

**SIRUBA**<sup>®</sup> Sew Reach

使用說明書與零件圖

INSTRUCTION BOOK & PARTS LIST

■ ASP-JBL100



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-JBL100，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-EBJ100 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.

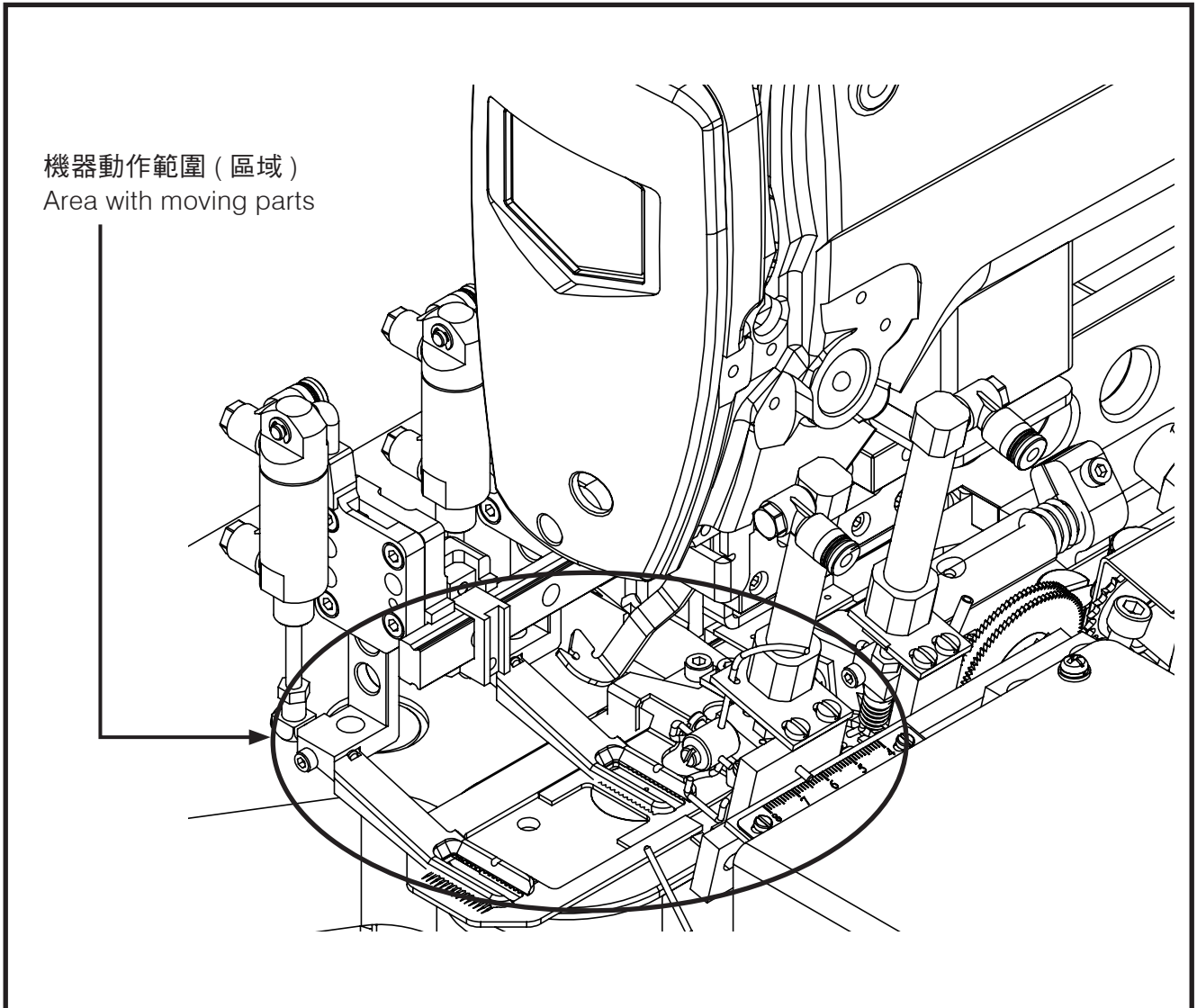
## 警告圖案表示

## 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><b>CAUTION</b></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>

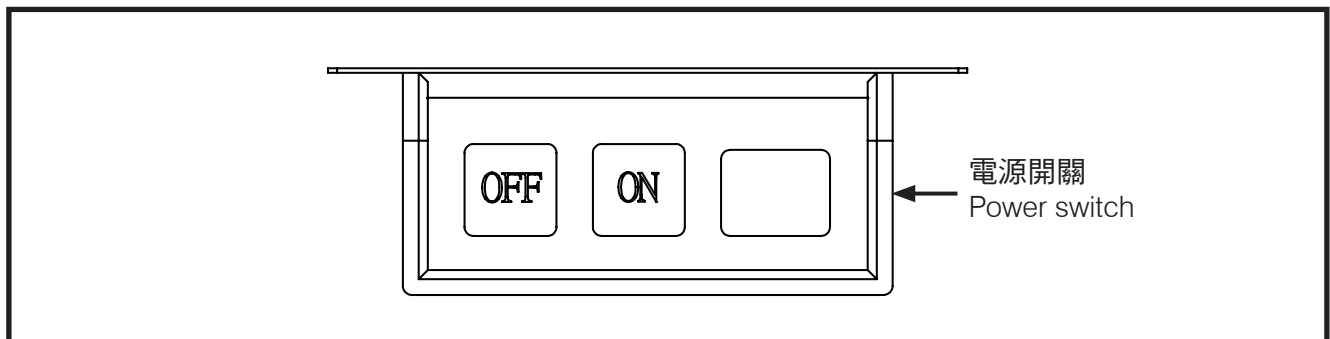
## 安全注意事項

## SAFETY INSTRUCTIONS



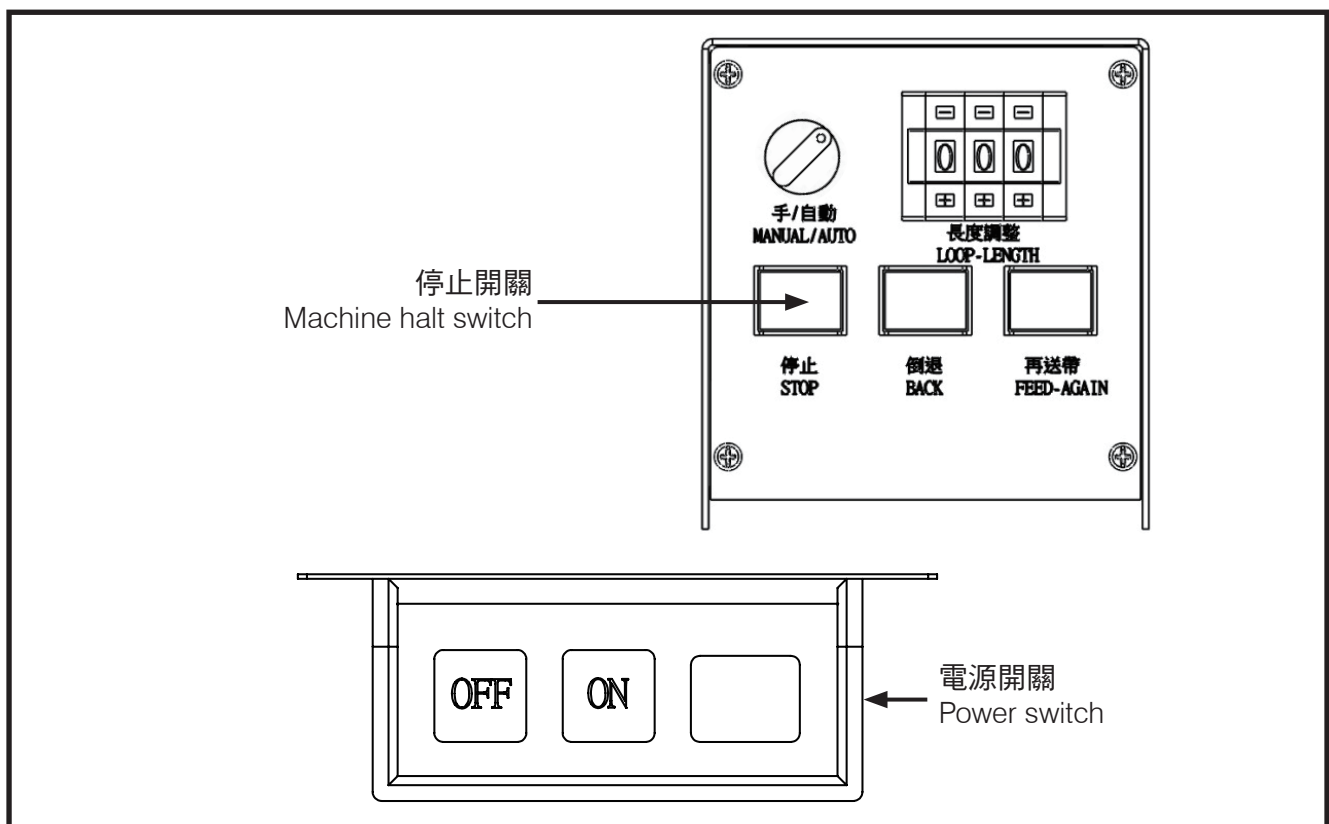
1. 機器在運轉時，不可將手指等放入該區域內。
2. 為了保修、檢修卸掉罩蓋時，必須將電源切到 OFF。

1. Do not put your fingers into the area while machine is operating.
2. Must switch off the power before take down the cover for repair and maintenance.



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，可以按下停止開關。並將（電源開關）切到 OFF。

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 stucked 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 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 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.

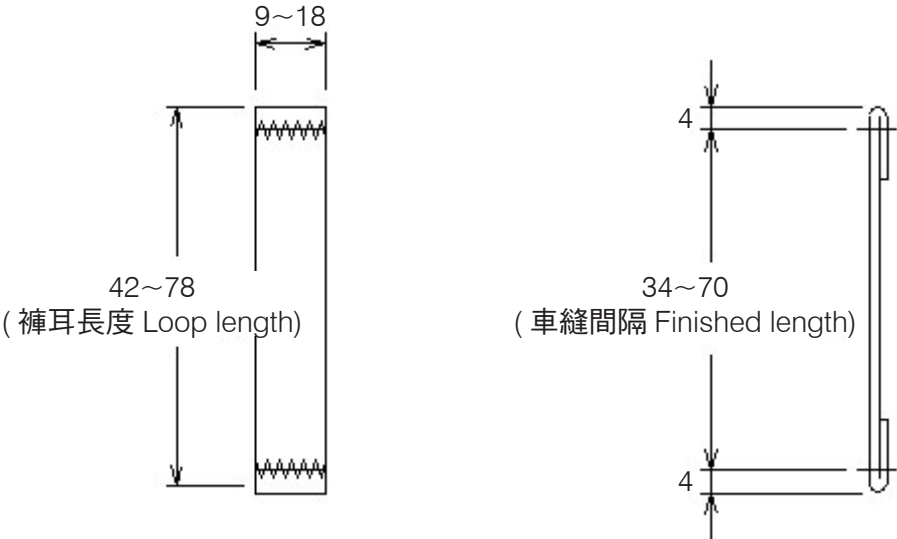
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## 規格

## SPECIFICATION

型式 Model	ASP-JBL-100
車縫型式 Sewing way	平縫 ( 高速電子套結機 ) Lockstitch single needle
車縫速度 Sewing speed	最高 2000 針 / 分 Max 2000 Rpm/Min
使用針 Typed needle	風琴牌 DP×17 # 19~21
褲耳長度 Loop length	42~78mm ( 標準出廠設定值 Default : 65mm )
褲耳寬度 Loop width	9~18mm ( 標準出廠設定值 Default: 13mm )
車縫範圍 Sewing range	垂直 0~3mm ( 最大 ) Y axis 0~3mm
	水平 5~22mm ( 最大 ) X axis 5~22mm
<p>褲耳車縫尺寸 Loop Sewing size</p> 	
電源電壓 Voltage	額定 Rated $\pm 10\%$ 50/60Hz
消費電力 Voltage consumption	550VA ( 最大 Max )
氣壓 Air Pressure	0.5 Mpa ( 5Kg/cm <sup>2</sup> )
氣體消耗量 Air consumption	1.4 公升 Litre / 每一褲耳 Loop

## 安裝

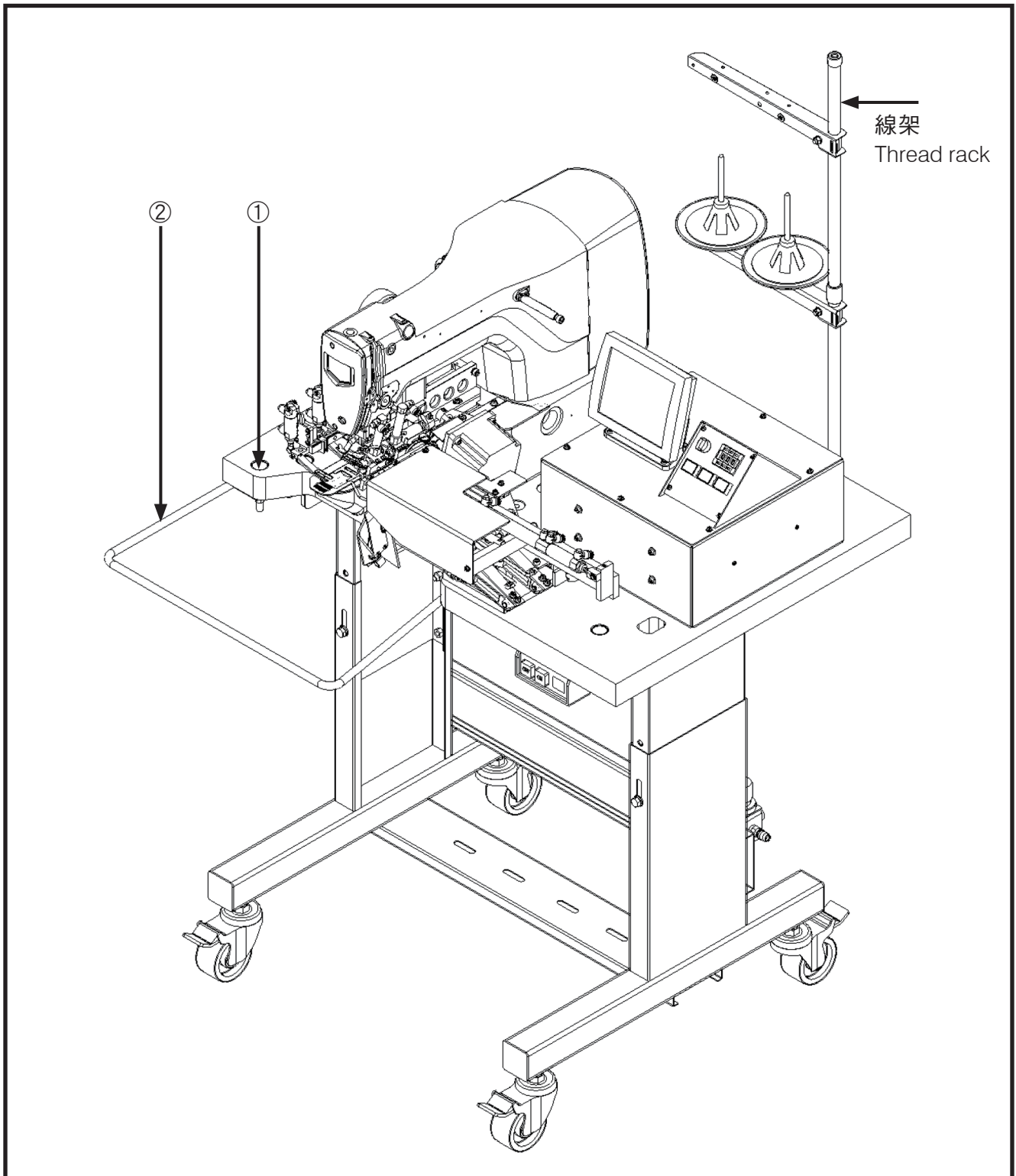
## INSTALLATION

桌板①上，鎖付支架②及線架。

(線架組裝組請參照 LK-1900A 使用說明書。)

Install holding rack ② and thread rack on the table ①.

(Ref LK-1900A user manual.)



## 運轉準備

## SPECIFICATION

### 1. 電源電壓

- A. 使用定額電壓  $\pm 10\%$ 。
- B. 接地線一定要接地。

### 2. 氣壓

- A. 使用 0.5 Mpa (5kg/cm<sup>2</sup>)。

### 3. 供油

- A. 縫紉機頭部  
請參照 LK-1900A 使用說明書。
- B. 供給裝置  
指標 a 部分一定要加油。(8 處)

### 1. Voltage

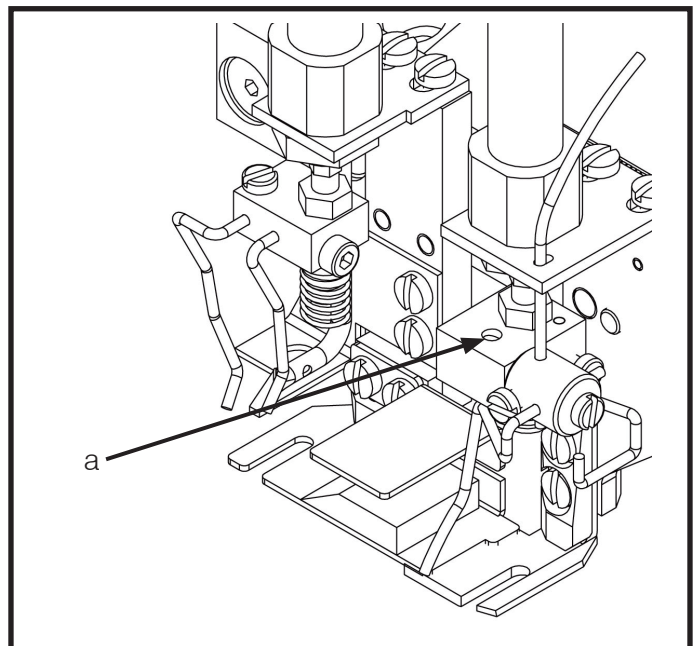
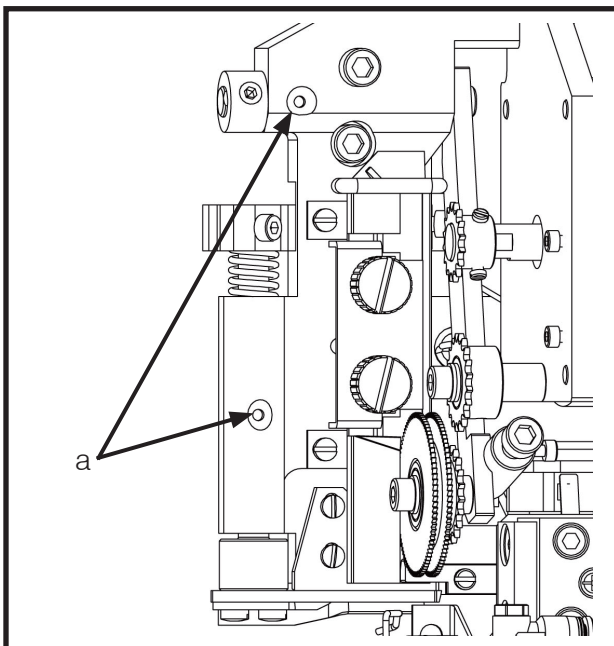
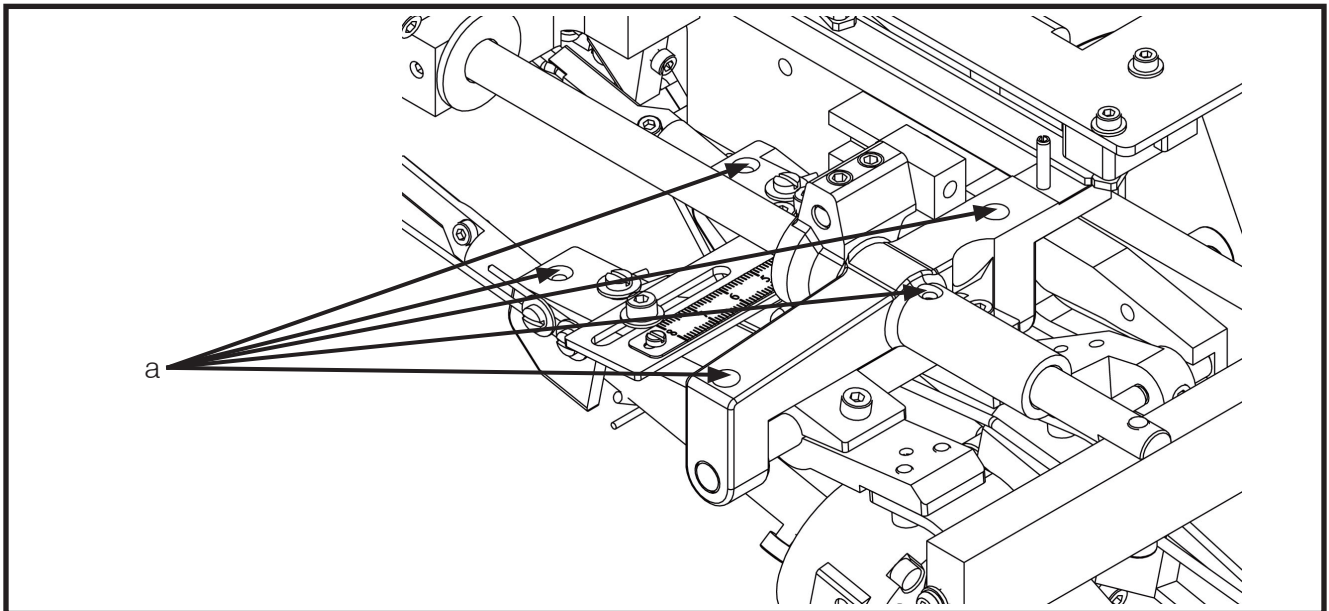
- A. Steady voltage at  $\pm 10\%$ 。
- B. Earth cable must be in contact with ground.

### 2. Air pressure

- A. Use 0.5 Mpa (5kg/cm<sup>2</sup>)。

### 3. Oil Supply

- A. Sewing Machine  
Ref LK-1900A user manual.
- B. Supply device  
Oil must be added on indicated "a" below.  
(8 areas)

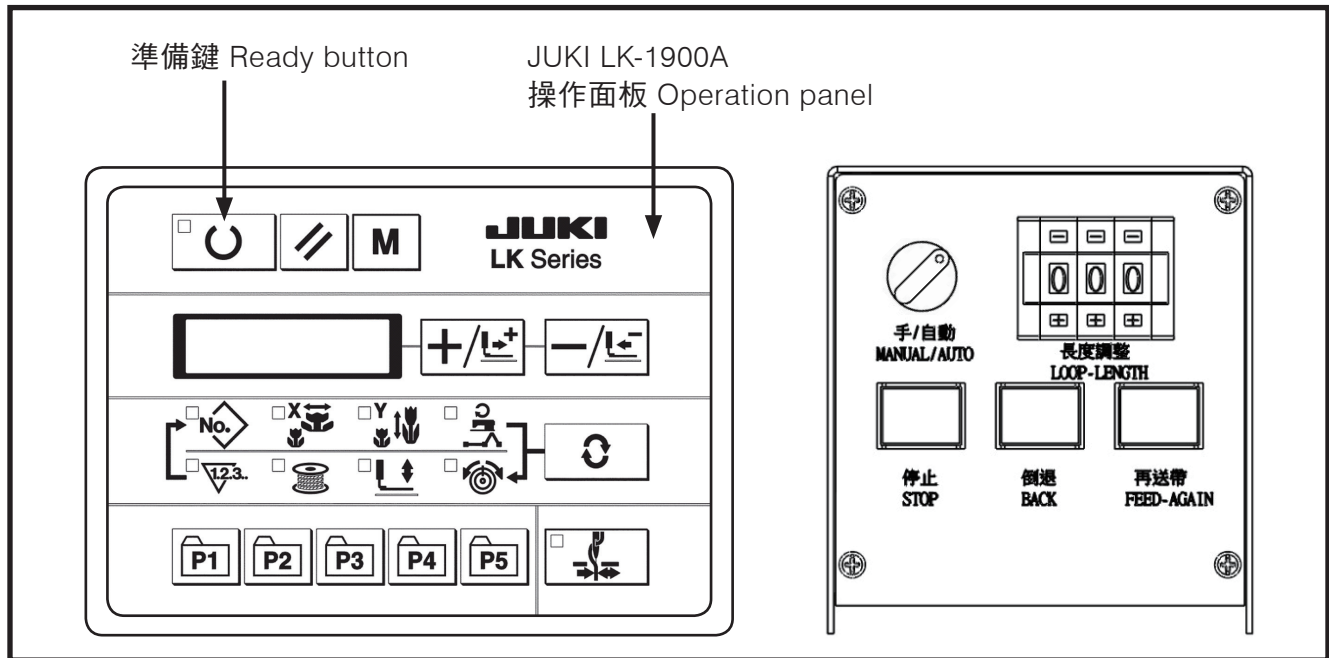


## 操作開關

## OPERATION SWITCH

### 1. 操作面板

### 1. Operation panel



### 操作面板說明

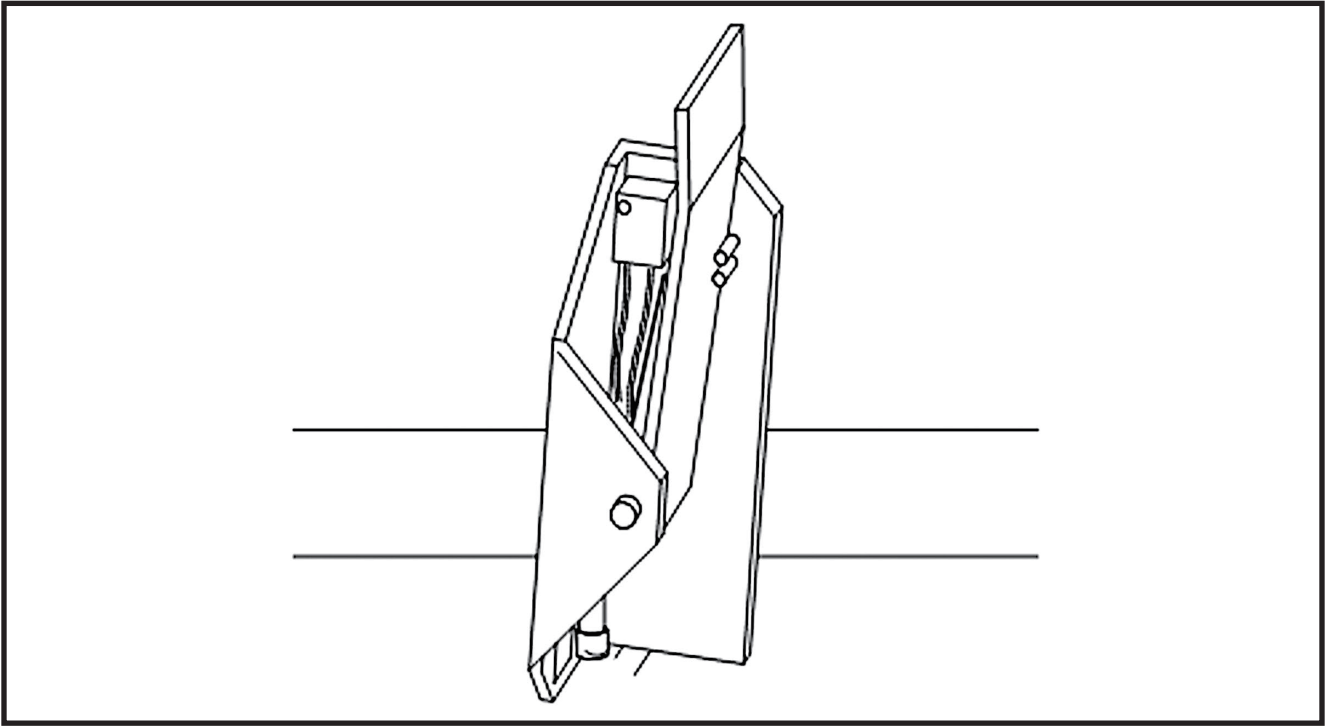
### Operation panel guide

名稱 Name	機能 Function
" 停止 " 開關 (紅) Stop Switch (Red)	<ul style="list-style-type: none"> <li>● 車子動作停止。</li> <li>● 待機狀態時壓下的話、壓腳就會下降。</li> <li>● Machine movement stop.</li> <li>● Pressing this button during standby made, foot litter will drop.</li> </ul>
" 倒退 " 開關 (黃) Back Switch (Yellow)	<ul style="list-style-type: none"> <li>● 只有「自動」時有效。</li> <li>● 按停止鍵降下的壓腳使之前進或後退。</li> <li>● Only Operational under "Automatic" made.</li> <li>● By Pressing the stop button the foot lites will move back and forth.</li> </ul>
" 再送帶 " 開關 (白) Feed Again Switch (White)	<ul style="list-style-type: none"> <li>● 重新再送一次褲耳。</li> <li>● Feed loop again.</li> </ul>
" 長度調整 " 開關 Loop length	<ul style="list-style-type: none"> <li>● 定位褲耳送料出長度。(最大設定長度 120mm)</li> <li>● Adjust loop length. (Max length 120mm)</li> </ul>
" 手 / 自動 " 切換開關 Manual/Auto Switch	<ul style="list-style-type: none"> <li>● 電源「ON」時切換無效。</li> <li>● 「自動」側 ... 自動運轉</li> <li>● 「手動」側 ... 成車單獨運轉</li> <li>● While Power is "ON" switch are ineffective.</li> <li>● Automatic mode: Operation</li> <li>● Manual mode: Machine operate manually</li> </ul>
" 準備鍵 " 開關 Ready	<ul style="list-style-type: none"> <li>● 從動作停止的待機狀態, 回復到準備</li> <li>● From stand-by mode, return to ready mode.</li> </ul>

JUKI LK-1900A 操作面板使用上、請參照 LK-1900A 使用明書。  
JUKI LK-1900A Operation panel, Ref LK-1900A user manual.

## 2. 起動鍵

Start switch



## 起動鍵說明

Start switch guide

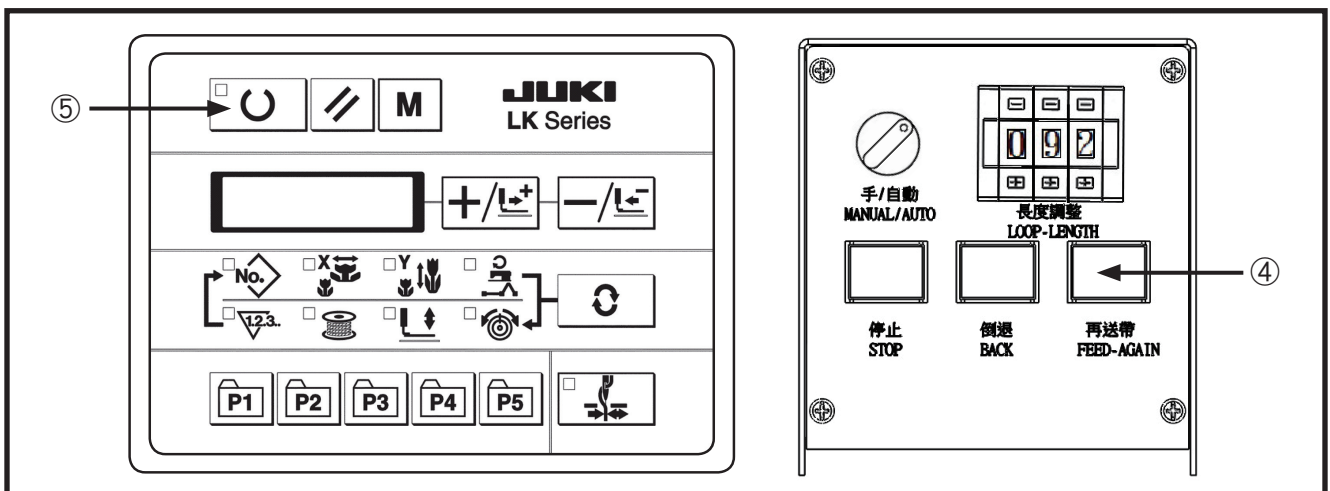
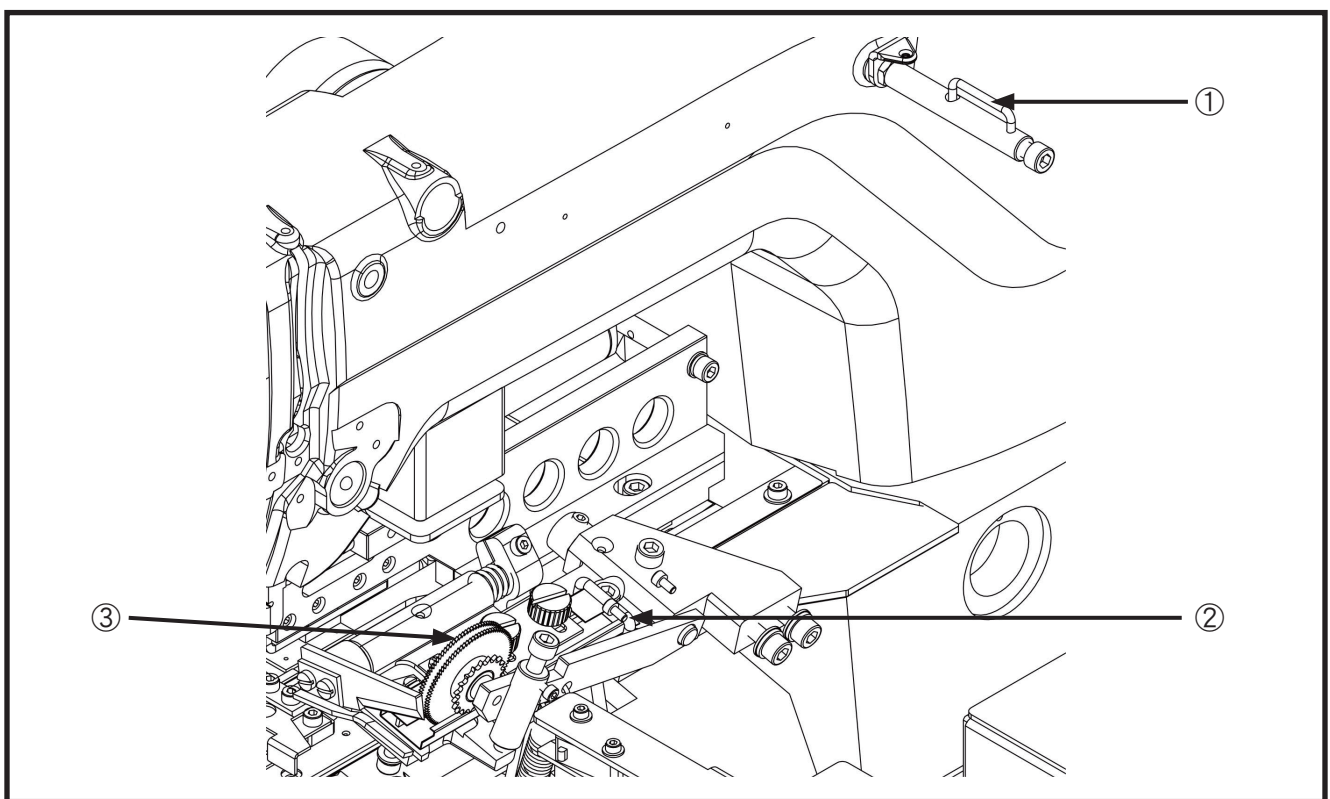
名稱 Name	機能 Function
起動鍵 Start switch	<ul style="list-style-type: none"><li>● 成車起動</li><li>● Switch begin</li></ul>

## 褲耳布料安裝方法

## LOOP MATERIAL INSTALLATION METHOD

1. 穿褲耳前，電源開關為 ON，按下 LK1900A 操作面板 "準備鍵⑤"。
2. 褲耳穿過褲耳限位架①。
3. 褲耳穿過褲耳調整器②，碰到鍊輪③，手推褲耳不放。
4. 按下 "再送帶④"，送出一截褲耳後，此為餘料，在按一次 "再送帶④"，裁切完後即為所設定尺寸。

1. Before loop installed, power switch are ON, press operation panel button ⑤ "
2. Loop go through loop limit rack ① .
3. Loop go through loop adjuster ② , engaged with sprocket wheel ③ , push the loop constantly.
4. Press "feed-again ④ " , It will feed a section of the loop as left over Press "feed-again ④ " after cutting, it will be final setting size.

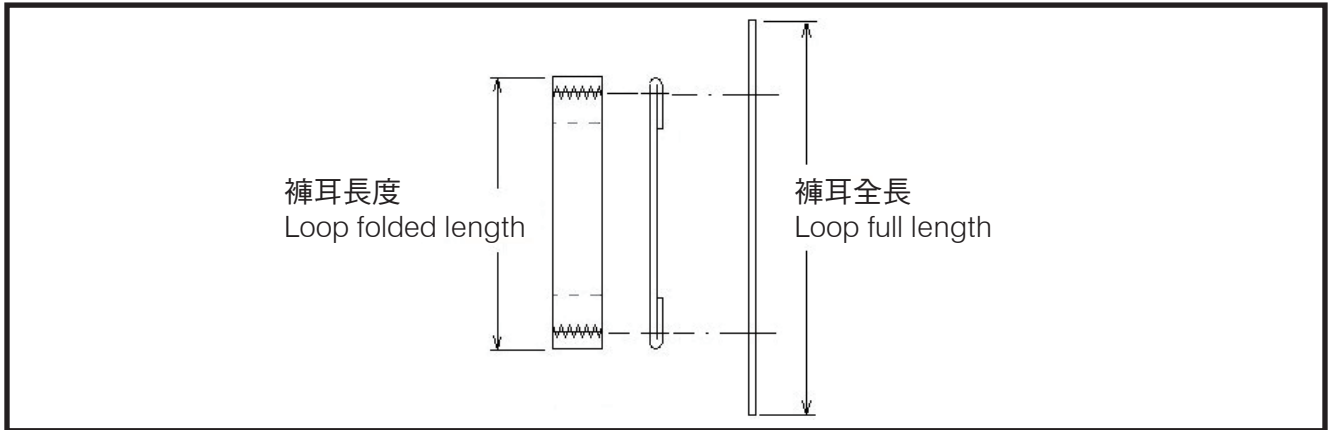


## 褲耳尺寸變更時

## LOOP SIZE CHANGES SETTING

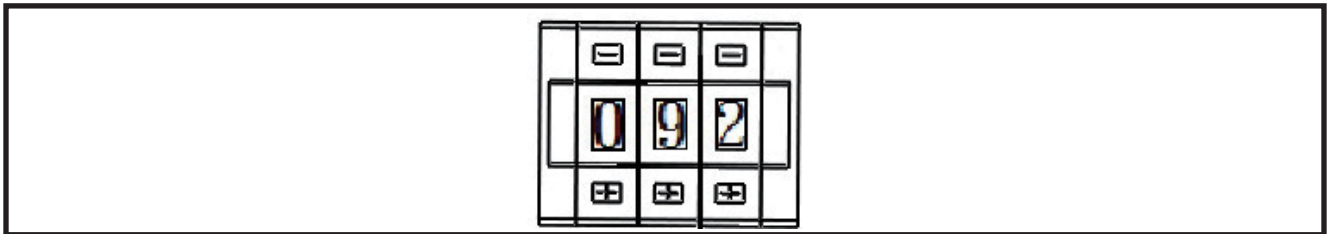
### (1) 褲耳長度變更時

### (1) Loop length setting



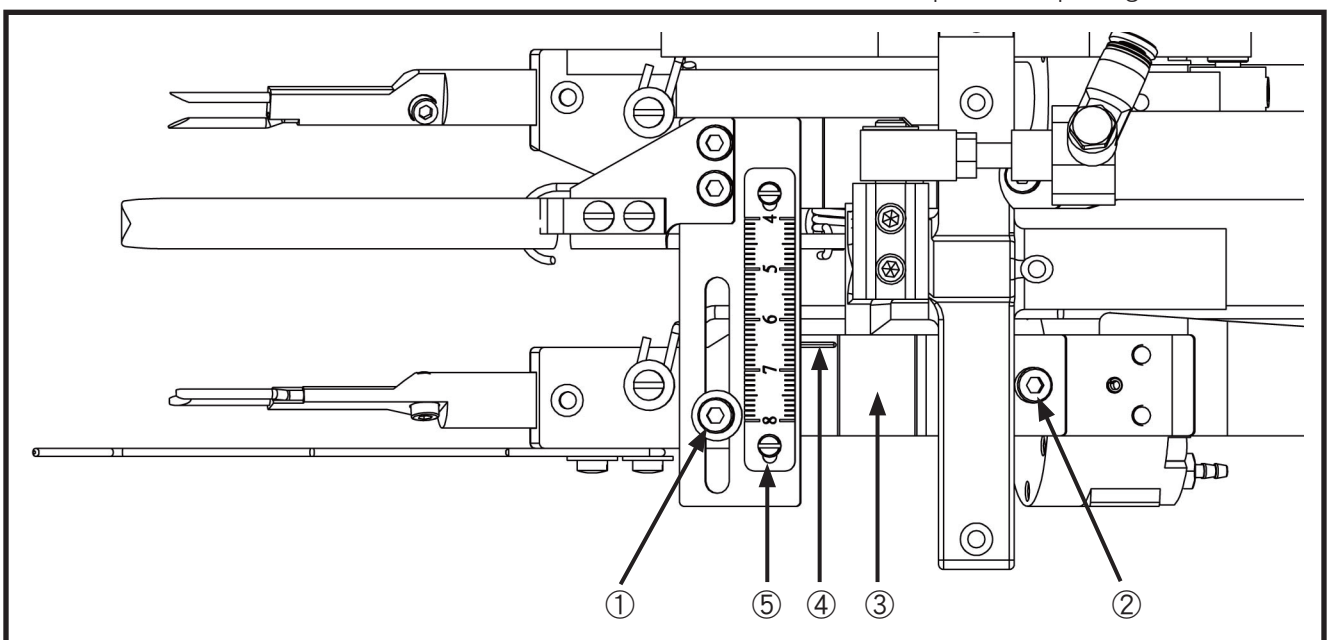
- A. 設定褲耳送出的長度  
用 " 長度調整鍵 "，設定送料時，褲耳送出的全長。

- A. Loop length setting  
Use length adjuster button to set the full length when it feed.



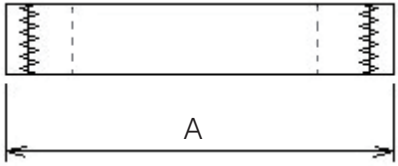
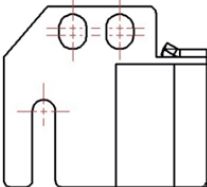
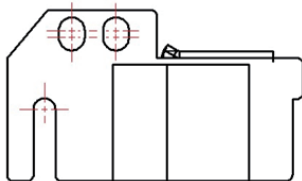
- B. 在車縫供給組上，移動固定座，至褲耳所需的長度  
i ) 鬆開固定螺絲①、②。  
ii ) 調整固定座③，將指示標誌④，對準 " 刻度尺⑤ "，移至所需的褲耳長度。

- B. Move the fixed support to the required loop length.  
i ) Release fixed screw ①、②.  
ii ) Adjust the fixed support ③ by shifting the pointer ④ to the "Scale ⑤" plate for the required loop length.



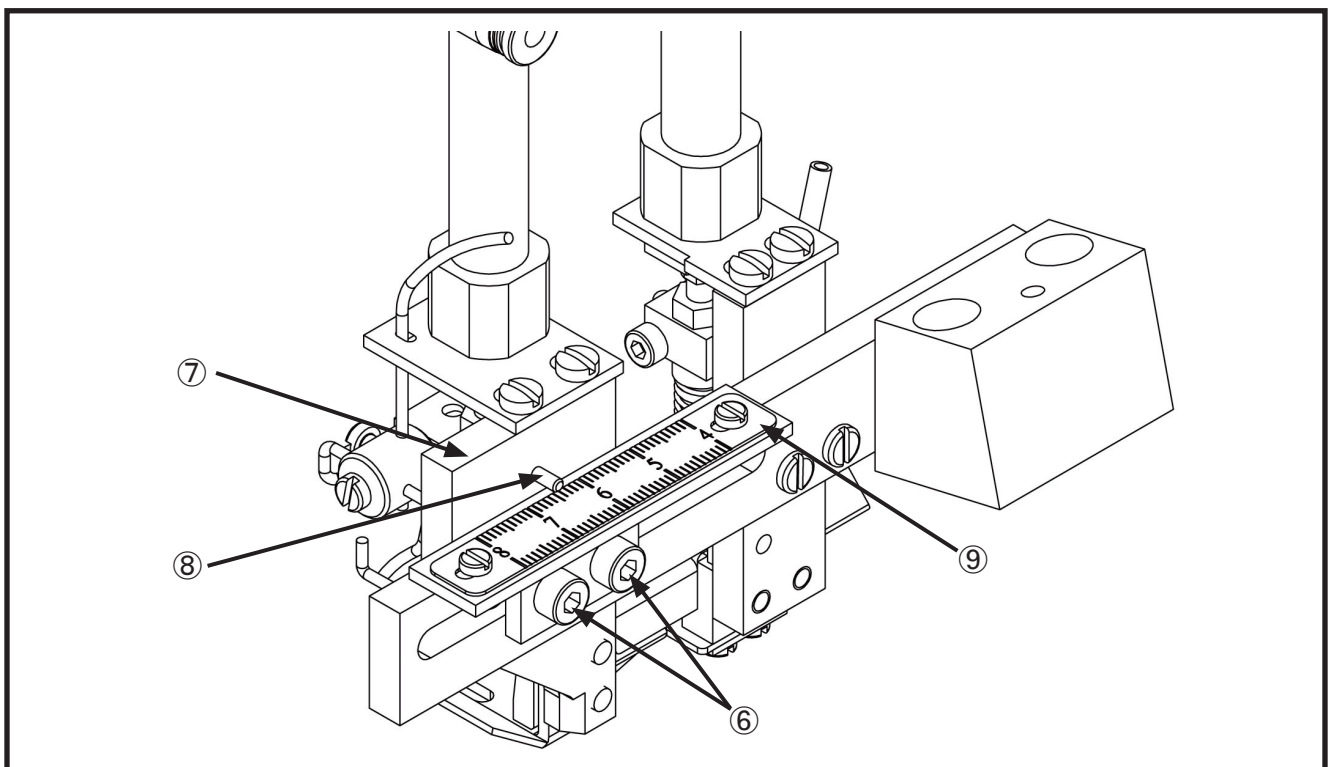
C. 選擇褲耳支撐板  
 依據所需的褲耳長度 A，選擇適合的褲耳支撐板。

C. Loop support plate selection  
 Based on the required loop length A, to select the suitable loop support plate.

	<p>褲耳支撐板 Loop support plate</p>
<p>A : 42 ~ 65 mm</p>	 <p>( 配件 ) Optional</p>
<p>A: 60 ~ 78 mm</p>	 <p>( 出廠設定值 ) Default</p>

D. 在平台組上，移動固定座，至褲耳所需的長度  
 度  
 i ) 鬆開固定螺絲⑥。  
 ii ) 調整固定座⑦，將指示銷⑧，對準 " 刻度尺⑨ "，移至所需的褲耳長度。

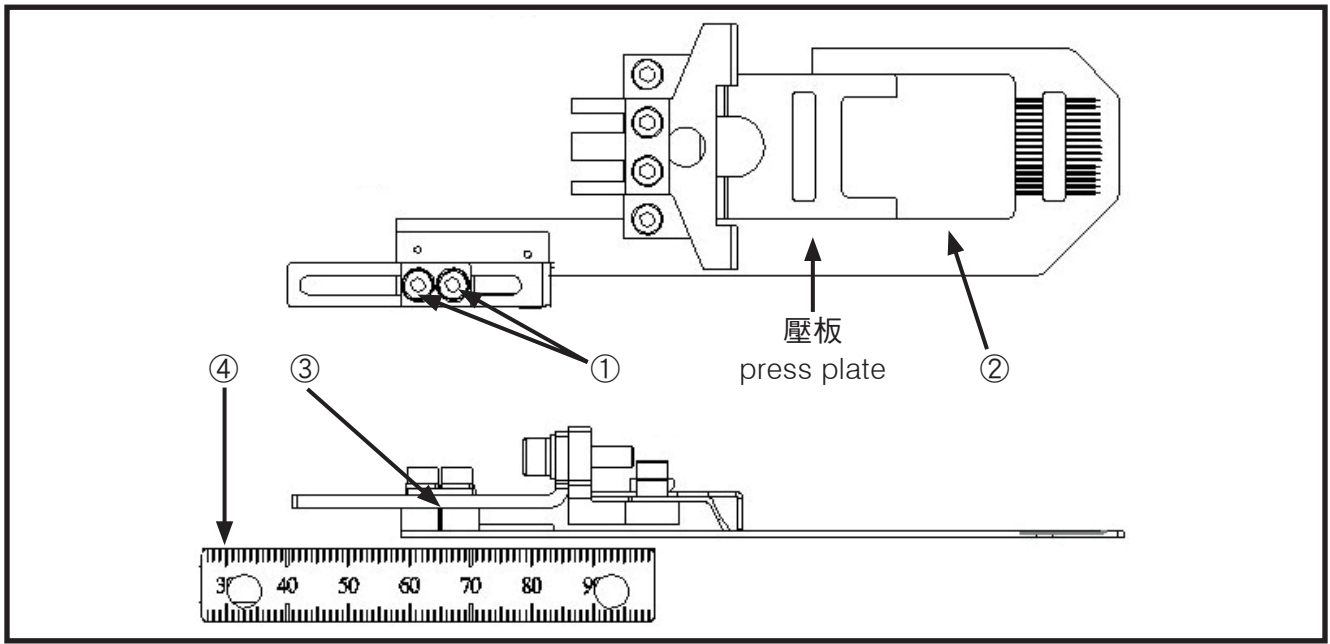
D. Move the fixed support on the platform to the required loop length.  
 i ) Release fixed screw ⑥ .  
 ii ) Adjust the fixed support ⑦ by shifting the pointer ⑧ to the scale ⑨ plate to the required loop length.





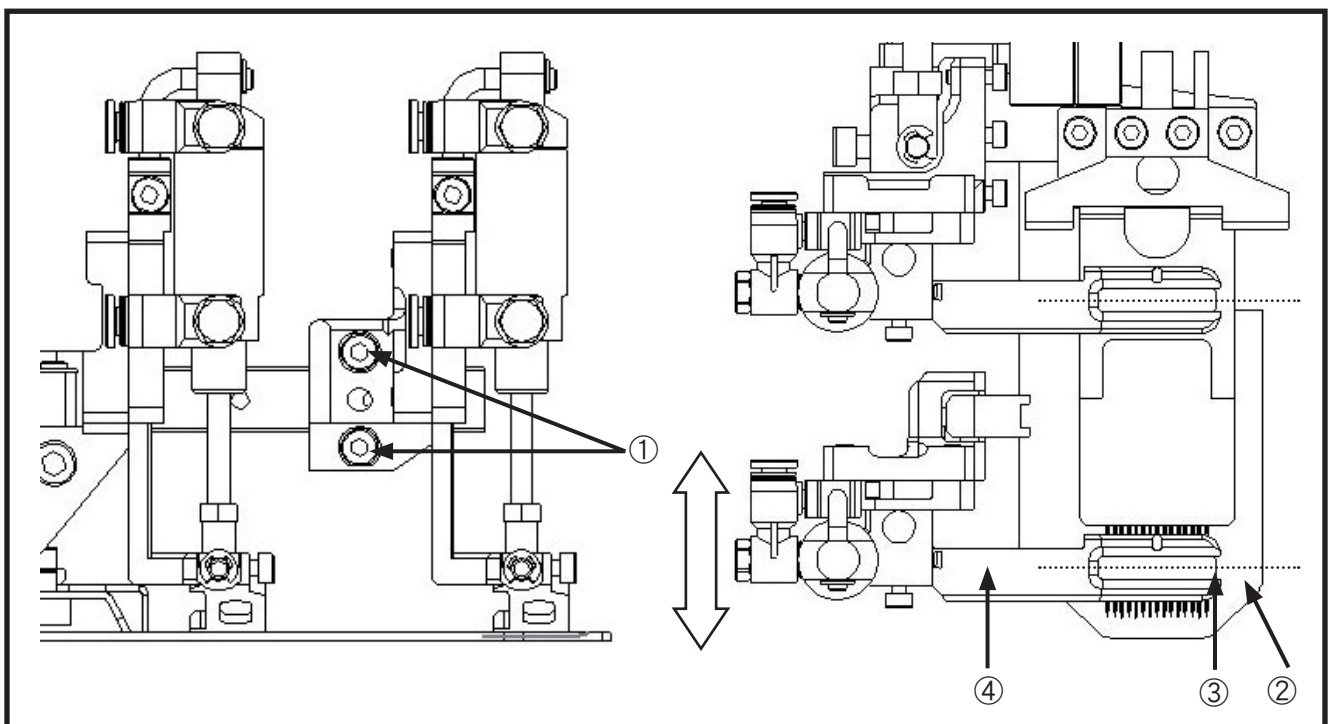
- E. 在壓腳機構上，移動壓板，至褲耳所需的長度  
 i) 鬆開固定螺絲①。  
 ii) 調整壓板②，將指示標誌③，對準刻度尺④，移至所需車縫的尺寸。

- E. Move the press plate on the presser foot lifter module, to the required length.  
 i) Release fixed screw ①.  
 ii) Adjust press plate ② by shifting the pointer ③ to the scale ④ plate for the required sewing size.



- F. 在壓腳機構上，移動前壓腳  
 鬆開固定螺絲①（2根），前後移動前壓腳④，須與下壓板②上的車縫方形孔③一致對齊。

- F. Move the press foot lifter on the presser foot lifter module.  
 Release screw ① (2 pcs), move back and forth presser foot lifter ④, to align with the square sewing hole ③, on the press plate ②.



## G. 在壓腳機構上，移動 "調整塊"

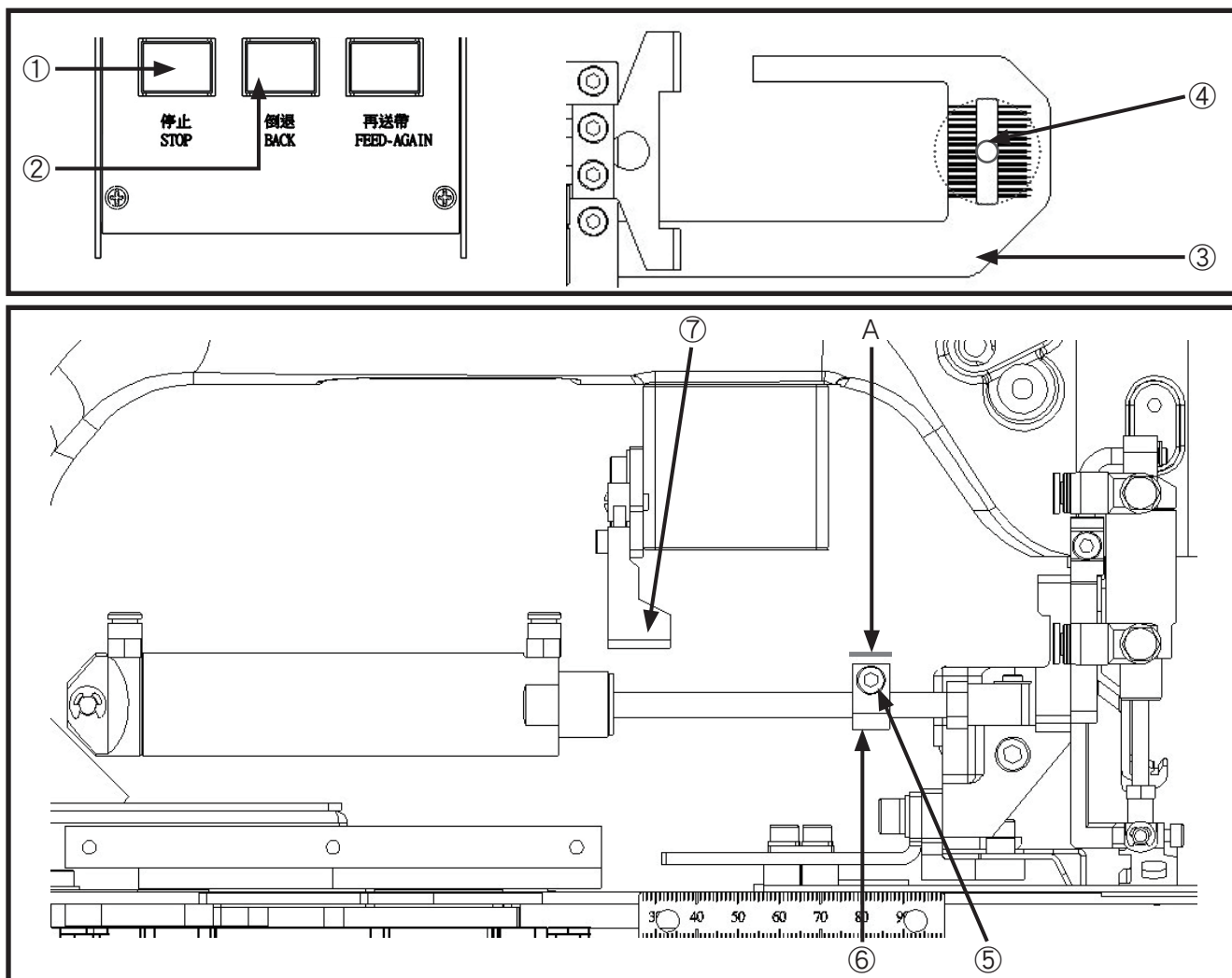
在使用自動模式下，按下停止鍵①，再按下倒退鍵②，壓板③後退時，壓板③上的方形孔，和針板④上的中心孔，前後方向需一致。

鬆開固定螺絲⑤，移動 "調整塊" ⑥至所需距離，再鎖附固定螺絲⑤，鎖緊後按下倒退鍵②，再按下停止鍵①。

## G. Move "adjustment block" on the presser foot lifter module.

Under automatic mode, press the "① Stop" button, then press the "② Back" button, when press plate ③ moving backwards, the square holes on the press plate ③ and the center hole on the needle plate ④ need to be in the constant direction.

Release fixed screw ⑤, shift the "adjusting block" ⑥ to the required distance fasten the fixed screw ⑤ afterwards, After locking, press the "② Back" button, then press the "① Stop" button.



(注 1) 調整成車 X-Y 壓腳裝置，需在原點位置進行。  
〔X-Y 壓腳裝置做為原點位置的方法〕  
電源 ON，按下操作面板準備鍵，X-Y 送料裝置在原點位置移動。(參照 LK-1900A 使用說明書)

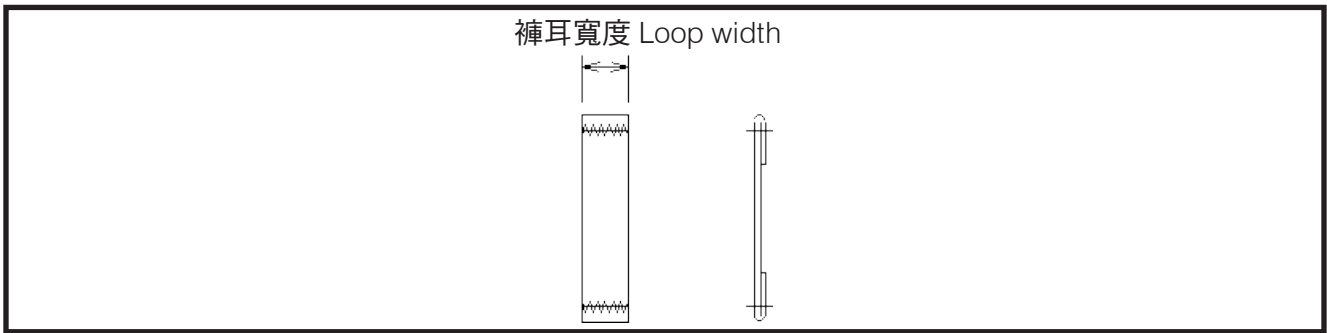
(注 2) A 面需在 SENSOR ⑦ 下面，平行按裝。

(Note 1) Adjustment for the X-Y axis on the presser foot module required to be on the sewing position.  
Press power ON then press the ready button, the X-Y axis will automatically move to sewing position.(Ref LK-1900A user manual.)

(Note 2) A side of the adjusting block need to be directly under SENSOR ⑦ .

## (2) 褲耳寬度變更時

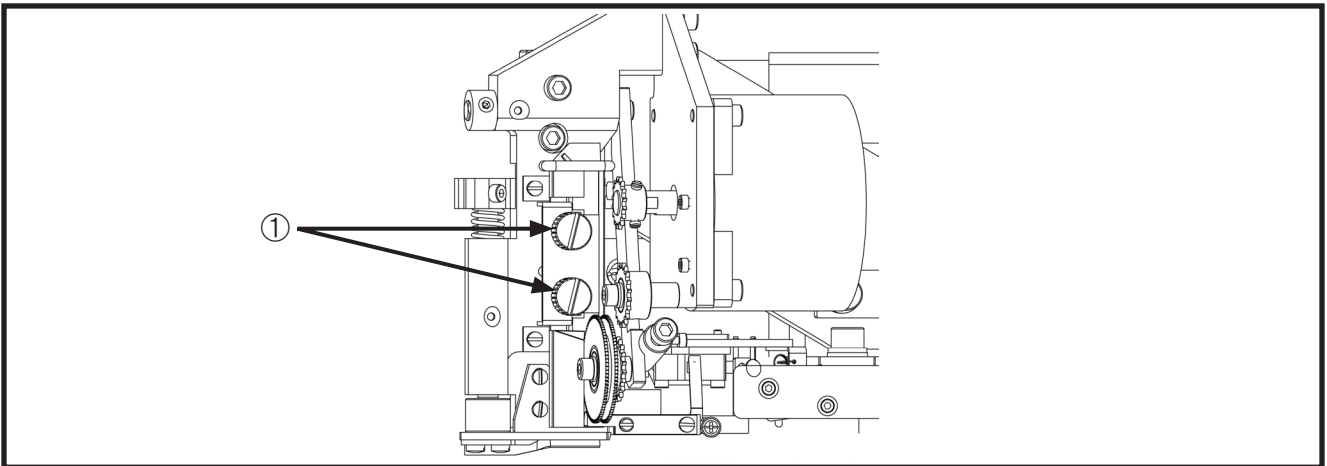
## (2) Loop width setting



### A. "褲耳調整座" 寬度調整

鬆開固定螺絲①，寬度調整約比褲耳寬 0.5 mm 左右，在鎖緊固定螺絲①。

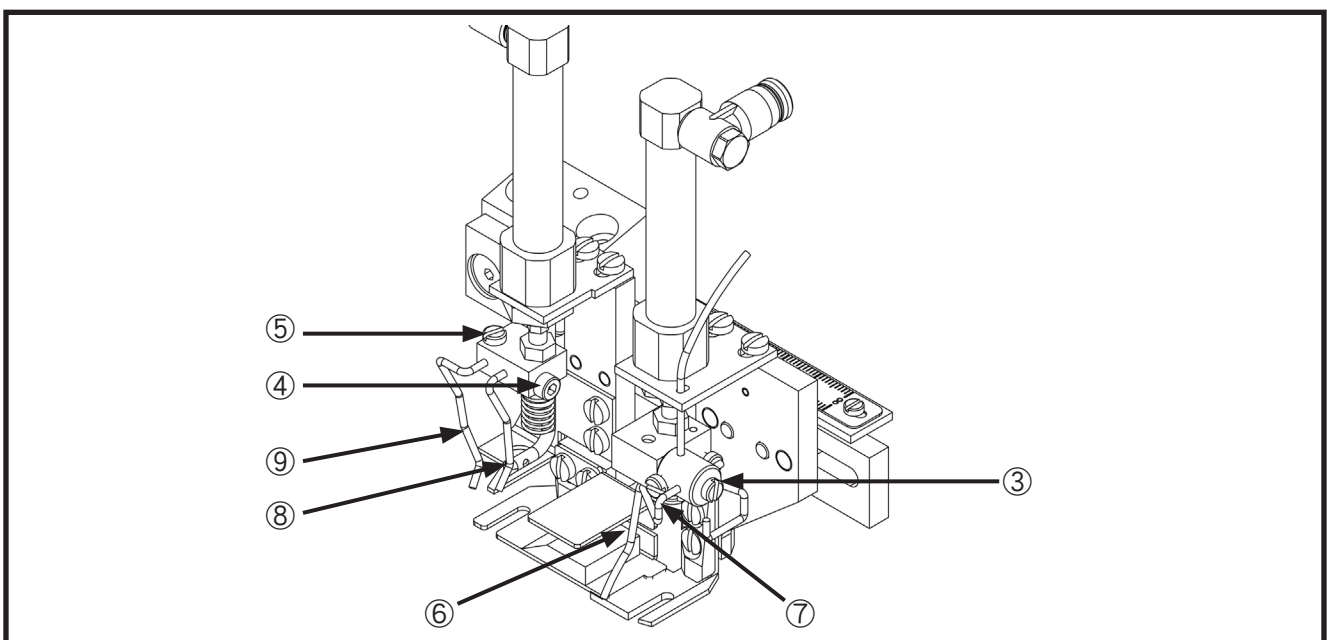
A. Loop adjusting mount for width adjustment  
Release screw ①, adjust the width about 0.5mm wider than the loop, fasten the screw ① afterwards.



### B. 限位架調整

褲耳碰到支撐板⑥的側面，鬆開固定螺絲③、④、⑤，進行限位架⑦、⑧、⑨調整。

B. Limit support rack adjustment  
When loop touch the side of the limit support rack loosen the screw ③、④、⑤ to proceed adjustment on ⑦、⑧、⑨.



## C. 褲耳位置調整

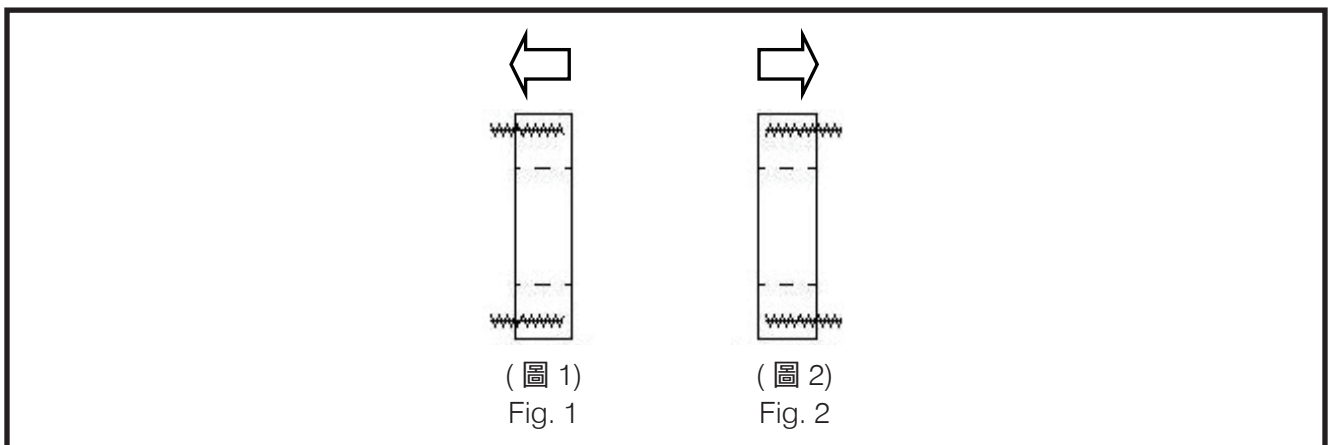
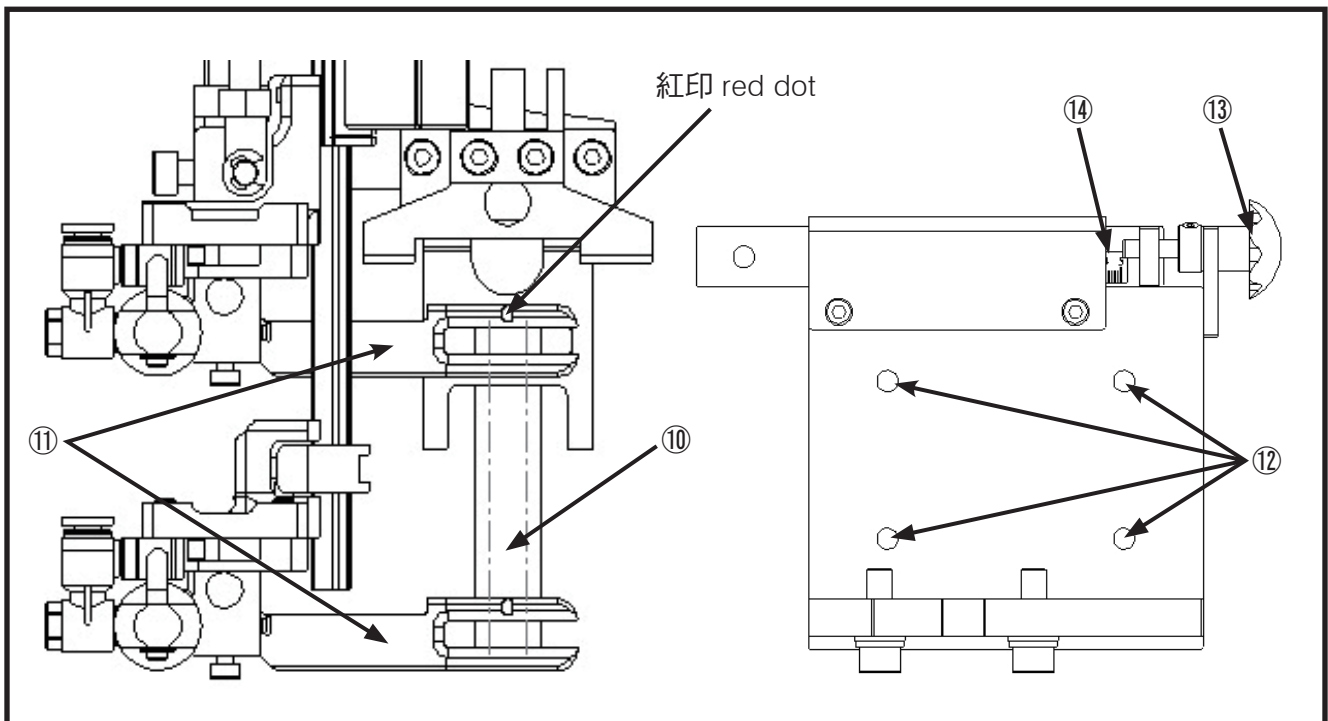
送褲耳⑩後，在壓腳⑪下，褲耳寬中心和壓腳中心（紅印）需一致，鬆開固定螺絲⑫，轉動旋鈕⑬，調整左右位置。

（刻度板⑭可檢視移動距離）

## C. Loop position adjustment

After loop delivered ⑩ to presser foot ⑪ lift, the center of loop and foot lifter need to be align (red dot).

Adjust the left and right position by loosening the screw ⑫ and tuning knob ⑬ use the scale plate ⑭ to measure the adjustment.



\* 如（圖 1）縫好後，轉動旋鈕 ⑬，順時針方向轉動。

如（圖 2）縫好時，轉動旋鈕 ⑬，逆時針方向轉動。

\* (Fig. 1) After sewing, turn knob ⑬ clockwise.

(Fig. 2) After sewing, turn knob ⑬ counter-clockwise.

## (3) 褲耳厚度變更時

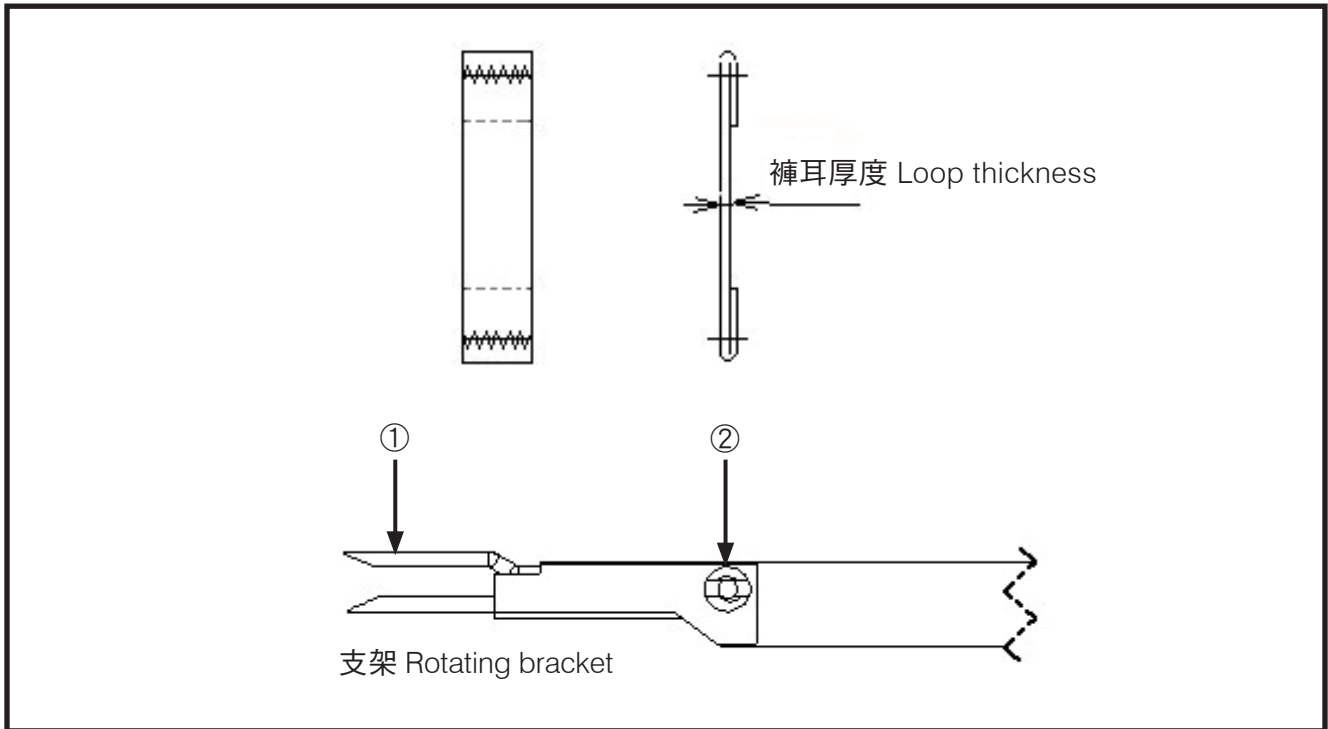
## (3) Loop thickness setting

### A. 支架變更

### A. Rotating bracket adjustment

下列 3 種 " 支架① " 分開使用，鬆開固定螺絲②進行更換。

The following three type of rotating bracket ① changes according to the loop thickness by loosen the screw ② .



褲耳厚度 (mm) Loop thickness (mm)	支架 Rotating bracket	組裝後尺寸 Rotating bracket assembly size
1.6~2.3	( 出廠設定值 Default ) 1.1mm	3.2mm
2.0~3.1	( 配件 Optional ) 1.9mm	4mm
1.0~1.8	( 配件 Optional ) 0.5mm	2.6mm

## B. 褲耳卡料檢出調整

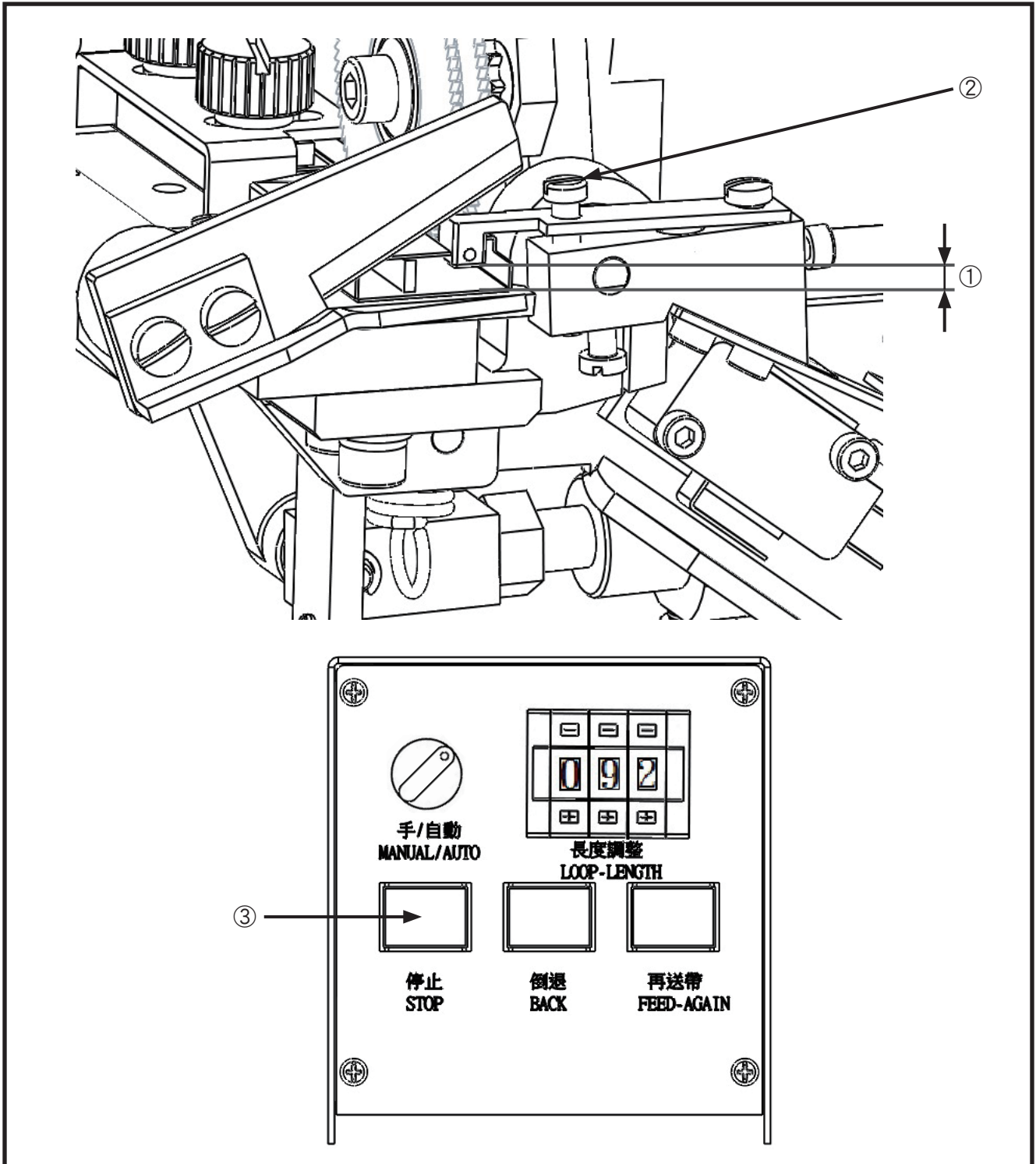
將新的褲耳，穿至限位架。

若 " 停止燈③ " 亮起時，按下 " 停止燈③ " 燈會熄滅，燈有或沒有亮時，都請轉動調整螺絲②，調整 " 高度① " 至適當位置。

## B. Loop anomaly detector

Through the new loop to the limit support rack.

If the "Stop ③" button light on, press it and it will light off. Whether the "Stop button" light on or not, please turn the adjustment screw ②. Then adjust the "height ①" to the appropriate position.



## 標準車縫花樣一覽表

## STANDARD SEWING PATTERN CHART

關於花樣變更方法、請參照 LK-1900A 使用說明書。

下記顯示為 JBL-100 之標準花樣。

Regarding method of changing pattern, refer to LK-1900A user manual.

Below are standard pattern for JBL-100.

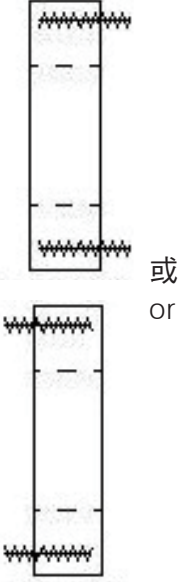
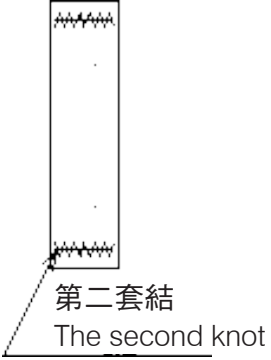
花樣	落針圖	車縫尺寸橫 x 縱 (mm)	針數
31		5x3	20
32		6x3	20
33		7x3	22
34		8x3	22
35		9x3	27
36		10x3	27
37		11x3	32
38		12x3	32
39		13x3	35
40		14x3	35
41		15x3	39
42		16x3	39
43		17x3	44
44		18x3	44
45		19x3	49
46		20x3	49
47		21x3	53
48		22x3	53

## 線套結

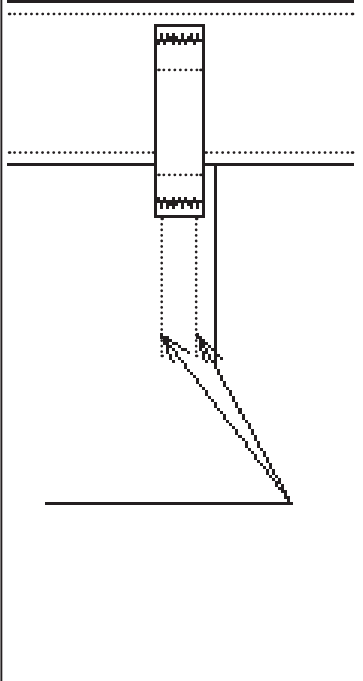

51		10x3	19
52		13x3	23
53		16x3	27

## 不良現象原因和對策

## TROUBLE SHOOTING

異常 Anomaly	原因 Reason	對策 Countermeasure	參考頁數 Ref page
<p>褲耳位置左右偏移</p> <p>Loop position deviated left and right</p> 	<p>"褲耳供給機構" 送料位置沒有對準車縫寬。</p> <p>Loop feeding module are not align with sewing machine.</p>	<p>調整 "褲耳供給機構" 的位置。</p> <p>Adjust loop feeding module position.</p>	<p>P.12</p>
<p>縫製第 2 套結時，針會與 "前壓腳" 有所衝突。</p> <p>When sewing the second knot, needle are in conflict with the front foot lifter.</p> 	<p>"前壓腳" 後退時，位置有誤差。</p> <p>When front foot lifter retreating backwards Location are misplaced.</p>	<p>調整壓腳機構上的 "調整塊"，重新調整 "前壓腳" 前後的位置。</p> <p>By adjusting the "Adjusting" block on the presser foot lift module.</p>	<p>P.10</p>



異常 Anomaly	原因 Reason	對策 Countermeasure	參考頁數 Ref page
<p>褲耳車縫時，車縫線有斷線的情況。</p> <p>During loop sewing thread breaks occurs.</p> 	<p>針前端有傷痕</p> <p>1) 針頂到壓腳 2) 梭尖撞到針 3) 撥線桿撞到針</p> <p>Scar on tip of the needle</p> <p>1) Needle press against foot lifter</p> <p>2) Shuttle tip hit the needle</p> <p>3) Wiper hit the needle</p>	<p>1) 調整壓腳機構上的 "調整塊"，調整 "前壓腳" 後退時的位置。</p> <p>2) 調整針和梭尖的間隙</p> <p>3) 撥線桿和針尖端的間隙為 2mm</p> <p>1) Adjust the "Adjustment block" on the presser foot lift module by adjusting the foot lift retreating position.</p> <p>2) Adjust the gap between needle and shuttle tip</p> <p>3) the gap between the wiper and needle tip are 2 mm minimum</p>	<p>1) P.10</p> <p>2) LK-1900A 使用說明書</p> <p>LK-1900A user manual</p>
<p>自動機送料時，"停止燈" 突然亮起。</p> <p>When feeding the "Stop Switch" will suddenly light on.</p>  <p>停止 STOP</p>	<p>褲耳有折到，或重疊。</p> <p>The loop has been broken or lapped.</p>	<p>將褲耳重新拉出一小截，重新裁剪。</p> <p>Pulling out a small piece of loop and trim it again.</p>	<p>1) P.22</p>

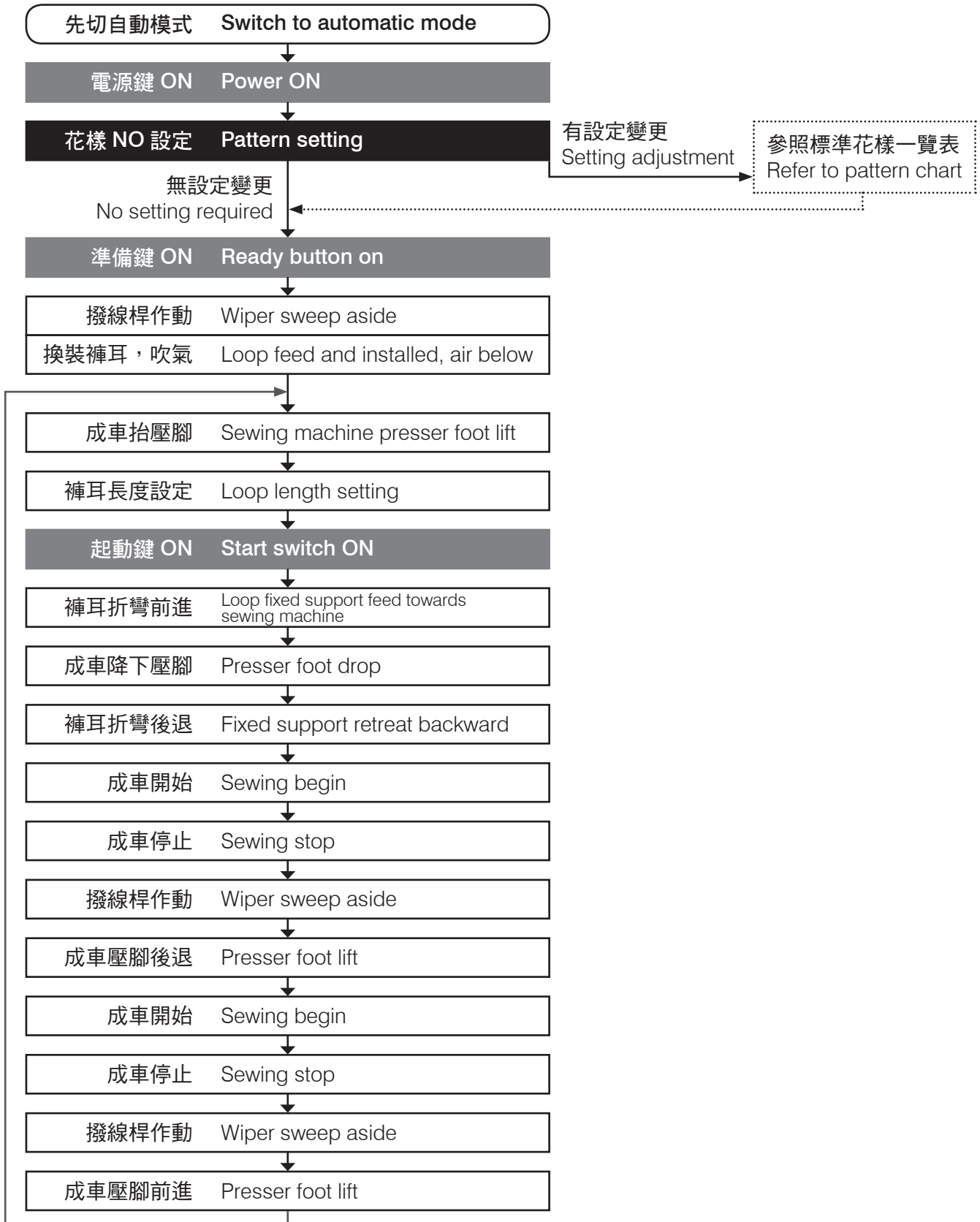
其他不良方面、請參照 LK-1900A 使用說明書。  
Other anomaly, refer to the LK-1900A user manual.

## 基本動作

## BASIC OPERATION

(1) 自動模式

(1) Automatic mode



## (2) 單動模式

在此模式下，每按一次，動作都不會連續被觸發，用以確認機構間的相對位置。

依照下列順序進行：

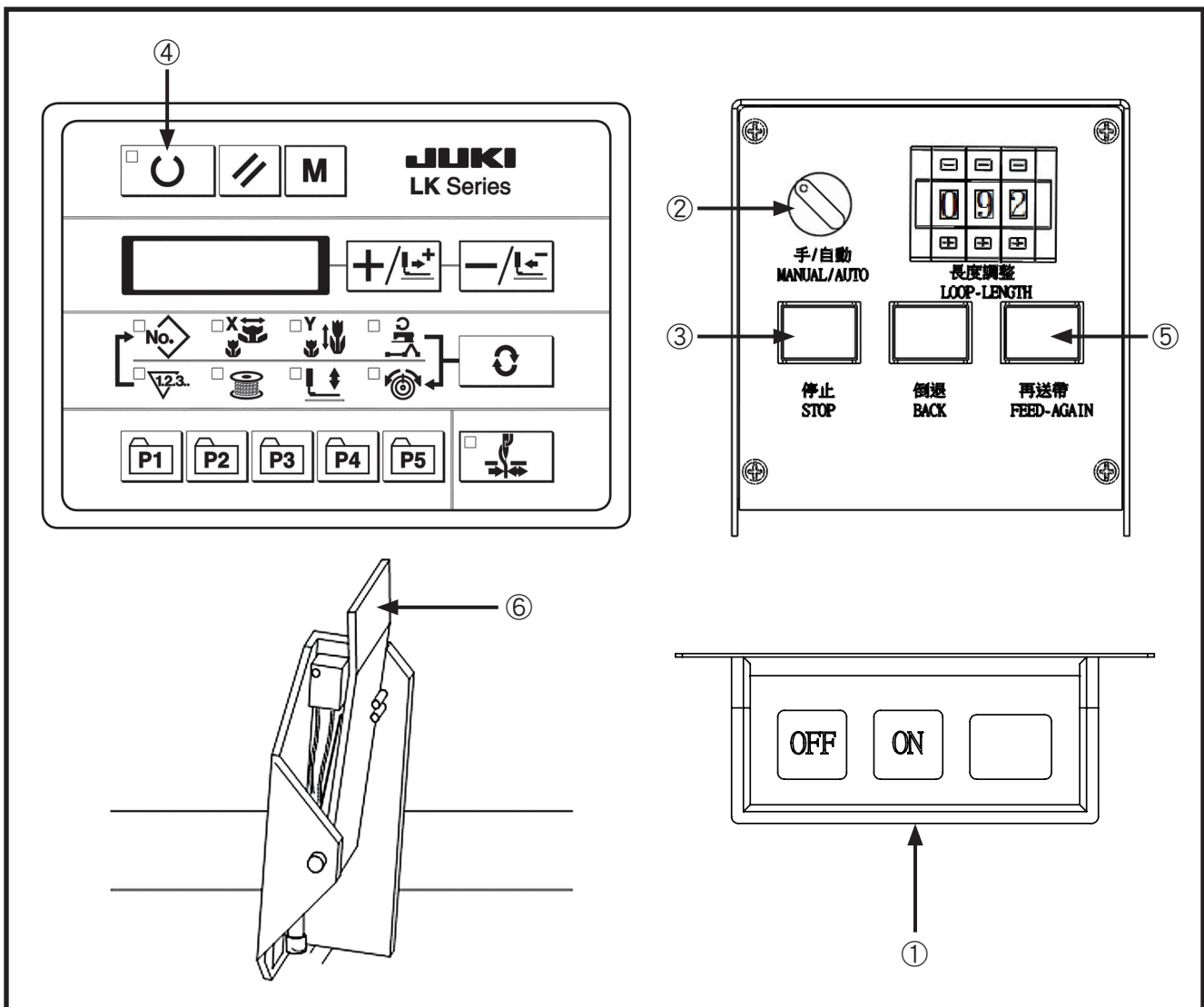
- A. 將 " 電源開關 ① " 切至 OFF。
- B. 將 " 切換鍵 ② "，切換至「手動」側。
- C. 按住 " 停止鍵 ③ " 不放，將 " 電源開關 ① " 切到 ON，" 停止鍵 ③ " 按 3 秒後放開。
- D. 按下 " 準備鍵 ④ "，壓腳裝置回到原點。
- E. 按下 " 再送帶鍵 ⑤ "，送出一個褲耳料帶。
- G. 按下 " 起動鍵 ⑥ "，進行下個動作。
- H. 動作最終後，若要再反覆時，由 E 開始。

## (2) Manul mode

Under this mode, all operation are single action for every time switch are pressed. This is to check all mechanical mechanism are in the correct relative position.

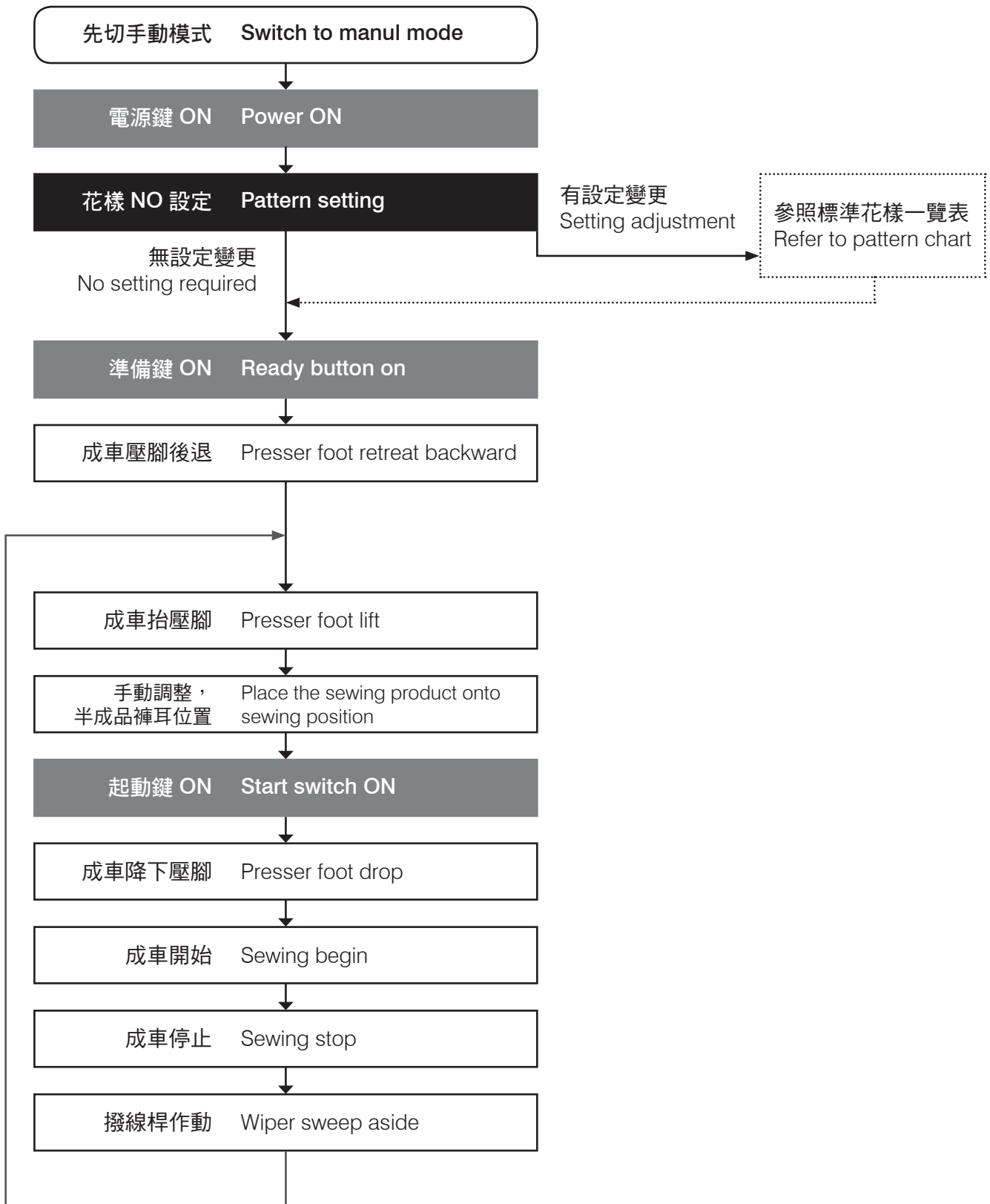
Proceed with the following:

- A. Switch " ① power" to OFF.
- B. Shift the "switch button ②" to manual.
- C. Press and hold the "stop ③" button while press the "power switch ①" to hold the stop button for about 3 seconds then release.
- D. Press "ready ④" button to set the foot back to original position.
- E. Press "Feed-again ⑤" to feed a loop.
- G. Press "start ⑥" for the next action.
- H. Start from step E to repeat above process.



(3) 手動模式 (補縫模式)

(3) Sewing mode



## (4) 單捲線模式

在此模式下，可單獨捲線。

依照下列順序進行：

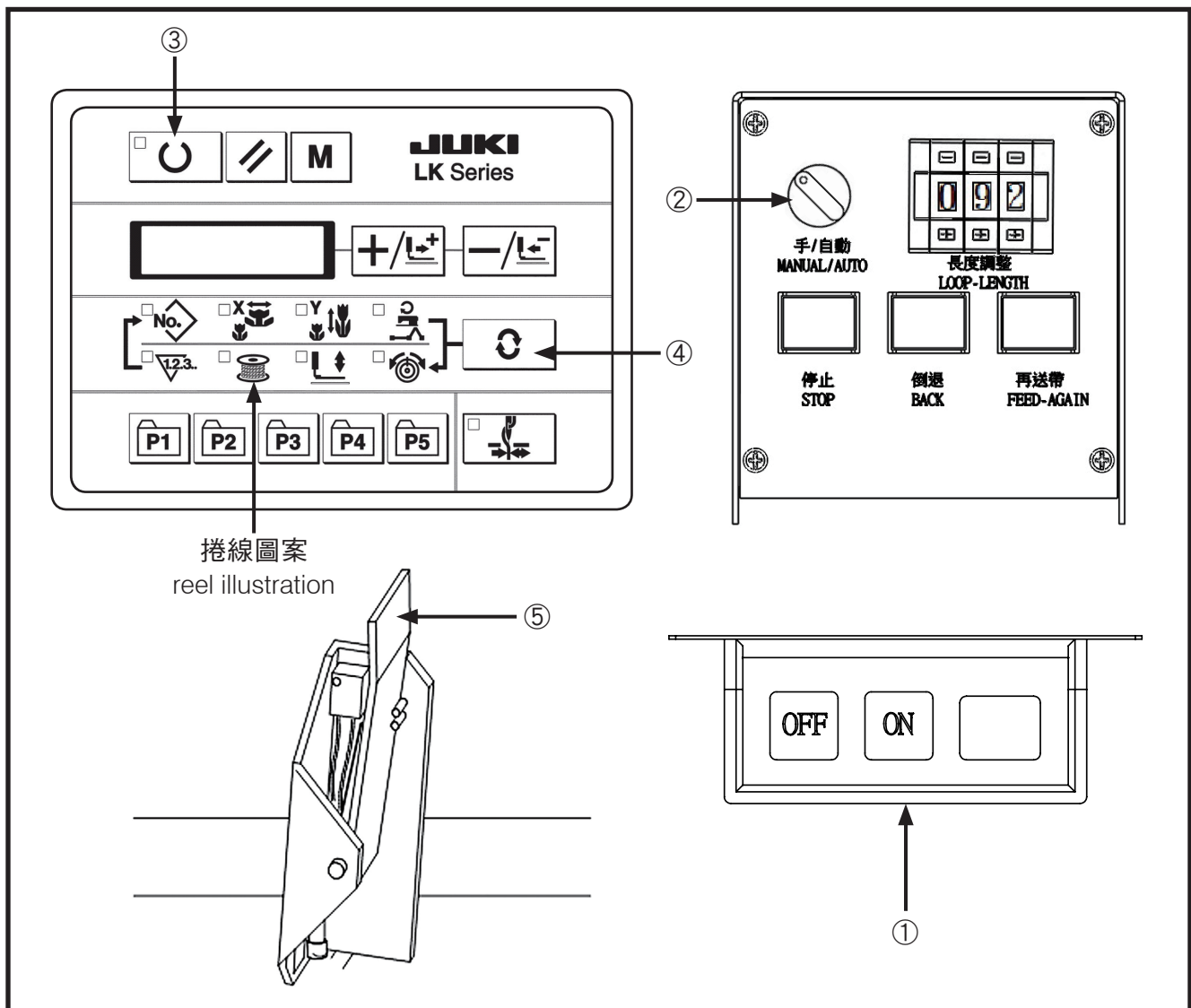
- A. 將 " 電源開關① " 切至 OFF。
- B. 將 " 切換鍵 ② "，切換至「手動」側 or「自動」側。
- C. 將 " 電源開關① " 切至 ON。
- D. 按下 " 準備鍵③ " 變成 ON。
- E. 按下 " 準備鍵③ " 變成 OFF。
- G. 按下 " 運轉鍵④ "，使其燈號在 " 捲線圖案 " 上亮起。
- H. 按下 " 準備鍵③ " 變成 ON。
- I. 按下 " 起動鍵⑤ " 即可運轉。
- J. 捲完線，按下 " 起動鍵⑤ " 即可停止。

## (4) Shuttle hook thread winding mode

Under this mode, Shuttle hook thread winding.

Proceed with the following:

- A. Switch " ① power" to OFF.
- B. Shift the "switch ② " button to manual or auto mode.
- C. Switch " ① power" to ON.
- D. Press "ready ③ " to ON.
- E. Press "ready ③ " to OFF.
- G. Press "rotation ④ ", until the light stop at reel illustration.
- H. Press "ready ③ " to ON.
- I. Press "start ⑤ " to operate.
- J. Press "start ⑤ " again to stop.



(5) 卡料時，排除方式

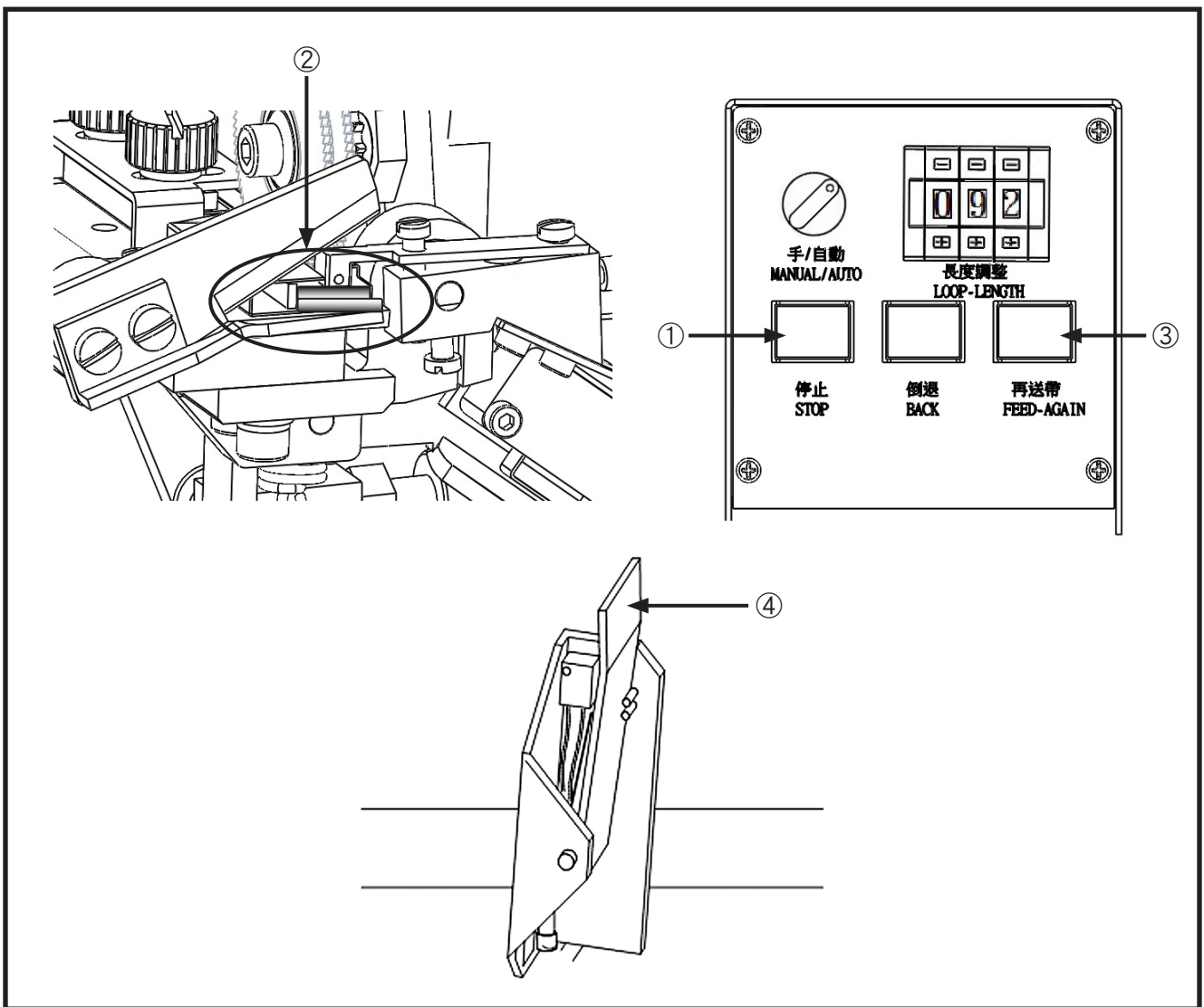
當褲耳有折到或堆疊時，"停止燈①"會亮起，自動機會停止動作，請依照下列順序排除。

- A. 按下 "停止燈①"，燈會熄滅。
- B. 在 "SENSOR ②"下，將折損的褲耳拉出，按下 "再送帶③" 裁剪。
- C. 按 "起動鍵④" 即可運轉。

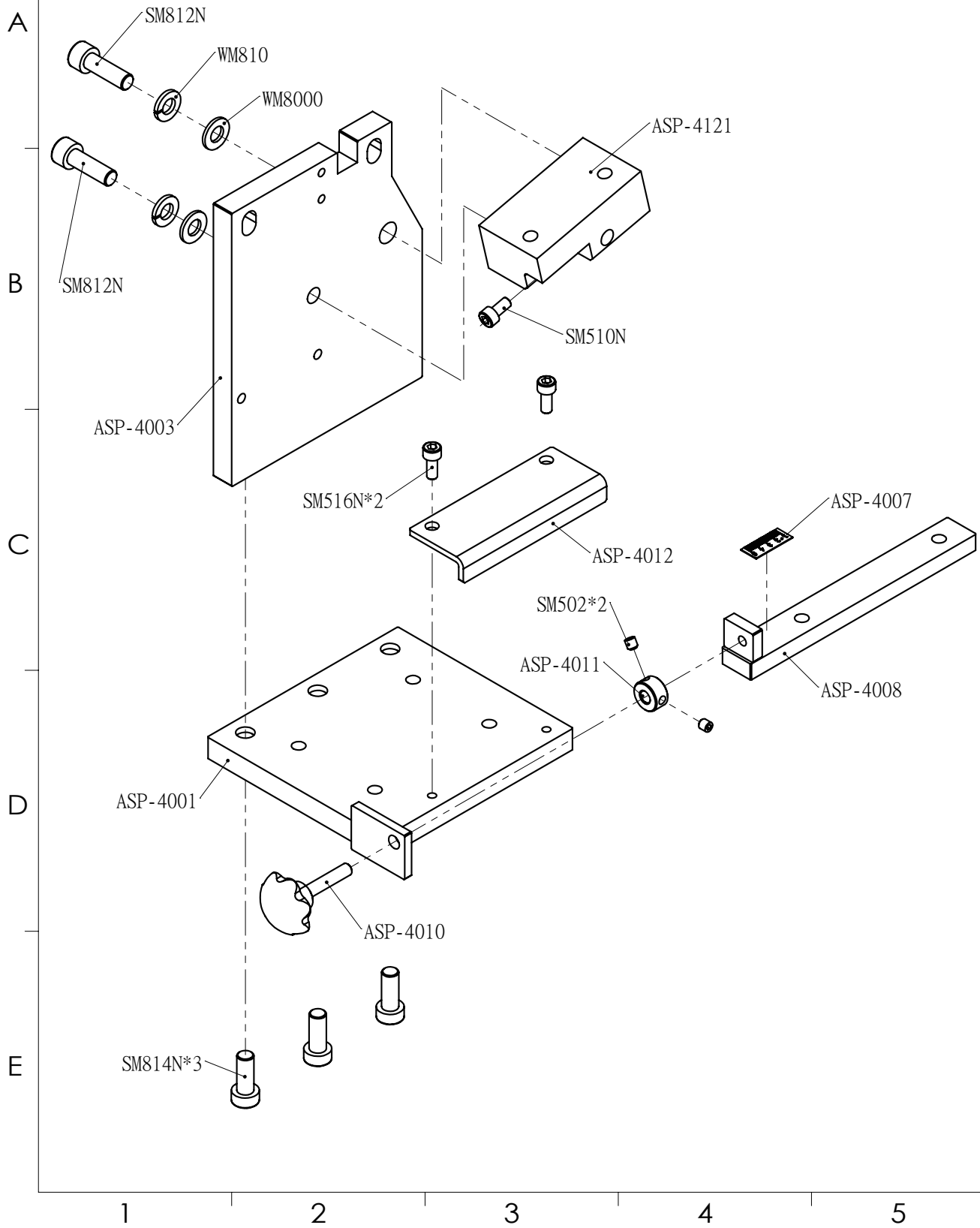
(5) When looping anomaly, the solution is

While loop is breaking or lapping, the "Stop ①" button will light on, and the Auto-machine will stop. Please follow the procedures as below to relief the situation.

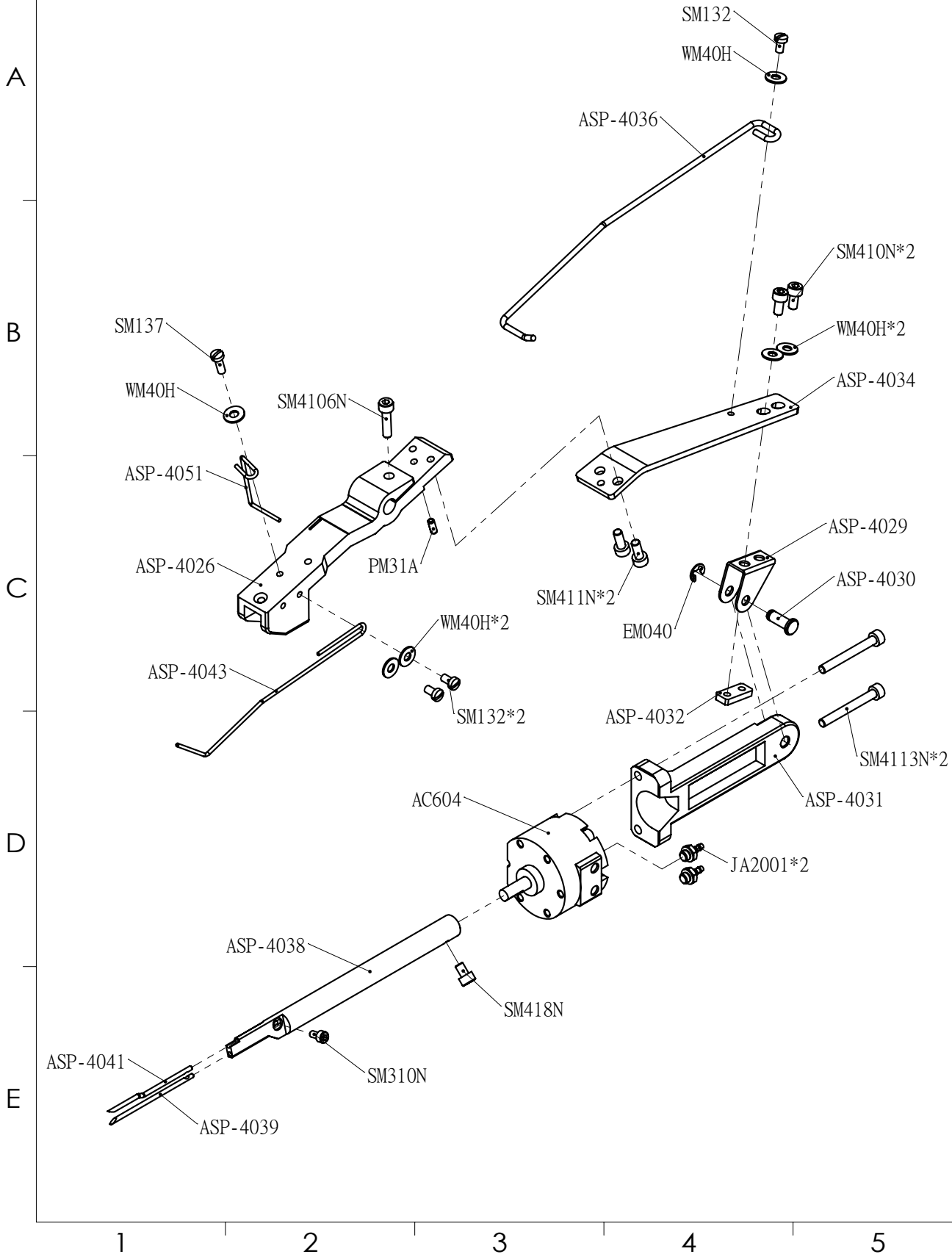
- A. Press "Stop ①" button, the light will go out.
- B. Under the "SENSOR ②", pulling out the breaking loop and press the "FEED-AGAIN ③" in order to trim.
- C. Press the "Start Switch ④", then machine will be started.



<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	底座	ASP-4001-A	1 / 23
				Date
				2016/08/10

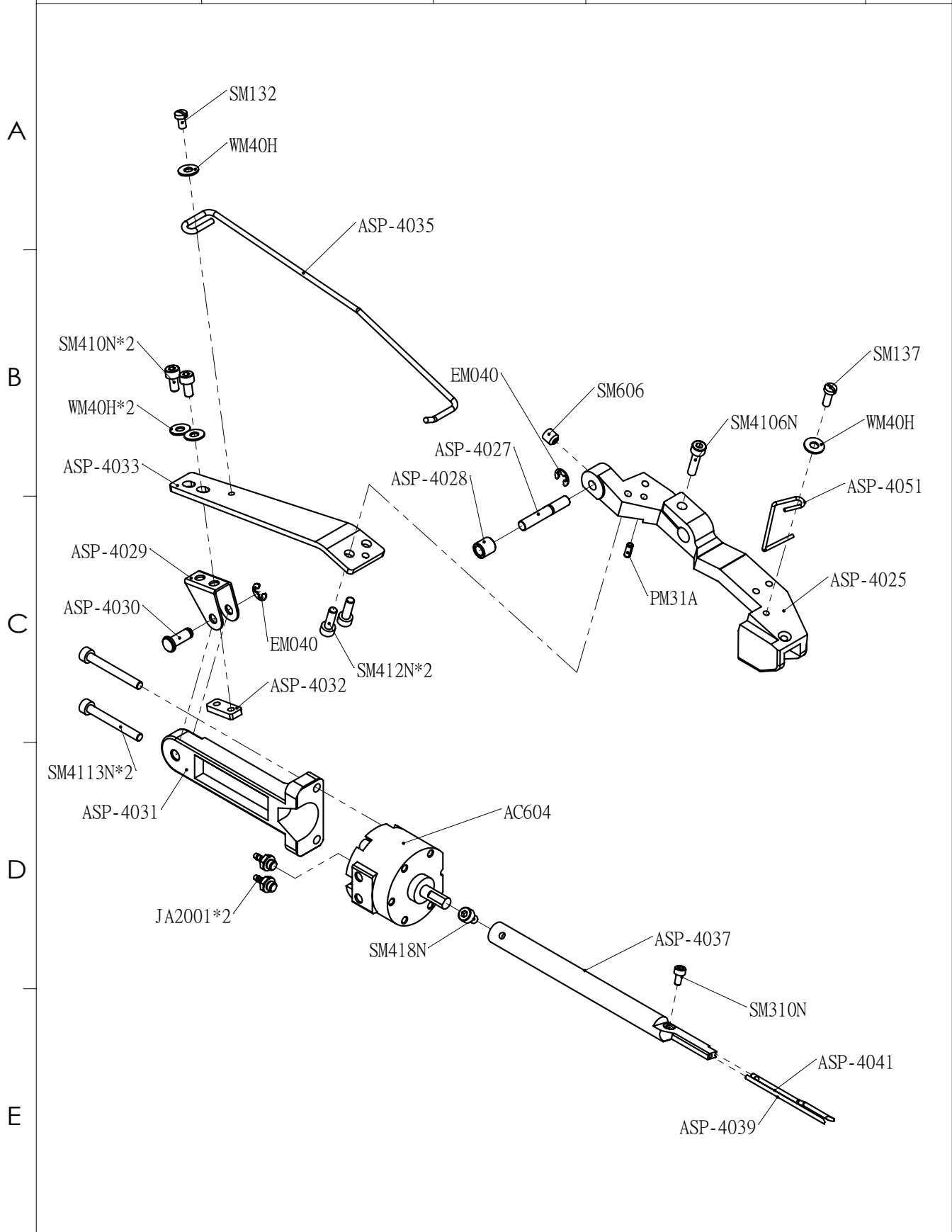


SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	折彎轉動(前)	ASP-4026-A	2 / 23
				Date
				2016/08/10





SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	折彎轉動(後)	ASP-4025-A	3 / 23
				Date
				2016/08/19



<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL-100	鬆帶裝置	ASP-4047-A	4 / 23
				Date
				2016/08/19

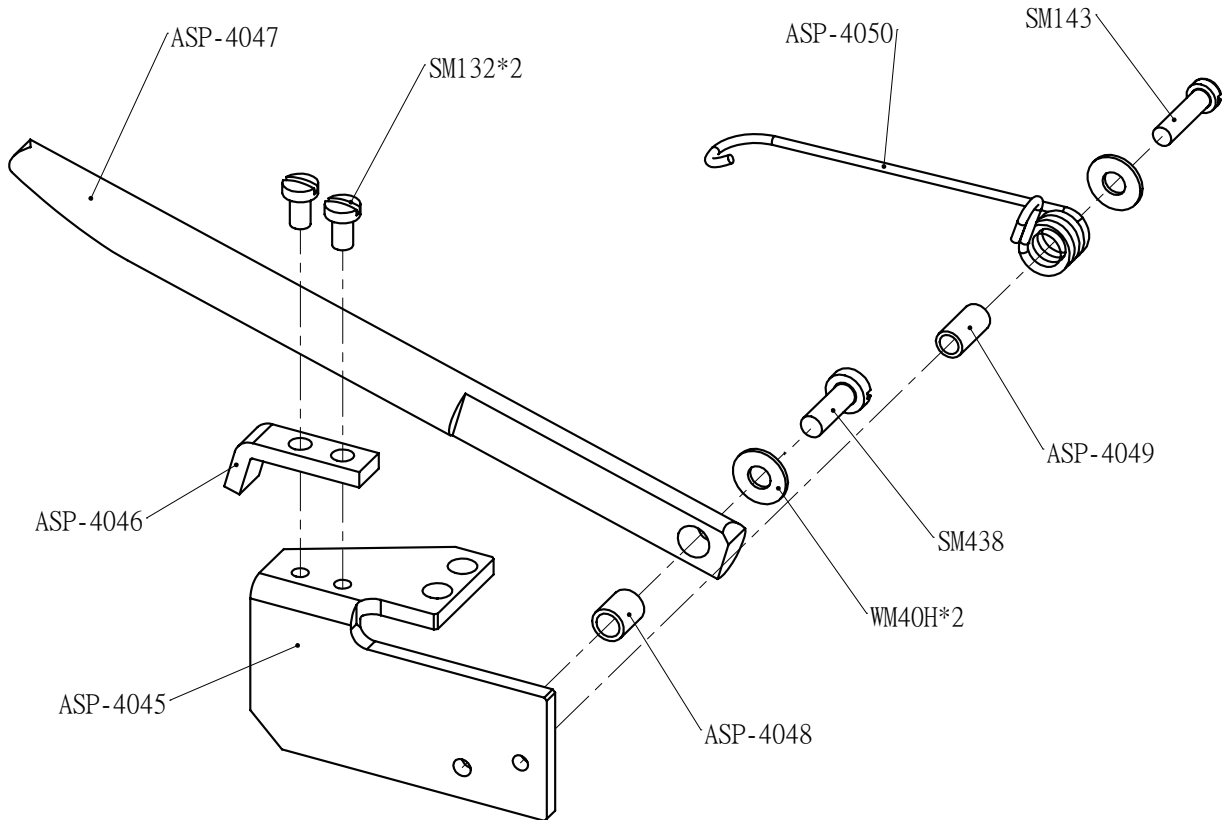
A

B

C

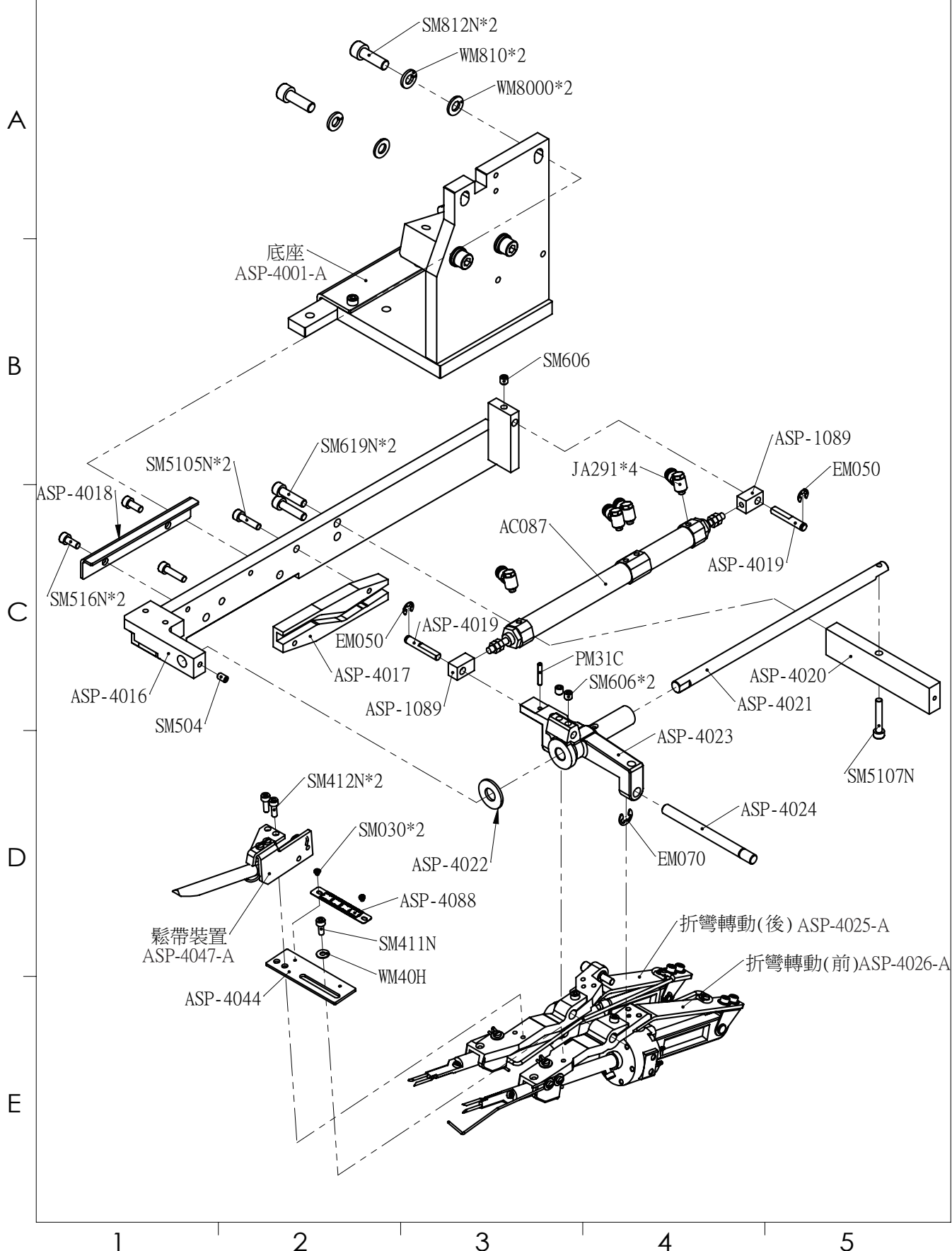
D

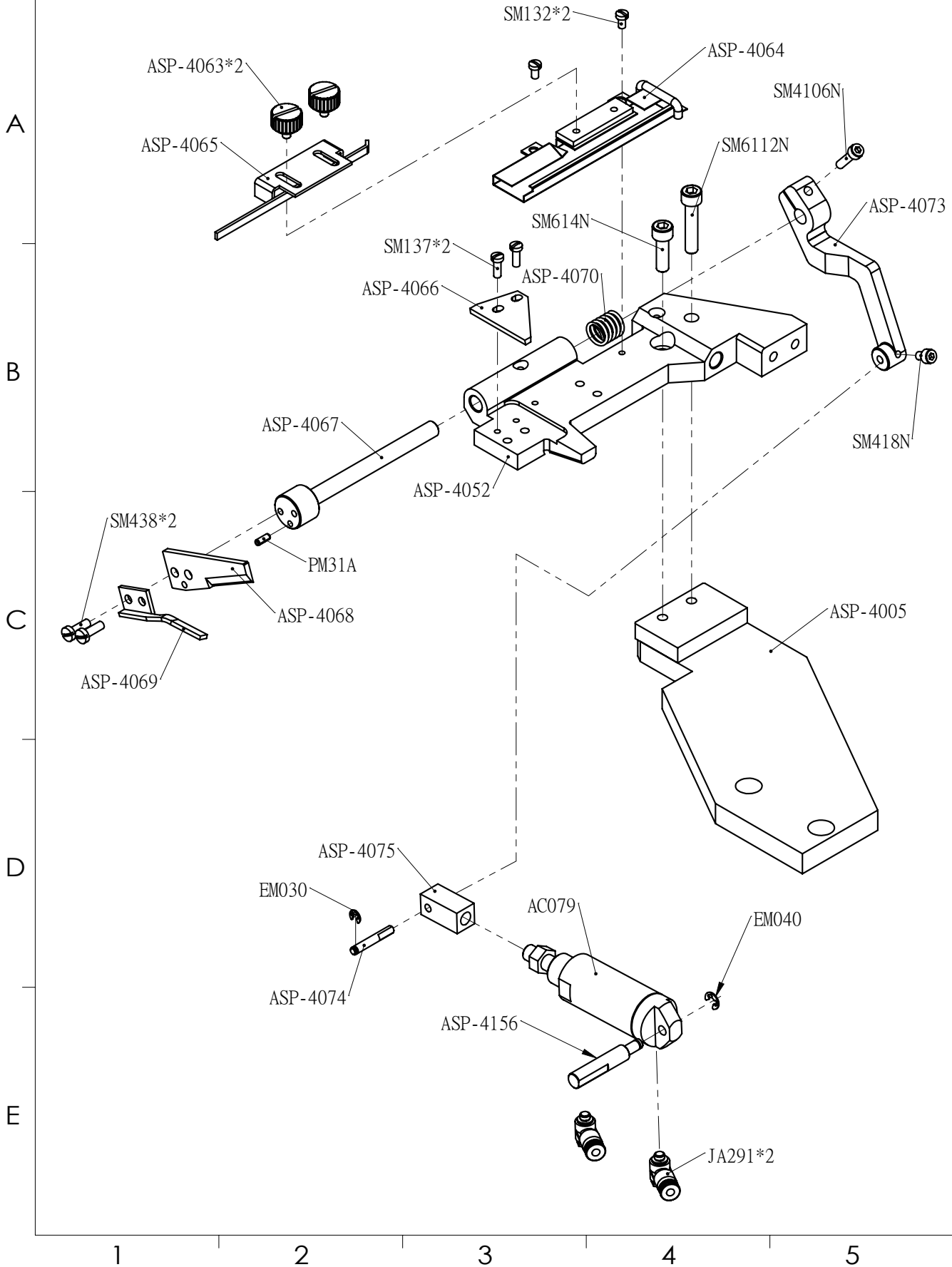
E



1                      2                      3                      4                      5

<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	車縫供給組	ASP-4016-A	5 / 23
				Date
				2016/08/10





<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	送料輪	ASP-4053-A	7 / 23
				Date
				2016/08/19

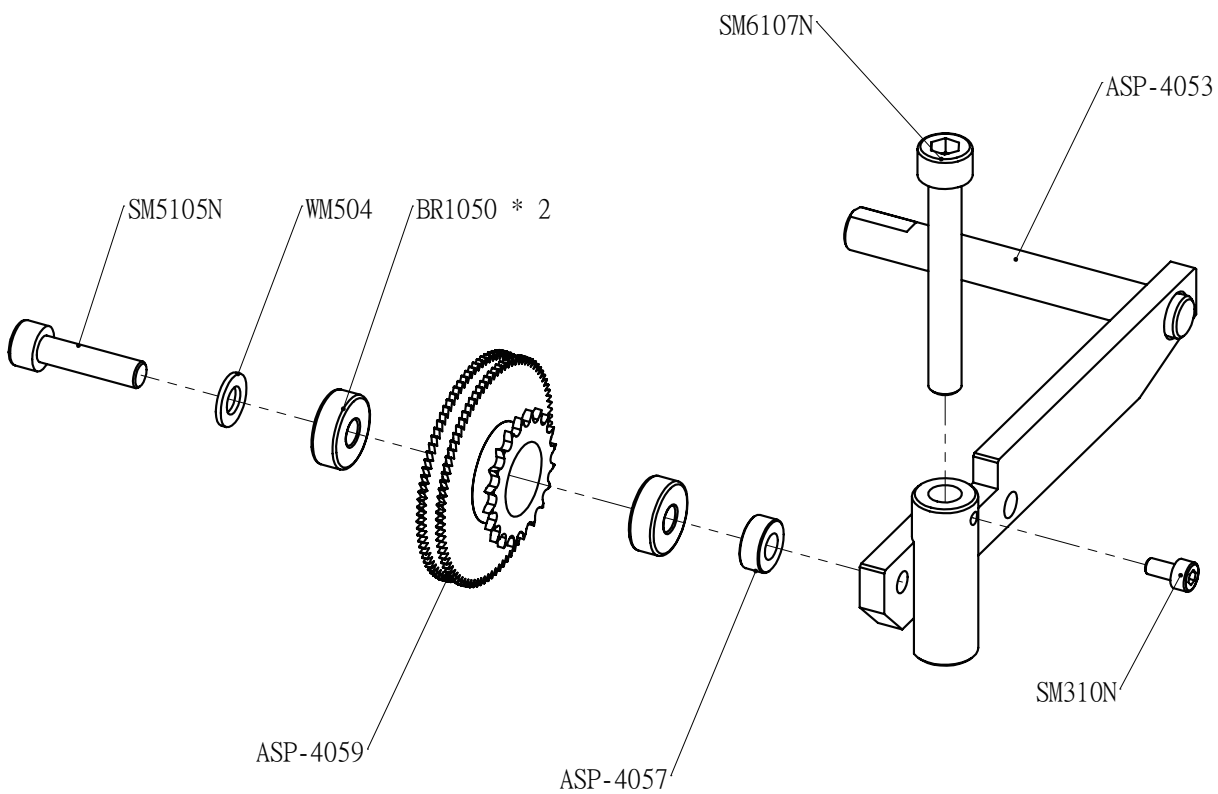
A

B

C

D

E



1

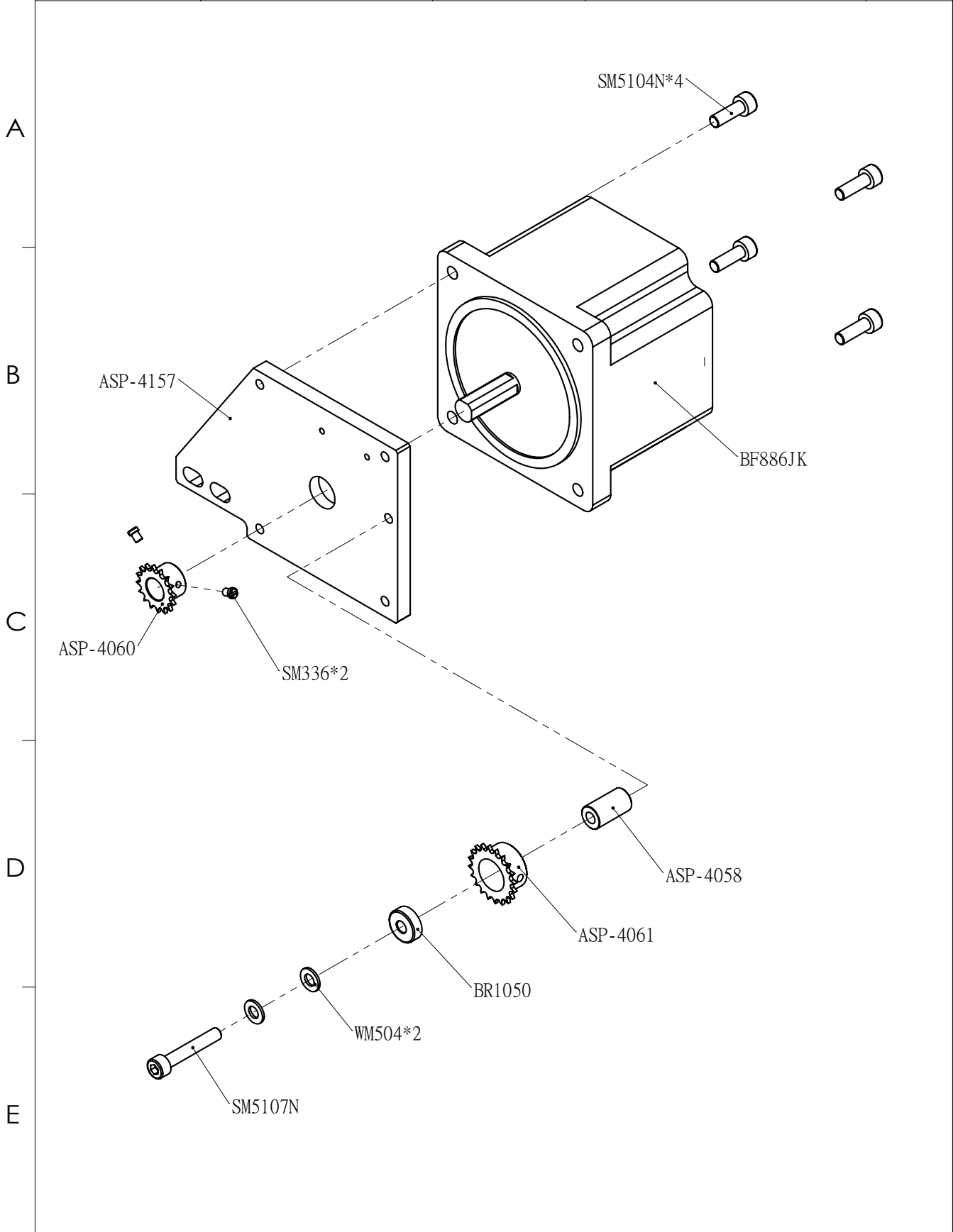
2

3

4

5

<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	供料傳動部	ASP-4157-A	8 / 23
				Date
				2016/08/19



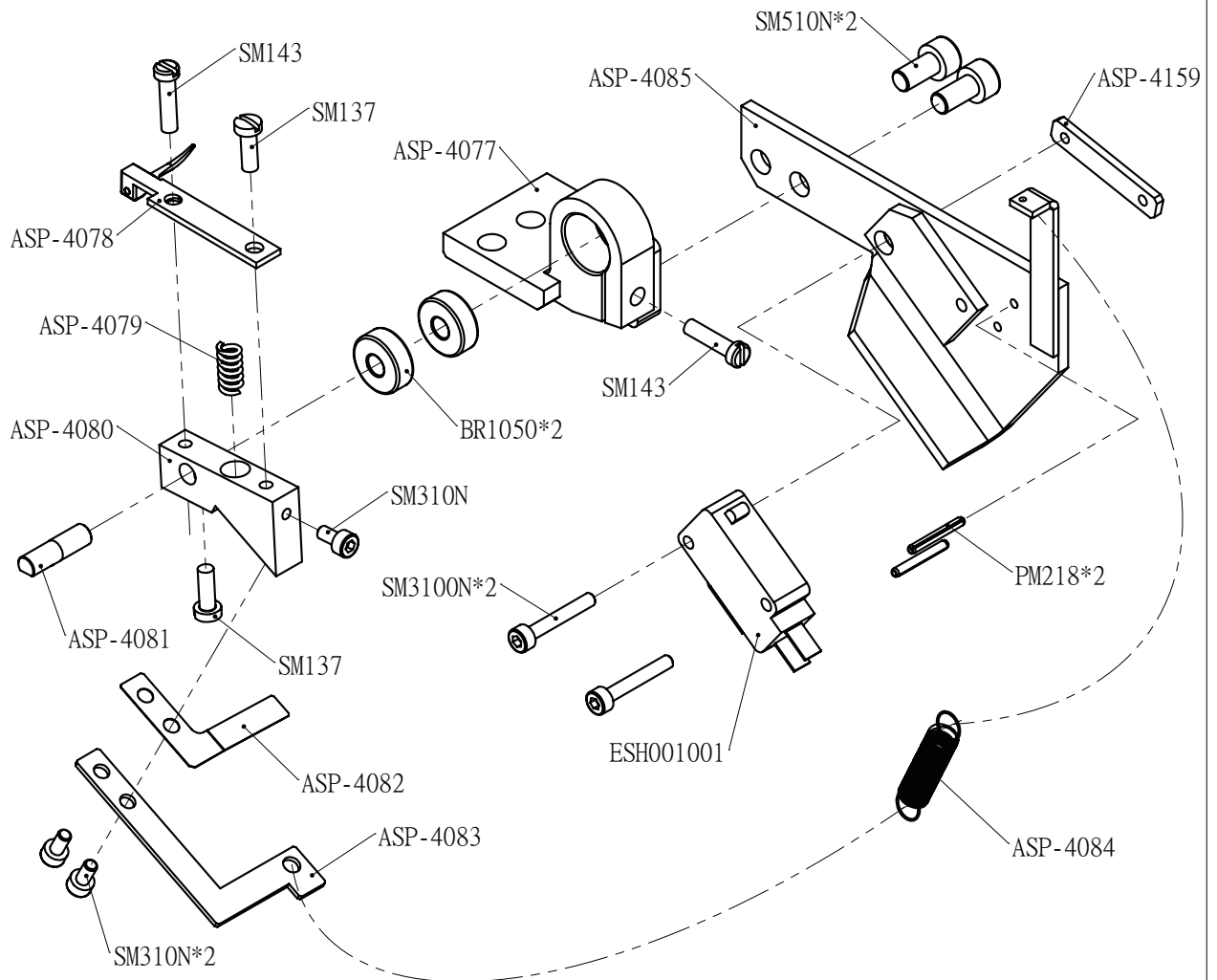
A

B

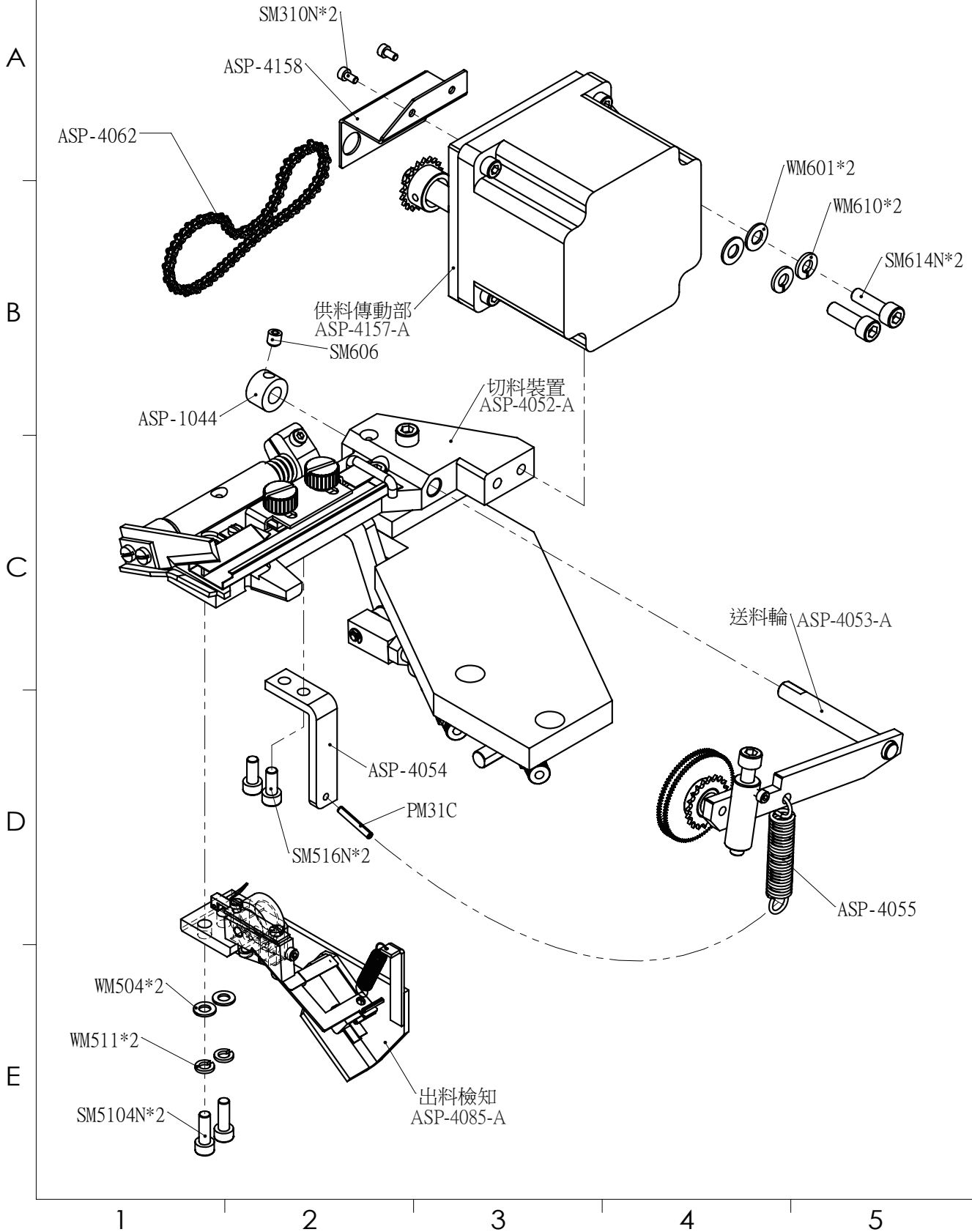
C

D

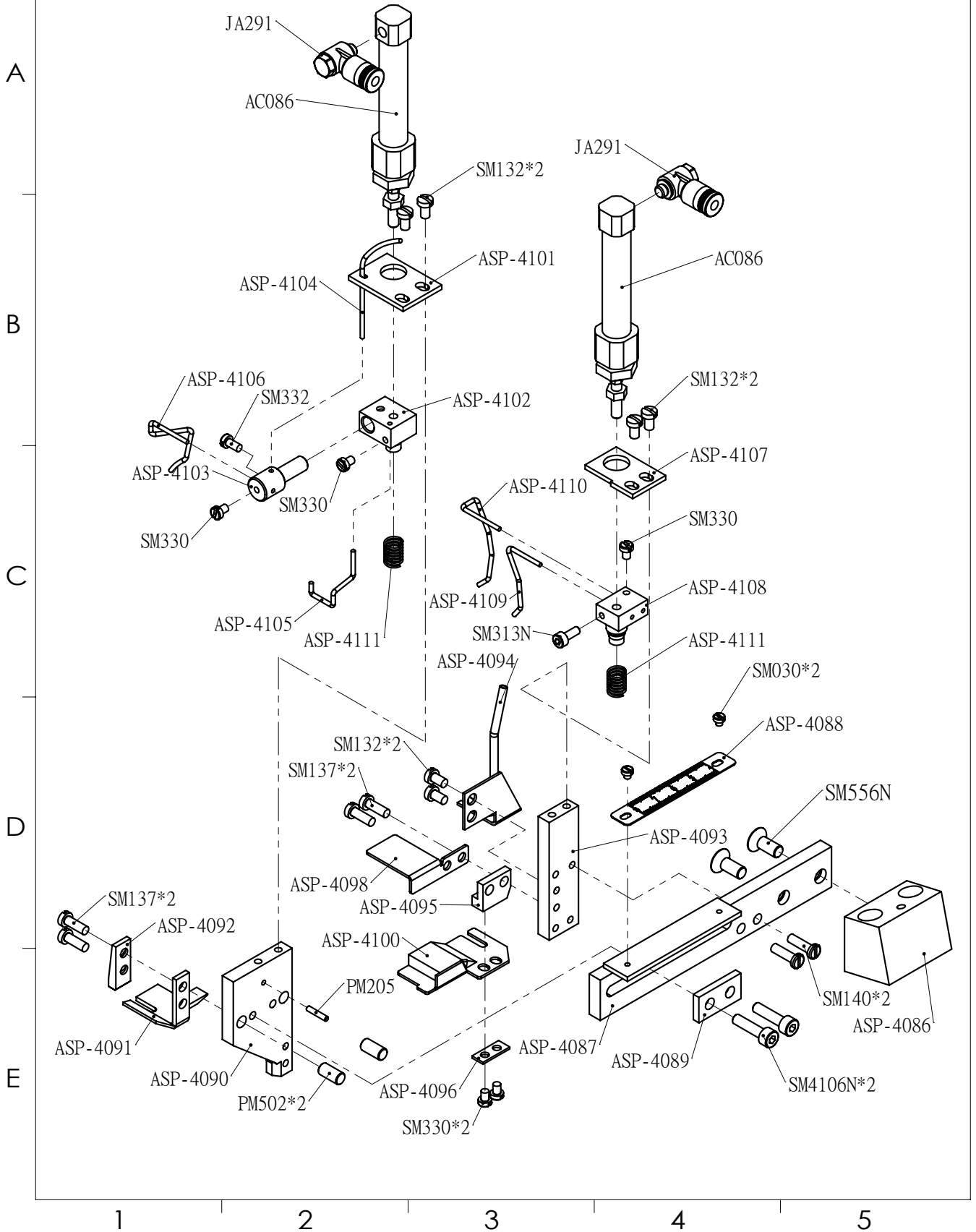
E

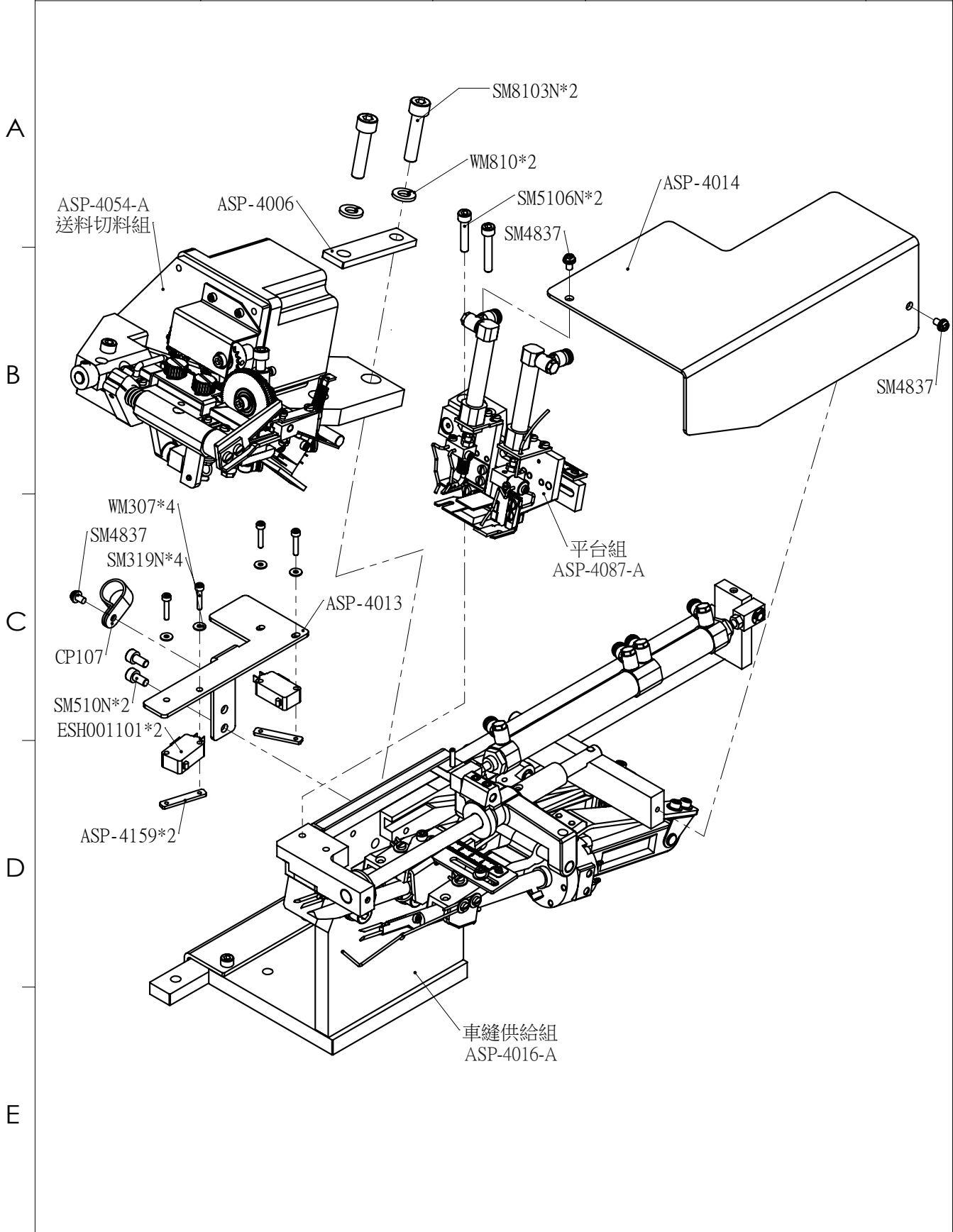


SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	送料切料組	ASP-4054-A	10/23
				Date
				2016/08/19

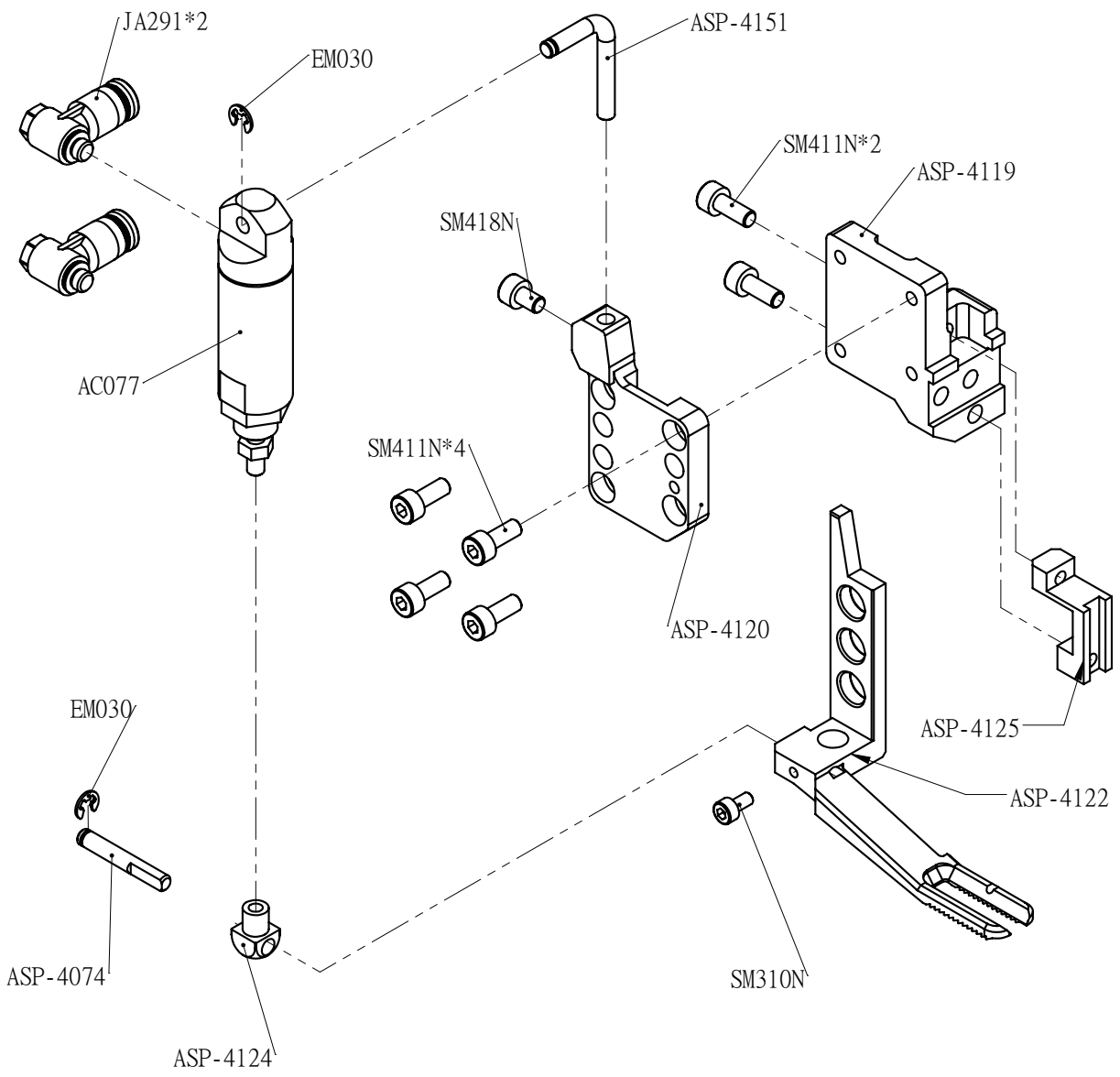




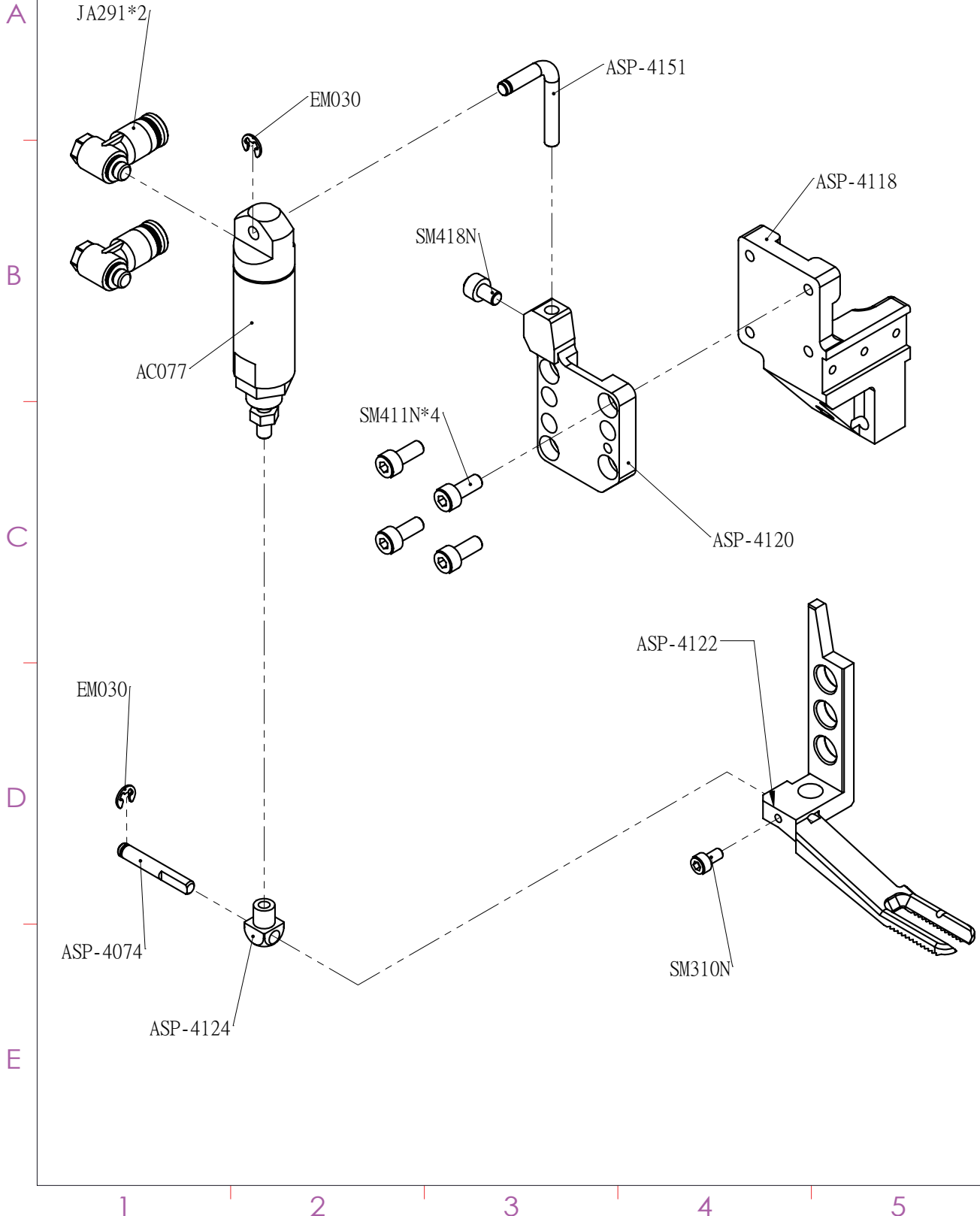


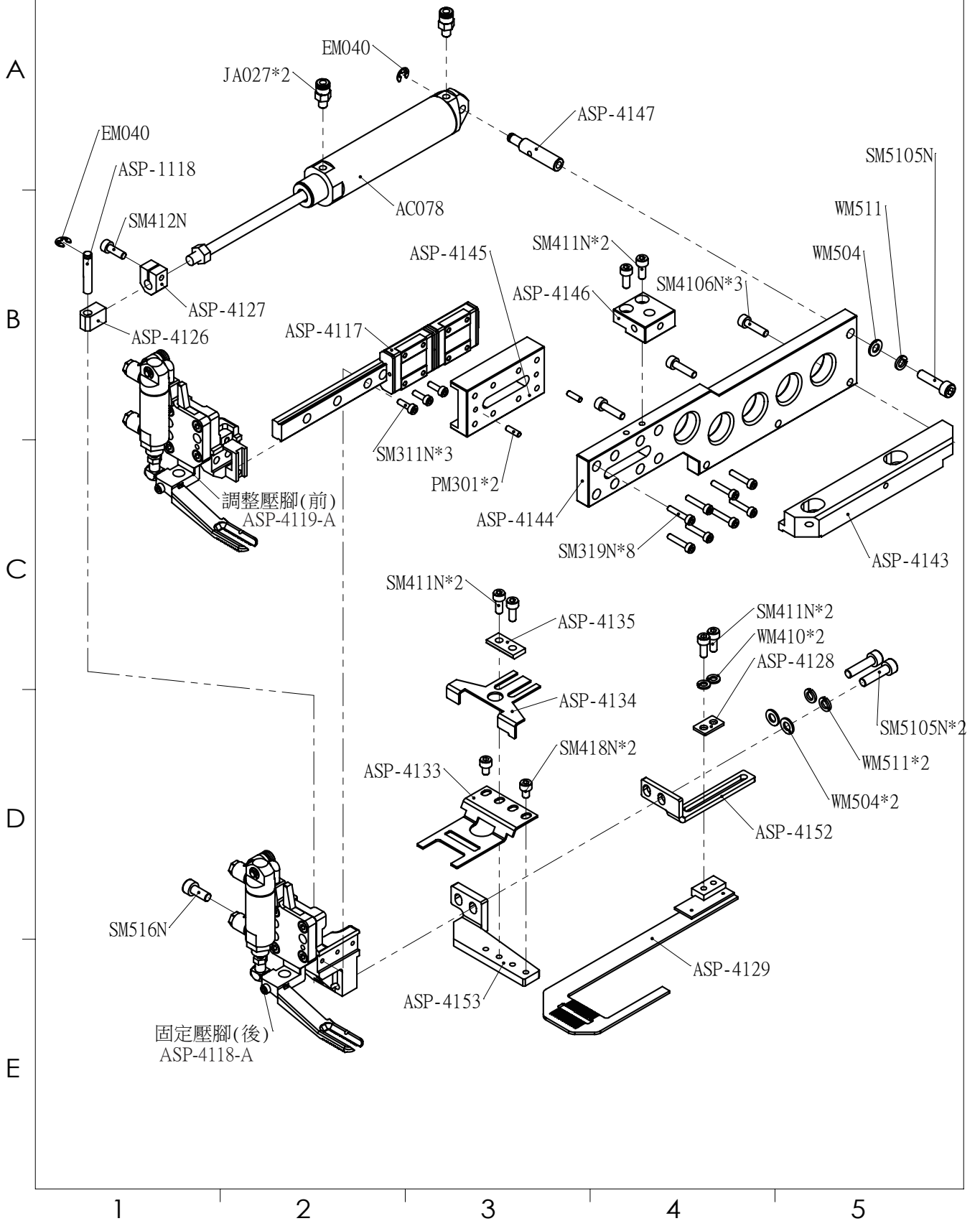


A  
B  
C  
D  
E

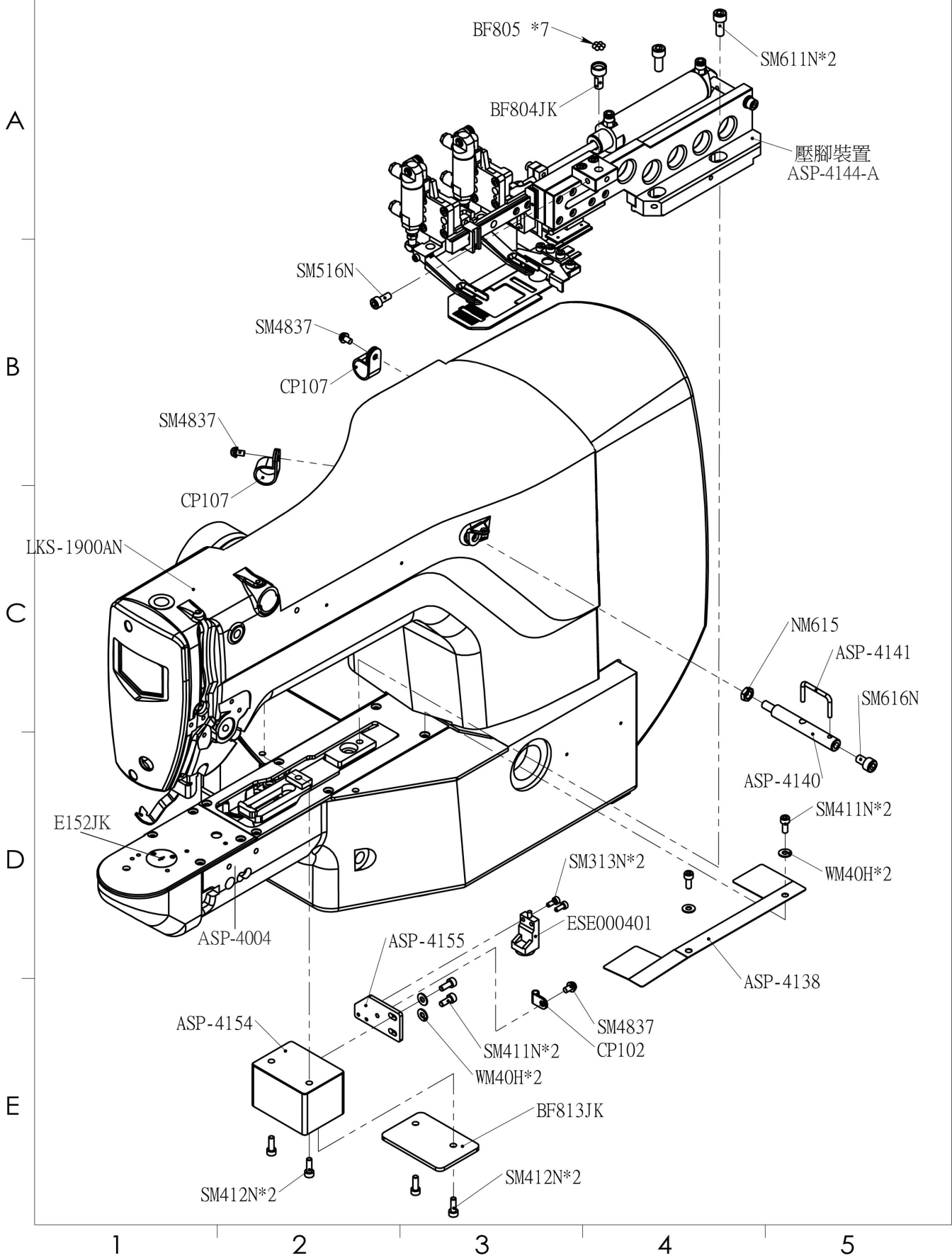


1 2 3 4 5

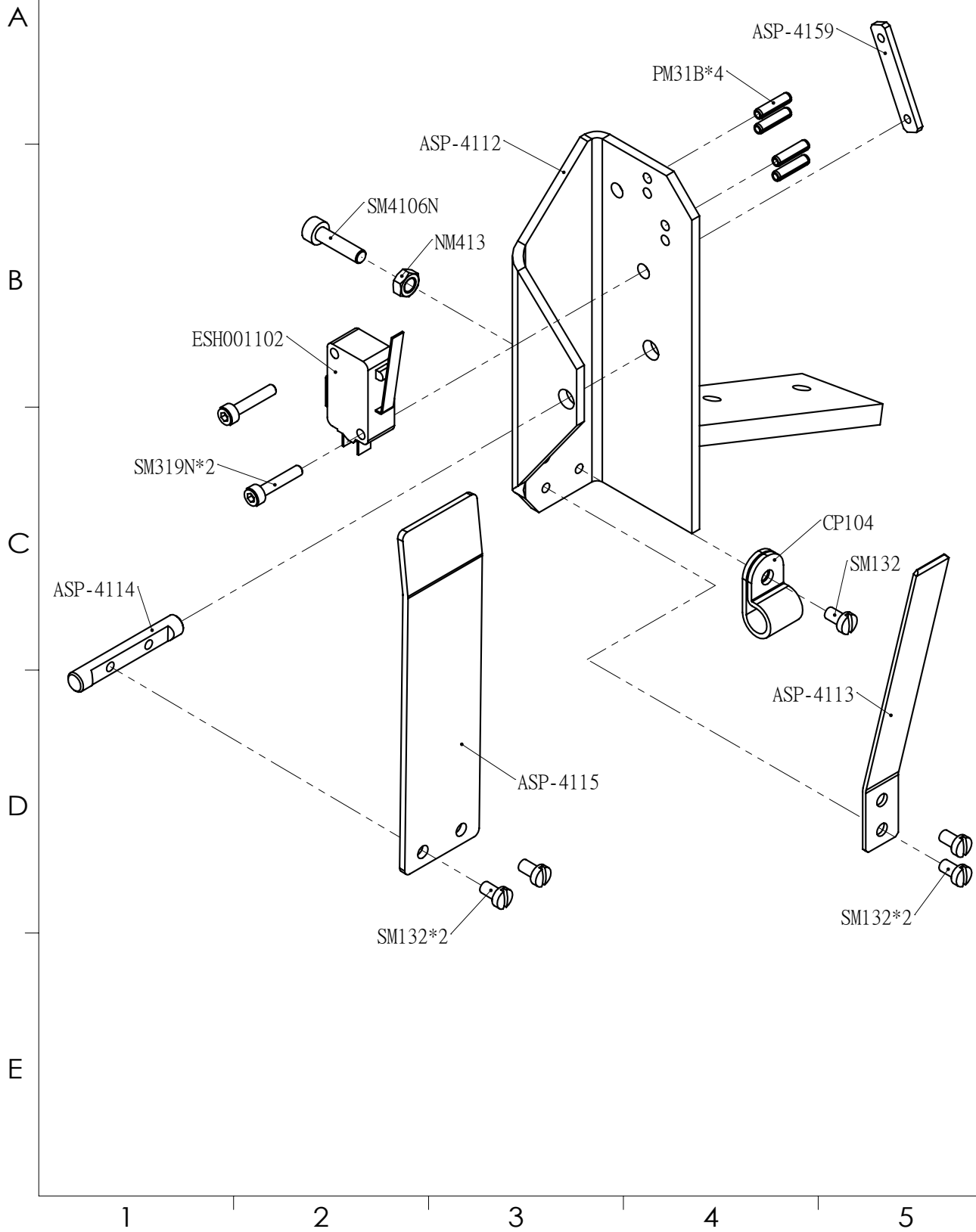




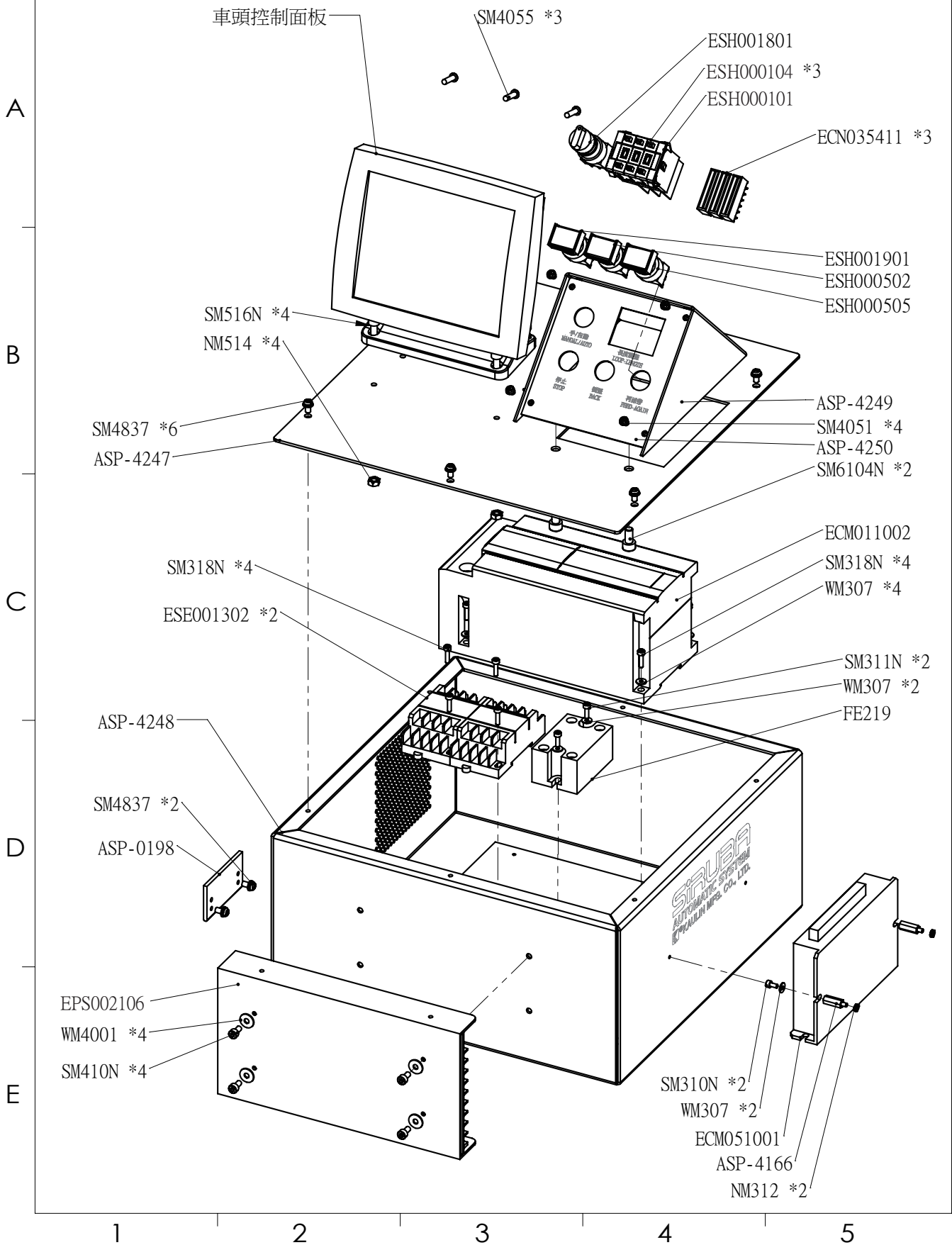
<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	車頭組	ASP-4154-A	16 / 23
				Date
				2016/08/19



SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	啟動器	ASP-4112-A	17 / 23
				Date
				2016/08/10



SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	PLC電控箱	ASP-4248-A	18/23
				Date
				2016/08/19





PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	電磁閥8連座	ASP-4149-A	19 / 23
				Date
				2016/08/19

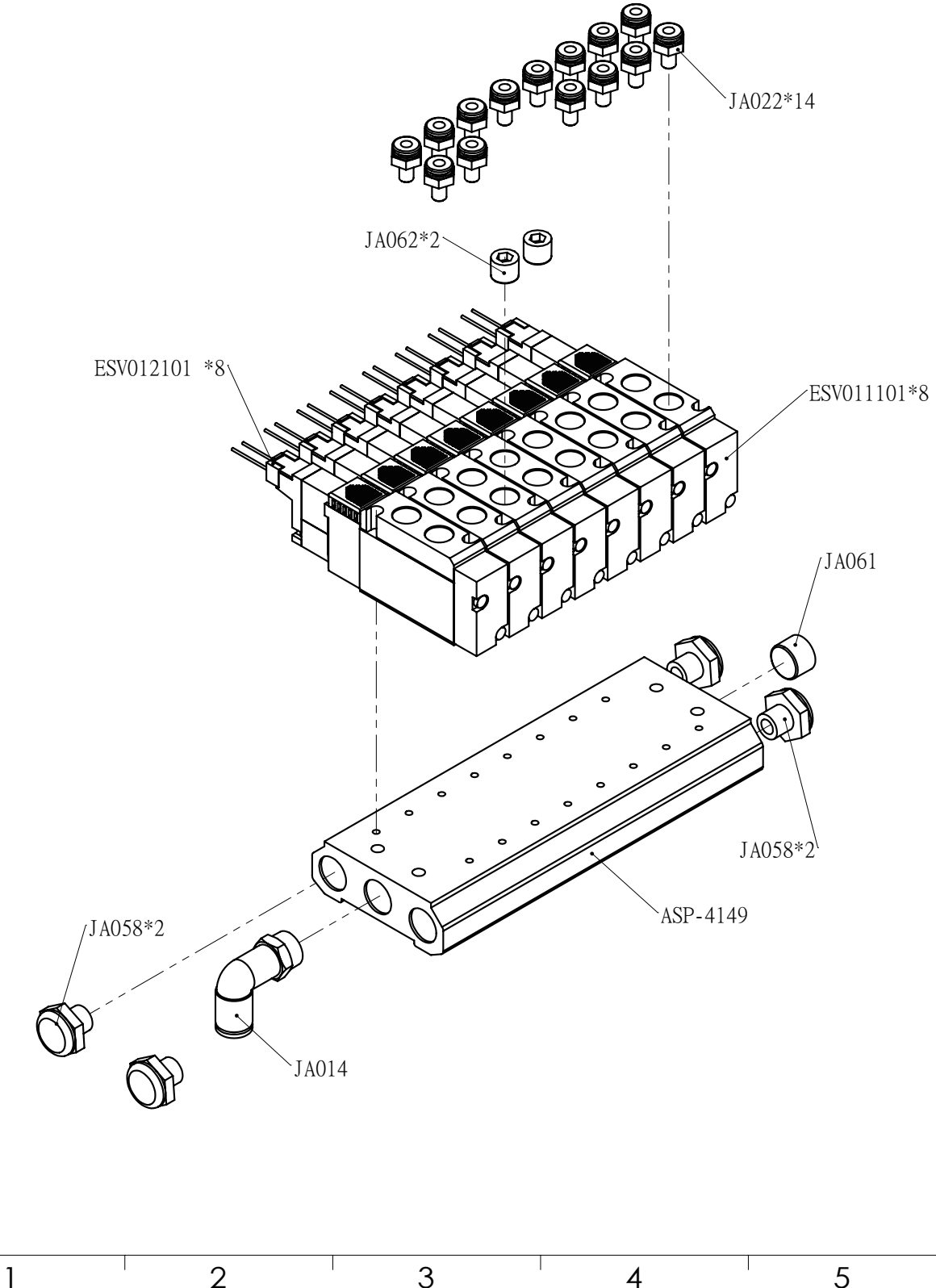
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B

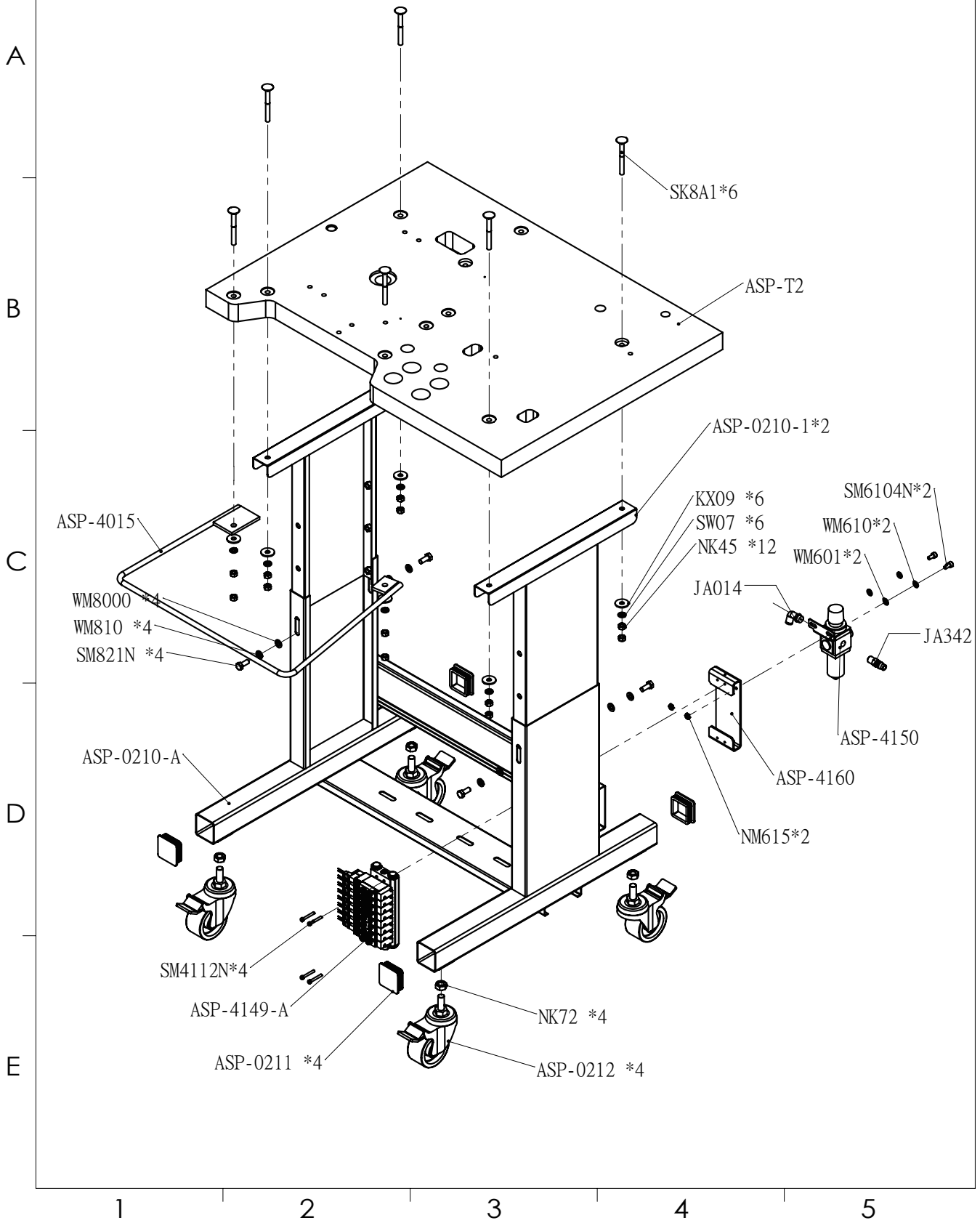
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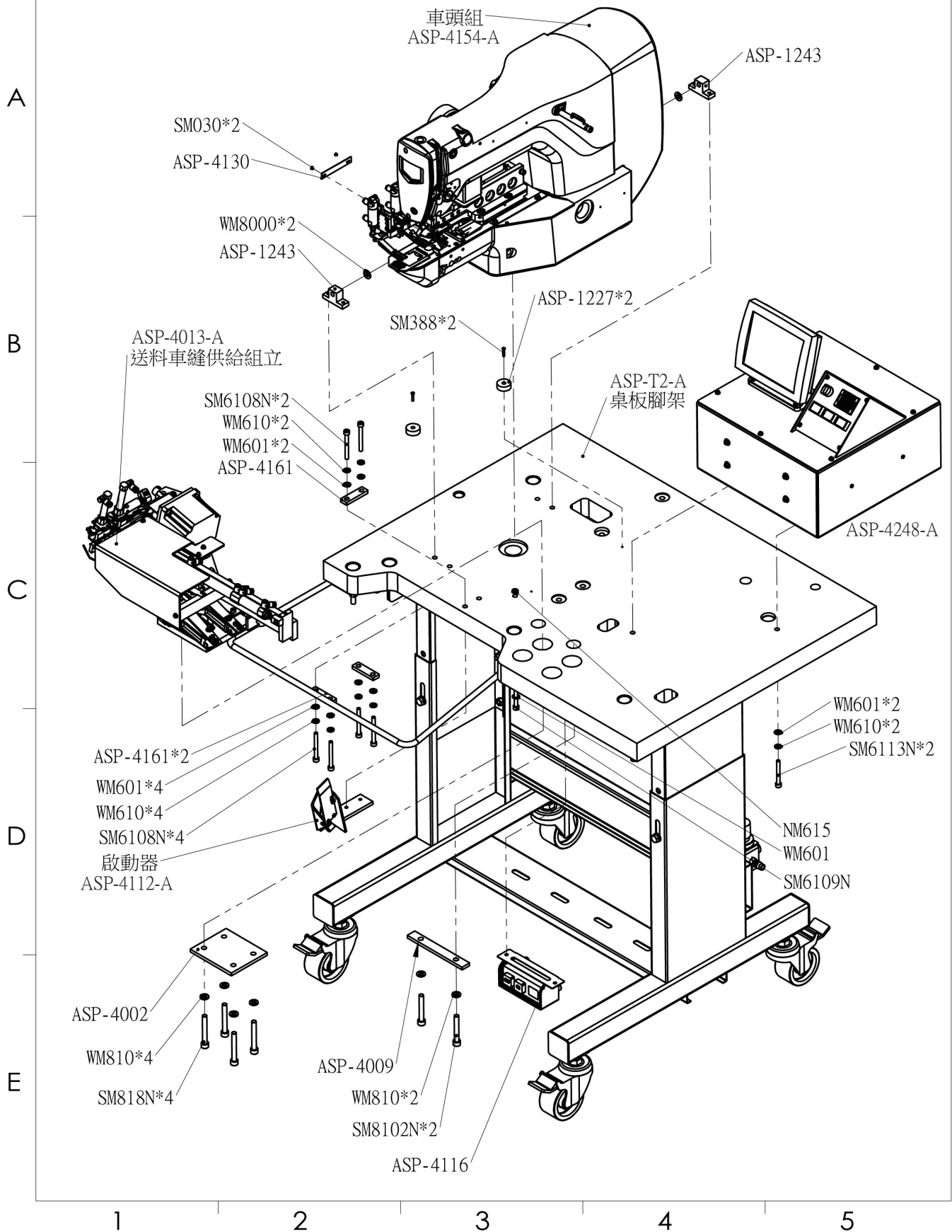
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<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASP-JBL100	桌板腳架	ASP-T2-A	20 / 23
				Date
				2016/08/19





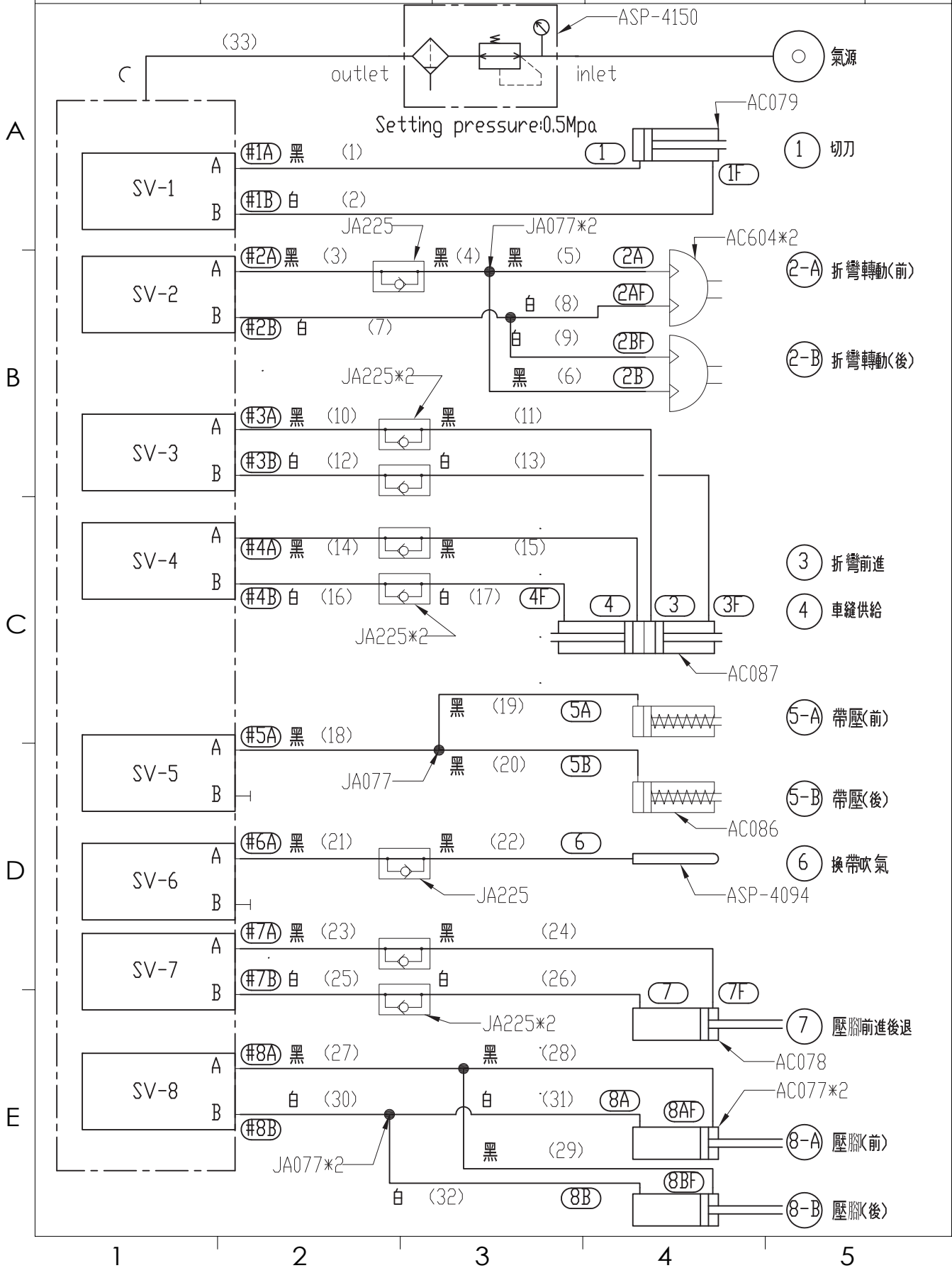
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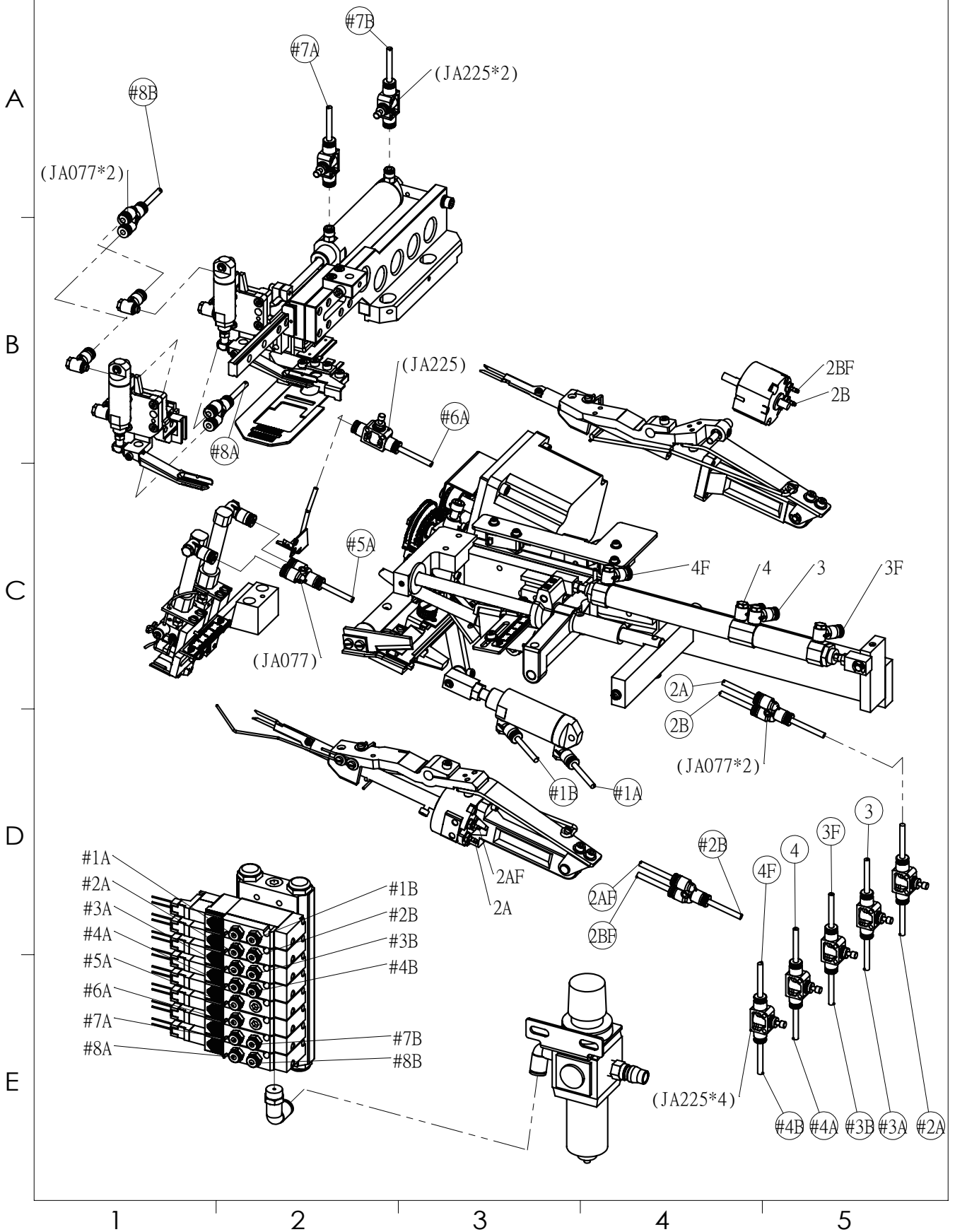
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由於對產品的改良及更新，本產品使用說明書中與零件圖之產品及外觀的修改恕不事先通知！  
The specification and/or appearances of the equipment described in this instruction book & parts list are subject to change because of modification which will without previous notice.  
ASP-JBL100.FEB.2018