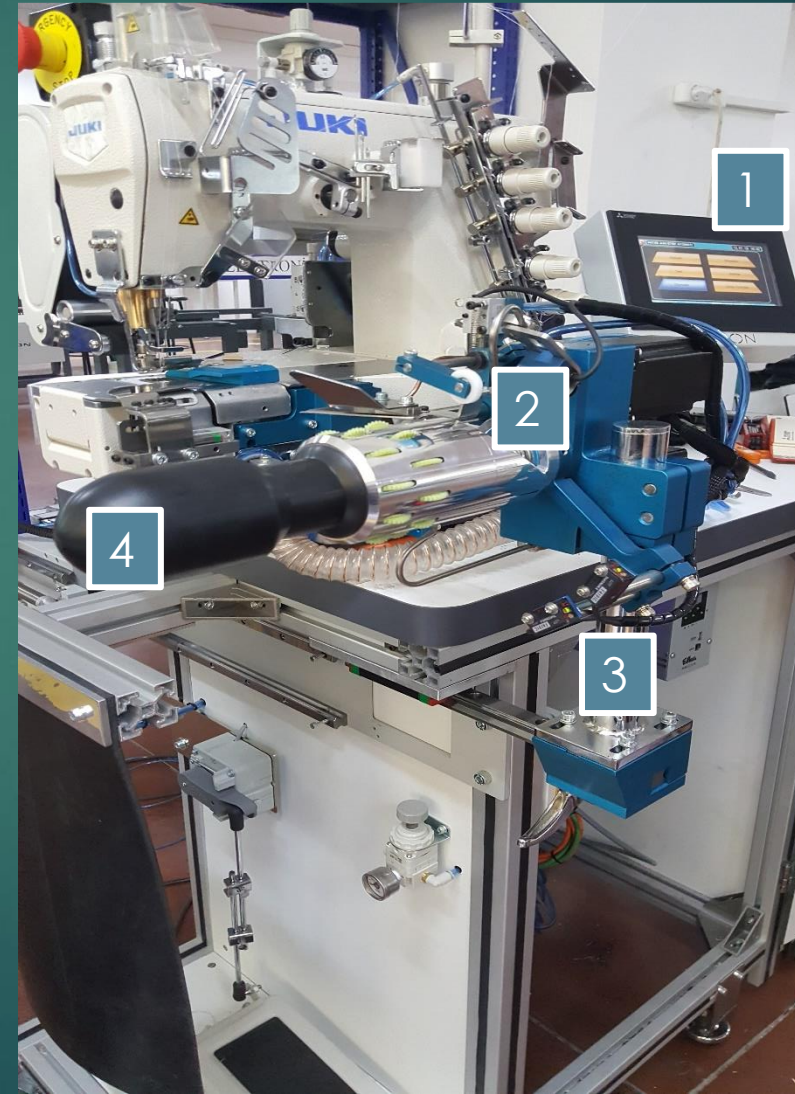
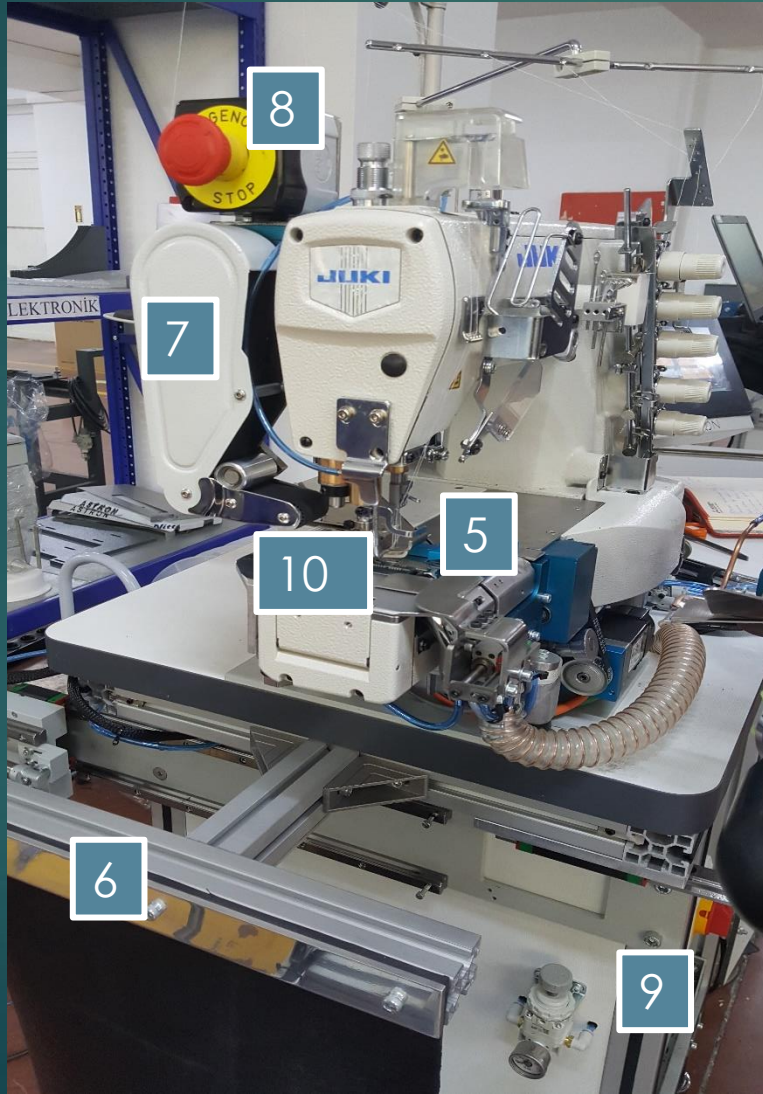


# ERDO-1 / ERDO-2



**▲ ASTRON**  
POWERED BY ASTAS

# MAKİNA GÖRÜNTÜLERİ



# 1. PANEL GÖRÜNTÜLERİ



**ASTAS JUKI ETEK OTOMATI** 12.07.19 14:38

Manuel 1	2 Modeller
Test 3	Ayarlar
Otomatik Modu 4	5 Giriş / Çıkışlar

Çalışma Seçimi : MANUEL / Aktif Program ABCDEFGHI JKLMNOPQR

# 1.1.MANUEL DİKİŞ SAYFASI



1. Dikiş kalınlığı ayarlanır.
2. Beden uzunluğu ayarlanır.
3. Yapılan işleri sıfırlama butonudur.
4. Yapılacak dikiş işlemlerinin manuel butonlarıdır.



# 1.2.PROGRAM SAYFASI



1. Masura sıfırlama butonudur.
2. Hafızada ki programların olduğu bölümdür.
3. Hafızada ki programları seçme ve kaydetme butonlarıdır.
4. Aktif programı gösterme ve kopyalama butonudur.

**ASTAS JUKI ETEK OTOMATI** 12.07.19 14:37

Program Sayfasi

1	[ ]	ABCDEFGHI JKLMNOPQRST	6	[ ]	ABCDEFGHI JKLMNOPQRST
2	[ ]	ABCDEFGHI JKLMNOPQRST	7	[ ]	ABCDEFGHI JKLMNOPQRST
3	[ ]	ABCDEFGHI JKLMNOPQRST	8	[ ]	ABCDEFGHI JKLMNOPQRST
4	[ ]	ABCDEFGHI JKLMNOPQRST	9	[ ]	ABCDEFGHI JKLMNOPQRST
5	[ ]	ABCDEFGHI JKLMNOPQRST	10	[ ]	ABCDEFGHI JKLMNOPQRST

Ana Menu

Sayac Reset

İs Sayacı 123456

Seçilen Program

Program Sec

Program Reset

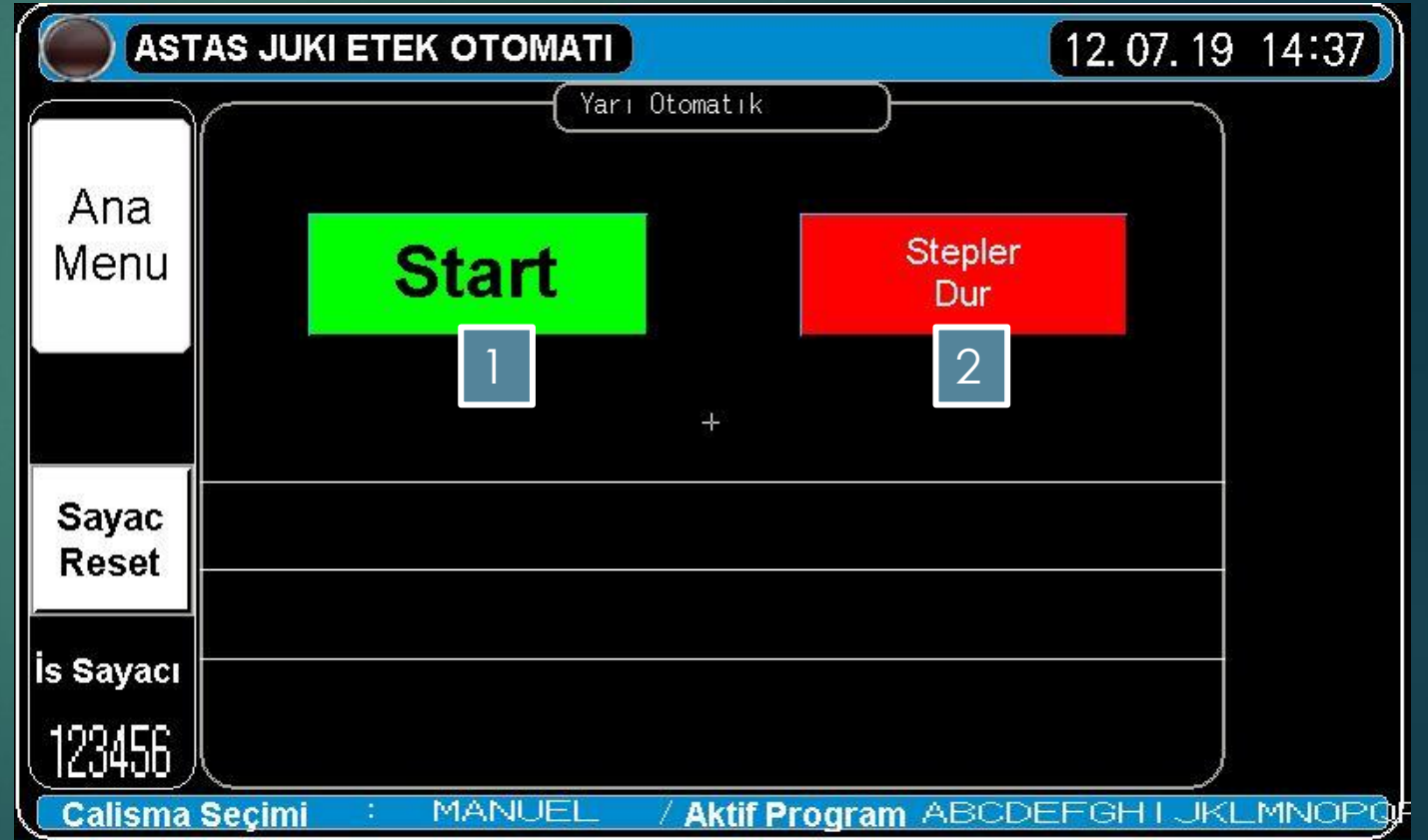
PROGRAM SEC

FAB. AYARLARI YUKLE

Çalışma Seçimi : MANUEL / Aktif Program ABCDEFGH I JKLMNOPQRST

# 1.3.TEST SAYFASI

1. Makine start alınır ve gerekli ayarlamaların yapılacağı manuel moda geçilir.
2. Herhangi bir hata ile karşılaşıldığında makine sadece steplerini durdurur ve o sürece kadar ki ayarların bozulması önler.



# 1.4. OTOMATİK DİKİŞ SAYFASI



**ASTAS JUKI ETEK OTOMATI** 12.07.19 14:39

**Dikiş Başı**

Bosta Dönme Zmn	3456
Bosta Donuş Hızı	23456
Dikiş Adımı	456.0
Dikiş Başı	345.6
Gerdirme Kolu	3456
Merdane Hızı	3456
Disli İceri Disari Hiz	İceri 3456 Dısarı 3456
Yan Dikiş Secimi	Yan Dikiş Kapalı

**Ana Menu**

**Sayac Reset**

**İs Sayacı** 123456

**Dikiş Başı**

**Dikiş**

**Dikiş Sonu**

**Dikiş Dur**

**Calisma Seçimi** : MANUEL / **Aktif Program** ABCDEFGHIJKLMNOPQR

**ASTAS JUKI ETEK OTOMATI** 12.07.19 14:40

**Dikiş**

Dikiş Bindirme Adımı	23456
Steplerin Devreye Girme Zmn	123456
Tokatlama zmn	23456
İstifleme Tokatlama Zmn	123456
Disli İceri Disari Hiz	İceri 3456 Dısarı 3456

**Ana Menu**

**Sayac Reset**

**İs Sayacı** 123456

**Dikiş Başı**

**Dikiş**

**Dikiş Sonu**

**Dikiş Dur**

**Calisma Seçimi** : MANUEL / **Aktif Program** ABCDEFGHIJKLMNOPQR

**ASTAS JUKI ETEK OTOMATI** 12.07.19 14:39

**Dikiş**

Ön Kol Hızı	23456
Arka Kol Hızı	23456
Makina Hızı	56 3456
Dikiş Bindirme Hızı	3456
Merdane Hiz %	3456
Disli İceri Disari Hiz	İceri 3456 Dısarı 3456

**Ana Menu**

**Sayac Reset**

**İs Sayacı** 123456

**Dikiş Başı**

**Dikiş**

**Dikiş Sonu**

**Dikiş Dur**

**Calisma Seçimi** : MANUEL / **Aktif Program** ABCDEFGHIJKLMNOPQR

# 1.4.1. DİKİŞ BAŞI

1. 8 numaralı butona basıldığı zaman aktive edilir. Yan dikiş için boşta dönme zamanı ayarlanır.
2. Ön ve arka kolun boşta dönüş hızıdır.
3. Makine dikiş adımıdır.
4. Dikiş başlangıç adımıdır.
5. Ön ve arka kolun beden uzunluğudur.
6. Merdane dönüş hızıdır.
7. Ön ve arka kolda ki hareket kısıtlayıcı dişlilerin hızlarıdır.

The image shows the control panel of an ASTAS JUKI ETEK OTOMATI sewing machine. The panel is divided into several sections:

- Top Bar:** Displays the machine name "ASTAS JUKI ETEK OTOMATI" and the date/time "12.07.19 14:39".
- Left Side:** Contains buttons for "Ana Menu", "Sayac Reset", and "İs Sayacı".
- Center:** A list of settings with numbered buttons (1-8) and corresponding values:
  - 1: Bosta Dönme Zmn: 3456
  - 2: Bosta Donüş Hızı: 23456
  - 3: Dikiş Adımı: 456.0
  - 4: Dikiş Başı: 345.6
  - 5: Gerdirme Kolu: 3456
  - 6: Merdane Hızı: 3456
  - 7: Disli İceri Disari Hız: İceri 3456, Disari 3456
  - 8: Yan Dikiş Secimi: Yan Dikiş Kapalı
- Right Side:** Contains buttons for "Dikiş Başı", "Dikiş", "Dikiş Sonu", and "Dikiş Dur".
- Bottom Bar:** Displays "Calisma Seçimi : MANUEL / Aktif Program ABCDEFGHIJKLMNOP".



# 1.4.2. DİKİŞ

1. Ön kol hızıdır.
2. Arka kol hızıdır.
3. Makine kafa hızıdır.
4. Üst üste dikiş hızıdır.

The image shows the control panel of an ASTAS JUKI ETEK OTOMATI sewing machine. The panel is divided into several sections. At the top, there is a blue header with the machine name and the date/time. Below this, there is a central display area with a list of settings and their values. On the left side, there are buttons for 'Ana Menu', 'Sayac Reset', and 'İs Sayacı'. On the right side, there are buttons for 'Dikiş Başı', 'Dikiş', 'Dikiş Sonu', and 'Dikiş Dur'. At the bottom, there is a blue bar with the current mode and program information.

Setting	Value
Ön Kol Hızı	23456
Arka Kol Hızı	23456
Makina Hızı	56 3456
Dikiş Bindirme Hızı	+ Pasif 56
Merdane Hız %	3456
Disli İceri Disari Hız	İceri: 3456, Disari: 3456

Calisma Seçimi : MANUEL / Aktif Program ABCDEFGH I JKLMNOPQR

# 1.4.3. DİKİŞ SONU

1. Dikiş bitiminde üst üste gelecek dikiş adımıdır.
2. Dikiş bitiminde durması için gerekli dur zamanıdır.
3. Dikiş bitiminde kumaşı istiflemeye gönderme süresidir.
4. İstifleme dayamasının istifleme tablasına taşıma süresidir.

**ASTAS JUKI ETEK OTOMATI** 12.07.19 14:40

Dikiş

Ana Menu	1	Dikiş Bindirme Adımı	23456
	2	Steplerin Devreye Girme Zmn	123456
	3	Tokatlama zmn	23456
	4	İstifleme Tokatlama Zmn +	123456
Sayac Reset			
İs Sayacı			
123456			
		İçeri	Dışarı
		3456	3456

Disli İçeri Disari Hz

Calisma Seçimi : MANUEL / Aktif Program ABCDEFGHI JKLMNOPQR

Dikiş Başı

Dikiş

Dikiş Sonu

Dikiş Dur

# 1.5. KONTROL SAYFASI



- Makinede çalışan tüm ekipmanların açık/kapalı olduğunun takip edildiği bölümdür.

**ASTAS JUKI ETEK OTOMATI** 12.07.19 14:35

Giriş / Çıkışlar

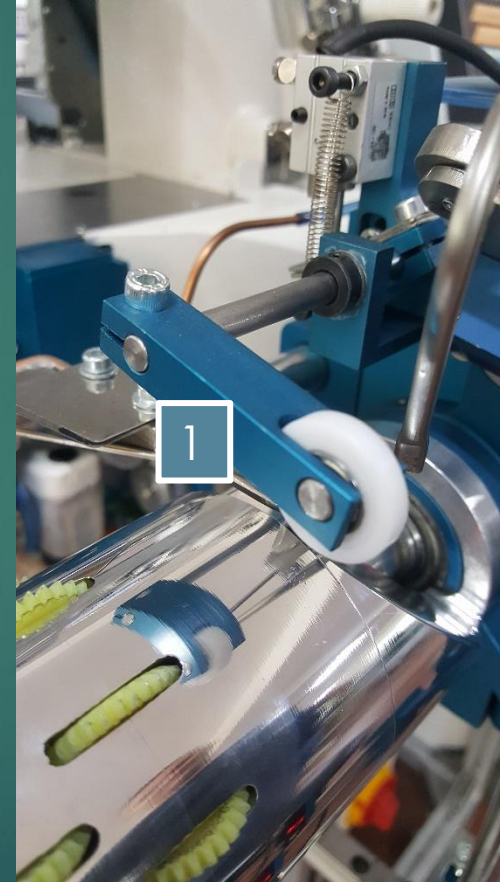
<input checked="" type="checkbox"/> Encoder A	<input checked="" type="checkbox"/> Kenar Kontrol Pul	<input checked="" type="checkbox"/> İstifleme Tokatlama
<input checked="" type="checkbox"/> Bıçak Sw	<input checked="" type="checkbox"/> Açıcı Puls	<input checked="" type="checkbox"/> İstifleme Tabla Valfi
<input checked="" type="checkbox"/> İğne Yukarıda	<input checked="" type="checkbox"/> Sarıcı Puls	<input checked="" type="checkbox"/> Vakum
<input checked="" type="checkbox"/> Üst Sensor	<input checked="" type="checkbox"/> Merdane Pu	<input checked="" type="checkbox"/> Apar Pist
<input checked="" type="checkbox"/> Orta Sensor	<input checked="" type="checkbox"/> Kenar Kontrol Yön	<input checked="" type="checkbox"/> Üfleme
<input checked="" type="checkbox"/> Alt Sensor	<input checked="" type="checkbox"/> Gergi Kol Puls	<input checked="" type="checkbox"/> Merdane Piston Valfi
<input checked="" type="checkbox"/> Dikis kontrol Sw	<input checked="" type="checkbox"/> Rezerve	<input checked="" type="checkbox"/> Pedal Role
<input checked="" type="checkbox"/> Acil Stop	<input checked="" type="checkbox"/> Gergi Kol Yön	<input checked="" type="checkbox"/> Bıçak Sinyal 1
<input checked="" type="checkbox"/> İp kontrol Sw	<input checked="" type="checkbox"/> Üfleme :	
<input checked="" type="checkbox"/> Ayak Kaldırma	<input checked="" type="checkbox"/> Gerdirme Kolu	
<input checked="" type="checkbox"/> Gergi Home Sw	<input checked="" type="checkbox"/> Tokatlam	
	<input checked="" type="checkbox"/> Ayak Kaldırma	

Calisma Seçimi : MANUEL / Aktif Program ABCDEFGH I JKLMNOPQR

## 2. YAN DİKİŞ VE 1.SENSÖR



1. Dikiş başlangıç noktasını ayarlamaktadır. Kalın kumaş gelince yukarı kalkar, makine adım sayar ve dikiş başlatır.
2. Kumaş hazırlama esnasında makine adımını sayar ve dikiş başlatır.



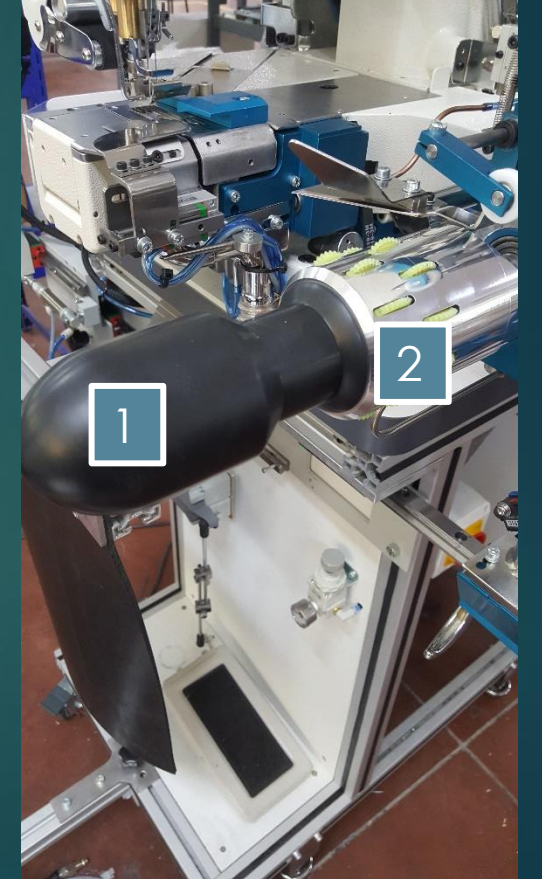
# 3. 2.SENSÖR VE 3.SENSÖR

1. Dikişin sonuna yaklaşılrken 1.sensörü kapatıp 3.sensörü aktive etmektedir.
2. İş başlangıç dikişi ve iş bitiş dikişini üst üste gelmesini sağlamaktadır.



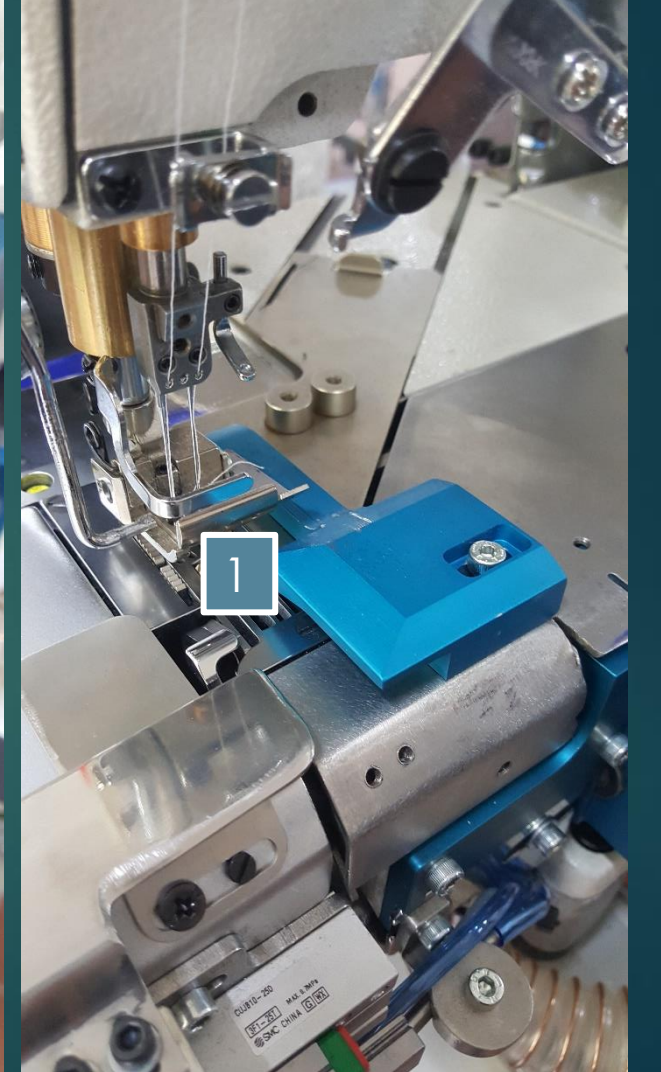
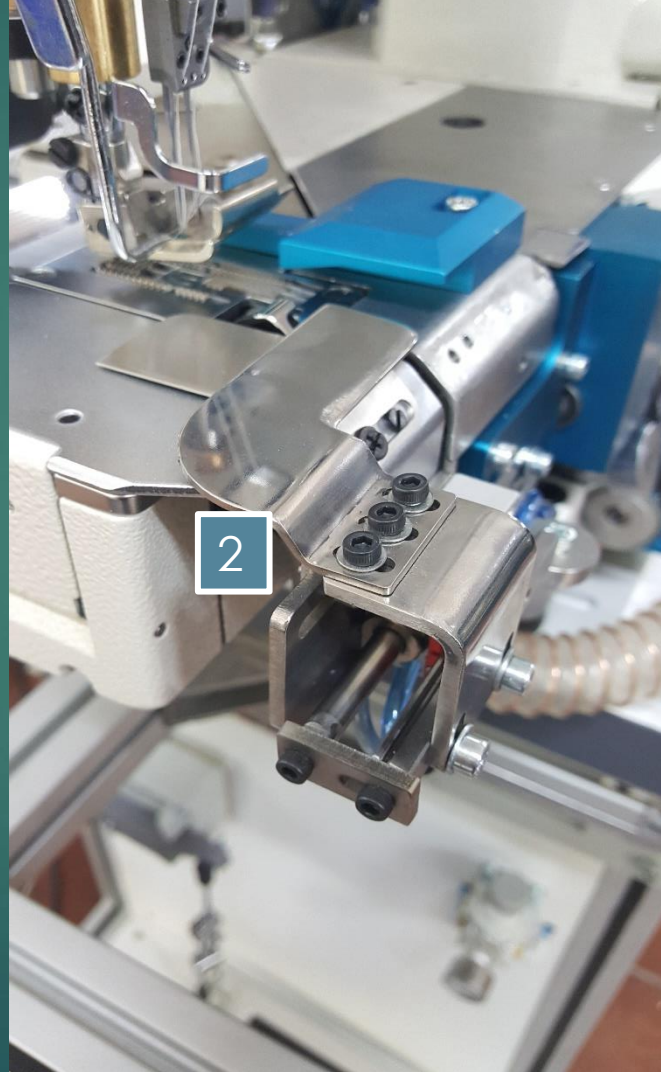
# 4. ÖN VE ARKA KOL

1. Dikilecek kumaşı sabit şekilde tutup çevirmek için kullanılır.
2. Aynı zamanda dişliler sayesinde kolay hareket etmesini engeller.
3. İstenilen uzunluk ve dikiş mesafeleri panelin otomatik dikiş bölümünden ayarlanabilmektedir. Extra durumlarda farklı ölçülere getirilebilir.



# 5. SINIRLANDIRMA

1. Sınırlandırma, dikmek istenilen ürünün dikiş ölçüsü ayarlanır.
2. Dikiş esnasında bedenin daha stabil kalması için çalışan gruptur.



# 6. İSTİFLEME DAYAMASI

- Biten nihai ürünü ileriye doğru iterek istifleme tablalarına bırakır.





# 7. ARKA ÇEKTİRME

- Dikişin başından itibaren kumaşa yön vererek daha stabil kumaş dikişi başlangıcı yaptırmak için kullanılır.



# 8. ACİL STOP BUTONU

- ▶ Sistemi komple durdurmaktadır.



# 9. AÇ/KAPA BUTONU



- Makineyi komple kapatıp açma butonudur.



# 10. KUMAŞ TOKATLAMA

- Dikiş bittikten sonra istifleme yapılması için ileriye iten mekanizmadır.

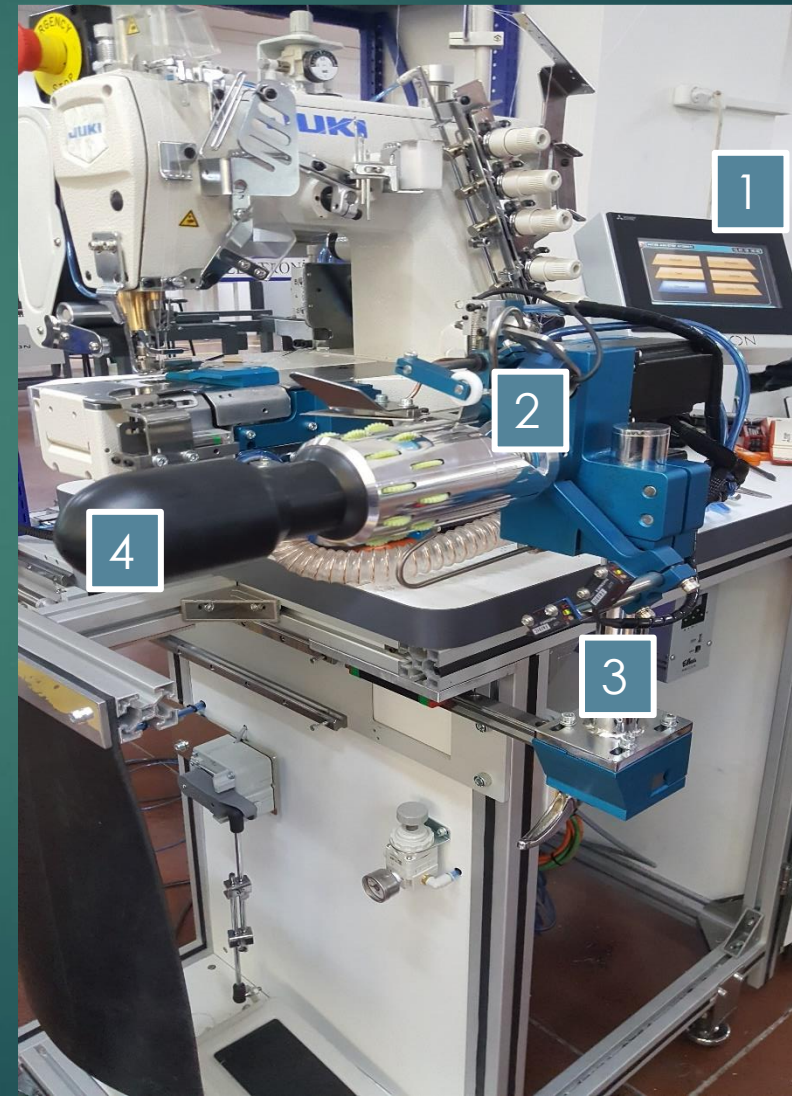
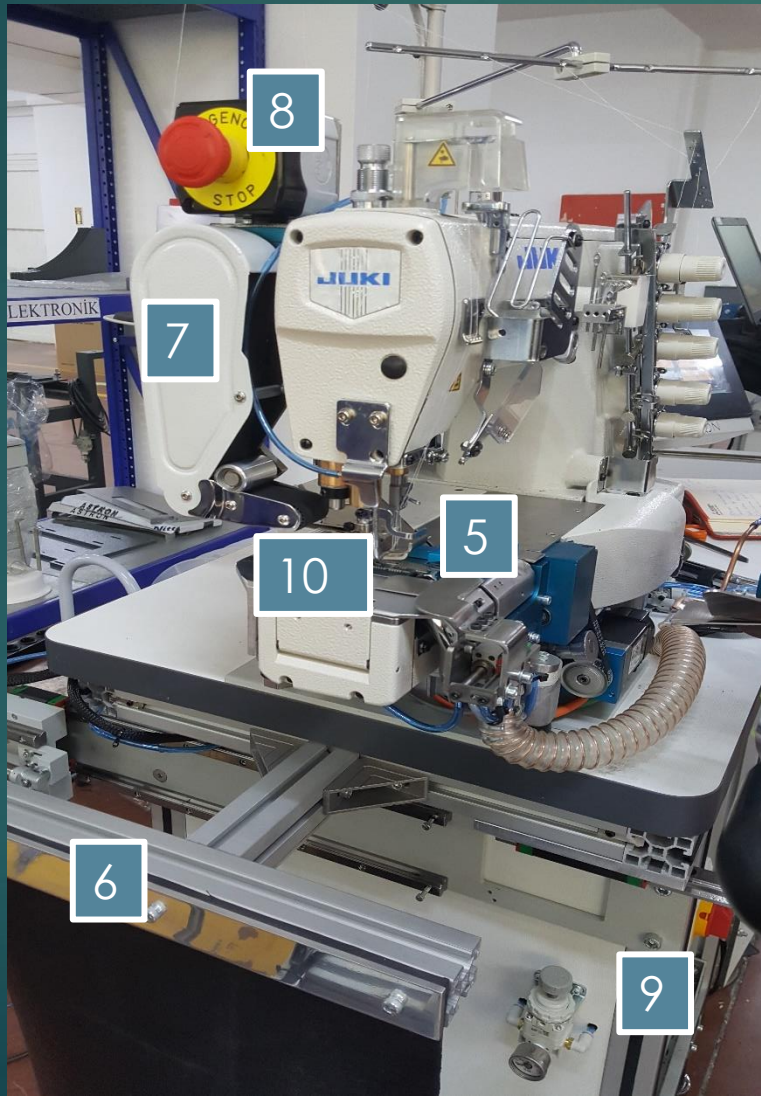


# 11. İSTİFLEME ÜNİTESİ

- ▶ Üst tablada dikilecek ürünler bulunur.
- ▶ Alt tablada ise bitmiş nihai ürünler bulunur.
- ▶ İstifleme dayaması alt tablaya işleri istifleyerek bırakır.



# MACHINE IMAGES



# 1. HOME PAGE



The screenshot displays the home page of the ASTRON BOTTOM HEMMER control system. At the top, a blue header bar contains the text "ASTRON BOTTOM HEMMER" on the left and the date and time "12.07.19 15:36" on the right. Below the header, a central area with a black background features six orange, trapezoidal buttons arranged in two columns. The left column contains buttons labeled "1 Manuel", "3 Test", and "4 Automatic Mode". The right column contains buttons labeled "2 Models", "Settings", and "5 Input / Output". A small white plus sign is positioned between the "Test" and "Settings" buttons. At the bottom of the interface, a blue status bar shows "Running Selection : MANUEL / Active Program" followed by a sequence of letters "A.BCDEFGH I JKLMNOPQR".

ASTRON BOTTOM HEMMER 12.07.19 15:36

1 Manuel 2 Models

3 Test + Settings

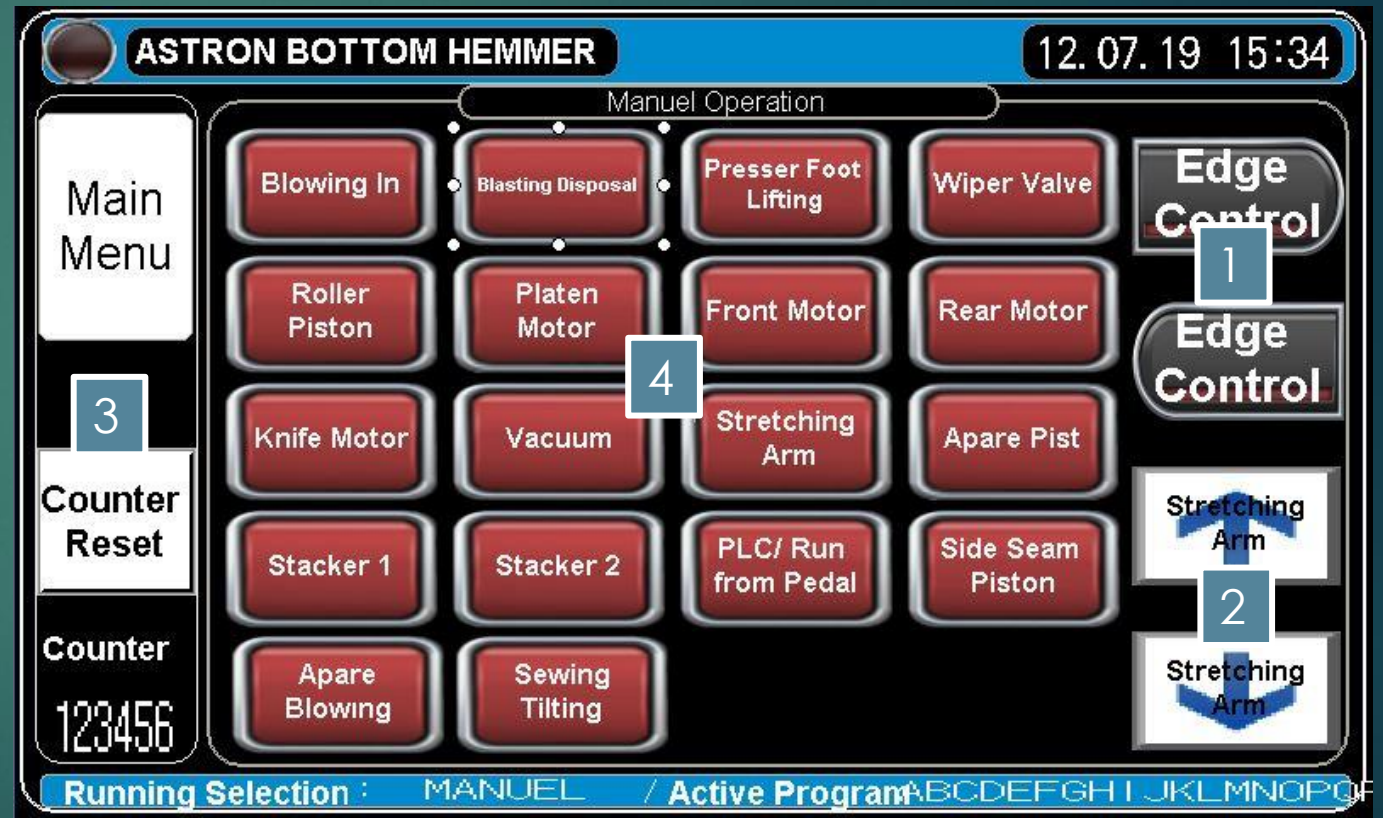
4 Automatic Mode 5 Input / Output

Running Selection : MANUEL / Active Program A.BCDEFGH I JKLMNOPQR

# 1.1.MANUEL STITCH PAGE



1. Stitch thickness is adjusted.
2. Size is adjusted.
3. It is the button to reset the jobs.
4. These are the manual buttons of sewing operations.





# 1.2.PROGRAM PAGE



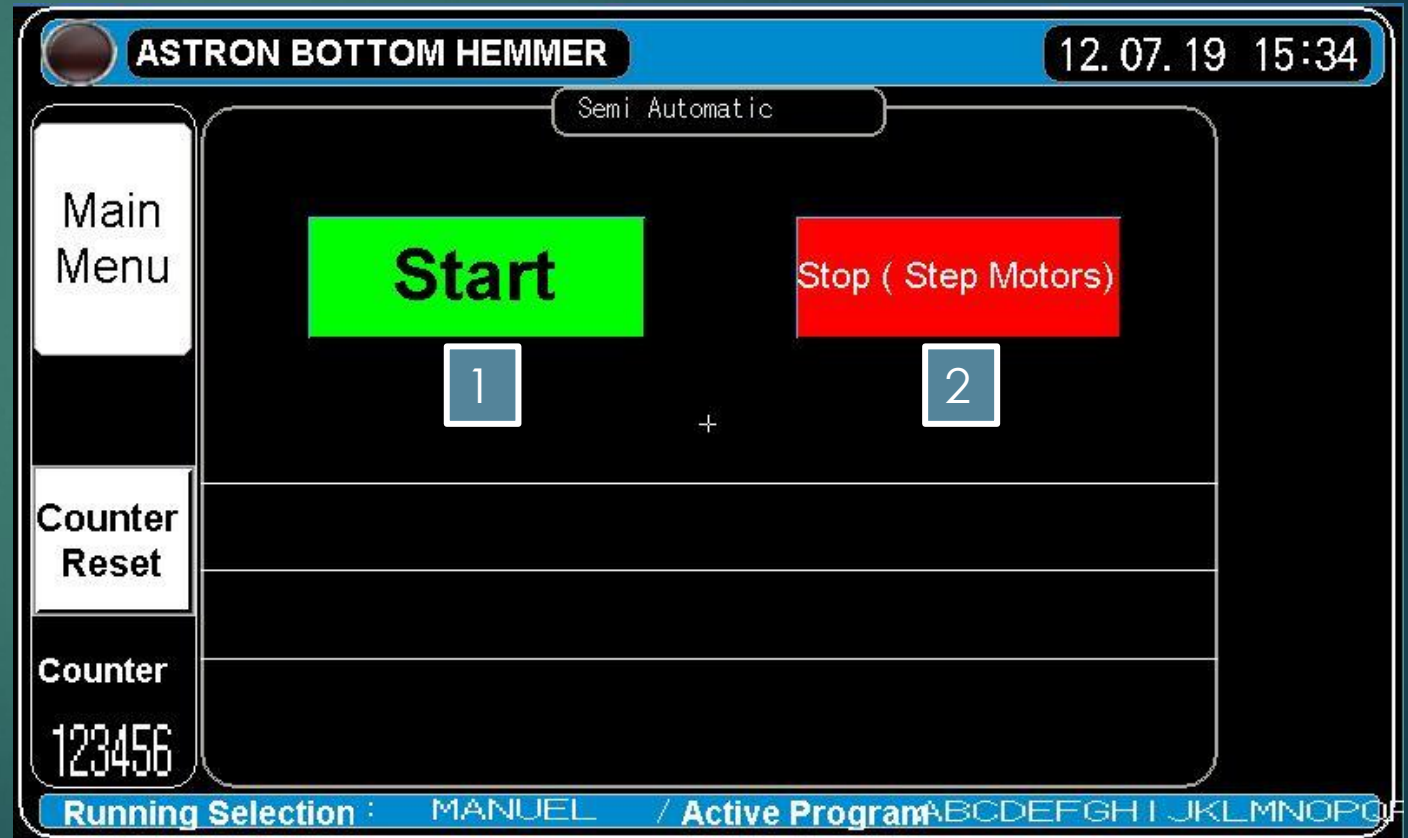
1. Counter reset button.
2. Program which saved before
3. To select saved program and copy.
4. Actual program and copying.

The screenshot shows the control panel for the ASTRON BOTTOM HEMMER. At the top, it displays the machine name and the date/time (12.07.19 15:35). Below this is a 'Program Sayfasi' (Program Page) section with a grid of 10 program slots, each containing a yellow square and the text 'ABCDEFGHI JKLMNOPQRST'. A blue box with the number '2' highlights the second slot. On the left side, there is a 'Main Menu' button and a 'Counter Reset' button with a blue box containing the number '1'. Below these is a 'Counter' display showing '123456'. At the bottom, there are three buttons: 'Selected Program' (with a down arrow), 'Select Program' (with an up arrow and a blue box containing '4'), and 'Program Reset'. A yellow button labeled 'SELECT PROGRAM' has a blue box with '3' on it. A red button labeled 'FAC. SETTING DOWNLOAD' is also present. At the very bottom, a status bar shows 'Running Selection : MANUEL / Active Program ABCDEFGHI JKLMNOPQRST'.

# 1.3.TEST PAGE



- ▶ The machine is started and the manual mode is entered where necessary adjustments are made.
- 1. If any error is encountered, the machine stops the steppes and prevents the settings from being corrupted until then.



# 1.4. AUTOMATIC STITCH PAGE



**ASTRON BOTTOM HEMMER** 12.07.19 15:36

Start Of Sewing

Idle Running Time	3456
Idle Running Speed	23456
Stitch Length	456.0
Start Of Sewing	345.6
Strechter Arm	3456
Roller Speed	3456
Gear In-Out Speed	3456 3456
Selection of Side	Side Seam OFF

SEWING START

Main Menu  
Counter Reset  
Counter 123456

Sewing Start  
Sewing  
End Of Sewing  
End of Sewing

Running Selection : MANUEL / Active Program: ABCDEFGHIJKLMNOPQR

**ASTRON BOTTOM HEMMER** 12.07.19 15:36

Sewing

Front Arm Speed	23456
Rear Arm Speed	23456
Machine Speed	3456
Overlap of Stitch Speed	36
Puller Speed %	3456
Gear In-Out Speed	3456 3456

SEWING

Main Menu  
Counter Reset  
Counter 123456

Sewing Start  
Sewing  
End Of Sewing  
End of Sewing

Running Selection : MANUEL / Active Program: ABCDEFGHIJKLMNOPQR

**ASTRON BOTTOM HEMMER** 12.07.19 15:37

End Of

Overlap of Stitch Length	23456
Running-Up Time of Step Motors	123456
Wiper Time	23456
Stacker Wiper Time	123456
Gear In-Out Speed	3456 3456

END OF SEWING

Main Menu  
Counter Reset  
Counter 123456

Sewing Start  
Sewing  
End Of Sewing  
End of Sewing

Running Selection : MANUEL / Active Program: ABCDEFGHIJKLMNOPQR



# 1.4.1. SEWING START PAGE

1. It is activated when button 8 is pressed. Idle rotation time is set for side stitching.
2. The idle speed of the front and rear arm.
3. The machine is the sewing step.
4. Sewing is the initial step.
5. The body length of the forearm and reararm.
6. Roller rotation speed.
7. The speed of the gears which is for limiting the movement of the material.

**ASTRON BOTTOM HEMMER**
12.07.19 15:36

Start Of Sewing

Main Menu	1	Idle Running Time	3456
	2	Idle Running Speed	23456
	3	Stitch Length	456.0
	4	Start Of Sewing	345.6
Counter Reset	5	Strecther Arm	3456
	6	Roller Speed	3456
Counter 123456	7	Gear In-Out Speed	3456 3456
	8	Selection of Side	Side Seam OFF

Sewing Start

Sewing

End Of Sewing

End of Sewing

Running Selection : MANUEL / Active Program ABCDEFGHI JKLMNOPQ

# 1.4.2. SEWING PAGE



1. Front arm speed.
2. Rear arm speed.
3. Machine head speed.
4. Overlapping stitch speed.

The screenshot shows the sewing machine's control panel in 'SEWING' mode. The top bar displays 'ASTRON BOTTOM HEMMER' and the date/time '12.07.19 15:36'. The main display area is divided into several sections:

- Main Menu:** A vertical list of four items, each with a numbered button (1-4) to its left:
  - 1 Front Arm Speed: 23456
  - 2 Rear Arm Speed: 23456
  - 3 Machine Speed: 56 3456
  - 4 Overlap of Stitch Speed: **Passive** 56
- Counter Reset:** A button on the left side of the main display area.
- Counter:** A digital display showing '123456'.
- Speed Settings:** A section at the bottom of the main display area showing 'Puller Speed %' at 3456 and 'Gear In-Out Speed' at 3456 and 3456.
- Control Buttons:** A vertical column of buttons on the right side:
  - Sewing Start
  - Sewing
  - End Of Sewing
  - End of Sewing (highlighted in red)
- Running Selection:** A bar at the bottom showing 'MANUEL' and 'Active Program' followed by a sequence of letters 'ABCDEFGHIJKLMNOR'.



# 1.4.3. END OF SEWING PAGE

1. It is the sewing step that will overlap at the end of sewing.
2. It is the stop time required to stop at the end of sewing.
3. It is the time to send the fabric to stacking at the end of sewing.
4. The time it takes the stacker to move to the stacking table.

**ASTRON BOTTOM HEMMER** 12.07.19 15:37

End Of

Main Menu	1	Overlap of Stitch Length	23456
	2	Running-Up Time of Step Motors	123456
	3	Wiper Time	23456
	4	Stacker Wiper Time +	123456
Counter Reset			
Counter			123456
		Gear In-Out Speed	3456 3456

Running Selection : MANUEL / Active Program: ABCDEFGHI JKLMNOPQR

Buttons: Sewing Start, Sewing, End Of Sewing, End of Sewing

# 1.5. CONTROL PAGE



1. It is the section where all the equipment working on the machine is monitored on / off.

**ASTRON BOTTOM HEMMER** 12.07.19 15:32

Input / Output

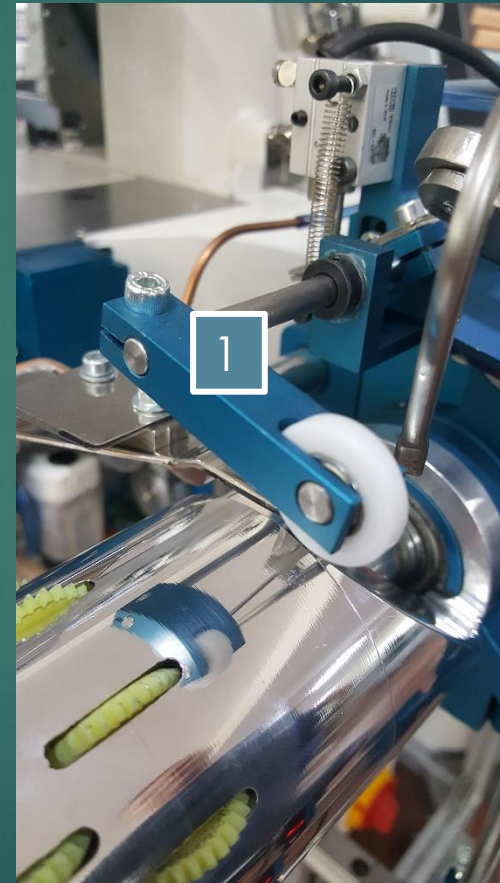
<b>Main Menu</b>	<input type="checkbox"/> Input	<input type="checkbox"/> Edge Control Puls	<input type="checkbox"/> Stacking Swing Valve
<b>Counter Reset</b>	<input type="checkbox"/> Encoder	<input type="checkbox"/> Opener Pulse	<input type="checkbox"/> Stacking Table Valve
<b>Counter</b>	<input type="checkbox"/> Needle Up	<input type="checkbox"/> Wrapper Pulse	<input type="checkbox"/> Vacuum
123456	<input type="checkbox"/> Up Sensor ( Right)	<input type="checkbox"/> Roller Pulse	<input type="checkbox"/> Aparent Pist
	<input type="checkbox"/> Middle Sensor ( Middle)	<input type="checkbox"/> Direction of Edge Contr	<input type="checkbox"/> Blowing In
	<input type="checkbox"/> Down Sensor ( Left)	<input type="checkbox"/> Stretch Arm Puls	<input type="checkbox"/> Roller Piston Valve
	<input type="checkbox"/> Signal of Presser Foot Lifter	<input checked="" type="checkbox"/> Rezerve	<input type="checkbox"/> Pedal Role
	<input type="checkbox"/> Emergency Stop	<input type="checkbox"/> Stretch Arm Direct	<input type="checkbox"/> Knife Signal 1
	<input type="checkbox"/> Thread Break Sensor	<input type="checkbox"/> Blower 2	
	<input type="checkbox"/> Presser Foot Lifting	<input type="checkbox"/> Strethter Arm	
	<input type="checkbox"/> Stretch Arm Home Sensor	<input type="checkbox"/> Wiper	
		<input type="checkbox"/> Presser Foot Lifting	

Running Selection : MANUEL / Active Program ABCDEFGH I JKLMNOPQ R

## 2. SIDE SEWING AND 1.SENSOR



1. Sets the sewing start point. When the thick fabric comes up, the side seam dedector steps up and starts sewing.
2. During preparation, the machine counts the step and starts sewing.





# 3. 2.SENSOR AND 3.SENSOR

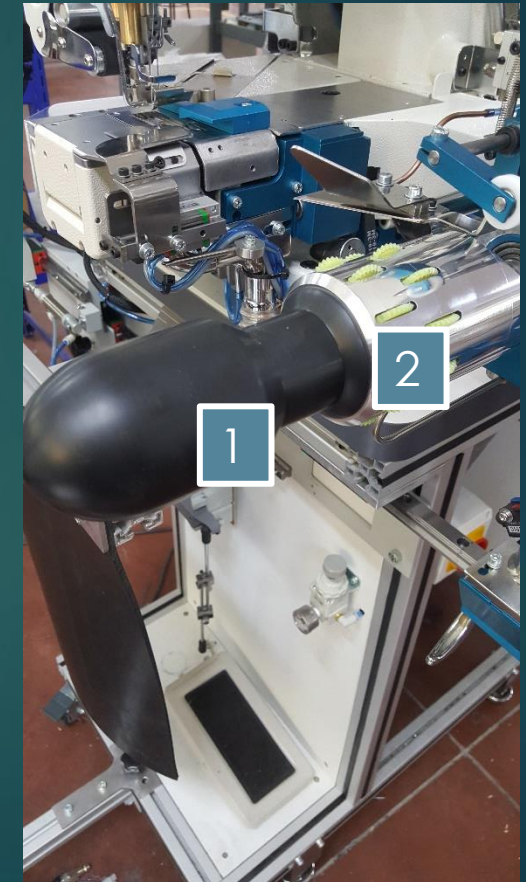


1. When approaching the end of the sewing, it closes the sensor 1 and activates the sensor 3.
2. It ensures that the start sewing and end sewing are overlapped.



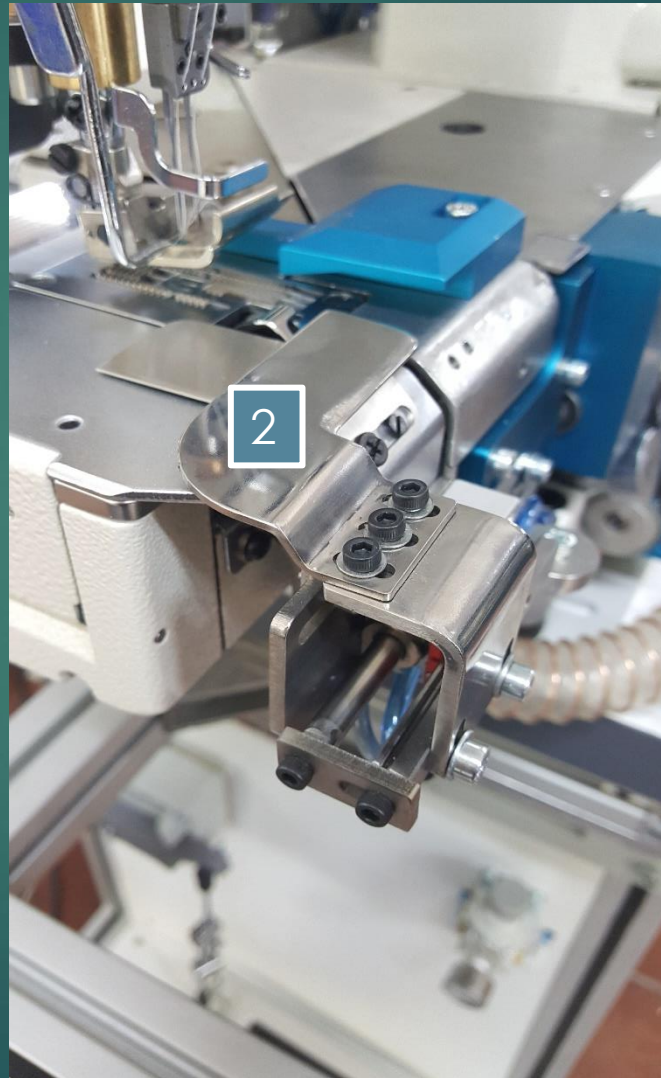
# 4. FRONT AND REAR ARM

1. It is used to hold and turn the fabric to be sewn.
2. At the same time, it provides stability of fabric by means of gears.
3. Desired lengths and sewing distances can be adjusted from the automatic sewing section of the panel. Extra cases can be brought to different sizes.



# 5. DELIMITATION

1. Limiting, sewing size of the product to be sewn is set.
2. It is the group that works to keep the body more stable during sewing.



# 6. STACKING ARM

- ▶ It pushes the finished product forward and leaves it on the stacking trays.



# 7. REAR PULLING

- ▶ It is used to direct the fabric from the beginning of sewing to make the beginning of stitching more stable.



# 8. EMERGENCY STOP BUTTON



- ▶ It stops the system completely.



# 9. ON/OFF BUTTON

- ▶ It is the button to turn the machine off and on completely.



# 10. FABRIC WIPING

- ▶ It is the mechanism that pushes forward for stacking after sewing is finished.





# 11. STACKER UNIT

- ▶ There are products to be sewn in the upper table.
- ▶ The lower tray contains finished finished products.
- ▶ The stacking gauge leaves the bottom table stacked.
- ▶ Hay productos para coser en la mesa superior.
- ▶ La bandeja inferior contiene productos terminados.
- ▶ El medidor de apilamiento deja la mesa inferior apilada.

