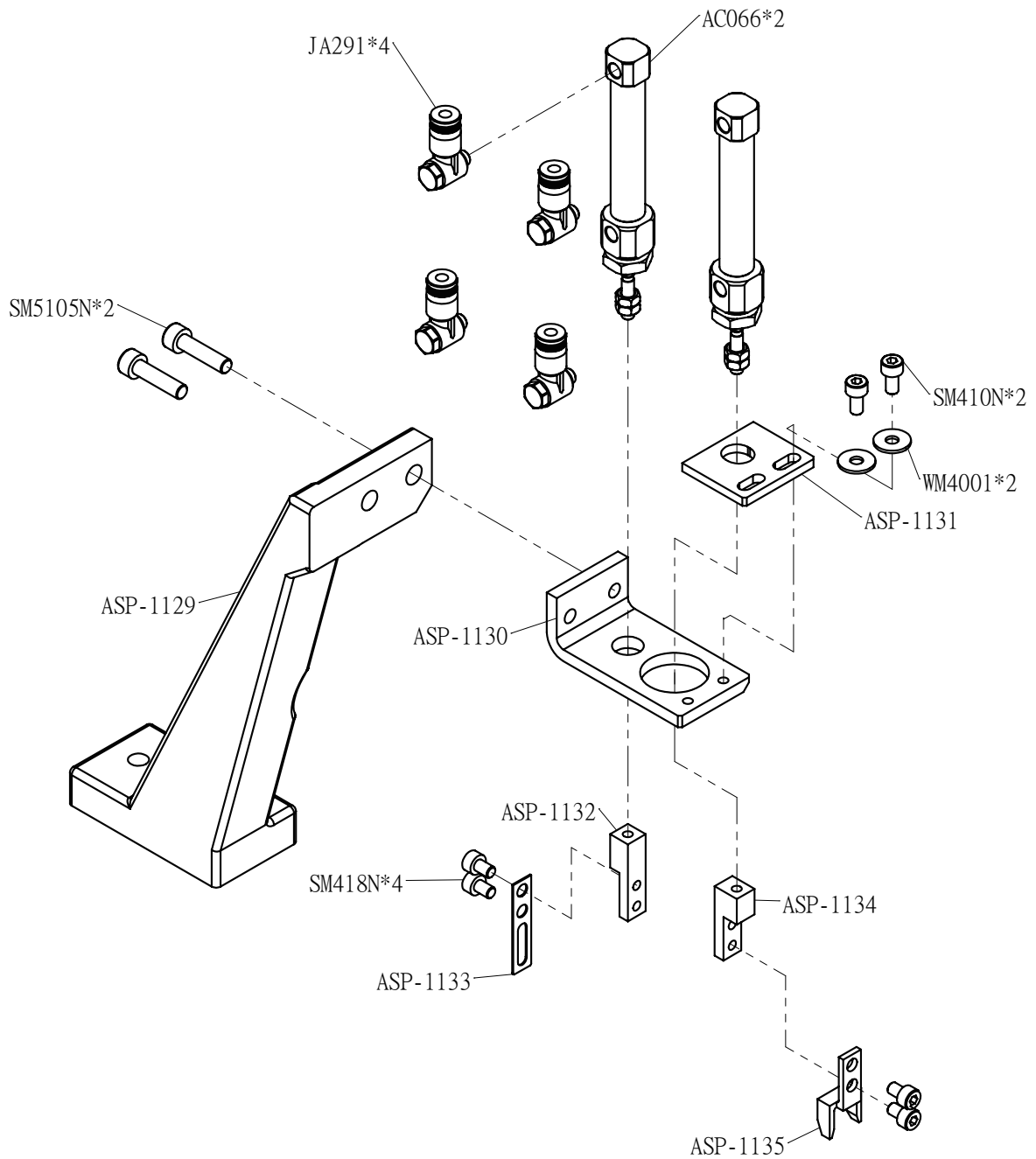
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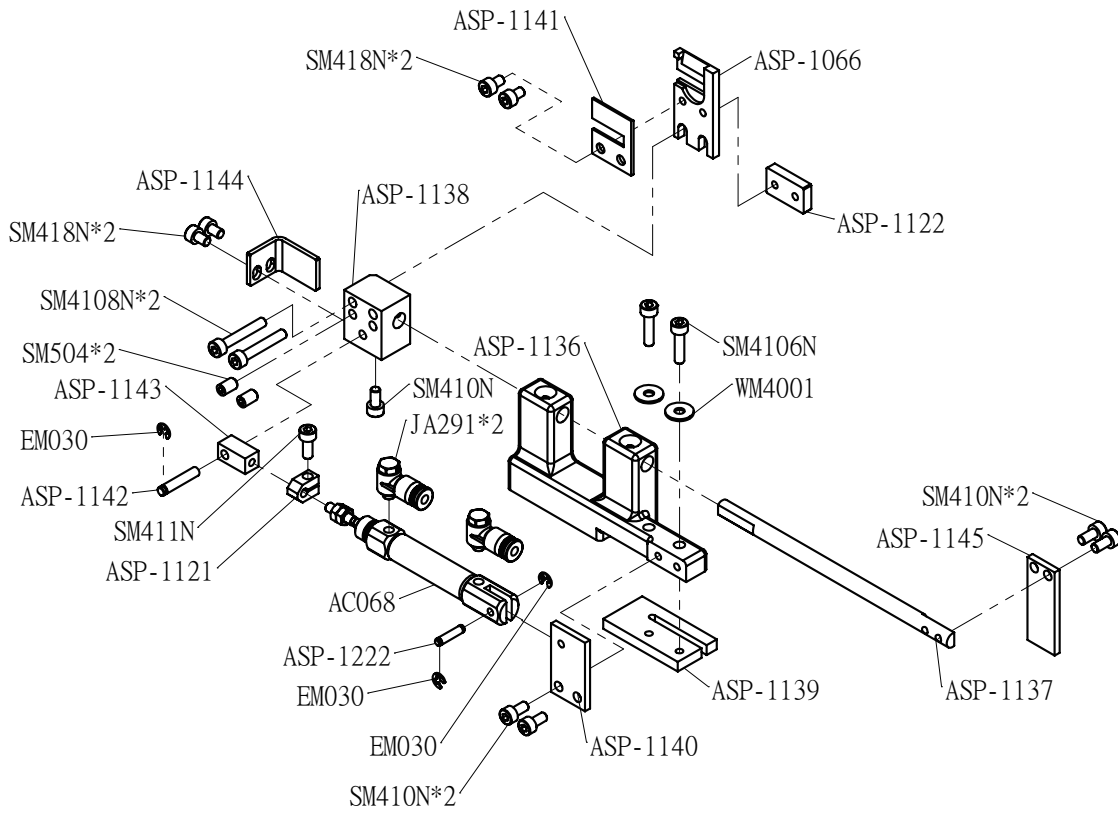
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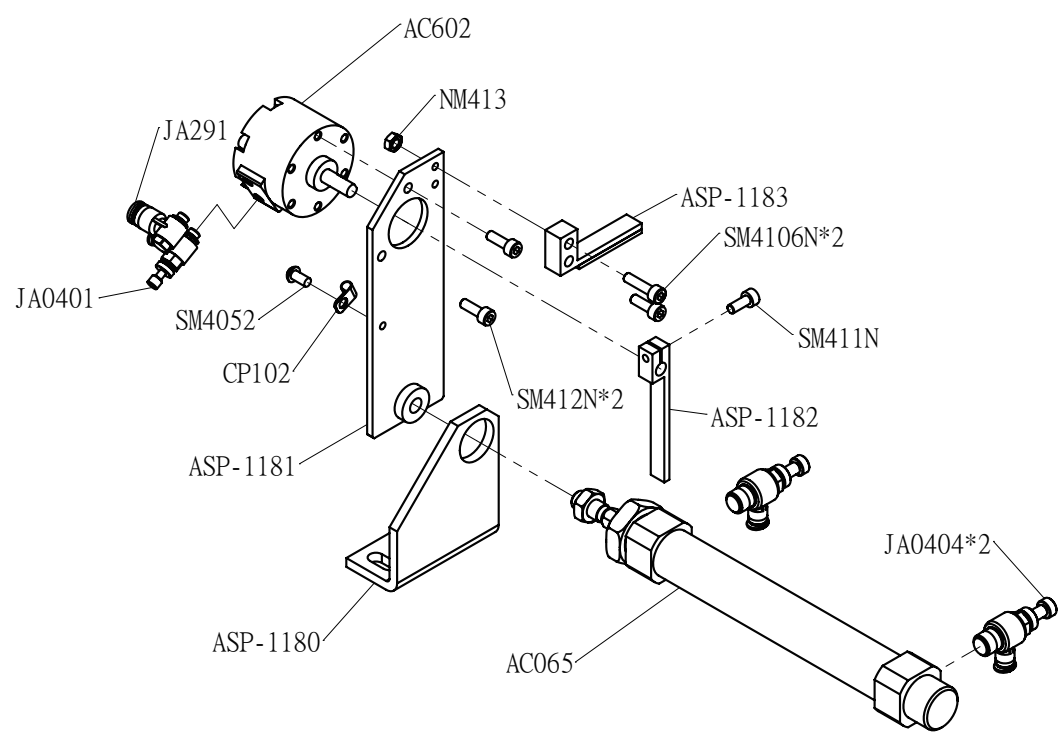
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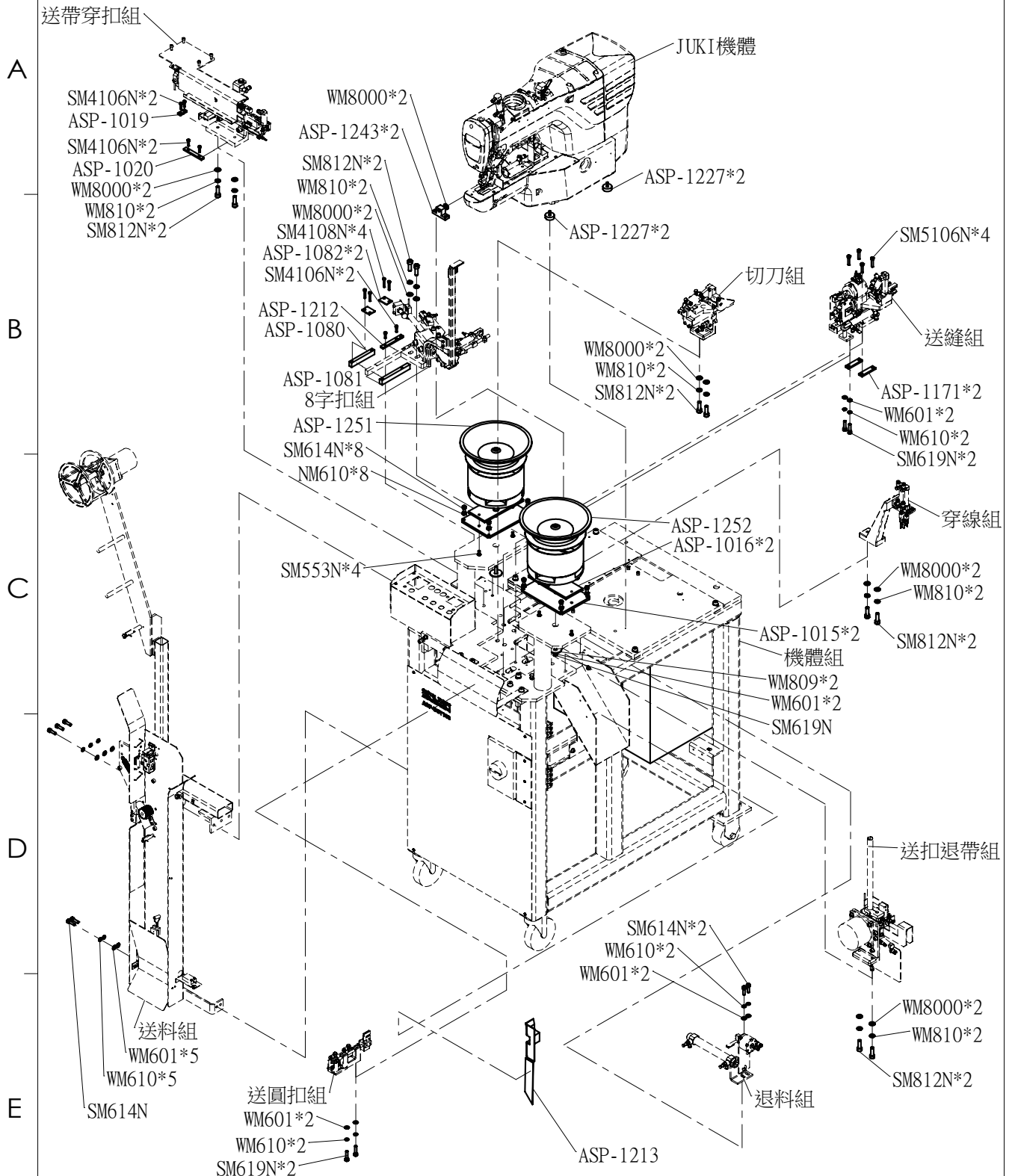
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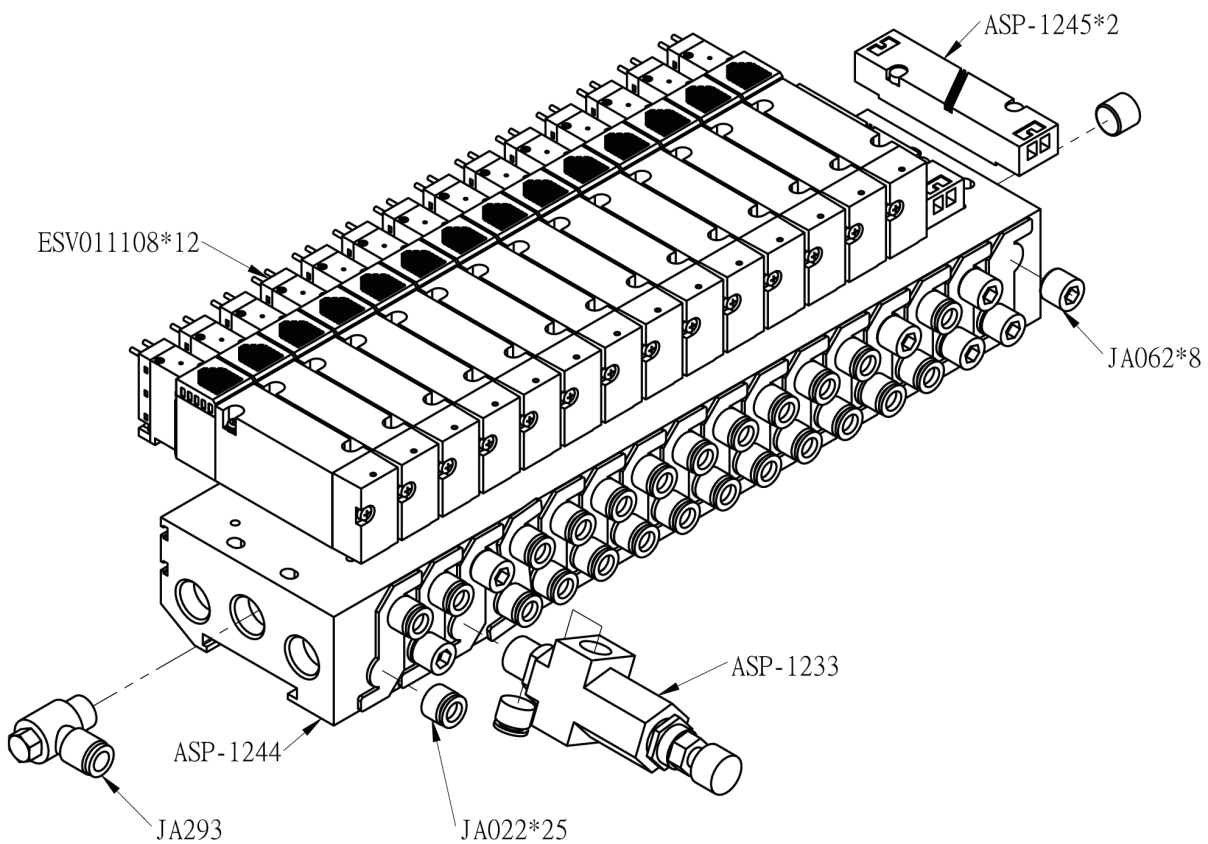
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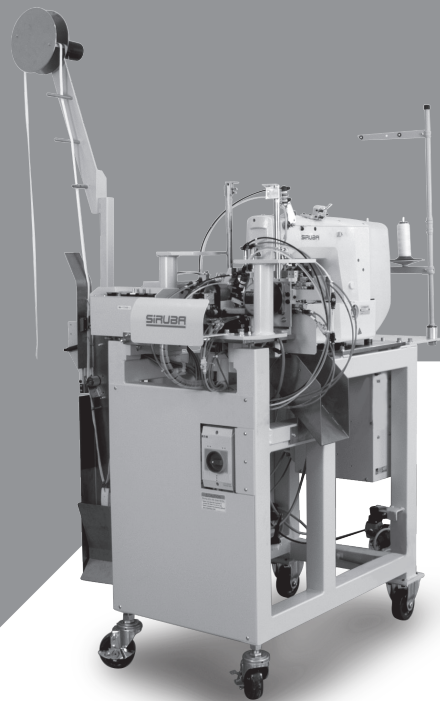
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