

# SIRUBA

ORIGINAL

使用說明書與零件圖

INSTRUCTIONS BOOK & PARTS LIST

■ASK-ASM100





**ENGLISH**

**ENGLISH**

## A WARM REMINDER

please register your Siruba machine online or through Siruba App at once, as to gain the full warranty protection. You may also acquire more useful information through Siruba APP.



## GENERAL SAFETY INSTRUCTION

For the sewing machine, automatic mechanic system, and auxiliary devices (hereinafter referred as “machine” ), it is inevitable to conduct work near moving parts of the machine. This means that there is always a potential risk from the moving parts. Operators actually operating the machine and service technicians performing maintenance and repair are strongly advised to read and understand fully the following instructions in advance.

The safety instructions include items which are not listed in the specifications of your product. It is the manager/ supervisor’s responsibility to have their fellow workers fully understand before operation.

Fail to follow the instructions may cause damage to properties, severe injure or even death.

Explanation of warning indications and labels.

	<p>HIGH VOLTAGE DANGER</p> <p>Do not open the power cabinet within 10 minutes after the power off.</p>		<p>Machine moving area!</p> <p>Stay away and keep clear to avoid injury.</p>
	<p>High speed moving area!</p> <p>Stay away and keep clear to avoid injury.</p>		

WARNING LABELS		WARNING LABELS	
	<p>A risk of cut and injury from moving parts. Stay away and keep clear.</p>		<p>Be aware that holding the sewing machine during operation can hurt your hands.</p>
	<p>A risk of electric shock. Stay away and keep clear.</p>		<p>There is a risk of entanglement in the belt resulting in injury.</p>
	<p>A risk of burn from the high temperature area. Stay away and keep clear.</p>		<p>There is a risk of injury if you touch the button carrier.</p>
	<p>Avoid direct eye contact with the laser beam or other light source.</p>	GENERAL SAFETY INDICATIONS	
	<p>A risk of injury to head from upper contact. Apply proper protection (helmet) and keep clear.</p>		<p>The correct direction is indicated.</p>
			<p>Grounding connection as indicated.</p>

## SAFETY PRECAUTIONS

### Danger

An accident means ” to cause personal injury or death, or damage to property. ”

When it is necessary to perform service on electrical parts, be sure to turn the power off and wait for 5 minutes or more before opening the power cabinet/box in order to avoid electrical shock.

### Caution

#### 1. Basic precaution

- (1) Read the manual and other papers supplied with accessories of the machine before operation. Keep the manual and papers at hand for quick reference.
- (2) The content of this section includes items which are not listed in the specification of your product.
- (3) Always wear safety goggles and gloves to avoid accident caused by parts breakage.
- (4) For those who use a heart pacer, please consult the medical specialist first.

#### 2. Safety devices and warning labels

- (1) Check to ensure all safety devices are correctly installed in place and properly before operation.
- (2) If any of the safety devices is removed for service cause, please be sure to replace it back to position and verify that it works normally before resuming operation.
- (3) Always keep the warning labels adhered on the machine clearly visible. If any of the labels missing or contaminated, replace with a new one at soon.
- (4) Fail to obey instructions above may cause severe injury or death to the operators.

#### 3. Application and modification

- (1) It is prohibited to use the machine for any application other than its original intention, or in any manner other than that prescribed in the instruction manual.
- (2) Never modify or alter the machine. Any unauthorized change of the specification will not be covered by the warranty.
- (3) Our company assumes no responsibility/liability to damages, injuries, or death resulting from the machine which has been modified or altered.

#### 4. Education and training

- (1) The plant managers/supervisors are obliged to provide education and training to operators and service technicians. A good education/training plan not only avoids personal injury but also prevent damage to the property.
- (2) Only a well-trained operator is allowed to operate the machine.
- (3) Only a certified technician is allowed to perform service to the machine.

#### 5. Situations that you must turn off the power

Turning off the power: press EMG Stop (if there is one), switch off the power, and remove the power plug from the outlet.

- (1) When there is a failure or abnormality, press EMG Stop (if there is one), switch off the power.
- (2) To prevent accident resulting from abrupt start of the machine, before operating the machine, always turn off the power and switch on again.
- (3) When cleaning or inspecting the machine, make sure the machine stops completely after turning off the power.
- (4) When performing service (i.e. changing of adjusting any component), make sure the power is off and the machine stops completely.

6. Remove the power plug by holding the plug section instead of the cord to avoid electrical shock, leakage, or fire accident.
7. Turn off the power whenever the machine is left unattended between works.
8. In case of a power failure or black out, turn off the power to avoid damage or accident.

## PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

### 1. Transportation

- (1) When lift or move the machine, please take the machine weight into consideration and apply a safe manner. Refer to the specification for the information you need for transportation.
- (2) Apply sufficient safety measures when lifting or moving the machine to avoid falling or dropping.
- (3) To avoid unexpected accident, do not reuse the packing material for transportation.

### 2. Unpacking

- (1) Before proceeding to unpacking, check the balance of the machine and apply necessary tools to hold the proper position.
- (2) When unpacking, follow the instruction printed on the cartoon. Be careful of the nails and chips when unpacking from a wooden rack.

### 3. Installation:

#### 3A. Table and Stand

- (1) Only adopt a qualified genuine table and stand to assure the holding support. In case you need to leave the machine on a surface temporarily for service, make sure the surface is strong enough to hold the weight.
- (2) If casters are applied to the table stand, adopt casters with a locking mechanism only and lock them well to secure the machine during the operation and service.

#### 3B. Cable and Wire

- (1) The cables and wires must comply with the specification and requirement.
- (2) The cables and wires shall be free from bending or extra force. Reserve a free space of at least 30mm between cables/wires and the moving parts.
- (3) Do not apply starburst connection when wiring.
- (4) All connectors must be fixed securely. And always hold the connector body when removing it.

#### 3C. Grounding

- (1) Grounding is necessary and must be done by a certified technician. (2) Check and ensure the grounding is secured before operation.

#### 3D. Motor

- (1) The motor must comply with the specification and requirement.
- (2) If there is a belt in the motor transmission, adopt or apply a proper protector to avoid entangling.

### 4. Before Operation

- (1) Before turning on the power, make sure all the connectors, cables, and wires are free from damage, dropout, or looseness.
- (2) Check and make sure the pulley rotation follows the same direction as labels.

- (3) Make sure all the stand casters are locked or fixed in position.
- (4) Keep the working area clean from obstacles.

#### 5. During Operation

- (1) Always keep your fingers, hair, or clothing away from the moving components and moving area. Do not place your personal belongings on the machine.
- (2) The machine is designed to run at high speed. Always keep your hands away from the moving area. Do not resume the work cycle until the machine stops completely.
- (3) Be careful not to be caught by the machine or components when removing or resetting the machine.
- (4) To avoid accident caused by abrupt start, when performing service on the motor or belt, make sure the power is off and the machine stops completely.
- (5) A servo motor is silent as the machine stops. Be sure to turn off the power to avoid an abrupt start. (6) Always keep the fan and airway of the power cabinet clean from any obstacle.

#### 6. Lubrication

- (1) Apply only qualified oil and grease onto the parts as instructed in the manual.
- (2) If the lubricant contacts your eye or body, wash it off immediately. Consult a medical care if necessary.
- (3) If the lubricant goes into your body accidentally, go to the nearby medical care immediately.

#### 7. Service

- (1) Only a certified engineer/technician is allowed to perform service to the machine, including adjusting and repairing. Use only genuine parts for replacement. Our company assumes no responsibility/liability for any accident caused by improper repair or adjustment, or the use of any parts other than genuine one.
- (2) Only a certified technician or authorized engineer is allowed to repair or maintenance the electric system.
- (3) When performing service to air-driven parts, like an air cylinder, first disconnect the air supply and expel the air completely to avoid abrupt start.
- (4) Check all screws and nut are fixed well after adjusting and replacement.
- (5) A periodical cleaning is necessary. Make sure the power is off and the machine stops completely before cleaning.
- (6) If the machine functions poorly or abnormally, stop the operation and turn off the power. Contact the authorized dealers or us to request for a technical service support.
- (7) When there is a fuse failure, turn off the power, find out the cause of the failure and apply solution to it, then replace with a new one with the same spec.
- (8) Periodically check and clean the fan airway and the cable/wiring.

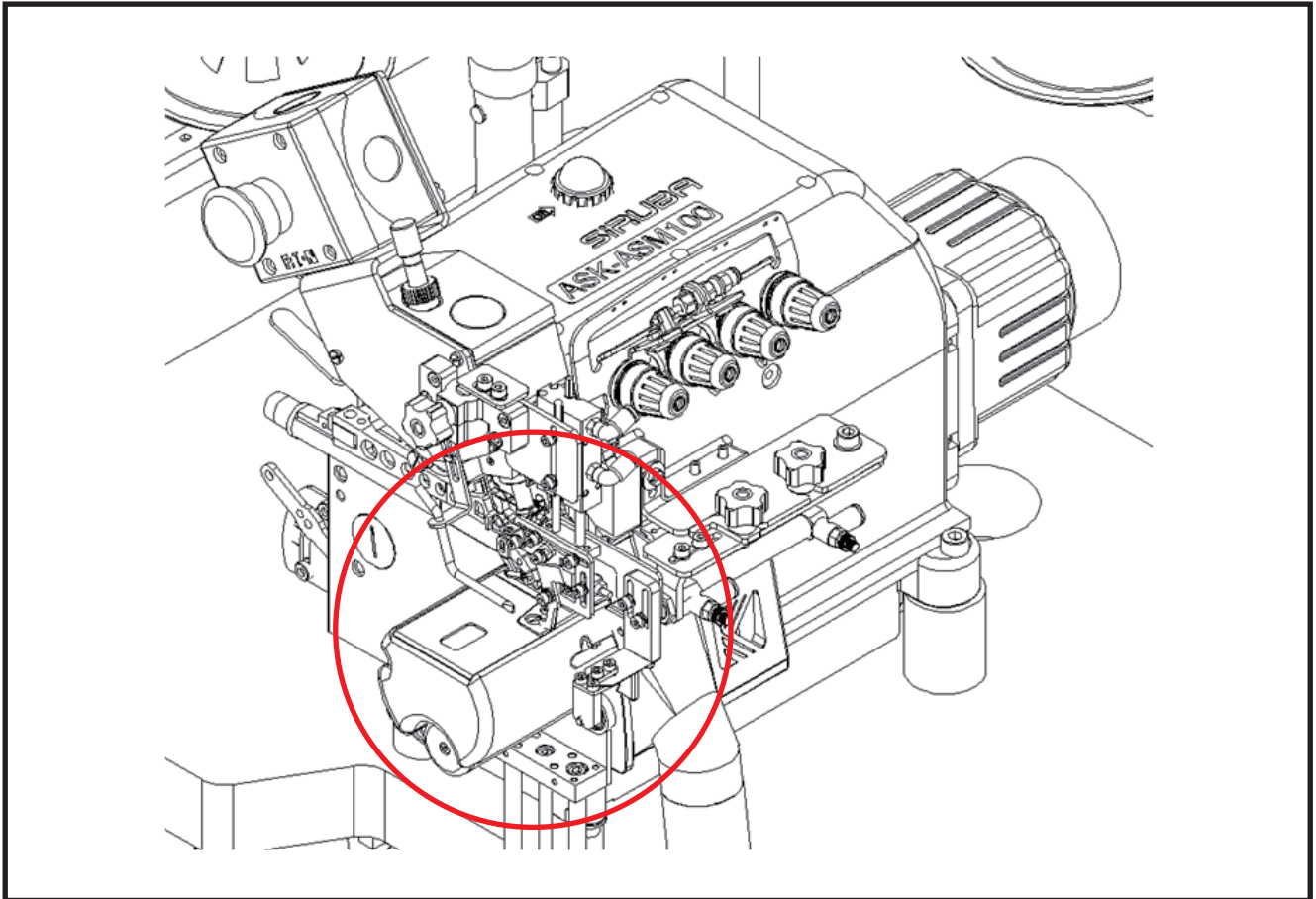
#### 8. Working Environment

- (1) The machine should be free from the affection of electro-magnetic wave.
- (2) The power supply should be in good and reliable condition, the fluctuation of rated voltage should be less than 10%.
- (3) Always check the air pressure and quality. Some extra device might be needed if the supply is not reliable.
- (4) The machine is designed to be used with ambient temperature  $5^{\circ}\text{C} \sim 35^{\circ}\text{C}$ , relative humidity 35%~85%.
- (5) To protect the electronic components and for safety cause, when there is a frost resulting from a dramatic temperature rise, disconnect the power and wait until it dry completely.
- (6) For safety cause, when there is a thundering or lightening, stop the operation and disconnect the power supply.
- (7) Do not use TV or radio nearby the machine as to avoid interference.
- (8) Apply necessary protection during operation. Follow applicable regulations set by local administration.
- (9) For disposal of packages, lubricant, and product, please follow the applicable regulations set by local administration.

## SAFETY INSTRUCTION FOR AMS SERIES

### Parts moving area

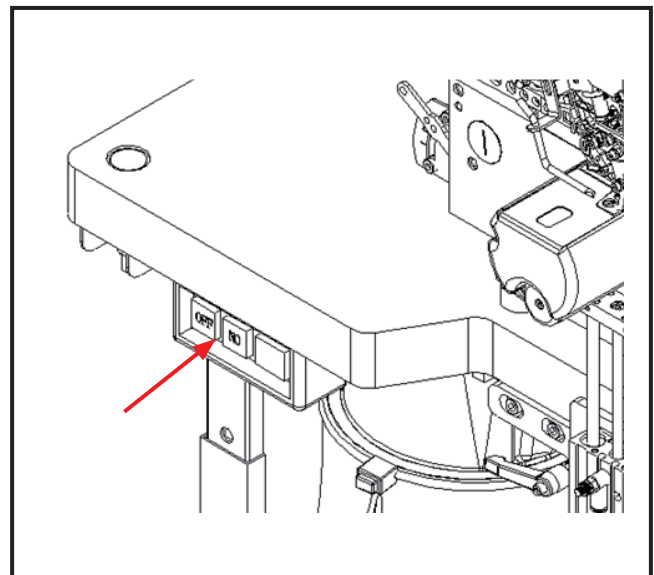
Always keep the moving area clean and free from any object.



### Power Switch

Always turn off the power when:

1. Performing service.
2. The machine is left unattended between works.



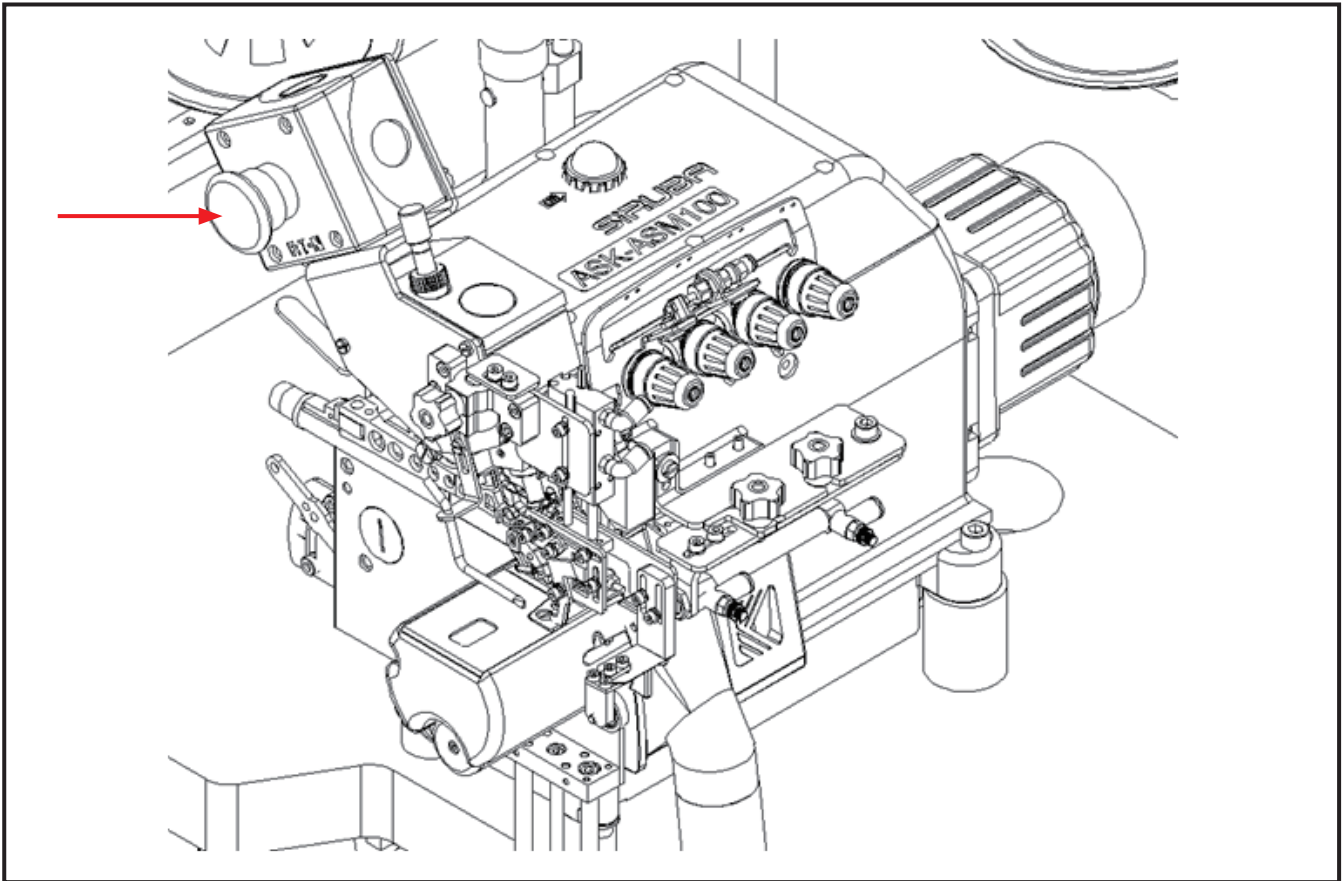


## 操作中停止

如果有緊急事件，在操作中急按紅色急停按鈕，機器將立即停止運作。同時運轉開關將會閃爍來提示現在為急停狀態。

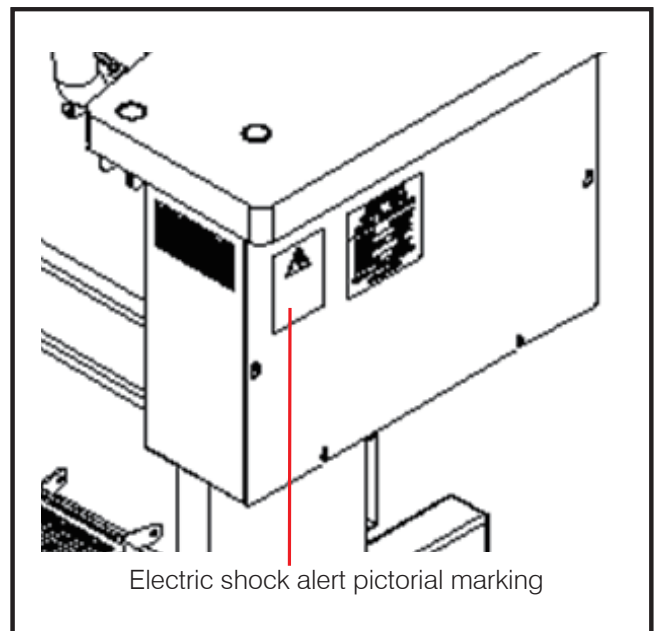
### Operation Stop

In urgent case, press emergency button to stop the machine immediately. The START button will flicker to indicate the status.



### Power Cabinet

Only certified engineers or technicians are allowed to open the power cabinet for service purpose. Turn off the power and disconnect the power source when performing service.



Electric shock alert pictorial marking

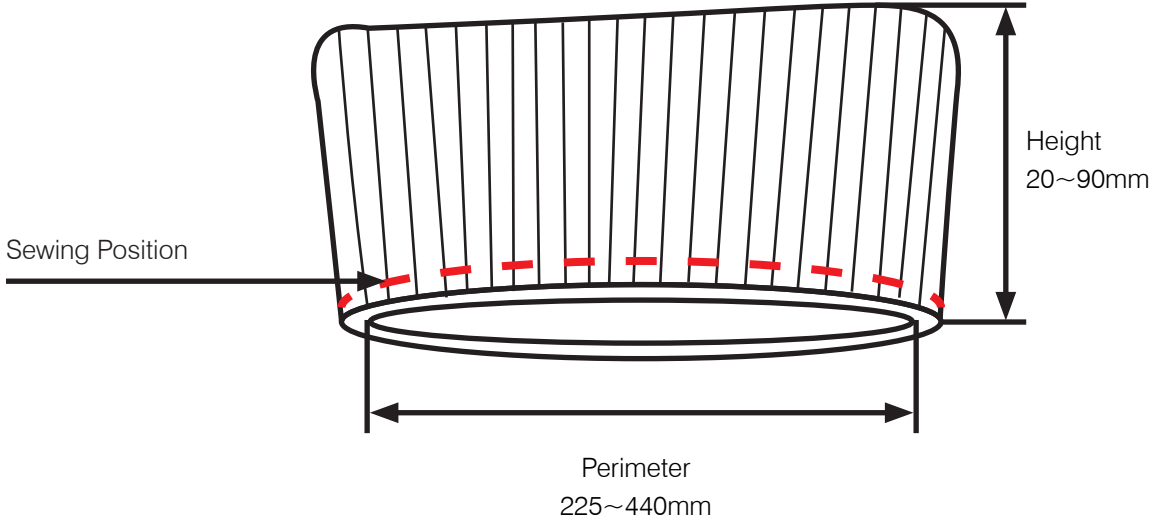
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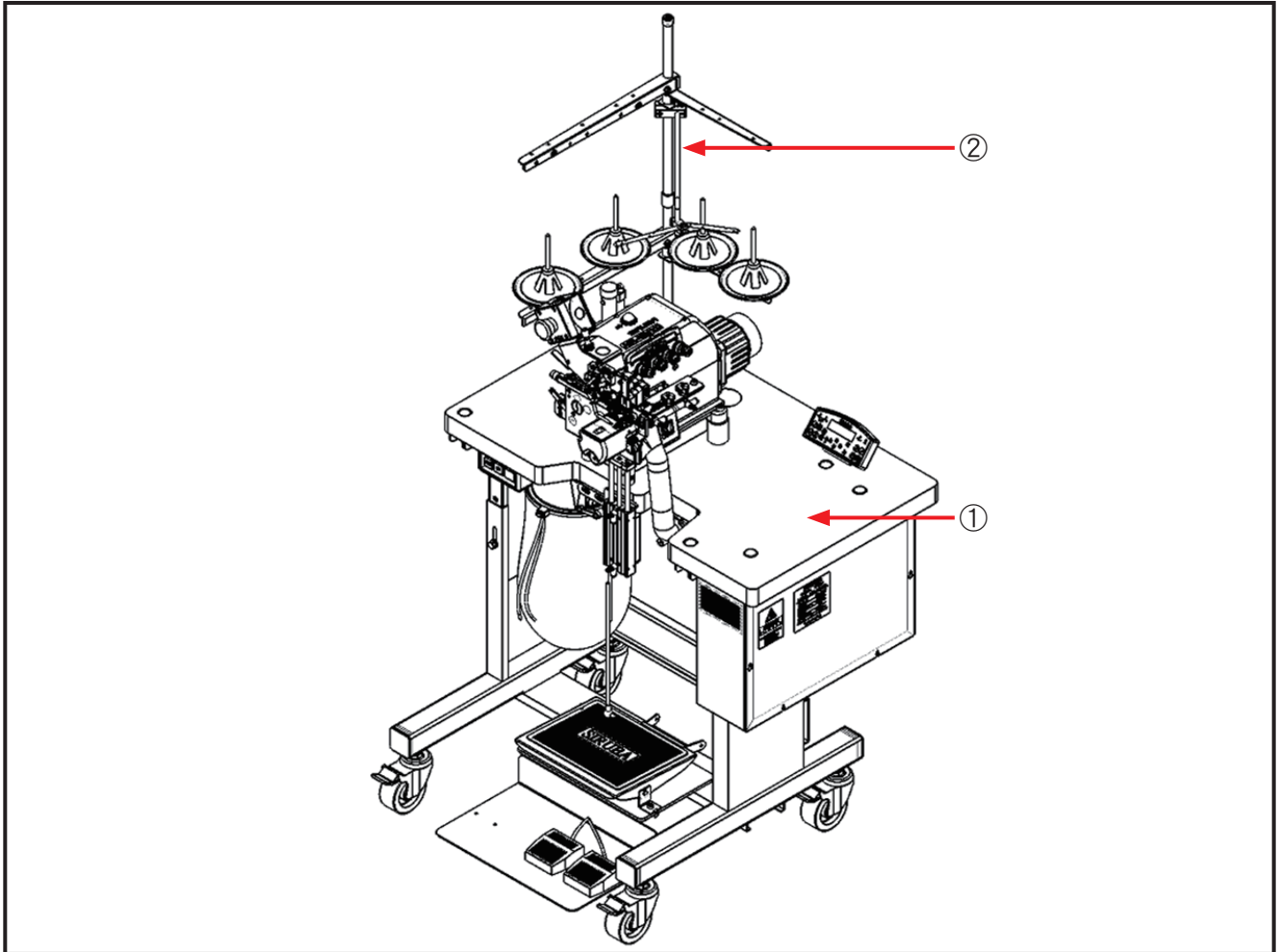
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## SPECIFICATION

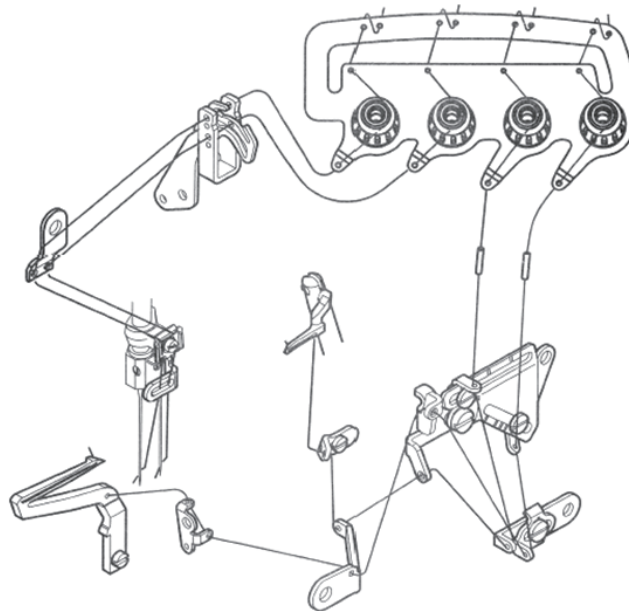
Model	ASK-ASM100
Machine Head	SIRUBA 747KST
Sewing Speed	5500 SPM ( Max )
Needle Type	DC×27 #11
Needle Distance	2mm
Presserfoot Height	7.5mm
Overedge Width	4mm
Rib Size (mm)	 <p>Height 20~90mm</p> <p>Perimeter 225~440mm</p> <p>Sewing Position</p>
Fabric Thickness	6.5mm ( Max )
Air Consumption	35 L/min
Air Pressure	0.5 Mpa
Power Supply	Single Phase 1 Φ AC200~240V 50/60Hz
Power Consumption	500 W ( Max )
Machine Dimensions	(W)825×(D)640×(H)1622mm ( With table and thread stand )

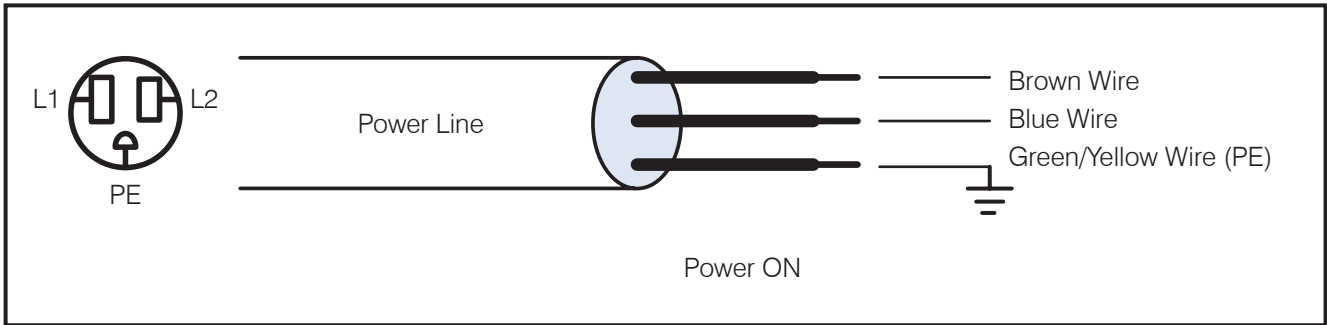
## INSTALLATION

Install the Thread Holder ② onto the Table ① . ( Please refer to the operation manual of Siruba 747KST)



## THREADING



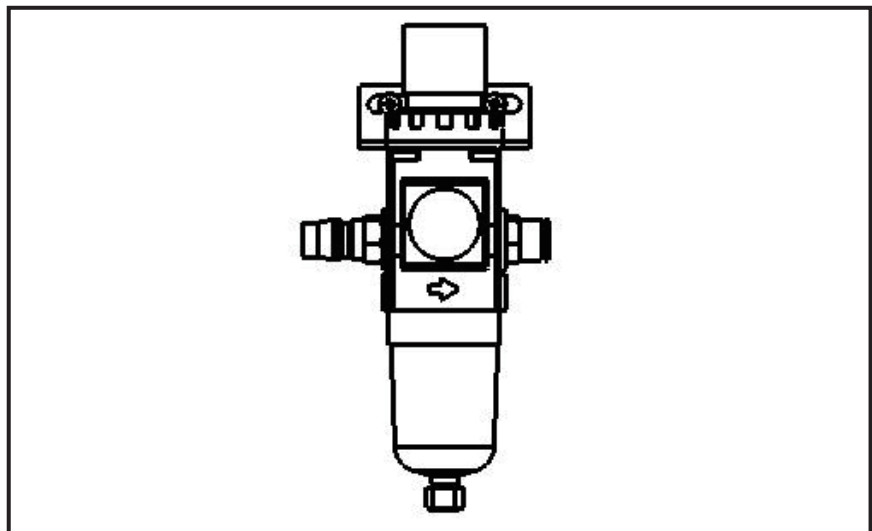


**Power Connection**

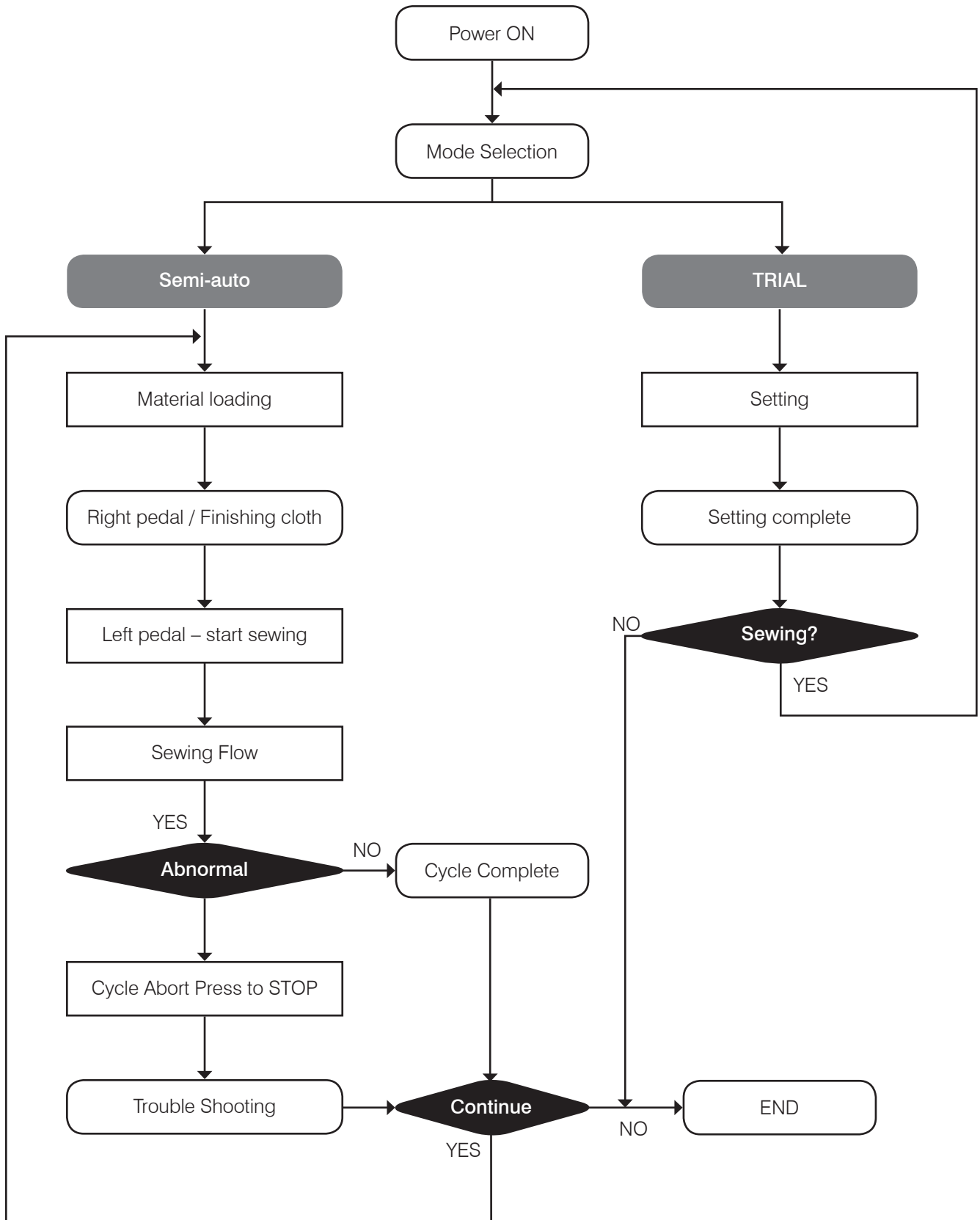
- (1) Check and set the power and air supply.  
 Rated Voltage: AC220V +/-10%  
 Air Pressure: 0.5Mpa (5kg/cm2)
- (2) Check and make sure the grounding wires are well connected.
- (3) Check and make sure the power switch is set OFF .
- (4) Power Connection: Single Phase Connection

**Air Connection:**

Plug the air supply. The air pressure is preset. In case you need to reset, pull up the switch and rotate to the setting value.



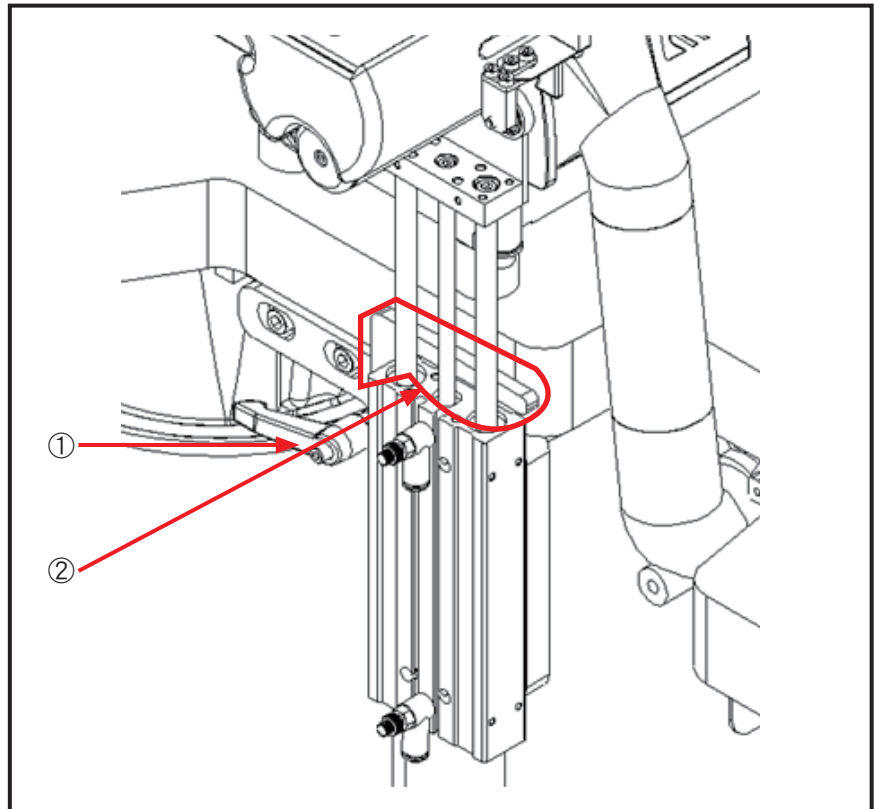
## OPERATION FLOW



## ADJUSTING & SETTING

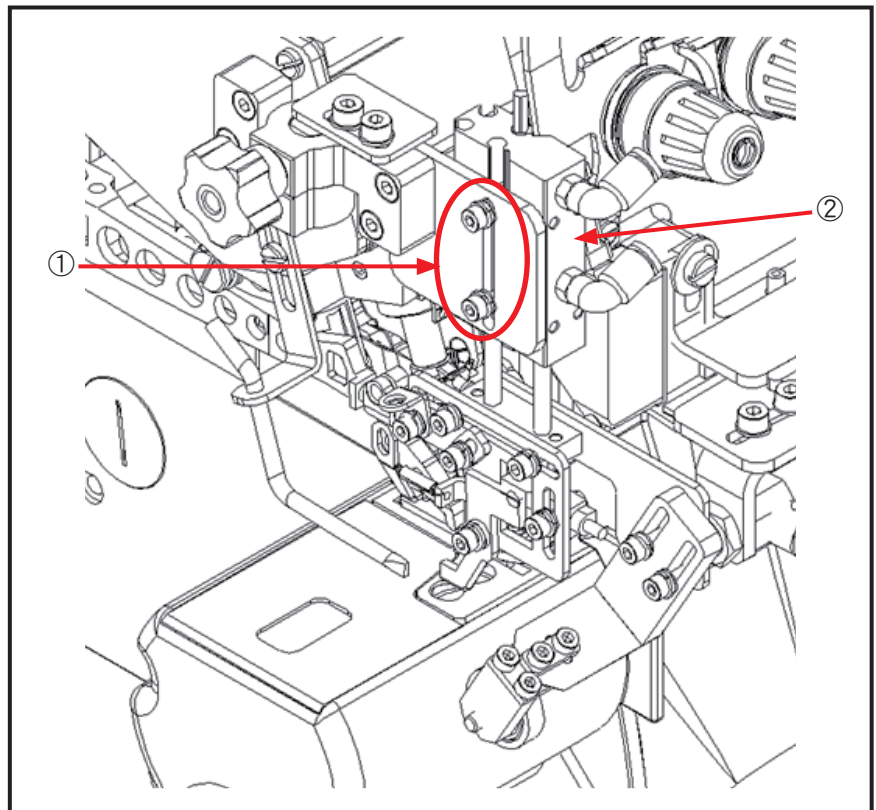
### 1. Stretching System

(1) Release Lever ① and adjust Cylinder Block ② to the working position. The Cylinder Block ② must closely move along to Cylinder during the adjustment. Tighten Lever ① when complete.



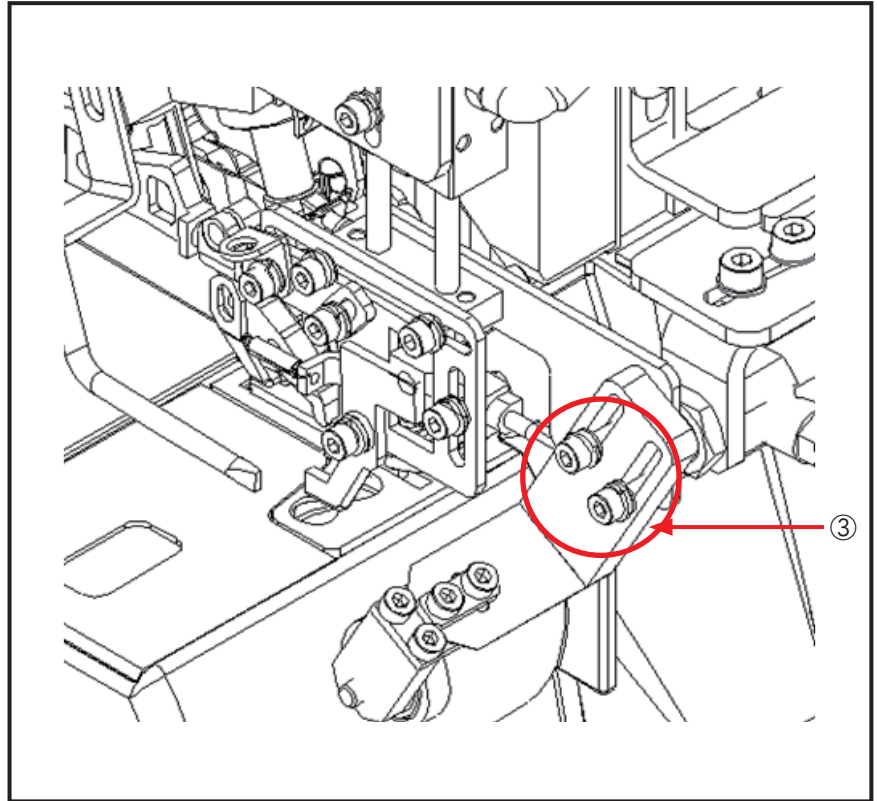
### 2. Aligning System

Apply inner hex driver #2.5 to release the screws ①. Adjust the Cylinder Set ② to proper position.



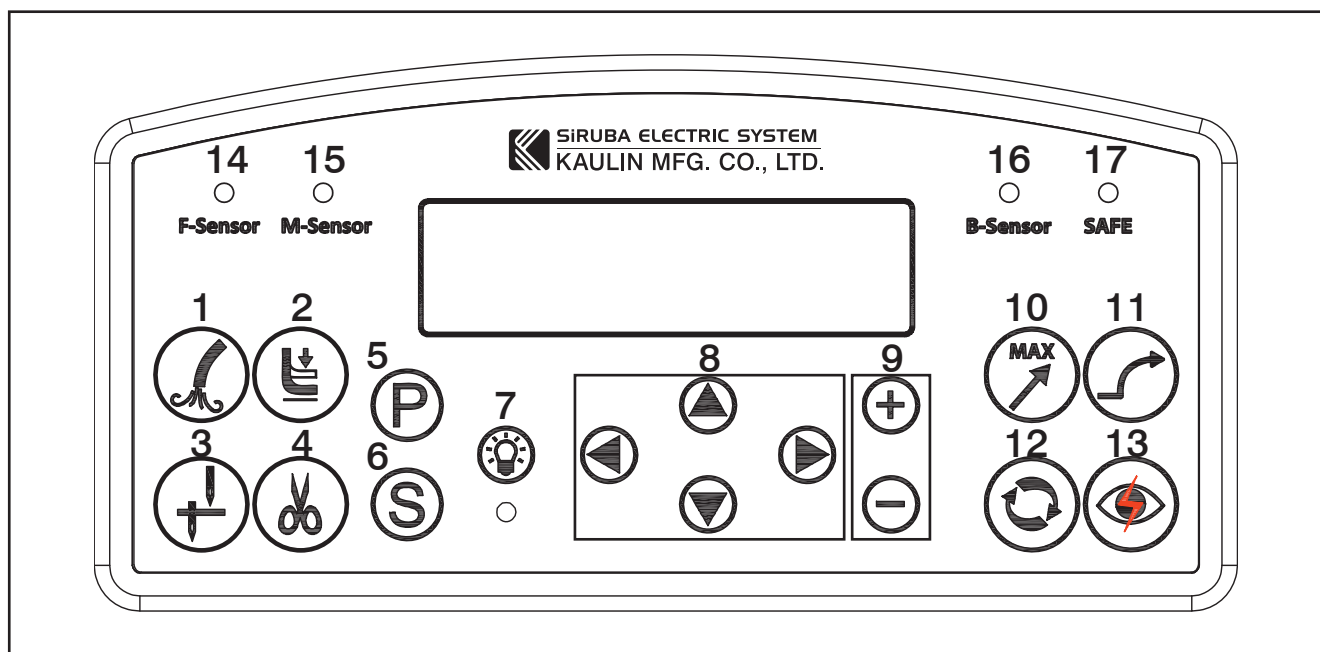
### 3. Pulling Roller

- (1) Apply inner hex driver#2.5 to release screws ③ .





## PANEL & PARAMETERS



### A. Control Panel

1	Suction / Aux. Stitch Function
2	Presser Foot Function
3	Needle Position Selection
4	N/A
5	Parameter Setting
6	Parameter Saved and Quit
7	LED Light Switch
8	Parameter Function, Content and Bit Adjustment
9	Value Up / Down
10	Motor Speed Setting
11	Soft Start Mode Selection
12	Sewing Mode Selection
13	N/A
14	Single Seam Detection
15	Double Seam Detection
16	N/A
17	Safety Switch Indicator


### B. Parameter Setting and Adjustment

- In Trial Mode, press P Key (P) to enter Parameter Selection Mode.
- Press (▲) or (▼) to select parameter.
- Press S Key (S) to enter Parameter Adjustment Mode.
- Press (+) or (-) to adjust the parameter.
- Press (S) to go back to Trial Mode. Or press (P) to go back to Parameter Selection Mode.
- Press and hold (▲) and turn power on, it will reset to default setting.
- In Trial Mode, long press (S), then enter the password 168 so as to go to the second level parameter.


## Parameter List

※ **DO NOT CHANGE THOSE PARAMETERS THAT MARKED "DO NOT CHANGE" !**

※ Some parameters require passwords. Refer to instruction above for passwords input.

Item	Code	Function	Range	Default	Unit	Description
1	H	Speed Adjustment	200~5500	3000	rpm	Setting limited by the highest speed limit "56.HL."
2	LMS	Selection of slow start function	ON/OFF	OFF	//	ON: turn on OFF: turn off
3	L	Slow Start speed	200~5500	3000	rpm	Setting of starting sewing speed
4	LSS	Stitch setting of slow start	1~100	30	STH	Setting of stitches
5	KMS	Selection of stitch counter mode	NOP/UTS	NOP	//	NOP: deactivate UTS: activate
6	KT	Setting of counter target value	1~9999	99	time	Setting of target counter numbers
7	KV	Counter display	1~9999	0	time	Instantaneous display
8	SV	Machine speed display	200~5500	0	rpm	Instantaneous display the motor exact rotary speed.
9	TMD	Sewing Mode select	NOP: Ordinary sewing CUF: Cuff PAN: Trousers bottom	CUF	//	NOP: Ordinary sewing CUF: Cuff PAN: Trousers bottom The sewing mode selection will not be influenced by pressing arrow key  to back to default setting-up
10	MRM	Setting of motor rotary mode	NOP/MA	MA	//	MA: Manual
11	AA	Stepping Motor Delay	0000 ~9999	1	ms	Setting the time to enable the stepping motor after pressing the start switch.
12	BB	Stretching wheel delay	0000 ~9999	5	ms	Setting the time to enable the stretching wheel solenoid valve after pressing the start switch.
13	CC	Presser Foot delay	0000 ~9999	10		Setting the time to enable Presser Foot after pressing the start switch.
14	DD	Overlapping sewing stitch	0000 ~9999	20		Setting the stitch number after sensor detects the seam.
15	EE	Loose stop stitch	0000 ~9999	15		Setting the stitch number to disable the Loose Stop after motor starts. (Loose Stop enable as default)
16	FF	Ejecting Rod timer	0000 ~9999	1000	ms	Set the running time of ejecting rod.
17	GG	Ejecting Rod delay time	0000 ~9999	75	ms	Set the time to enable ejecting rod after cross seam sensor activates.
18	HH	Suction, Cut and loose Stitch	0000 ~9999	50		Set the stitch to run suction, cutting, and loose stitch after parameter#14.
19	IRD	Stepping motor speed	320~800	350		
20	BIR	Double overlapping	ON/OFF	ON		OFF: Enabling the Cutting & Suction after once overlapping ON: Enabling the Cutting & Suction after twice overlapping
21	SS	Unload materials, air blow time	0-200	2		
22	SWC	Suction Mode	1/2/3/4/5	4		1. No suction 2. Only Front suction 3. Only Back suction 4. Front and Back suction 5. Mechanical suction(only for manual mode)
23	FOR	Lever back delay time	0000 ~9999	150		

24	TN1	Needle Location	U/D/UD	U	//	U: The highest location D: The lowest location UD: The lowest location, but presser foot rises when fully pedal.
25	BUZ	Buzzer	ON/OFF	ON	//	When presser foot protection On for 30 seconds (or set time), the buzzer will beep twice.
26	LE	Overlapping loose close stitch	200~6000	60		Set stitch to run loose stitches after overlapping and parameter 14.
27	ABC	Long Suction	ON/OFF	OFF		Enable suction continuously during operation when set ON.
30	ATF	Start mode selection	ON/OFF	ON		ON: Pedal OFF: Speed controller
31	INF	Laser light marker	ON/OFF	ON		ON OFF
32	TFD	Solenoid Valve Check	0~9	0	//	Each code refers to: 1. Presser Foot on (2 seconds). 2. All Off 3. Cut / Suction (50ms) 4. Stretching (2 seconds) 5. Cross Seam 6. Loose Stitch (2 seconds) 7. Ejecting Rod (ref. parameter 82) 8. Aligning 9. Stepping Motor 10. Reserved 11. Reserved 12. Speed Controller Voltage (ref. parameter 82)
33	TIN	Presser foot motion stimulation	0、1、2、3	0~3		Stimulated mechanism adjustment for seam thickness
34	FT	The initial full output time of presser electromagnet	0~990	250	ms	Presser Foot Magnetic Setting. DO NOT CHANGE
35	FD	Presser Foot Cycle %	10~50%	25	%	The motion cycle of the presser foot electromagnet
36	FPM	Presser Foot Protection	ON/OFF	ON	//	Protecting functions when the presser foot electromagnet activates.
37	FP	Presser Foot Protection Time	1~300	Solenoid:120 E.Mag :30	Second	Set the protection time when the presser foot electromagnet performs.
38	FMM	Presser Foot Mode	ON/OFF	ON	//	When #38 FMM is set ON (presser foot Up), set the delay time to lower the presser foot.
39	FMS	Presser foot down delay time.	1~3000	10	ms	
40	HT	half pedaling confirmation time	0~990	100	ms	Set the time of delaying as half pedaling
48	FMD	Motor start delay time.	50~500	500	ms	Set the time to start motor after presser foot down.
50	MSW	Safety switch	ON/OFF	OFF	//	ON: Enable (When removing the proximity switch, stop all functions and motors) OFF: Disable
53	SDA	The stop angle as the needle descending	0-360	220	Angle	DO NOT adjustment
54	SUA	The stop angle as the needle rising	0-360	30	Angle	DO NOT adjustment
55	ER	Error code display	0~9		Set	To save the last error codes up to 10 sets

56	HL	Speed limit of sewing machine head	200~5500	3000	rpm	Speed limit ( first priority). After configure “56.HL” as 5500rpm, and the parameter “01.H” can be configured as the highest speed.
57	ACR	Motor speed of assistant trimming	200-5000	3000	rpm	Under VTE/CTE mode, after the sewing completes, press Manual Trimming to activate “trimming and assistant suction”
58	ACS	Rotary stitches of assistant trimming	1-99	20	Stitch	
59	CS	Pedal sensitivity	1-10	2	level	IN OT/A mode, set “#59.CS” to decide the depth of pedaling as to initiate the motor. The bigger the setting, the deeper you need to pedal.
60	NUF	Needle auto-rising after power on	ON/OFF	ON	//	ON: Enable the needle to rise automatically to the highest position after power on. OFF: Disable
61	LSH	Safety switch of side plate	ON/OFF	OFF	//	ON: Enable OFF: Disable
62	HVR	Highest voltage record display	//	//	//	“62HVR” and “63LVR” can record the highest and the lowest current effective value of the control box AC.
63	LVR	Lowest voltage record display	//	//	//	
64	PV	Present voltage record display	//	Realtime display	//	
65	AOT	Time setting of auto running test	1~500	240	hr	Set time of auto running test
66	AO1	Auto running start time	1~20	2	s	Set time to start the auto running
67	AO2	Auto running stop time	1~20	2	s	Set time to stop the auto running
68	AOS	Auto Running	ON/OFF	OFF	//	ON: Enable the auto running test OFF: Disable the auto running (Resume to OFF after power off.)
69	UTT	Time display of auto running	1~1000	Instantaneous display	hr	Accumulate running time
70	VER	Software version				The display controller firmware version is SXEX. If press  key then display UI firmware version
71	GHT	Functional automatic operation	ON/OFF	OFF		ON OFF * Parameters unable to make changes while the motor is working.
78	PS	Password	//	OFF	//	When Password Lock is ON, all parameters cannot be changed. The unlock password: 0168 Note: To go to the parameter setting, press S and input the password, hold S till the monitor shows.
79	FED	The front sensor rotation lock without fabric	ON/OFF	OFF	//	Under the OT/A mode, motor stops when the front sensor detects no fabric.
80	BKL	LCD Backlight	0%~100%	40%	//	
81	LAN	Language	//	English	//	English / Traditional Chinese / Simplified Chinese
82	FOO	Speed controller' s voltage display	0~4096	Instantaneous display	//	
83	UEG	start / stop complex switch	ON/OFF	ON		OFF: Only starting function. ON: Start and stop function.
91	LDL	Motor speed slope	165、200、250、300、350	200	ms	Motor Acceleration / deceleration slope 165ms, 200ms, 250ms, 300ms, 350ms

## OPERATION

### 1. Power and Air Pressure

#### (1) Main Power

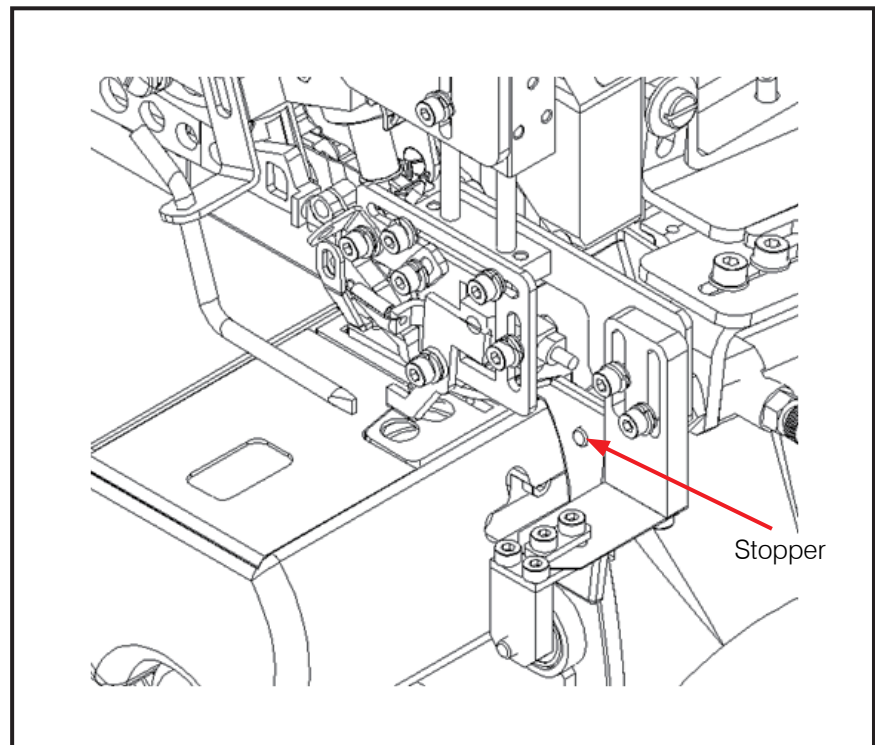
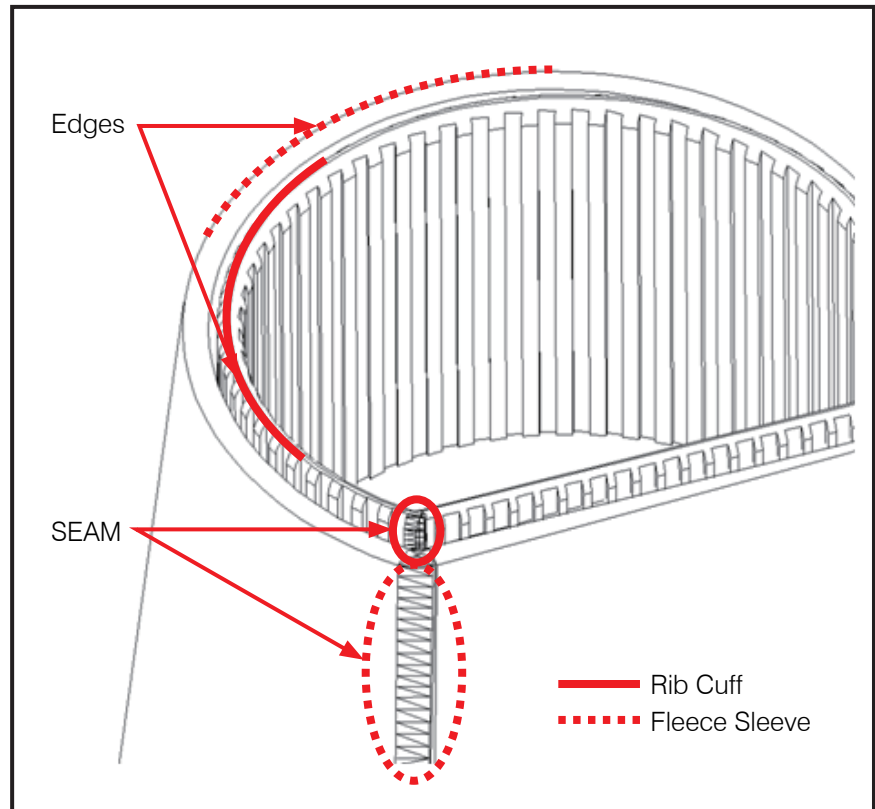
Rate Power Supply AC  
220V  $\pm$  10% ° Must be  
grounded °

#### (2) Air Supply Setting

0.5Mpa (5kg/c m<sup>2</sup>) °

### 2. To upload the material

Insert the rib cuff into the fleece sleeve (seam facing outward). Align the edges and make sure the seams are overlapped. Then load the material onto the sewing machine to the stopper.



### 3. 車縫流程

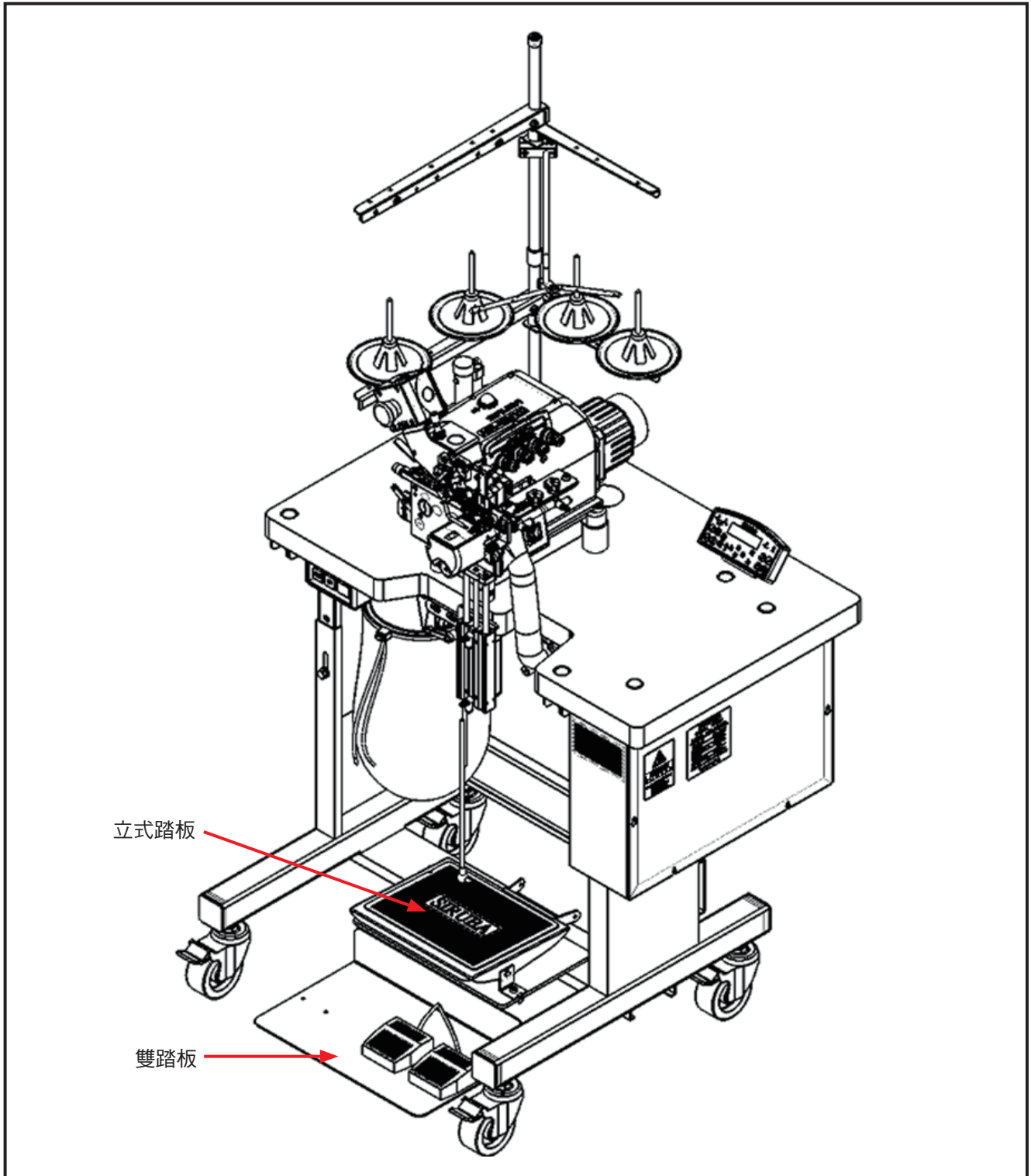
選擇要使用立式踏板或雙踏板。

#### (1) 立式踏板

踏板後踩可控制撐布機構、壓腳的上升及下降，上料後前踩一下，即啟動車縫流程。

#### (2) 雙踏板

右踏可控制撐布機構、壓腳的上升及下降，上料後踩左踏，即啟動車縫流程。




## TROUBLE SHOOTING

### Mechanic or finished quality issue

Issue	Cause	Solution	Reference
Deformation : ◆ Poor elasticity ◆ Rippled cuff	◆ Stretching system over-stretches. ◆ Not enough stretching distance	Adjust the stretching system	Stretching System
Poor stitching line	Angle error on Pulling Roller.	Adjust the Roller angle and contact area with fabric.	Cross Seam System : Pulling Roller
Fabric accumulation : ◆ Fabric overlapping ◆ Bad fabric feeding	◆ Aligning roller over-presses, causing fabric jam ◆ Poor contact of Feeding Roller against the fabric	Adjust the Roller angle and contact area with fabric.	Aligning System
Abnormal sewing : ◆ Sewing stops before operation completes. ◆ Sewing cannot stop	◆ Cross-seam Sensor is too low, any tiny ridge may taken as operation completes. ◆ Cross-seam sensor is too high, cannot detect cross-seam to end the operation.	Adjust the sensor of cross-seam system.	Cross-Seam System : Cross-Seam Sensor
Bad Cutting	◆ Not enough reserved stitch after ejection ◆ Not enough stitch after suction/cut	Reset the parameter #14 、 #18	Parameter List : Item #14 、 #18

### Electronic Issues

Error Code	Cause	Solution
Err 1	Over Current	<ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check if the IGBT module is normal.</li> <li>3. Reboot the system after 1 min.</li> <li>4. If the error code still exists, please exchange control box and contact Kaulin or authorized agents.</li> </ol>
Err 4	Over Voltage	<ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check the power connection to the control box. Check if the power supply complied to specification.</li> <li>3. If the voltage is too high, please wait until the power is normal and then reboot. If not, reboot the system after 1 minute.</li> <li>4. If the error code still exists, please exchange control box and contact Kaulin or authorized agents.</li> </ol>

Err 7	Over Torque	<ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check the power connection to motor.</li> <li>3. Check if there is a jam to the machine, mechanical interference, or if the textile is too thick.</li> <li>4. Check the trimmer condition, replace a new trimmer if needed.</li> <li>5. Reboot the system. If the error code still exists, please contact us or authorized agents.</li> </ol>
Err 8	Operation Box Communication Error	<ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check if the power/cable connection to the operation box. Re-connect or replace if needed.</li> <li>3. Reboot the system. If the error code still exists, please contact us or authorized agents.</li> </ol>
Err 17	emergency stop	<ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check if the power/cable connection to the START switch box. Re-connect or replace if needed.</li> <li>3. Reboot the system. If the error code still exists, please contact us or authorized agents.</li> </ol>
Err 20	Control Box Over Heat	<ol style="list-style-type: none"> <li>1. Turn off the power. Wait for at least 10 minutes until the control box cools down.</li> <li>2. Reboot the system. If the error code still exists, please contact us or authorized agents.</li> </ol>
Err 21	Motor Encoder Abnormal	<ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check if the power/cable connection to the motor encoder. Re-connect or replace if there is a bad connection or failure.</li> <li>3. Reboot the system. If the error code still exists, please contact us or authorized agents.</li> </ol>
Err 24	Solenoid Valve Abnormal	<ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check the connection to the solenoid valve. Re-connect or replace if needed.</li> <li>3. Reboot the system. If the error code still exists, please contact us or authorized agents.</li> </ol>
Err 60	Speed controller Abnormal	<ol style="list-style-type: none"> <li>1. Turn off the power.</li> <li>2. Check the power/cable connection to the speed controller. Re-connect or replace if needed. °</li> <li>3. Reboot the system. If the error code still exists, please contact us or authorized agents.</li> </ol>
	Safety Switch Error	<p>Under Trial mode, if the motor stops rotation:</p> <ol style="list-style-type: none"> <li>1. Turn off the power and check the connection to safety switch. Re-connect or replace if needed.</li> <li>2. Reboot the system. If the error code still exists, please contact us or authorized agents.</li> </ol>



中文

中文

## 溫馨提醒

請儘快下載 SIRUBA APP，並將您的機器註冊，以便獲得原廠的保固。APP 還提供多項有用的資訊。



## 安全警示

有關於縫紉機，自動化機構，以及其他輔助設備（以下統稱為機器），在工作中無可避免會接近機器移動區域，也就有伴隨著潛在風險。因此，我們強烈要求操作者，維修技師一定要先仔細閱讀並瞭解本操作手冊的內容。

安全指示係包含了某些未載於規格書上的加裝配件。

現場管理者有責任要求所有操作者要閱讀並瞭解機器的操作與注意事項。

未能確實遵守本手冊所記載的事項，將可能導致機器的損害，或是人員的傷亡。

### 警告標示說明

	<p>高壓電危險</p> <p>在機器關機後十分鐘內， 勿開啟電控箱。</p>		<p>零部件移動區</p>
	<p>零部件高速移動區</p> <p>勿接近，以避免人員受傷。</p>		<p>勿接近，以避免人員受傷。</p>

標告標示說明		標告標示說明	
	<p>機器零部件移動區，勿接近，以避免人員損傷。</p>		<p>請注意，在操作過程中握住縫紉機會傷到您的手。</p>
	<p>有電，危險。</p>		<p>小心被機械捲件受傷！</p>
	<p>高溫度區！危險，勿靠近。</p>		<p>如果觸摸按鈕托架，可能會造成人身傷害。</p>
	<p>強光！勿直視，以避免眼睛受傷。</p>	一般安全標示	
	<p>小心頭部撞擊！</p>		<p>機器運行方向</p>
			<p>電氣接地位置標示</p>

## 安全須知

### 危險

意外事件將會導致人員受傷甚至死亡，也會造成財產的損害。

當有必要進行電控系統的檢修時，務必要關閉電源，並等候至少 5 分鐘以上才能打開電控箱／操作箱，以避免電擊。

### 注意

#### 1. 基本預防

- (1) 在操作前務必先閱讀操作手冊與其他機器電件的說明書，請妥善保存操作手冊與說明書以便隨時查閱。
- (2) 這些注意措施包含了機器上加裝，但未列在規格書上的項目。
- (3) 務必要戴護目鏡與手套，以避免破損零件所帶來的傷害。
- (4) 有裝戴心臟調節器的人員，請先詢問醫護人員有關注意事項。

#### 2. 安全裝置與警告標示

- (1) 操作前要檢查，並確認所有的安全設施有妥善安裝且運作正常。
- (2) 若安全設施因維修需要而移動，在機器重新啟動操作前，請確認安全設施有重新安裝回原位，並且運作正常。
- (3) 機器上的安全警告標示要保持完整與可辨視。如果有污損或遺失，請儘以更新。
- (4) 未能確實遵守安全規範，將會導致人員受傷，甚至影響生命安全。

#### 3. 應用與修改

- (1) 嚴格禁止機器使用在非原始設計用途。也禁止以任何不是操作手冊上記載的方式來操作機器。
- (2) 嚴格禁止修改機器。任何未經原廠許可的變動將不在保固範圍內。
- (3) 機台一經修改變動，本公司將不擔負財務損失，人員傷亡的責任。

#### 4. 教育與訓練

- (1) 工廠主管人員有義務提供機台使用人（操作者／維修者）相關的教育訓練。良好的教育訓練不僅可以避免造成人員傷害，也可以避免財產的損失。
- (2) 操作人員操作機器之前，都必需接受過良好的訓練。
- (3) 機器的維修保養必須由合格的技師執行。

#### 5. 必須關閉電源的情況：

如何關閉電源：按壓下緊急停止開關（如果機器有配置的話），關閉電源，拔除電源線。

- (1) 當機器出現異常時，按下緊急停止開關（如果有配置），關閉電源。
- (2) 為了避免機器突然起動造成意外，在操作機器前，要先確定機器電源關閉，再行開啟電源。
- (3) 當檢查或清潔機器時，關閉電源，並確定機器已完全停止運作。
- (4) 當維修機器時（如更換或調整零件），要關閉電源，並確定機器已完全停止運作。

6. 拔除電源線時，務必要抓住電源插頭，而非抓住電源線，以避免斷裂，電擊，甚至火災。

7. 當機器停止運作，且無人看管時，要關閉電源。

8. 萬一停電或電力供應出現不穩，關閉電源，以避免意外發生。

## 在不同階段的注意事項

### 1. 運輸

- (1) 當搬運或移動機器時，請考量機器重量，選擇安全合適的方式。請參考機器規格。
- (2) 採取足夠的安全防護，以避免機台在搬運或移動中掉落。
- (3) 為避免意外，運送時不要重覆使用包裝材料。

### 2. 拆箱

- (1) 在拆箱前，檢查機器是否平穩放置，並採用適當的工具維持拆箱過程的穩定。
- (2) 進行拆箱時，遵循外箱上的指示，小心外箱上的釘子或碎片。

### 3. 安裝：

#### 3A. 桌板與腳架

- (1) 採用原廠的桌板以確保機器得到足夠的保護與支撐。如果在安裝或維修時，需要暫時將機器置放於物件上，請確定該物件有足夠的支撐力。
- (2) 如果桌板有裝置滾輪，滾輪需要有煞車鎖定機構，而且在操作與維修時，煞車機構必需鎖定。

#### 3B. 電線與管路

- (1) 電線與管路的材質必需符合規範與需求。
- (2) 電線與管路不能夠有折彎或壓迫。移動的零配件上，電線與管路需有至少 30mm 以上的預留量。
- (3) 接線時不能有跳火。
- (4) 所有接頭都必需確實固定。當拆除時，務必要抓住接頭本體。

#### 3C. 接地

- (1) 接地是必需的。且需由合格的技師來施工。
- (2) 在操作前需確認接地有確實。

#### 3D. 馬達

- (1) 馬達的選用，必需符合規範與需求。
- (2) 如果馬達為皮帶傳動，務必要安裝保護措施以避免捲入危險。

### 4. 在開始操作前

- (1) 在開啟電源前，確認所有接頭，電線，管路都完好無損，確實連結。
- (2) 檢查皮帶輪的轉向與標示為同一方向。
- (3) 確認腳架滾輪都已鎖定。
- (4) 保持作業範圍淨空。

## 5. 在操作中

- (1) 注意手，頭髮，衣服不在機件移動範圍。不要將個人物品置放於機器上。
- (2) 機器會高速運作。保持雙手遠離移動機件範圍。機器完全停止前不要靠近。
- (3) 在移動物件或重新設定機器時，注意不要被機器或零件撞擊。
- (4) 避免突然起動造成意外，在檢查或維修馬達或皮帶時，務必關閉電源並確認機器完全停止。
- (5) 機器停止時，伺服馬達是無聲的。注意要關閉電源以免突然起動。
- (6) 永遠保持電控箱的風扇與氣道淨空。

## 6. 潤滑

- (1) 請依照說明書指示，選用合格的油脂來潤滑機件。
- (2) 如果油品接觸到眼睛或身體，立即以清水沖洗。如有不適，立即尋求醫護人員協助。
- (3) 如果油品不慎進入身體，立即尋求最近的醫療協助。

## 7. 維修保養

- (1) 只有合格的技師或工程師能夠進行維修服務，包含機器調整與修理。只採用原廠的零件進行更換。如果採用非原廠零件，或是因不當維修／調整所造成的傷害，本公司將不負任何責任。
- (2) 只有合格的技師或認證的工程師才能對電控系統進行維修或保養。
- (3) 當對氣動原件（如氣缸）進行維修保養時，務必先拔除風源，並將氣體完全洩除，以避免突然啟動。
- (4) 在調整或更換部件後，檢查所有螺絲是否鎖固。
- (5) 定期清潔是必需的。在清潔前務必先關閉電源，並確認機台完全停止。
- (6) 如果運作異常或不良，立即停止操作並關閉電源。聯絡授權經銷商或我們公司以尋求技術協助。
- (7) 當保險絲故障，立即關閉電源，找出故障原因並予以排除後，更換同規格的新的保險絲。
- (8) 定期檢查與清潔風道，電線與管路。

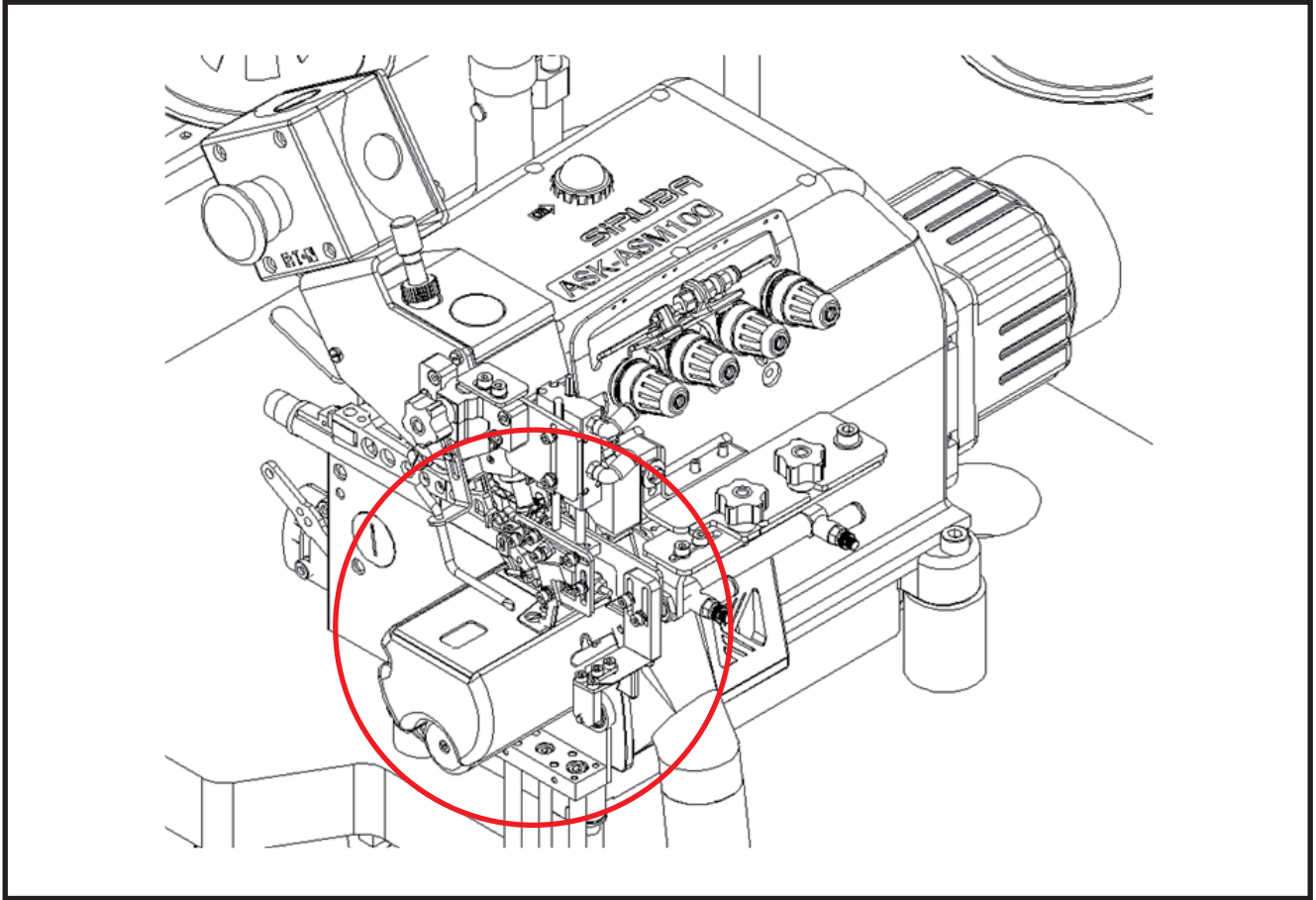
## 8. 工作環境

- (1) 機器必需不用電磁波干擾。
- (2) 電源供應必需良好且穩定。電壓波動不得超過 10%。
- (3) 隨時檢查空壓的壓力與品質。如果氣源不穩定，請安裝合適器材以改善。
- (4) 機器操作環境，室溫 5° C ~ 35° C, 相對濕度 35%~85%.
- (5) 為了保護電子元件與安全起見，當有劇烈氣溫變化而導致凝水時，立即關閉並拔除電源，並靜候至完全乾燥為止。
- (6) 為了安全起見，當有打雷或閃電時，請停止操作，關閉並拔除電源。
- (7) 勿在機器週遭使用電視或收音機，以避免干擾。
- (8) 依當地法令規範，在操作中採取必要的防護。
- (9) 關於包裝材料，潤滑油品，以及機器（含零配件）的丟棄，請依各地政府法規的規範執行。

## ASM 安全注意事項

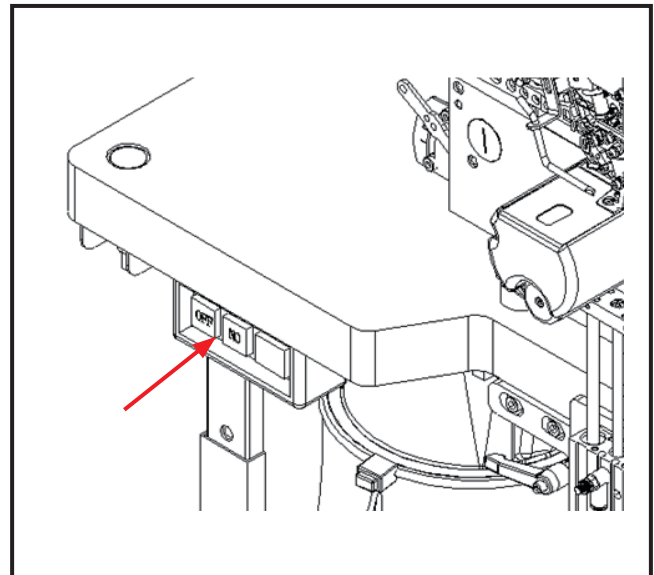
### 機械移動區

永遠保持機械移動區域淨空，不受阻礙。



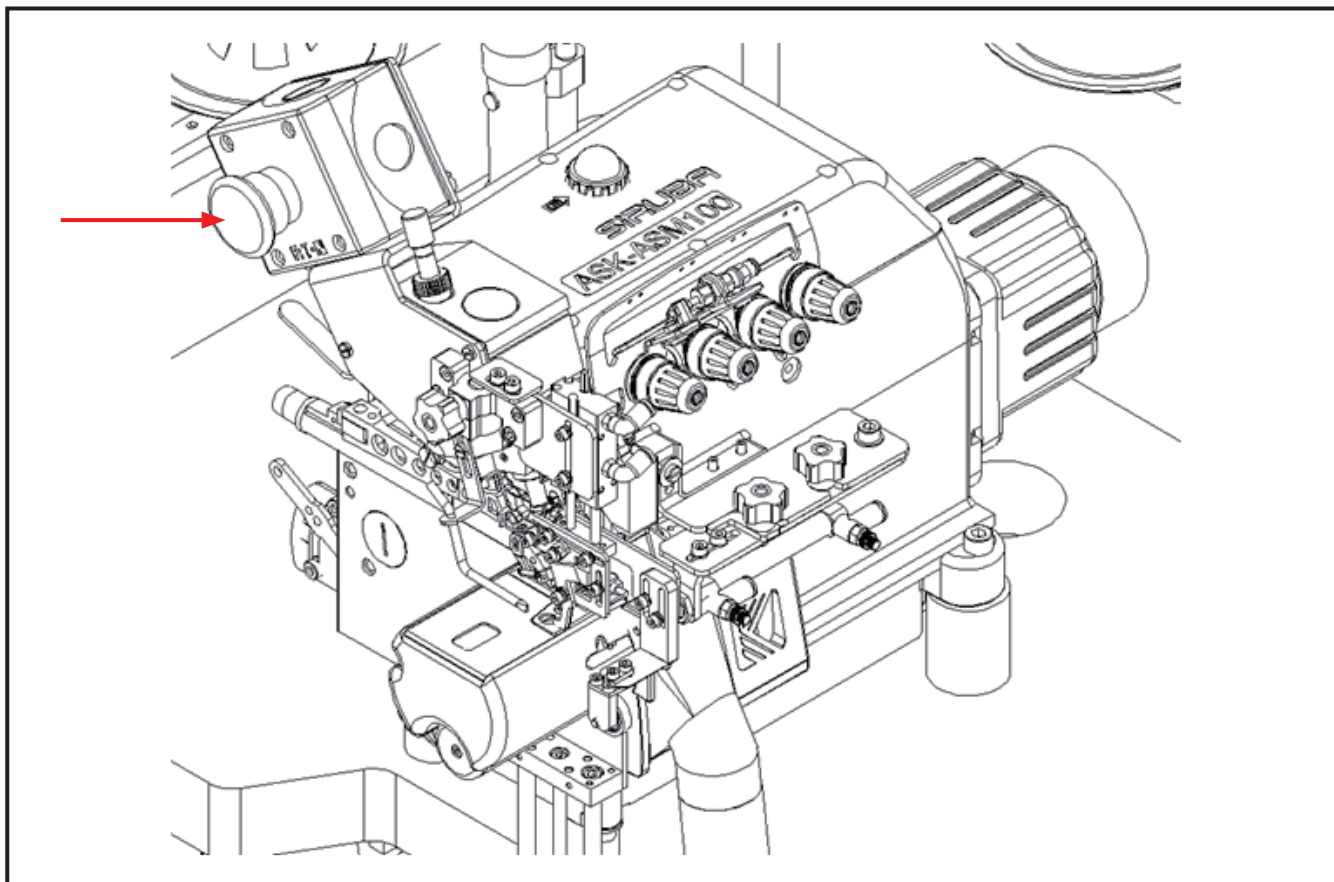
### 電源開關

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 。



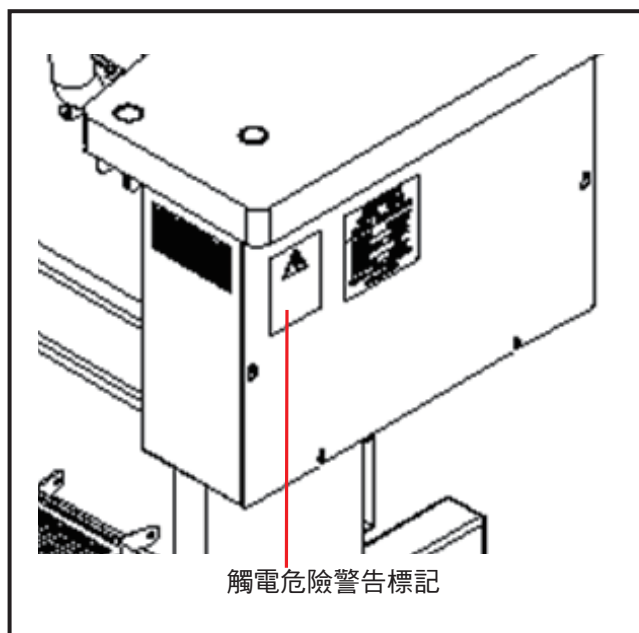
### 操作中停止

如果有緊急事件，在操作中急按紅色急停按鈕，機器將立即停止運作。同時運轉開關將會閃爍來提示現在為急停狀態。



### 電控箱

要打開電控箱，進行檢查或維修，必需由經過專業訓練與得到認證的工程師或技師來執行。當進行檢查或維修時，務必要關閉電源，並拔除電源線，以策安全。

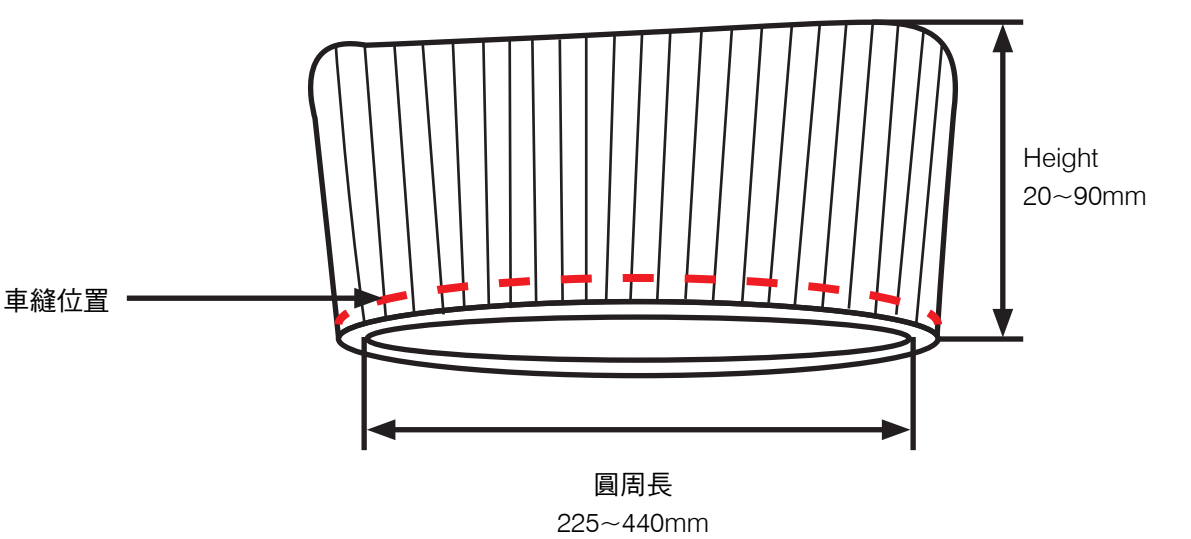


觸電危險警告標記

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基本動作	4
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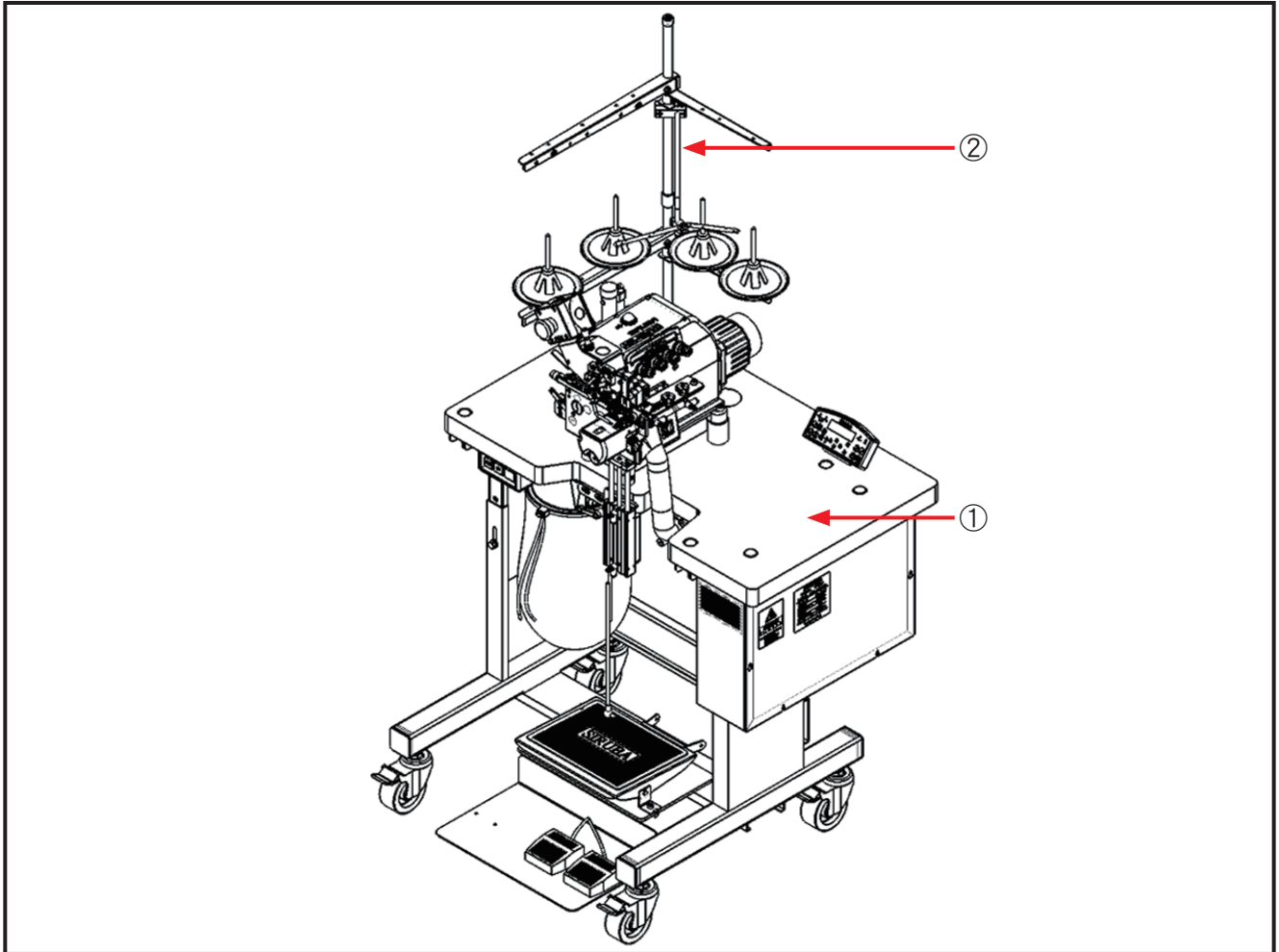


## 規格

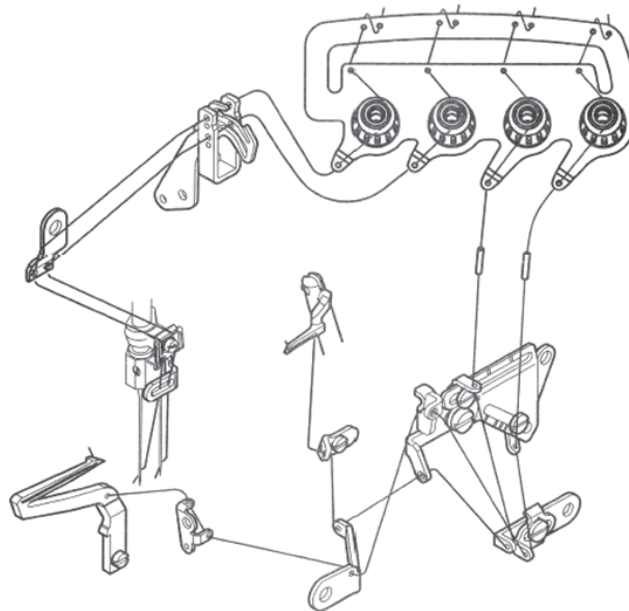
型號	ASK-ASM100
搭配縫紉機機頭	SIRUBA 747KST
車縫速度	5500 SPM ( Max )
使用針型	DC×27 #11
縫紉針距	2mm
壓腳高度	7.5mm
包邊寬度	4mm
羅紋布尺寸 (mm)	 <p>Height 20~90mm</p> <p>車縫位置</p> <p>圓周長 225~440mm</p>
布厚範圍	6.5mm ( Max )
氣體消耗量	35 L/min
氣壓	0.5 Mpa
電源電壓	Single Phase 1 $\Phi$ AC200~240V 50/60Hz
消費電力	500 W ( Max )
機器尺寸	(W)825×(D)640×(H)1622mm ( 含桌板、線架 )

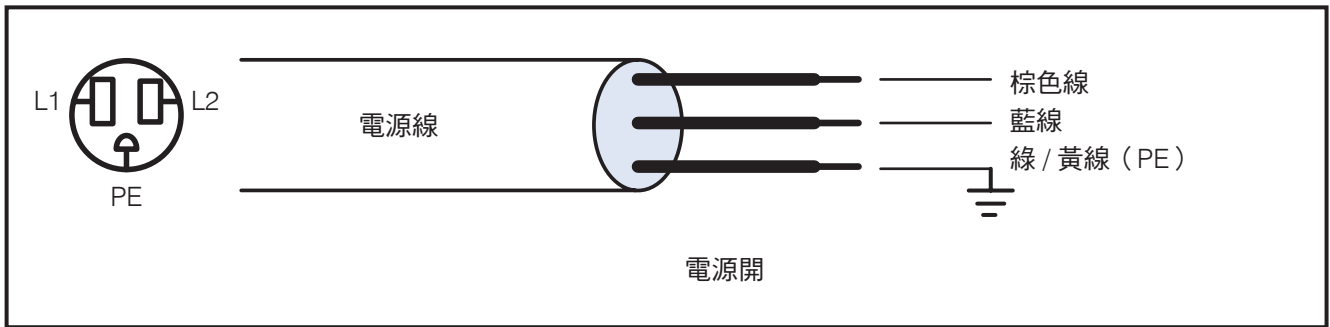
## 安裝

桌板①上，鎖附線架②。(線架組裝組請參照 747KST 使用說明書。)



穿線圖



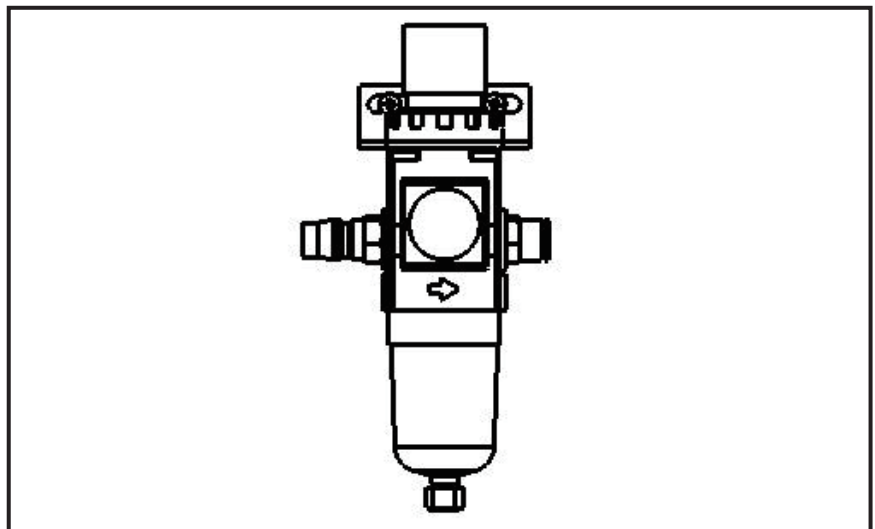


#### 電源連接

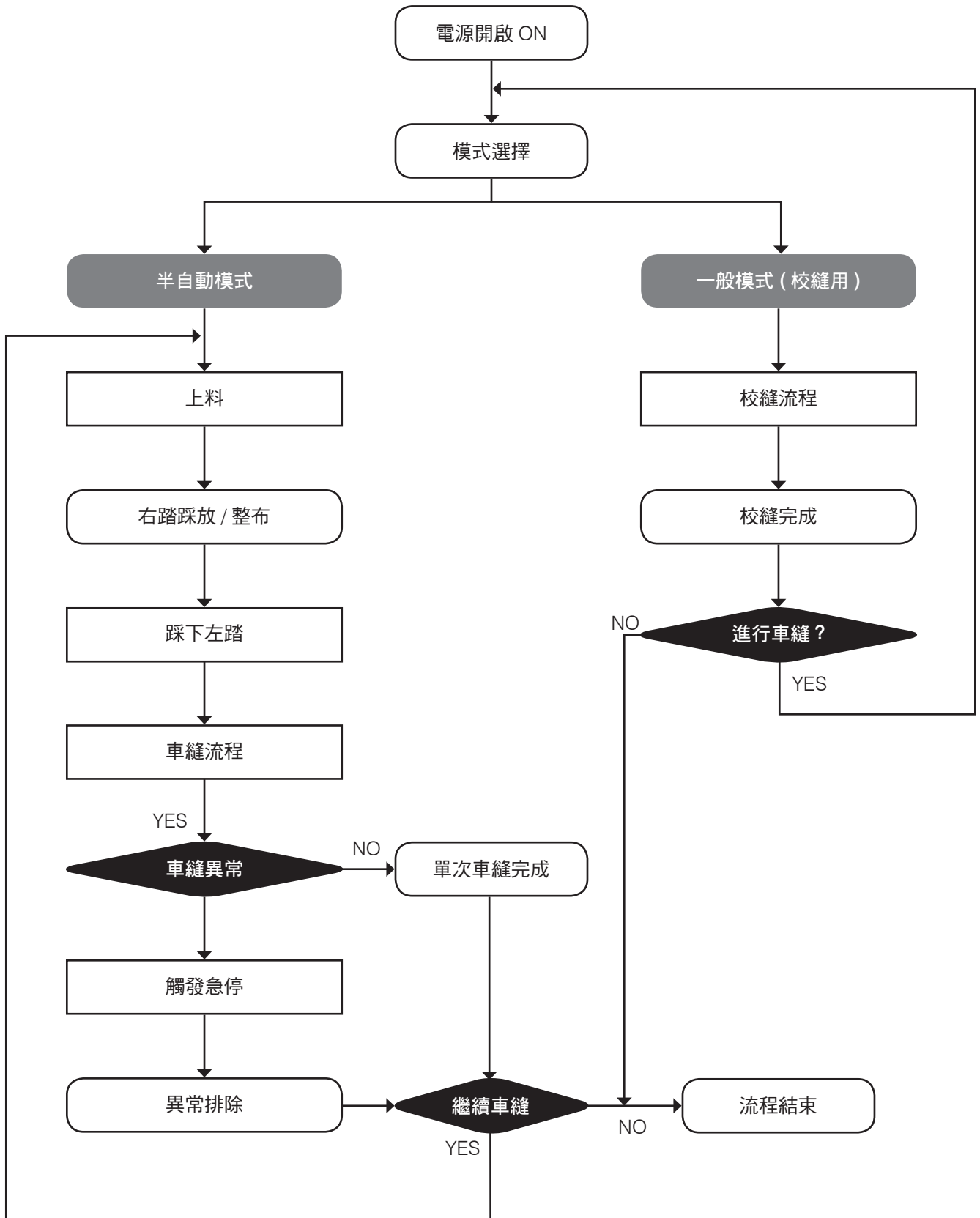
- (1) 檢查並設置電源和空氣供應。  
額定電壓：AC220V +/- 10%  
氣壓：0.5Mpa (5kg / cm<sup>2</sup>)
- (2) 檢查並確保接地線連接良好。
- (3) 檢查並確保電源開關已設置為 OFF。
- (4) 電源連接：單相連接

#### 空氣連接

插入氣源。氣壓存在。如果需要重置，請拉起開關並旋轉到設定值。



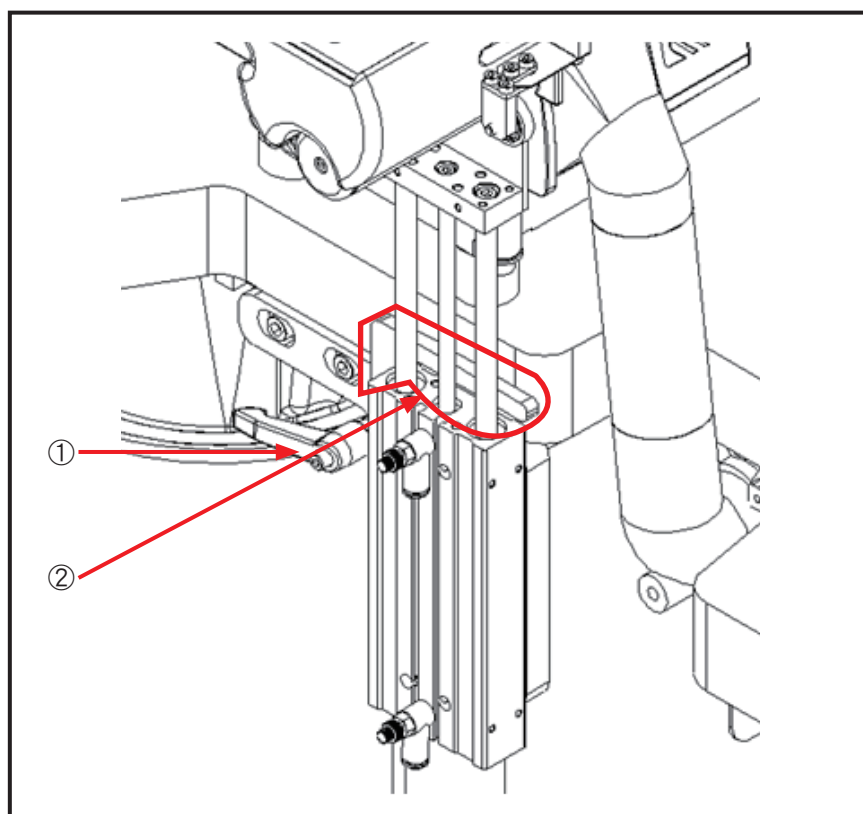
## 基本動作



## 規格變更與參數設定

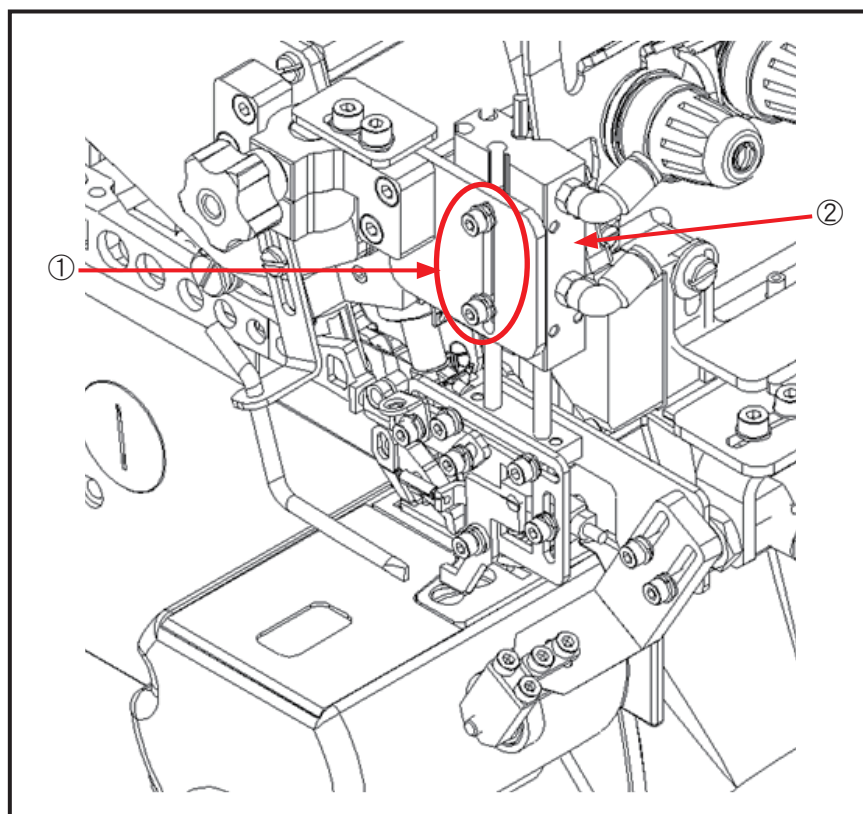
### 1. 撐布機構

逆時針方向將把手①鬆開後，調整汽缸擋板②至需求的高度，調整時汽缸擋板②須緊貼汽缸，至位置後再將把手①順時針旋緊。



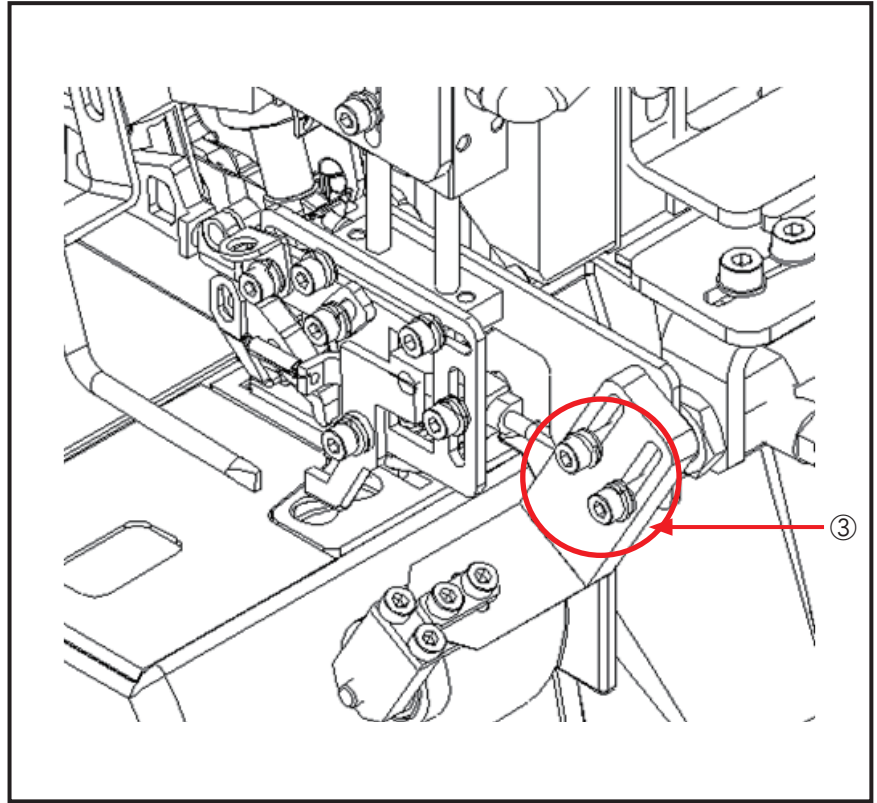
### 2. 過股感知機構

使用 2.5 號內六角鉸手將四顆螺絲①鬆開，即可調整過股汽缸②前後位置至需求處。

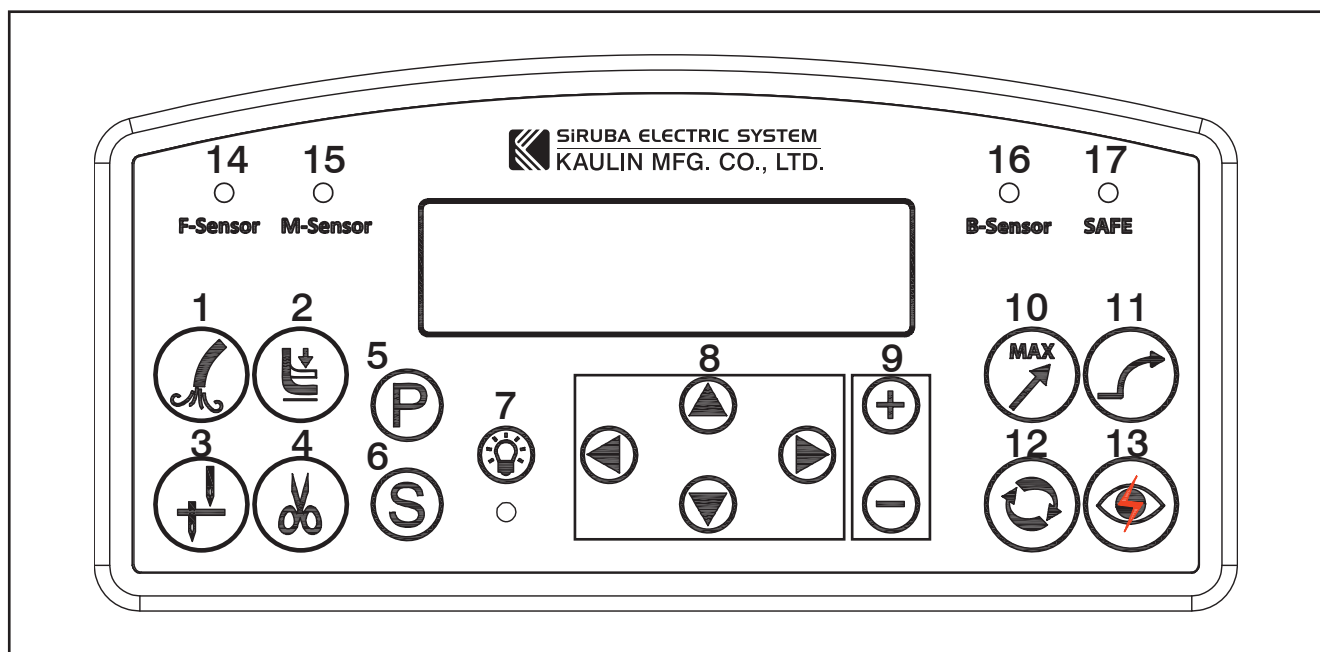


### 3. 推布小滾輪

- (1) 使用 2.5 號內六角扳手將螺絲③鬆開，調整小滾輪組角度與高低至適當位置。



## 選針盒操作設定



### A. 按鍵說明

1	輔助運轉補針功能鍵
2	抬壓腳功能
3	針上 / 針下定位功能選擇
4	無作用
5	參數設定
6	儲存參數設定並離開
7	照明用 LED 開關
8	參數功能別 / 參數內容選擇鍵 / 位元調整鍵
9	數值加 / 減鍵
10	馬達轉速設定
11	慢速起縫模式選擇
12	縫紉模式選擇
13	無作用
14	一次過骨設定指示燈
15	二次過骨設定指示燈
16	無作用
17	安全開關指示燈

### B. 參數設定模式說明

- 在一般模式中長按 P 鍵 (P) 可進入參數選擇模式。
- 利用增 (▲) 減 (▼) 選擇參數模式。
- 按 S 鍵 (S) 進入參數調整模式。
- 利用增 (+) 減 (-) 設定參數。
- 按 S 鍵 (S) 回到一般模式 / 或按 P 鍵 (P) 回到參數選擇模式。
- 長按增鍵 (▲) 開機，即可回復出廠值。
- 在一般模式中長按 S 鍵 (S)，輸入密碼 0168 可以進入第二階參數。

## 參數表

※ 請勿更改標記為“請勿更改”的參數！

※ 有些參數需要密碼。有關密碼輸入，請參閱上述說明。

項次	參數碼	參數功能	設定範圍	出廠值	說明
1	H	速度調整	200~5500	3000 / rpm	本參數受 "56.HL" 最高速度限制管制
2	LMS	前慢速起縫功能開啟選擇	ON / OFF	OT/A : ON MA : OFF	ON : 開啟      OFF : 關閉
3	L	慢速起縫速度設定	200~6000	3000 / rpm	車縫速度設定
4	LSS	慢速起縫針數設定	1~100	30 / 針	車縫針數設定
5	KMS	計數器模式選擇	NOP / UTS	NOP	NOP : 關閉      UTS : 開啟功能
6	KT	計數目標值設定	1~9999	99 / 次	計數次數設定
7	KV	計數值顯示	1~9999	-	即時顯示
8	SV	車頭運轉速度顯示	200~6500	-	即時顯示馬達實際轉速
9	TMD	機型選擇碼	NOP: 一般車 CUF: 袖口 PAN: 褲管	CUF/	NOP: 一般車    CUF: 袖口    PAN: 褲管 ** 此參數不受按  鍵重置出廠值影響
10	MRM	馬達運轉模式設定	MA / OT / A	MA	MA : 半自動 OT : 一次觸發 ( 踏板採踏後，馬達立即運轉至車縫結束 ) A : 全自動
11	AA	步進汽缸啟動延遲	-	1 / 秒	按下啟動開關後延遲 ms 後，步進馬達轉輪前後電磁閥啟動
12	BB	撐布輪汽缸啟動延遲	-	1 / 秒	按下啟動開關後延遲 ms 後，撐布輪電磁閥啟動
13	CC	壓腳汽缸啟動延遲	-	10 / 秒	按下啟動開關後延遲 ms 後，壓腳放下
14	DD	過骨後車縫針數	-	50 / 針	縫紉經過過骨 SENSOR 後，繼續縫紉針數
15	EE	車縫啟動鬆線關閉針數	-	15 / 針	馬達啟動經過幾針後，關閉鬆線 ( 正常情況下一直鬆線 )
16	FF	退布桿啟動後執行時間	-	2000 / 秒	退布桿電磁閥執行時間 ms
17	GG	退步桿啟動延遲時間	-	1 / 秒	過骨感知 SENSOR 觸動後，延遲 ms 啟動退布桿電磁閥
18	HH	後吸風切刀鬆線針數	-	80 / 針	執行完參數 14 後，執行吸風鬆線切線針數
19	IRD	步進馬達轉速	Y = 240~1200	350 / rpm	齒輪比 : 500 0.72 度 / Step XKHz = 600 / Y Rpm = XK / 500      ** 數值越大，則速度越慢
20	BIR	兩次過骨	ON/OFF	ON	OFF : 經過一次過骨感知後執行吸風切線 ON : 經過兩次過骨感知後執行吸風切線 **ON 時，M-Sensor 燈示恆亮
21	SS	吹氣退布時間	0-200	2	
22	SWC	吸風動作模式選擇	1/2/3/4/5	4	1. 無吸風動作    2. 僅前吸風    3. 僅後吸風 4. 前後吸風    5. 機械吸風開啟 ( 手動模式有效 )
23	FOR	撥叉收回延遲時間	0000~9999	150	



24	TN1	針上 / 針下定位功能選擇	U/D/UD	U	U 為上停針、D 為下停針、UD 模式則為下停針，但全後踩執行提針抬壓腳。
25	BUZ	按鍵蜂鳴器開關	ON/OFF	ON	當壓腳保護 (30 秒) 或計數值到達時，蜂鳴器會發出嗶嗶兩聲。
26	LE	過骨後鬆線關閉針數	200~6000	60	過骨後，經過參數 14 後，執行鬆線之針數
27	ABC	運轉長吸風開關	ON/OFF	OFF	運轉即吸風開關。
30	ATF	啟動模式選擇	ON/OFF	ON	ON: 立式踏板模式 OFF: 控速器模式
31	INF	紅外線標示器	ON/OFF	ON	ON: 開啟 OFF: 關閉
32	TFD	動作功能檢查選擇	0~9	0	各數字代表： 1. 抬壓腳氣動 (動作 2 秒). 2. All Off 3. 切線吸風 (動作 50ms) 4. 撐布 (動作 2 秒) 5. 過骨 6. 鬆線 (動作 2 秒) 7. 退布桿 (跳至參數 82) 8. 順布 9. 步進馬達啟動 10. 保留 11. 保留 12. 控速器電壓值 (跳至參數 82)
33	TIN	壓腳提昇器動作模擬	0、1、2、3	0~3	過骨布厚機構調整模擬
34	FT	抬壓腳電磁鐵出力初始全額輸出時間	0~990	250 ms	抬壓腳電磁鐵參數 請勿調整
35	FD	抬壓腳電磁鐵出力動作週期 %	10~50%	25%	
36	FPM	抬壓腳電磁鐵動作時的保護功能開啟選擇	ON/OFF	ON	
37	FP	抬壓腳電磁鐵動作時的保護時間設定	1~300	電磁閥 :120 秒 電磁鐵 :30 秒	
38	FMM	抬壓腳動作模式選擇	ON/OFF	ON	當抬壓腳抬起時且 "38.FMM" ON，啟動後延遲 "39.FMS" 時間後，壓腳自動放下。
39	FMS	壓腳放下延遲時間設定	1~3000	10 ms	
40	HT	半後踏抬壓腳確認時間	0~990	100 ms	半後踩延遲時間設定
48	FMD	馬達啟動時間延遲。	50~500	500 ms	壓腳放下延遲時間 "48.FMD" 經過後，才允許馬達啟動。
50	MSW	安全開關功能選擇	ON/OFF	OFF	ON: 開啟安全開關保護功能 (當近接開關被移開時，停止所有機能且馬達不轉動)，OFF: 取消安全開關保護。
53	SDA	針下停止角度	0-360	220 角度	勿調整
54	SUA	針上停止角度	0-360	30 角度	勿調整
55	ER	故障碼顯示	0~9	組	可記憶最近 10 組故障代碼
56	HL	車頭最高速度限制	200~5500	3000rpm	最高速度限制 (最高優先權)，"56.HL" 設為 5500rpm 後參數 "01.H" 才能設定為最高轉速。
56	HL	車頭最高速度限制	200~5500	5500rpm	最高速度限制 (最高優先權)，"56.HL" 設為 7500rpm 後參數 "01.H" 才能設定為最高轉速。

57	ACR	輔助切線馬達速度	200-5000	3000 rpm	VTE/CTE 模式下，在車縫機能完成後，按壓手動切刀開關可執行”切刀吸風輔助功能”。
58	ACS	輔助切線運轉針數	1-99	20 Stitch	
59	CS	踏板靈敏度調整	1-10	2 (1)	調整`59.CS`可設定 OT/A 模式時控速器”踩一下”之踩踏深度判斷，作為馬達啟動訊號。段速越大則深度越深。
60	NUF	開電自動提針	ON/OFF	ON	ON: 開電後將自動提針至上停位位置 OFF: 無此功能
61	LSH	側板安全開關	ON/OFF	OFF	ON: 開啟 OFF: 無此功能
62	HVR	最高電壓紀錄顯示	//	//	`62HVR`、`63LVR` 可記錄控制盒 AC 入電最高與最低電壓有效值。
63	LVR	最低電壓紀錄顯示	//	//	
64	PV	目前電壓顯示	//	即時顯示	
65	AOT	自動運轉測試全程時間設定	1~500	240 小時	自動運轉測試全程時間設定
66	AO1	自動運轉啟動時間設定	1~20	2 s	自動運轉啟動時間設定
67	AO2	自動運轉停止時間設定	1~20	2 s	自動運轉停止時間設定
68	AOS	自動運轉功能	ON/OFF	OFF	ON: 自動運轉測試開始； OFF: 自動運轉關閉 ( 關電即恢復 OFF 狀態 ) 運轉累積時數
69	UTT	自動運轉時間顯示	1~1000	即時顯示 小時	Accumulate running time
70	VER	軟體版本顯示			顯示控制器軟體版本為 SXEX。 若按  鍵顯示 UI 版本
71	GHT	機能式自動運轉	ON/OFF	OFF	ON: 自動運轉測試啟動 OFF: 關閉 ** 馬達運轉時，參數無法調整設定
78	PS	Password	//	OFF	密碼鎖功能設為 ON 後，所有選針盒參數皆不能更改。解鎖密碼為：0168。 PS: 此參數 ON 時，欲進入第二階參數請先按 S 顯示輸入密碼後，再按住 S 直到顯示反白可輸入的畫面
79	FED	前電眼無布料運轉鎖定	ON/OFF	OFF	OT/A 模式時，前電眼若無布料，馬達停止運轉。
80	BKL	LCD 背光亮度	0%~100%	40%	
81	LAN	液晶面板語言選擇	//	英文	英文 / 繁體中文 / 簡體中文
82	FOO	控速器電壓顯示	0~4096	即時顯示	
83	UEG	二次啟動鍵停止開關	ON/OFF	ON	OFF: 啟動鍵僅啟動功能 ON: 啟動鍵在啟動後再壓下，可以緊急停止
91	LDL	馬達升 / 降斜率	165、200、 250、300、 350	200 ms	馬達加速 / 減速斜率

## 操作說明

### 1. 電源與氣壓

#### (1) 電壓

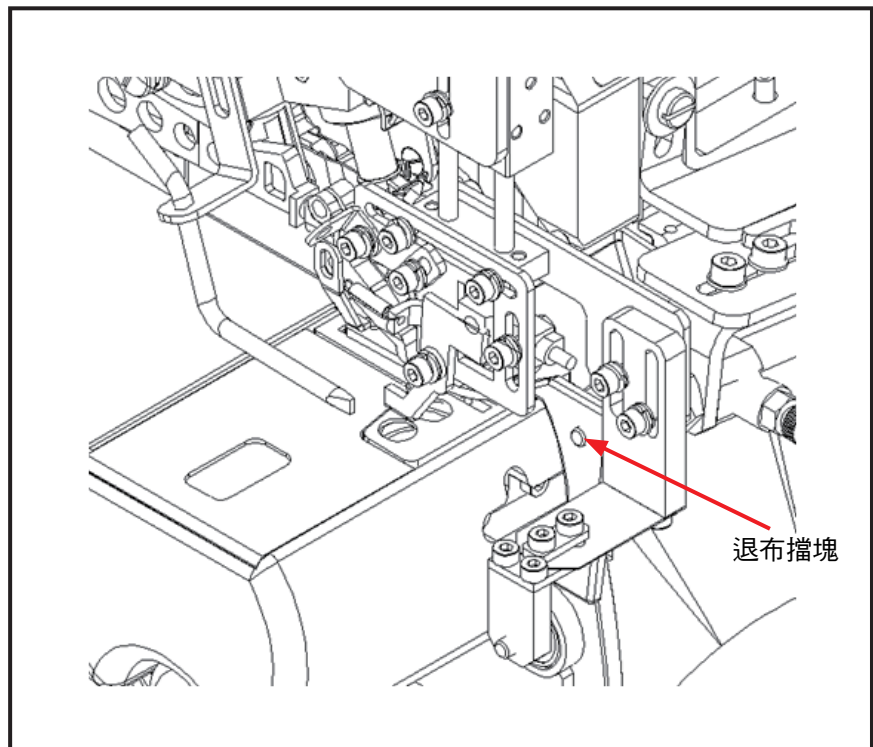
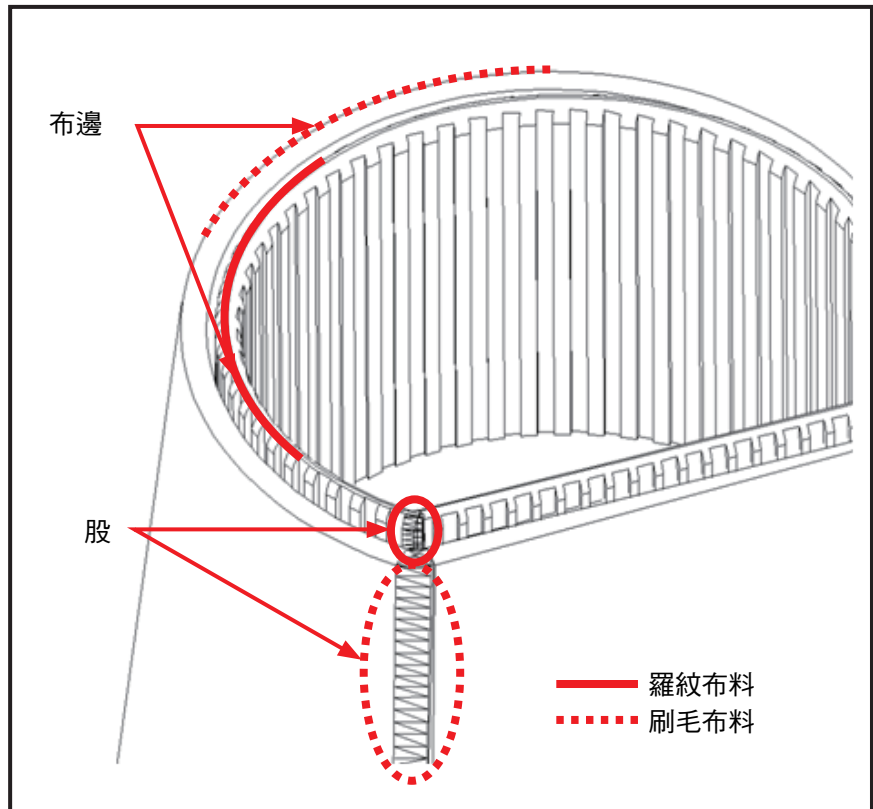
使用額定電壓 AC 220V ± 10%  
，接地線必須接地。

#### (2) 氣壓

使用 0.5Mpa (5kg/c m<sup>2</sup>)。

### 2. 上料步驟

將預先準備之羅紋布料套入刷毛布料 (股朝外) 內，兩兩布邊相互齊平，並確認兩股對位正確，即可平整套入筒嘴至貼齊退布擋塊。



### 3. 車縫流程

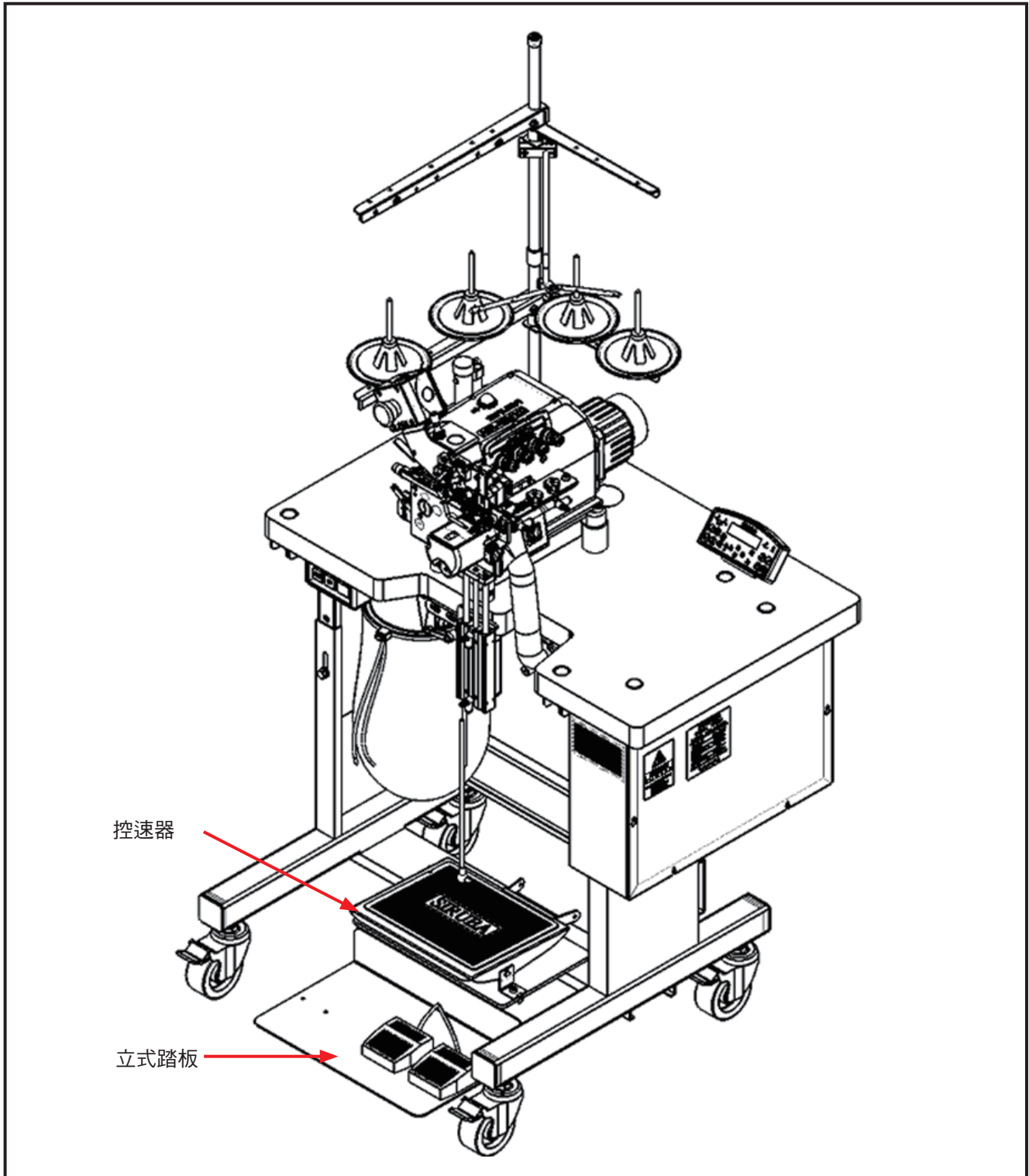
選擇要使用立式踏板或雙踏板。

#### (1) 控速器模式

踏板後踩可控制撐布機構、壓腳的上升及下降，上料後前踩一下，即啟動車縫流程。

#### (2) 立式踏板模式

右踏可控制撐布機構、壓腳的上升及下降，上料後踩左踏，即啟動車縫流程。



## 異常排除

### 異常原因與對策

異常	原因	對策	參考
成品布料變形： ◆ 布料失去彈性 ◆ 袖口呈現波浪狀	◆ 撐開機構拉伸過度 ◆ 撐開機構拉伸距離不足	調整撐開機構之拉伸量	撐布機構
車縫成品線跡對線不良	小滾輪傾斜角度有誤，故無法順利將線跡對齊	調整小滾輪與布面貼合角度與接觸量	過股感知機構： B. 推布小滾輪
布料堆積： ◆ 嚴重積布 ◆ 送布無力	◆ 順布滾輪擠壓過度，導致布料無法通過 ◆ 順布滾輪未順利貼靠布面	調整順布機構與布面接觸量	順布機構
車縫狀態異常： ◆ 未車縫完成即停止 ◆ 車縫無法停止	◆ 過股感知 Sensor 過低，以至於布料輕微隆起即誤判為車縫完畢 ◆ 過股感知 Sensor 過高，無法偵測過股，則無法結束車縫	調整過股感知機構之 Sensor 高低位置	過股感知機構： A. 過股 Sensor
切線異常	◆ 退布後預留針數過少 ◆ 吸風切線針數過少	調整參數設定	參數表： 項次 14、項次 18

### 電控故障排除

選針盒顯示錯誤碼	異常現象說明	解決措施
Err 1	過電流保護	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 確認 IGBT 模組工作正常。</li> <li>3. 一分鐘後重新送電。控制器若仍有錯誤碼顯示，請更換控制器並通知廠商。</li> </ol>
Err 4	過電壓保護	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 請檢查是否插錯供應電源或電壓過高。</li> <li>3. 如電壓過高，則待電壓回復正常後重新開機。如無，則一分鐘後重新送電。</li> <li>4. 控制器若仍有錯誤碼顯示，請更換控制器並通知廠商。</li> </ol>

Err 7	堵轉檢知遮斷	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 檢查馬達動力線插頭配線是否接觸不良。</li> <li>3. 是否有異物纏繞機頭、其他機械結構干涉異常、或紡織物是否過厚。</li> <li>4. 確認切刀是否磨耗需更換。</li> <li>5. 排除後重新送電，若仍無法正常運轉，請通知廠商。</li> </ol>
Err 8	選針盒通訊介面異常	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 檢查選針盒連接線是否脫落、鬆動、破損、插入方向錯誤。</li> <li>3. 排除後重新送電，若仍無法正常運轉，請通知廠商。</li> </ol>
Err 17	緊急停止	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 檢查啟動鍵連接線是否脫落、鬆動、破損、插入方向錯誤。</li> <li>3. 排除後重新送電，若仍無法正常運轉，請通知廠商。</li> </ol>
Err 20	控制器過熱保護	<ol style="list-style-type: none"> <li>1. 關閉電源，10 分鐘後重新送電。</li> <li>2. 控制器若仍有故障燈顯示，請通知廠商。</li> </ol>
Err 21	電機編碼板異常	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 檢查電機編碼器連接線是否接觸不良或馬達編碼器是否故障。</li> <li>3. 排除後重新送電，若仍無法正常運轉，請通知廠商。</li> </ol>
Err 24	電磁閥異常	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 檢查電磁閥接線是否有錯誤或是短路。</li> <li>3. 排除後重新送電，若仍無法正常運轉，請通知廠商。</li> </ol>
Err 60	控速器異常	<ol style="list-style-type: none"> <li>1. 關閉電源。</li> <li>2. 檢查控速器接線是否有錯誤或是短路。</li> <li>3. 排除後重新送電，若仍無法正常運轉，請通知廠商。</li> </ol>
	安全開關檢知遮斷	<p>一般模式下，旋轉符號不轉動時：</p> <ol style="list-style-type: none"> <li>1. 關閉電源，檢查縫紉機安全開關是否故障。</li> <li>2. 排除後重新送電，若仍無法正常運轉，請通知廠商。</li> </ol>

## SERVICE PARTS POLICY

To ensure the quality and safety of machine, all SIRUBA parts pass the highest quality inspection and test. For any case of adopting non-genuine SIRUBA parts for replacement and service, it may cause not only losing the warranty coverage, but also the unexpected damage to the operator and property.

In some cases, issues such as difficulty of obtaining parts might make it impossible for us to repair or replace malfunctioning items even if the service period has not yet ended. We ask for your understanding on this matter

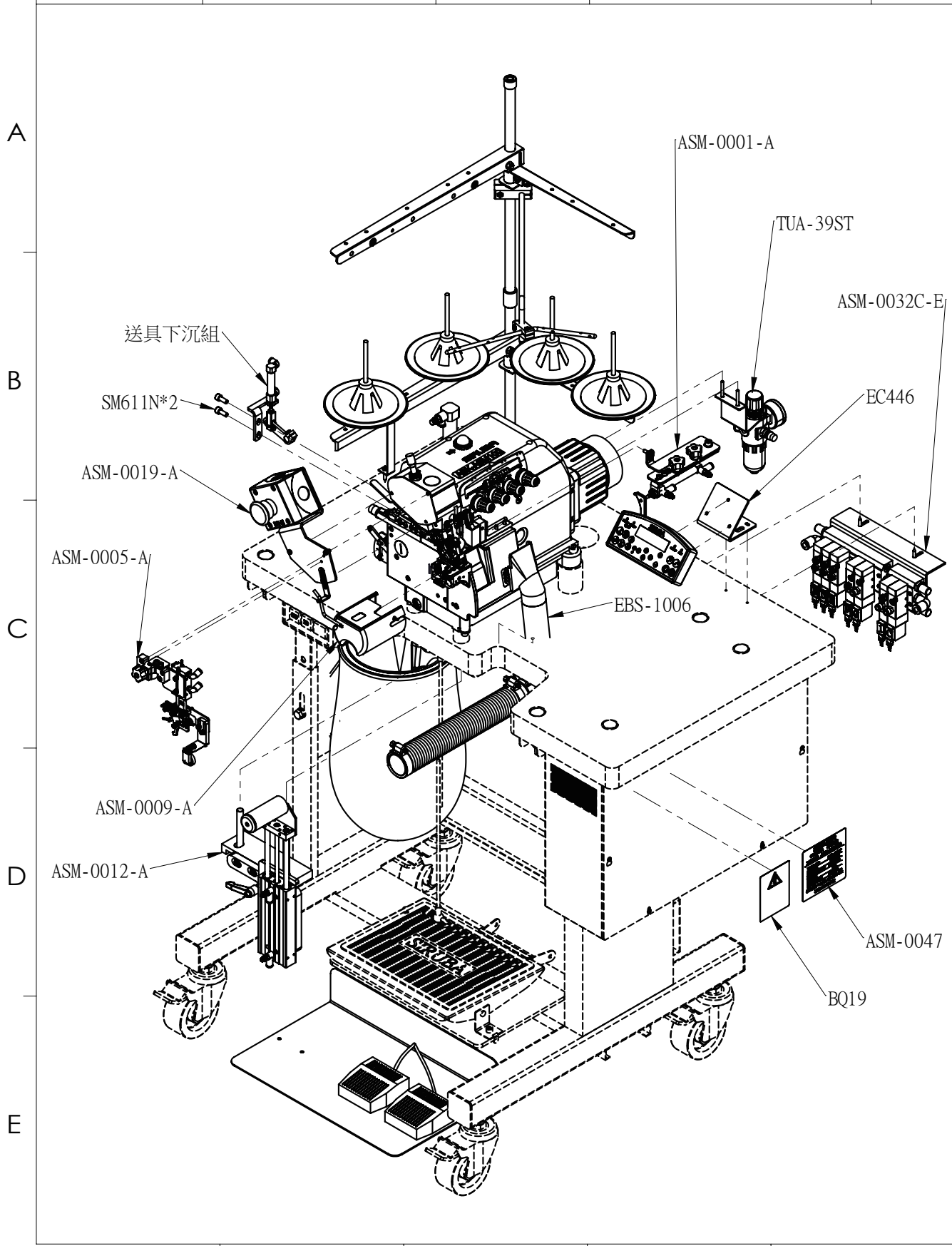
To continuously provide our customers the high quality machines and service, we do not guarantee the parts supply service for the discontinued models after 5 years since the production stops.

## 服務部分政策

為確保機器的質量和安全，所有 SIRUBA 部件均通過了最高質量的檢驗和測試。對於任何採用非正品 SIRUBA 部件進行更換和維修的情況，不僅可能導致保修範圍的損失，還可能導致對操作員和財產的意外損壞。

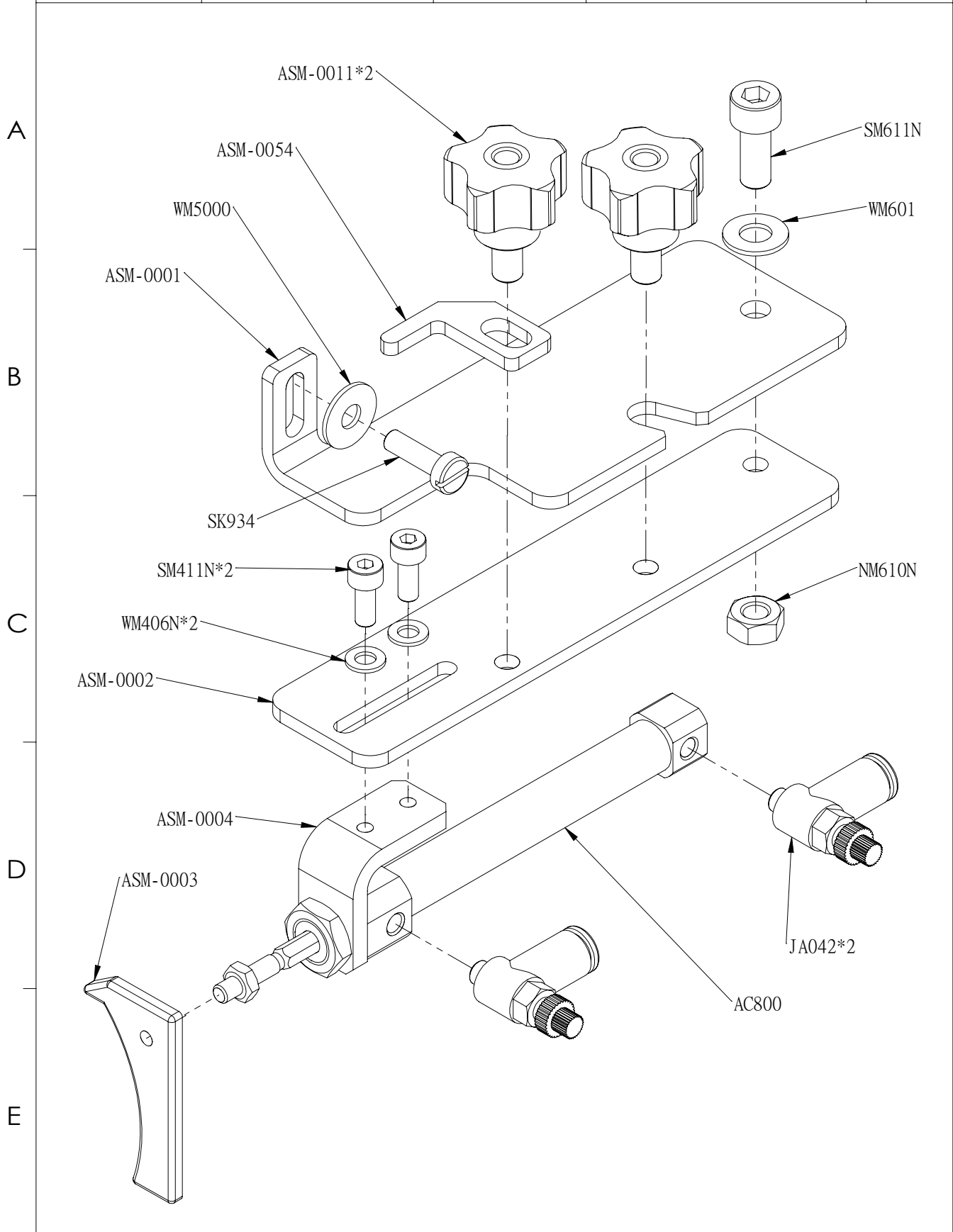
在某些情況下，即使服務期尚未結束，諸如難以獲得零件等問題也可能使我們無法修理或更換故障物品。我們要求您就此事達成諒解

為了不斷為客戶提供高質量的機器和服務，我們不保證自生產停止 5 年後停產的型號的零件供應服務。

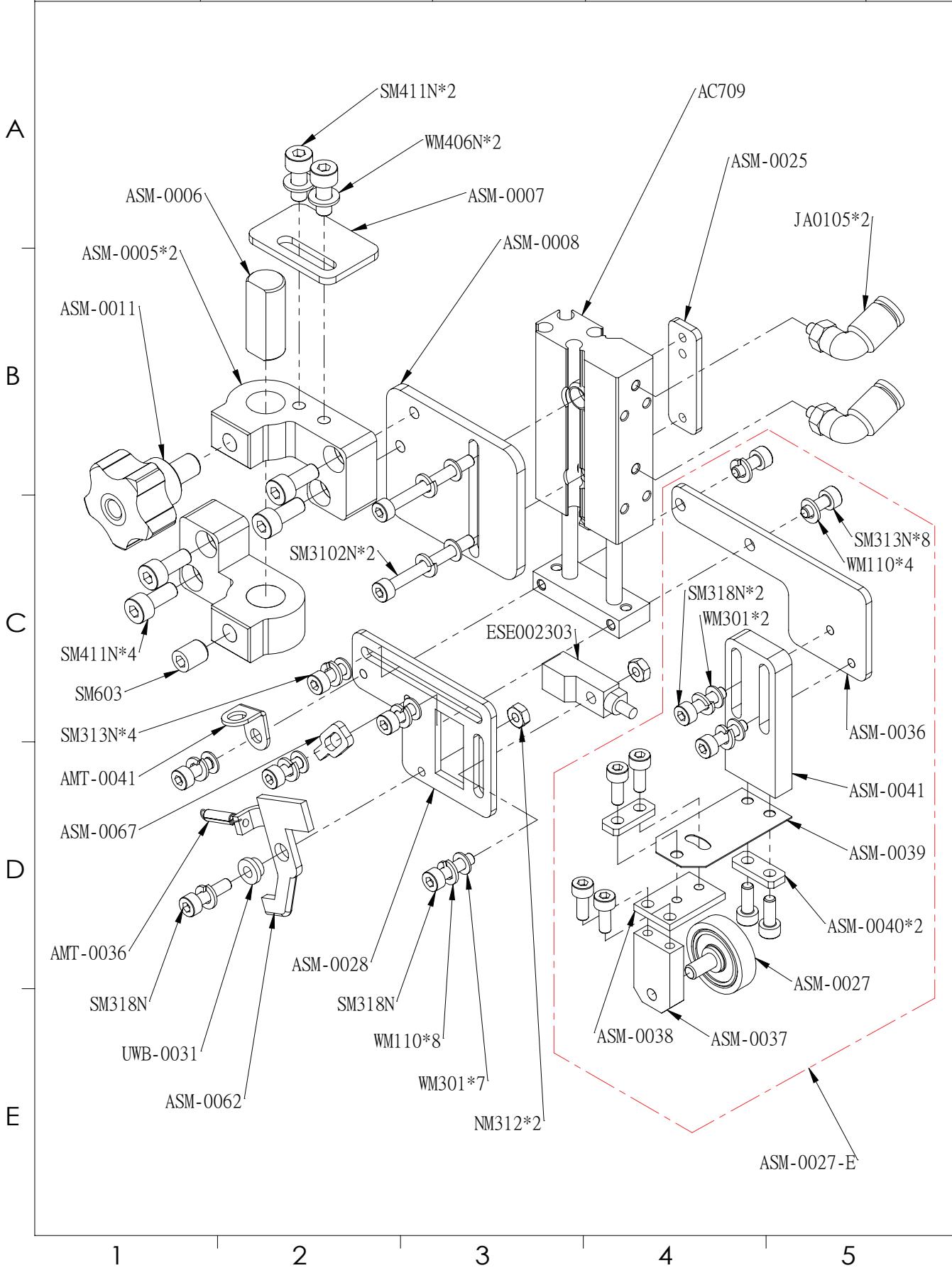




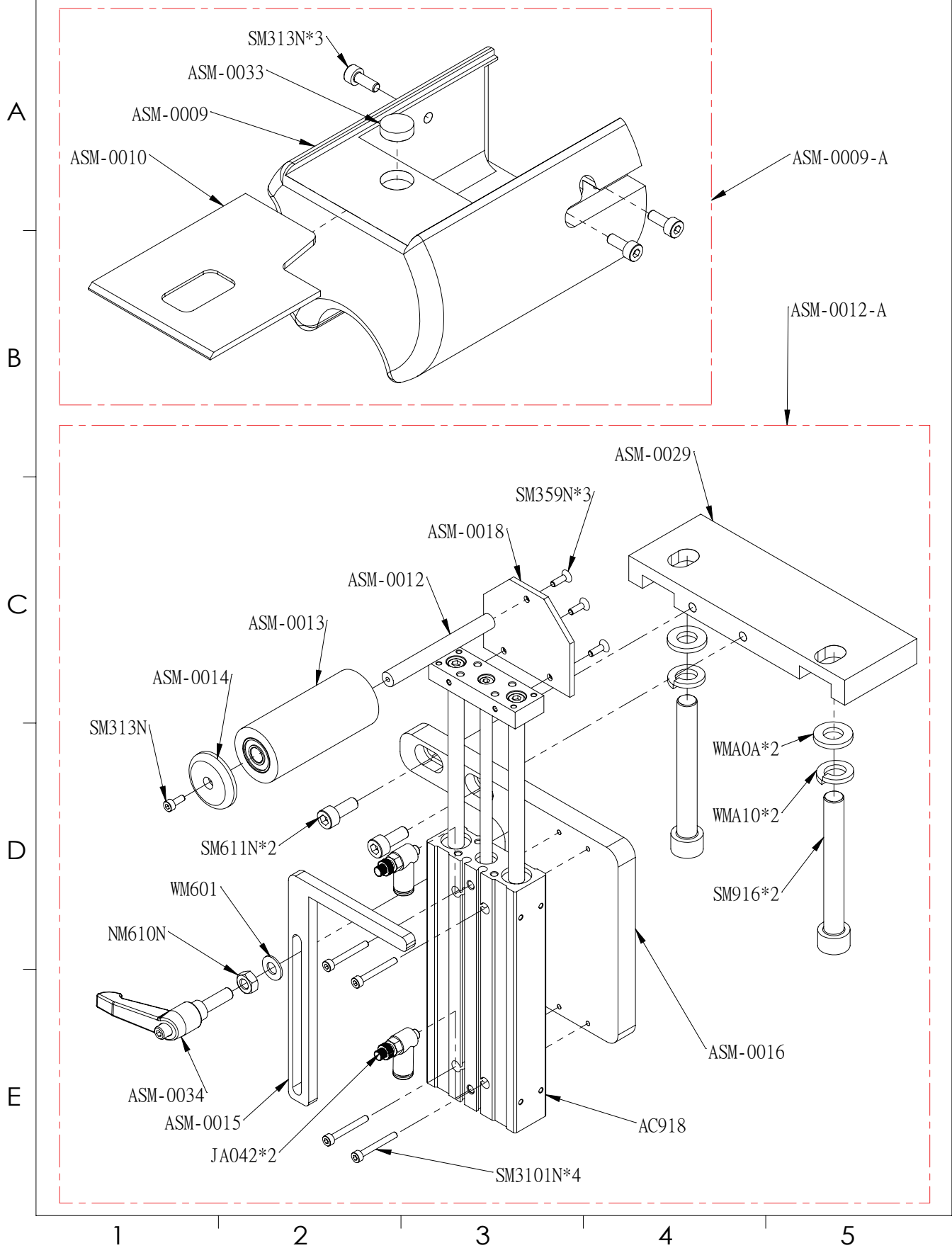
<b>SIRUBA</b>  PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASK-ASM100	ASM-0001-A	ASK07	2/9
				Date
				2019/07/05

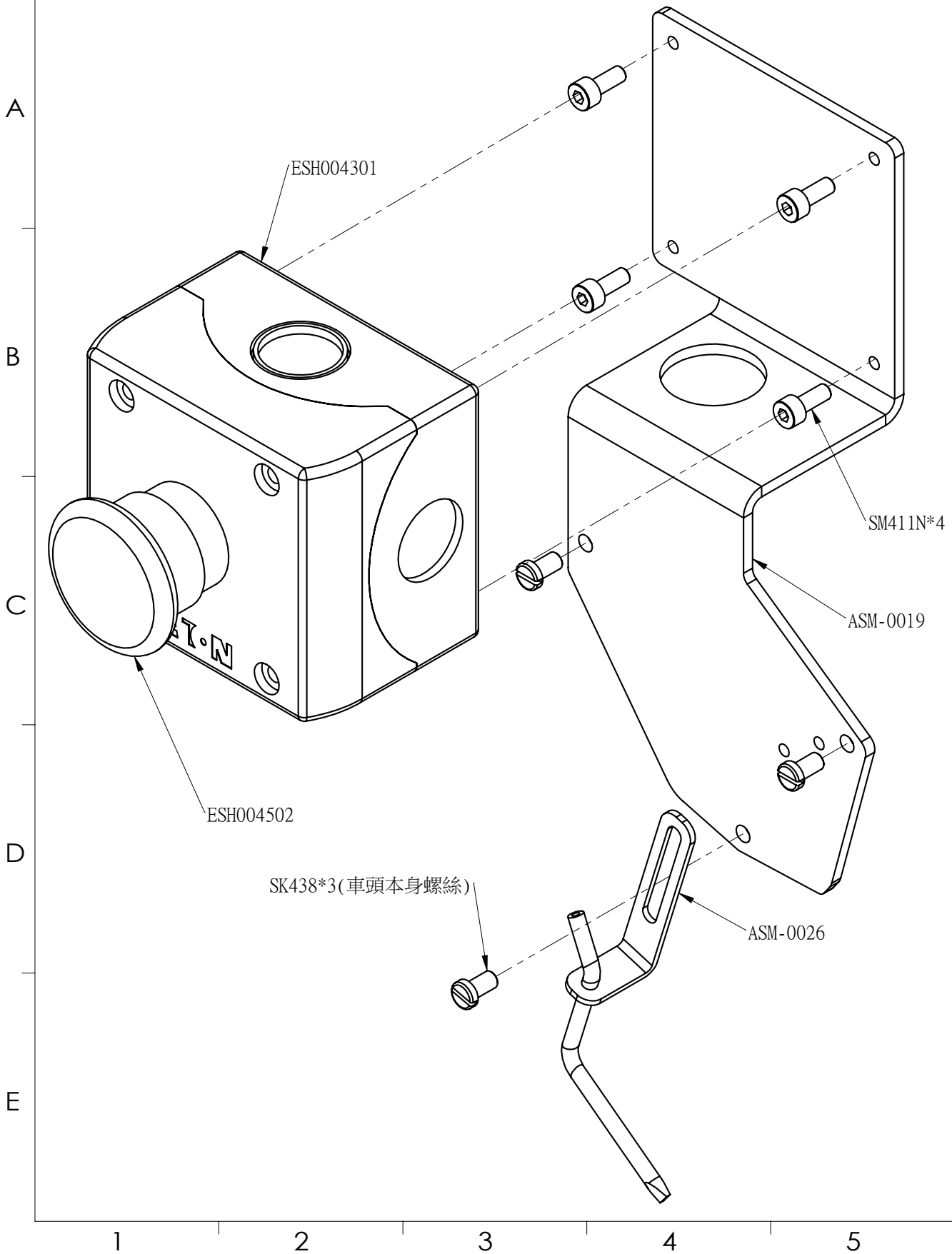


<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASK-ASM100	ASM-0005-A ASM-0027-E		3/9
				Date
				2019/07/08

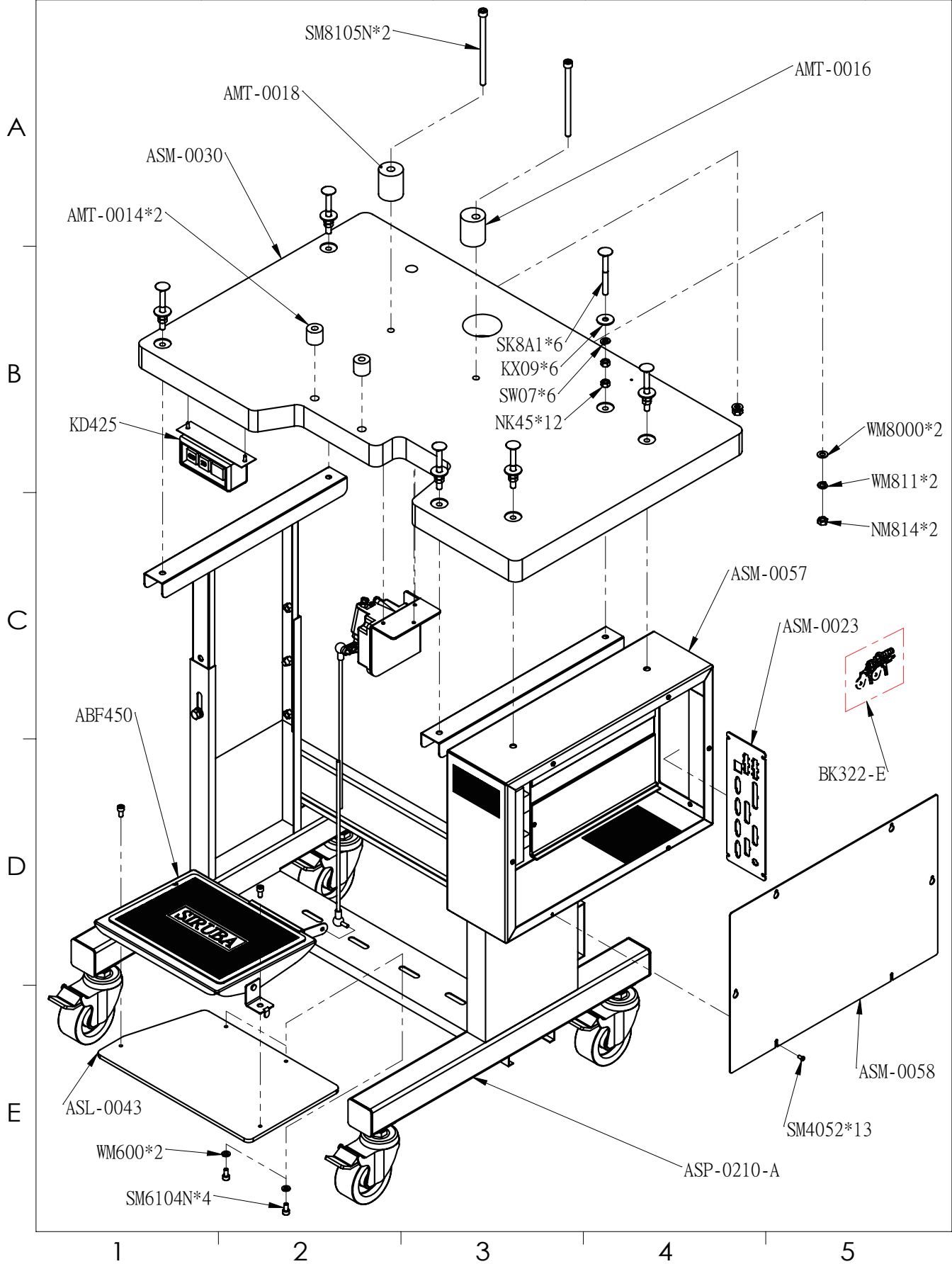


<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASK-ASM100	ASM-0009-A	ASK07	4/9
				Date





<b>SIRUBA</b>  PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASK-ASM100	ASM-0030-A	ASK07	6/9
				Date
				2019/07/08



<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASK-ASM100	ASM-0032C-E	ASK07	7/9
				Date

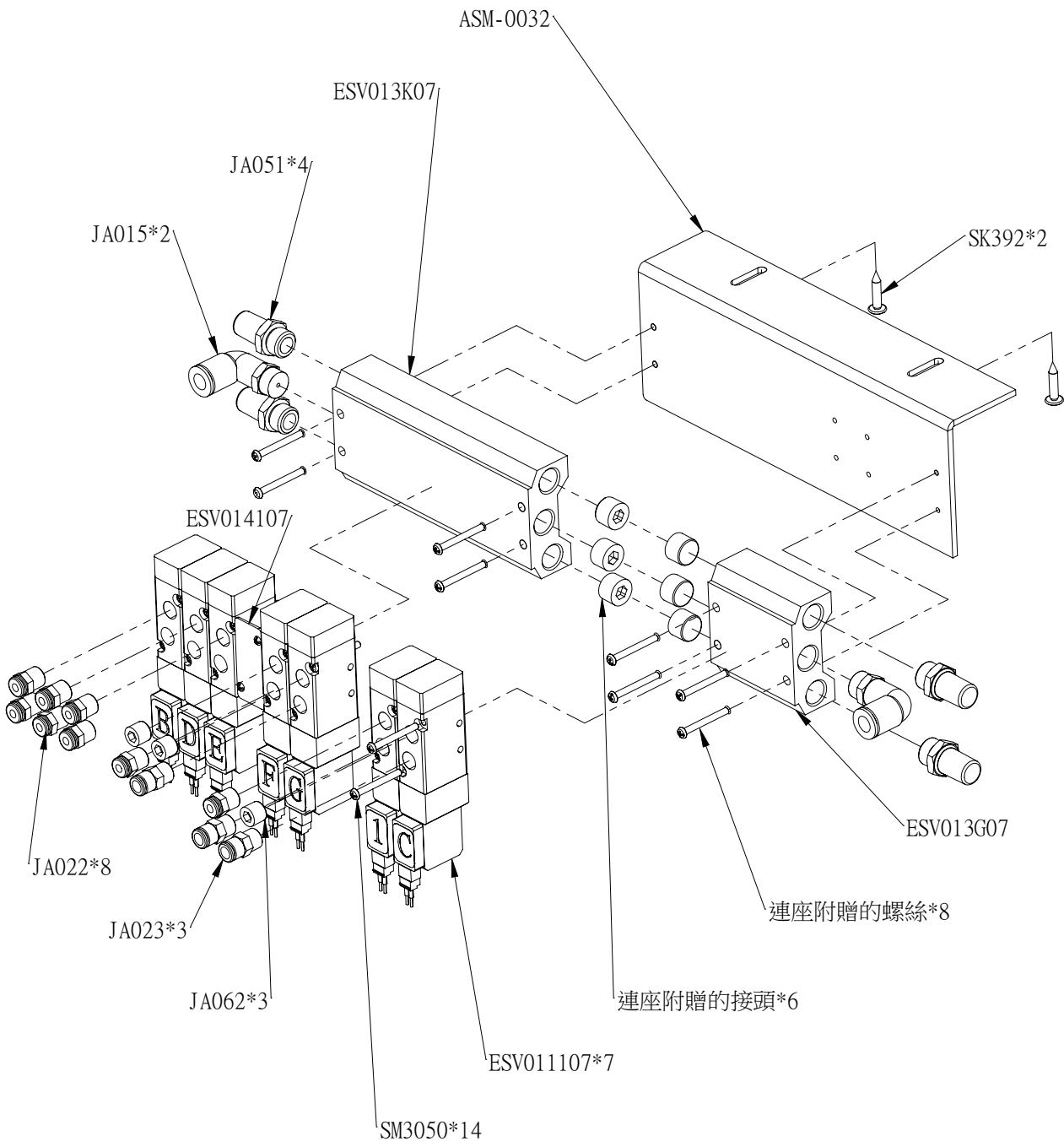
A

B

C

D

E



1

2

3

4

5

<b>SIRUBA</b>  PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ASK-ASM100	BK322-E	ASK07	8/9
				Date
				2018/09/20

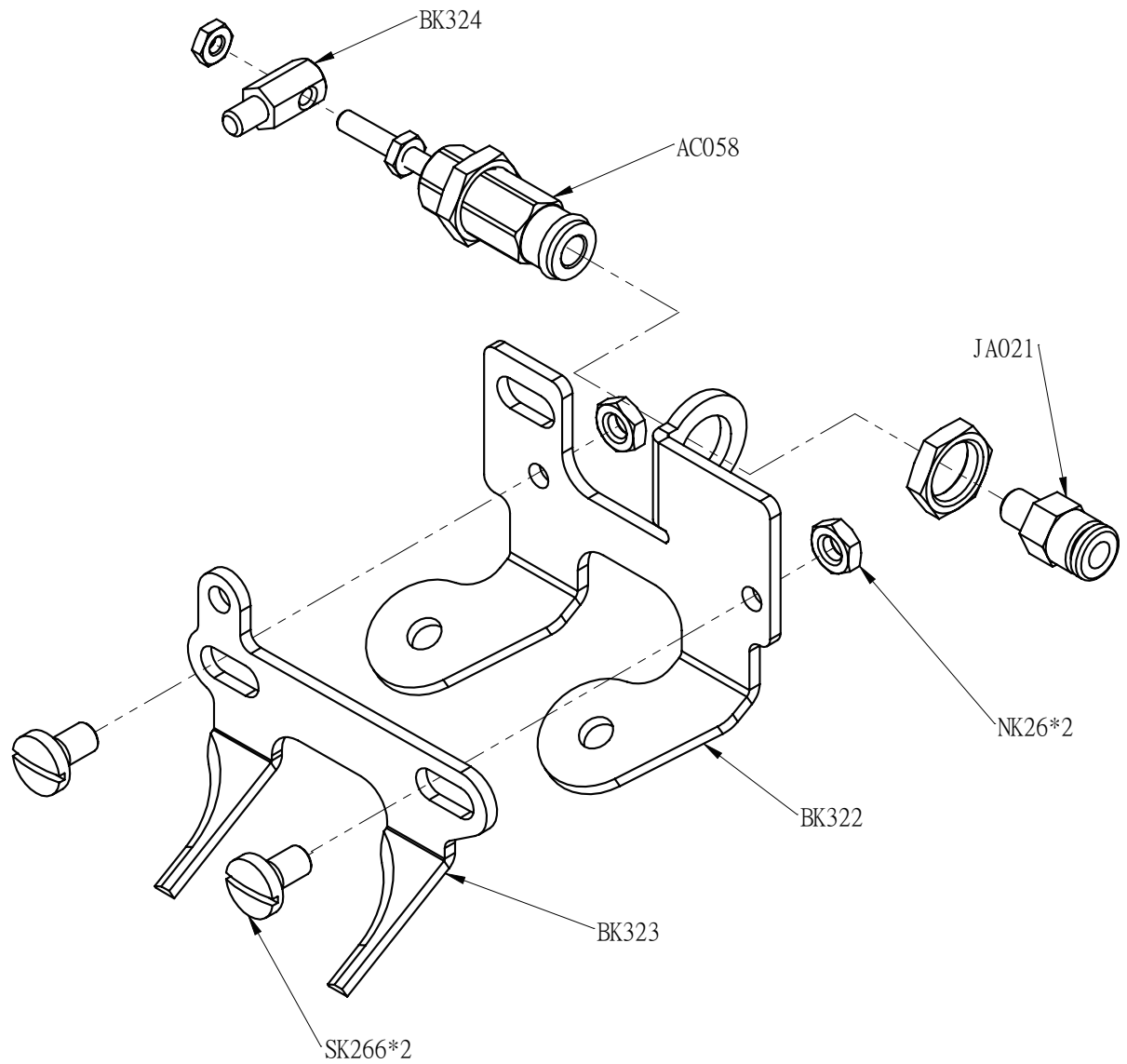
A

B

C

D

E




1

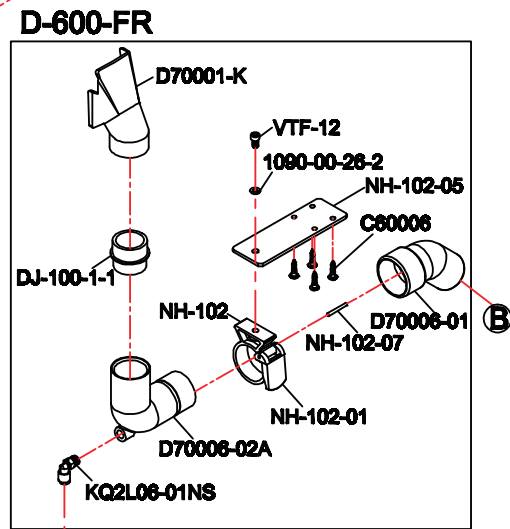
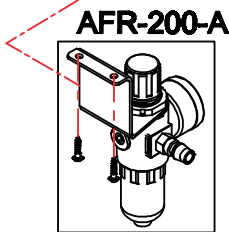
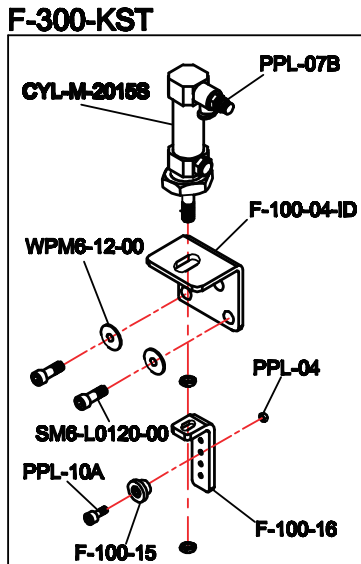
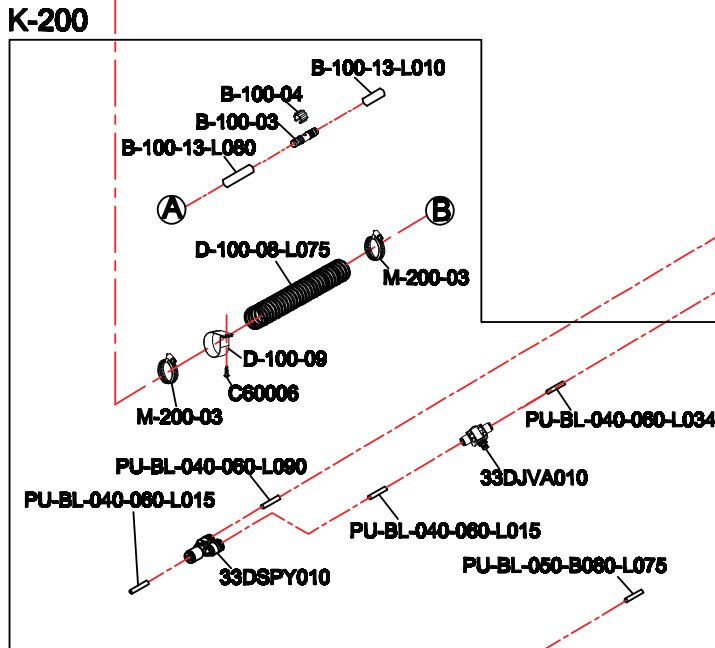
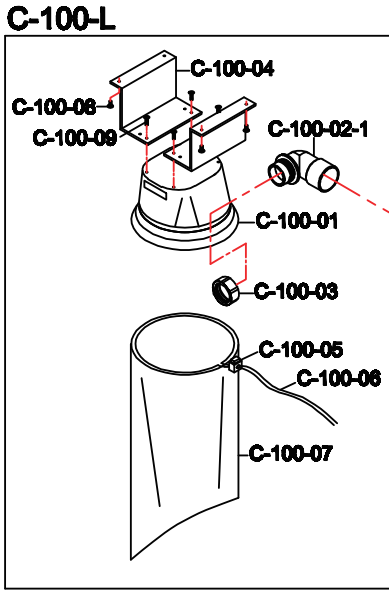
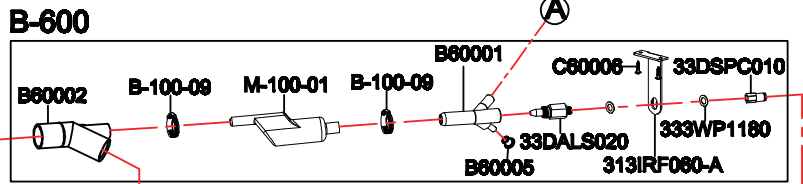
2

3

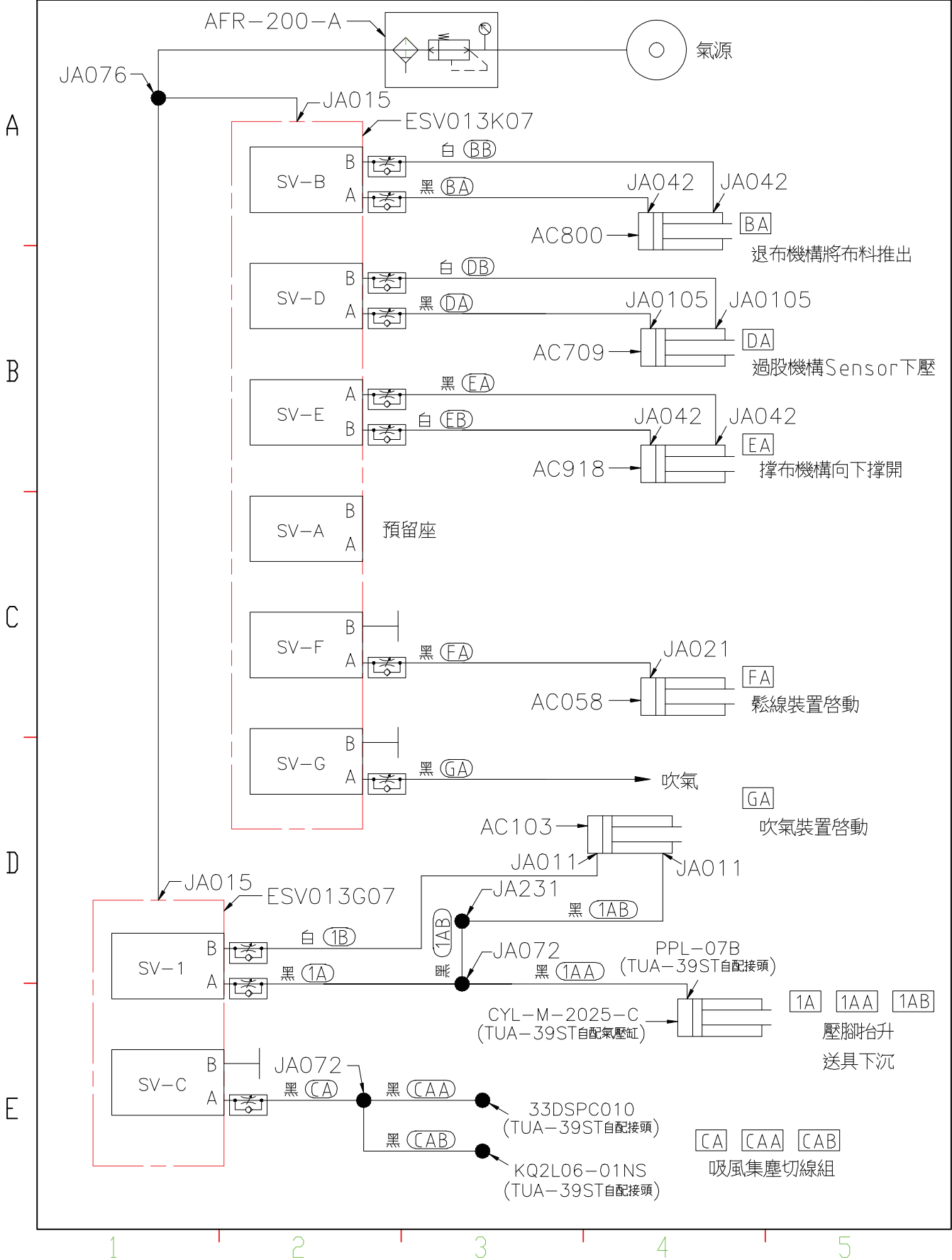
4

5

 <b>PARTS LIST</b>	Series	Parts Group	Subclass / Remark	Page
	ASK-ASM100	TUA-39ST	Note 註記: 1) 空氣有效使用壓力 Effective air pressure: 4~6 kg/cm 2) 請適度修飾管子長度，以達到風力最佳效能。	9/9
				Date
				2018/09/20



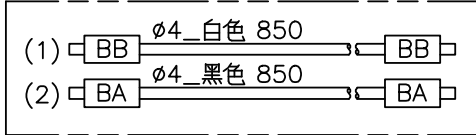




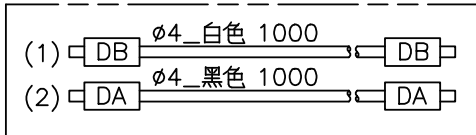
氣瓶連座組



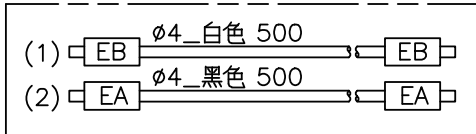
SV-B  
退布機構



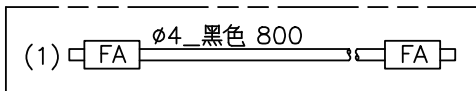
SV-D  
過股機構



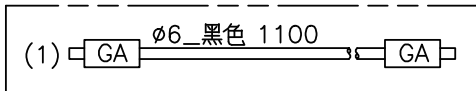
SV-E  
撐布機構



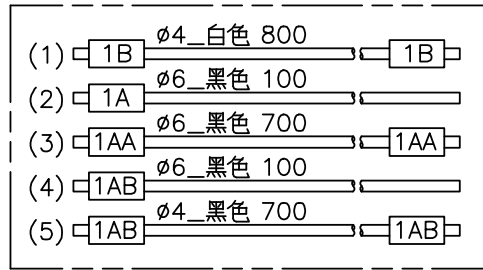
SV-F  
鬆線裝置



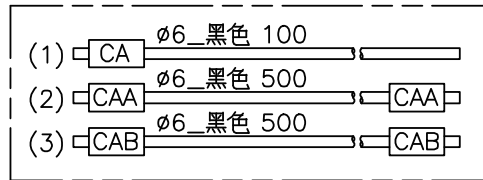
SV-G  
吹氣裝置



SV-1  
抬壓腳機構  
送具下沉組

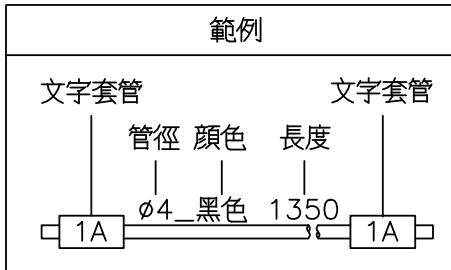


SV-C  
吸風集塵組  
切線組



文字套管

- (1) BB x2 (10) 1A x1
- (2) BA x2 (11) 1AA x2
- (3) DB x2 (12) 1AB x3
- (4) DA x2 (13) CA x1
- (5) EB x2 (14) CAA x2
- (6) EA x2 (15) CAB x2
- (7) FA x2
- (8) GA x2
- (9) 1B x1



廠商:PISCO

規格:UM0425-100-B (ø4\_黑)

規格:UM0425-100-W (ø4\_白)

規格:UM0640-100-B (ø6\_黑)

規格:UM0860-100-B (ø8\_黑)

熱處理:	NO	更改內容					高林關係企業		
硬度:	NO						空壓管組		
硬度層深度:	NO	表面處理:					中文品名	Air Compression Tube Comb.	
加工區分 尺寸區分 mm	切割加工 (車, 銑, 鑽)	沖壓加工	鑄造 鍛造	脫蠟 壓鑄	第三角法	單位: mm	英文品名	材質	
					重量: - (kg)	比例: 1:1			責任者
0.5以上6以下	±0.1	±0.2	±0.4	±0.2	繪圖			途程	
6以上30以下	±0.2	±0.3	±0.5	±0.3	校對				成品圖
30以上120以下	±0.3	±0.5	±0.7	±0.5	覆核			圖號	
120以上315以下	±0.5	±0.6	±1.0	±0.6	核准				ASM-0044-A
315以上1000以下	±0.8	±1.1	±1.5	—				0	
1000以上	±1.2	±1.8	—	—					
切割加工形狀·位置精度		公差的 1/4		角度公差 ±2°		1/100		0.2/100	
表面粗度之範圍 (Ra)		▽▽▽ 0.2		▽▽ 0.2~1.6		▽ 2~6.3		▽ 8~25	
註:成品需符合歐盟RoHS危害物質限用指令規範									

表 E f09





 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.  
ASK-ASM100.OCT.2019