

# SIRUBA®

銀箭牌工業用縫紉機  
INDUSTRIAL SEWING MACHINE

# L818-RM1

## 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 European Directive  
Machinery Directives:98/37/EC, as amended by 89/336/EEC and  
73/23/EEC.

The undersigned, ROBERT TSAI, representing KAULIN MFG. CO., LTD., 11F, No.128,  
Sec.3, Minsheng East Road, Songshan District, Taipei, Taiwan, ROC., manufacturer,  
Declares that the machine described hereafter:

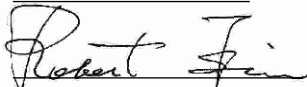
One Needle Straight Lockstitch Machine  
with Vertical Cutting Knife  
Model:L818F-RM1

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: Jun/01/2006

Signature: 

Qualification: R&D MANAGER

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## 裁布刀的調整

## KNIFE HEIGHT ADJUSTMENT

### 1. 裁布刀的高度調整：(圖1)

- (1). 裁布刀②的操作可透過旋鈕①來控制。將旋鈕①往下轉時，裁布刀②可開始修布邊，將旋鈕①往上轉時，裁布刀②即不修布邊。
- (2). 當旋鈕①往下轉時，將裁布刀②的螺絲③放鬆並調整裁布刀②的高度，使A點部份低於針板0.5 mm，調整後，並旋緊螺絲③。

### 2. 裁布刀前後位置的調整(圖2)

- (1). 將針距調整鈕調至0的位置。
- (2). 裁布刀的標準位置要在車針⑤中心點的前方2 mm的位置。
- (3). 裁布刀的前後位置調整，可藉由鬆開螺絲⑥來進行調整，可調整的範圍是針前2 mm到針後3 mm。

### 1. Knife height adjustment (Fig. 1)

- (1). The operation of knife ② is controlled by switch ①. Winding switch ① down to start fabric side trimming. Winding switch ① up to stop fabric side trimming.
- (2). When switch ① is wound to down side, loose screws ③ of the fabric trimming knife ② to adjust the height. Make point "A" 0.5 mm lower than the needle plate. Then, lock the screws ③.

### 2. Adjustment of fabric trimming knife's front and rear position (Fig. 2)

- (1). Turn the stitch length adjusting knob to the position "0".
- (2). Standard position of the knife is 2 mm in front of the needle center point.
- (3). By loosening screw ⑥ can adjust the knife backward and forward. The adjustable range is 2 mm in front of the needle to 3 mm in the back.

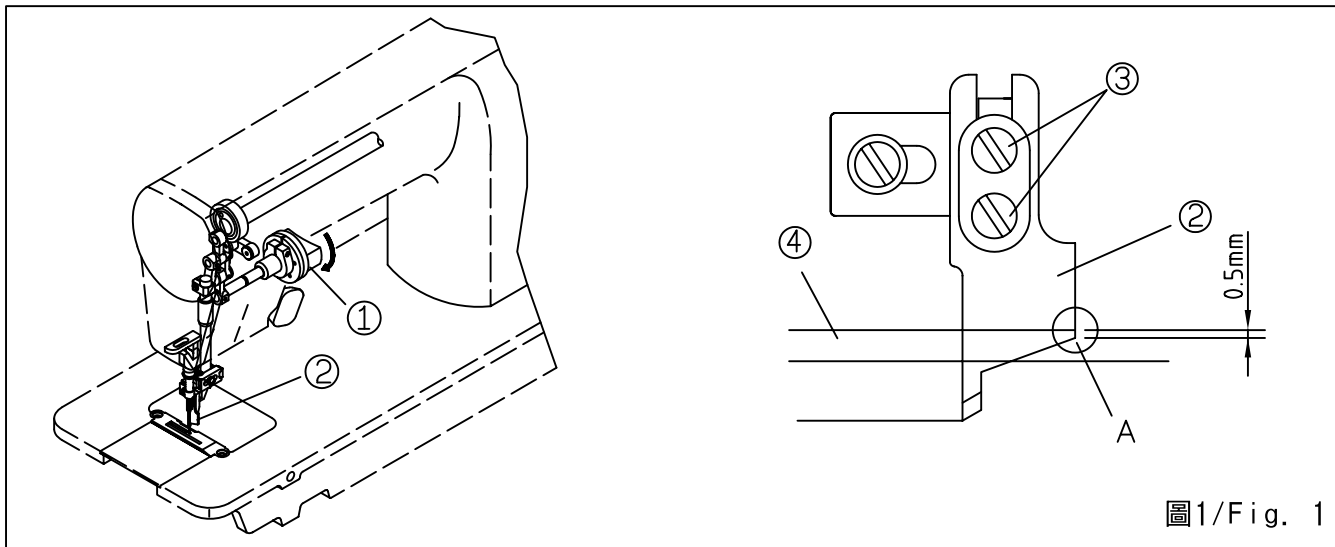


圖1/Fig. 1

### 3. 裁布刀的左右位置的調整(圖2)

- (1). 裁布刀的左右位置調整可以藉由鬆開螺絲⑧而移動⑦來調整左右。

### 3. Adjustment of fabric trimming knife's left and right position. (Fig. 2)

- (1). By loosening screw ⑧ and moving ⑦ to adjust the knife's left and right position.

- (2). 鬆開螺絲⑧來調整裁布刀與針板的距離，調整完之後再旋緊螺絲。
- (3). 此裁布刀如太靠近針板，裁布時的阻力會很大，如距離與針板太遠，裁布的效果又會不好，所以使用者可以藉由旋鈕①(圖1)的上下動作來調整。

- (2). Loosen screw ⑧ to adjust the distance from the knife to needle plate. Retighten the screw after adjustment.
- (3). If the knife is too close to the needle plate, the fabric trimming resistance will be large. If the knife is away from the needle plate, the effect of fabric trimming will be bad. Therefore, users can adjust it by winding the switch ① (Fig. 1) up and down to reach the proper distance.

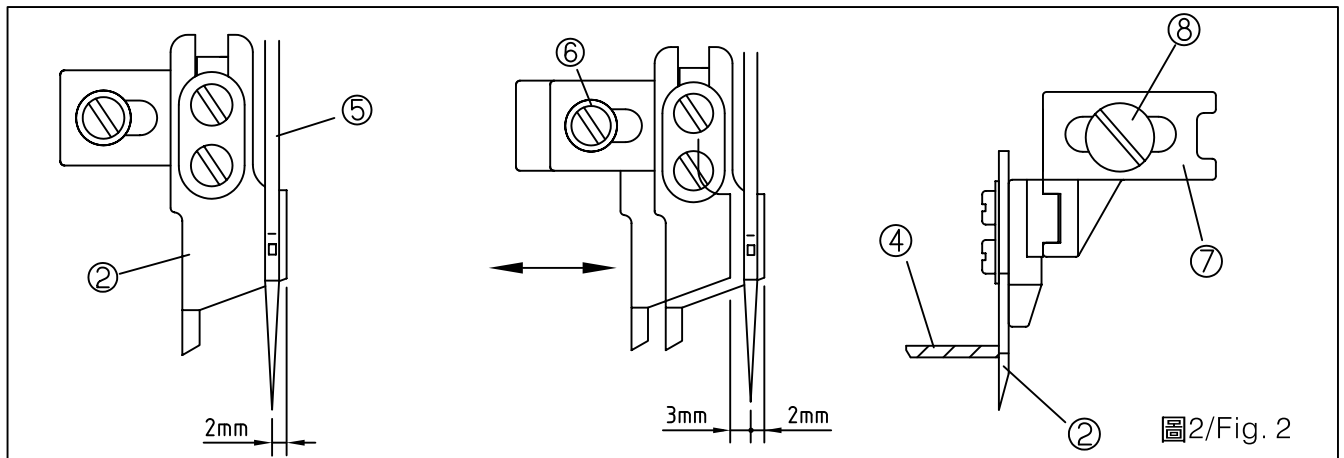


圖2/Fig. 2

## 導布片及輔助版之選用

## FABRIC GUIDING PARTS AND SCRAPE HOLE COVER

1. 在使用裁布刀的同時，可用配件盒內的導布片②來協助車縫。(圖3)
2. 如不使用裁布刀時，可將導布片②拆掉用輔助板③來代替而變為一般的平車使用。(圖4)

1. Fabric guiding part ②, packed in the accessory box, can be used to assist sewing while using fabric trimming knife. (Fig. 3)
2. Remove fabric guiding part ② if not using the knife, and replace the part with the scrape hole cover ③. (Fig. 4)

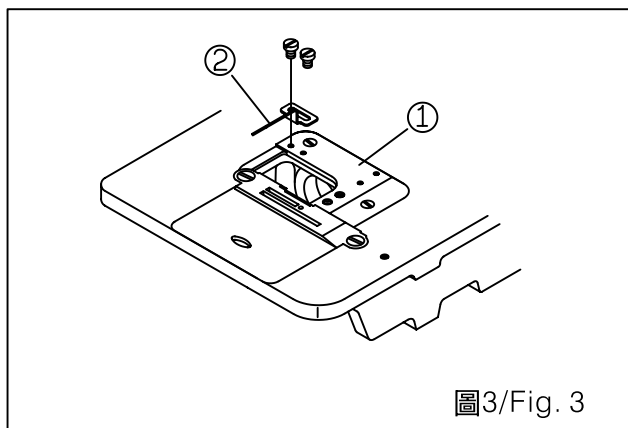


圖3/Fig. 3

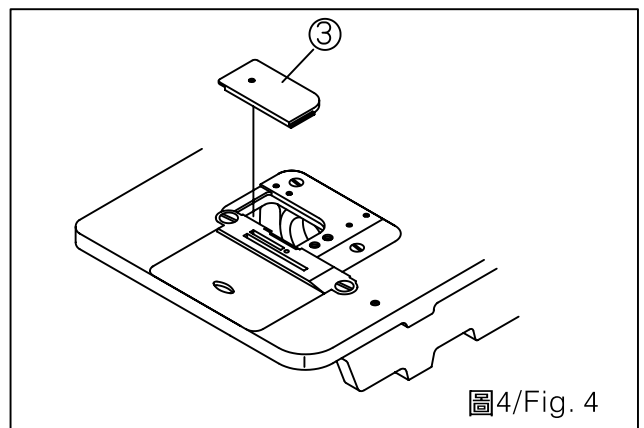


圖4/Fig. 4

## 裁邊寬度的安裝調整

## INSTALLATION AND ADJUSTMENT OF FABRIC TRIMMING WIDTH

### 1. 拆卸過程 (圖5)

- (1). 鬆開螺絲①，將車針②拆下。
- (2). 鬆開押具的螺絲③，拆下押具④。
- (3). 鬆開針板螺絲⑤，拆下針板⑥。
- (4). 鬆開送具的螺絲⑦，拆下送具⑧。
- (5). 鬆開輔助板的螺絲⑨，拆下輔助板⑩。
- (6). 鬆開導布片的螺絲⑪，拆下導布片⑫。

### 2. 組裝過程

- (1). 調整導布片⑫至適當距離並稍為鎖緊導布片的螺絲⑪。
- (2). 鎖緊輔助板的螺絲⑨，固定輔助板⑩。
- (3). 鎖緊送具螺絲⑦，固定送具⑧。
- (4). 鎖緊針板螺絲⑤，固定針板⑥。

### 1. Disassembling process (Fig. 5)

- (1). Loose screw ① to take needle ② apart.
- (2). Loose screw ③ to take presser foot ④ apart.
- (3). Loose screws ⑤ to take the needle plate ⑥ apart.
- (4). Loose screws ⑦ to take feed dog ⑧ apart.
- (5). Loose screws ⑨ to take scrape chute side plate ⑩ apart.
- (6). Loose screw ⑪ to take scrape chute ⑫ apart.

### 2. Assembling process

- (1). Adjust scrape chute ⑫ to proper distance and lock the screws ⑪ a little.
- (2). Place scrape chute side plate ⑩ correctly, and retighten screws ⑨.
- (3). Place feed dog ⑧, and retighten screws ⑦.
- (4). Place needle place ⑥ correctly, and retighten the screws ⑤.

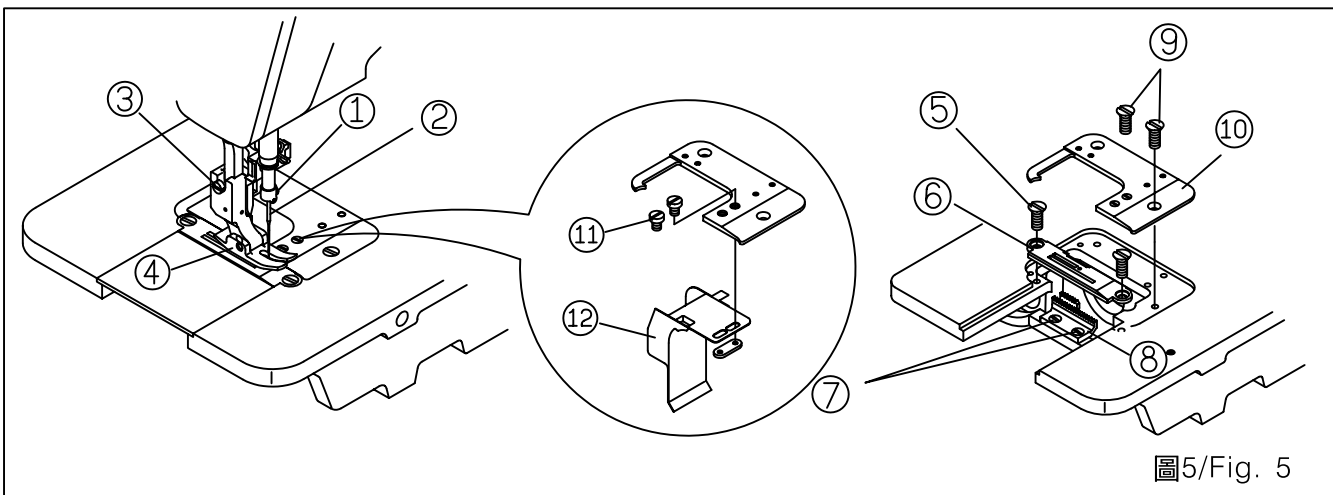


圖5/ Fig. 5

註：

- A. 手轉動手輪確認送具與針板的間隙無誤後，再調整裁布刀與針板之距離。

Remarks:

- A. Rotate the pulley to confirm the clearance between the feed dog and the needle plate is correct. Then, adjust the distance from fabric trimming knife and needle plate.

B. 確認下導布片⑫距針板⑥的距離為0.5 mm後，將螺絲⑪鎖緊。

(5). 調整裁布刀⑭與刀座⑦有正常的壓力及裁布刀⑭與針板⑥的距離後，鎖緊螺絲⑬(請參考裁布刀的調整)。(圖6)

(6). 裝上押腳④，並鎖緊螺絲③。

(7). 裝上針②，並鎖緊螺絲①。

(8). 依照上述方法調整裁布刀座⑦的位置後，鎖緊螺絲⑬。

註：  
組裝後，請再度確認「裁布刀的位置」。

B. Confirm the distance between the lower scrape chute ⑫ and the needle plate ⑥ is 0.5 mm, and then retighten screws ⑪.

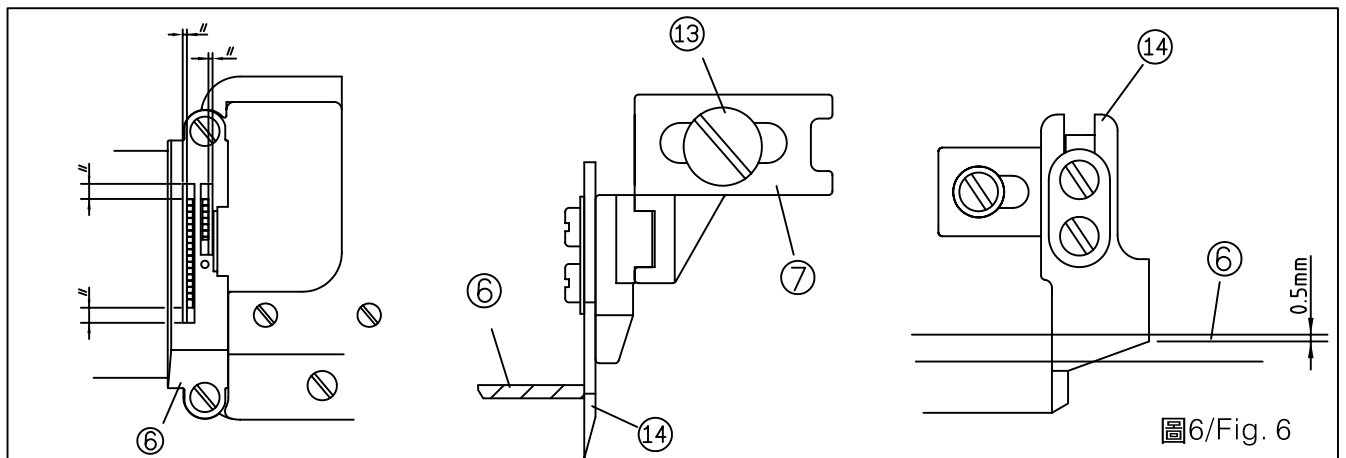
(5). Adjust the knife ⑭ and the knife base ⑦ are under proper pressure, and the knife ⑭ has a proper distance to the needle plate ⑥. Then retighten the screw ⑬ (Please refer to "Knife Height Adjustment"). (Fig. 6)

(6). Install the presser foot ④ correctly, and tighten the screw ③.

(7). Place the needle ② and tighten the screw ①.

(8). Adjust the knife base ⑦ as the process mentioned above and retighten the screw ⑬.

Remarks:  
Please reconfirm "the knife position" after the assembly.



## 排油擋板之安裝

## LUBRICANT COVER ASSEMBLY

安裝排油擋板①，並特別注意以下事項：  
(圖7)

(1). 排油裝置頂部不應超出布屑蓋②上平面(A)左邊之延伸線。

(2). 當機頭提起或傾斜時，布屑蓋②之(B)板，不可與排油裝置接觸。

Assemble lubricant cover ①, and special notices. (Fig. 7)

(1). The top of the lubricant cover must not be over the extension line (A) from left side of the scrape chute ②.

(2). When lift or tilt the machine head, the (B) plate of the scrape chute ② must not touch the lubricant cover ①.



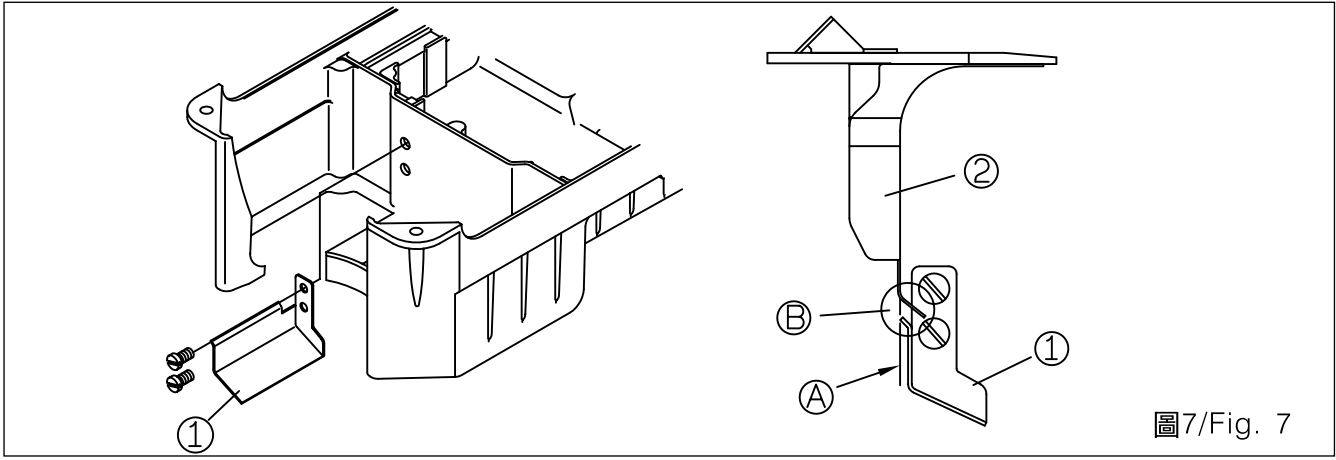


圖7/Fig. 7



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