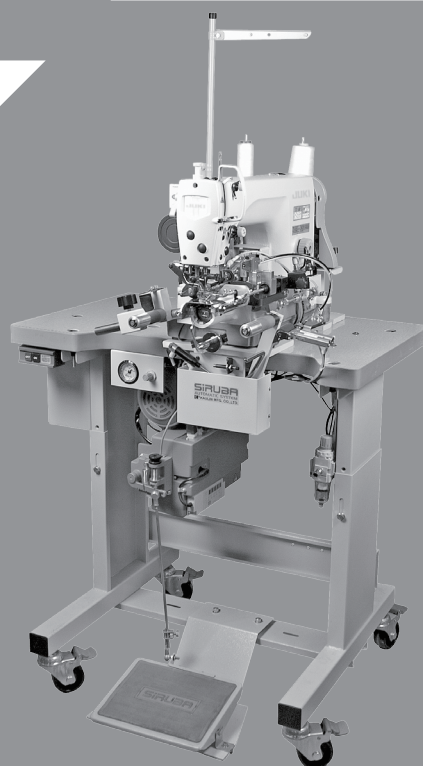


SIRUBA[®] Sew Reach

使用說明書與零件圖

ORIGINAL INSTRUCTIONS BOOK & PARTS LIST

■ **ASL-JBH100**



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 ASL-JBH100，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 ASL-JBH100 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

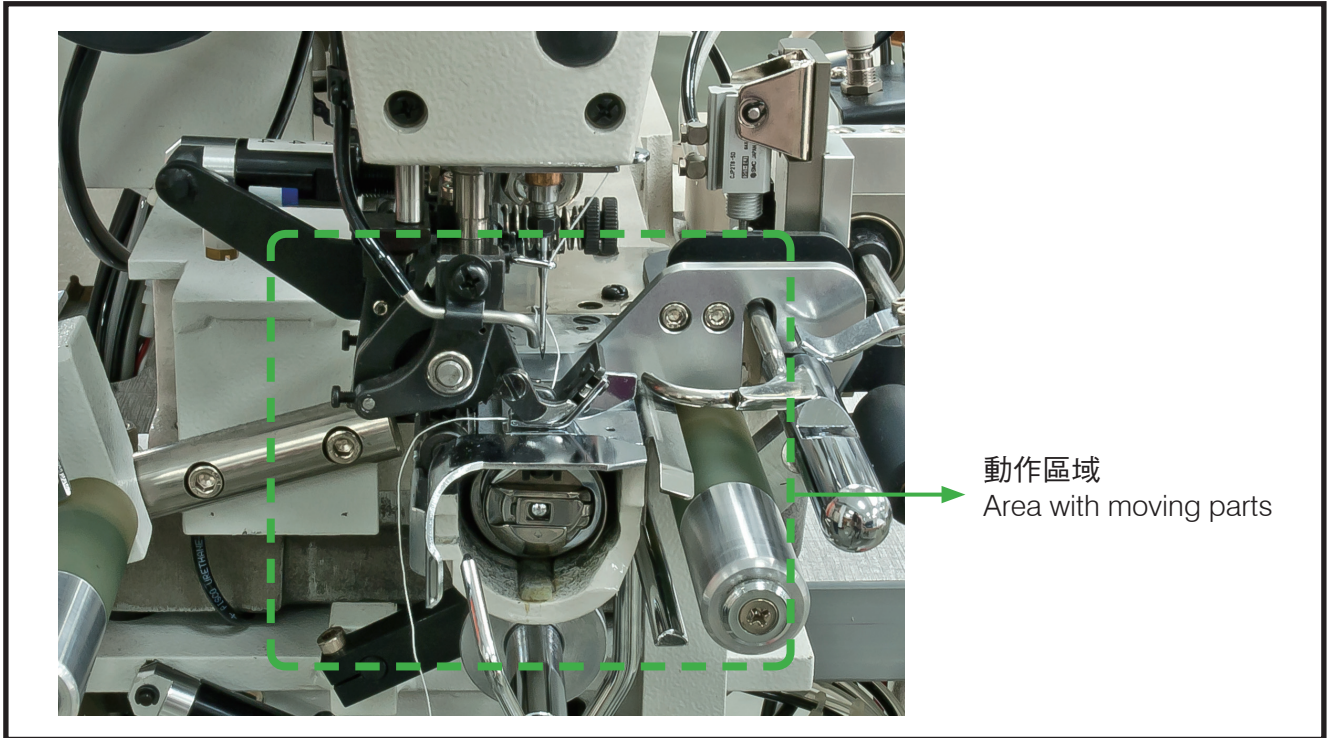
<p>高壓部位 HIGH-VOLTAGE POSITION</p>	 <p>高壓電危險 DANGER</p> <p>注意-請關閉電源10分鐘後始可打開此蓋</p> <p>TO OPEN THIS COVER: TURN OFF POWER SUPPLYING AND WAIT MORE THAN 10 MINUTES BEFORE OPENING.</p>	<p>務必關閉電源 10 分鐘後始打開電控箱蓋子</p> <p>Be sure to turn off the power and wait till 10 minutes before opening the control box's cover.</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。</p> <p>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</p> <p>In case of industrial accident</p>
<p>高速運動部位 HIGH-SPEED MOTION POSITION</p>	 <p>Be careful of its movement.</p> <p>移動快速 敬請小心</p>	<p>謹防工傷事故</p> <p>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</p> <p>In case of industrial accident</p>

安全注意事項

SAFETY INSTRUCTIONS

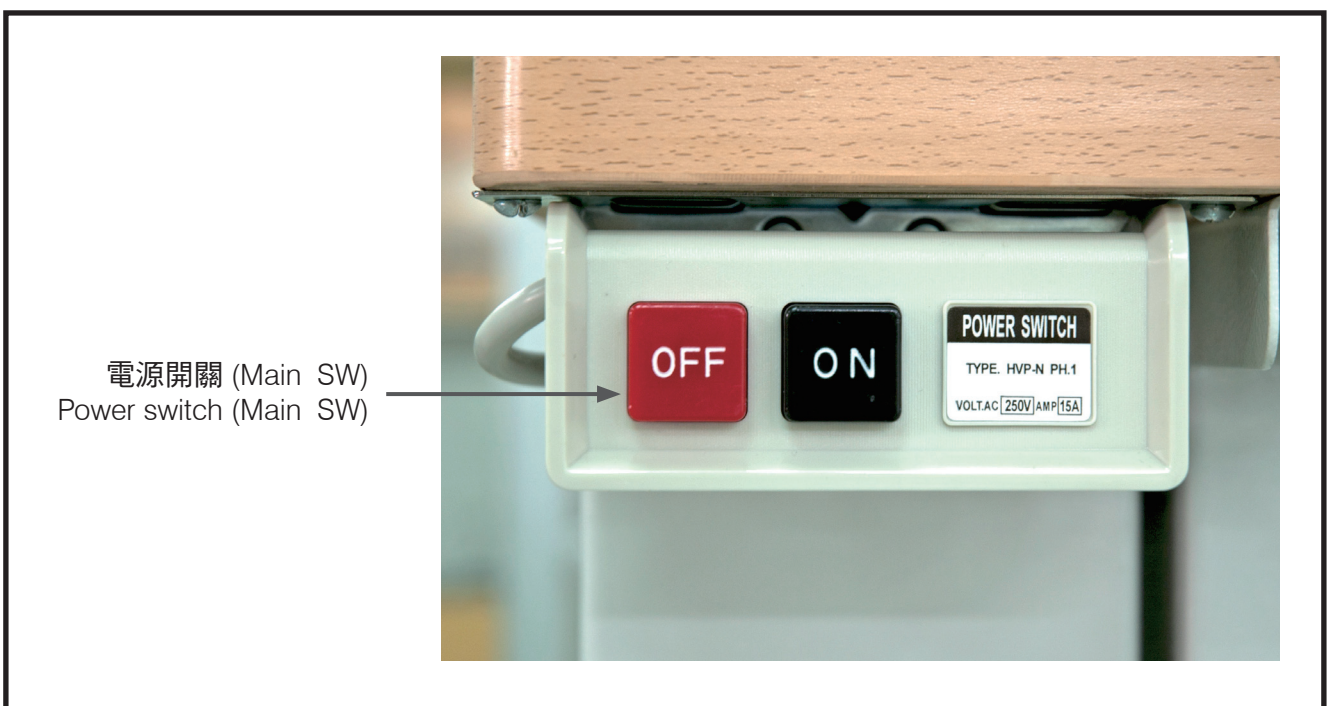
1. 在機器運行過程中，請勿進入動作區域內。

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



2. 定期檢查時，打開蓋子後，應務必將電源開關設置為 OFF。

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



3. 在有對人體有危害的高壓電極的地方都貼了危險警告的標籤。在對貼著此標籤的控制部進行保養、定期檢查時，應由專門的電氣技術人員操作。

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.



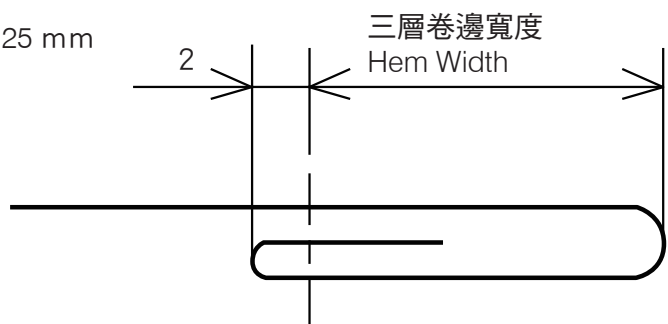
4. 在機器運行中，需要突然中止運行的情況時，按緊急停止鍵中止機器。
5. 安全起見，未插電源的地線的情況下，請勿運行機器。
6. 有雷電的天氣。安全起見，請拔出電源插頭。
7. 離開機器操作區時、作業完成後等，請務必將關閉電源。
8. 在需要打開蓋子類的部件處於未合蓋子的狀態下請勿運行機器。

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. For safety do not operate the machine when it is not earthed.
6. When there is lightning, stop the machine and pull out the plug for safety.
7. Turn off the power switch when you are not near the machine or after the operation is finished.
8. Do not operate the machine with the covers off.

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規格

SPECIFICATION

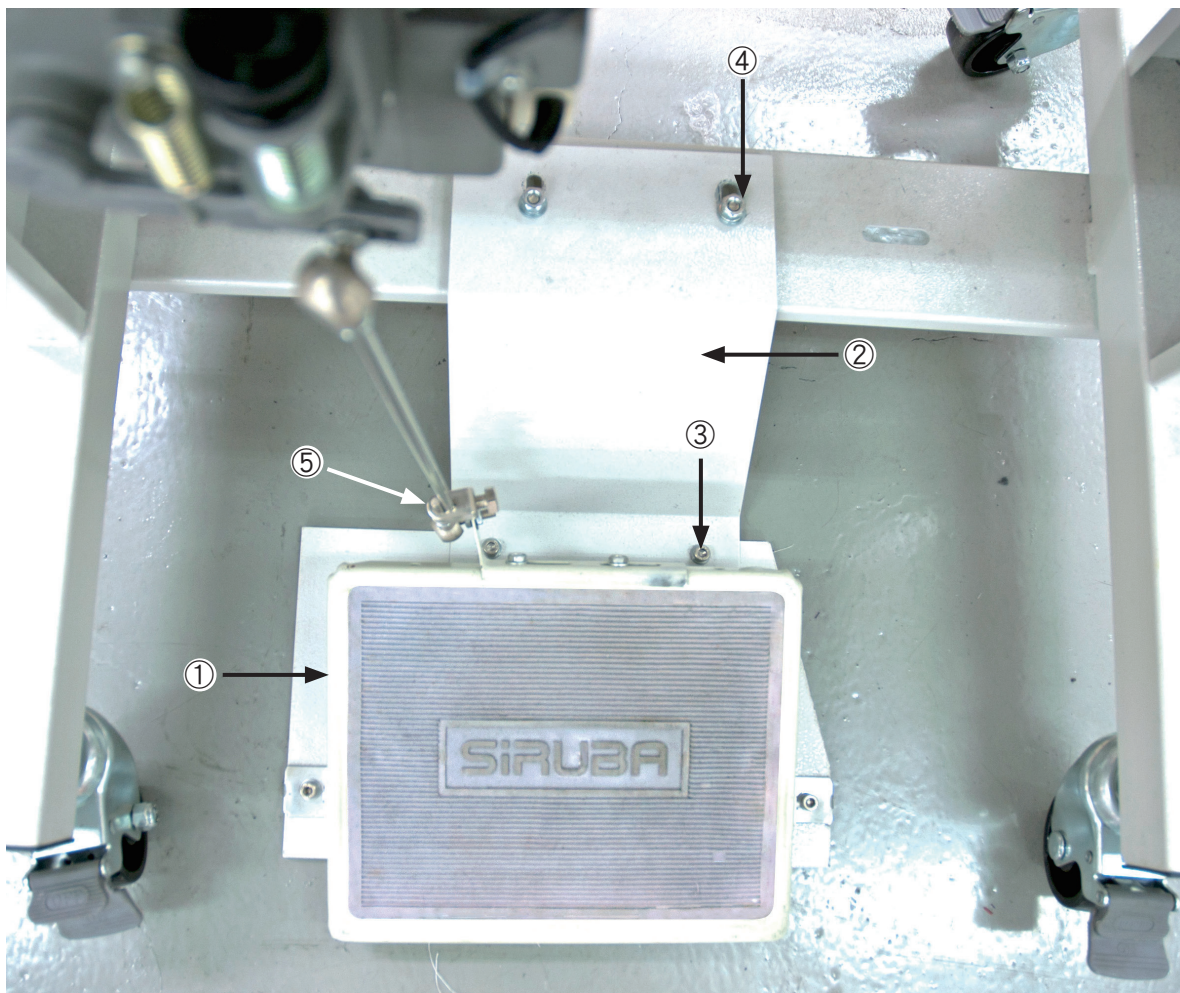
型號 Model	ASL-JBH100
縫紉機機頭 Machine Head	JUKI DLN-6390-7
使用針型 Needle	UY180GVS SERV7 Nm140
縫製速度 Sewing Speed	最高 4000rpm (根據腳踏板的踩踏程度可變) Max. 4000rpm (Changing according to the treadle speed.)
電 源 Voltage	單相 200、220、230、240 V 50/60 Hz / 3相 380 V 50/60Hz (因出貨目的地以及產品型號而變化) single-phase 200、220、230、240 V 50/60 Hz / three-phase 380 V 50/60Hz (Changes according to the model and output destination.)
氣 壓 Air Pressure	0.5 MPa
機器尺寸 Dimensions	寬 750× 深度 670× 高 1300 mm (安裝線軸架後 1700 mm) 750(W)×670(D)×1300(H) mm (1700mm when cotton stand is attached)
縫紉針距 Stitch Length	2.8 mm (根據齒輪可更改為 2.3 mm、3.2 mm、3.6 mm) 選項 2.1 mm、2.5 mm、4.2 mm 2.8 mm (2.3mm、3.2mm、3.6mm are also available by changing gear) Option 2.1 mm、2.5 mm、4.2 mm
下擺內裡尺寸 Trousers Bottom Size	280 ~ 600 mm (下擺寬 140 ~ 300 mm) 280 ~ 600 mm (Bottom Width 140 ~ 300 mm)
三層卷邊寬度 Hem Width	15 ~ 25 mm  <p>The diagram illustrates a three-layer hem. It shows a horizontal line representing the fabric edge. A vertical line is drawn 2 mm from the edge, and another vertical line is drawn further out, defining the 'Hem Width'. A horizontal line is drawn between these two vertical lines, representing the hemmed edge. The distance between the two vertical lines is labeled '三層卷邊寬度 Hem Width'. The distance from the fabric edge to the first vertical line is labeled '2'.</p>
縫紉開始 Sewing Start Position	根據接頭檢測器自動決定位置 Automatic positioning by Splicing Detector
縫紉結束 Sewing End	腳踏板操作 Treadle operation

安裝

INSTALLATION

- 安裝腳踏板：
 - (1) 將腳踏板底座①安裝至連接板②上。
(螺絲③)
 - (2) 將連接板②安裝至桌子橫桿上。(螺絲④)
 - (3) 安裝聯動棒⑤。

- Install treadle :
 - (1) Install the treadle base ① to the connector plate ② . (screw ③)
 - (2) Install connector ② to the cross bar between the machine legs. (screw ④)
 - (3) Attach the connecting rod ⑤ to the treadle.

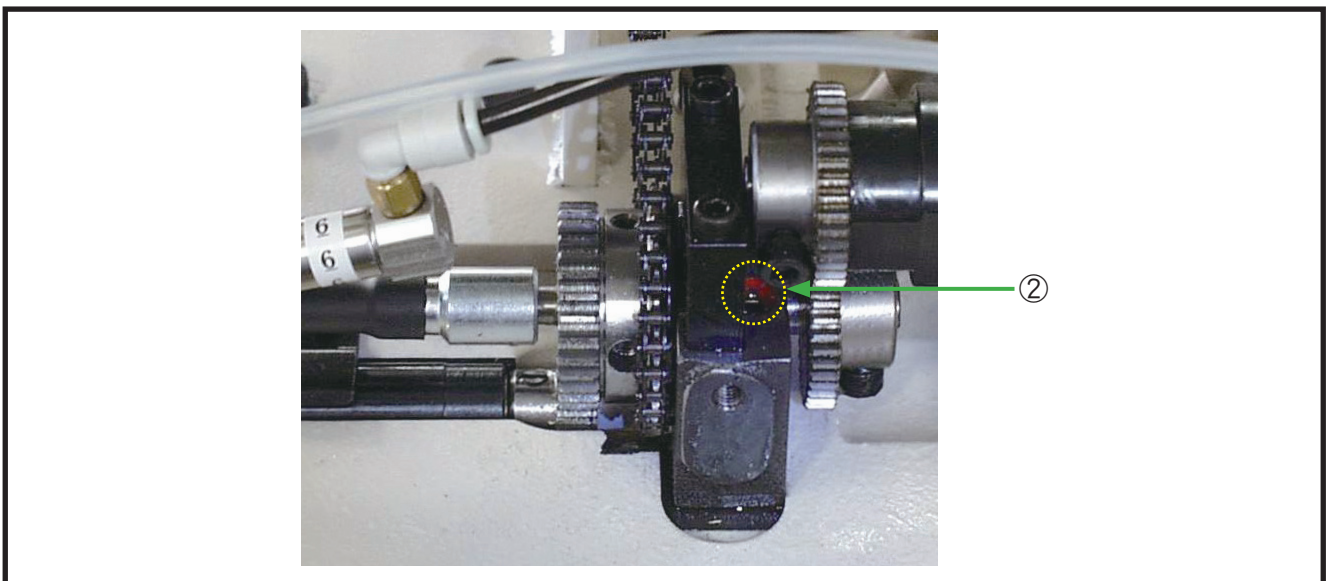
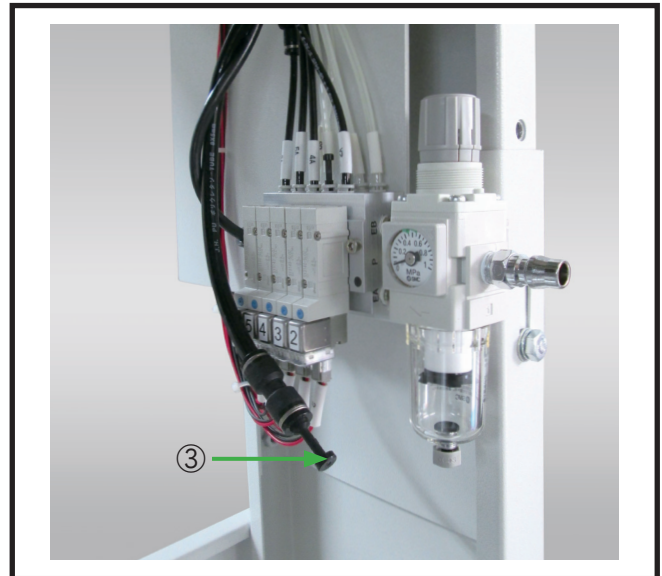
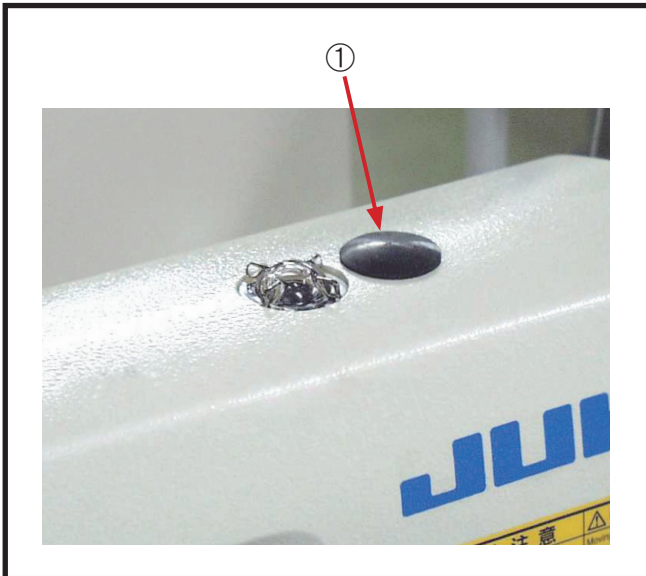


運行準備

1. 電源電壓：
 - (1) 應在定壓電壓的 $\pm 10\%$ 下使用。
 - (2) 地線必須接地。
2. 空氣壓：
 - (1) 在 0.5Mpa 的空氣壓下使用。
3. 給油：
 - (1) 按照 DLN-6390-7 使用說明書給縫紉機機頭上臂①給油。（交換油時將插頭③拔出）
 - (2) 紅色印記部位②需要定期給油。

PREPARATION

1. Voltage：
 - (1) Operate $\pm 10\%$ of the rated voltage.
 - (2) Be sure to connect the earth wire being grounding.
2. Air Pressure：
 - (1) Set to 0.5 MPa
3. Lubrication：
 - (1) Lubricate the sewing machine upper arm ① according to the instruction manual for DLN-6390-7. (Remove the plug ③ to discharge the oil for refilling.)
 - (2) Oil the spot where marked in red ② periodically.

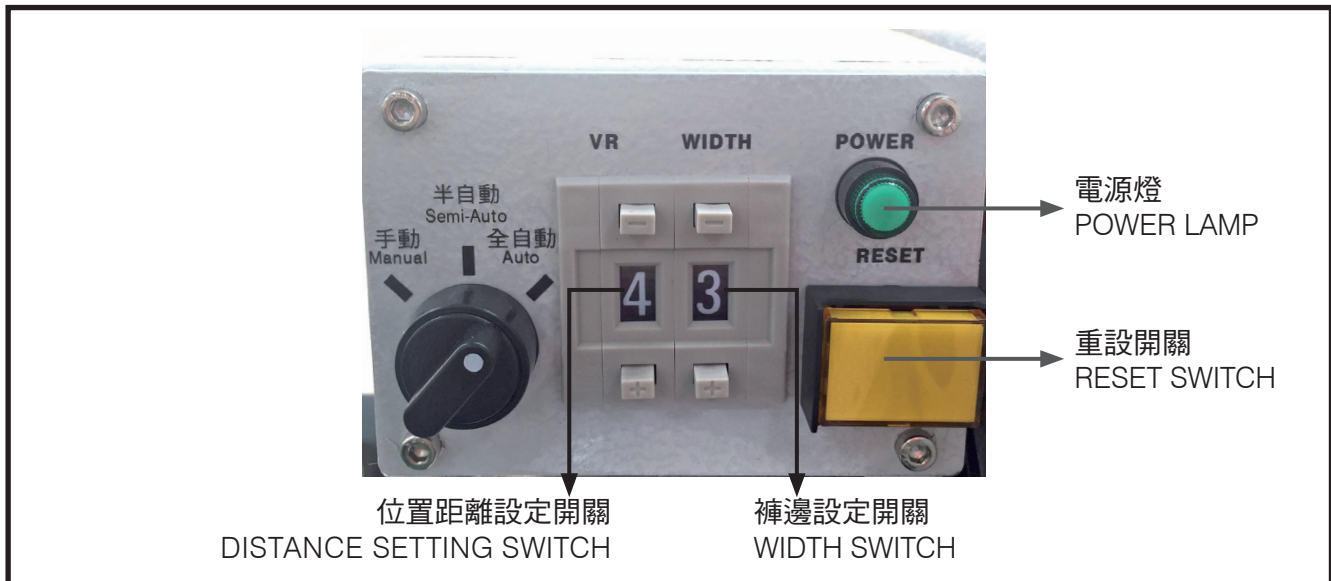


操作開關

OPERATIONAL SWITCHES

1. 操作面板說明：

1. Illustration of operational panel :



名稱 Names	功能 Functions
電源燈 POWER lamp[POWER]	<ul style="list-style-type: none"> • 打開電源開關，電源燈亮燈。 • Light up if power switch on.
位置距離設定 Distance setting switch [VR]	<ul style="list-style-type: none"> • 起縫點位置設定。※1 • Start sewing point position setting. ※1
褲邊寬度設定 WIDTH switch [WIDTH]	<ul style="list-style-type: none"> • 「1~9」：根據褲邊寬度 1~9 的設定。※2 • 「0」：縫紉機單獨運行模式。※3 • 「1~9」：Set 1-9 according to bottom width.※2 • 「0」：Sewing machine isolated operation mode.※3
重設開關 RESET switch [RESET]	<ul style="list-style-type: none"> • 未踩腳踏板前：穿過上線，交換底線的時候按此鍵。按第二次時回到原處。 • 空轉前：重新進行褲邊設定時按此鍵。 • 按此鍵的同時同時打開電源開關：進入接頭檢測模式和三層卷邊器調整模式。（參考 P.9、P.10） • Before stepping the treadle : Thread through the upper thread, and press the switch as the bobbin thread is replaced. Press again to release it. • Before feeding idle : Press when redoing bottom setting. • Press reset switch and power switch on simultaneously : Enter to splicing detector and hemmer adjustment mode. (See P.9、P.10)

※ 1 : 參考如下頁 2。

※ 2 : 參考如下頁 3。

※ 3 : 不執行接頭檢測和三層卷邊的動作。

※ 1 : Refer to page 5, 2。

※ 2 : Refer to page 5, 3。

※ 3 : Do not operate the splicing detector and the hemmer.

2. 位置距離設定開關 (VR) 的設定：

2. Distance setting switch (VR)：

位置距離 (mm) Distance (mm)	VR <small>起縫點 Start sewing point</small> - 0 +	位置距離 (mm) Distance (mm)	VR <small>起縫點 Start sewing point</small> - 0 +
-8 ~ -7	1	5 ~ 6	6
-5 ~ -4	2	8 ~ 9	7
-3 ~ -2	3	10 ~ 11	8
-1 ~ 0	4	13 ~ 14	9
2 ~ 3	5		

3. 褲邊寬度設定開關 (WIDTH) 的設定：

3. Setting of bottom width setting switch (WIDTH)：

褲邊寬度 (mm) Bottom width (mm)	WIDTH	褲邊寬度 (mm) Bottom width (mm)	WIDTH
140 ~ 150	2	220 ~ 240	6
150 ~ 170	3	240 ~ 260	7
170 ~ 190	4	260 ~ 280	8
190 ~ 220	5	280 ~ 300	9

【參考】

- WIDTH 的設定是為了保證從縫紉開始到縫紉結束的過程中，可跳過接頭而必須有的設定。只要不是遠遠超出表所示的設定值，機器的運行動作都沒有太大問題。
- 如果在中間的接頭處三層卷邊器滑掉的情況下，加大設定值。
- 另外，如果在最後的介面前，卷邊器拔不出來的情況下，將設定值減小。

【Reference】

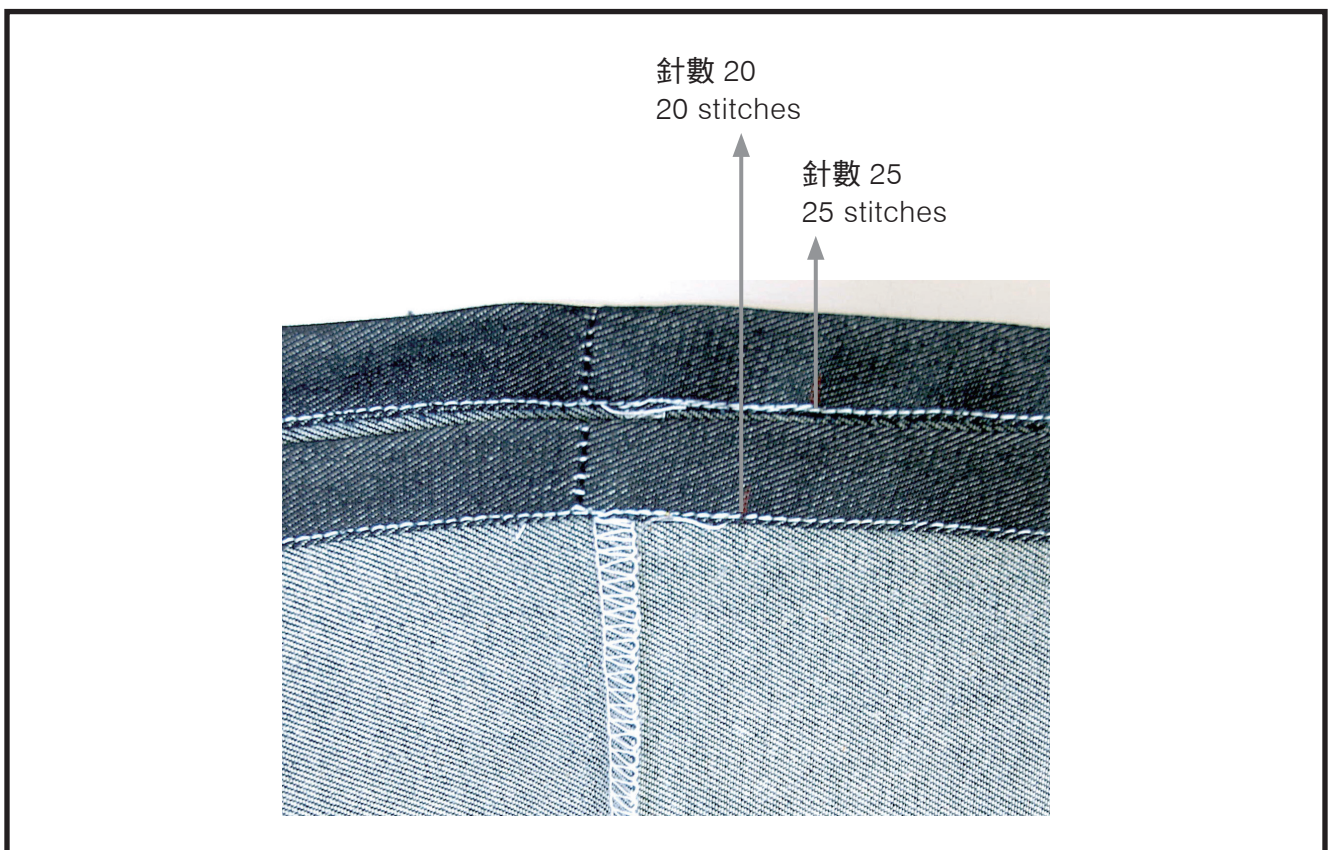
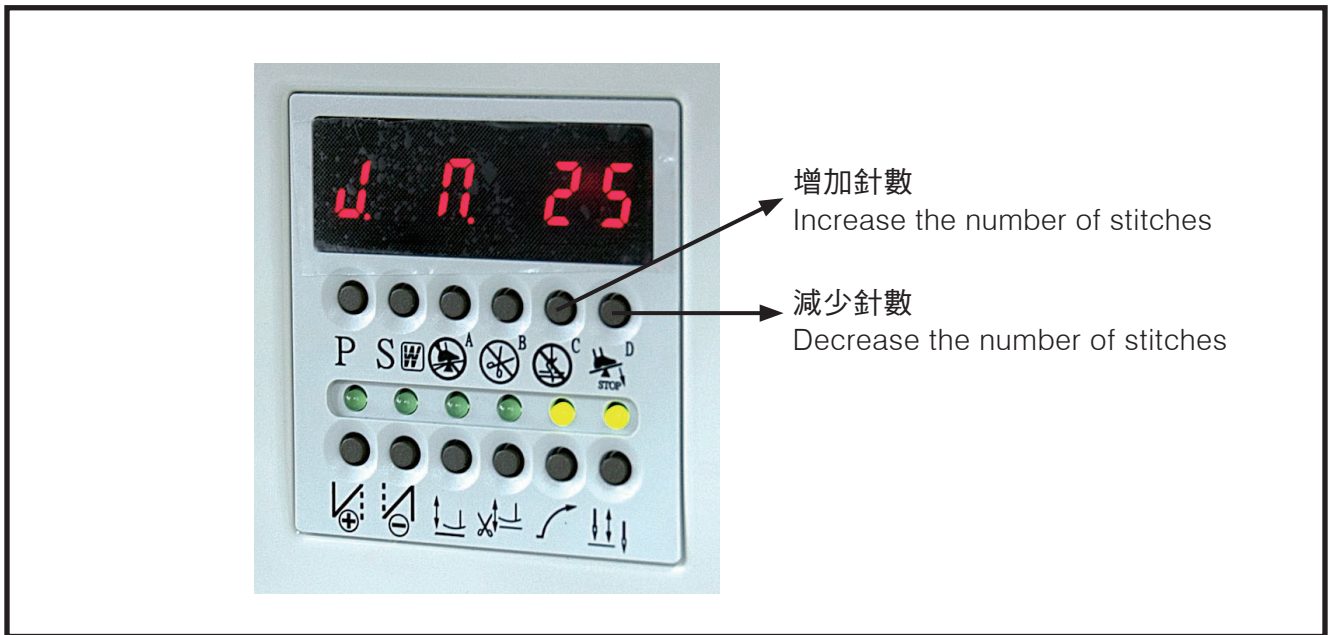
- Setting a set value by WIDTH switch is necessary for the machine to skip splicing between the starting position and the last splicing. Unless the selected set value is completely wrong, the machine will work properly.
- In case the hemmer goes back to its original position when it comes to a splicing in the middle, select a larger set value.
- In case the hemmer doesn't go back to its original position when it comes just before the last splicing, select a smaller set value.

4. 搭縫線跡調整：

建議針數 20~25 針。

4. Adjust the number of covering stitches:

Recommendation is 20 ~ 25 number of stitches.

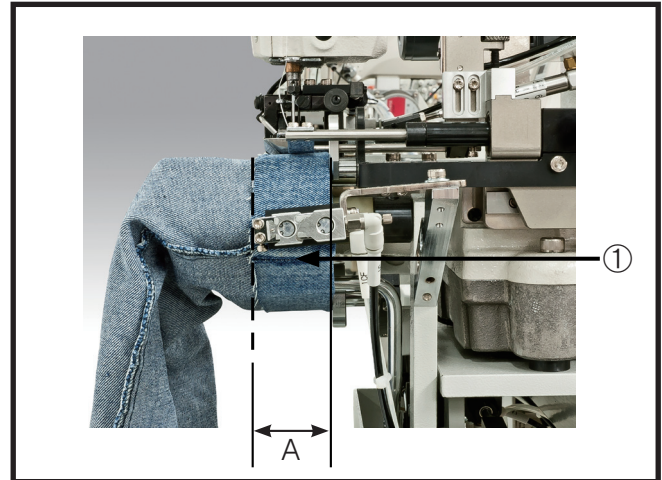


褲邊的設置方法

METHOD OF SETTING BOTTOM CLOTH

- 將褲邊摺 2 次，從開始縫紉的一側的接頭①到右側這樣的方式設置布料。
- 摺 2 次的尺寸 A 請參考下表。

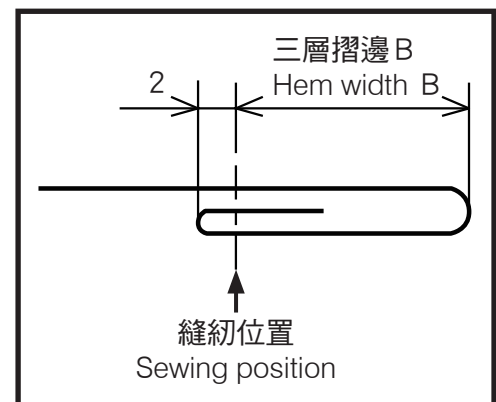
- Folded the bottom cloth twice, set the bottom cloth from starting position splicing side① to the right side.
- Refer to the width of folded twice A table below.



- 摺 2 次的參考尺寸：

- Reference width of folded twice：

三層摺邊尺寸 B (mm) Hem width B (mm)	兩次摺邊尺寸 A (mm) Width of folded twice A (mm)
15	27 ~ 32
20	32 ~ 37
25	37 ~ 42



褲邊張力的調整

ADJUSTING BOTTOM CLOTH TENSION

- 通過旋鈕①來調整。拔出旋鈕①後，沿順時針方向旋轉後壓力升高。調整後，將旋鈕①插回並鎖好。
- 標準壓力為 0.1~0.2MPa。(薄布料~中厚布料) 薄布料，具有伸縮性的布料：下調壓力。厚布料：上調壓力。

- Use knob ① to adjust. Pull the knob ① out, and turn it clockwise to raise pressure. After adjustment, put the knob ① back and lock it.
- Standard pressure is 0.1~0.2MPa. (Thin ~middle-thick fabric) Thin and elastic fabric : lower pressure. Thick fabric : raise pressure.



褲邊寬度變化零件的調整

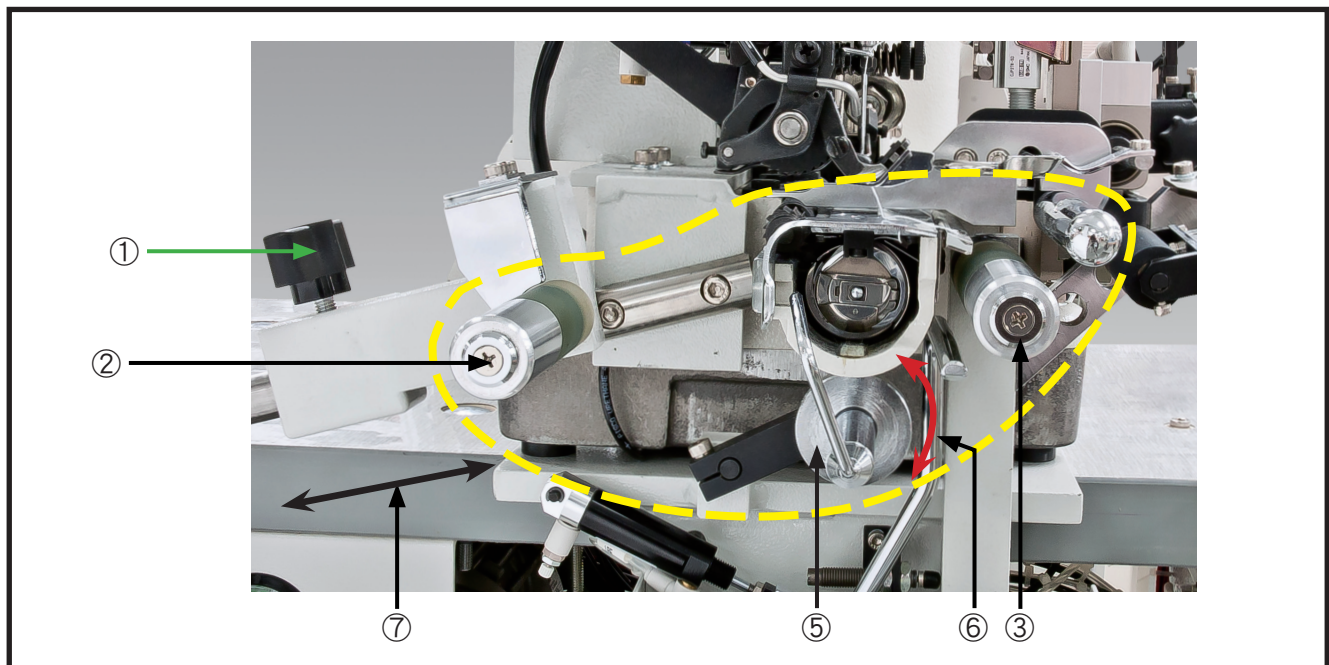
ADJUSTING PARTS ACCORDING TO BOTTOM CLOTH WIDTH

1. 褲邊寬度 200 ~ 300 mm

- (1) 將前引導滾輪⑤沿著箭頭方向⑥移動調整。
- (2) 鬆開調整把手①，將後引導滾輪②沿著箭頭方向⑦移動調整。
- (3) 在撐開褲邊的動作中，撐褲邊滾輪開關處於 ON 的狀態，撐褲邊滾輪③回到原處，後引導滾輪②向左移動。

1. Bottom cloth width 200~300m m

- (1) Move front guide roller ⑤ to the arrow direction ⑥ to adjust.
- (2) Loosen adjusting handle ①, and let rear guide roller ② move to arrow direction ⑦ to adjust.
- (3) During the motion of holding the bottom cloth open, the bottom tension roller switch ③ goes back to its original position while it is in operation, move rear roller ② to left.

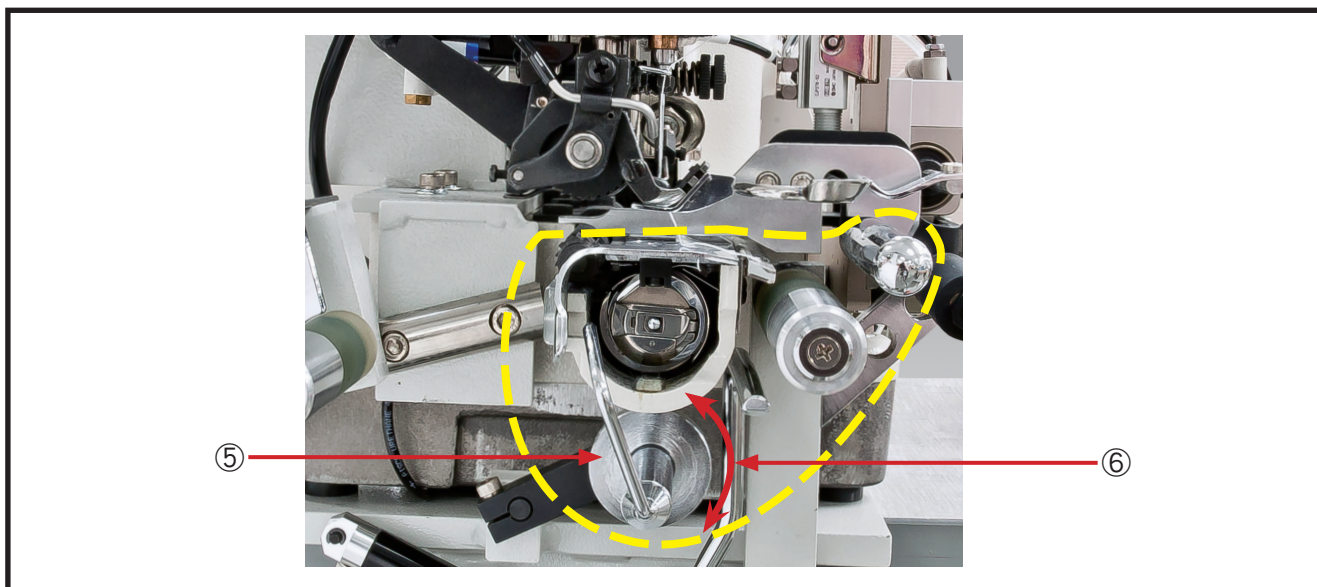


2. 褲邊寬度 170 ~ 200 mm

(1) 將前引導滾輪⑤沿著箭頭方向⑥方向移動調整。

2. Bottom cloth width 170 ~ 200 mm

(1) Move front guide roller ⑤ to arrow direction ⑥ to adjust.

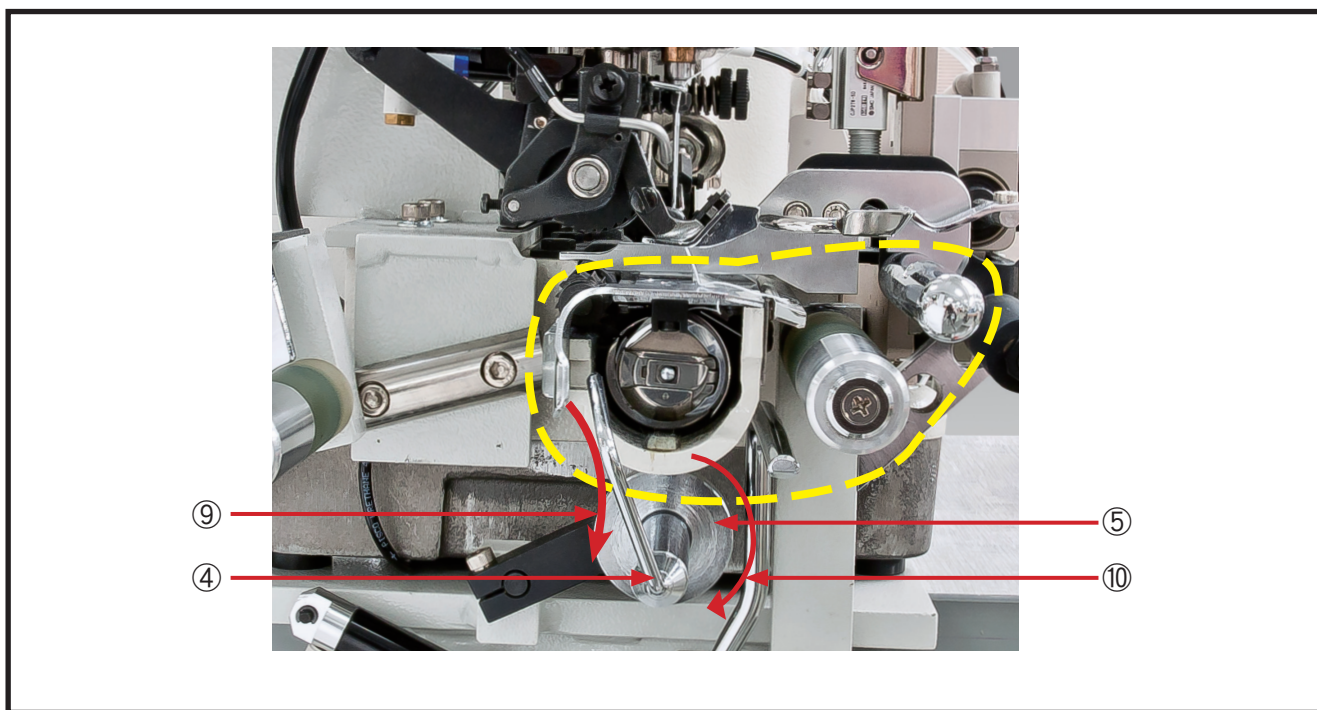


3. 褲邊寬度 140 ~ 170 mm

(1) 前引導滾輪⑤沿著箭頭方向⑨下降。
(2) 前引導滾輪軸④沿著箭頭方向⑩旋轉。

3. Bottom cloth width 140 ~ 170 mm

(1) Lower front guide roller ⑤ to arrow direction ⑨.
(2) Turn the front guide roller shaft ④ to arrow direction ⑩.

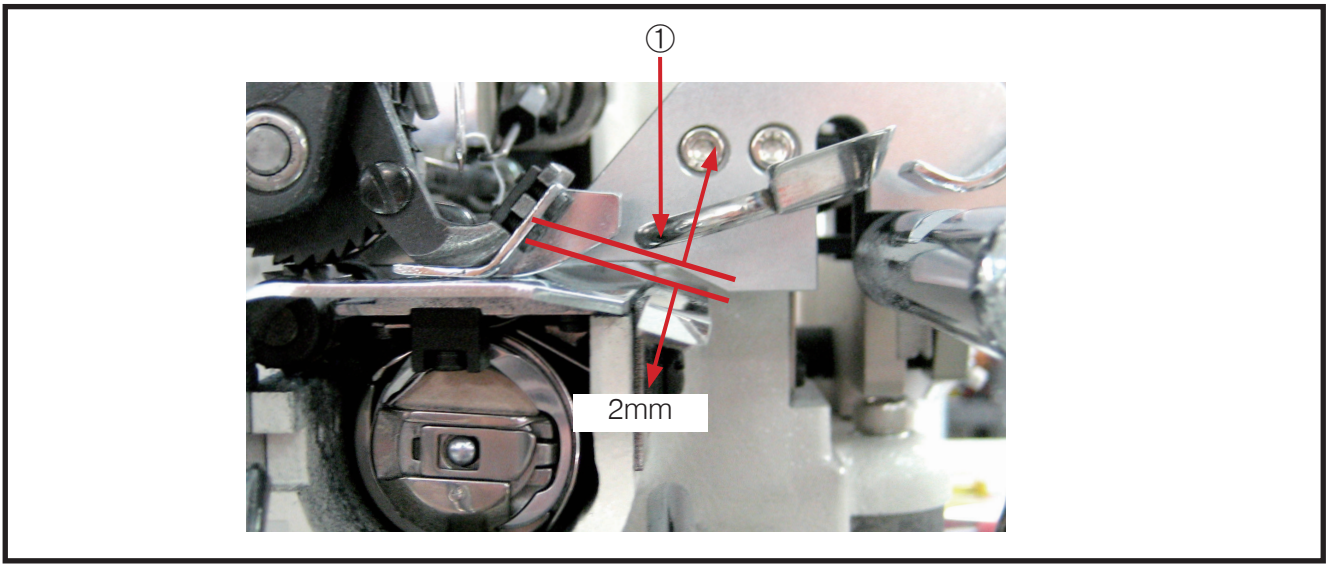


三層卷邊器的調整

THE ADJUSTMENT OF HEMMER

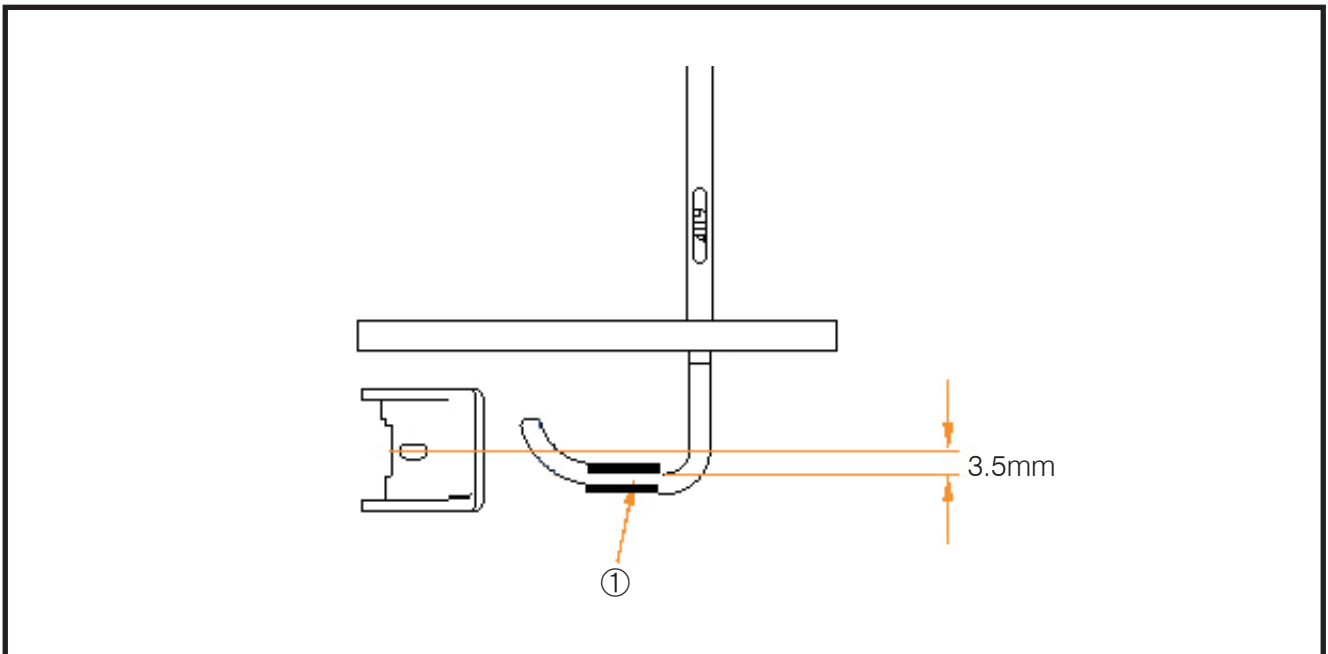
1. 三層卷邊器①將布捲入的時候，卷邊器①的前端與針板上方的間隙為 2mm。厚布料的接頭部分難以通過的情況時，增大這個間隙（5.5mm）。

1. As hemmer ① rolled up cloth, the gap between front hemmer ① and upper needle plate is 2mm. Enlarge the gap (5.5mm) as the splicing part of thick cloth hard to make it through.



2. 三層卷邊器①將布捲入的時候，卷邊器與針的落點間的距離為 3.5mm。

2. As hemmer ① rolled up cloth, the distance between hemmer and needle falling position is 3.5mm.



接頭檢測的調整

接頭檢測板①下降的時候，與接頭檢測承軸②之間間隙，大約為布料厚度的3~4倍。接入空氣，按著重設按鈕的同時打開電源開關，調整會變得容易操作。（調整後，關閉電源）

【調整方法】

(1)微調的情況

鬆開閉鎖螺絲③，旋動調整螺絲來進行調整。

(2)進行大量調整的情況

鬆開螺絲④，將把手⑤沿著箭頭方向移動進行調整。

THE ADJUSTMENT OF SPLICING DETECTOR

As splicing detector plate ① getting lower, its gap between splicing detector shaft ② is about three or four times thickness of fabric. Put into air, press Reset switch and turn the power on simultaneously, which could make operation easier. (Turn off power after adjustment.)

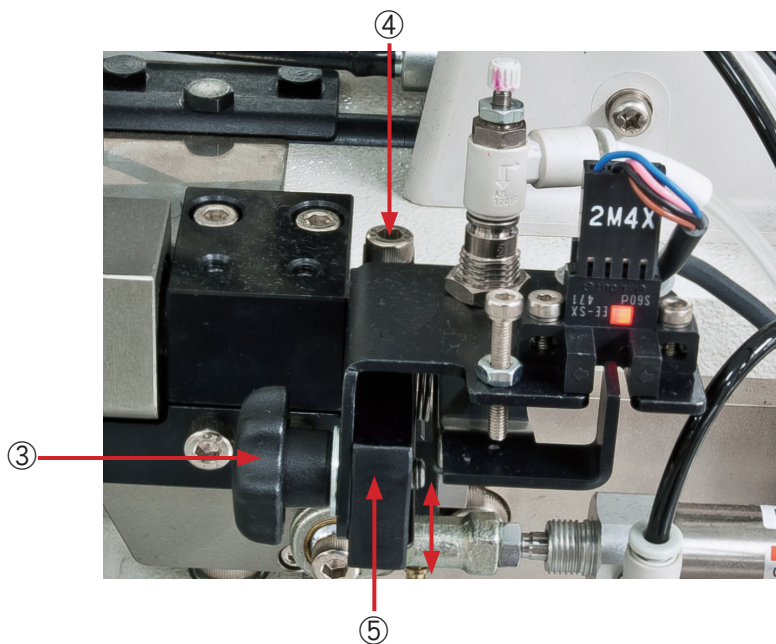
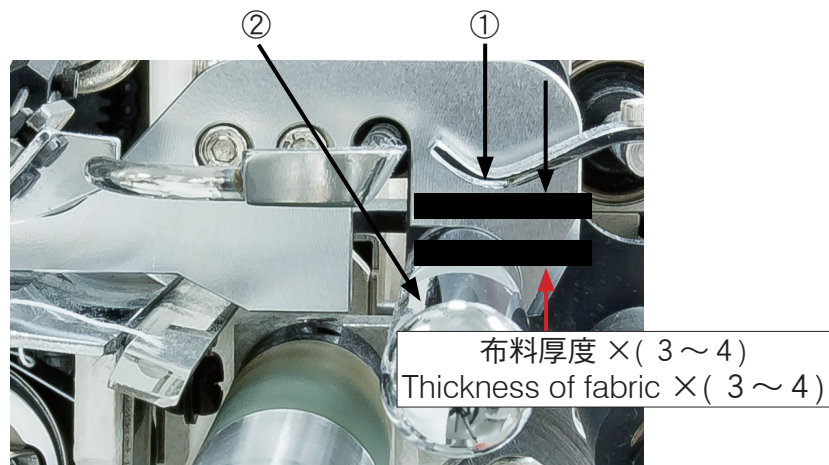
【Adjustment】

(1)Fine adjustment

Loosen lock screw ③, turn adjusting screw for fine adjustment.

(2)Large adjustment

Loosen screw ④, move handle ⑤ to the arrow direction for adjustment.



根據三層卷邊零件的調整

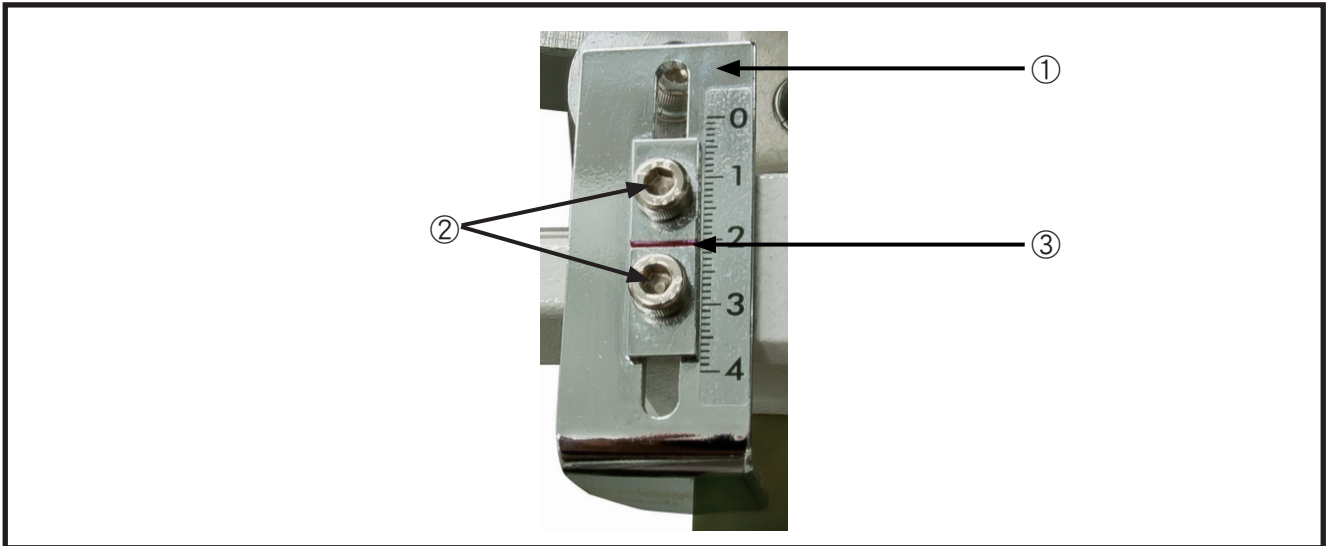
ADJUSTING PARTS ACCORDING TO HEM WIDTH

1. 後引導滾輪定規①

【調整】鬆開螺絲②，將刻度③與三層卷邊布對齊。

1. Rear guide roller ruler ①

【Adjustment】 Loosen screw ②, align hem width with scale ③.



2. 前引導滾輪定規④

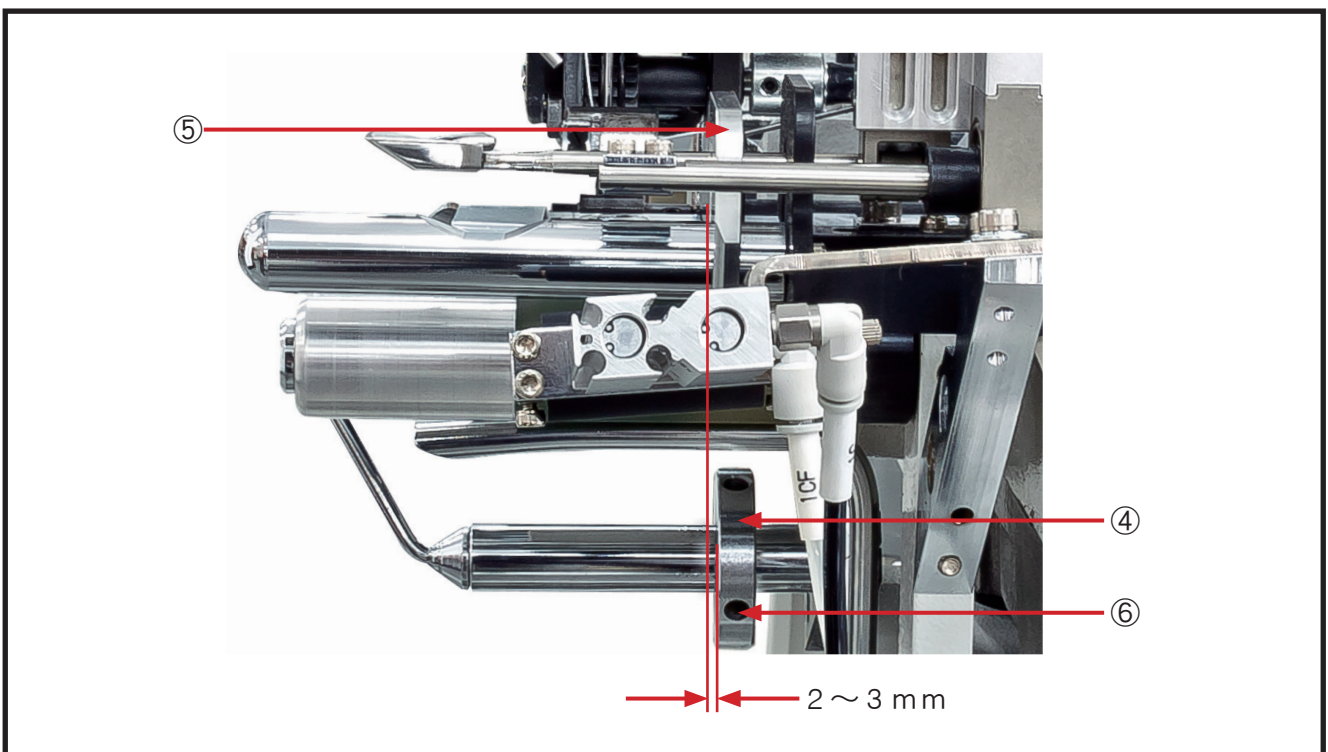
與當定規⑤之間的落差為 2~3mm。

【調整】鬆開螺絲⑥（2 個螺絲），移動前引導滾輪定規④。

2. Front guide roller ruler ④

The distance between positioning ruler ⑤ is 2~3mm.

【Adjustment】 Loosen screw ⑥ (two screws), and move front guide roller ruler ④.



縫紉針距的更改

縫紉針距的變化更改通過「送布量的變更」和「送針量的變更」來實現。

1. 送布量的變更

送布量的變更通過交換上送布齒輪①和下送布齒輪②來實現。

• 齒輪交換順序

- (1) 取下螺絲③（2個螺絲），並取下離合器盒止動板④。
- (2) 鬆開螺絲⑤，取出上送布齒輪①。
- (3) 鬆開螺絲⑥，取出下送布齒輪②。（由於離合器盒⑦而取不出下送布齒輪②的情況下，直到離合器盒⑦的壓痕處到達下送布齒輪②的上部為止，用手轉動縫紉機皮帶輪一邊拔掉下送布齒輪②。）
- (4) 將與變更的縫紉針距長度對應的上送布齒輪①，與離合器盒⑦對準後，一邊轉緊螺絲⑤固定
- (5) 用螺絲③安裝離合器盒止動板④。
- (6) 壓腳放下的狀態下，將與變更的針距長度相對應的下送布齒輪②，與上送布齒輪的齒距相吻合，並用螺絲⑥固定。

CHANGE OF STITCH LENGTH

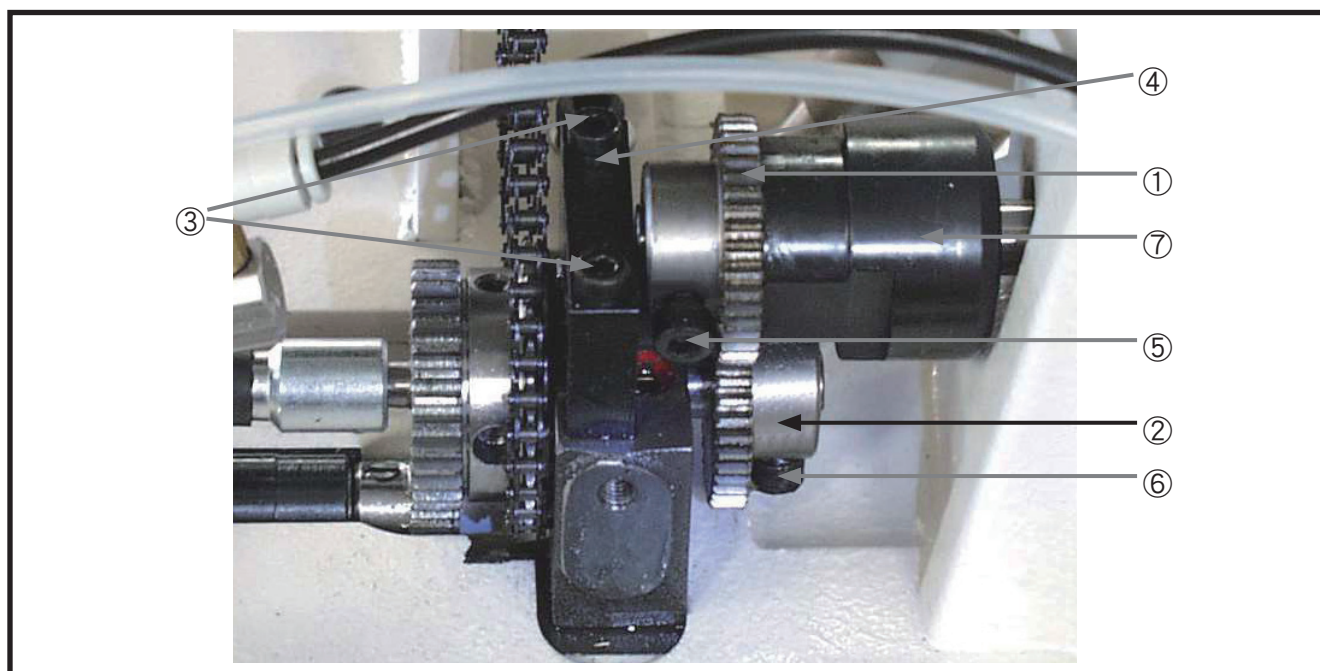
Stitch length shall be changed by both change of feeding amount of cloth and change of needle distance.

1. Change of feeding amount of cloth

Feeding amount of cloth is changed by replacing upper feeding gear ① and lower feeding gear.

• Sequence of replacing gear

- (1) Take off screws ③ (two screws), and take clutch case stopper ④ out.
- (2) Loosen screw ⑤, and take off upper feeding gear ①.
- (3) Loosen screw ⑥, and take off lower feeding gear ②. (In case that clutch case ⑦ is in a way to take lower feeding gear ② out, move hollow of clutch case ⑦ by turning Sewing Machine Pulley by hand till it comes over lower feeding gear ②, and then take lower feeding gear ② out.)
- (4) Fix screw ⑤ as pressing upper feeding gear ① which correspond to the desired stitch length against clutch case ⑦.
- (5) Use screw ③ to install clutch case stopper ④.
- (6) Lower the Presser all the way down, and then fix lower feeding gear ② of the desired stitch length with screw ⑥ as engaging it with upper feeding gear.

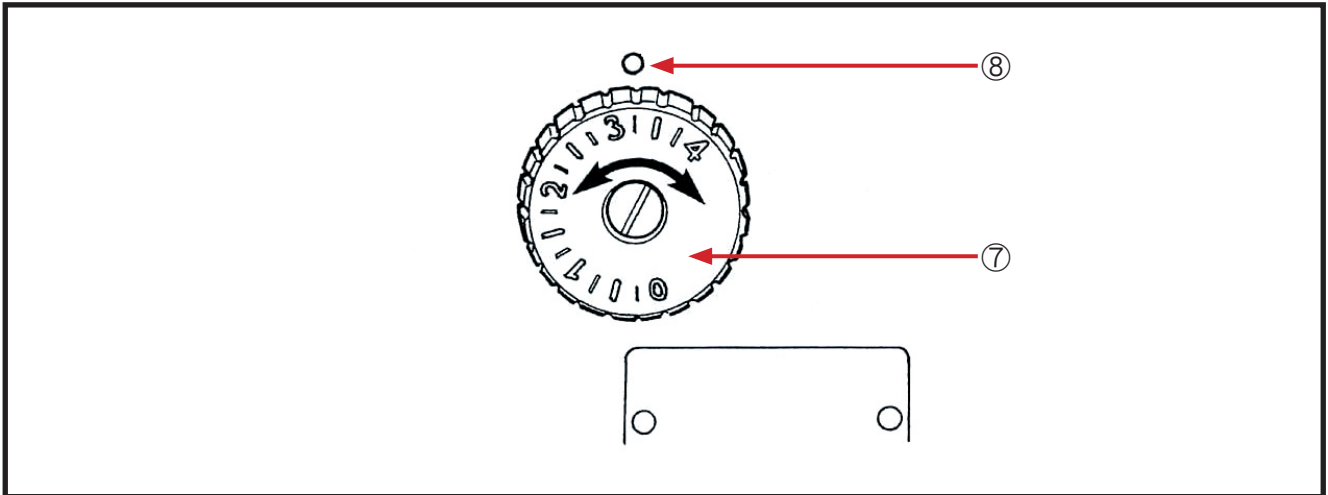


2. 送針量的變更

將送料刻度⑦的刻度值⑧調整為與更換後的齒輪相對應的縫紉針距長度一致的刻度值。

2. Change of needle feed amount

Set the scale of Feeding Dial ⑦ which correspond to gear replaced at dot ⑧ engraved on the sewing machine.

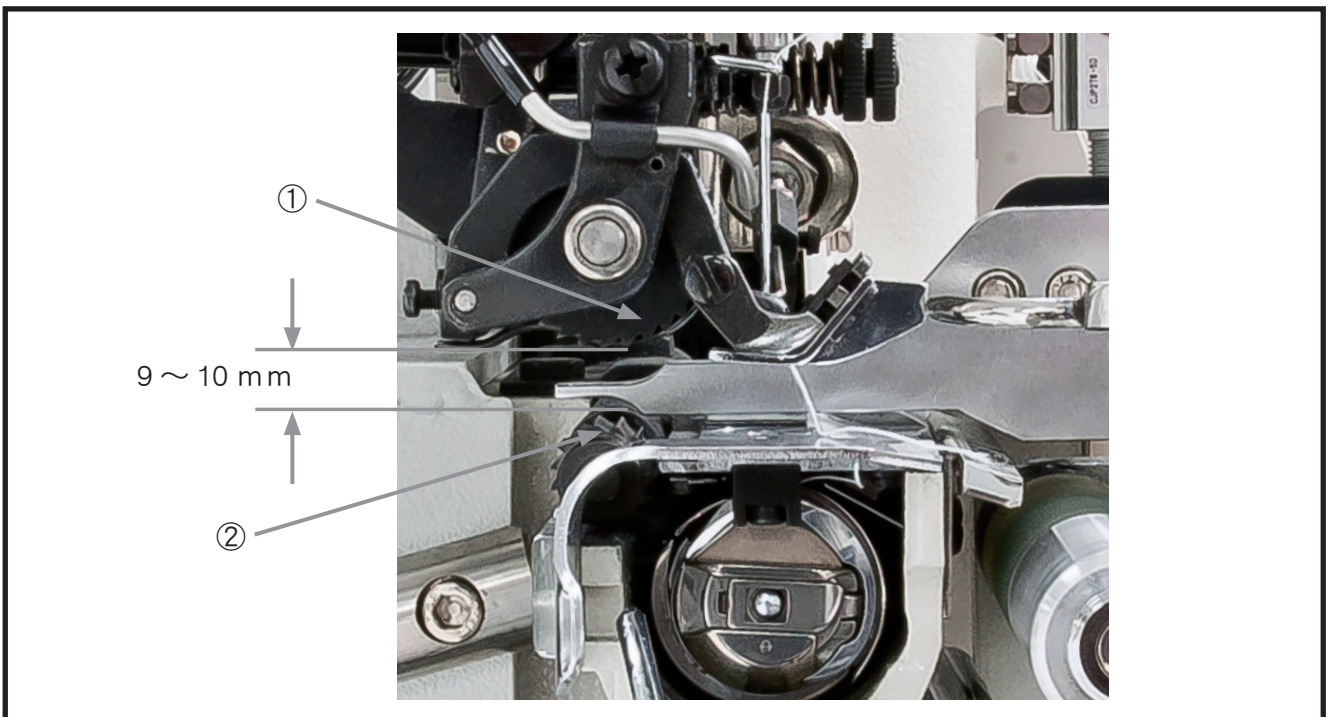


上送布滾輪的標準高度

THE STANDARD HEIGHT OF UPPER FEED ROLLER

上送布滾輪①上抬時，距離下送布滾輪②的高度是 9-10mm。（空氣汽缸上抬時）

When the upper feed roller ① raises, the distance between lower feed roller ② is height 9-10mm. (with air cylinder raises.)

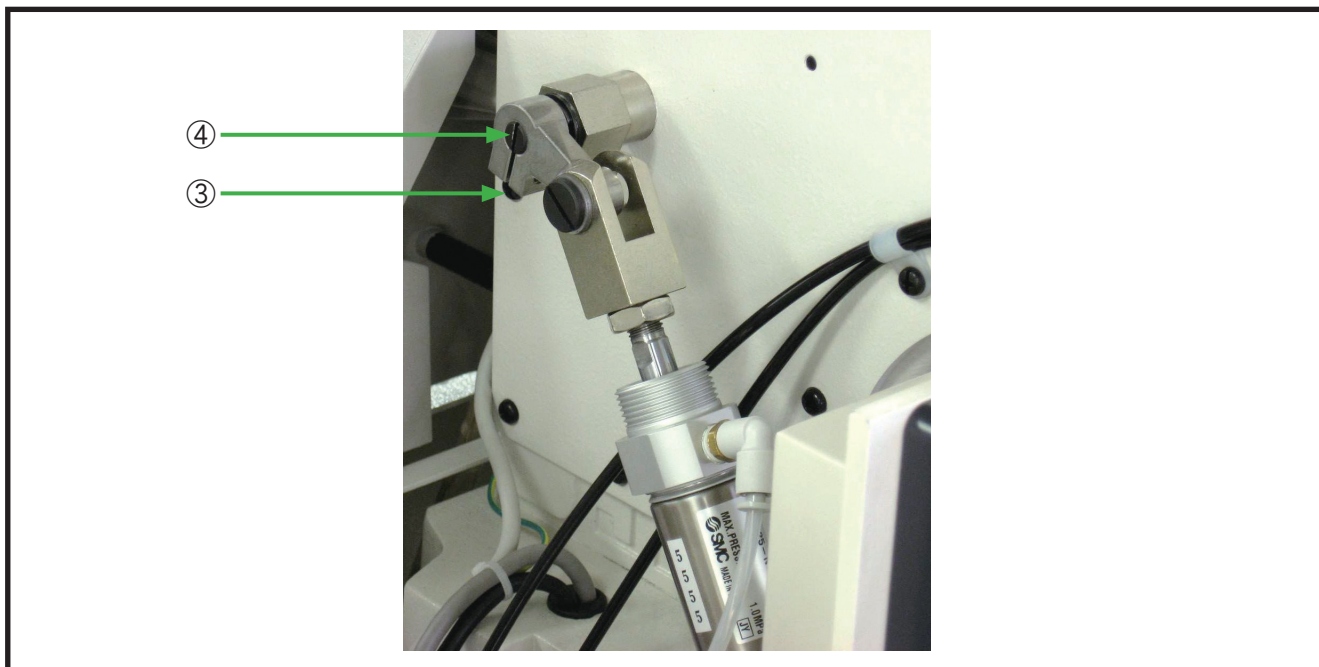


【調整】

鬆開鎖定螺母③，旋轉轉軸④進行調整。

【Adjustment】

Loosen locknut ③, turn the rod ④ to adjust.

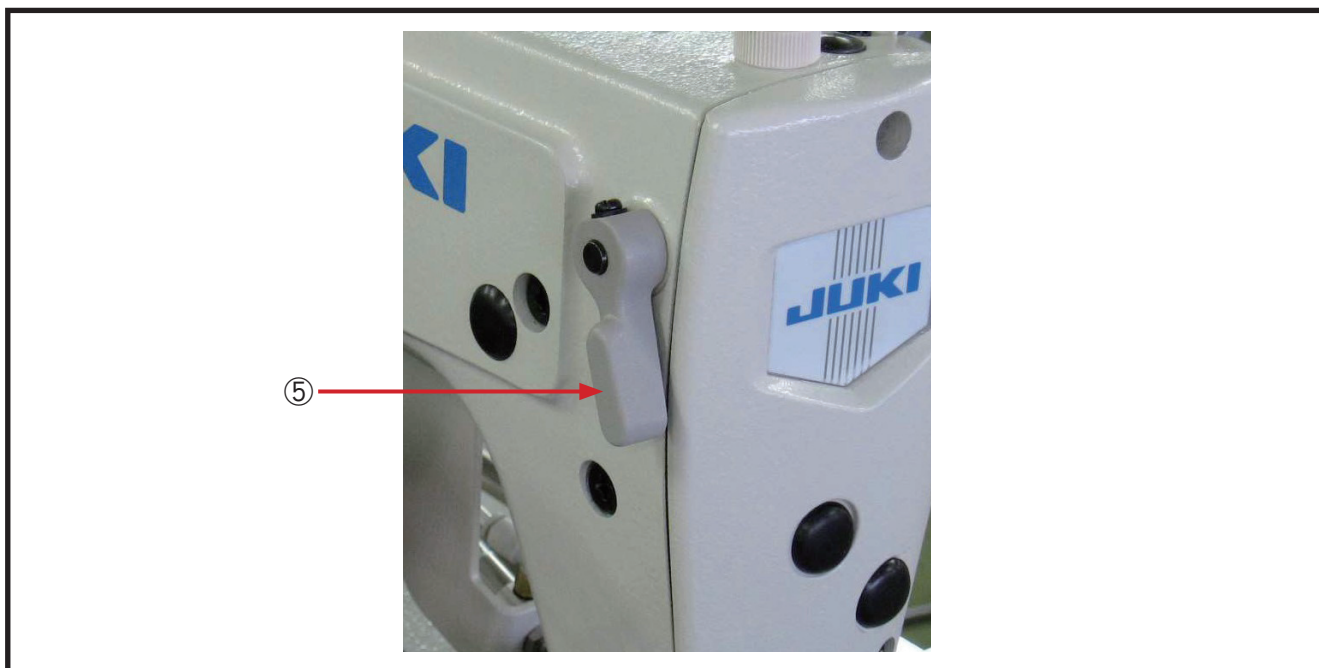


【注意】

電源以及空氣送入時，壓腳上抬把手⑤不進行操作。另外，通過壓腳上抬把手⑤將上送布滾輪上抬後，不可通入空氣。

【Caution】

Do not use the presser bar lifter ⑤ when power on or air supplied. Therefore, do not supply air while using presser bar lifter ⑤ to raise upper feed roller.



模式調整

MODE DEPICTION

1. 手 動：

- (1) 踩→勾布。
- (2) 踩→順布。
- (3) 踩→車縫 (必須持續踩踏)。

2. 半自動：

- (1) 踩→勾布 + 順布。
- (2) 踩→自動車縫 (無需持續踩踏)。

3. 自 動：

踩→勾布 + 順布 + 自動車縫。

1. Manual:

- (1) Step on the treadle→Hook on cloth.
- (2) Step on the treadle→Smooth cloth.
- (3) Step on the treadle→Start sewing. (Keep stepping on to complete full sewing process.)

2. Semi-Auto:

- (1) Step on the treadle→Hook on cloth and smooth it.
- (2) Step on the treadle→Start sewing. (No need to keep stepping on.)

3. Auto:

Step on the treadle→Hook on cloth, smooth it, and complete sewing.



從反面縫切換至正面縫的方法

HOW TO CHANGE THE PARTS
TO SEW FACE-UP FROM
BUTTON-UP SEWING

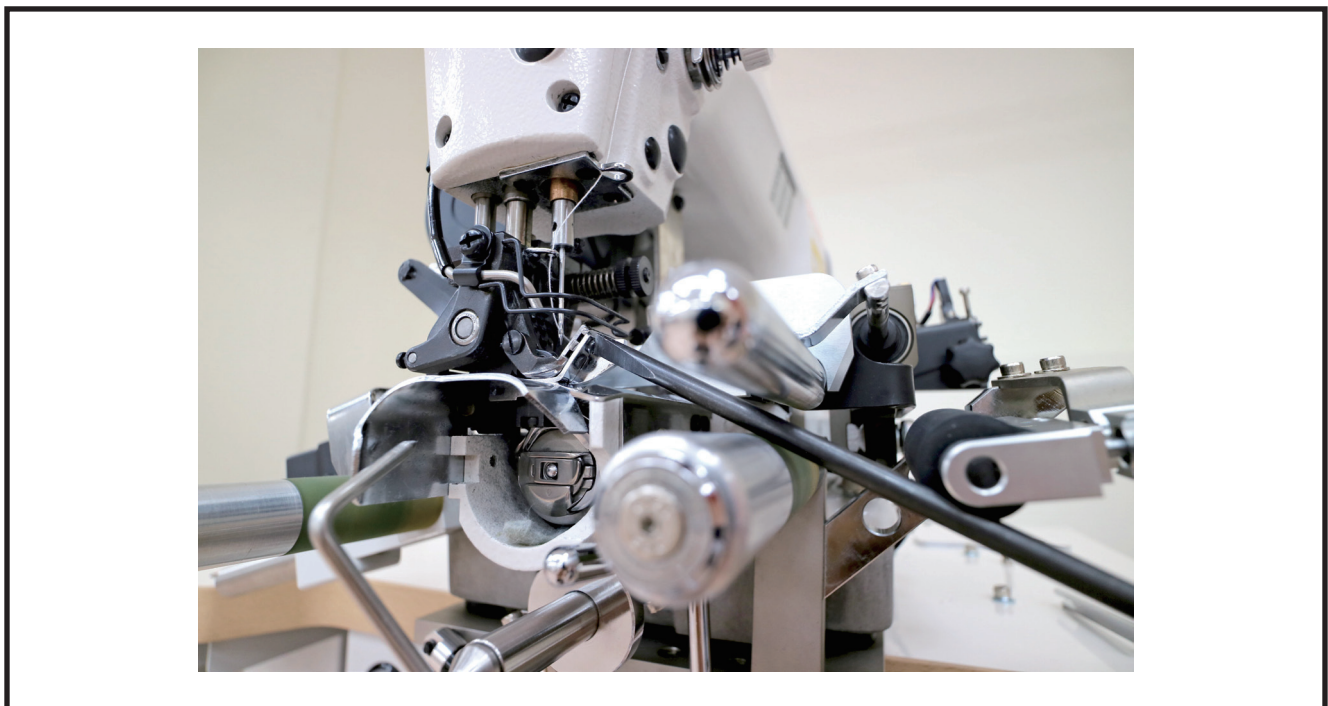
1. 正面縫用的零件裝置

1. How to install face-up sewing parts



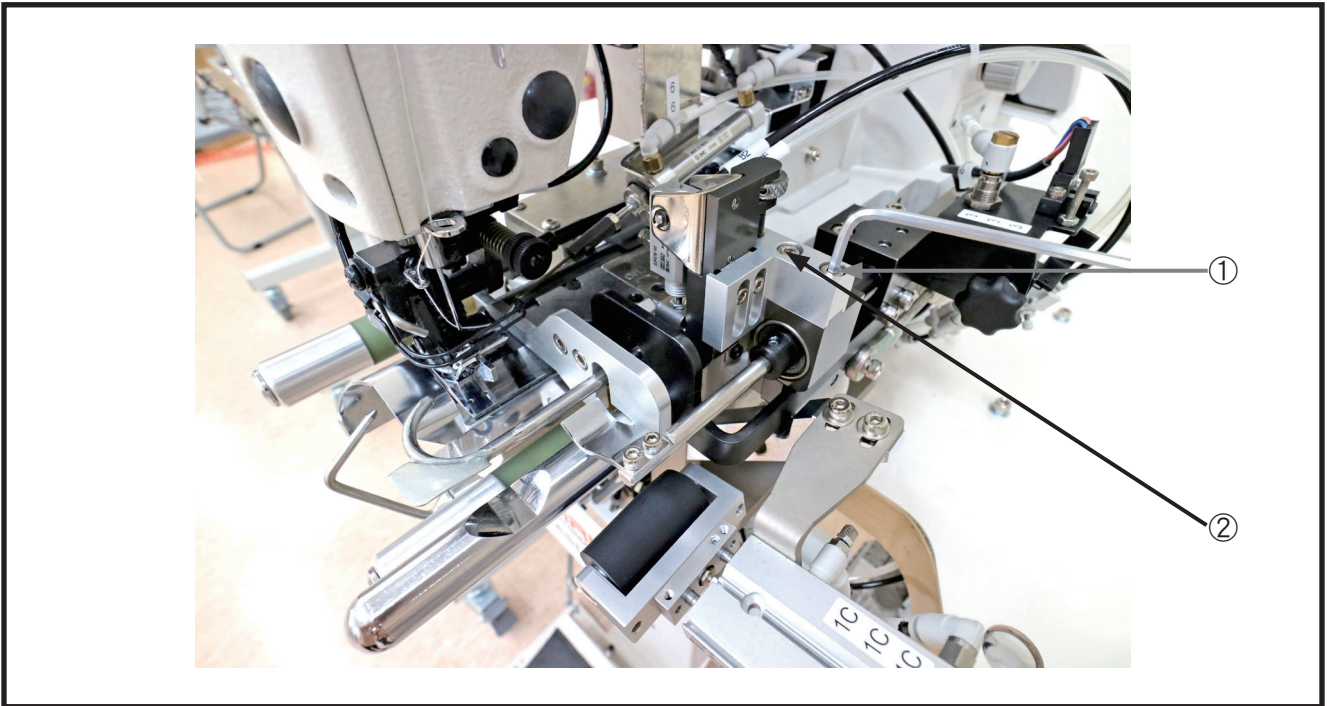
2. 鬆開螺絲，拆下反縫檔邊

2. Loosen screw, take out button-up blocker.



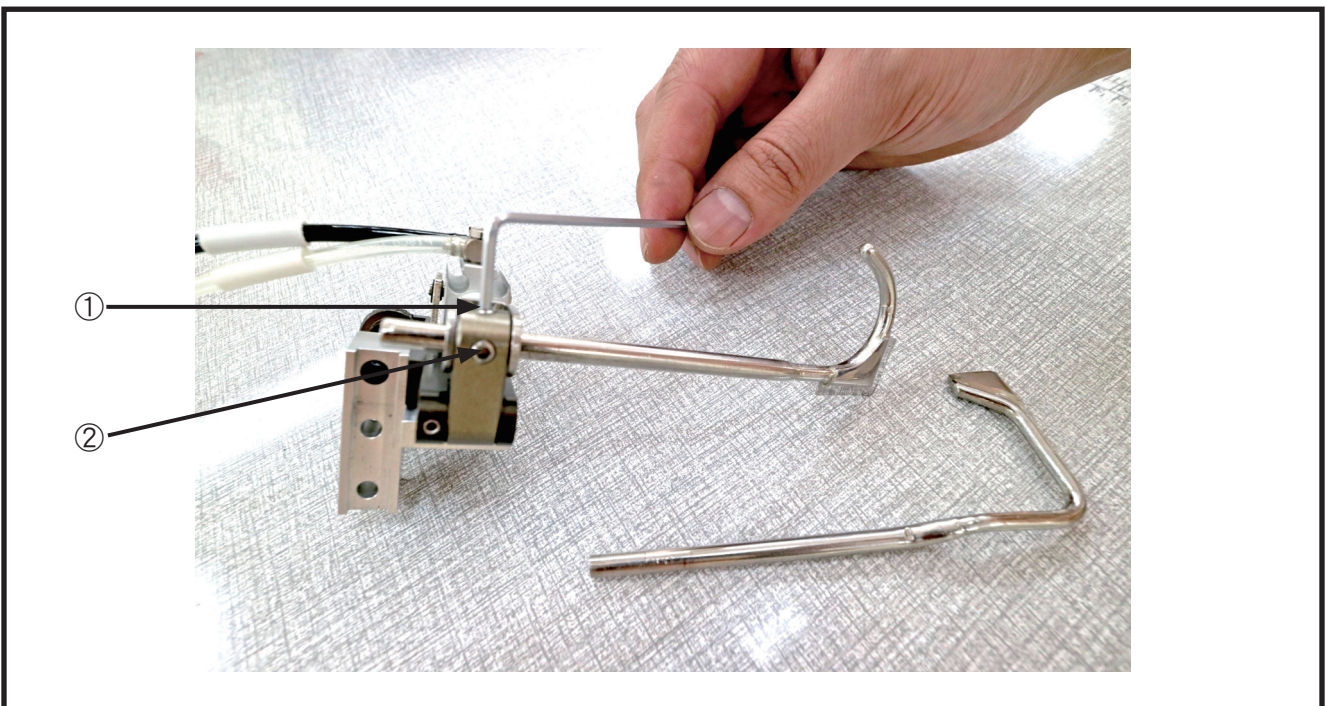
3. 鬆開螺絲①和②，取下勾布組

3. Loosen screw ① & ②, take out cloth-hook assembly.



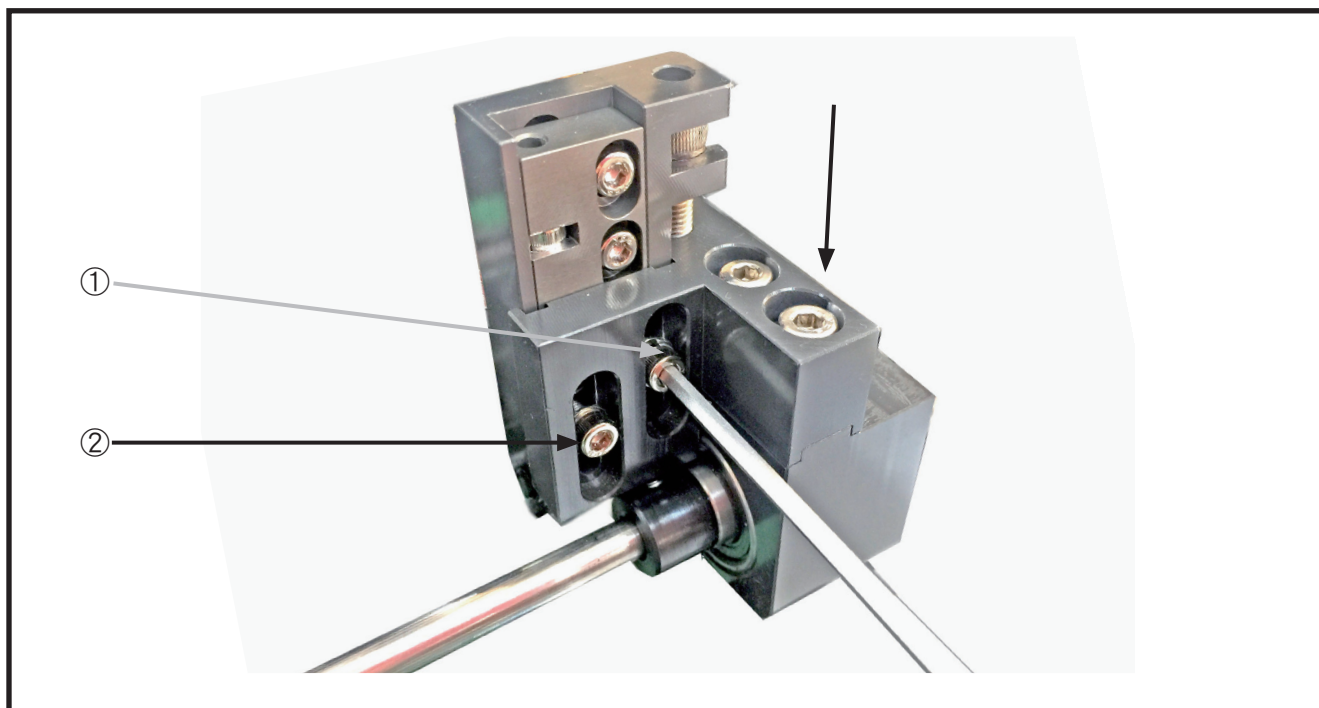
4. 鬆開螺絲①和②，換上正縫勾布桿

4. Loosen screw ① & ②, replace with face-up hook.



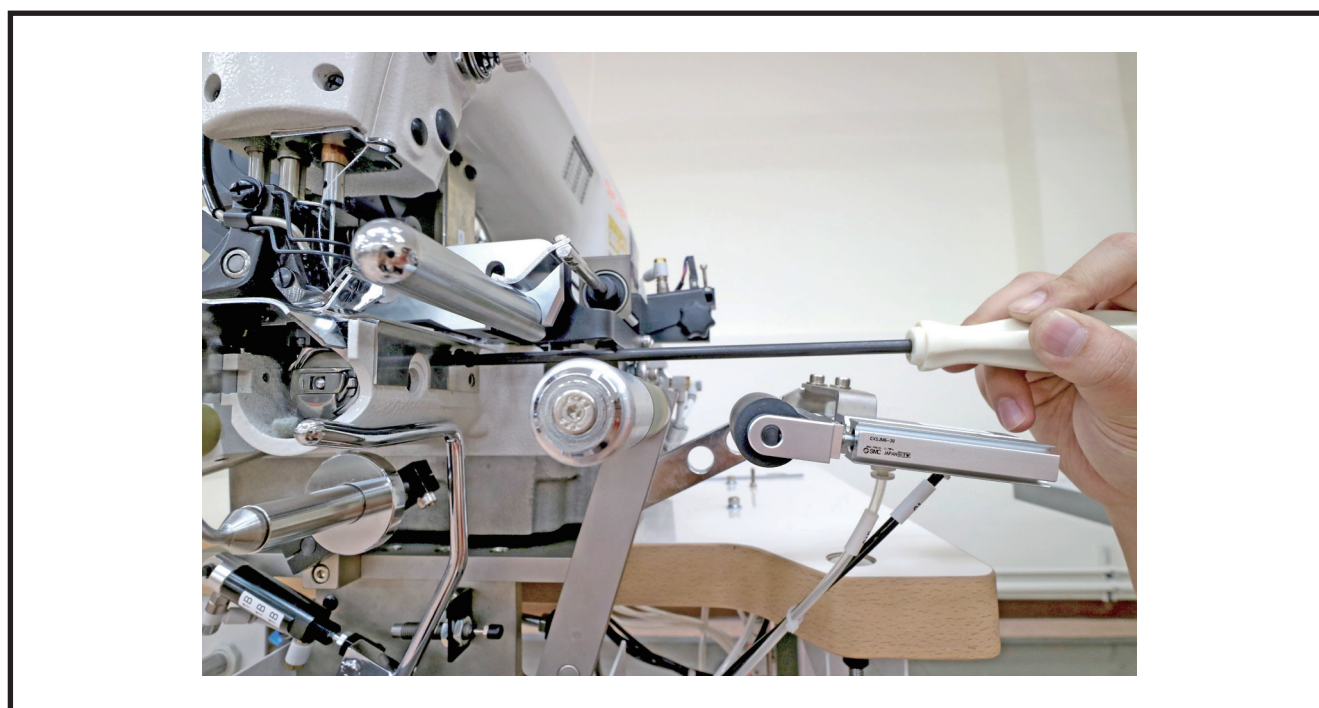
5. 鬆開螺絲①和②，調整布高度。

5. Loosen screw ① & ②, adjust height.



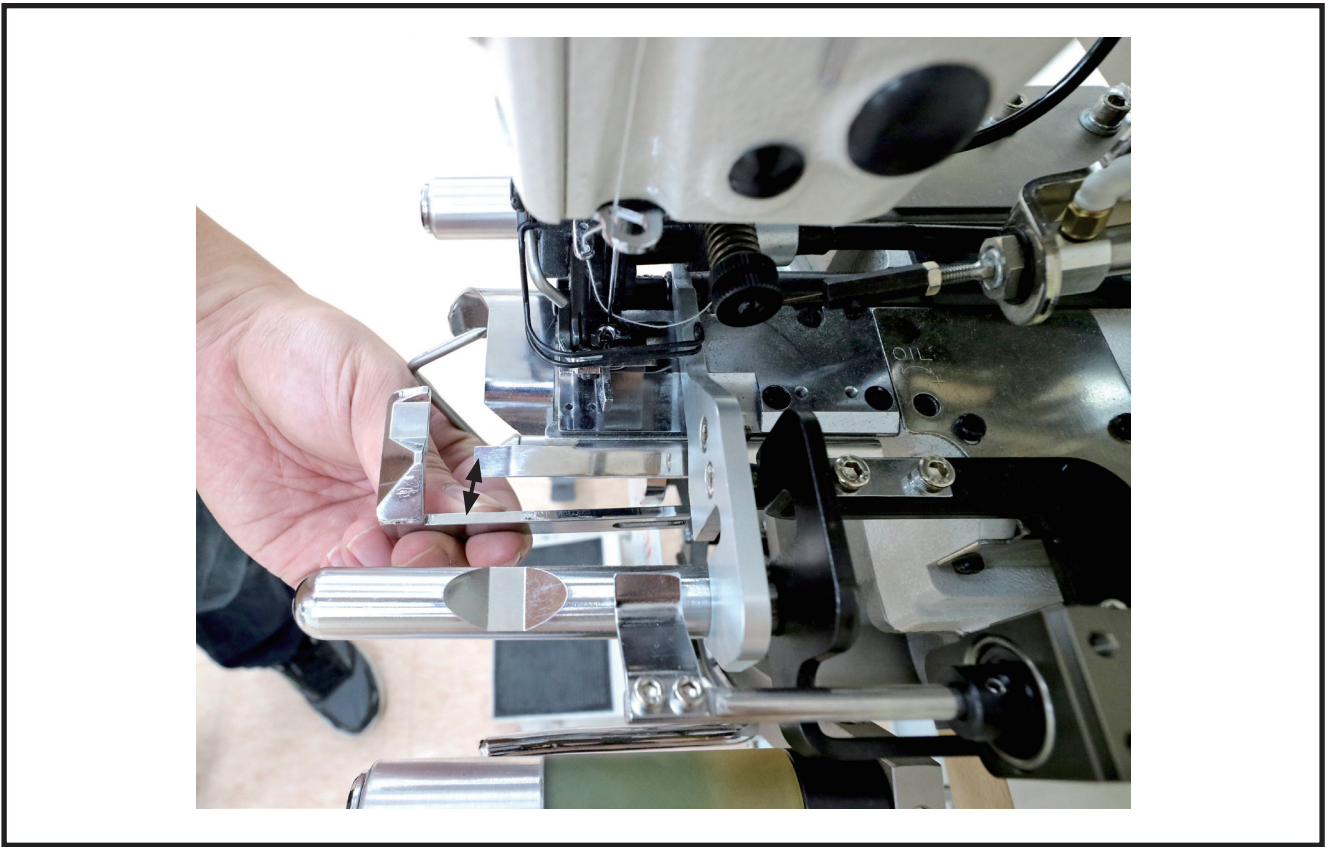
6. 鬆開螺絲。

6. Loosen screw.



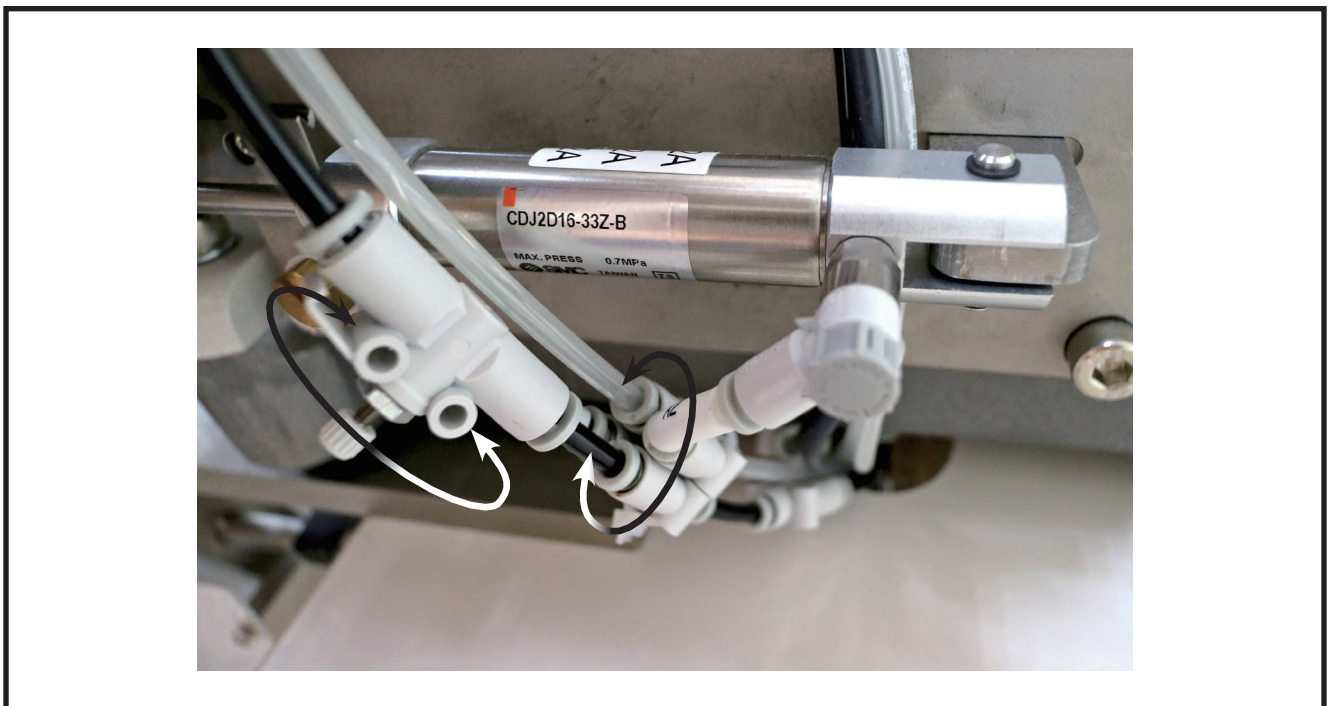
7. 換上正縫檔邊。

7. Replace with face-up blocker.



8. 裝上勾布組，氣壓管位置交換。

8. Assemble cloth-hook assembly, switch positions of two air tubes.

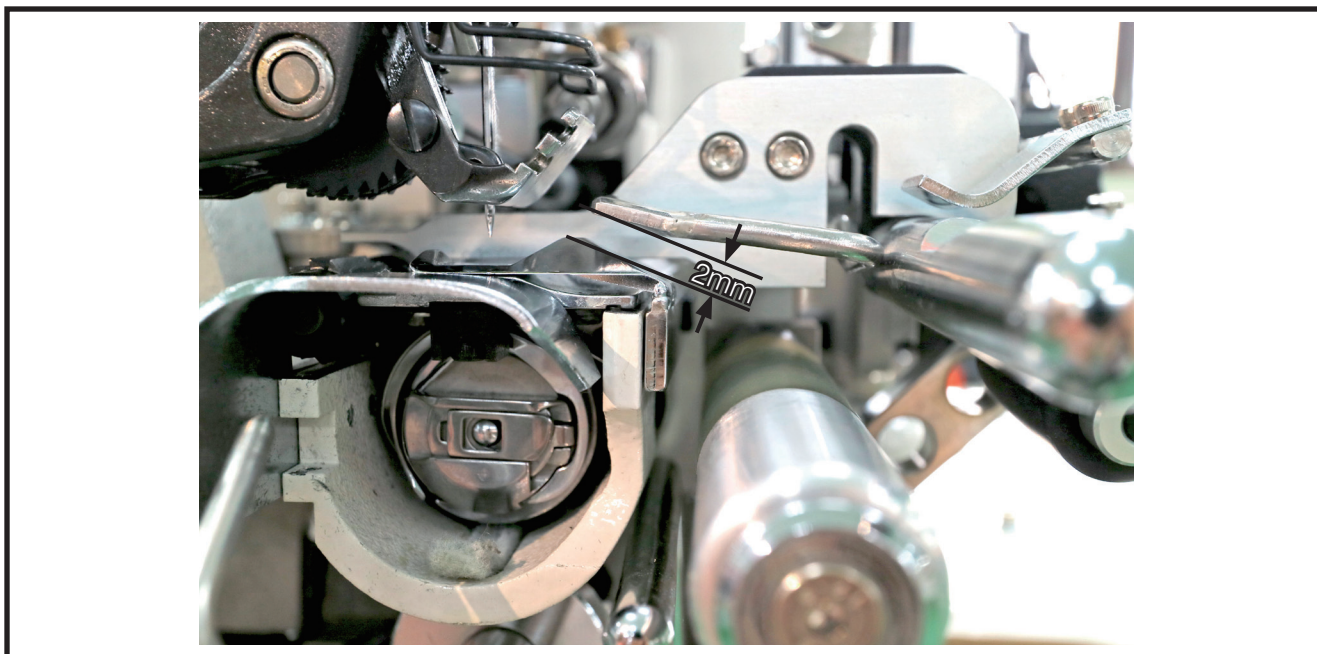


調整方法

ADJUSTMENT METHOD

1. 在調整模式下 (Reset 長壓 + 電源 ON)
勾布桿與檔邊距離 2mm

1. Under adjustment mode (Hold Reset button and push power ON), distance between cloth-hook rod and blocker: 2mm.

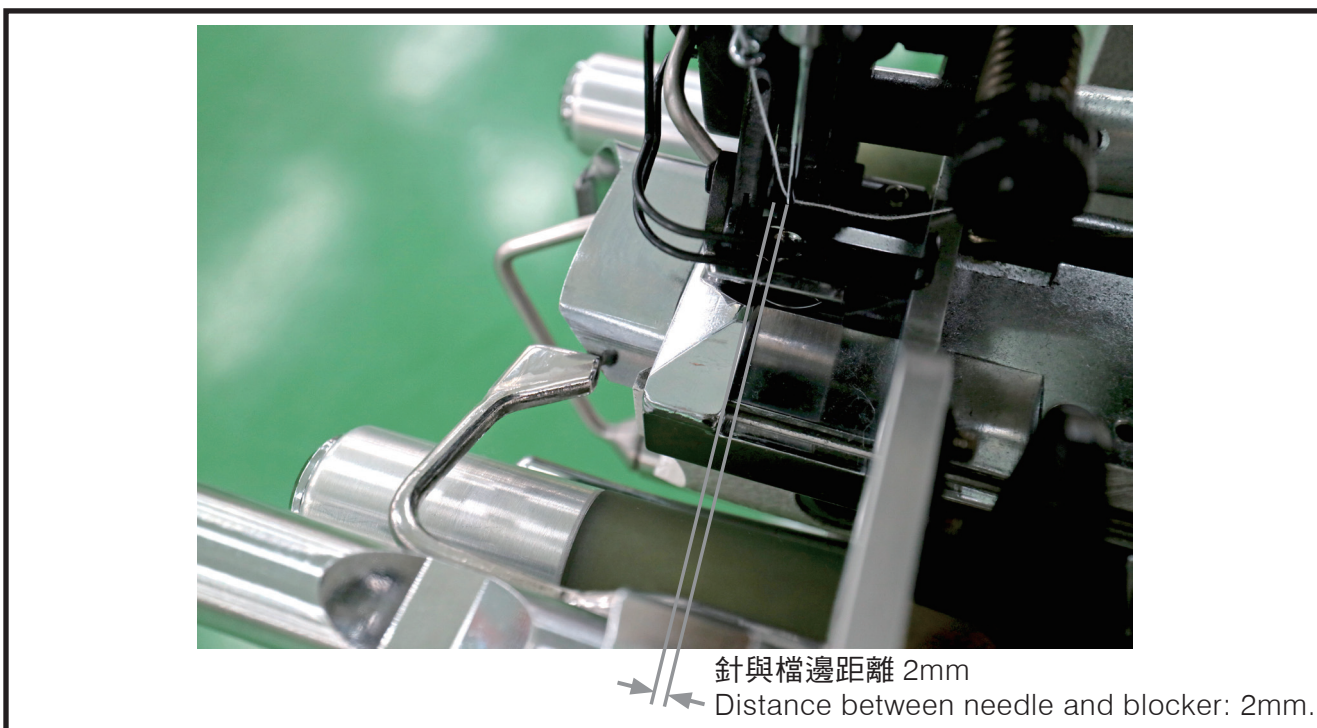


2. 正面縫用的定位件、繞腳機片之基準

2. How to adjust front-guide & hemmer for face-up sewing

- (1) 前定位件①基準
前定位件①之端面和針的間隙為 2mm。
(調整) 鬆開螺絲②進行調整。

- (1) Front-guide ①
Between needle & Front-guide is 2mm.
(Adjustment) Loosen screw ②.

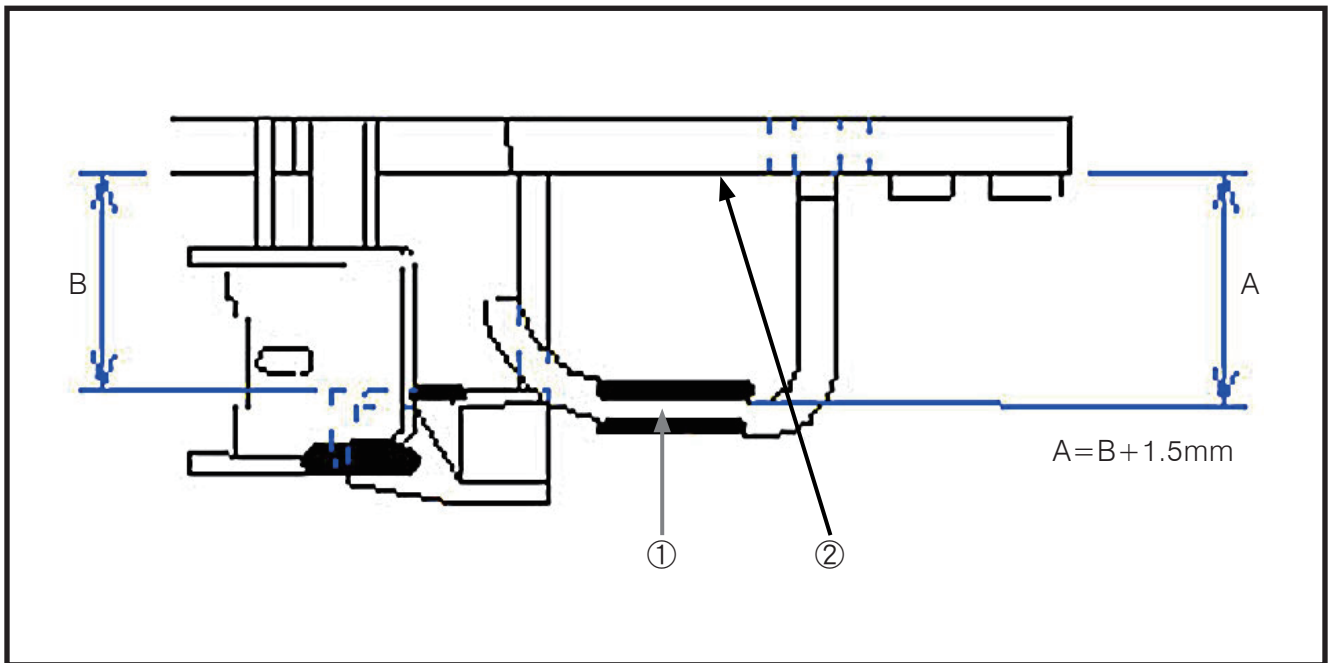


3. 繞腳機片①拉進時、繞腳機片①和定位頂件
②間隔 A 為 $B + 1.5\text{mm}$ 。

3. When hemmer ① go backwards, distance
between bottom of hemmer-end ① and
ruler ② is $A=B+1.5\text{mm}$.

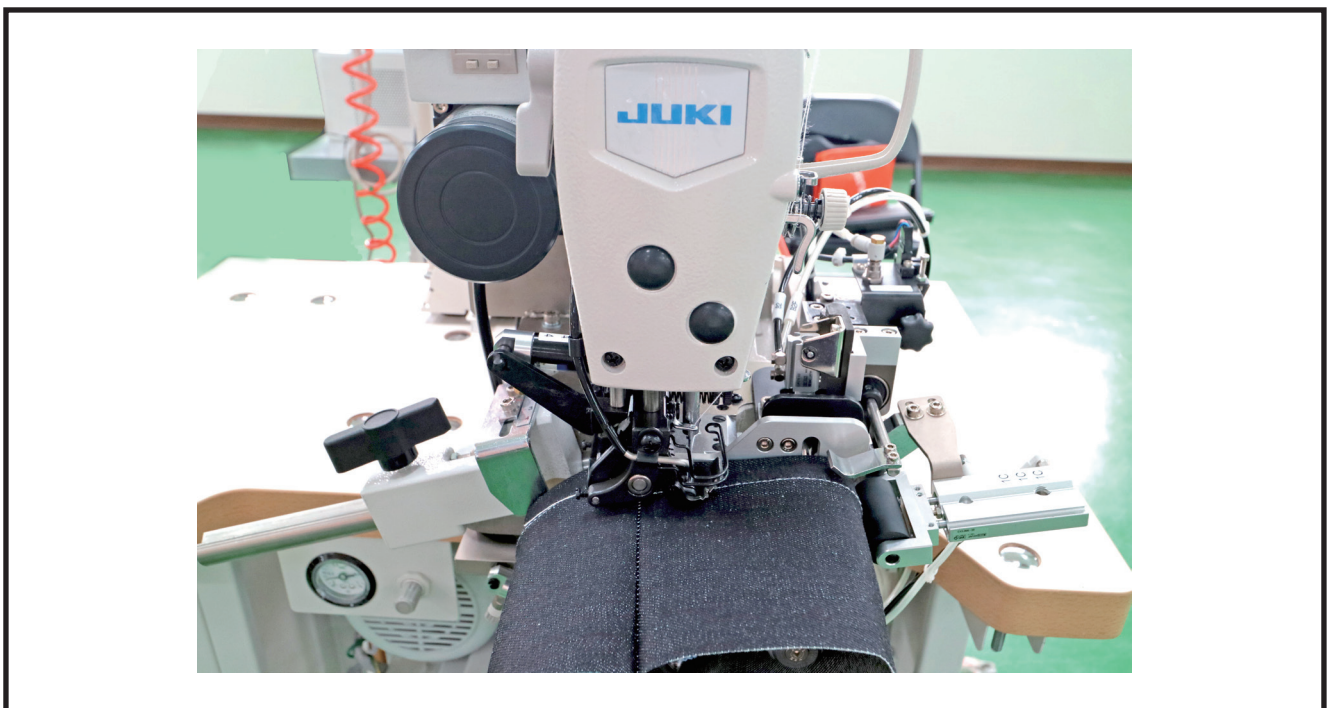
(例) 繞腳寬 20mm 時
 $B = 22\text{mm}$ 、 $A = 23.5\text{mm}$ 基準尺寸

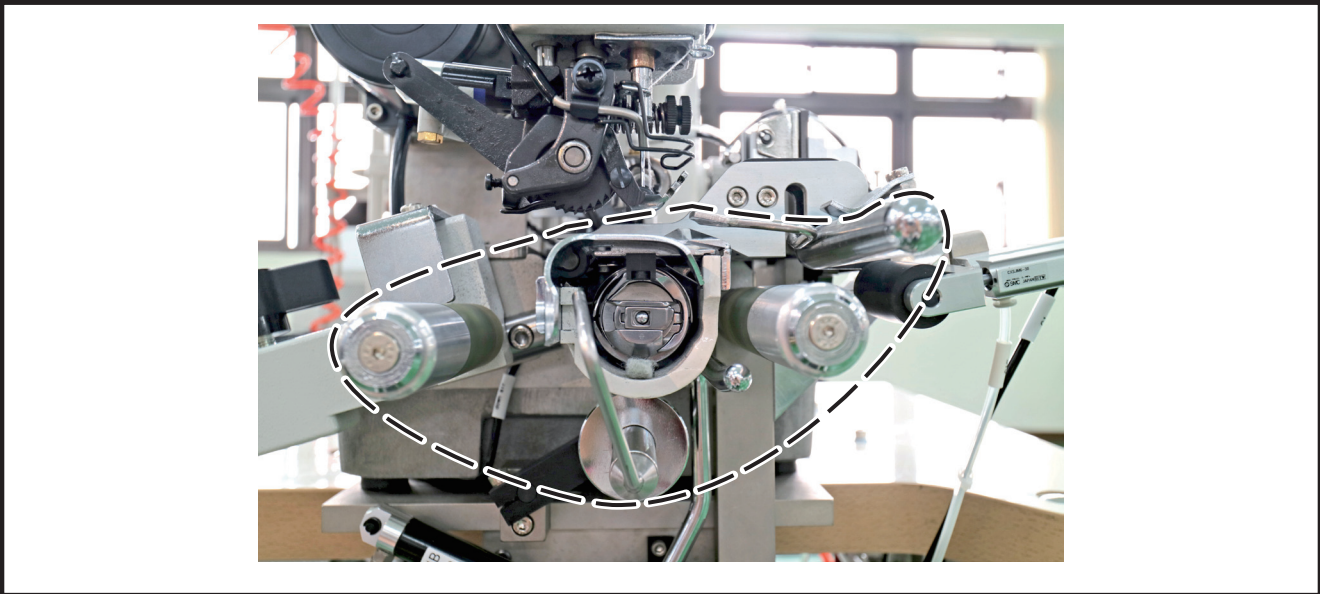
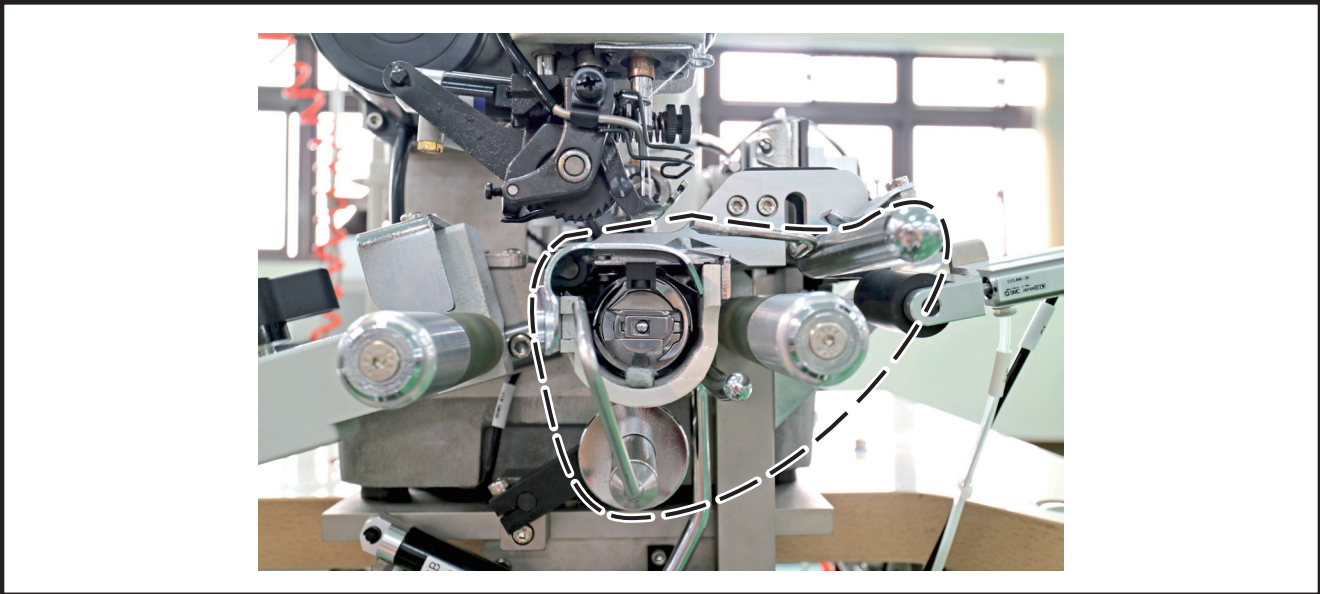
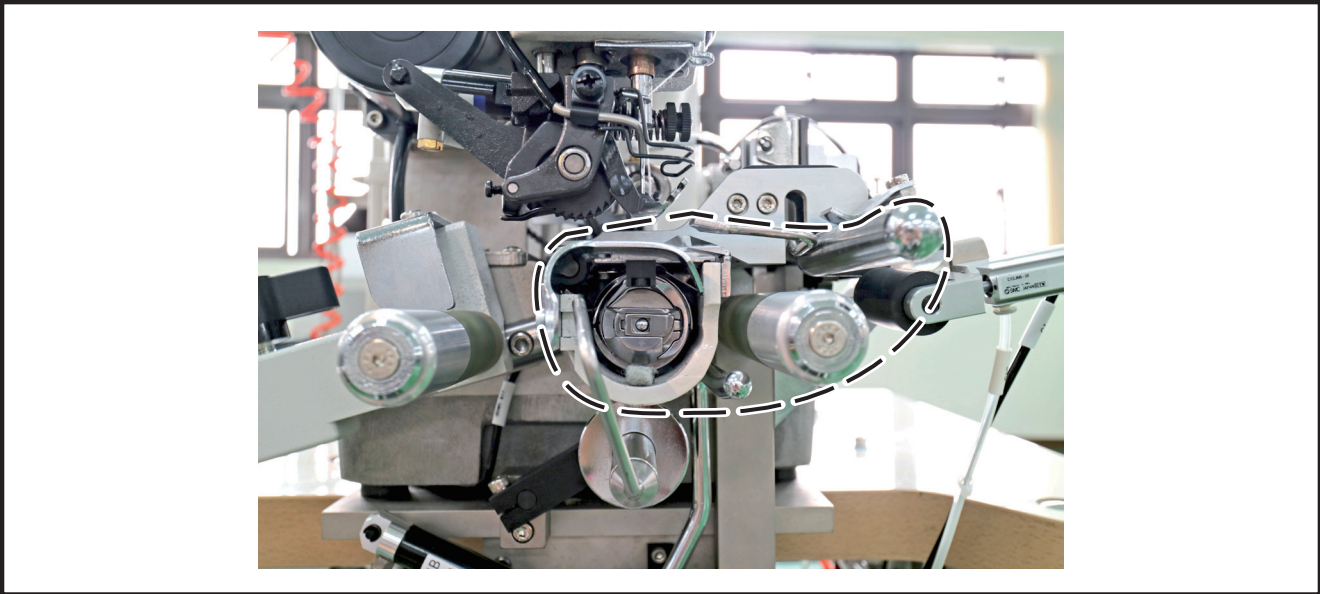
(Example) Hem width is 20mm
 $B = 22\text{mm}$, $A = 23.5\text{mm}$



下擺布料組裝方法

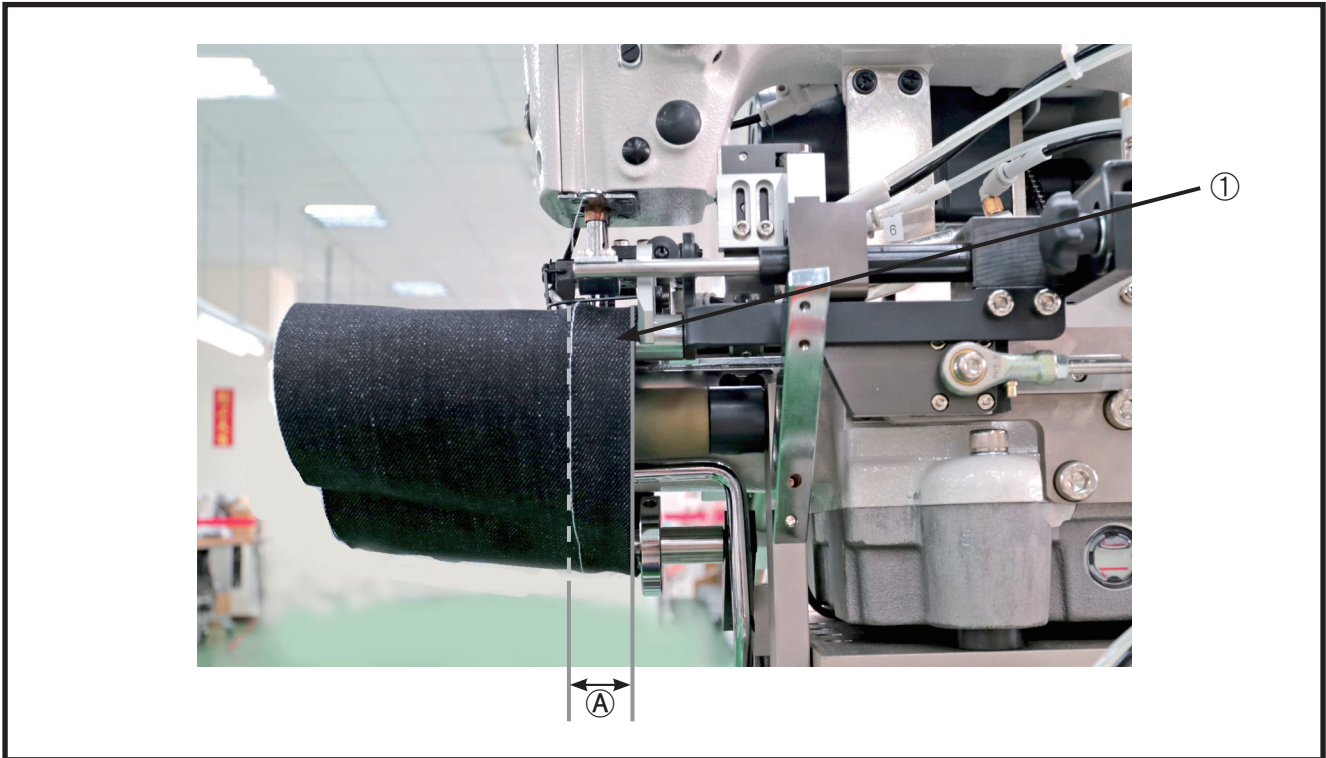
HOW TO SET FABRICS



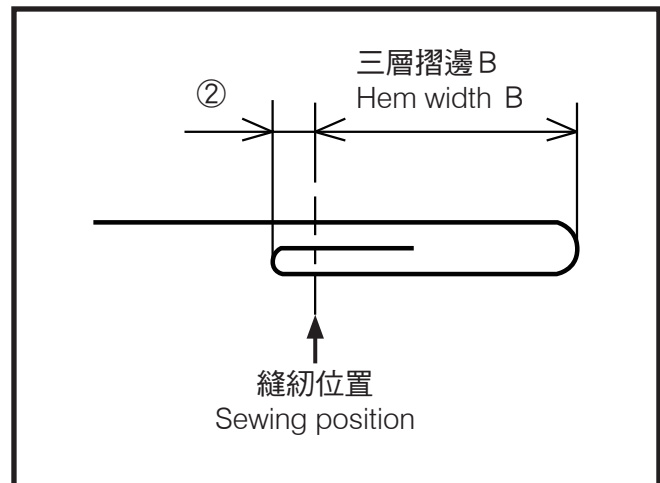


將下擺布料端折成兩邊、始縫面的接縫①過到右側進行安裝。
折成兩邊尺寸①參考下表。

After fold hem, set the 1st seams ① come to the right down side.
Please refer to following size ① about how much you fold the hem. At the start.



三層摺邊尺寸 B (mm) Hem width B (mm)	兩次摺邊尺寸 A (mm) Width of folded twice A (mm)
12.7	18 ~ 23
15	20 ~ 25
20	25 ~ 30
25	30 ~ 35



不良問題的原因和對策

STRATEGIES & CAUSES FOR MALFUNCTION

問題 Problems	造成原因 Causes	對策 Strategies	頁碼 Page
1. 三層卷邊刺破。 1. Hemming is not bedone properly.	① 褲邊兩層摺疊尺寸過小。 ② 褲邊張力過小。 ① Bottom cloth folded width is too small. ② The tension of bottom cloth is too low.	<ul style="list-style-type: none"> 調整和三層卷邊一樣的兩層摺疊尺寸。 增大褲邊張力。 Adjust folded part width to hem width. Raise bottom cloth tension. 	5 6 5 6
2. 卷邊出現褶皺。 2. Hem has wrinkles.	① 褲邊兩層摺疊尺寸過大。 ① Bottom cloth folded part is too large.	<ul style="list-style-type: none"> 調整和三層卷邊一樣的兩層摺疊尺寸。 Adjust folded part width to hem width. 	5 5
3. 不能進行三層卷邊。 3. Hemming cannot be done at all.	① 三層卷邊引導板的高度過高。 ① Upper Guide is placed too high.	<ul style="list-style-type: none"> 降低三層卷邊引導板的高度。 Lower the height of Upper Guide. 	
4. 撐開褲腳時，褲邊滾輪回到原來的位置。 4. Bottom tension roller goes back to its original position while bottom tension is working.	① 撐褲邊裝置的設置和褲腳尺寸不符。 ① Setting of bottom tension device doesn't match bottom .	<ul style="list-style-type: none"> 將其調整和褲腳尺寸相符合。 Make arrangement which suited bottom width. 	7 7
5. 中間的接頭處，布料從卷邊器中脫開。 5. Hemmer goes back to its original position when it comes to splicing in middle.	① WIDTH 設定值過小。 ① Set value of WIDTH is too small.	<ul style="list-style-type: none"> 增大 WIDTH 設定值。 Select bigger set value of WIDTH. 	4 4
6. 縫紉最後的接頭時，卷邊器也拔不開。 6. Hemmer doesn't go back to its original position when it comes to last splicing.	① WIDTH 設定值過大。 ① Set value of WIDTH is too big.	<ul style="list-style-type: none"> 減小 WIDTH 設定值。 Select smaller set value of WIDTH. 	4 4
7. 接頭處無法被檢測出。 7. Splicing cannot be detected.	① 接頭檢測的調整不良。 ① Splicing detector does not adjust well.	<ul style="list-style-type: none"> 根據布料的厚度調整接頭檢測板的高度。 Adjust position of splicing detector plate according to material thickness. 	10 10
8. 斷針。 8. Needle brakes.	① 滾輪送布量和送針量不相符。 ① Needle feed amount doesn't match roller feed amount.	<ul style="list-style-type: none"> 調節滾輪送布量和送針量使之相符。 Match needle feed amount with roller feed amount. 	12 12

SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0142-A	-	1/16
				Date
				2018/02/27

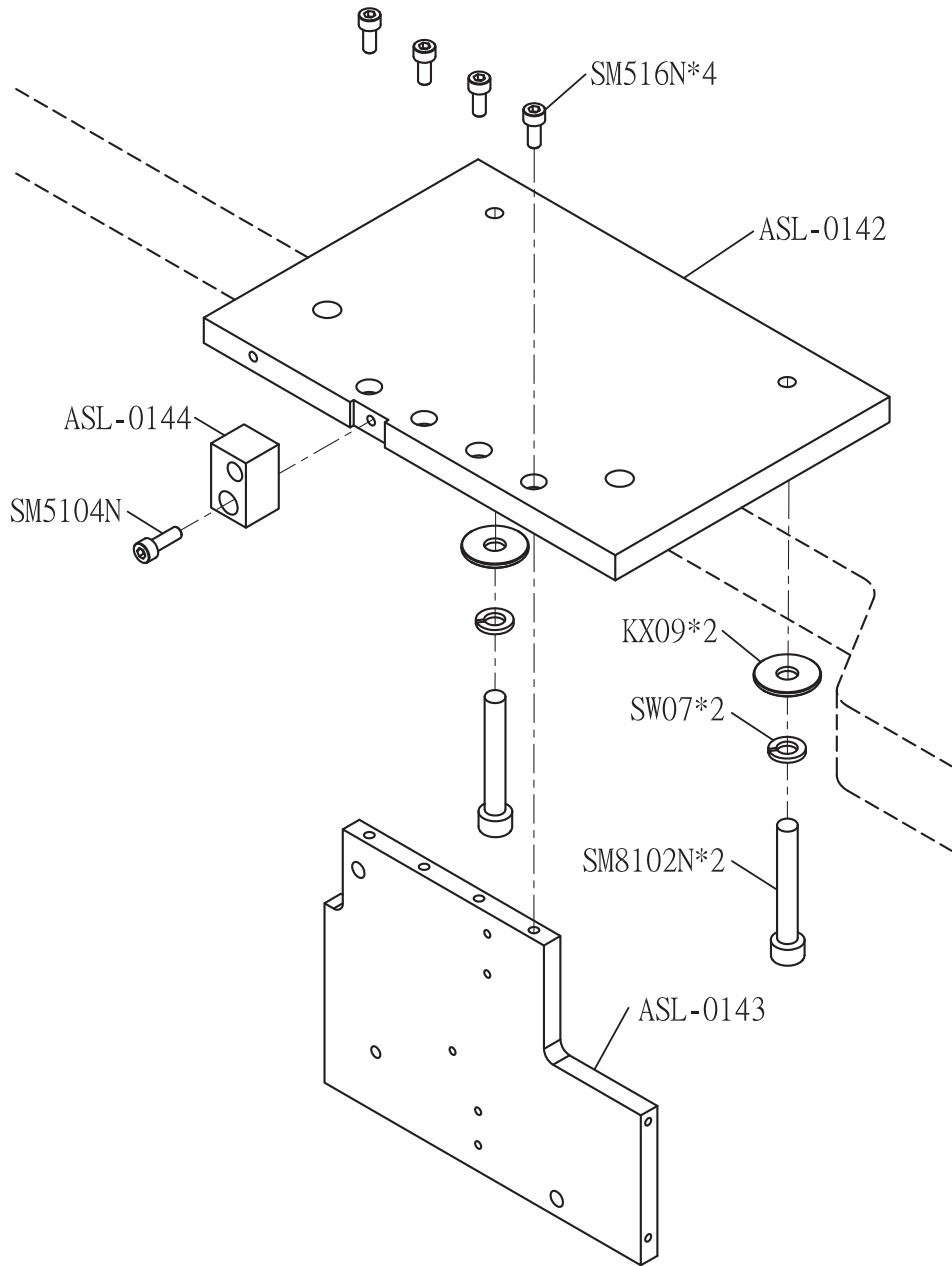
A

B

C

D

E



1

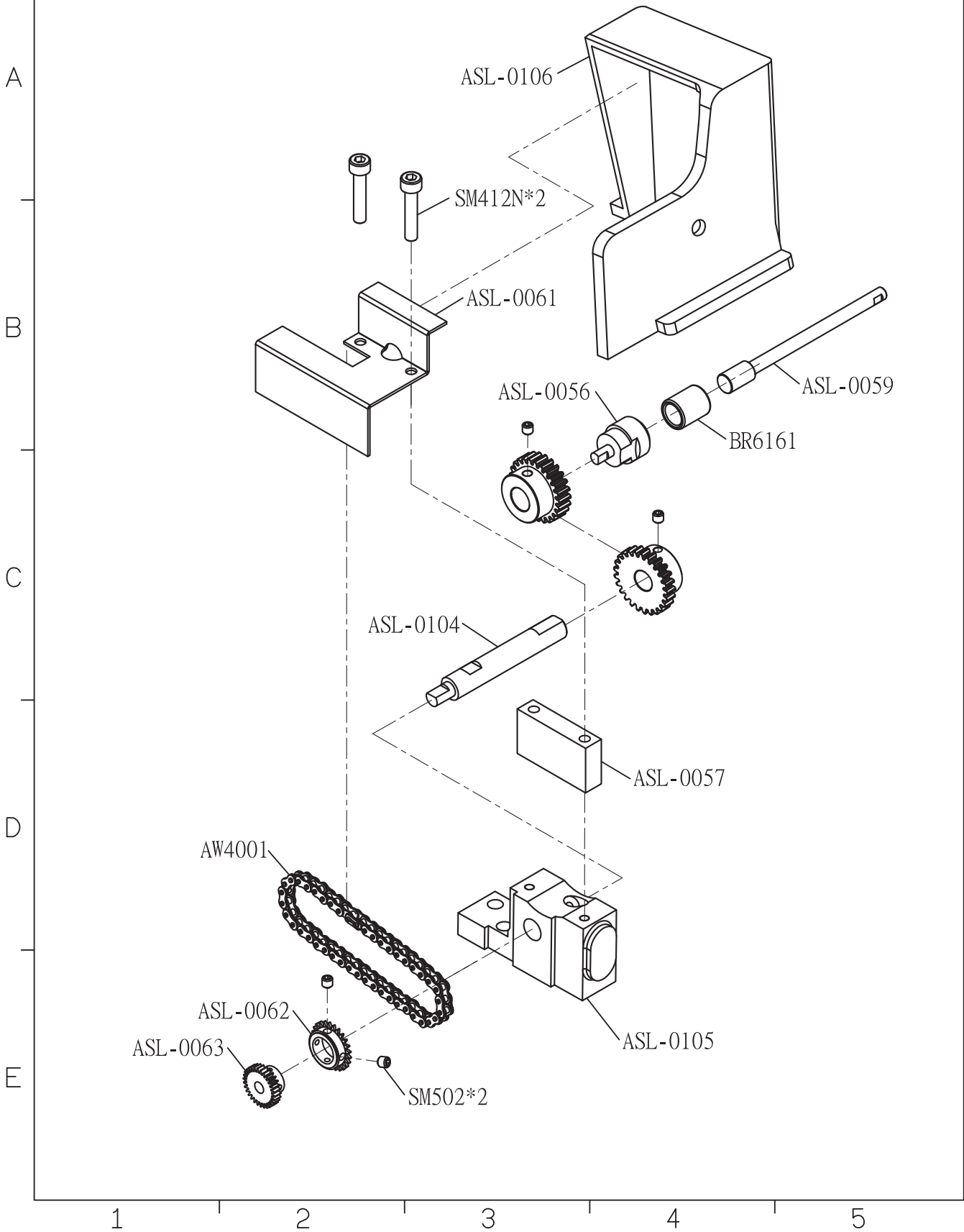
2

3

4

5

SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0105-A	-	2/16
				Date 2018/02/27



SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0107-A	-	3/16
				Date 2018/02/27

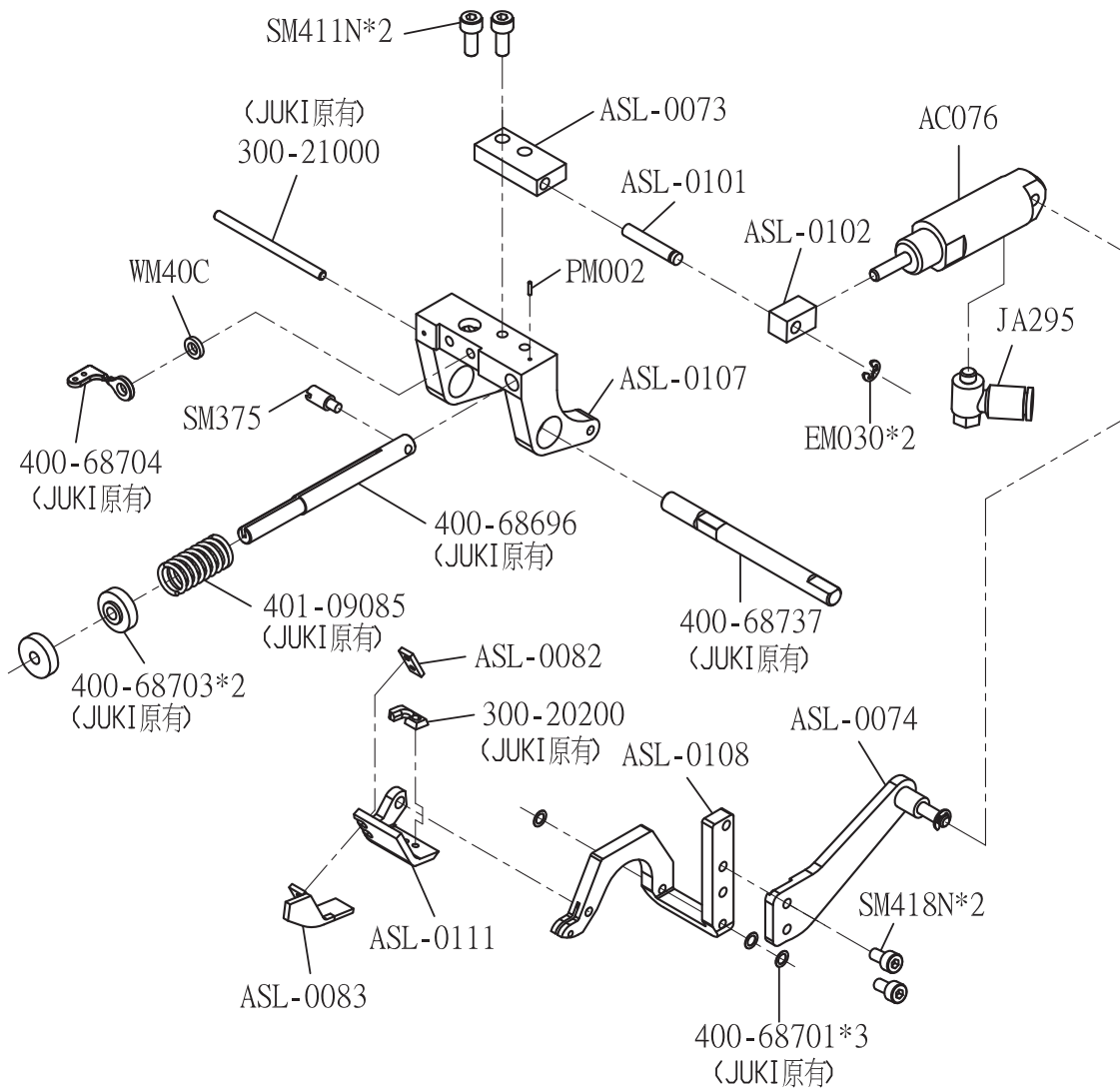
A

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1

2

3

4

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SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0071-A	-	4/16
				Date
				2018/02/27

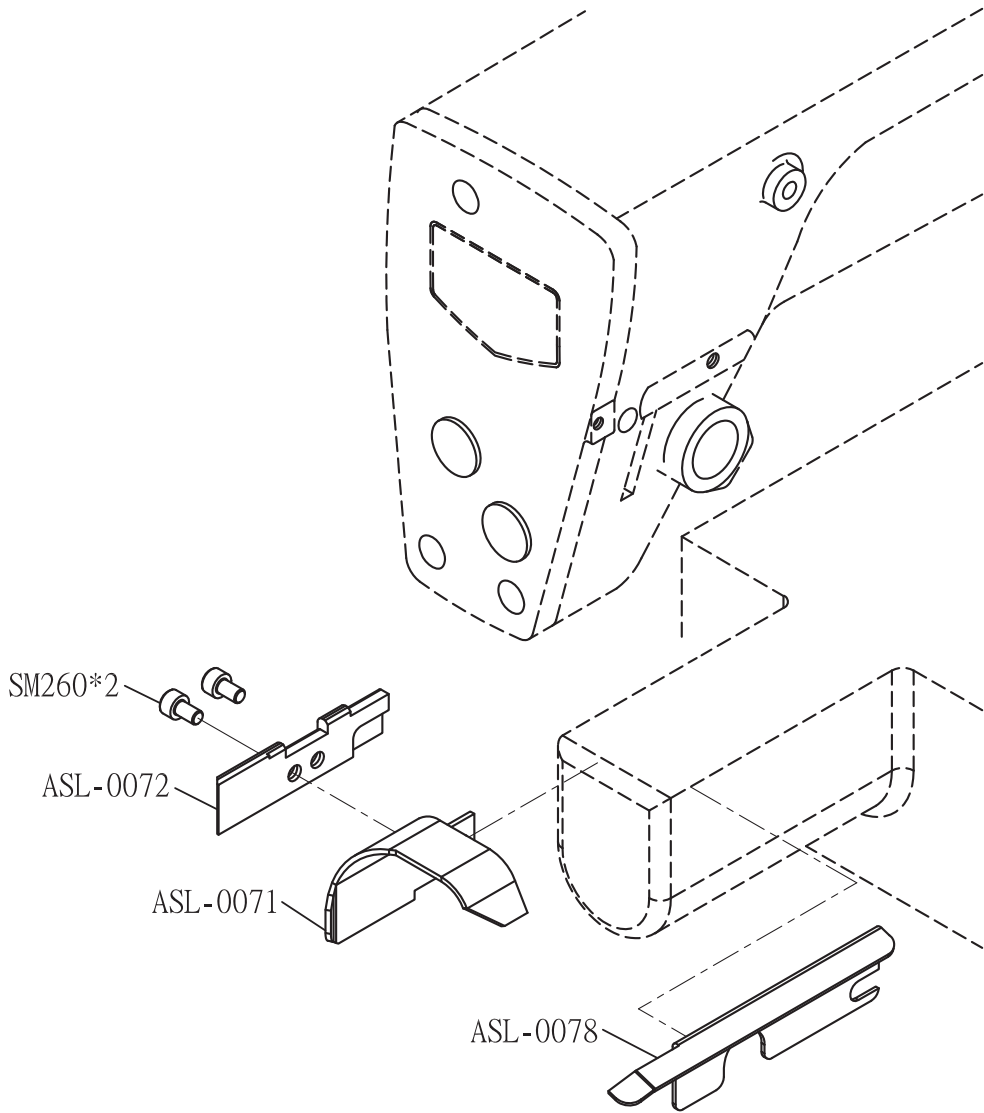
A

B

C

D

E



1

2

3

4

5

SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0001-A	-	5/16
				Date
				2018/02/27

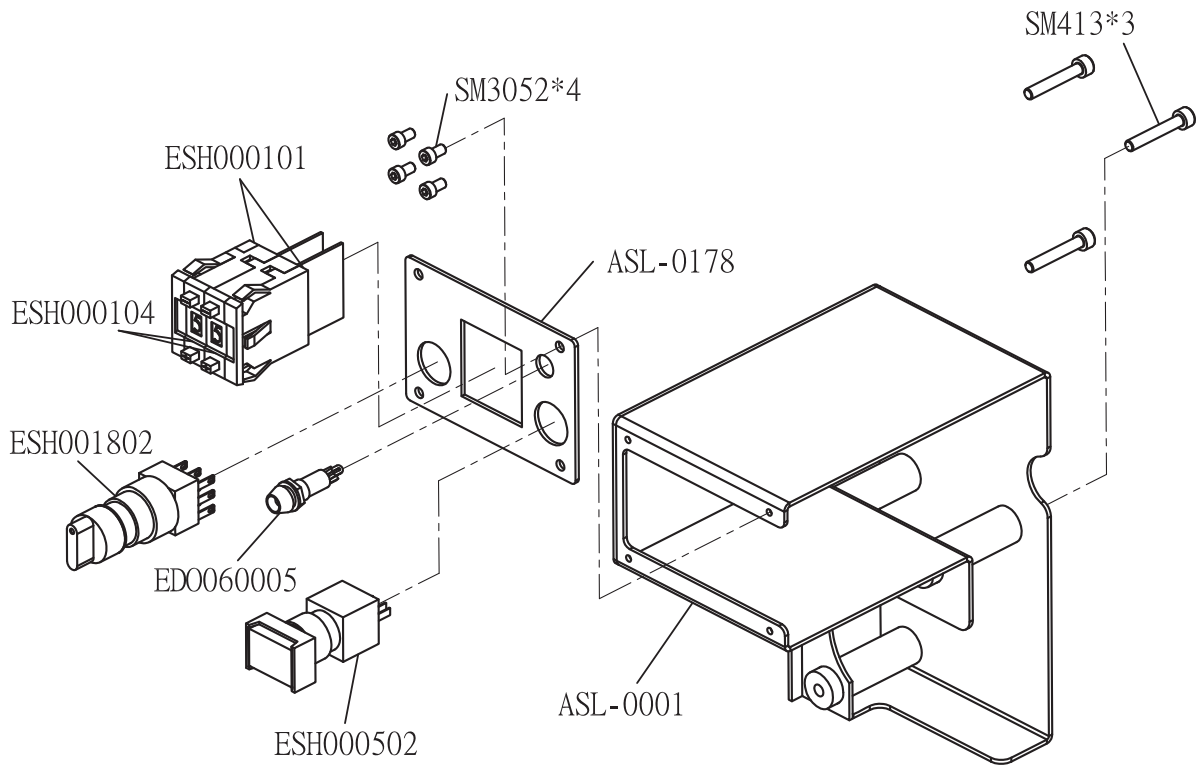
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SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0055-A	-	6/16
				Date
				2018/02/27

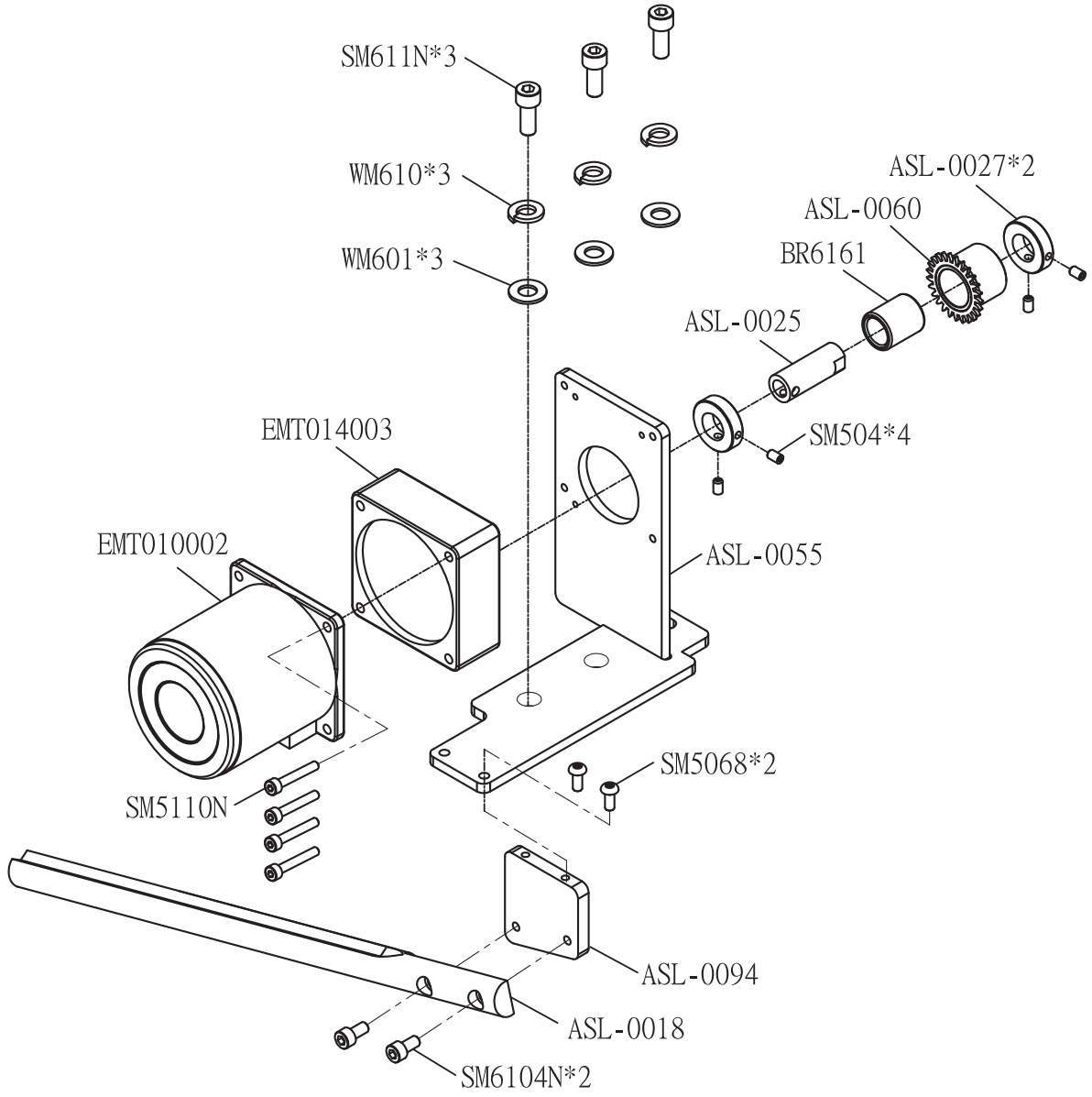
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SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0064-A	-	7/16
				Date
				2018/02/27

A

SM510N*2

SM8804

ASL-0035

B

ASL-0010

C

ASL-0018

ASL-0091

NM514

SM5106N

ASL-0064

D

ASL-0016

SM602*2

E

ASL-0054

BR4121*2

ASL-0058

SM556N

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SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0033-A		8/16
				Date 2018/02/27

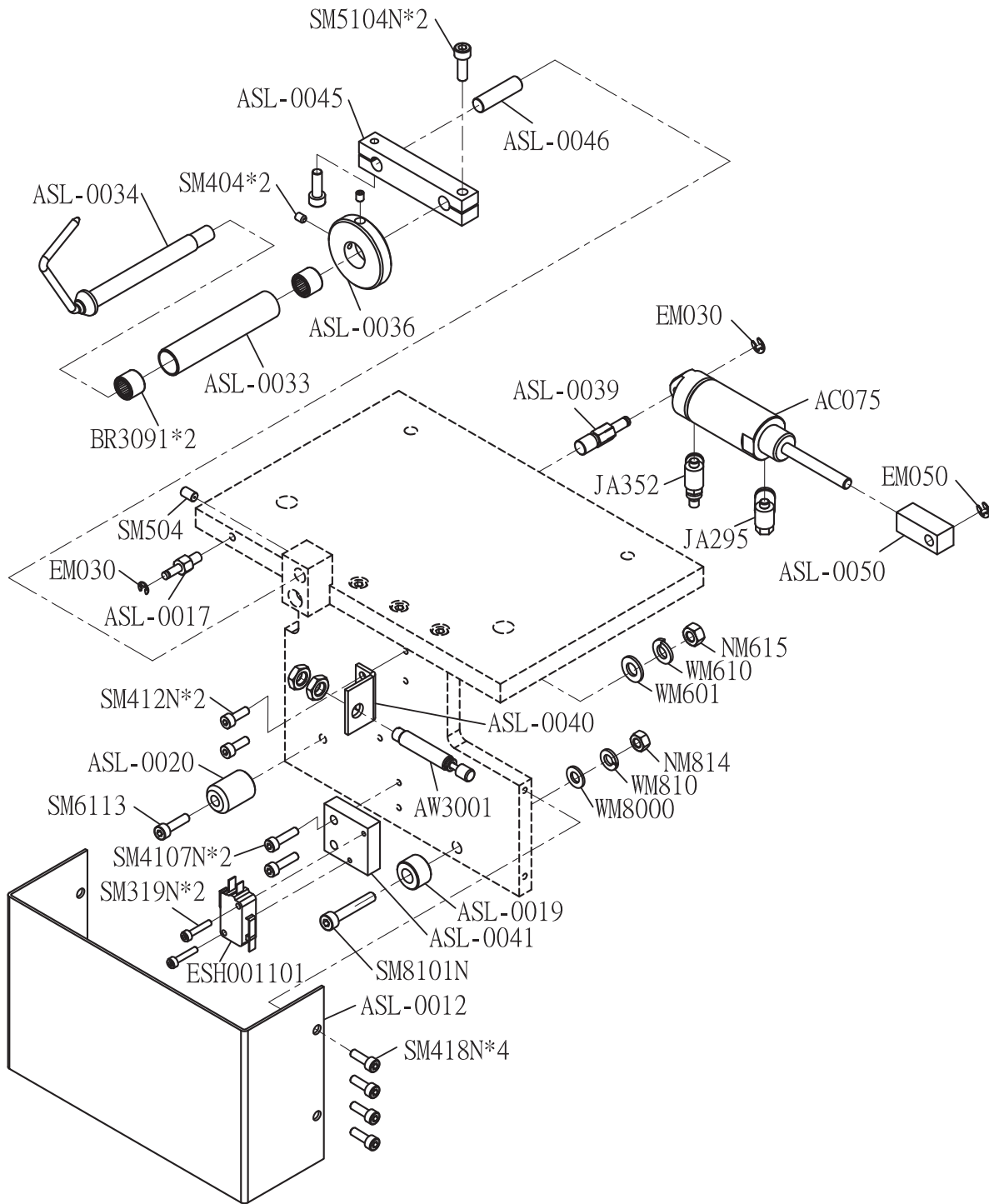
A

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SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0005-A	-	9/16
				Date 2018/02/27

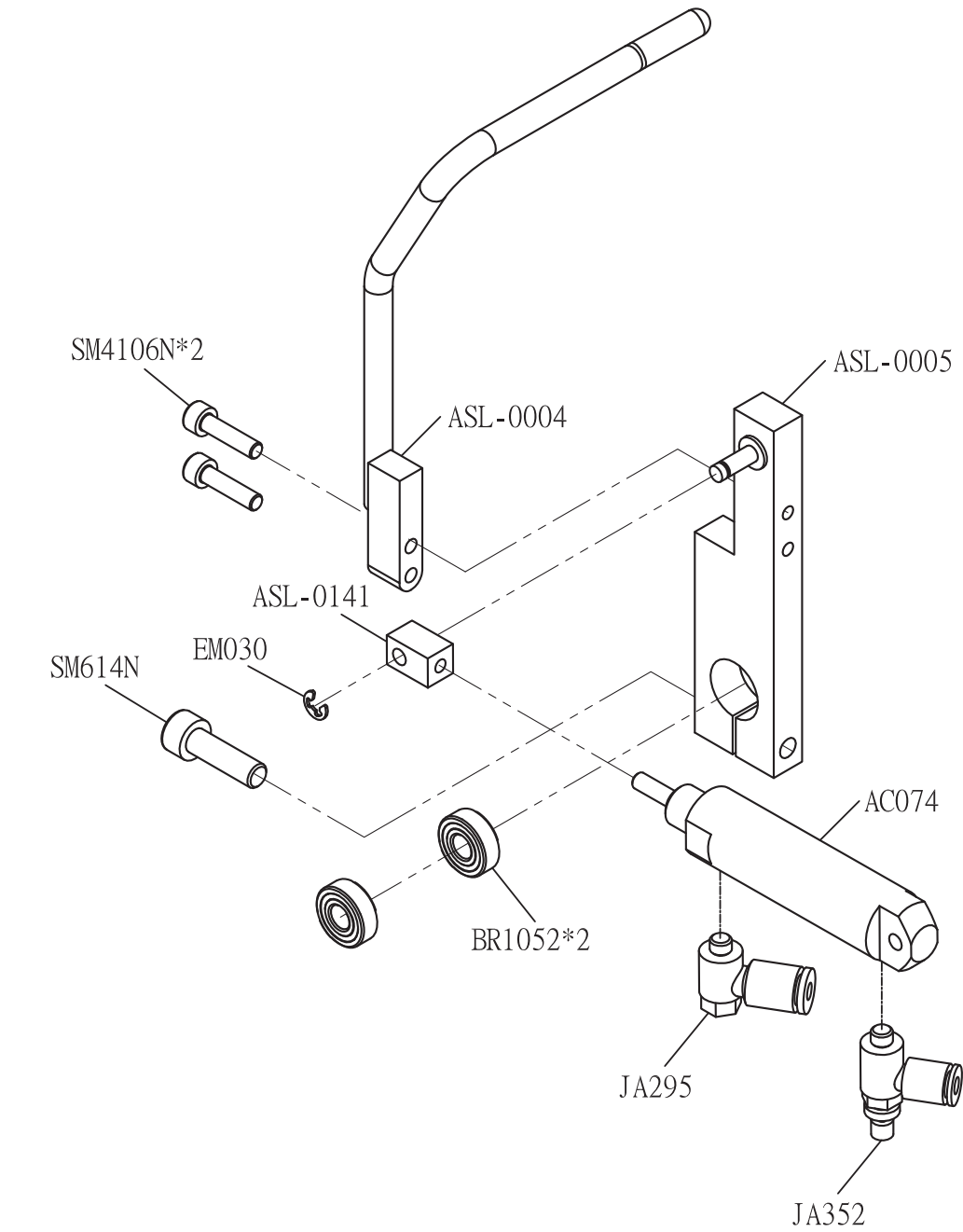
A

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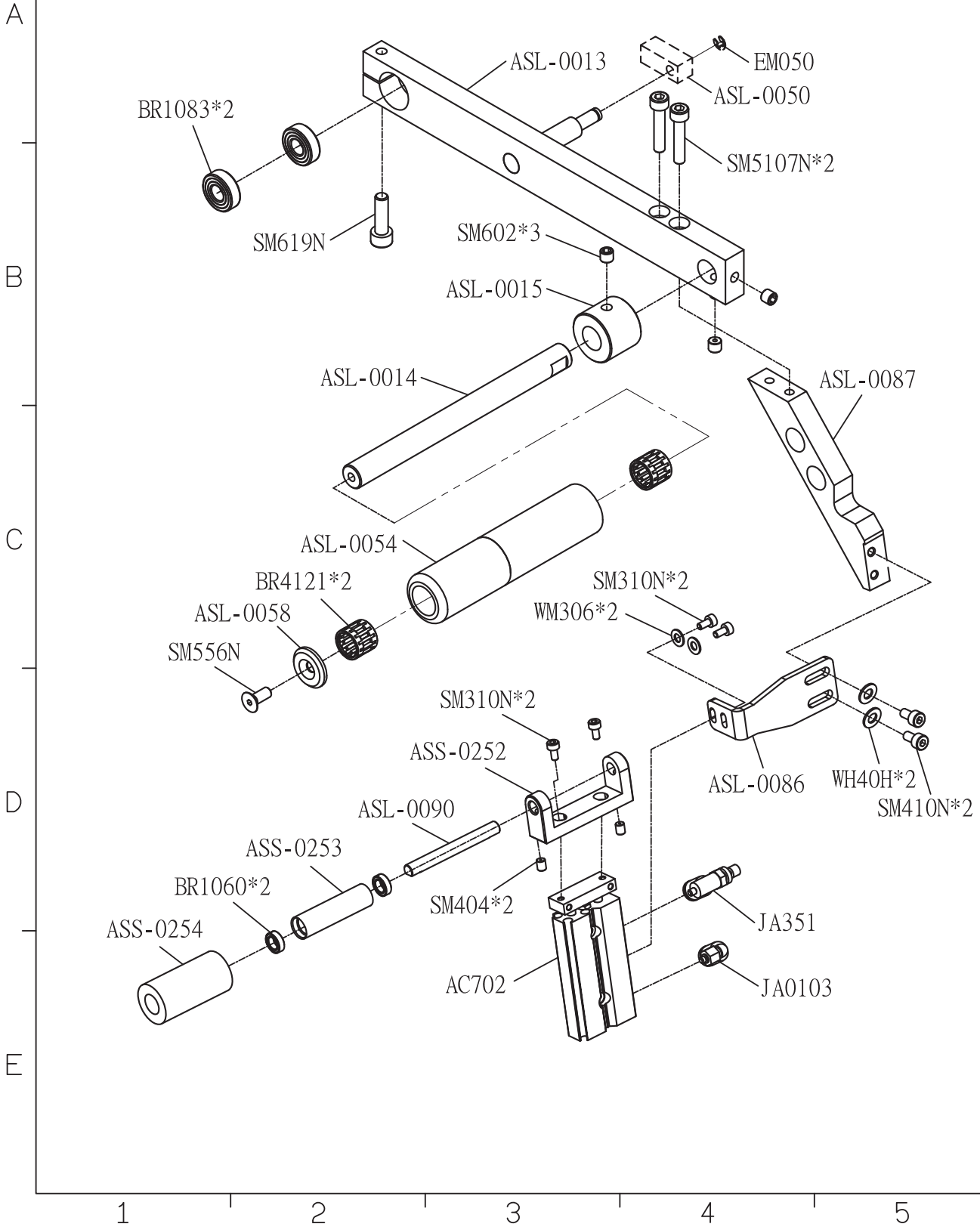
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SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0013-A	-	10/16
				Date 2018/02/27



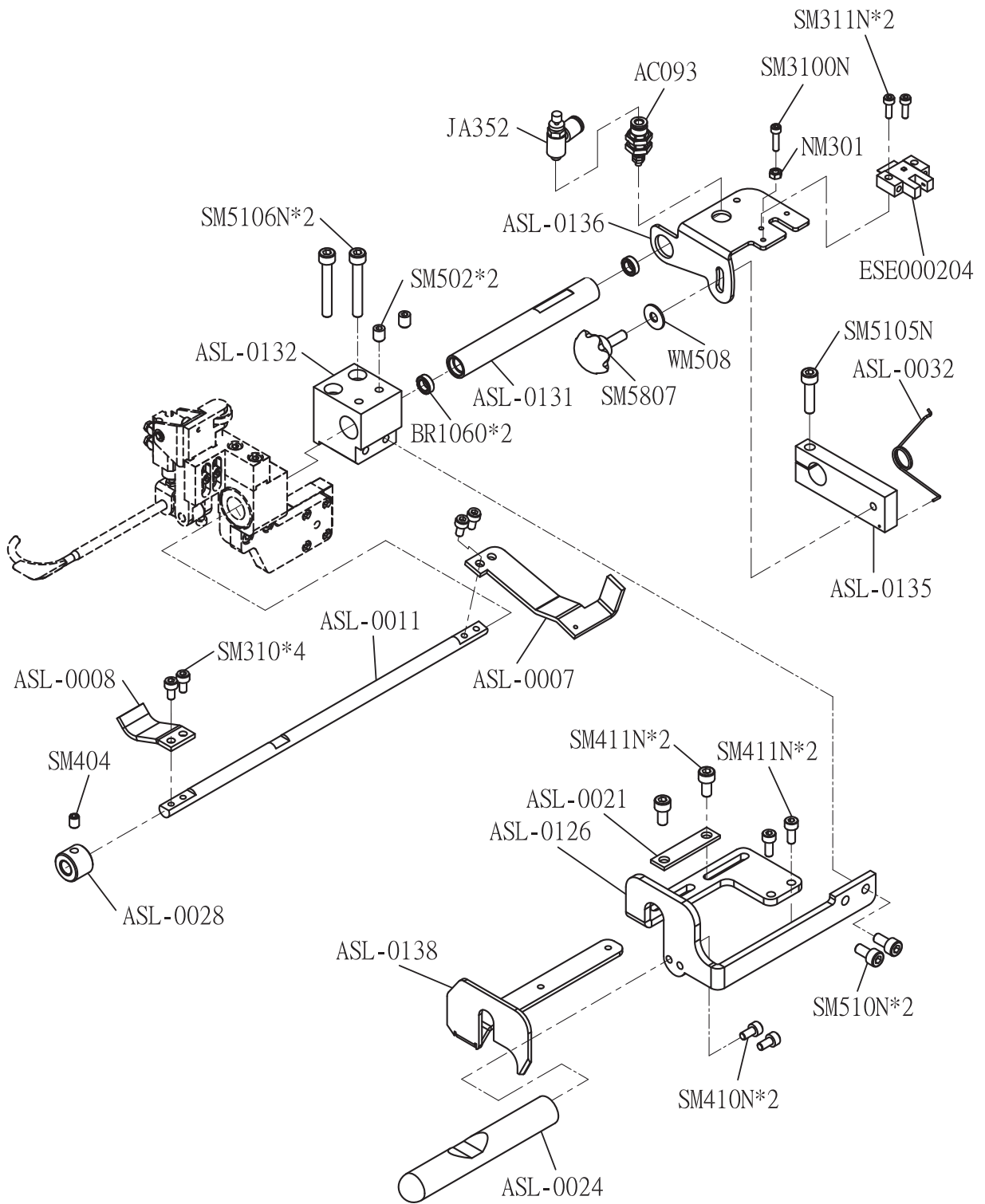
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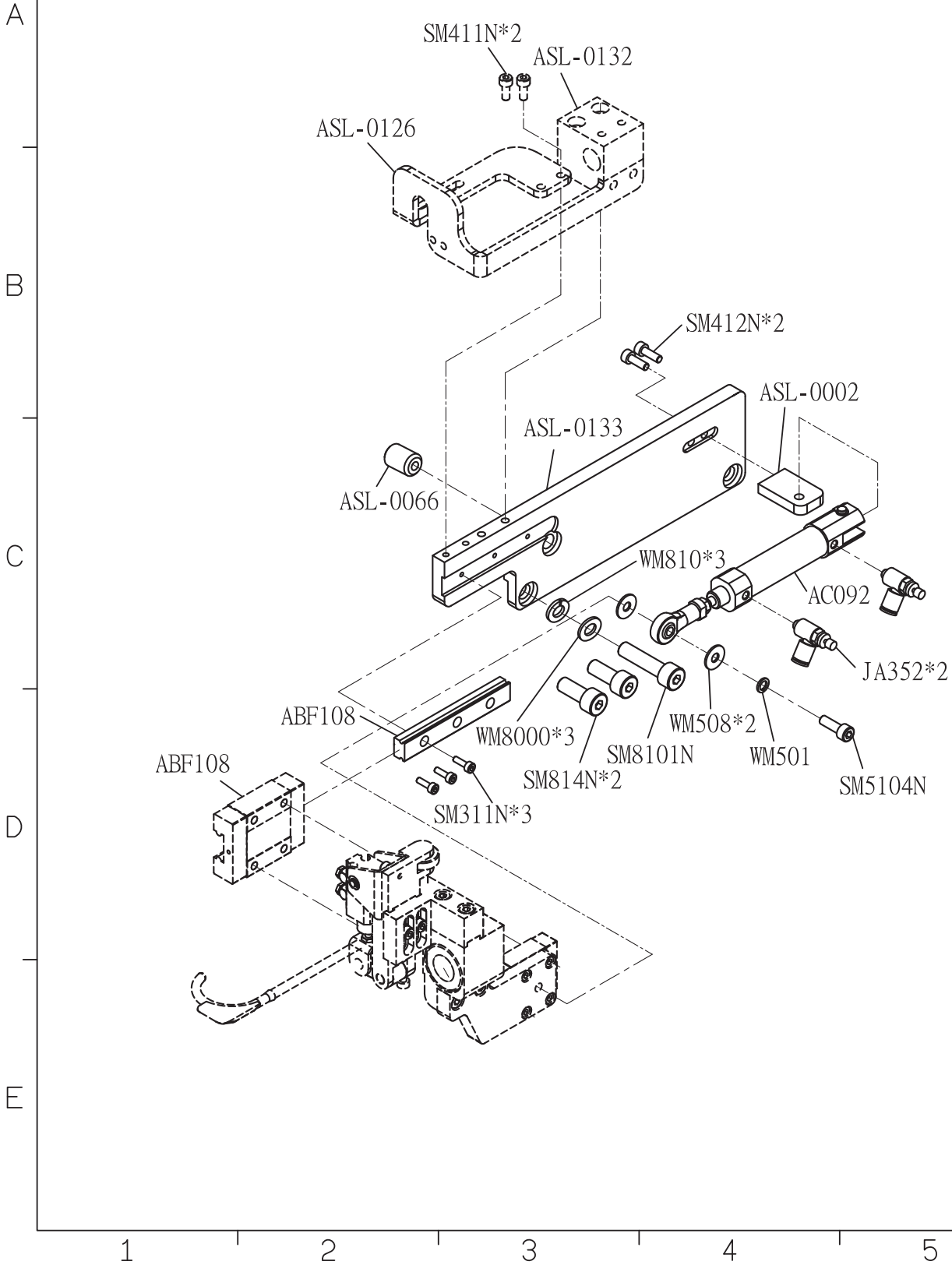
2

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SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0133-A	-	12/16
				Date 2018/02/27



SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0145-A	-	13/16
				Date
				2018/02/27

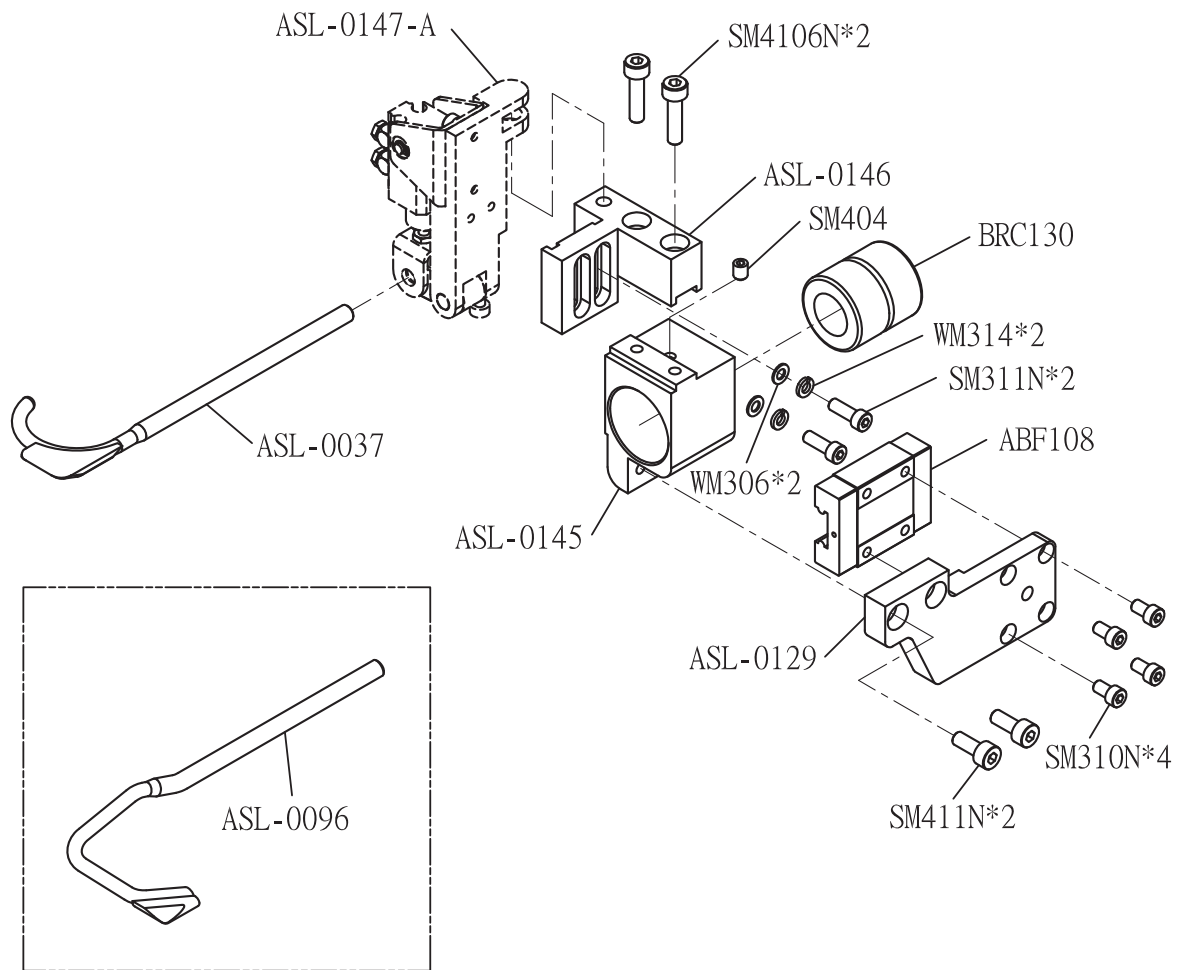
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SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0147-A	-	14/16
				Date 2018/02/27

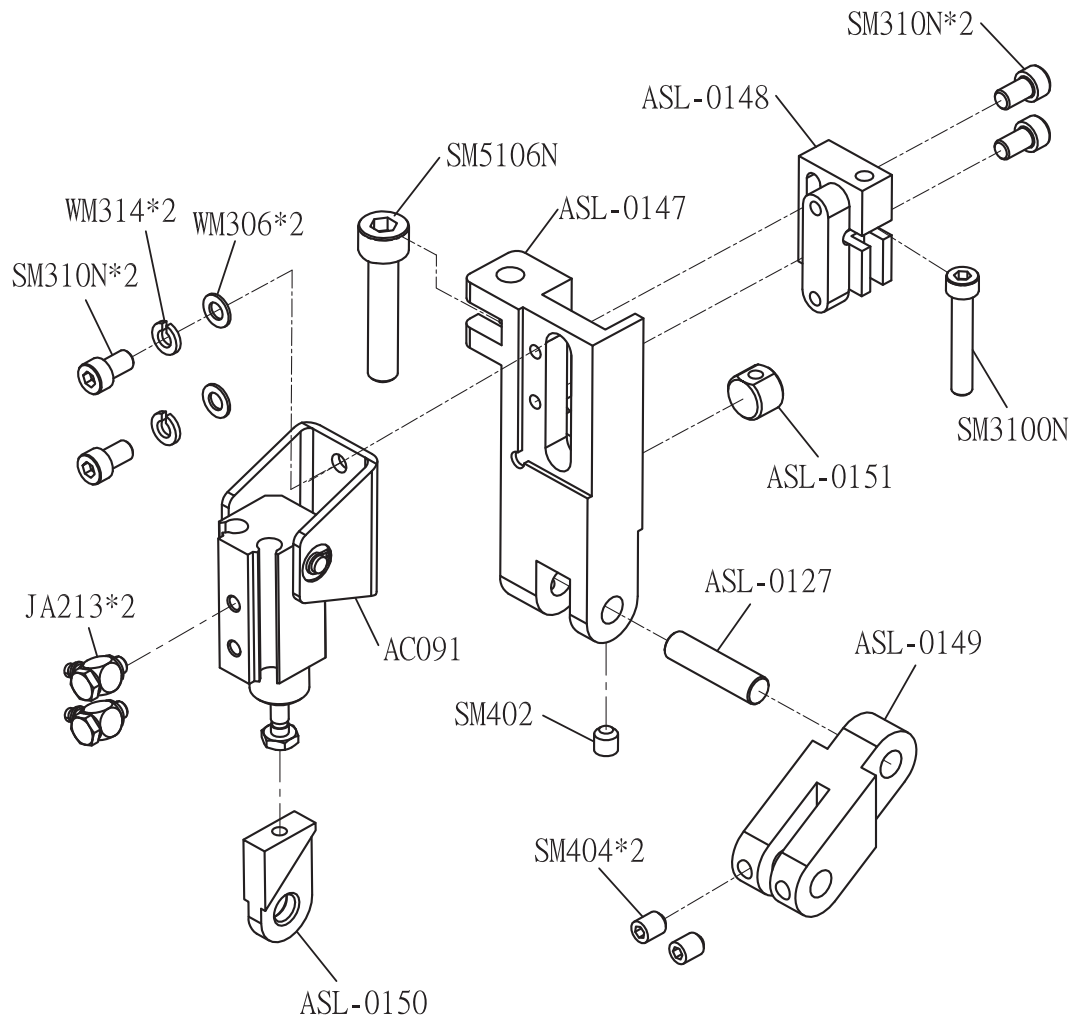
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SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0042-A	-	15/16
				Date
				2018/02/27

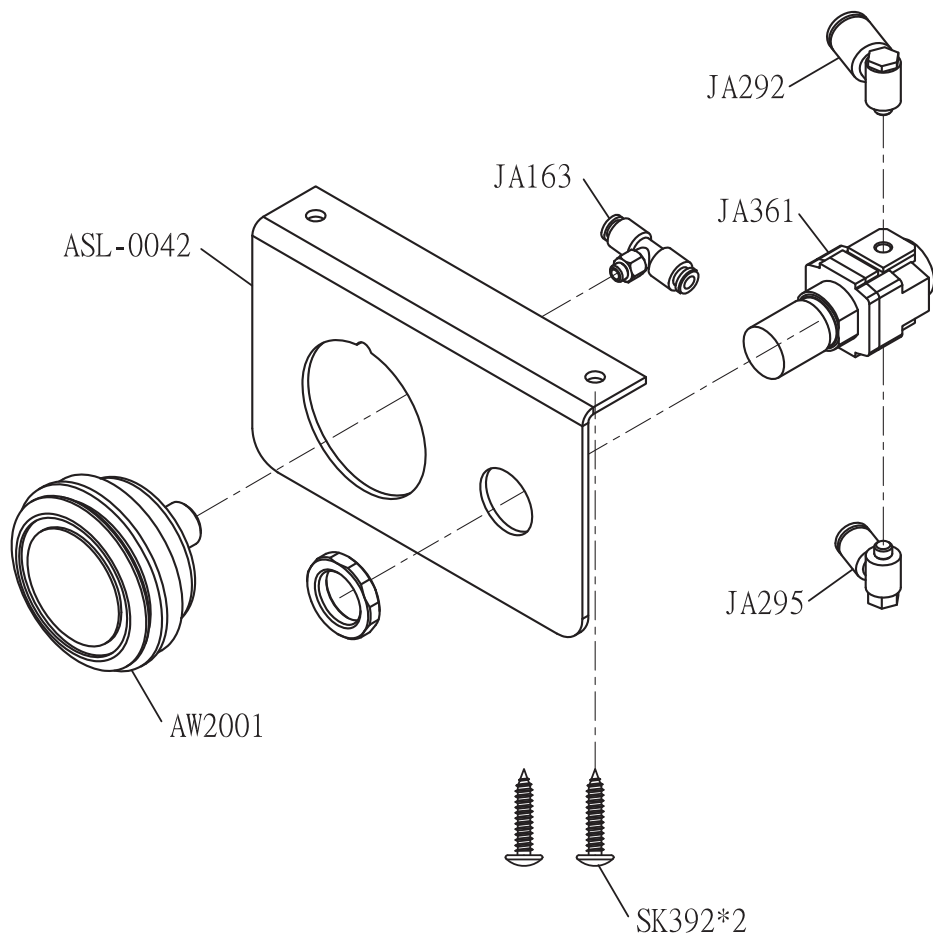
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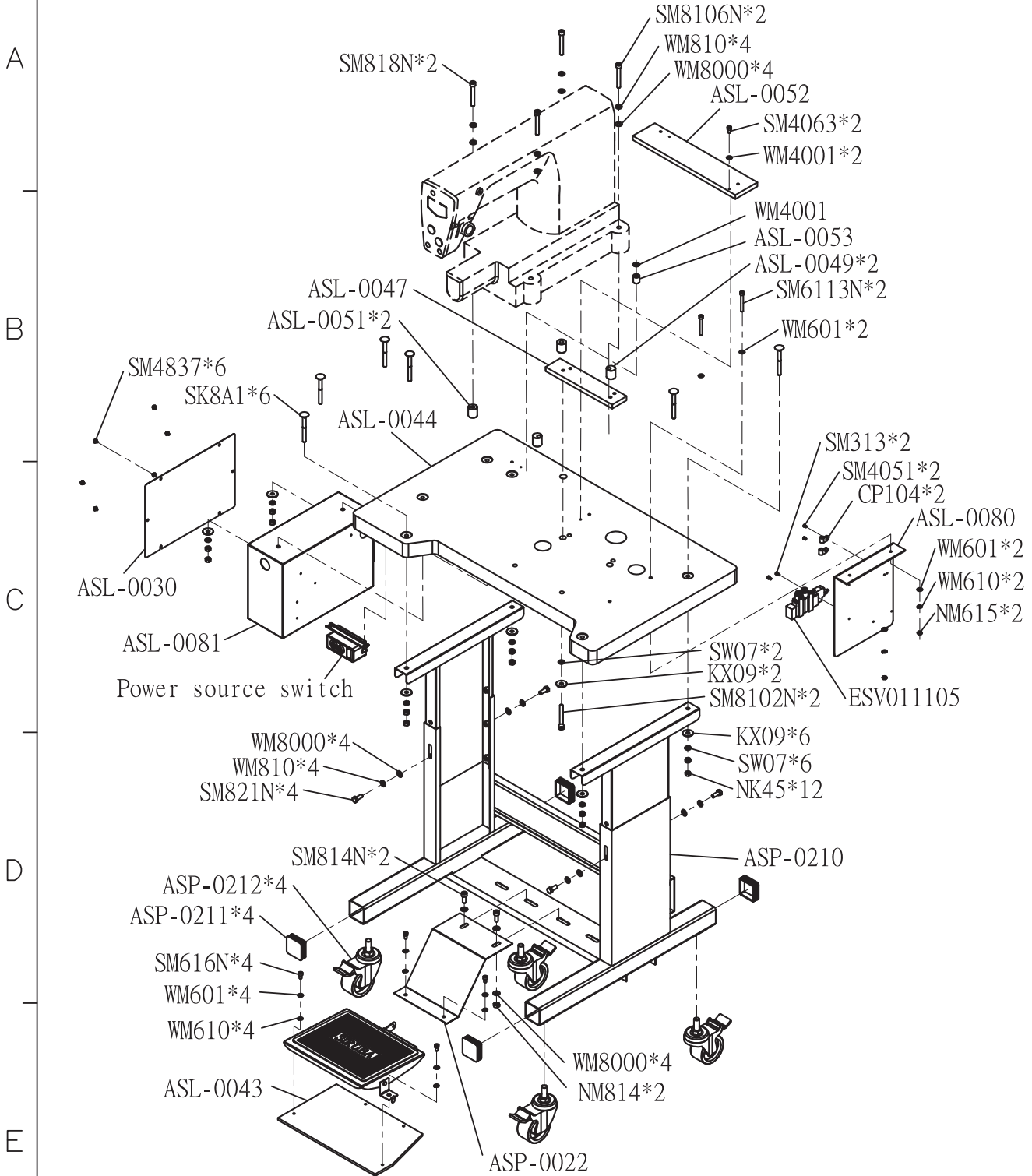
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SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	ASL-JBH100	ASL-0044-A	-	16/16
				Date
				2018/02/27



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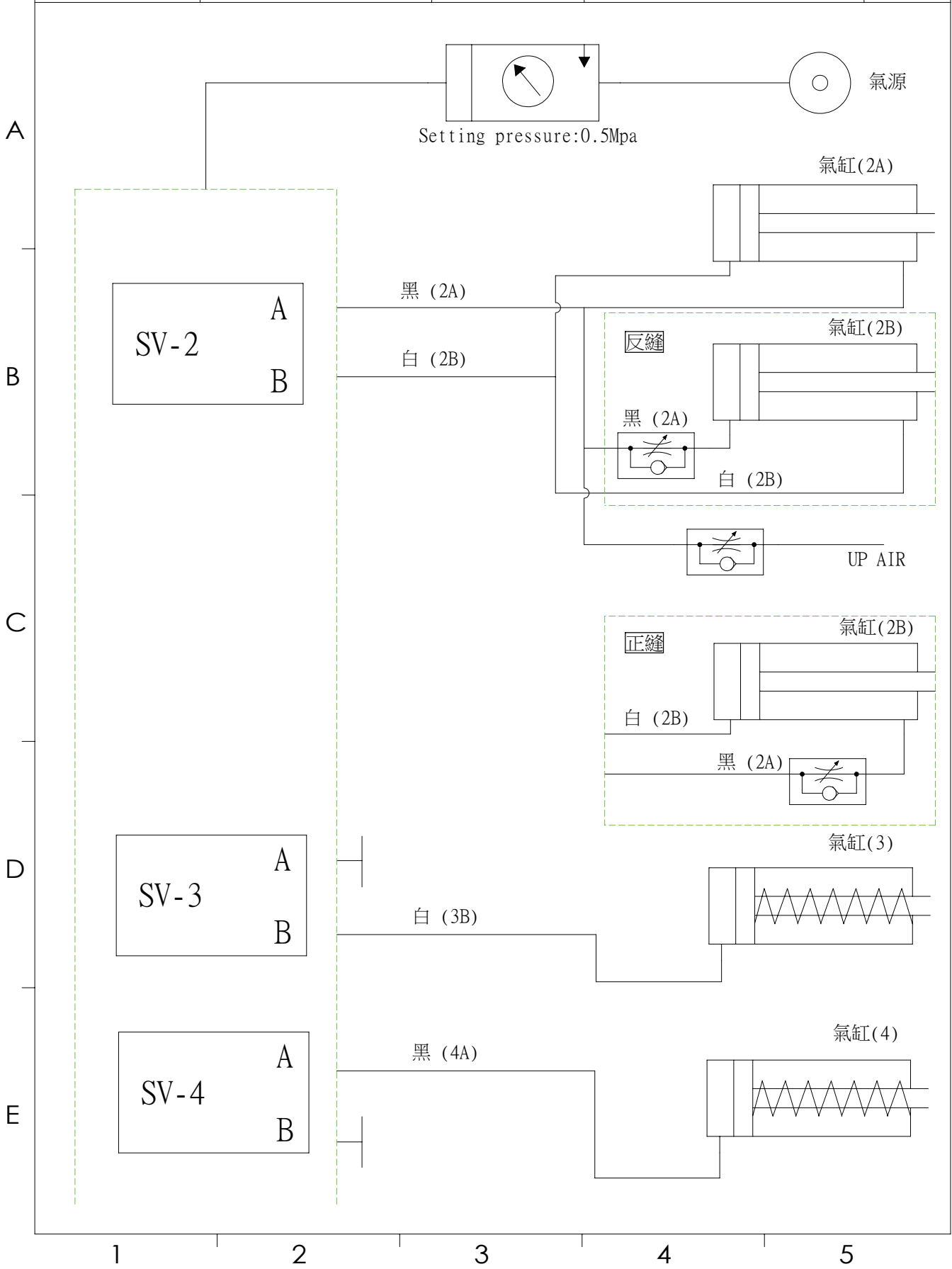
2

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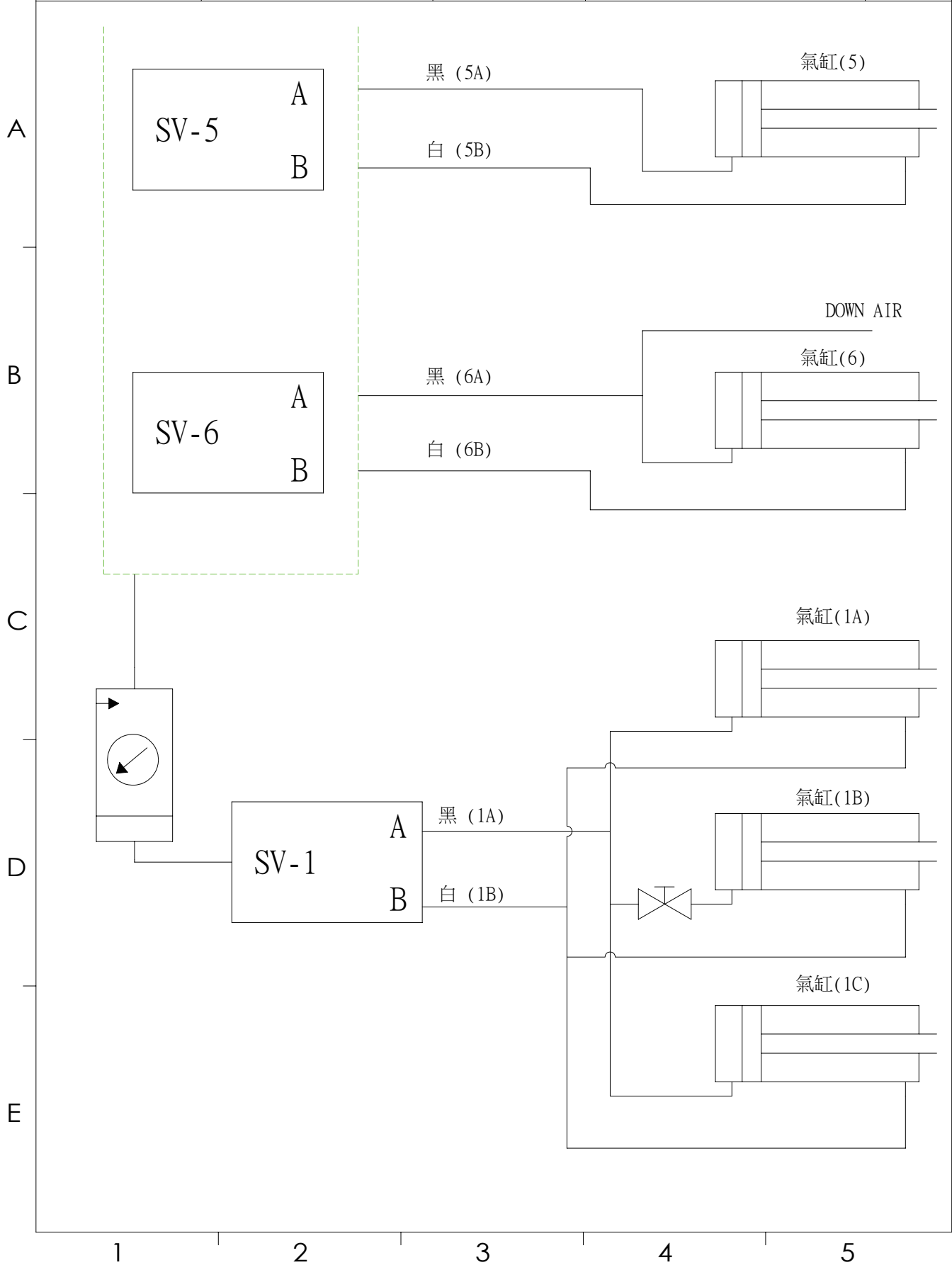
4

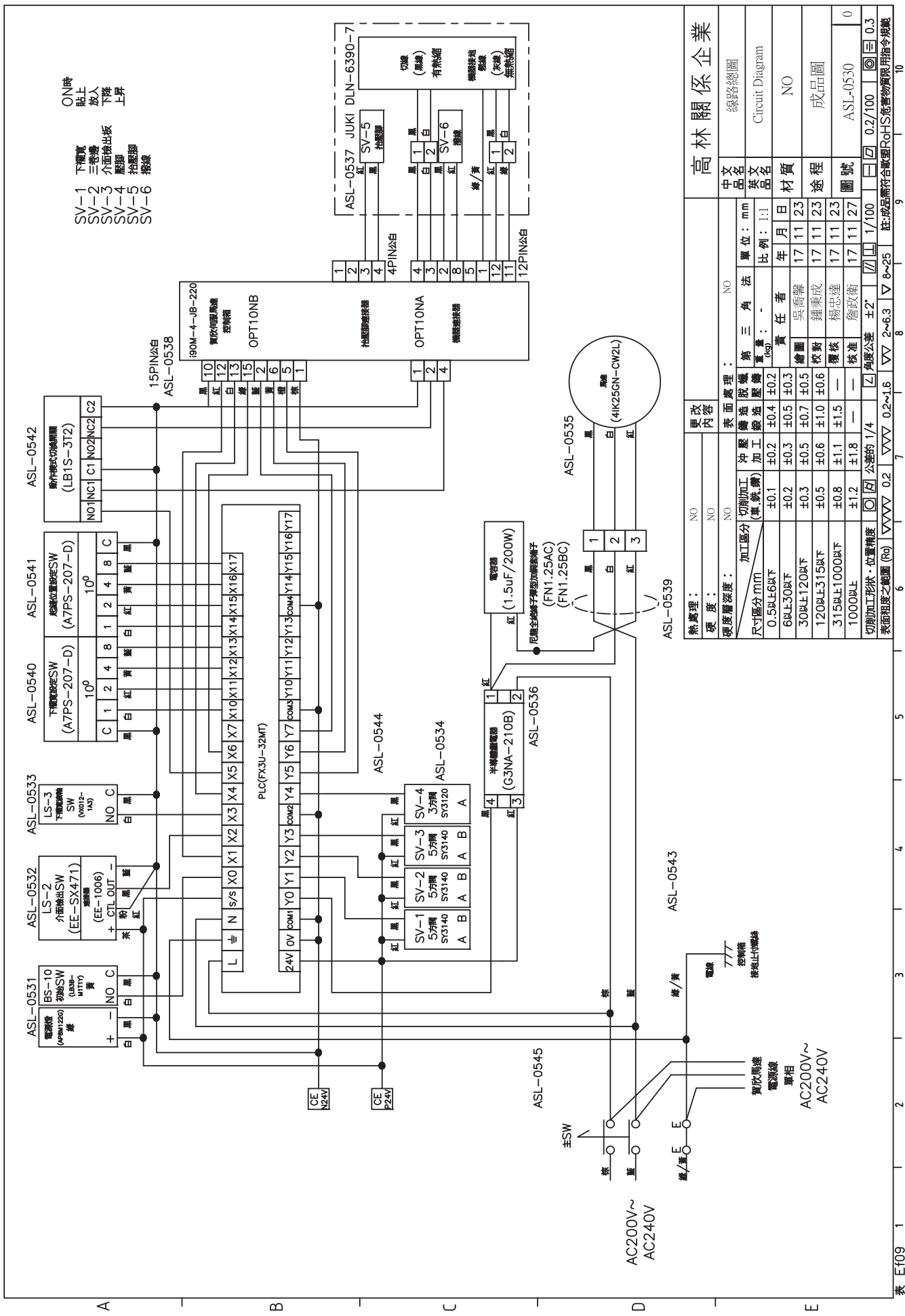
5

SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASL-JBH100	氣壓流程圖		1 / 2
				Date
				2017/07/19



SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASL-JBH100	氣壓流程圖		2 / 2
				Date
				2017/07/19





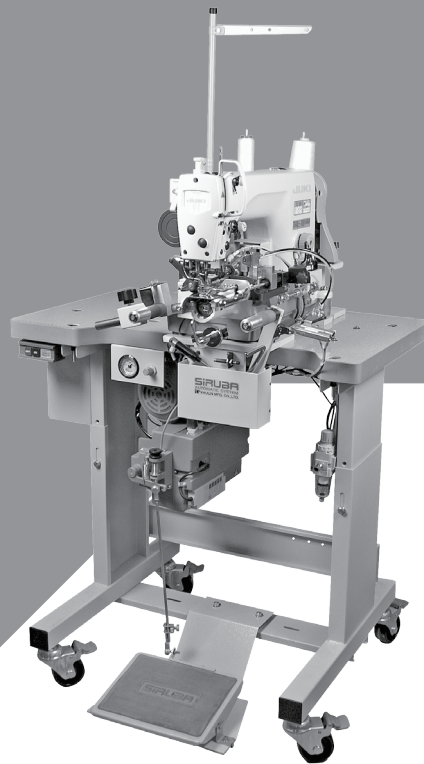
ON時
 貼上
 放入
 下壓
 上昇

下觸寬
 三卷邊
 介面輸出板
 壓腳
 捲線

SV-1
 SV-2
 SV-3
 SV-4
 SV-5
 SV-6

高林關係企業		線路總圖	
中文品名	英文品名	單位: mm	比例: 1:1
表面處理: NO		沖壓加工	NO
硬度: NO		加工	NO
硬層深度: NO		表面處理: NO	NO
尺寸區分	加工區分	切削加工	NO
0.5以上6以下	±0.1	衝壓	±0.2 ±0.4 ±0.2
6以上30以下	±0.2	鍛造	±0.5 ±0.3
30以上120以下	±0.3	加工	±0.5 ±0.7 ±0.5
120以上315以下	±0.5	壓鑄	±1.0 ±0.6
315以上1000以下	±0.8	切削	±1.1 ±1.5
1000以上	±1.2	鑄造	±1.8
切削加工形狀・位置精度	公差約 1/4	公差	±2
表面粗糙度之範圍 (Ra)	▽▽▽ 0.2	表面公差 ±2	▽ 1/100
註冊商標符合歐盟RoHS危害物質限制指令規範		註: 成品需符合歐盟RoHS危害物質限制指令規範	9

表 E109 1



 高林股份有限公司
KAULIN MFG. CO., LTD.

由於對產品的改良及更新，本產品使用說明書中之產品及外觀的修改恕不事先通知！
The specification and/or the equipment and appearances described in the instruction book are subject to change because of modification which will without previous notice.
ASL-0201_ASL-JBH100.MAR.2018