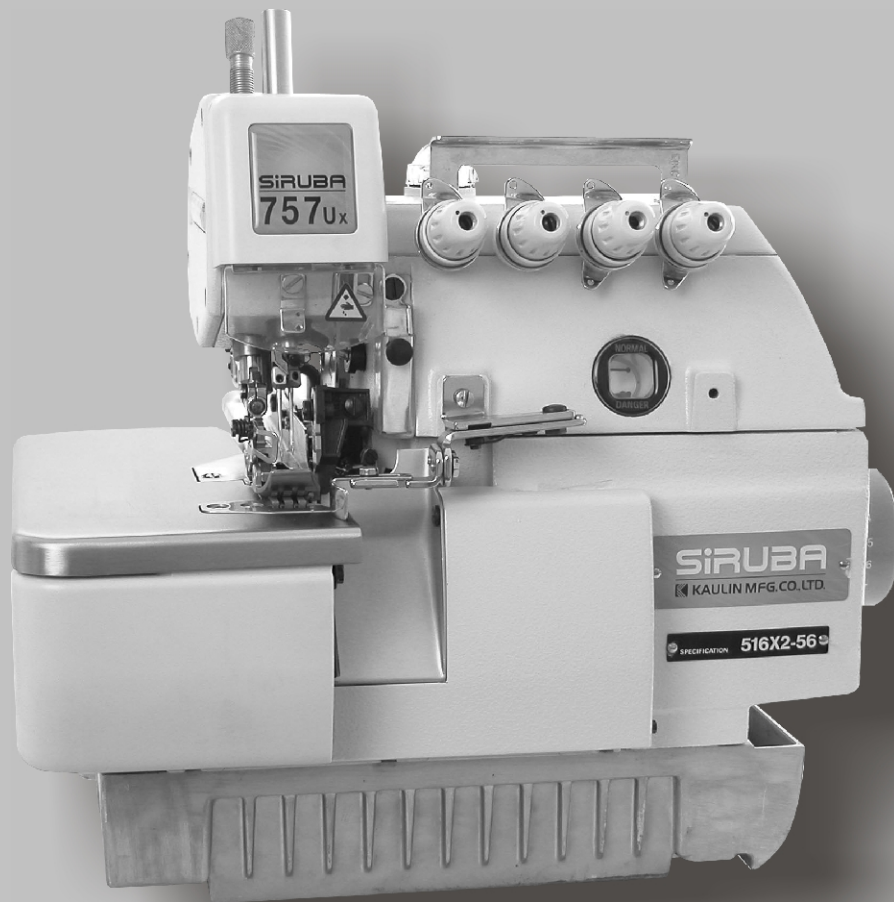


SIRUBA®

銀箭牌工業用縫紉機
INDUSTRIAL SEWING MACHINE

700UX

使用說明書 INSTRUCTION BOOK



CE

 高林股份有限公司
KAULIN MFG. CO., LTD.

EC DECLARATION OF CONFORMITY

According to the following EC Directive

Machinery Directive : 89 / 392 / EEC , as amended by 91 / 368 / EEC and 93 / 44 / EEC.

The undersigned, ROBERT TSAI , representing KAULIN MFG. CO., LTD. 11F 128 Sec. 3 Min Shen E. Road, Taipei , Taiwan ROC., manufacturer, declares that the machine described hereafter :

High speed overlock safety stitch machine

Model :700UX

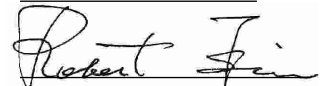
Provided that it is used and maintained in accordance with the generally accepted codes of good practice and the recommendations of the instructions manual, meets the essential safety and health requirements of the Machinery Directive.

For the most specific risks of the machine, safety and compliance with the essential requirements of the Directive has been based on elements of : the European Standard EN 292 - 1 & - 2 : 1992 Safety of machinery ; basic concepts, general principles for design.

The compliance of the model with the requirements of EC Machinery Directive was established by AIB-VINCOTTE Inter n.f.p, Avenue A. Drouart 27-29 , B 1160 , Brussels, Belgium (Notified body under the number 26 for machinery listed in annex IV of EC Machinery Directive).

Date : AUG. / 15 / 2005

Signature :



Qualification : R&D MANAGER

General Safety Instructions

Warning ! When using this machine, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury, including the following.

Read all these instructions before operating this product and save these instructions.

1. Keep work area clean.

Cluttered areas and benches invite injuries.

2. Consider work area environment.

Do not expose power to rain. Do not use machine tools in damp or wet locations. Keep work area well lit. Do not use power tools where there is risk to cause fire or explosion.

3. Guard against electric shock.

Avoid body contact with earthed or grounded surfaces (e.g. pipes, radiators, ranges refrigerators).

4. Keep children away.

Do not let visitors touch the tool or extension cord.

5. Dress properly.

Do not wear loose clothing or jewelry, they can be caught in moving parts. Wear protecting hair covering to contain long hair.

6. Do not abuse the cord.

Never carry the machine by cord or yank it to disconnect it from the socket. Keep the cord away from heat, oil and sharp edges.

7. Maintain machine with care.

Follow instructions for lubrication and changing accessories. Inspect tool cord periodically and if damaged have it repaired by an authorized serviced facility.

8. Disconnect machine

When not in use, before servicing and when changing accessories.

9. Avoid unintentional starting.

Do not carry a plugged in tool with a finger on the switch. Ensure switch is off when plugging in .

10. Check damaged parts.

Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function.

11. Warning.

The use of any accessory or attachment, other than those recommended in this instruction manual, may present a risk of personal injury.

12. Have your tool repaired by a qualified person.

Repairs should only be carried out by qualified persons using original spare parts.

Special Warning For Electric Connection !

1. Incorporate this machine only with "CE" certificate hold-to-run control device.
2. Follow the instruction manual device to install control device.
3. Always earth machine appropriately during operation.
4. Before adjustment, parts change or servicing must be sure to pull out the plug from socket to prevent the hazard of unintentionally start of machine.

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Model		757UX	
Net Weight (Kgs)	33	Noise Level, dB(A)	As attachment
Serial No.		Vibration (m/sec ²)	

致使用者

- 我們非常感謝您使用本公司出品之超高轉速直針鎖邊縫紉機(拷克車)。
- 請詳細閱讀此說明書，將使您更了解本機器獨特之性能及正確的使用方法，進而提高您縫製的效率及品質。
- 首先請您注意：請先注入潤滑油及確認馬達之轉向為順時鐘方向，才可以開動本機器。

TO THE OPERATORS

- Thank you very much for using our Ultra High Speed, Straight Needle , Overlock / Safety Stitch Machine.
- Before operating this machine, Please study this book carefully, understand the functions and features of the machine. Then it will help you to increase your sewing efficiency and quality.
- ATTENTION: Because this is an ultra high speed machine, do not run it before filling oil and making sure the motor turns clockwise.

機器安裝

- 1 · 依本機所附桌板裁製圖及零件組合圖所列之配件，依序安裝防震機座鋁板如安裝為半沉式時，機台針板面與桌面之距離為100mm，若全沉式則只有5mm。
- 2 · 馬達啟動踏板裝於左邊，押具腳踏板則裝於右邊。
- 3 · 按零件圖示裝置廢料槽及線架。
- 4 · 注意馬達之轉向為順時鐘方向，皮帶之鬆緊度以用手指向內壓下縮10mm之緊度為宜。皮帶輪與縫合轉速請參照表(1)。

HOW TO INSTALL THE NEW MACHINE

- 1 · Install Cushion Rubber and Rest Board according to the table out-out diagram. In case of semi-submerged installation is required, the distance between top surface of Needle Plate and Table Top should be about 100mm, and distance for fully-submerged installation is about 5mm.
- 2 · Setting the pedal of clutch motor on the left side and the pedal of presser foot lift on the right side
- 3 · Install the cloth waste chute, and thread stand as parts list.
- 4 · Be sure the motor's turning is in clockwise direction, V-belt transmission, the best tension of belt is to press down the bet to 10mm with finger. As for the pulley and sewing speed, please refer to Tab.1

表1/Tab 1

Machine (S.P.M.)	Motor pulley Diameter(mm)	
	60Hz	50Hz
6,000	95	115
6,500	105	125
7,000	110	135
7,500	120	145

新機器啟用規定

新機器在最初啟用磨合期的四個星期內，請用低於最高速度20%的速度運轉，之後換上新潤滑油，才運轉至最高速度。

HOW TO OPERATE THE NEW MACHINE

Please run the new machine in the first four weeks at the speed of 20% less than maximum. Then renew the oil and the machine may be allowed to run at its maximum speed thereafter.

潤滑油之注入與更換

LUBRICATION AND DRAINAGE

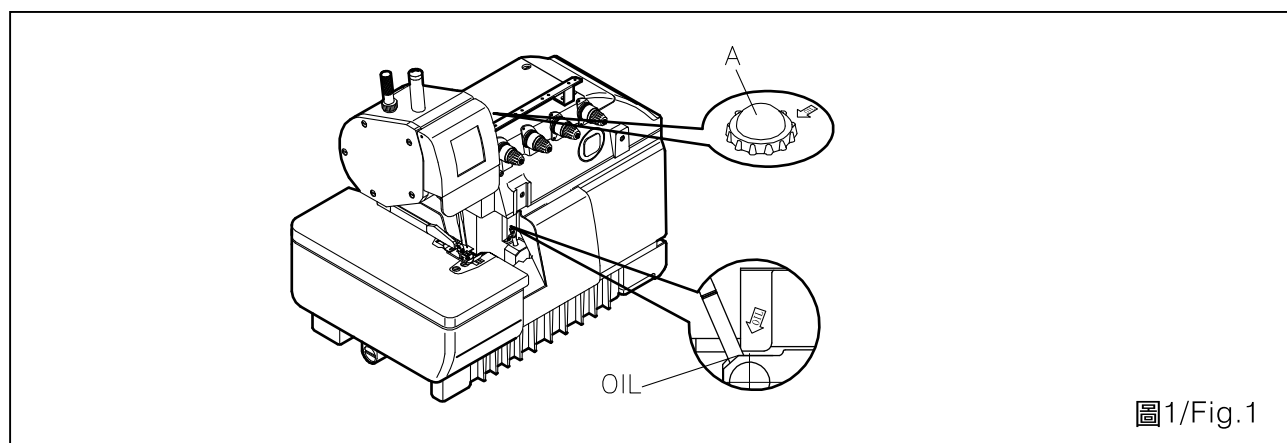


圖1/Fig.1

1. 潤滑油之注入(圖1)

- a. 將螺絲 (A) 旋開，以包裝箱內所附之超高速潤滑油或ESSO #32或同等級潤滑油加入，使油量指示桿位於油標上下之間即可，然後再鎖緊螺絲 (A)。
- b. 開箱新機器或久置未使用重新要用時，請在針棒、上勾針台等加油潤滑。

1 • Lubrication Filling (Fig.1)

- a. Remove screw (A) and fill in enclosed ultra high speed lubricating oil or ESSO#32 or equivalents until the tip of oil level indicator floats up between two marking lines. Then tighten Screw (A).
- b. When the machine is operated for the first time or it is idle for a long time; before using it, be sure to oil the top of the needle bar or upper looper shaft.

2 · 潤滑油之更換(圖2)

- a · 將螺絲(A)放鬆旋開，使油槽完全排出後再鎖緊。
- b · 為延長本機器之壽命，請於開始使用後四個星期更換新油，爾後約四個月更換一次。
- c · 本機器特別裝有濾油器，約每使用一個月後卸下清洗，必要時更換新品。

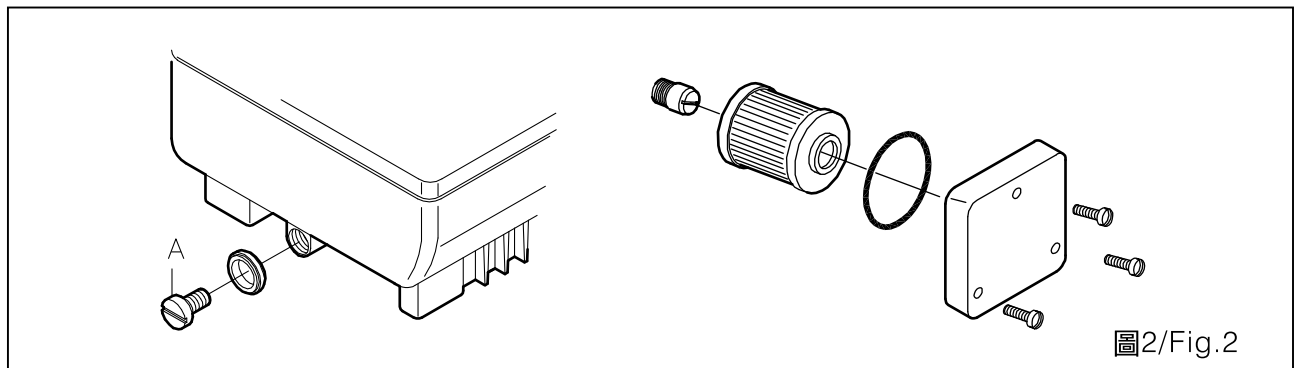
3 · 針之冷卻油

使用油：矽油(SILICON OIL)

2 · Drainage (Fig. 2)

- a · Remove screw (A) and drain out the oil then replace Screw (A).
- b · For keeping the good lubrication and machine life, please replace the new oil when the new machine has been operating over four weeks. And after that, change oil every four months.
- c · This machine has been fixed with Oil Filter. Please clean it every month or replace a new one if necessary.

3 · Needle Cooling Lubrication—Silicon Oil.

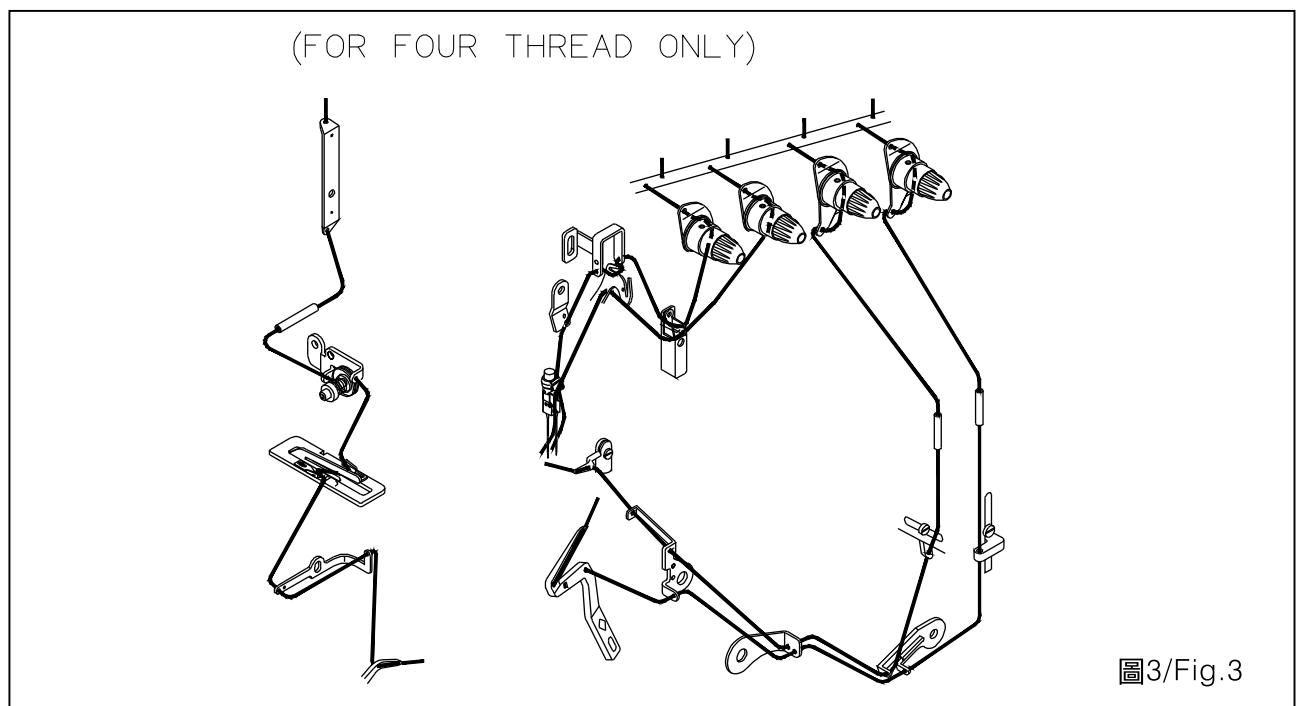


穿線方法

請確實按照圖示各種不同縫合形式穿線，錯誤之穿線將引起斷線、跳針或車縫不平坦等現象。

THREADING THE MACHINE

Refer to the sewing type you need for correct threading. Any incorrect threading may cause thread breaking, uneven stitches or stitch skipping etc.



控線調整

THREAD TENSION ADJUSTMENT

控線強弱必須根據縫合材料種類、厚薄、線、針距及包邊寬度等之不同而做不同之調整。

1. 調整鈕之控線關係(圖4)

第一調整鈕控制雙環針線或左邊拷克線。

第二調整鈕控制包邊針線。

第三調整鈕控制上勾針線。

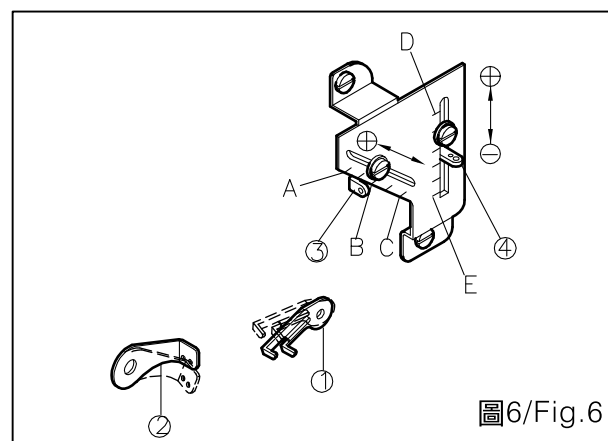
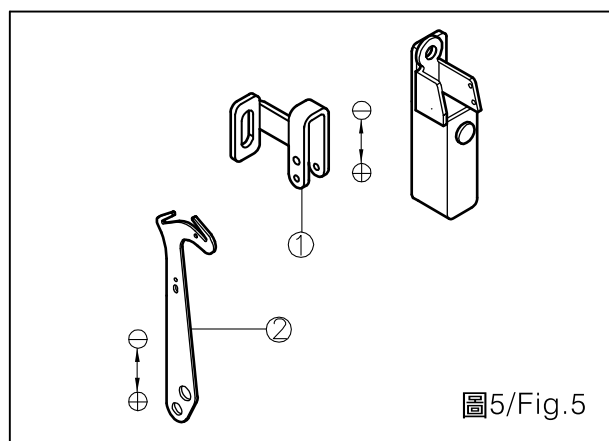
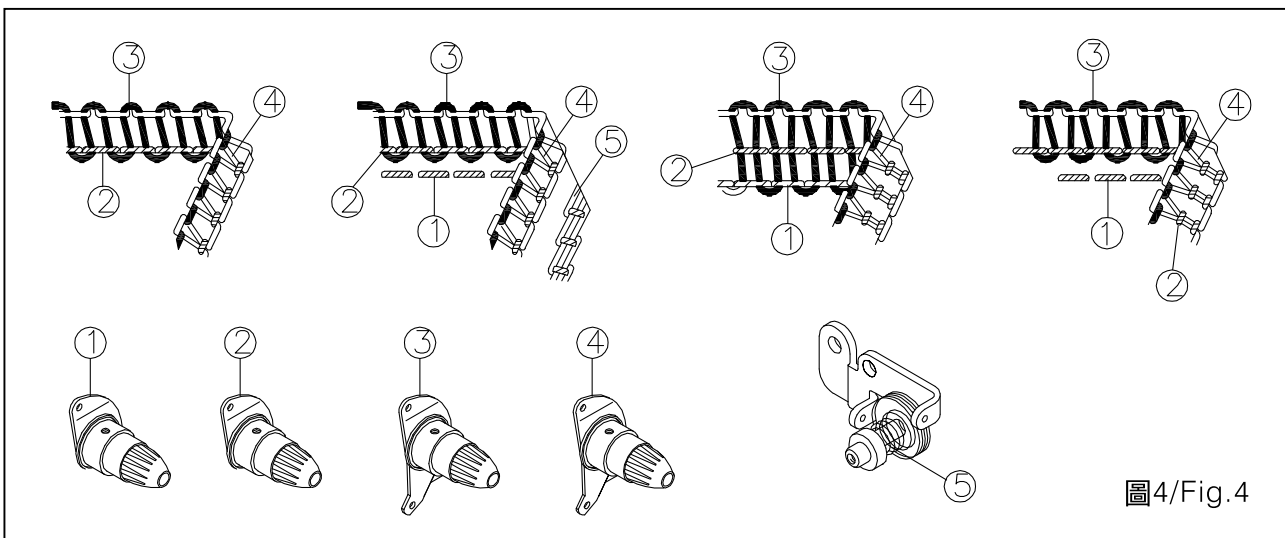
第四調整鈕控制下勾針線。

第五調整鈕控制雙環勾針線。

The thread tension should be adjusted according to sewing fabric, thickness, sewing thread, seam width, binding width etc. Therefore the pressure of the Tension Nuts or Thread Guide must be adjusted in each individual case.

1. Tension Nuts Adjustment. (Fig. 4)

- The Tension Nut(1) Controls the double chain needle thread or left side overlock needle thread.
- The Tension Nut(2) controls the overlock needle thread.
- The Tension Nut(3) controls the upper looper thread.
- The Tension Nut(4) controls the lower looper thread.
- The Tension Nut(5) controls the double chain looper thread.



2 · 針線控線關係(圖5)

- a · 在縫合方式504、512、514時，將(1)、(2)移至最下端，縫合方式503及505時，將(1)、(2)移至最上端。
- b · (+)表示增加針線強度，(-)表示減少針線強度。

3 · 勾針控線關係(圖6)

- a · 在縫合方式為512，當上勾針移至最左時，將(1)及(2)調整至虛線位置。若縫合方式為503、504、505及上勾針移至最低時，將(1)及(2)調整至實線位置。
- b · 固定線導板(3)如下：
 - A點：尼龍伸縮線
 - B點：拷下擺
 - C點：縫合方式512
- c · 固定線導板(4)如下：
 - D點：尼龍伸縮線
 - E點：拷下擺(+)方向為縫合線較多，反之則較少。

2 · Needle Thread Control(Fig.5)

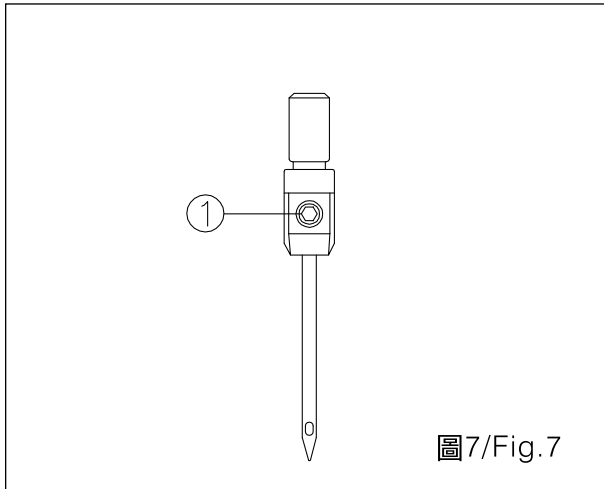
- a · When sewing type is 504, 512 or 514, push Thread guide (1) and (2) to the lowest point. And push up to the highest point for sewing type 503, 505.
- b · NOTE : The (+) direction is for more needle thread tension, and the (-) direction is for less needle thread tension

3 · Looper Thread Control(Fig.6)

- a · When sewing type is 512, and upper looper is extremely left, push Take up (1) and (2) at the position as the dotted line. When sewing type is 503, 504, or 505, and upper looper moves to the lowest position, set take up (1) and (2) at the position as the continuous line.
- b · Adjust Thread guide (3) as follows.
 - Point A : for nylon stretchy thread.
 - Point B : for blind hemming.
 - Point C : for sewing type 512.
- c · Adjust Thread Guide (4) as follows :
 - Point D : for stretchy thread.
 - Point E : for blind hemming.NOTE : The direction (+) is for more thread in sewing seam, and the(-) direction is for less thread in sewing seam.

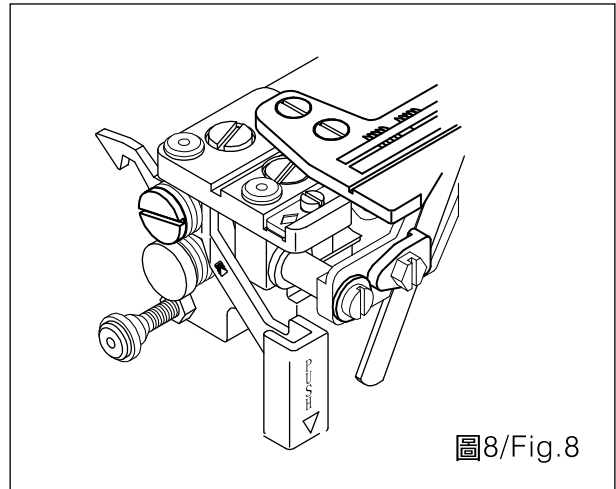
換針方法

- 使用DC×27或同規格之針(圖7)。
- 旋開螺絲並取下針。
- 將新針插至針孔最底端，並使針之長溝面向自己。
- 固定螺絲



NEEDLE REPLACEMENT

- Please use DC×27 or equivalent needle size(Fig 7).
- Loosen Screw and remove the old needle
- Insert the needle which long groove faces you and push it up deep into the needle hold until it stops and
- Tighten Screw .



針距調整

通常按縫合布料，差動比之不同而調整。持續壓下按鈕並轉動皮帶輪使鈕卡住，再轉動皮帶輪至所需之針距後放開此按鈕(圖8)。

STITCH LENGTH ADJUSTMENT

The stitch length adjustment is made according to sewing fabric, differential feed ratio etc.

Keep pressing the push bottom and turning the pulley until the push bottom is locked , and turning the pulley again to adjust the stitch length you desired and then loosen the push bottom(Fig. 8).

表2/Tab 2

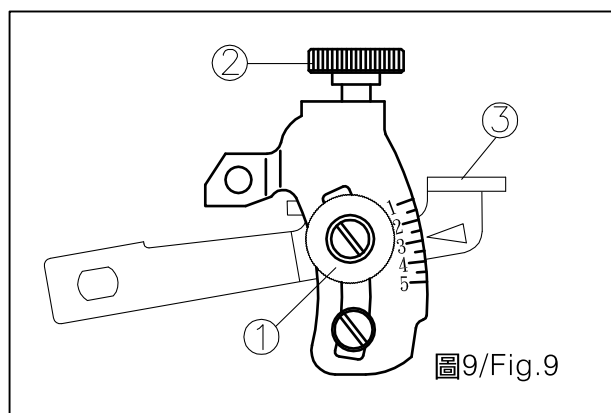
Maxi Diff ratio	Machine type	Pulley scale						
		1	2	3	4	5	6	7
1 : 2	Seaming	1	1.5	2	2.5	3	3.5	3.8
1 : 3	Shirring	0.7	1	1.4	1.7	2	2.3	2.5
1 : 1.3	Serging	1.6	2.3	3.1	3.9	4.7	5.4	5.9
1 : 4	Special	0.6	0.9	1.2	1.5	1.8	2.1	—

差動比調整

DIFFERENTIAL FEED RATIO ADJUSTMENT

若主送料具之運動程大於分送料具運動程時，則布料車縫時伸張，反之則收縮。調整方法為放鬆螺絲(1)轉動螺絲(2)順時鐘方向時使布料伸張，反之則收縮，調整後再固定螺絲(1)。

註：當調整桿(3)之表面固定在刻劃2時，其差動比為1：1，若將其固定在刻劃2以上時，可使布料伸張至1：0.7。



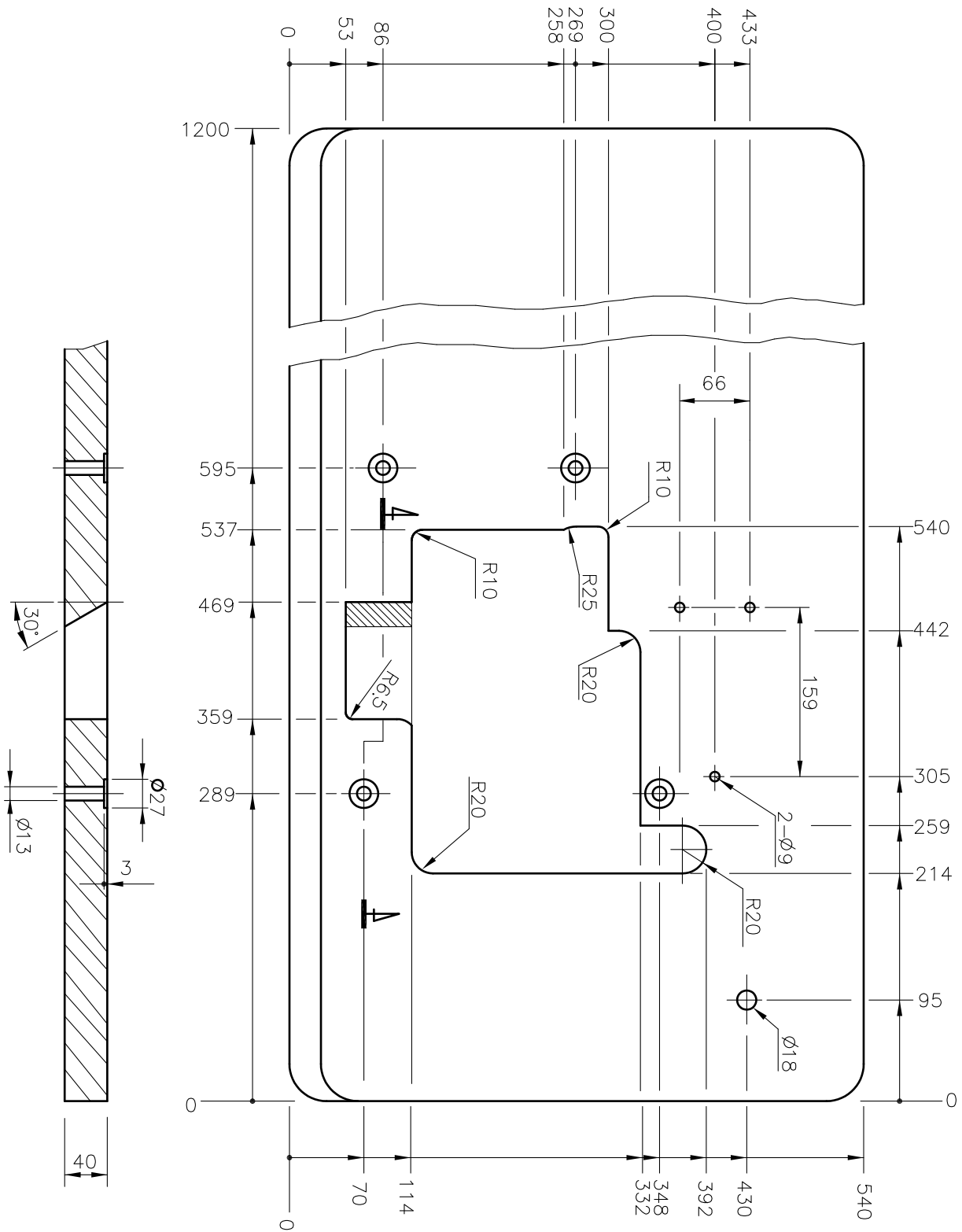
The differential feed ratio is the ratio of movements between Main Feed Dog and Differential Feed Dog. When the movement of Main Feed Dog is bigger than Differential Feed Dog, the fabric is stretched in sewing and shrunk to the contrary. Loosen Nut (1) and turn the screw (2) in clockwise for stretching the fabric, and in reverse direction for shrinking the fabric then tighten the screw(1).

NOTE : When the surface of adjusting Level (3) be set at the scale (2), the differential feed ratio is 1 : 1, and if it is set over the scale (2) it can make the fabric stretch to the ratio 1 : 0.7.

表3/Tab 3

Scale		1	2	3	4	5
Differential Feed ratio	1 : 1.3	—	1 : 0.7	1 : 0.9	1 : 1.1	1 : 1.3
	1 : 2	1 : 0.7	1 : 1	1 : 1.4	1 : 1.7	1 : 2
	1 : 3	1 : 1	1 : 1.5	1 : 2	1 : 2	1 : 3
	1 : 4	1 : 1.1	1 : 1.6	1 : 2.3	1 : 2.3	1 : 3.3

TABLE CUT-CUT SEMI-SUBMERGED





700UX

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