

SIRUBA®

使用說明書與零件圖

ORIGINAL INSTRUCTIONS BOOK & PARTS LIST

■ ASC-EBS100



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 ASC-EBS100，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 ASC-EBS100 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 done 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 agents, 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 needs to be repaired by the worker who is well trained.
 6. While doing the repair or maintaining 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 fillings 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.

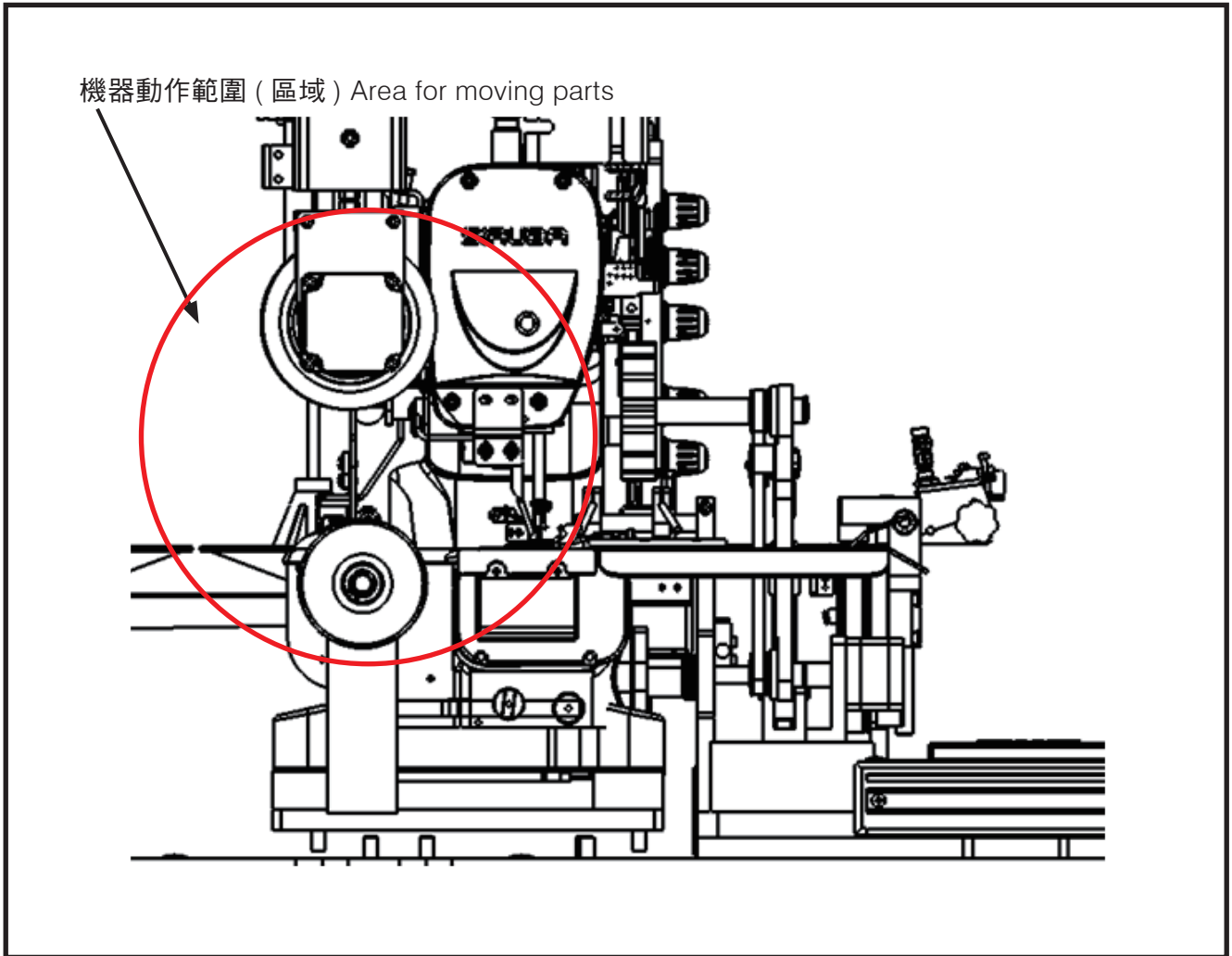
警告圖案表示

INDICATED 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>

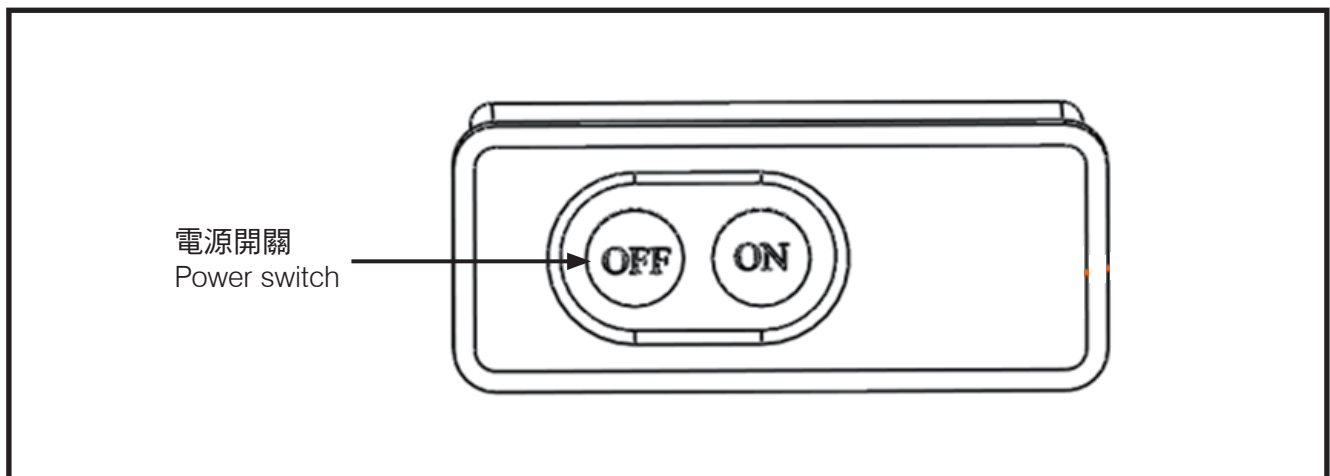
安全注意事項

SAFETY INSTRUCTIONS



1. 機械在運轉時，後拉輪轉動作業區域內不得將手放入。

1. Do not put your fingers into operating field of back roller while machine is operating.

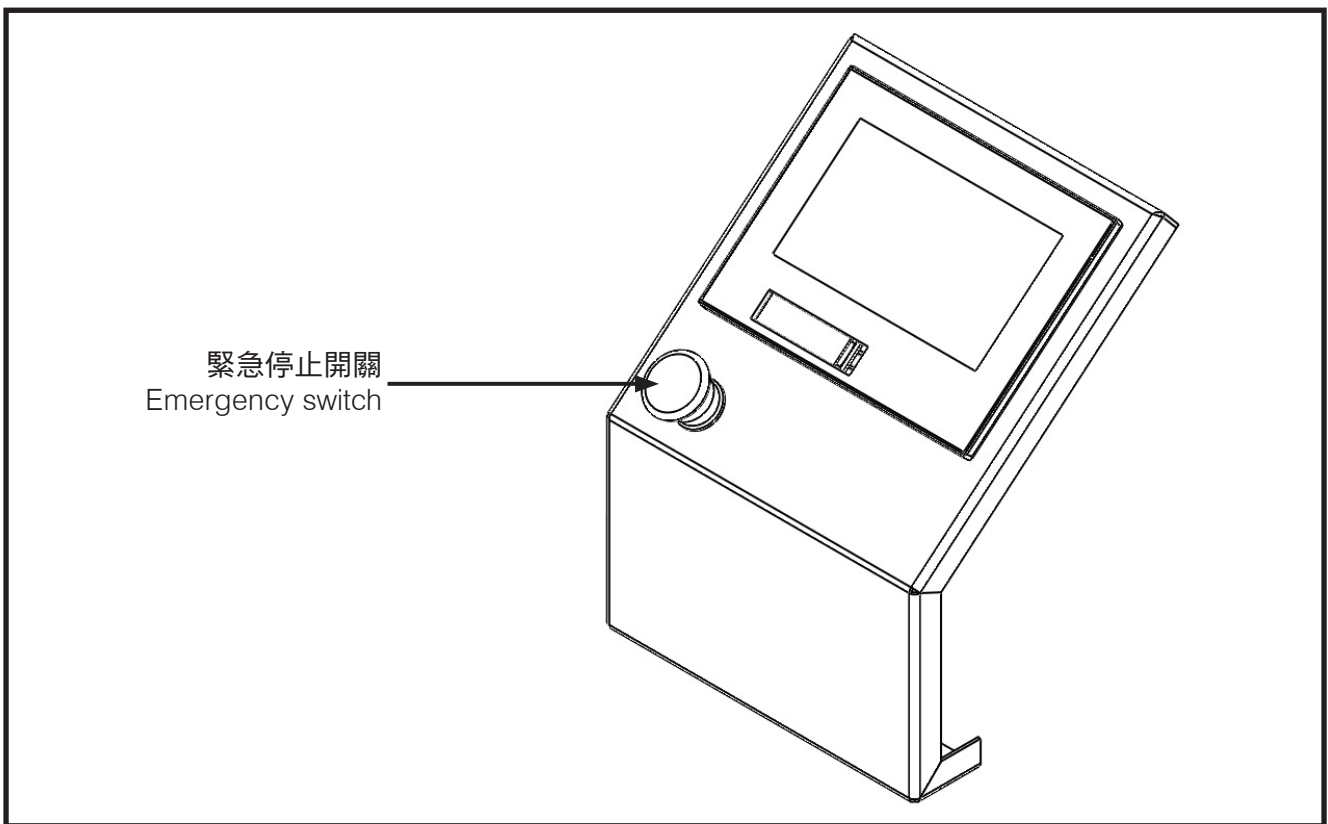


3. 在有危及人體的高壓電處，貼有觸電危險警告標記。在貼有本警告的電器控制部位而需要保修、檢修時，打開罩蓋僅能由專業的電氣技術人員進行。

4. 機器運轉時，有必要馬上停止機器的時候，可以按下緊急停止開關。

3. Stick the electric shock alert pictorial marking at high voltage place which may cause human danger. Therefore, only the professional and electric technician could open the cover, while the electric place which have stuck on the alert pictorial marking need to be repair and maintenance.

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



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 line pipe need to make sure being fixed and settle down. Do not put them disordered on the ground in case of people stumble and cause danger.

6. No matter under any circumstances, for your life safety, do not pull out the power ground wire while operating the machine.

7. For your safety, you need to stop your work and cut off the power, if it starts thundering.

8. Must switch off the power before you leave your work or work ending.

9. Do not take down any cover while operating the machine.

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規格

SPECIFICATION

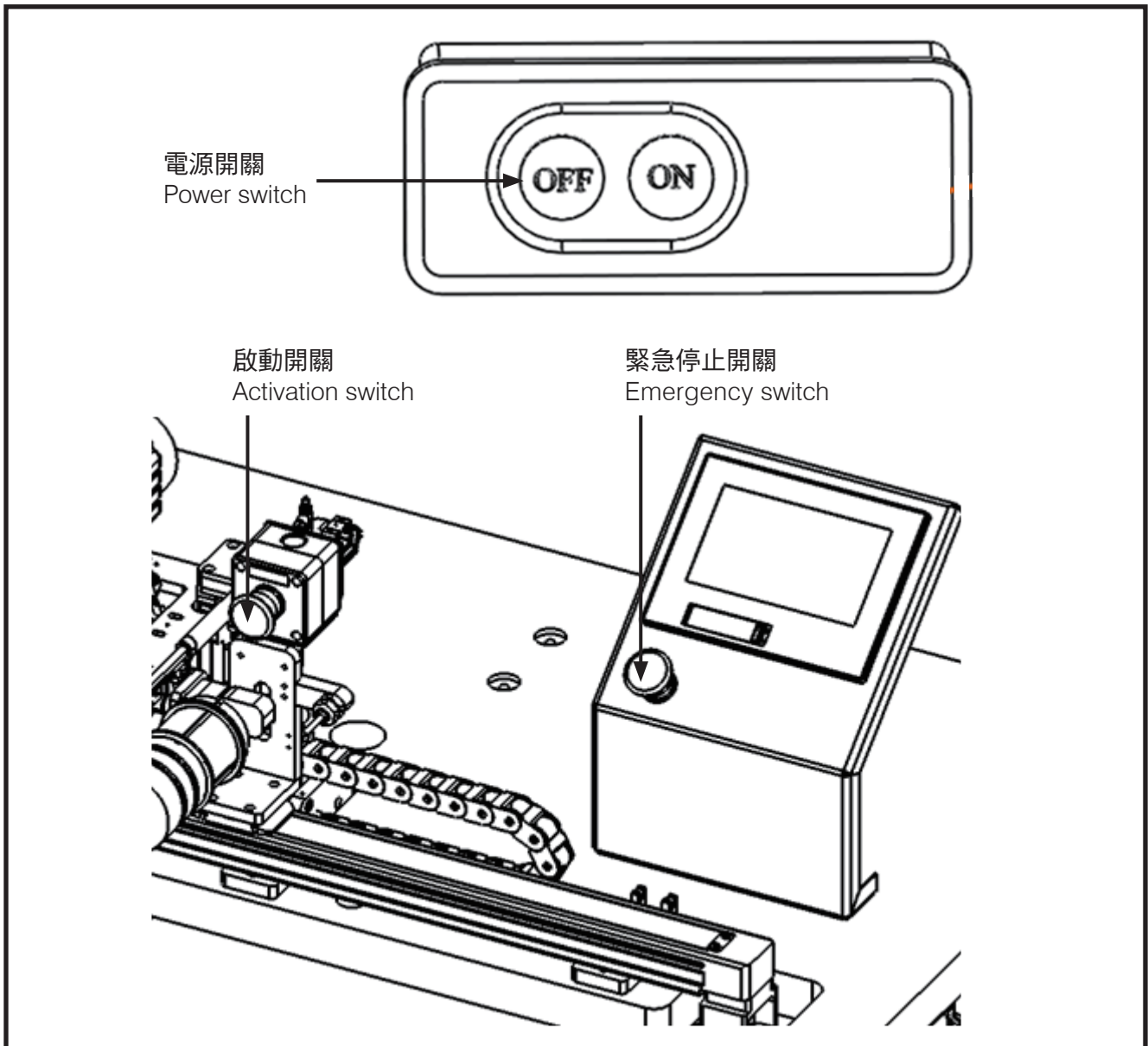
型號 Model	ASC-EBS100
搭配縫紉機機頭 Collocation Machine Head	C007K-W122
車縫速度 Sewing speed	最高 Max 4000 SPM
使用針型 Needle Type	UY×128GAS #10
車縫布料 Fabric Type	彈性棉布 & 尼龍布 Lycra, Nylon
鬆緊帶寬度 Waistband Width	20 ~ 40 mm
鬆緊帶長度 Waistband Length	24 inch (依褲頭尺寸而定) 24 inch (according to trouser size)
撐開周長範圍 Applicable Circumference Range	940mm ~ 1600 mm
氣體消耗量 Air consumption	150L/min
氣壓 Air Pressure	0.6 Mpa
電源電壓 Voltage	單相 AC200~240V 50/60Hz Single Phase AC200~240V 50/60Hz
機器尺寸 Dimensions	寬 1400× 深 800× 高 1700mm (含桌板、線架) (W)1400×(D)800×(H)1700mm (with table and thread stand)

操作開關

OPERATION SWITCH

按鈕開關

Button switch



名稱 Name	功能 Description
電源開關 Power switch	整機所有電源之開關。 Switch for main power of full machine.
啟動開關 Activation switch	自動模式下，啟動所需之按鈕。 In auto mode, press this button to activate.
緊急停止開關 Emergency switch	機器發生異常時，需緊急停止之按鈕。 When machine is on error, press this button to shut down machine.

人機介面

PANEL INSTRUCTION

(1) 電源與氣壓

A. 電壓

使用額定電壓 AC 220V±10%。

接地線一定要接地。

B. 氣壓

使用 0.5Mpa (5kg/c m²)。

(2) 初始化與主選單

A. 初始化

按壓電源 ON 後點擊面板上的「設備初始化
啟動按鈕」，使機構作動回歸原點。

(1) Voltage and Air pressure.

A.Voltage

Rated voltage at AC 220V±10% .

Earth cable must be in contact with ground.

B.Air pressure

Use 0.5Mpa (5kg/c m²) .

(2) Initialization and Menu

A.Initialization

Press power ON and touch "Initialization
button" on panel then machine will reset.

操作步驟

1. 面板上點擊一下進入下一頁

Operational procedures

- 1.Click the screen once to enter next page

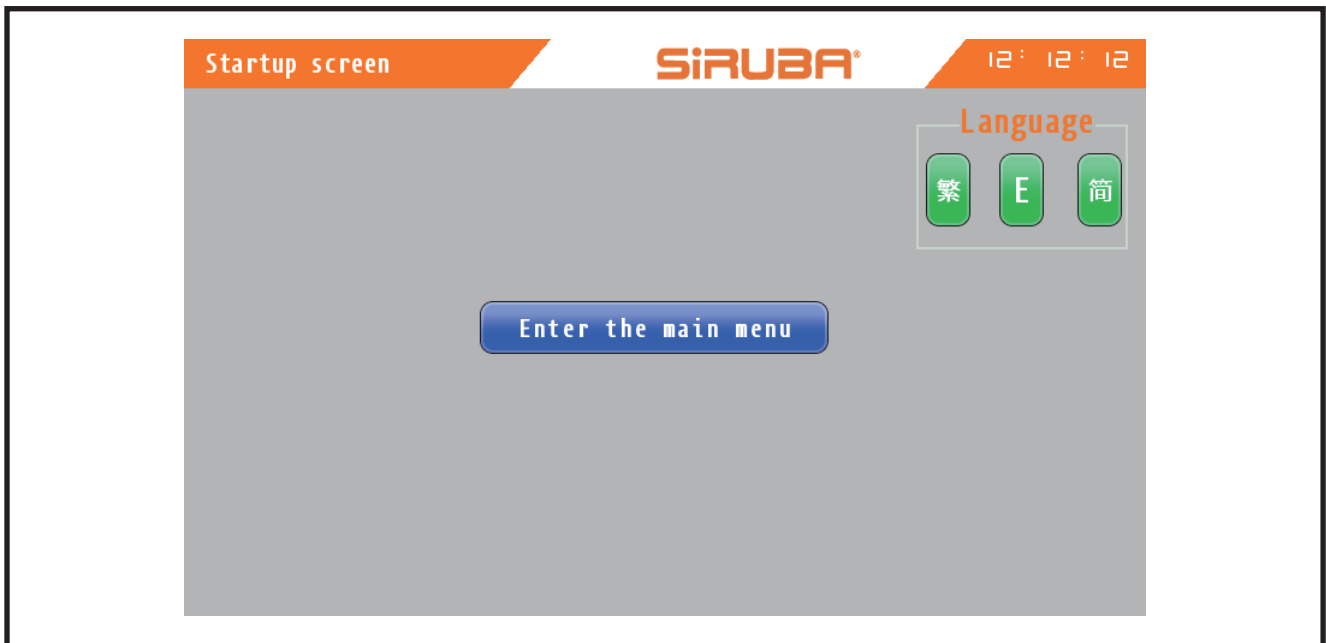
The image shows the SIRUBA logo in a bold, orange, sans-serif font. The logo is centered within a white rectangular area that is framed by a thick black border. A registered trademark symbol (®) is located to the upper right of the letter 'A'.

2. 開機畫面

- A. 在語系切換按鈕中選擇想使用的語系。
- B. 切換語系後“進入選單”將變成藍色，請點擊後進入下一頁。

2. Startup screen

- A. Press language button to select language
- B. After selecting language, "Enter the main menu" button becomes blue, please click it to enter the next page.

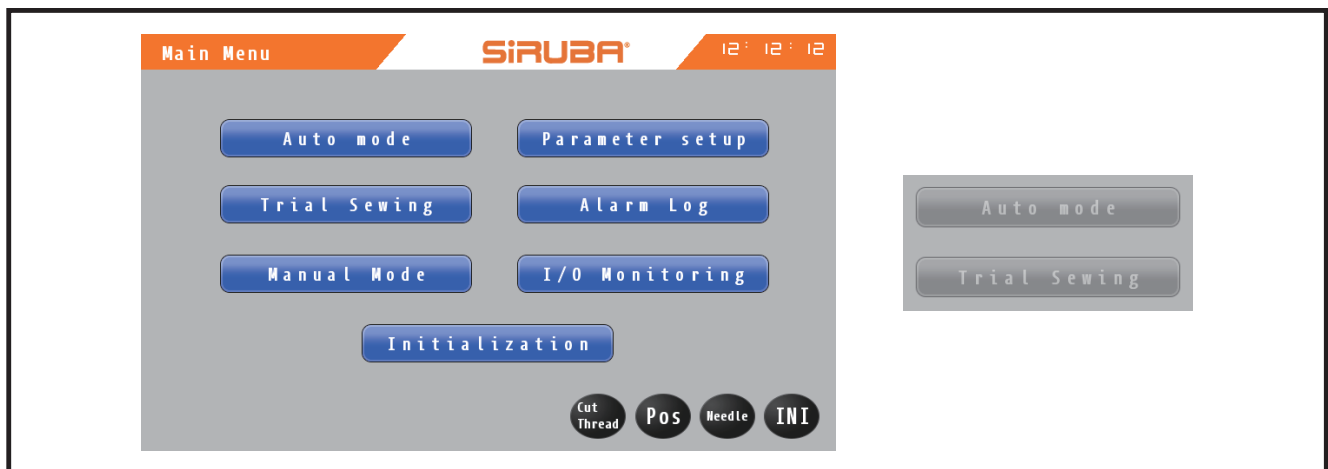


3. 主選單

- (1) 確認【切線】、【定位】、【針上】、【原點】亮燈。
- (1.1) 如果上述燈號不亮，“自動模式”與“試縫模式”將反灰並且不給執行（如圖 4）。
- (1.2) 如果【定位】、【切線】燈號沒亮，則“設備初始化”會反灰。
- (2) 執行“設備初始化”。
- (3) 確認【原點】燈號亮燈。
- (4) 點選其他功能。
 - (4.1) 想進入自動車縫流程，點選“自動模式”。
 - (4.2) 想進入教導檔建立流程，點選“試縫模式”。
 - (4.2.1) 在使用本設備時，請先完整執行一次“試縫模式”建立教導檔，再使用該教導檔進行自動模式。
 - (4.3) 想局部測試功能，點選“手動控制”。
 - (4.4) “參數設定”必須輸入密碼才可修改。
 - (4.5) “歷史警報”可看到過去發生的警報。
 - (4.6) “訊號監控”可簡單觀察當前訊號的收發狀況。

3.3.main menu

- (1) Make sure the leds of 【Cut Thread】、【Pos】(position)、【Needle】(needle up)、【INI】(original point) turn on
 - (1.1) If leds above do not work, "Auto mode" and "Trial Sewing" will turn gray and disable
 - (1.2) If leds of 【Pos】 and 【Cut Thread】 do not turn on, "Initialization" will turn gray
- (2) Press "Initialization"
- (3) Make sure 【INI】 led is on
- (4) Click other functions
 - (4.1) If you want to sew automatically, press "Auto mode"
 - (4.2) If you want to record process, press "Trail sewing"
 - (4.2.1) Before running this machine, enter "Trial Sewing" to record full-period process. Then, use the record to process sewing automatically
 - (4.3) When you want to check part of functions, press "Manual Mode"
 - (4.4) Need password to modify "Parameter setup"
 - (4.5) You could find past alarm records in "Alarm Log"
 - (4.6) You could find I/O signal records in "I/O Monitoring"



4. 試縫模式

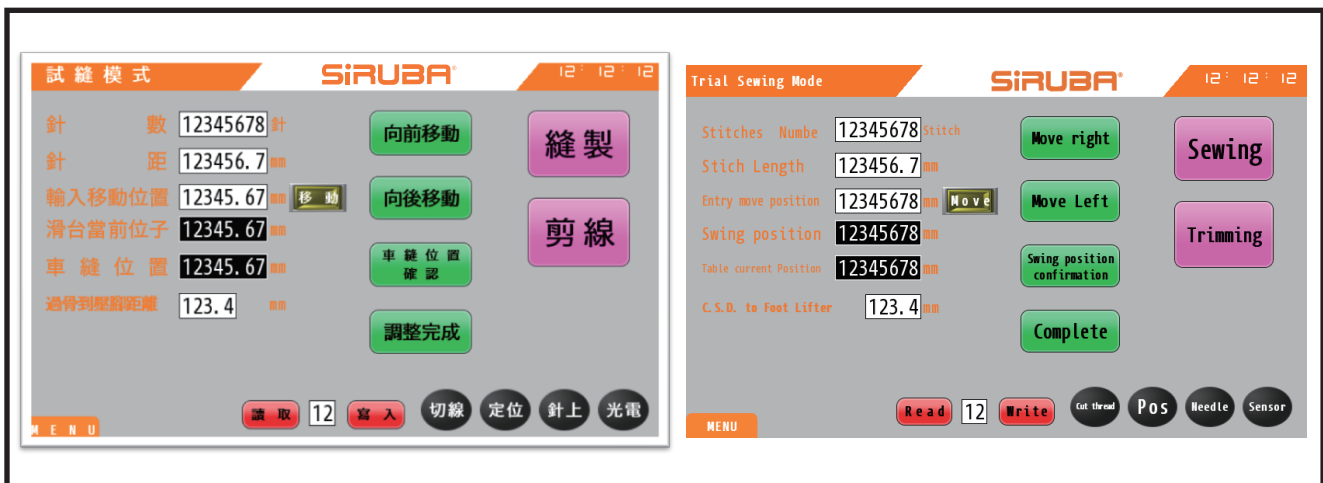
(注意：操作過程中請勿移動滑台組。)

- (1) 進入試縫模式後，滑台將移動至原點
- (2) 等待壓腳上升。
- (3) 在“讀取”右側輸入想要建立或修改的教導檔編號。
- (4) 將褲料放上機台。
- (5) 按下〈啟動〉綠色按鈕開關，此時吹氣銅嘴會噴出氣體。
- (5.1) 此時人機介面上面綠色按鈕從灰色轉成綠色。
- (6) 輸入「輸入移動位置」後按下《移動》來調整滑台位置，並透過“向前移動”與“向後移動”來進行微調。
- (7) 透過“車縫位置確認”來記錄想要定位的位子。
- (8) 確認「針距」、「過骨到壓腳的距離」的數值是與需求值相同。
- (9) 完成上述步驟後，按下“調整完成”，執行順布動作。
- (9.1) 此時，所有氣缸皆會動作，請注意自身安全。
- (9.2) 按下調整完成後，「過骨到壓腳的距離」將不得變更。
- (9.3) 此時綠色按鈕由綠色轉成灰色，當順不動作完成後，“縫製”與“剪線”按鈕從灰色轉成粉紅色。
- (10) 當滾布輪停止且壓腳下降後，按下“縫製”不放，當車縫至重合時，放開“縫製”。
- (10.1) 當縫製開始時，滾布輪會隨車頭馬達速度開始滾布。
- (11) 按下“剪線”，此時下切刀、勾線、壓腳皆會動作。
- (12) 待車頭完成剪線動作後，取下成品。
- (13) 按下“寫入”完成教導檔建立。

4. Trial Sewing mode

Note: do not move sliding part when machine is operated.

- (1) After entering trial sewing mode, sliding platform will move to original point
- (2) Wait for the raise of presser foot
- (3) Type the number of process record on the right side of "Read" button to build and to modify process record
- (4) Put semi-finished trouser on the machine platform
- (5) Press green button <activation> switch and blowing nozzle will start to blow.
- (5.1) Then, gray buttons turn to green color
- (6) Fill in 「Entry move position」 and then press <<move>> to adjust the position of sliding platform. You can press "Move right" and "Move Left" to fine tune the position.
- (7) Press "Sewing position confirmation" to record the position.
- (8) Make sure values of 「Stitches Number」 and 「C.S.O. to presser foot」 are what we need.
- (9) After processes above, press "Complete" to setup up the cloth
- (9.1) Then, cylinders start working. Please make sure operator safety.
- (9.2) After adjusting, the value of 「C.S.O to presser foot」 will fix.
- (9.3) After setuping up the cloth, green buttons become gray. Buttons of "Sewing" and "Trimming" change from gray to pink color.
- (10) When roller stops and presser foot lowers, keep pressing "Sewing" button. Release "Sewing" after sewing line matches together.
- (10.1) When starting sewing, roller will follow motor speed of machine head and start to roll cloth.
- (11) Press "Trimming" and then lower cutter, upper looper and presser foot will work
- (12) After machine head cuts thread, take off finished product.
- (13) Press "Write" to finish process record.

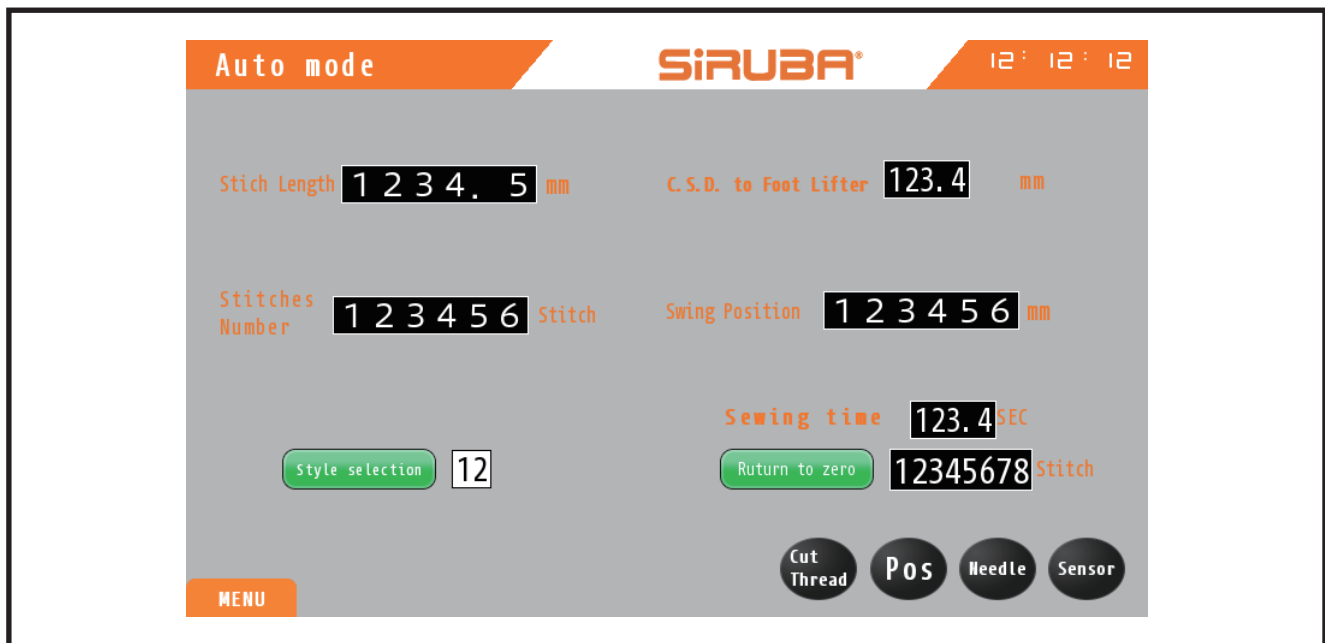
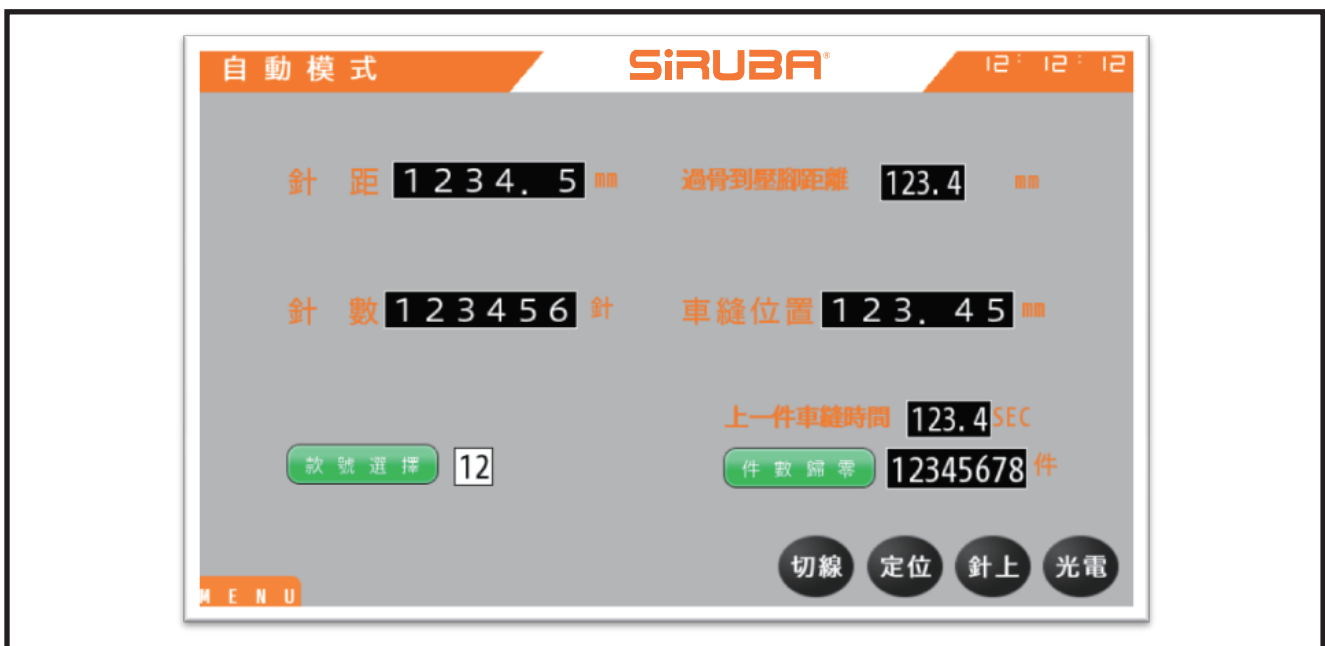


5. 自動模式

- (1) 選擇功能後，等待滑台返回原點、壓腳上升、警報聲響結束，方可進行下一動作。
- (2) 輸入想要使用的教導檔號碼，按下“款號選擇”。
- (3) 將布料放上。
- (4) 按下〈啟動〉綠色按鈕開關，按下車縫流程。
- (5) 待全機停止後，取下成品，完成車縫。

5. Auto mode

- (1) After selecting the function, wait until sliding platform moves back to original point, presser foot raises and alarm voice stops. Then, we can move to next step.
- (2) Input the number to choose process record and then press "style selection"
- (3) Put the cloth on the machine
- (4) Press green <Activation> switch to start sewing process
- (5) After machine stops running, take off final product and finish sewing.



6. 手動控制

- Ⓐ：感測器狀態
- Ⓑ：維持型功能按鈕
- Ⓒ：氣缸動作
- Ⓓ：滑台動作、車縫、復歸、手動參數調整。

(1) 車縫啟動為按壓後維持按壓才能持續動作。

車縫啟動可用條件：

1. 壓腳下壓。
2. 針在針上。
3. 剪線後退。
4. 勾線後退。

(2) “復歸” 將會將氣缸與功能都關閉。

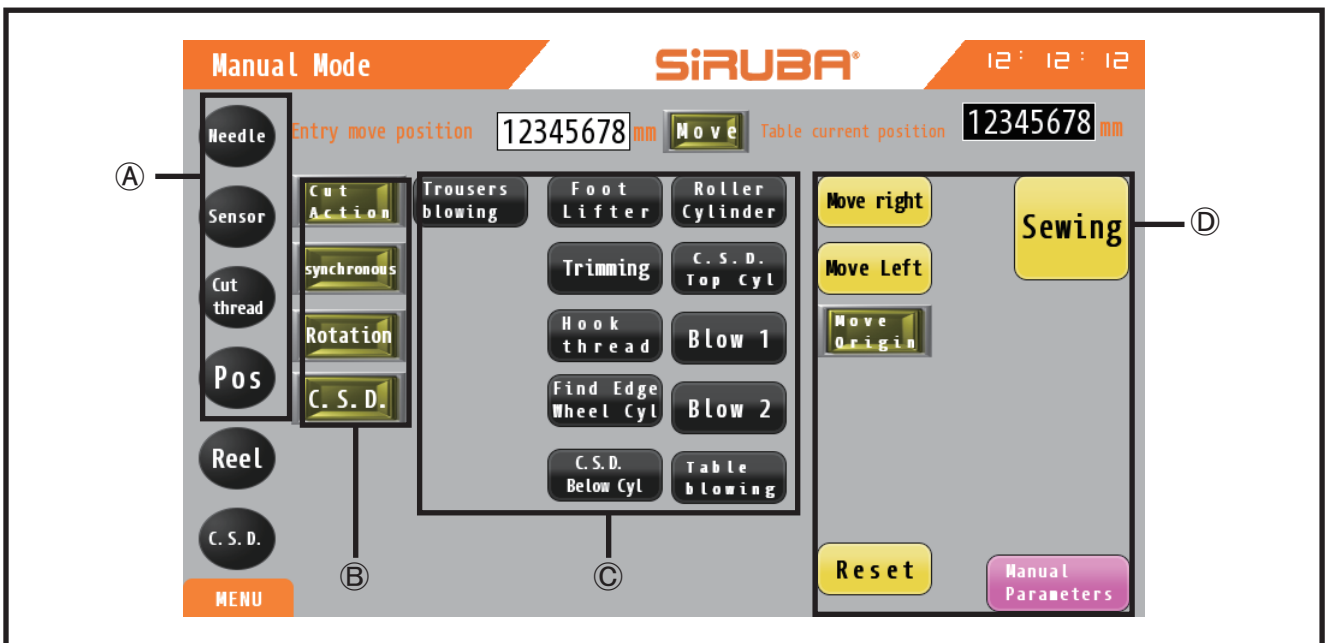
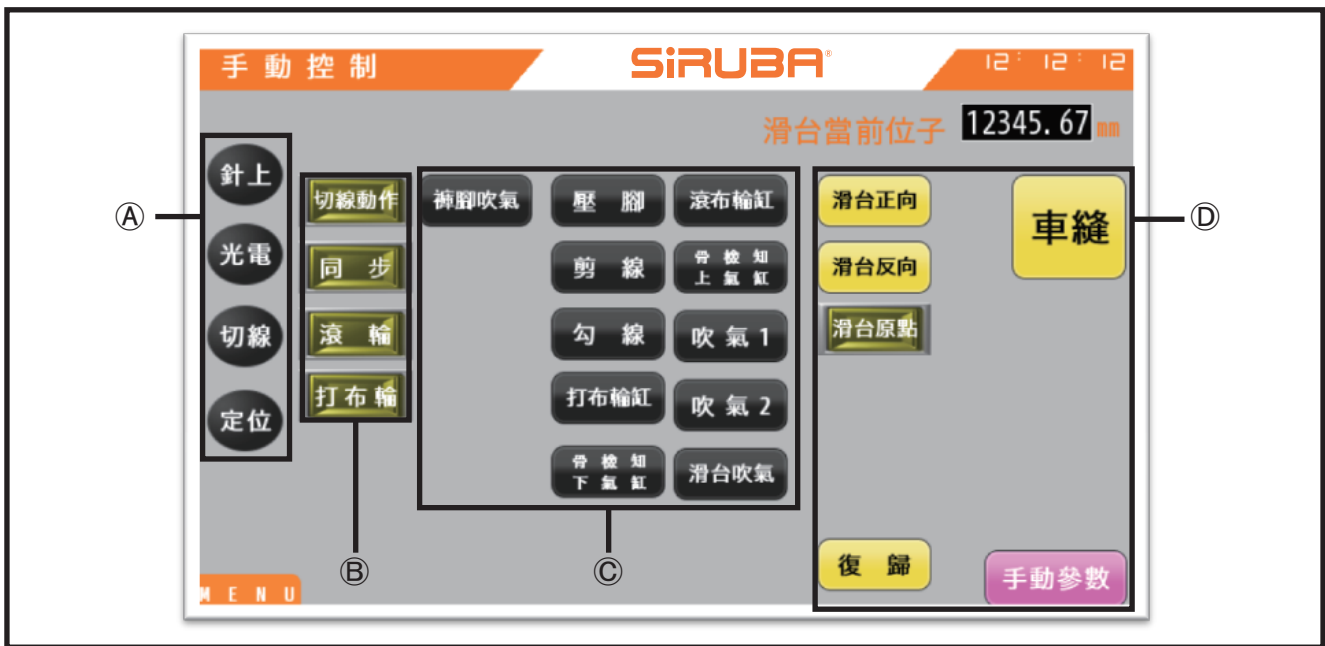
6. Manual mode

- A: Sensor status
- B: Maintenance functional buttons
- C: Cylinder actions
- D: Actions of sliding platform, sewing, reset and Manual parameters adjustment

(1) Keep pressing "Sewing" to keep the process. Need to satisfy the followings before pressing "Sewing":

1. Lower presser foot
2. Needle is on the top
3. Lower thread cutter needs to move back
4. Upper looper needs to move back

(2) To press "Reset" will close cylinders and functions.



7. 歷史錯誤

(1) 顯示歷史警報

(1.1) 紅色：急停按鈕。

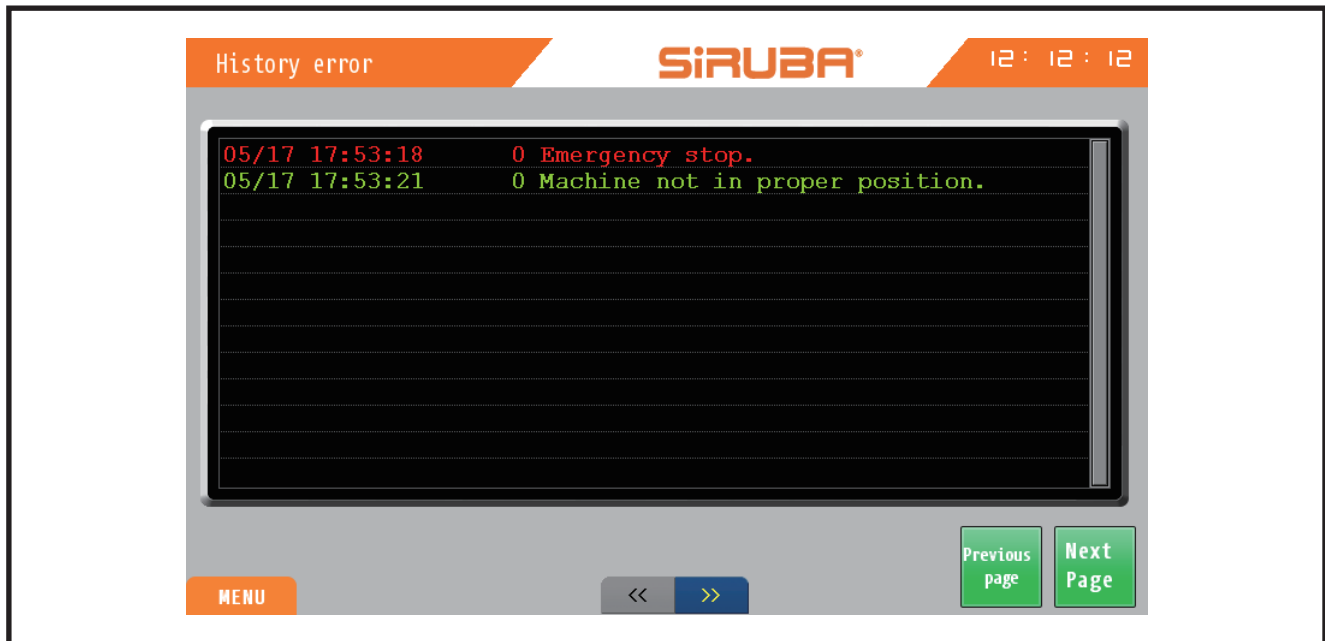
(1.2) 綠色：軟體偵測錯誤急停

7. History error

(1) show historical alarms

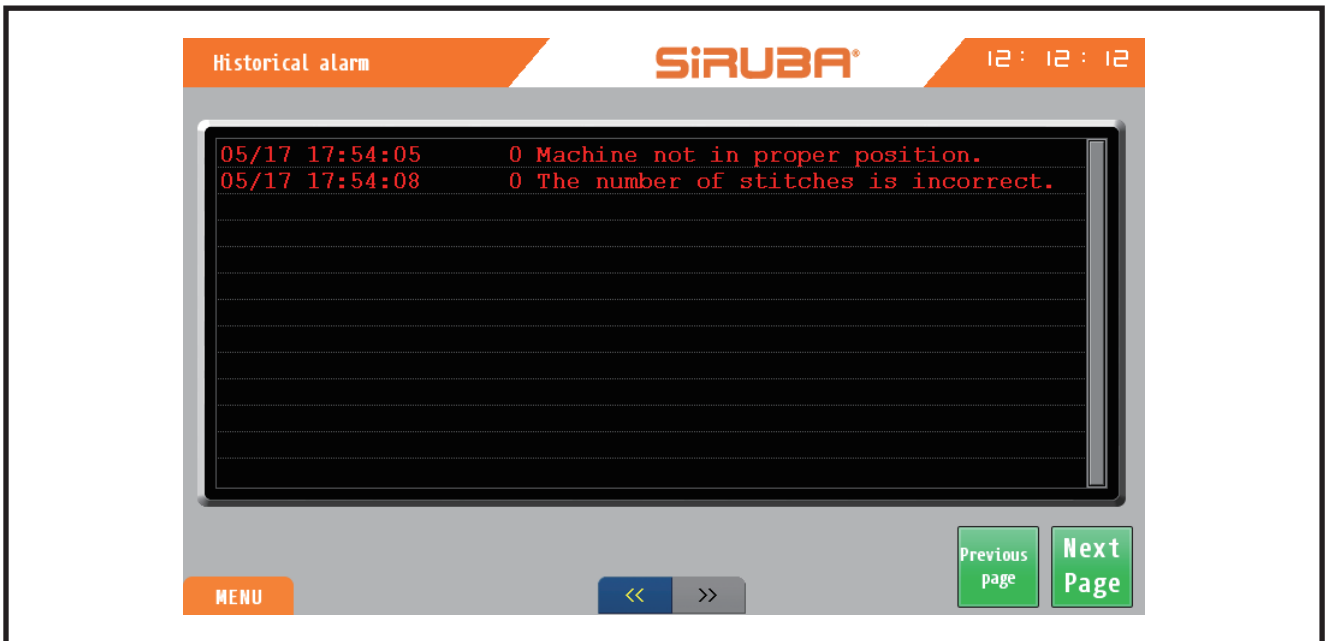
(1.1) Red: emergent stop button

(1.2) Green: emergently stop when software finds error



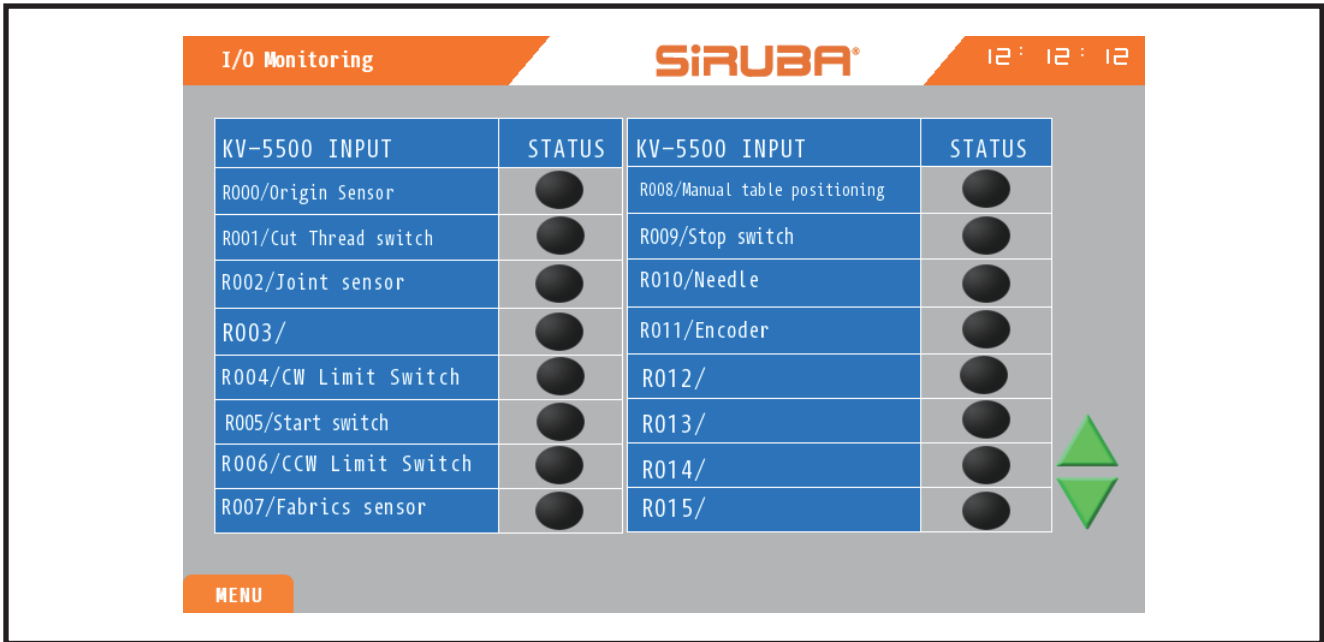
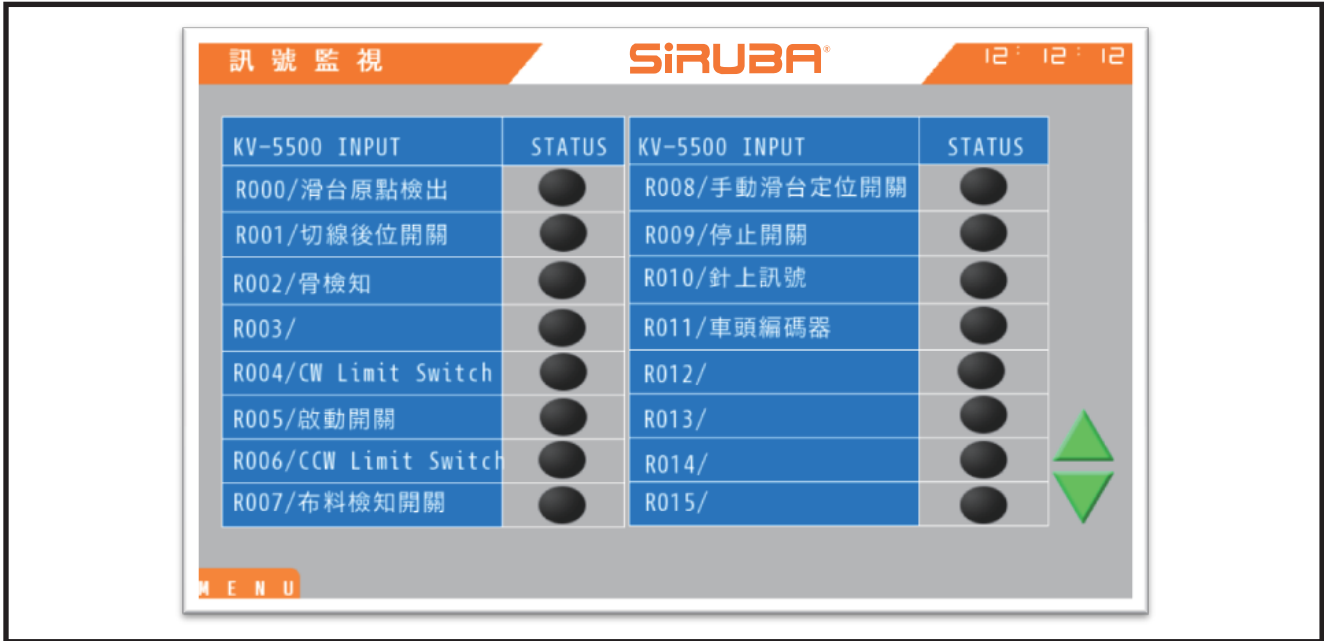
8. 歷史警報
顯示歷史警報

8. Historical alarm
Show historical alarm



9. 訊號監視
顯示當前訊號狀況

9. I/O Monitoring
Show current I/O status



錯誤碼原因與排除

TROUBLESHOOTING

NO	名稱 Description	原因 Reason	排除 Solution
0000	急停啟動 Emergent stop	按下手動停止按鈕 Emergent button is pressed	請排除急停原因後再繼續 Release the button after remove the reason of emergent stop
0001	針不再上死點 Needle is not on the top	在流程運行的情況下，車頭不再針上，此狀況通常是車頭馬達或者車頭馬達控制箱有異常。 In process, needle in machine head is not on the top. The reason might be motor or motor control box run improperly.	<ol style="list-style-type: none"> 1. 確認人機上針上燈號有亮燈 2. 確認車頭的針有在針上 3. 確認控制箱有無異常碼顯示 <ol style="list-style-type: none"> 1. Make sure "Needle" led is on 2. Make sure needle of machine head is on the top 3. Make sure no error code on control box
0002	CW 極限觸發 CW limit is triggered	滑台極限檢知器被觸發 Sliding platform sensor is triggered.	<ol style="list-style-type: none"> 1. 檢查極限檢知器有無被異物遮住。 2. 使用紙張對檢知器進行測試，確認燈號會閃爍。 3. 如果會閃爍，進入訊號監視畫面，使用上一步的方法，確認 R000、R004、R006 燈號會閃爍。 4. 如果 2 或 3 任一步有問題，請更換檢知器。 <ol style="list-style-type: none"> 1. check if limit sensor is covered by dust. 2. use paper to check the sensor if led flashes or not 3. If led flashes, we need to enter signal monitor, use methods described above and then check R000, R004 and R006 leds will flashes. 4. If we find any problems in step 2 or step 3, please change sensor.
0003	CCW 極限觸發 CCW limit is triggered	滑台極限檢知器被觸發 Sliding platform sensor is triggered.	<ol style="list-style-type: none"> 1. 檢查極限檢知器有無被異物遮住。 2. 使用紙張對檢知器進行測試，確認燈號會閃爍。 3. 如果會閃爍，進入訊號監視畫面，使用上一步的方法，確認 R000、R004、R006 燈號會閃爍。 4. 如果 2 或 3 任一步有問題，請更換檢知器。 <ol style="list-style-type: none"> 1. check if limit sensor is covered by dust. 2. use paper to check if sensor led flashes or not 3. If led flashes, we need to enter signal monitor, use methods described above and then check R000, R004 and R006 leds will flashes. 4. If we find any problems in step 2 or step 3, please change sensor.
0004	左右極限觸發 Left or right limits are triggered.	滑台極限檢知器被觸發 Sliding platform sensor is triggered.	<ol style="list-style-type: none"> 1. 檢查極限檢知器有無被異物遮住。 2. 使用紙張對檢知器進行測試，確認燈號會閃爍。 3. 如果會閃爍，進入訊號監視畫面，使用上一步的方法，確認 R000、R004、R006 燈號會閃爍。 4. 如果 2 或 3 任一步有問題，請更換檢知器。 <ol style="list-style-type: none"> 1. check if limit sensor is covered by dust. 2. use paper to check if sensor led flashes or not 3. If led flashes, we need to enter signal monitor, use methods described above and then check R000, R004 and R006 leds will flashes. 4. If we find any problems in step 2 or step 3, please change sensor.
0006	手動滑台不再定位 Manual sliding platform does not position.	在車縫過程中，手動滑台有移動狀況 When sewing, manual sliding platform is moving.	請將手動滑台固定，將設備初始化，在開始原本工作。 Please fix manual sliding platform, initialize the machine, and then re-start the work.
0007	剪線氣缸異常 Cutter cylinder error	剪線器缸復位檢知器異常 Return sensor of cutter cylinder error	<ol style="list-style-type: none"> 1. 確認電磁閥沒被手動鎖定 2. 確認氣缸有復位 3. 確認近接開關狀態正常 <ol style="list-style-type: none"> 1. Make sure solenoid valve is not locked 2. Make sure cylinder return 3. Make sure the status of nearer switch is well

警報碼原因與排除

Alert Code Reason and Solution

NO	名稱 Description	原因 Reason	排除 Solution
2000	針不再上死點 Needle is not on the top	在動作啟動前，針不再針上 Before activating, needle does not raise.	請將車頭手動轉到針上後，先按下清除，在按下關閉 Please adjust machine head to raise the needle, press "clear" and then press "close" to close error message.
2003	布料沒有遮到光電開關 Cloth does not cover optoelectronic switch	在動作啟動前，布料沒有遮到電眼 Before starting machine, cloth does not cover optoelectronic switch	請將布料遮到電眼後，先按下清除，在按下關閉 Please move cloth to cover the sensor, press "clear" and then press "close" to close error message.
2005	手動滑台不再定位 Manual sliding platform does not position.	在動作啟動前，手動滑台不再定位 Before starting machine, manual sliding platform does not position.	請將手動滑台移至定位後，先按下清除，在按下關閉 Please move manual sliding platform to the proper position, press "clear" and then press "close" to close error message.

其他問題

Other questions

現象 Problem	原因 Reason	排除 Exclusion
當滑台移動至原點時，在離原點檢知器很遠的地放降低速度，直到原點檢知器備觸發後才停止。 When sliding platform moves to original, lower the speed far from original point sensor. Platform stops when triggering original point sensor.	滑台上的極限與原點檢知器在運動過程中被異物遮蔽到。 Limit sensor and original sensor on sliding rail is covered by dust when machine is on process.	1. 先到“主畫面”上按下“手動控制”。 2. 對“滑台正向”或者“滑台反向”按下，使得滑台移動一點距離。 3. 清除檢知器周邊異物。 4. 再按下“滑台原點”，等待原點完成後，狀況就可以排除。 1. Press "manual mode" on "main menu". 2. Press "Move right" or "Move left" for sliding platform to let sliding platform leave some space 3. Clean the dust around the sensor 4. Then, press "Move origin" and wait. Problems will be solved.

運轉

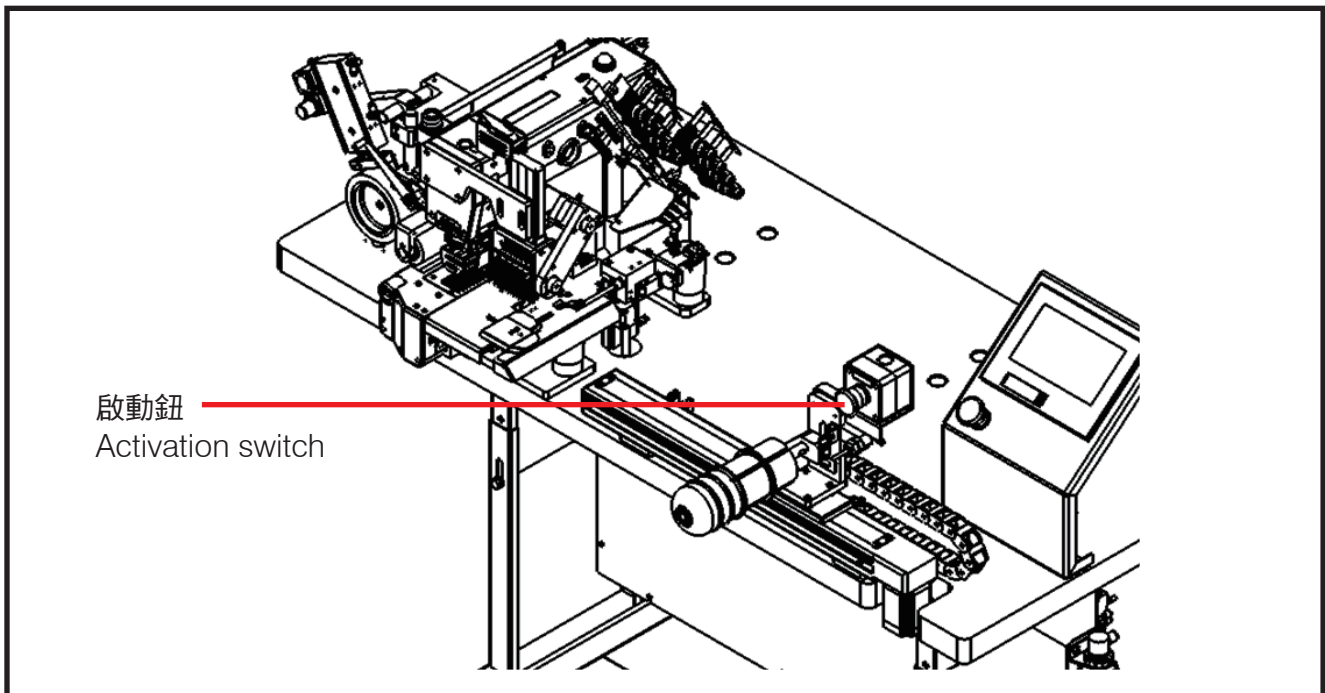
OPERATION

裝帶與啟動

在自動模式下，將鬆緊帶放至左右滾輪上（如上圖所示），之後按下啟動鈕（如上圖所示），機器滑台會作動到鬆緊帶確認位置，之後開始吹氣，使操作者易於放布，當放完布料後（下圖所示）再按下啟動鈕後進行車縫，車縫完後機器會回到初始狀態。

Fill waistband and activate

In auto mode, put waistband on left roller and right roller and then press activation switch, displayed as the drawing. Then, sliding platform will roll the waistband to setup place and start to blow the air. Users can put on cloth easily, displayed as below drawing, and then press activation switch to start sewing. After sewing, machine will be back to original status.

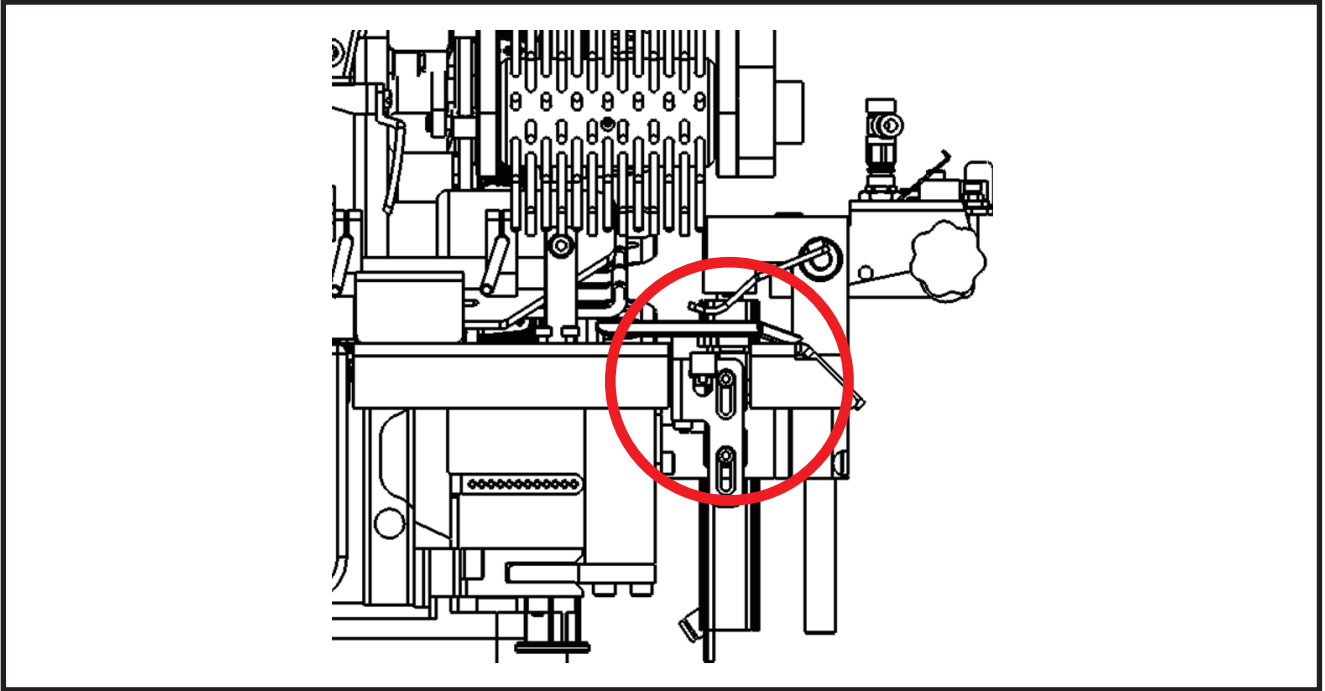


尺寸改變調整

ADJUST THE DIMENSION

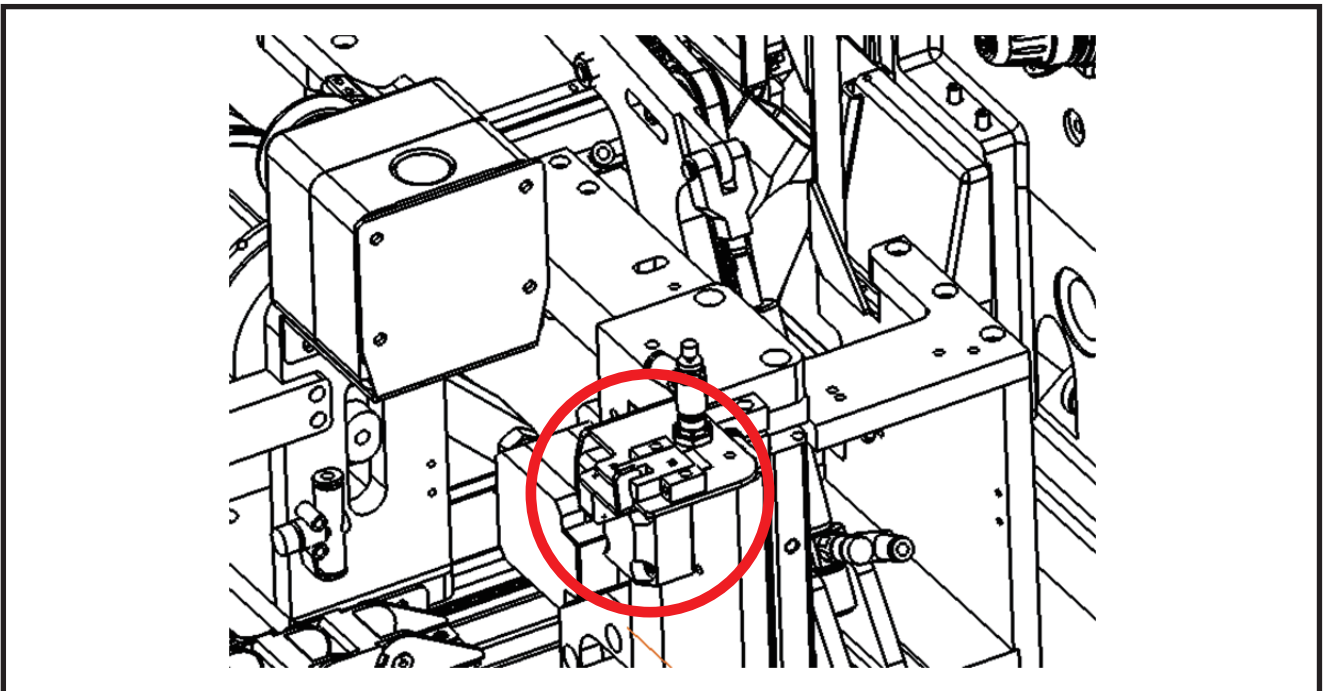
1. 鬆緊帶尺寸改變需調整各部位之擋邊 (下圖圈起處)，鬆開螺絲並調整擋邊位置。

1. To change the dimension of waistband needs to adjust guide block of each part (see the red circle on below drawing). Loosen screws and adjust the position of guide block.



2. 鬆緊帶與布料厚度改變時，過股感應器高度需調整。

2. If the thicknesses of waistband or cloth change, we need to adjust the height of the sensor for cloth connection.



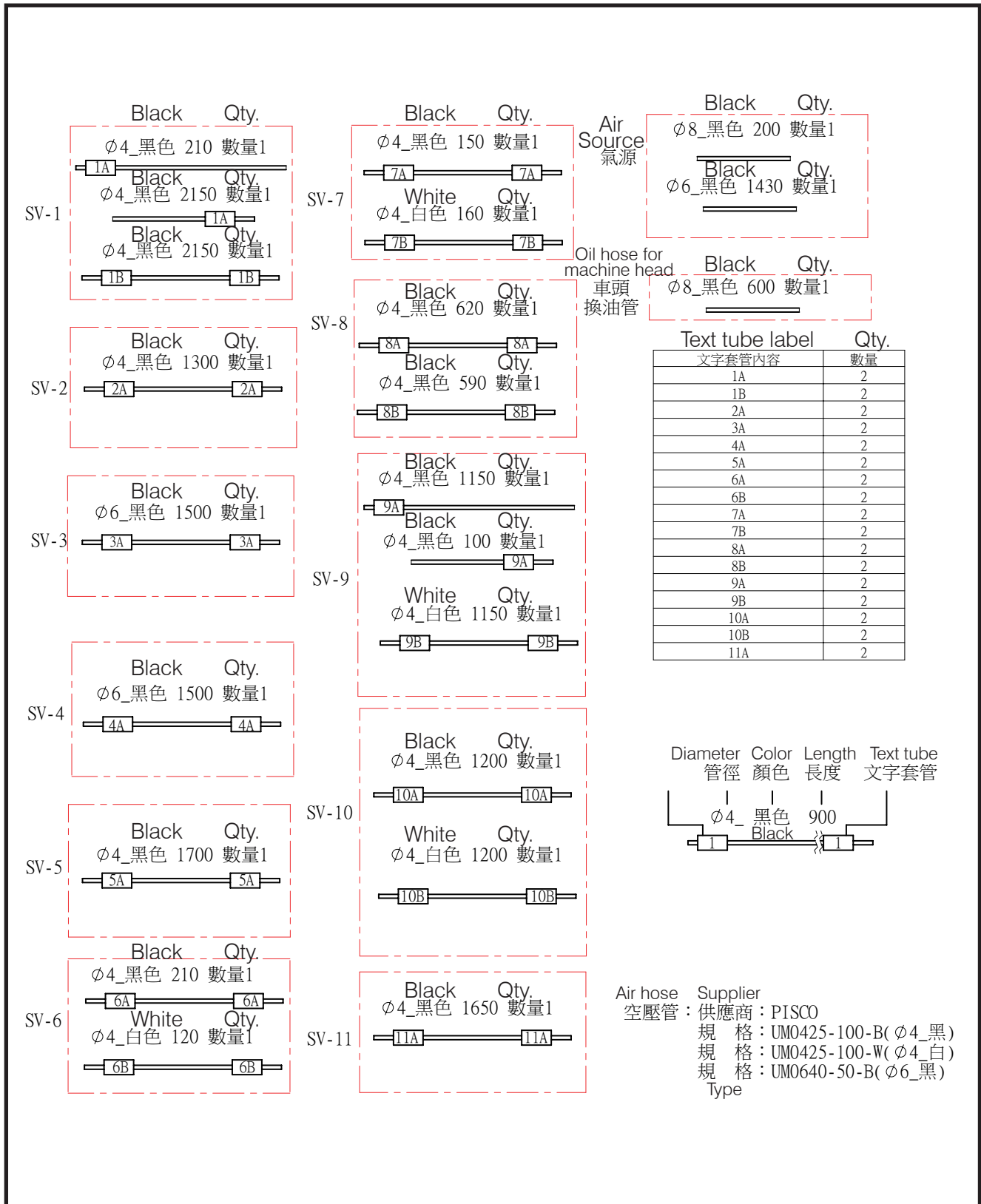
不良現象的原因以及對策

TROUBLESHOOTING

現象 Problem	原因 Reason	對策 Solution
穩布機構捲布 Stabilization structure will roll the cloth.	張力調整不當 Do not adjust tension well.	進入試縫模式重新調整張力 Enter trial sewing to re-adjust the tension.
過股無反應 Sensor does not find cloth connection	過股感應器位置過高 Sensor for cloth connection is on too high position.	調整過股感應器位置 Adjust the position of cloth connection sensor
縫合感應器無反應 No reaction from sewing sensor	1. 張力調整不當造成布料越過感應器 2. 感應器位置錯誤，導致誤判 1. Incorrect tension adjustment cause cloth over the sensor. 2. Incorrect sensor position causes incorrect result.	1. 進入試縫模式重新調整張力 2. 調整感應器位置與角度。 1. Enter trial sewing to readjust tension 2. Adjust the position and angle of sensor

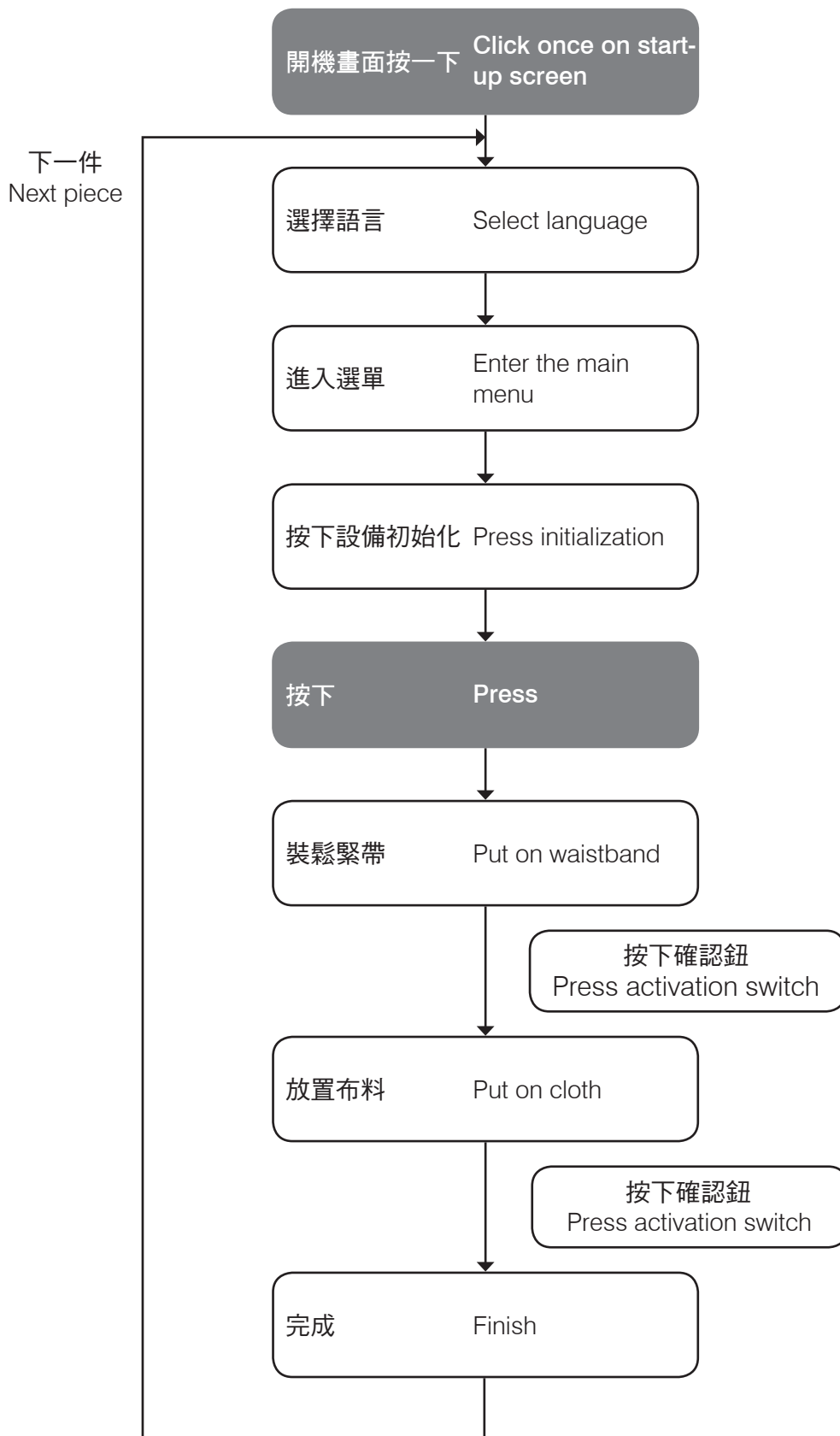
配管圖

PIPING DIAGRAM



動作流程

FLOW CHART



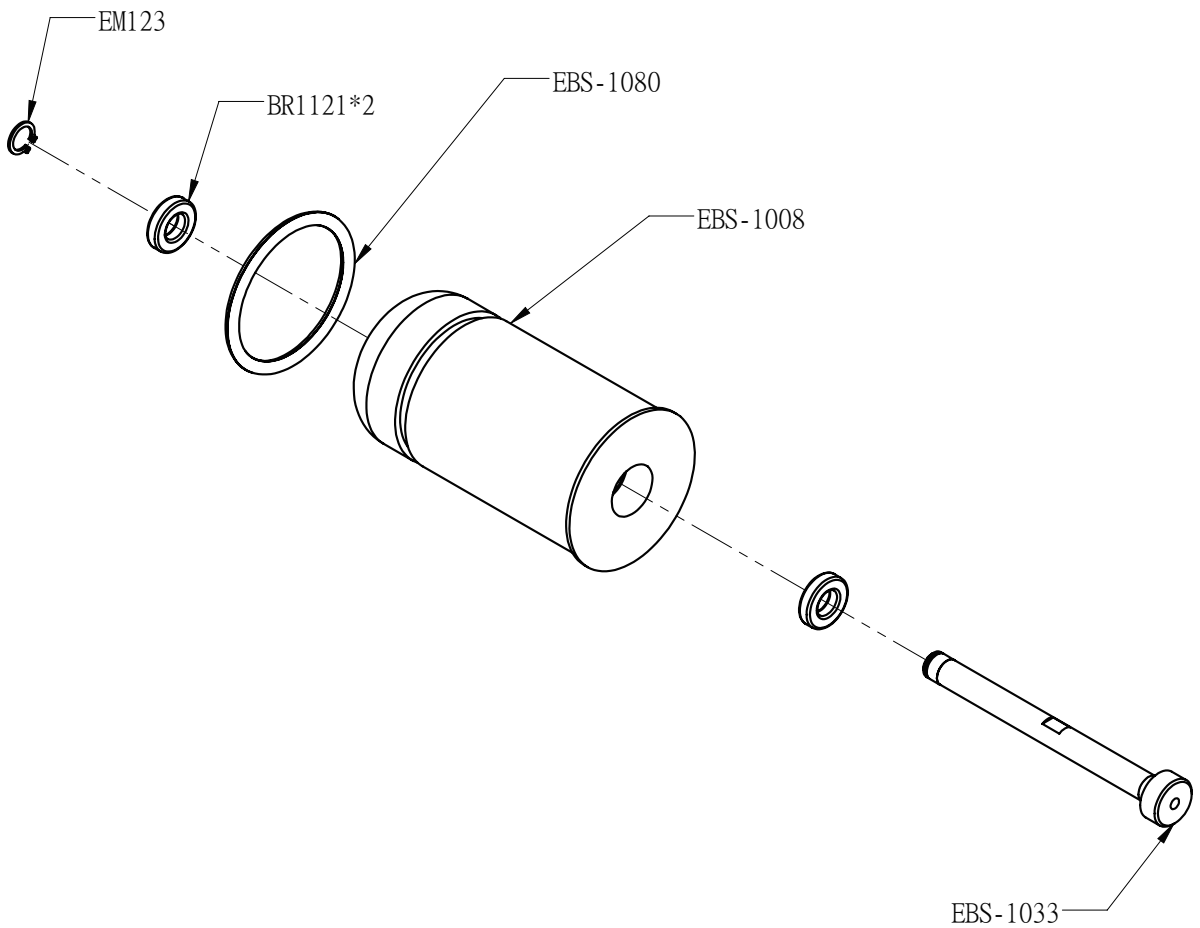
A

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				Date
				2018/03/28

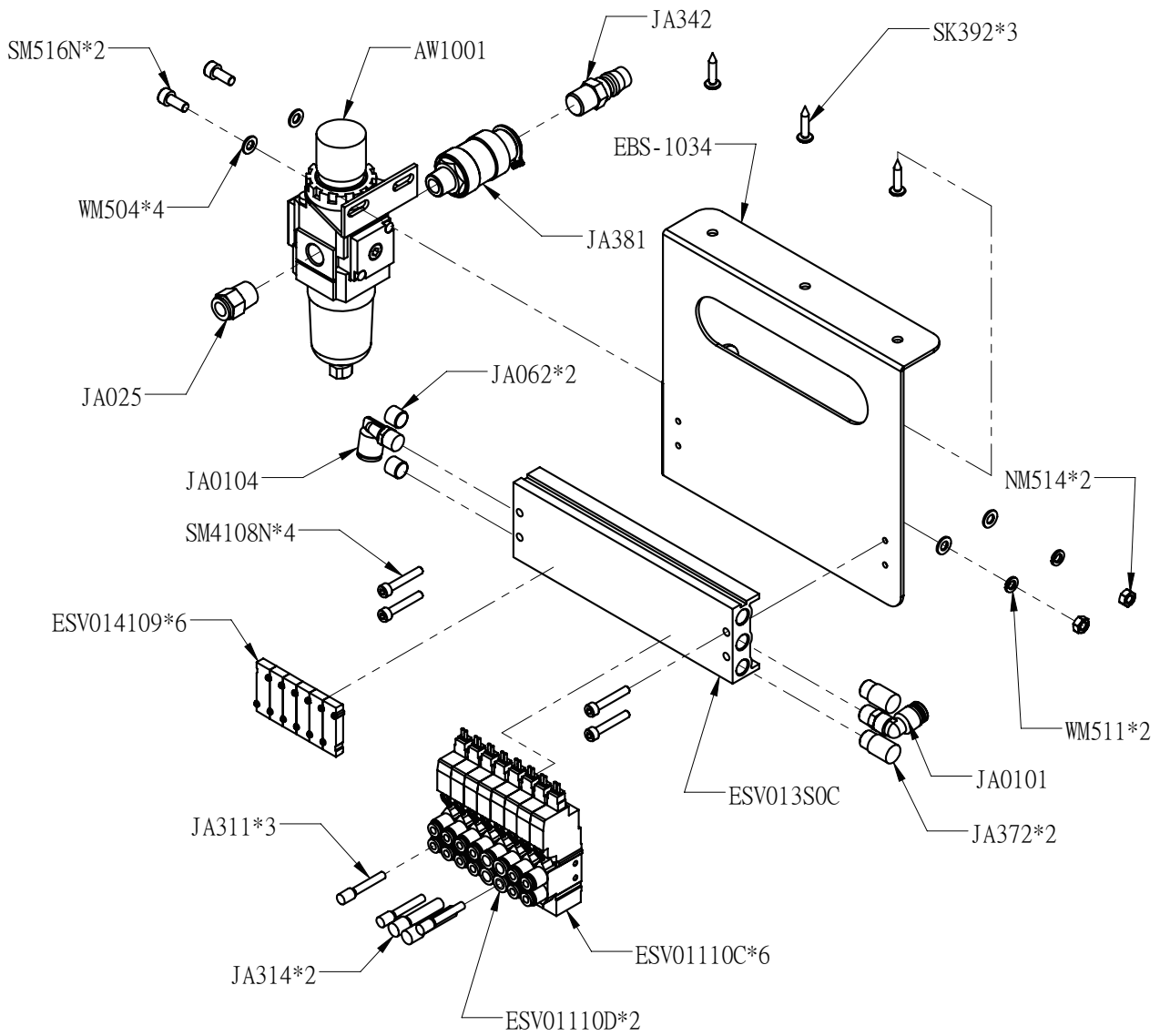
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1

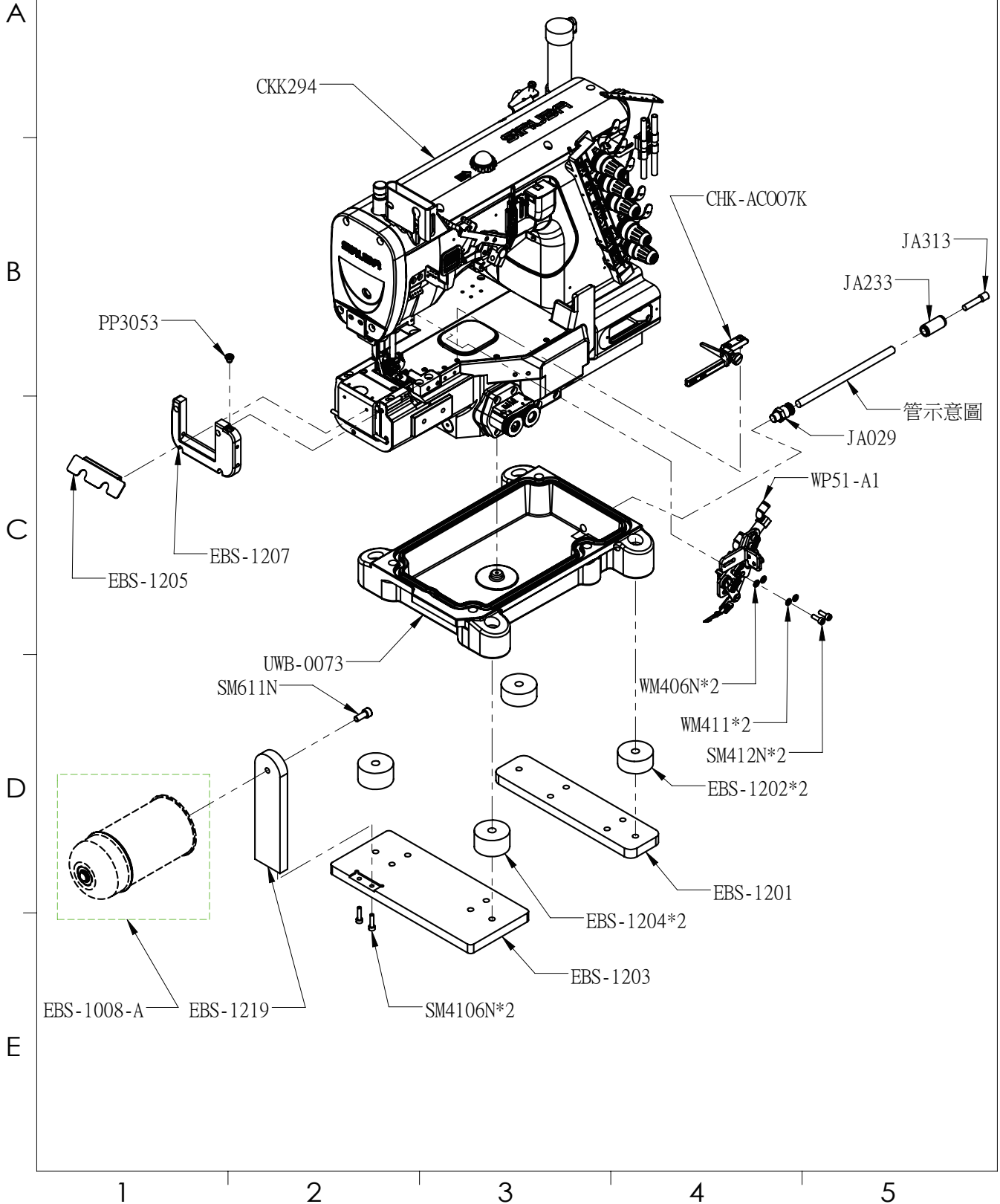
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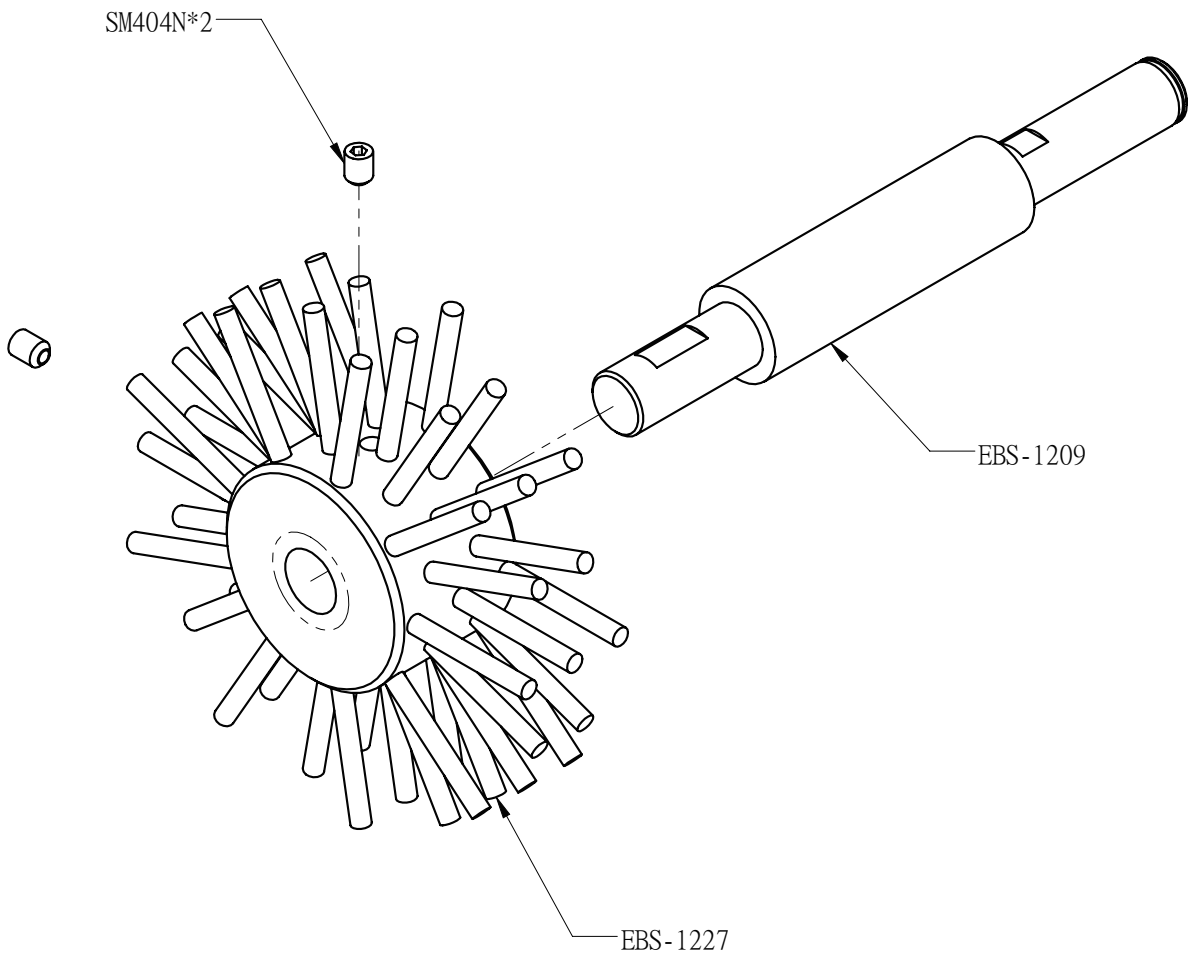
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SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
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				2018/03/27

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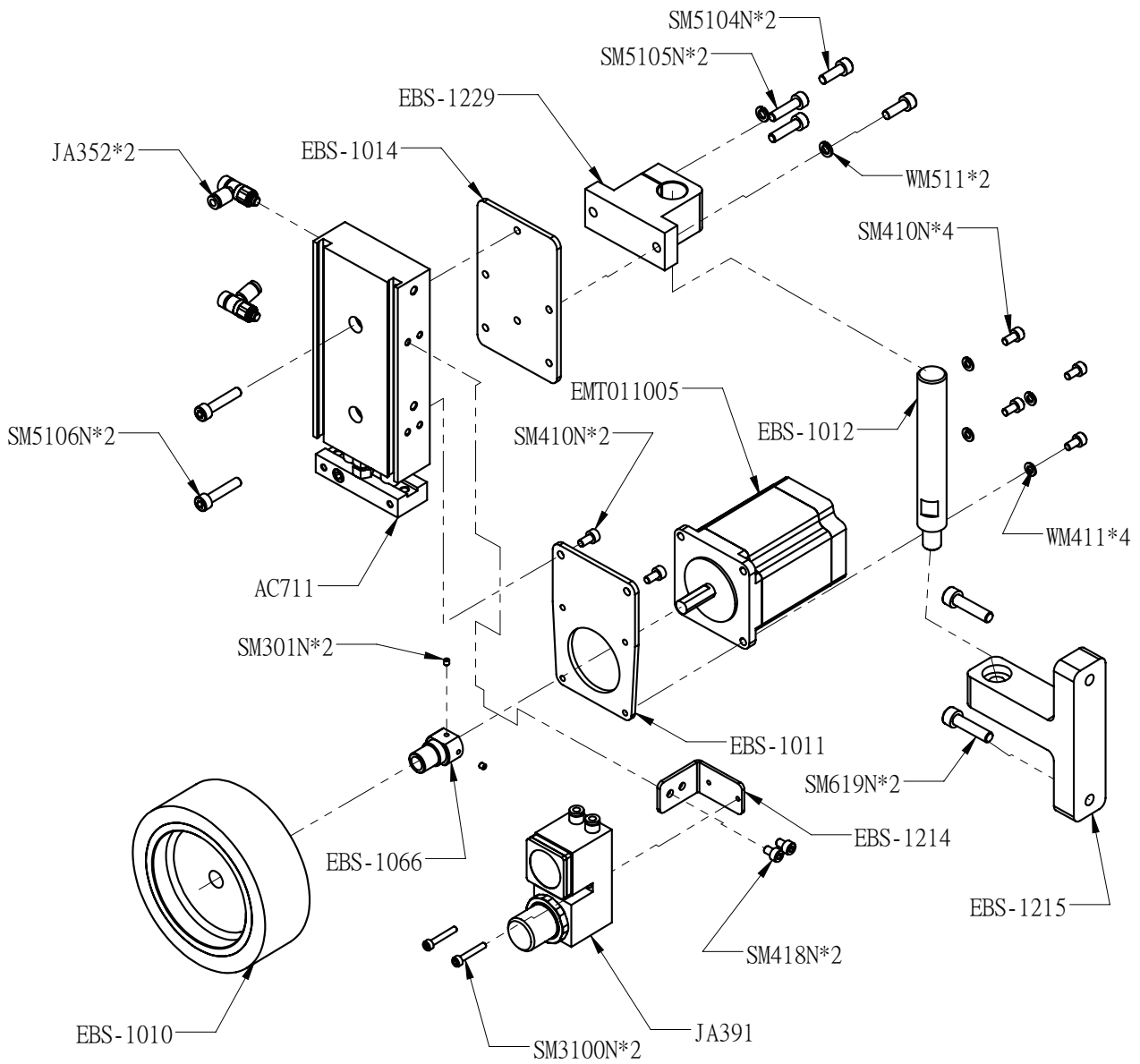
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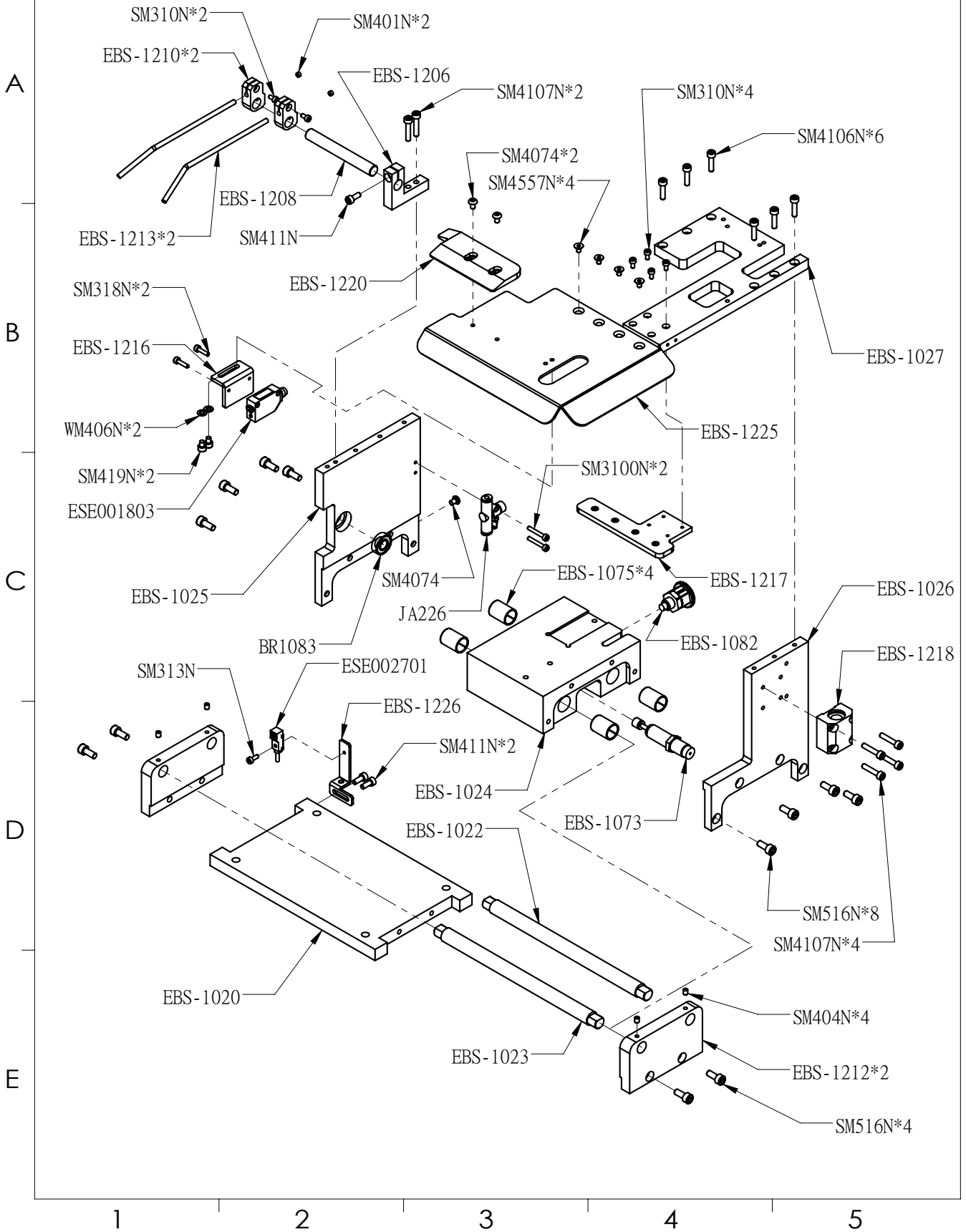
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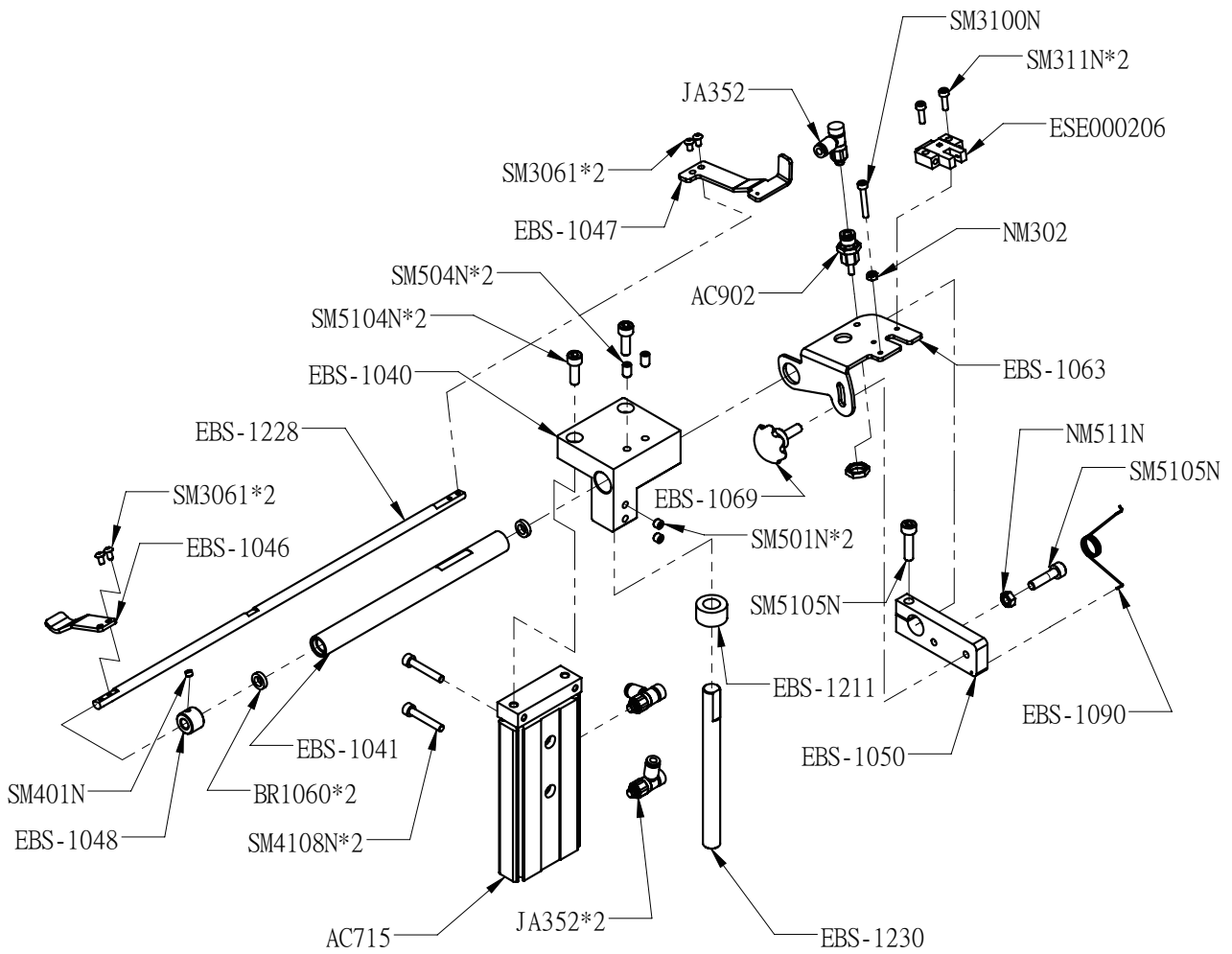
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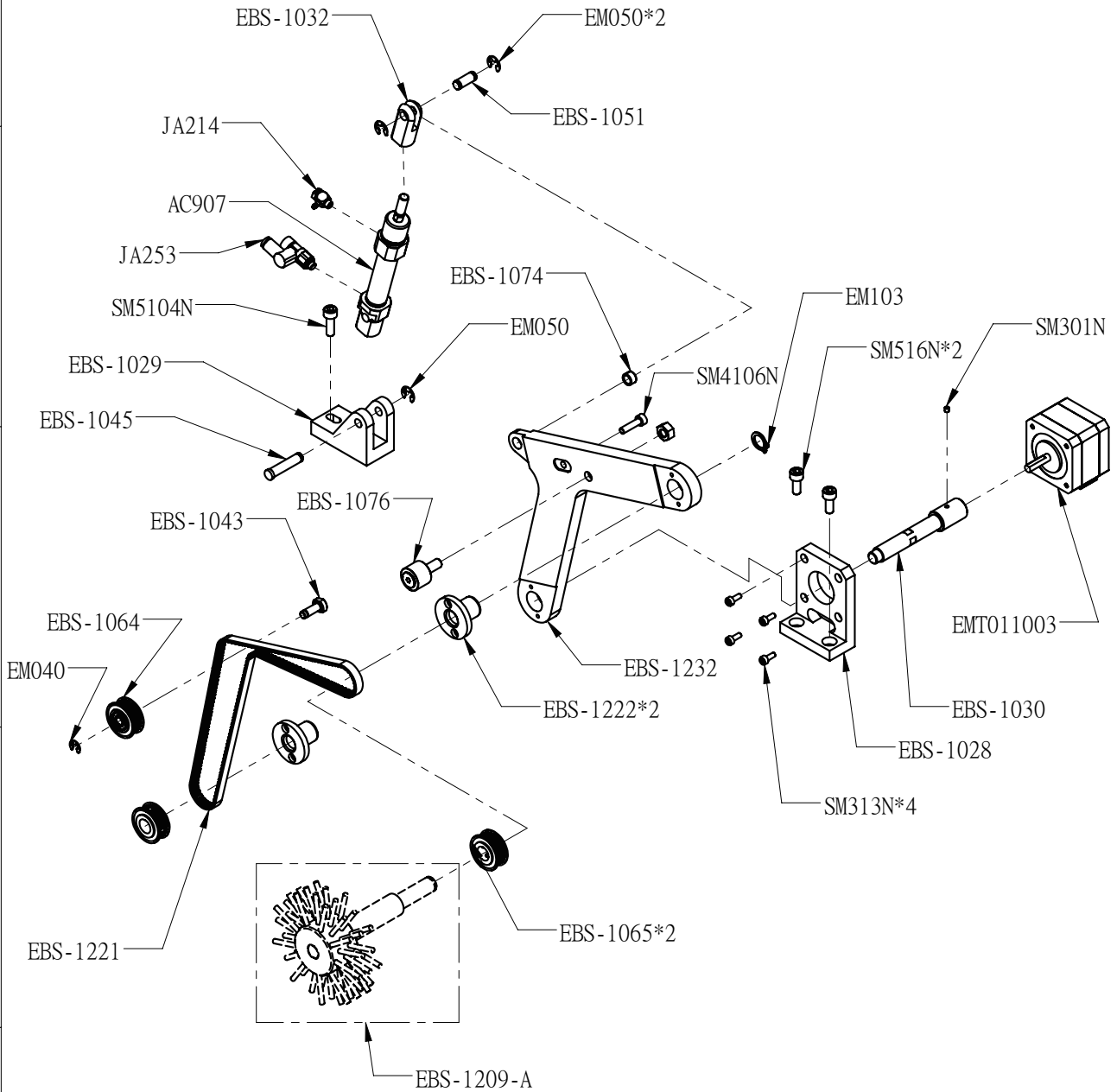
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SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
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				2018/05/17

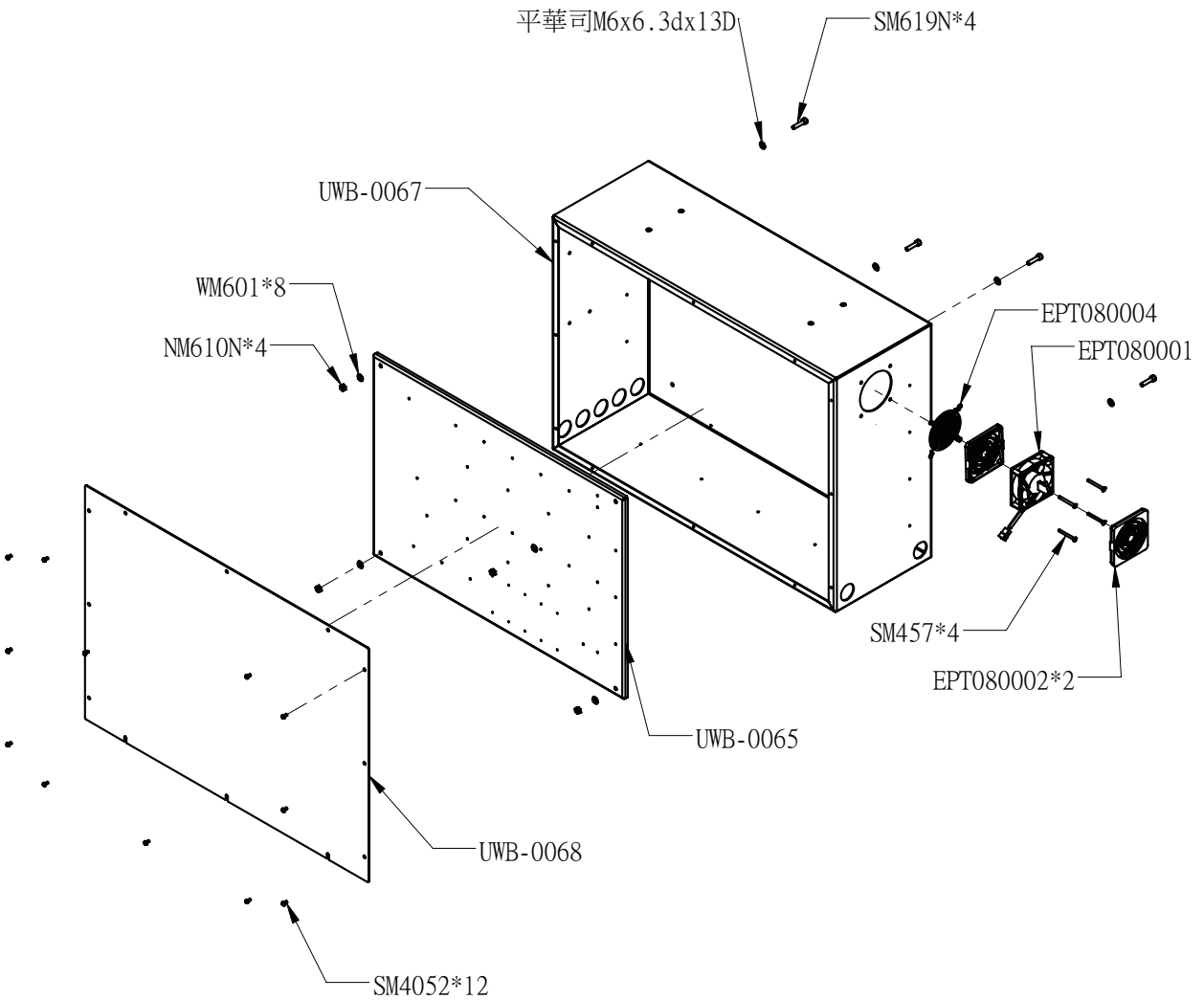
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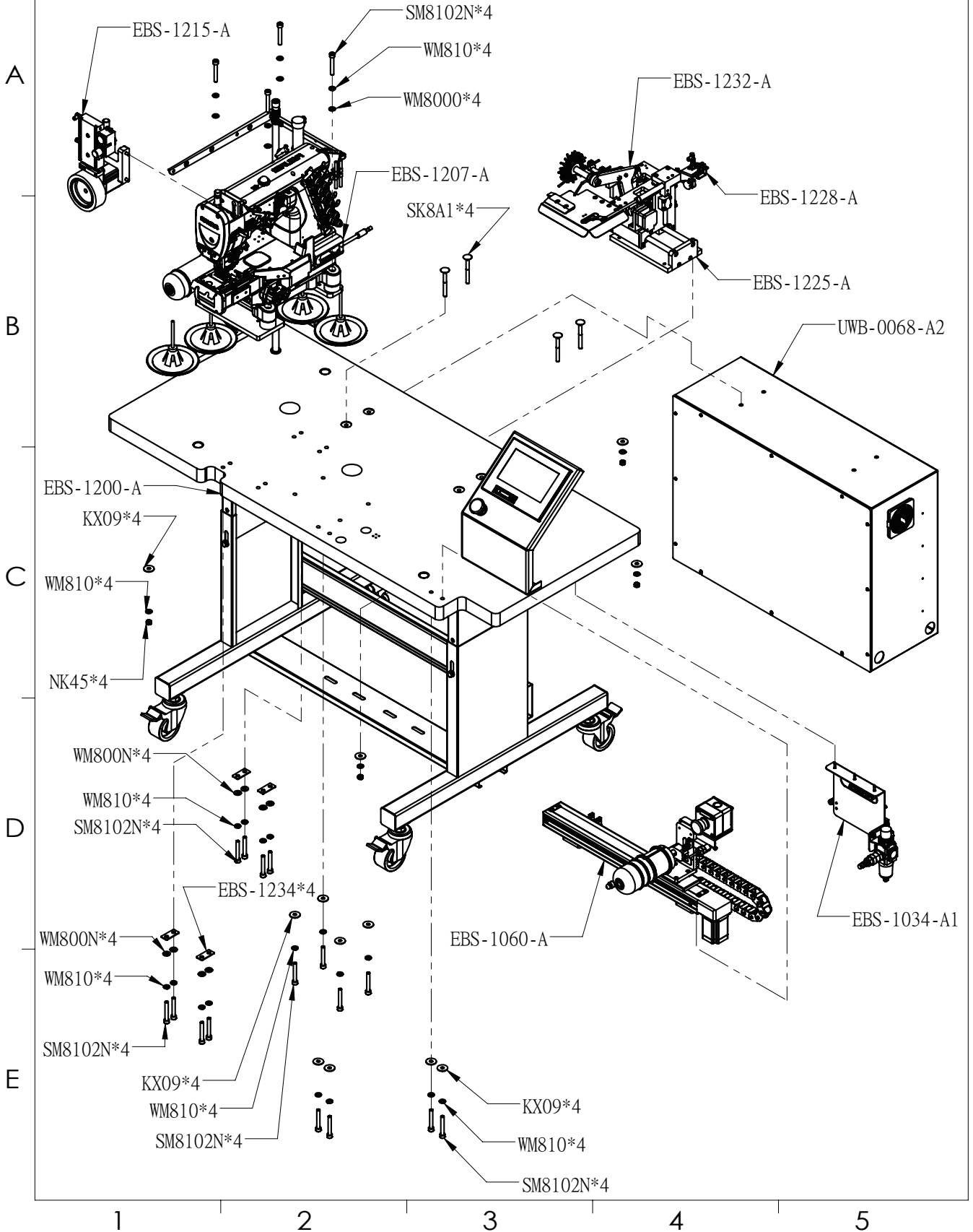
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 高林股份有限公司
KAULIN MFG. CO., LTD.

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The specification and/or appearances of the equipment described in this instruction book & parts list are subject to change because of modification which will without previous notice.
ASC-EBS100.JUN.2018