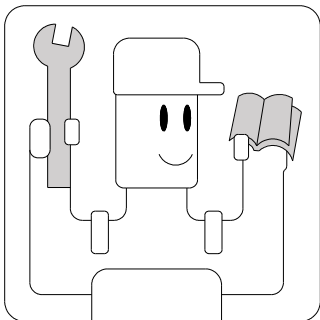
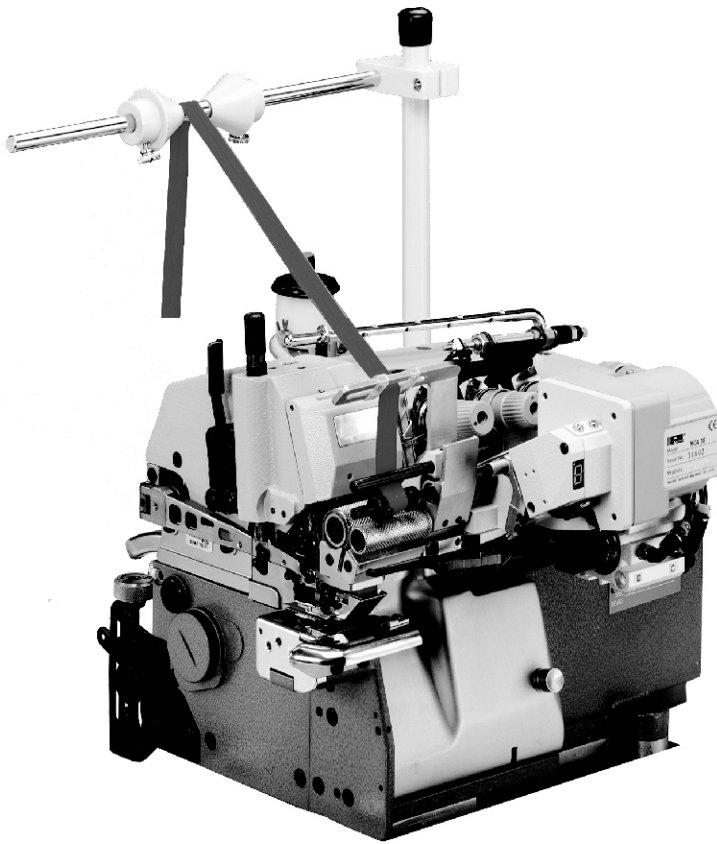


MCA 18K<sup>-38</sup><sub>-64</sub> /TR

**RACING**<sup>®</sup>  
NO.MCA18K-02-19

# 電子送帶機安裝手冊

## THE INSTALLATION GUIDE BOOK



- 安裝前，請詳細閱讀安裝說明書
- PLEASE READ INSTRUCTIONS & ASSOCIATED DRAWINGS BEFORE INSTALLATION

# 目 錄

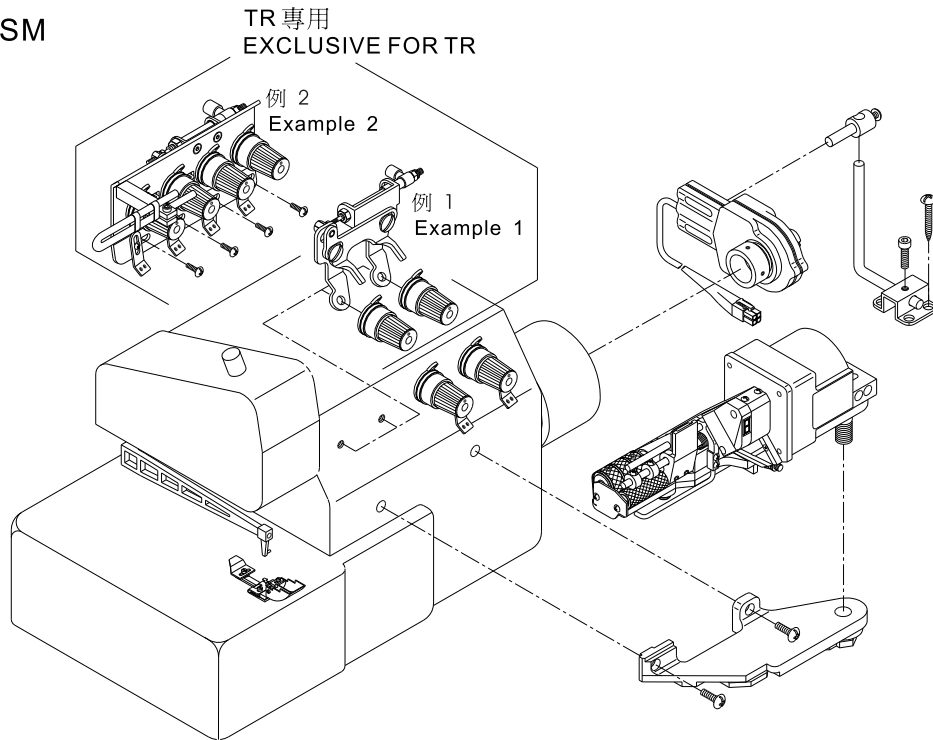
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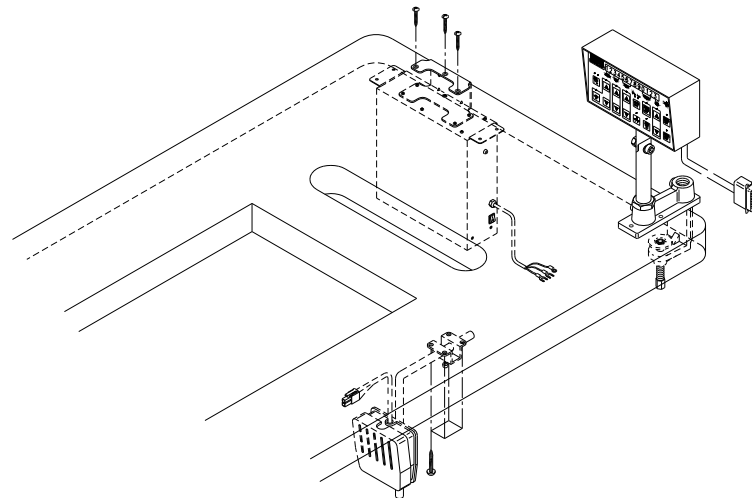
# MCA 18K<sup>-38</sup>/<sub>-64</sub> /TR 組合圖

## THE COMBINATION OF MCA 18K<sup>-38</sup>/<sub>-64</sub> /TR

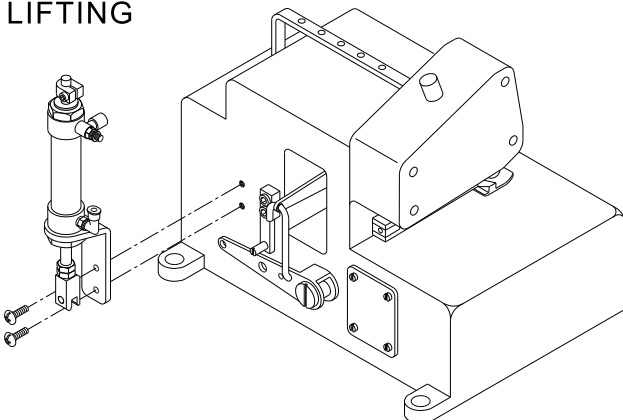
### 主機組 MAIN MECHANISM



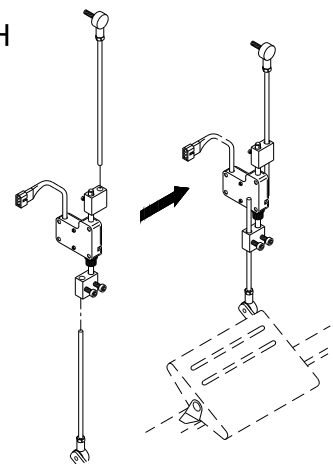
### 控制組 CONTROL BOX



### 壓腳提升組 ACCESSORIES FOR PRESSER FOOT LIFTING

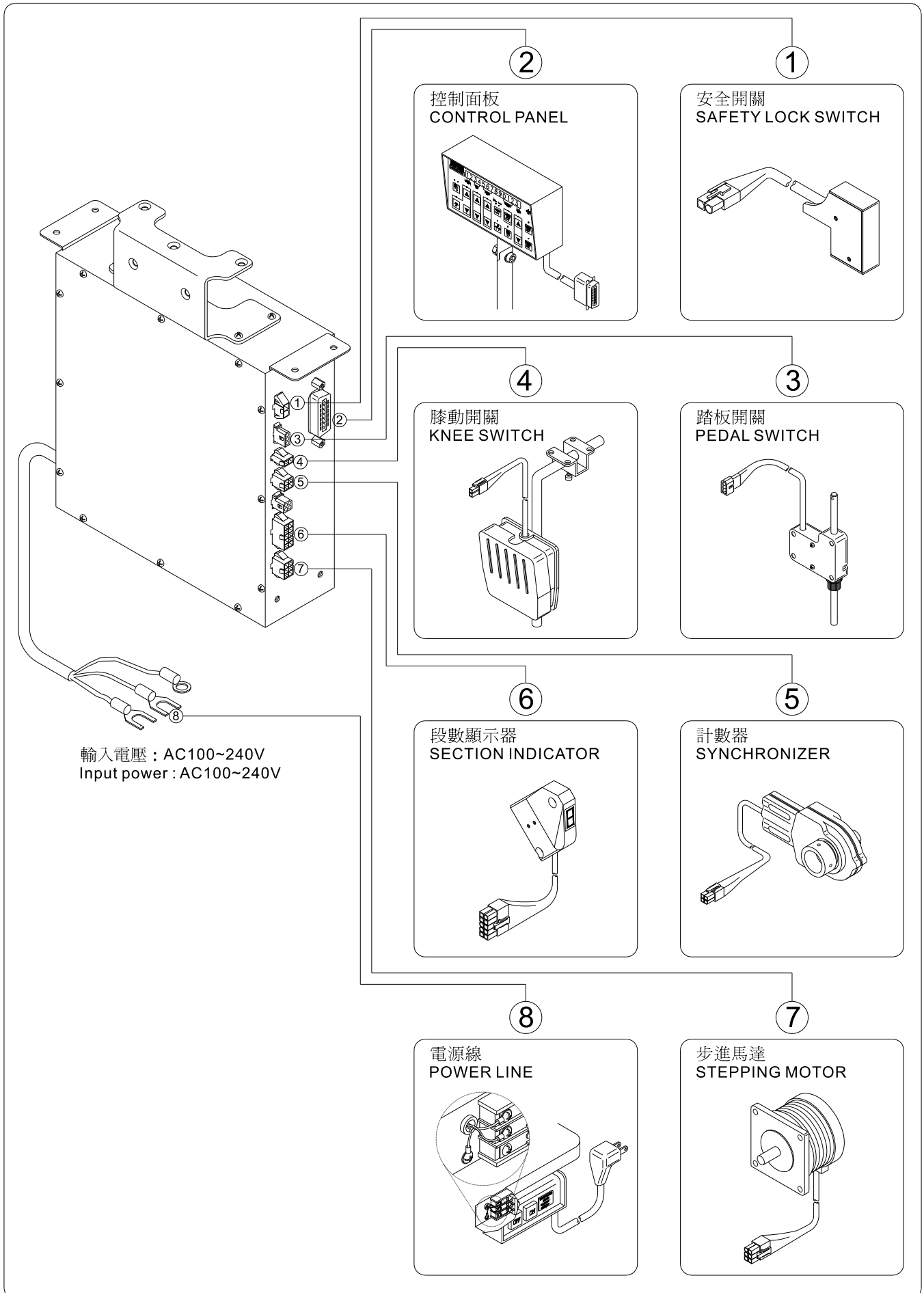


### 踏板開關 PEDAL SWITCH



# MCA 18K<sup>-38</sup>/<sub>-64</sub> /TR 接線圖

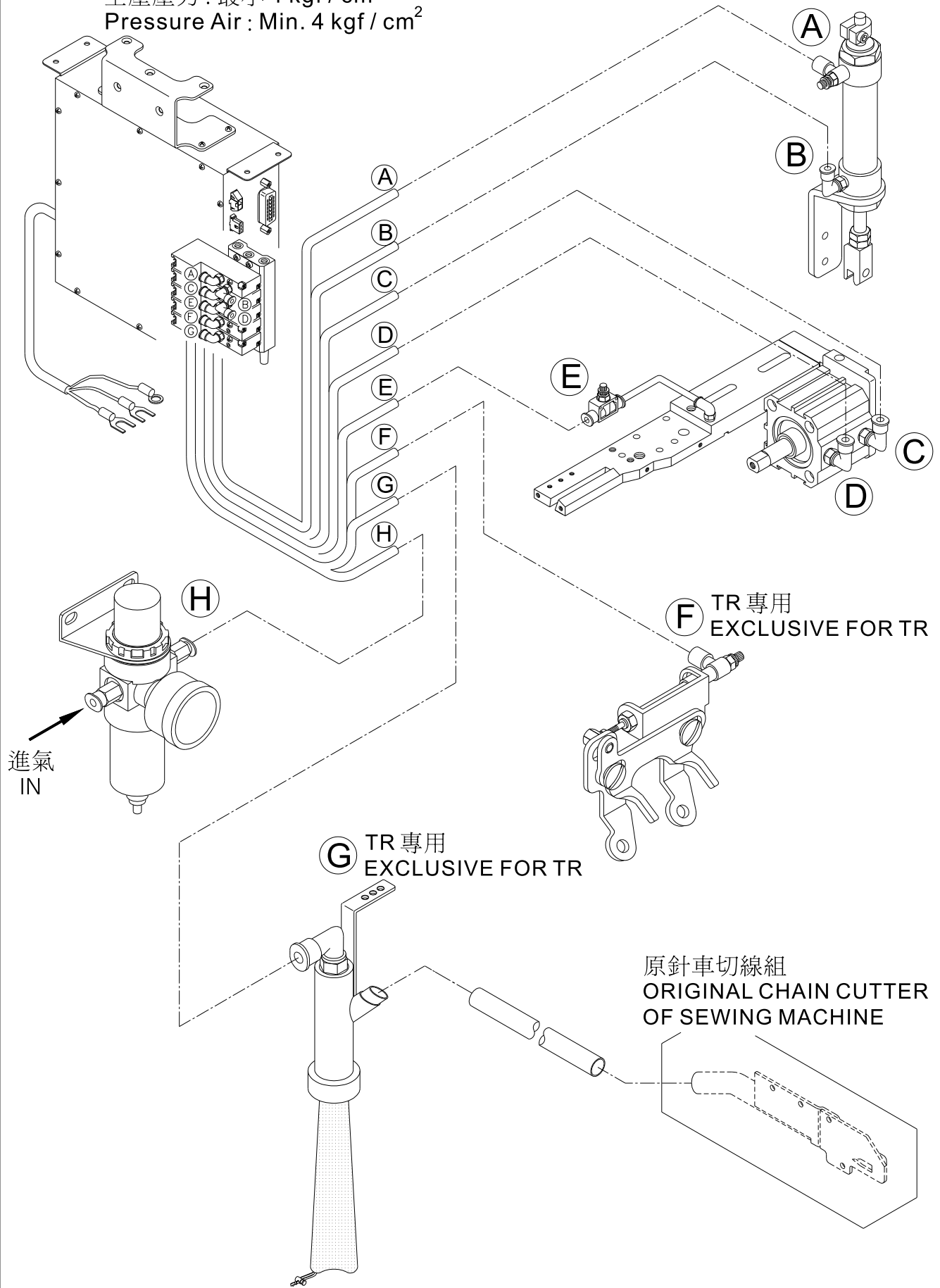
## WIRING DIAGRAM FOR MCA 18K<sup>-38</sup>/<sub>-64</sub> /TR



# MCA 18K<sup>-38</sup>/<sub>-64</sub> /TR 管路圖

## AIR HOSE PLUG DIAGRAM FOR MCA 18K<sup>-38</sup>/<sub>-64</sub> /TR

空壓壓力：最小 4 kgf / cm<sup>2</sup>  
 Pressure Air : Min. 4 kgf / cm<sup>2</sup>



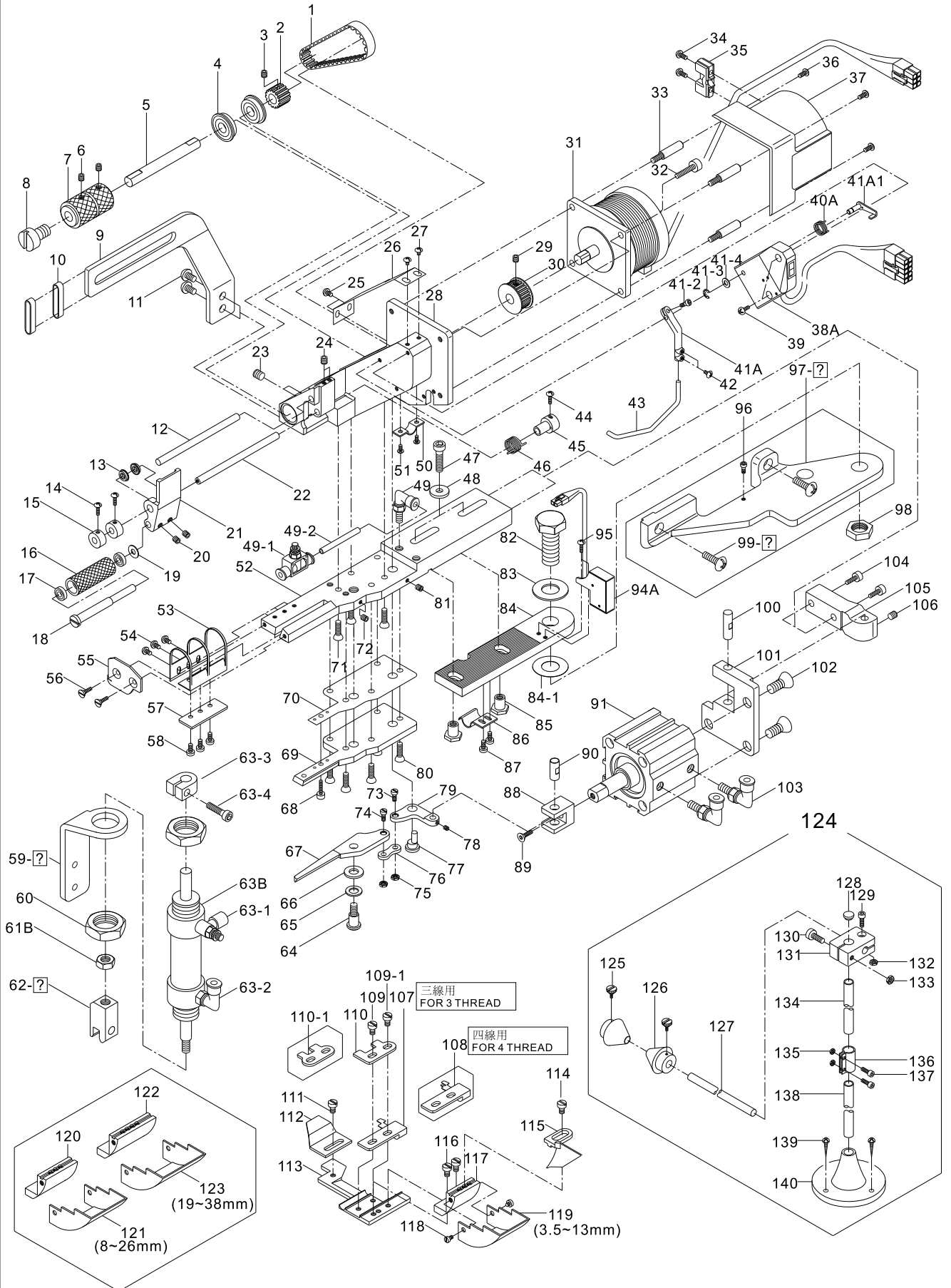
# MCA 18K<sup>-38</sup>/<sub>-64</sub> 零件圖

## PARTS LIST FOR MCA 18K<sup>-38</sup>/<sub>-64</sub>

記號說明：  
Mark description：

選擇性配件  
Optional parts

☐ 選擇性配件，請告知針車廠牌機型  
Optional parts, please indicate sewing machine model no.



圖號 Fig. No.	電腦編號 Computer Code	中文名稱 Description	英文名稱 Description	數量 Q'ty
1	D7100C0800	皮帶 100MXL 8mm	Belt 100MXL 8mm	1
2	C218K00200	主軸齒輪 MXL25T	Timing gear MXL25T	1
3	D2M0407004E6	螺絲M4×4 止付內六角	Screw M4×4	1
4	D6F0814040	培林LF-1480ZZ	Bearing LF-1480ZZ	2
5	C318K00500	主軸φ8×89	Main roller shaft φ8×89	1
6	D2M0407003E6	螺絲M4×3 止付內六角	Screw M4×3	2
7	E618K00700	主輪	Main roller	1
8	D218K00800	主輪塞螺	Main roller screw	1
9	E618K00900	導帶架(短)	Tape guide (short)	1
10	C8S6-01900	擋帶膠管(小)	Rubber stopper (small)	2
11	D2M0407008B3	螺絲M4×8半圓頭 一字一字	Screw M4×8	2
12	C318K01200	引布軸	Stud	1
13	D6F0510040	培林LF-1050×2ZZ	Bearing LF-1050×2ZZ	2
14	D2W3540005B3	螺絲9/64"×40W×3/16"半圓頭	Screw 9/64"×40W×3/16"	2
15	E618K01500	擋帶套筒φ12×φ6×6	Collar φ12×φ6×6	2
16	E618K01600	副輪(短)	Auxiliary roller (short)	1
17	D6L0711030	培林L-1170ZZ	Bearing L-1170ZZ	2
18	C318K01800	副輪軸(短)	Auxiliary roller shaft (short)	1
19	D418K01900	副輪華司5.1×7×0.6(銅)	Washer 5.1×7×0.6(brass)	1
20	D2M0407004E6	螺絲M4×4 止付內六角	Screw M4×4	2
21	E618K02100	壓板	Aux. roller release lever	1
22	C318K02200	壓板軸	Release lever stud	1
23	D2M0407004E6	螺絲M4×4 止付內六角	Screw M4×4	2
24	D2M0407004E6	螺絲M4×4 止付內六角	Screw M4×4	2
25	D2M0305006B3	螺絲M3×6半圓頭 一字一字	Screw M3×6	2
26	C118K02600	皮帶蓋	Belt cover	1
27	D2M0305006B3	螺絲M3×6半圓頭 一字一字	Screw M3×6	2
28	E618K02800	主輪架	Roller base	1
29	D2M0407004E6	螺絲M4×4 止付內六角	Screw M4×4	1
30	C218K03000	馬達齒輪 MXL34T	Motor gear MXL34T	1
31	C518K03100	馬達	Motor	1
32	D2M0407010A6	螺絲M4×10方頭內六角	Screw M4×10	1
33	D218K03300	馬達螺絲	Motor screw	3
34	D2M0305012B3	螺絲M3×12半圓頭十字一字	Screw M3×12	2
35	C818K03500	馬達線蓋	Wire cover for motor	1
36	D2M0305006B3	螺絲M3×6半圓頭十字一字	Screw M3×6	3
37	C818K037A0-K	馬達蓋-MCA18K	Motor cover	1
38A	E618K038A0	新指示燈組(全組)	Section indicator led	1
39	D2M0305012B3	螺絲M3×12半圓頭十字一字	Screw M3×12	2
40A	C418K040A0	換段旋簧(新)	Section changing spring	1
41A	E618K041A0	換段架(新)	Section changing link	1
41A1	E618K041A1	換段軸(新)	Section changing shaft	1
41-2	D4G-110503	紅紙板 11x5x0.25t	Red ring 11x5x0.25t	1
41-3	D5ETW04-00	E型止輪 4mm	E Type stopper 4mm	1
41-4	D2M0305008A6	螺絲M3×8方頭內六角	Screw M3×8	1
42	D218K06800	螺絲M3×5平頭 一字	Screw M3×5	2
43	E618K04300	換段桿	Section changing lever	1
44	D2M0407004E6	螺絲M4×4 止付內六角	Screw M4×4	1
45	E618K04500	調節座	Tension adjusting collar	1
46	C460K01600	彈簧1.4×8.2×6	Spring 1.4×8.2×6	1
47	D2M0508018A6	螺絲M5×18方頭內六角	Screw M5×18	2
48	D4A1100510	鐵平華司10×5×1.0	Washer 10×5×1.0	2

圖號 Fig. No.	電腦編號 Computer Code	中文名稱 Description	英文名稱 Description	數量 Q'ty
49	C518K04900	彎接頭SPL-4-M5	Elbow connection SPL-04-M5	1
49-1	C518K049-1	線上調速閥 X-JSU4	Speed adjusting valve X-JSU4	1
49-2	C5C1401000	空壓管φ2.5×4mm	Polyamide tubingφ2.5×4mm	1
50	E618K05000	主輪架電線扣	Wire fastener	1
51	D2M0305006B3	螺絲M3×6半圓頭十字一字	Screw M3×6	2
52	E618K05200	刀台	Knife base	1
53	E618K05300	主輪保護片	Roller finger protector	1
54	D2M0305005B3	螺絲M3×5半圓頭十字一字	Screw M3×5	3
55	E618K05500	刀具保護片(短)	Knife cover plate (short)	1
56	D2M0305006D6	螺絲M3×6沙拉頭內六角	Screw M3×6	2
57	E618K05700	主輪保護片固定片	Cover plate	1
58	D218K06800	螺絲M3×5平頭一字	Screw M3×5	3
59-?	請告知廠牌機型 PLEASE ADVISE BRAND & MODEL OF SEWING MACHINE	抬押腳氣缸架	Air cylinder bracket	1
60	D3M20152708A	螺母M20×1.5	Nut M20×1.5	2
61B	D3M08121306A	螺母M8	Nut M8	1
62-?	請告知廠牌機型 PLEASE ADVISE BRAND & MODEL OF SEWING MACHINE	氣缸桿頭	Air cylinder joint	1
63B	E618K0630B	氣缸 DKA20×25+MS(新)	Air cylinder DKA20×25+MS	1
63-1	C518K063-1	調速閥JSC-4-1/8PT-A	Pressure controller connection JSC-0401-A	1
63-2	C5PL-A1404	彎接頭管徑φ4，牙口1/8PT	Elbow connection SPL-04-01	1
63-3	E618K063-3	氣缸頂架	Air cylinder stopper	1
63-4	D2M0508014A6	螺絲M5×14方頭內六角	Screw M5×14	1
64	D218K06400	活動刀調整螺	Adjusting screw for moveable knife	1
65	D418K06600	皿型彈片DB-7(φ7.2×φ14×0.5)	Disc spring DB-7(φ7.2×φ14×0.5)	1
66	D4A1100510	鐵平華司10×5×1.0	Washer 10×5×1.0	1
67	E618K06700	活動刀(38mm)	Moveable knife, 38mm	1
68	D218K06800	螺絲M3×5平頭一字	Screw M3×5	1
69	E618K06900	固定刀(38mm)	Fixed knife, 38mm	1
70	E618K07000	固定刀墊片	Fixed knife Spacer	1
71	D2M0407012D6	螺絲M4×12沙拉頭內六角	Screw M4×12	3
72	D2M0407004E6	螺絲M4×4止付內六角	Screw M4×4	1
73	D218K07300	活動刀連桿螺絲	Link screw for moveable knife	1
74	D218K07300	活動刀連桿螺絲	Link screw for moveable knife	1
75	D3M05080804A	螺母M5	Nut M5	2
76	E618K07600	活動刀連桿	Moveable knife link	1
77	E618K07700	活動刀連桿調整軸	Movable knife link adjusting shaft	1
78	D2M0407004E6	螺絲M4×4止付內六角	Screw M4×4	1
79	E618K07900	活動刀連桿座	Moveable link base	1
80	D2M0407016D6	螺絲M4×16沙拉頭內六角	Screw M4×16	5
81	D2M0407004E6	螺絲M4×4止付內六角	Screw M4×4	1
82	D218K08200	主連架螺	Roller bracket screw	1
83	D418K08300	皿型彈片DB-10(φ20×φ10x1.0)	Disk spring DB-10(φ20×φ10x1.0)	1
84	E618K08400	下主連架	Bracket	1
84-1	D4H-251002	麥拉片華司φ25×φ10×0.2	Washer φ25×φ10×0.2	1
85	D318K08500	主連架調節螺母	Bracket nut	2
86	E618K08600	扣座彈片	Lock spring	1
87	D2M0407006A6	螺絲M4×6方頭內六角	Screw M4×6	2
88	E618K08800	切刀氣缸桿座	Knife cylinder pivot	1
89	D218K08900	螺絲M5×14沙拉頭內六角	Screw M5×14	1
90	E618K09000	切刀氣缸桿座軸	Knife cylinder pivot pin	1
91	E618K09100	切刀氣缸 JDA25×20	Knife cylinder JDA25×20	1




圖號 Fig. No.	電腦編號 Computer Code	中文名稱 Description	英文名稱 Description	數量 Q'ty
94A	E618K094A0	安全開關	Safety switch mounting bracket	1
95	D2M0407010B3	螺絲M4×10半圓頭十字一字	Screw M4×10	2
96	D2M0407008A6	螺絲M4×8方頭內六角	Screw M4×8	1
97-?	請告知廠牌機型 PLEASE ADVISE BRAND & MODEL OF SEWING MACHINE	固定架本體	Mounting bracket	1
98	D3W95241404A	螺母3/8"×24W	Nut 3/8"×24w	1
99-?	請告知廠牌機型 PLEASE ADVISE BRAND & MODEL OF SEWING MACHINE	固定架本體螺絲	Mounting bracket screw	2
100	E618K10000	切刀氣缸座軸	Knife cylinder base pivot shaft	1
101	E618K10100	切刀氣缸座	Knife cylinder base	1
102	D2M0610016A6	螺絲M6×16方頭內六角	Screw M6×16	3
103	C518K04900	彎接頭SPL-4-M5	Elbow Connection SPL-04-M5	2
104	D2M0508014A6	螺絲M5×14方頭內六角	Screw M5×14	2
105	E618K10500	刀台轉接座	Knife cylinder pivot bracket	1
106	D2M0407004E6	螺絲M4×4止付內六角	Screw M4×4	1
107	C918K10700	3針押腳舌	3 needle presser foot tongue	1
108	C918K10800	4針押腳舌	4 needle presser foot tongue	1
109	D218K10900	定片螺絲1/8"×44W×5.3	Screw 1/8"×44W×5.3mm	1
109-1	D218K109-1	定片螺絲1/8"×44W×6.6mm	Screw 1/8"×44W×6.6mm	1
110	C918K11000	押腳壓片	Presser foot tongue att. Plate	1
110-1	C918K110-1	押腳壓片	Presser foot tongue att. Plate	1
111	D218K11100	後片螺絲3/32"×48W×2.4	Screw 3/32"×48W×2.4mm	1
112	C918K11200	押腳後片	Curl plate	1
113	C918K11301	押腳底(新)	Presser foot base	1
114	D218K11400	前擋螺絲3/32"×48W×7	Screw 3/32"×48W×7mm	1
115	C918K11501	押腳前擋(新)	Presser foot tape guide (upper)	1
116	D218K11600	中底螺絲3/32"×48W×5.7	Screw 3/32"×48W×5.7mm	2
117	C918K11700	中底 3.5~13mm	Tape guide bracket 3.5~13mm	1
118	D218K11800	前蓋螺絲3/32"×48W×3.5	Screw 3/32"×48W×3.5mm	2
119	C918K11901	前蓋 3.5~13mm(新)	Tape guide (lower)3.5~13mm	1
120	C918K12000	中底 8~26mm	Tape guide bracket 8~26mm	1
121	C918K12101	前蓋 8~26mm(新)	Tape guide (lower) 8~26mm	1
122	C918K12200	中底 19~38mm	Tape guide bracket 19~38mm	1
123	C918K12301	前蓋 19~38mm(新)	Tape guide (lower) 19~38 mm	1
124	S318K12400	組件,布條架組	Tape holder	1
125	D260K00100	螺絲9/64"×11一字方頭	Screw 9/64"×11mm	2
126	C860K00200	布條限寬環	Stopper	2
127	E7S6-06300	支架	Tape rod	1
128	C8S6-06400	塑膠蓋	Plastic cap	1
129	D2M0407012B3	螺絲M4×12半圓頭一字一字	Screw M4×12	1
130	D2M0407025B3	螺絲M4×25半圓頭一字一字	Screw M4×25	1
131	C8S6-06700	分條桿扣	Extension joint	1
132	D3M04070703A	螺母M4	Nut M4	1
133	D3M04070703A	螺母M4	Nut M4	1
134	E7S6-07000	延長桿φ16×260	Extension rod φ16×260	1
135	D3M05080804A	螺母M5	Nut M5	2
136	E7S6-07200	延長桿扣	Fastener	1
137	D2M0508016B3	螺絲M5×16半圓頭一字一字	Screw M5×16	2
138	E7S6-07000	延長桿φ16×260	Extension rod φ16×260	1
139	D2A4700019C2	螺絲3/16"×3/4鐵板牙大扁頭十字	Screw 3/16"×3/4"	3
140	E7S6-07500	布條架固定座	Tape stand base	1


# MCA 18K-64 零件圖

## PARTS LIST FOR MCA 18K-64

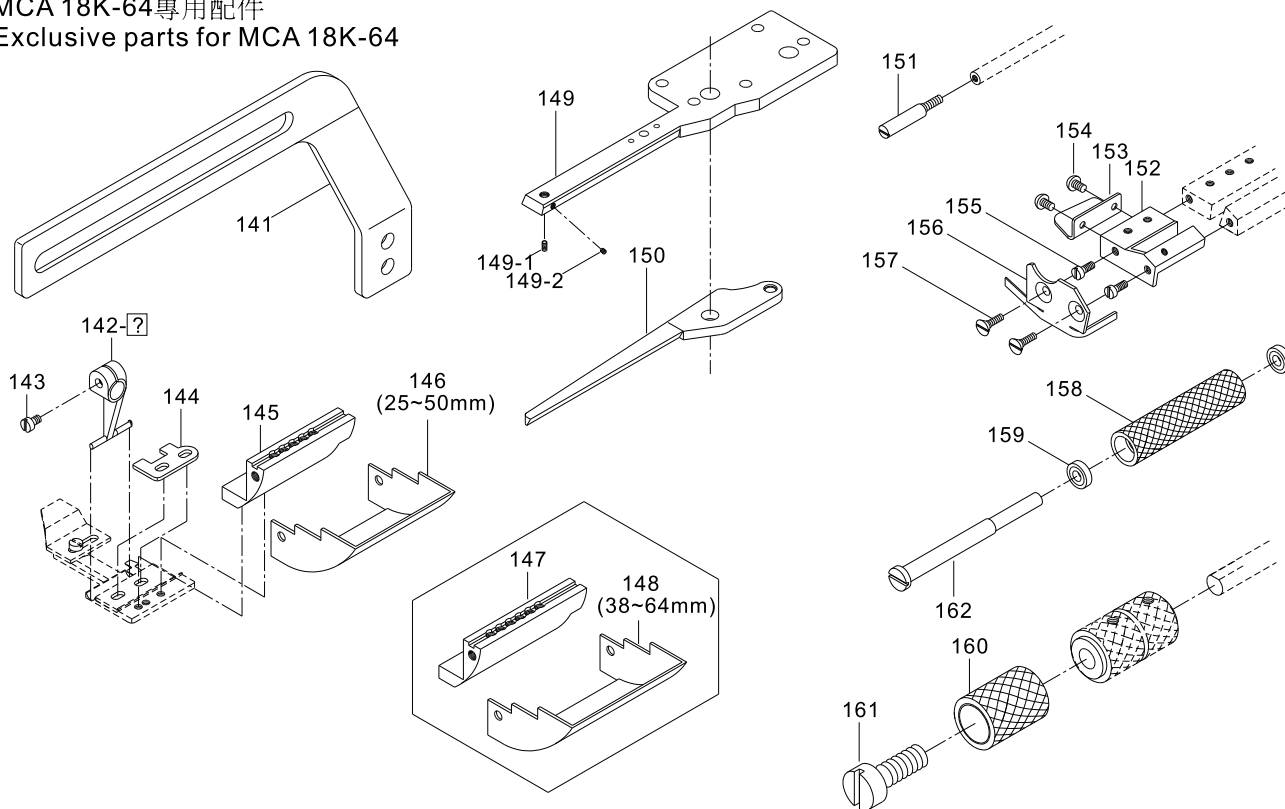
記號說明：

Mark description :

 選擇性配件  
Optional parts

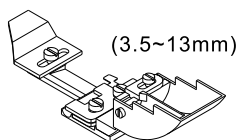
 選擇性配件，請告知針車廠牌機型  
Optional parts, please indicate sewing machine model no.

### MCA 18K-64專用配件 Exclusive parts for MCA 18K-64



### MCA 18K-38 專用壓腳 PRESSER FOOT FOR MCA 18K-38

163

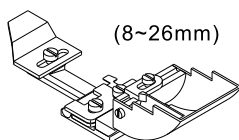


三線用  
FOR 3 THREAD



四線用  
FOR 4 THREAD

164

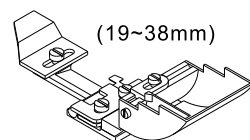


三線用  
FOR 3 THREAD



四線用  
FOR 4 THREAD

165



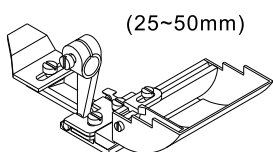
三線用  
FOR 3 THREAD



四線用  
FOR 4 THREAD

### MCA 18K-64 專用壓腳 PRESSER FOOT FOR MCA 18K-64

166

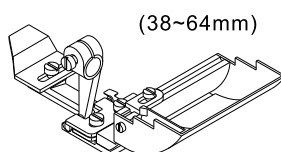


三線用  
FOR 3 THREAD



四線用  
FOR 4 THREAD

167



三線用  
FOR 3 THREAD



四線用  
FOR 4 THREAD


圖號 Fig. No.	電腦編號 Computer Code	中文名稱 Description	英文名稱 Description	數量 Qty
141	E618K12400	導帶架(長)	Tape guide (long)	1
142-?	請告知廠牌機型 PLEASE ADVISE BRAND & MODEL OF SEWING MACHINE	桿腳架	Foot bracket	1
143	D218K12600	押腳架螺絲9/64"×40W×6	Screw 9/64"×40W×6mm	1
144	C918K11000	押腳壓片	Presser foot tongue att. plate	1
145	C918K12800	中底 25~50mm	Tape guide bracket 25~50mm	1
146	C918K12901	前蓋 25~50mm(新)	Tape guide (lower) 25~50mm	1
147	C918K13000	中底 38~64mm	Tape guide bracket 38~64mm	1
148	C918K13101	前蓋 38~64mm(新)	Tape guide (lower) 38~64 mm	1
149	E618K14400	固定刀(長)	Fixed knife, long	1
149-1	D2M0407004E1	螺絲M4×4止付一字	Screw M4×4	1
149-2	D2M0305003E6	螺絲M3×3止付內六角	Screw M3×3	1
150	E618K14500	活動刀(長)	Moveable knife , long	1
151	C318K13200	壓板車用加長軸	Stud shaft	1
152	E618K13800	刀台加長座	Knife base extension	1
153	E618K13700	刀具開口保護片	Cover plate	1
154	D2M0305006B3	螺絲M3×6半圓頭十字一字	Screw M3×6	2
155	D218K13500	螺絲M3(車)	Screw M3	2
156	E618K13400	刀具保護片(長)	Knife cover plate, long	1
157	D218K13300	螺絲M5(車)	Screw M5	2
158	E618K14100	副輪(長)	Auxiliary roller, long	1
159	D6L0711030	培林L-1170ZZ	Bearing L-1170ZZ	2
160	E618K13900	主輪加長輪	Main roller extension	1
161	D218K14000	加長輪螺絲	Screw	1
162	C318K14300	副輪軸(長)	Auxiliary roller shaft (long)	1
MCA 18K-38 專用押腳 PRESSER FOOT FOR MCA18K-38				
163	S318K107-1	組件, 押腳組3.5~13mm	Presser foot. 3.5 ~13mm	1
164	S318K107-2	組件, 押腳組8~26mm	Presser foot. 8 ~26mm	1
165	S318K107-3	組件, 押腳組19~38mm	Presser foot. 19 ~38mm	1
MCA 18K-64 專用押腳 PRESSER FOOT FOR MCA18K-64				
166	S318K107-4	組件, 押腳組25~50mm	Presser foot. 25 ~50mm	1
167	S318K107-5	組件, 押腳組38~64mm	Presser foot. 38 ~64mm	1


# MCA 18K<sup>-38</sup>/<sub>-64</sub>/TR 零件圖

## PARTS LIST FOR MCA 18K<sup>-38</sup>/<sub>-64</sub>/TR

記號說明：

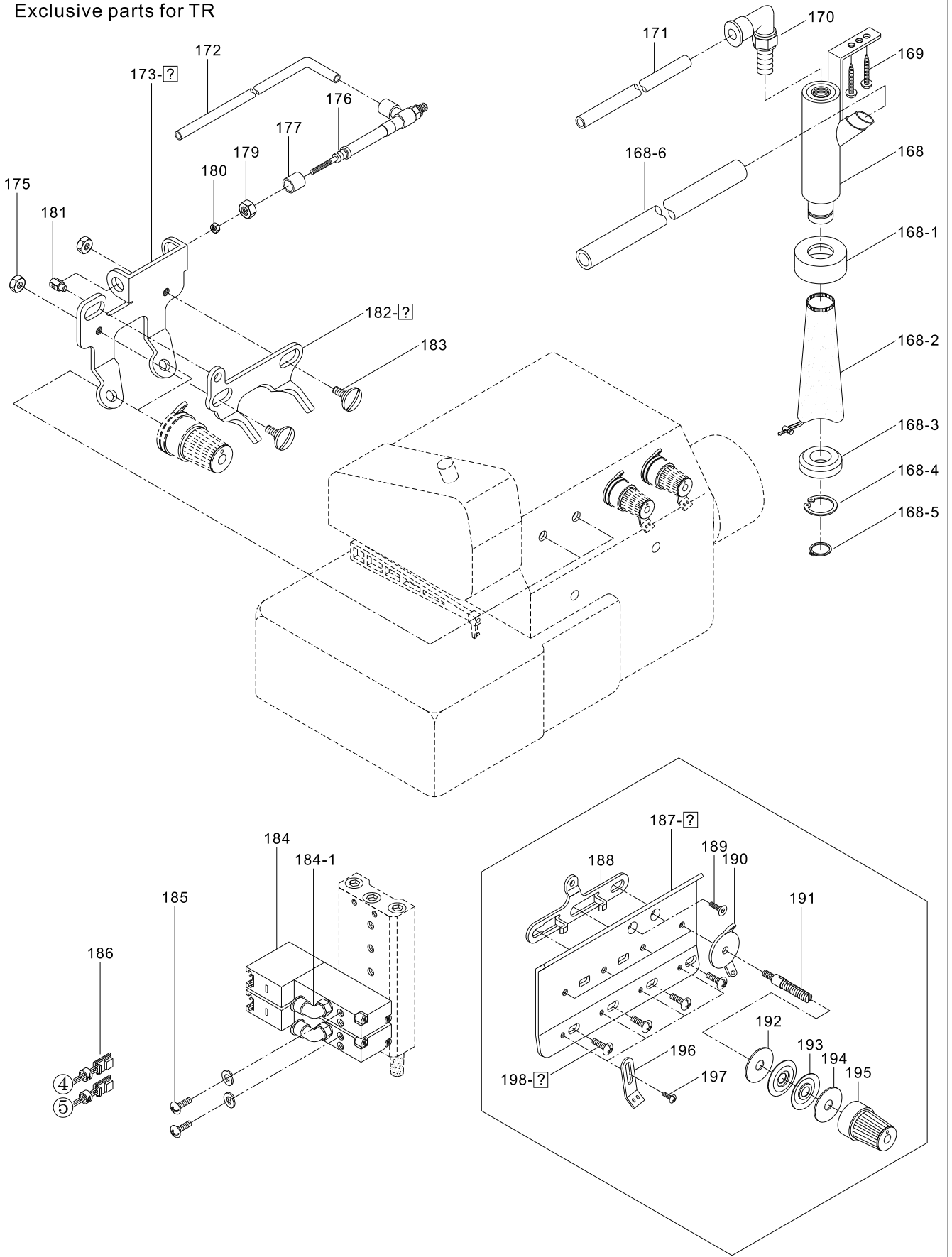
Mark description :

 選擇性配件  
Optional parts

 選擇性配件，請告知針車廠牌機型  
Optional parts, please indicate sewing machine model no.

TR 專用配件

Exclusive parts for TR

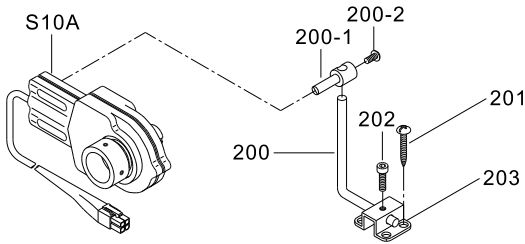


圖號 Fig. No.	電腦編號 Computer Code	中文名稱 Description	英文名稱 Description	數量 Qty
168	G3ECV19000	集屑座	Chain & waste collection base	1
168-1	G3ECV20300	集屑座固定蓋	Fixing cover	1
168-2	G3ECV20400	集屑袋	Chain & waste collection bag	1
168-3	G3ECV20500	集屑座固定環	Fixing ring	1
168-4	D5RTW36-00	孔用扣環 RTW-36	C Type ring 36mm	1
168-5	D5STW18-00	軸用扣環 STW-18	C Type ring 18mm	1
168-6	G3ECV19200	塑膠管	Plastic hose	1
169	D2A4000016C2	螺絲5/32"×5/8鐵板牙大扁頭	Screw 5/32"×5/8"	2
170	C5PL-A1404	彎接頭SPL-4-1/8PT	Elbow connection SPL-04-01	1
171	C5C1401000	空壓管φ2.5×4mm	Polyamide tubingφ2.5×4mm	1
172	C5C1401000	空壓管φ2.5×4mm	Polyamide tubingφ2.5×4mm	1
173	請告知廠牌機型 PLEASE ADVISE BRAND & MODEL OF SEWING MACHINE	鬆線板座	Thread release bracket	1
175	D3M04070703A	螺母M4	Nut M4	2
176	C518K14700	鬆線氣缸 PBSA6×5	Thread release cylinder PBSA6×5	1
177	E618K14800	鬆線氣缸套管	Thread release cylinder collar	1
179	D3M06101005A	螺母M6	Nut M6	1
180	D3M03050625A	螺母M3	Nut M3	1
181	E618K15201	鬆線連結螺(長)	Thread release cylinder conn. screw	1
182-?	請告知廠牌機型 PLEASE ADVISE BRAND & MODEL OF SEWING MACHINE	鬆線板座	Thread release bracket	1
183	D218K18300	鬆線板螺	Screw	2
184	C518K17300	電磁閥	Valve	2
184-1	C518K04900	彎接頭SPL-4-M5	Elbow connection SPL-04-M5	2
185	D2M0407020A6	螺絲M4×20方頭內六角	Screw M4×20	2
186	C518K17200	電磁閥電線	Valve plug	2
187-?	請告知廠牌機型 PLEASE ADVISE BRAND & MODEL OF SEWING MACHINE	調線組主座	Tension mounting plate	1
188	E618K15400	鬆線活動片	Thread release plate	1
189	D2M0407004D6	螺絲M4×4沙拉頭內六角	Screw M4×4	2
190	E618K15700	調線片	Tension thread guide	4
191	E618K16300	調線螺絲	Thread tension stud	4
192	E618K16400	羊毛氈	Felt	4
193	E618K16500	調線盤	Thread tension disc	8
194	E618K16400	羊毛氈	Felt	4
195	E618K17500	調線螺母	Post nut	4
196	E518K17000	過線片	Thread guide	4
197	D2W3540006B3	螺絲9/64"×40W×1/4"半圓頭十字一字	Screw 9/64"×40W×1/4"	4
198-?	請告知廠牌機型 PLEASE ADVISE BRAND & MODEL OF SEWING MACHINE	鬆線座板螺絲	Screw	4

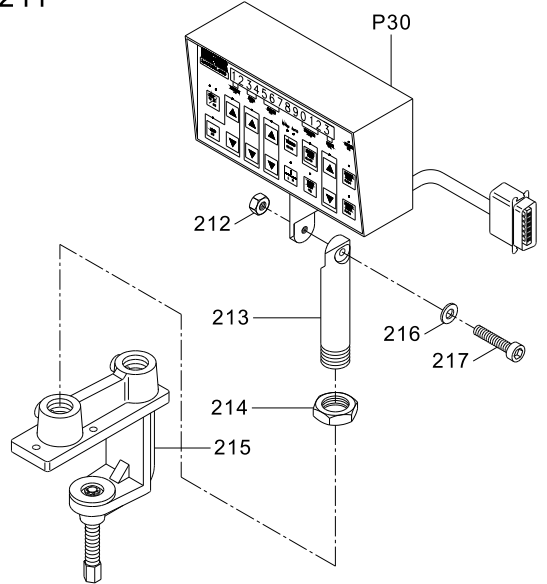
# MCA 18K<sup>-38</sup><sub>-64</sub> 零件圖

## PARTS LIST FOR MCA 18K<sup>-38</sup><sub>-64</sub>

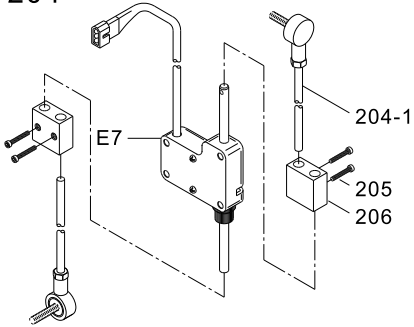
199



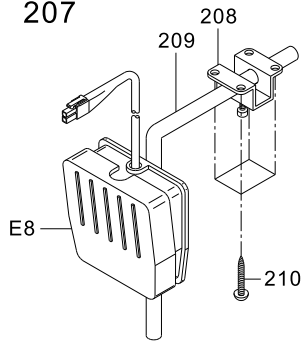
211



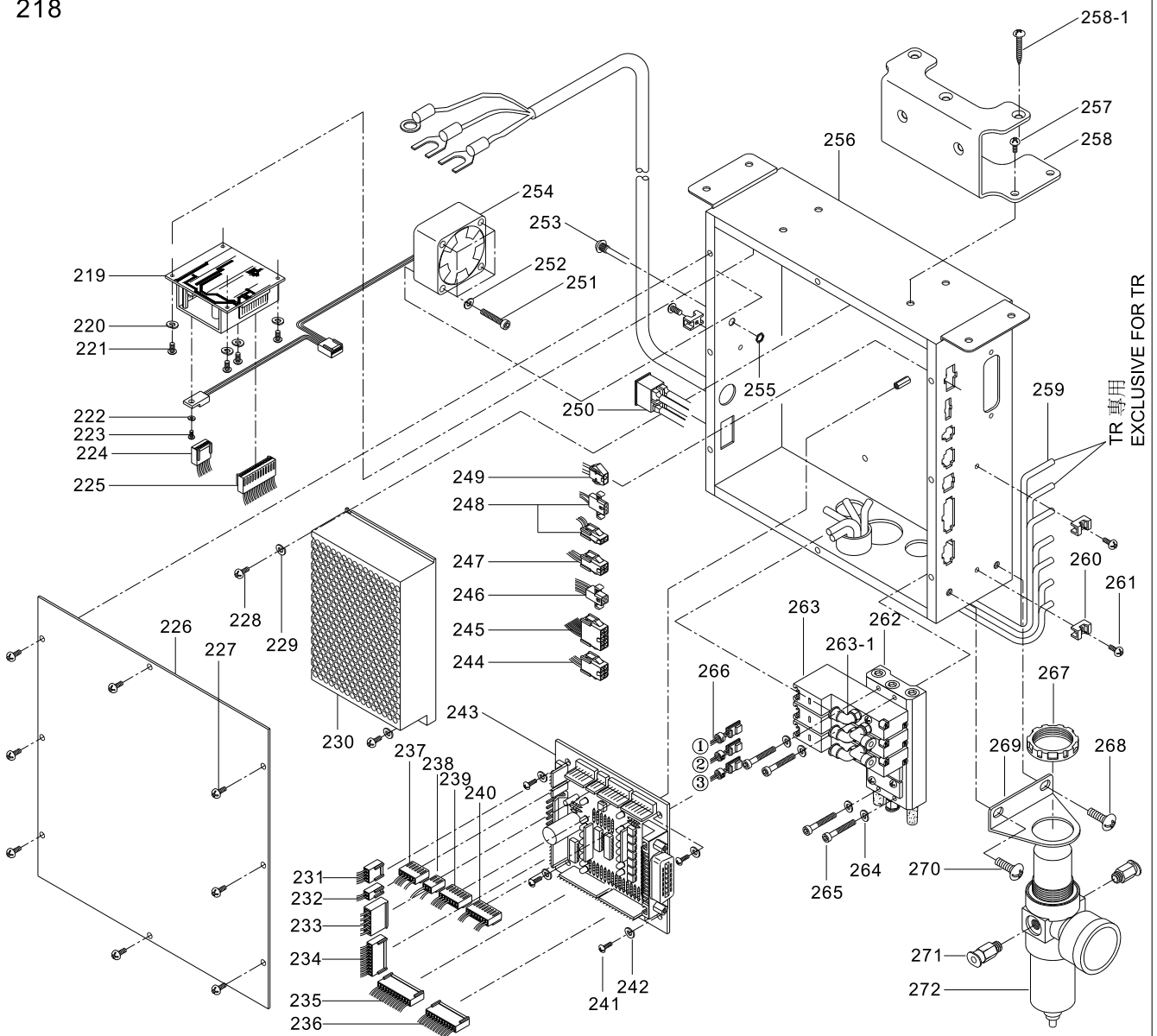
204



207



218



圖號 Fig. No.	電腦編號 Computer Code	中文名稱 Description	英文名稱 Description	數量 Qty
199	S218K176A0	零組件, 檢知器組(拷克車用)	Synchronizer complete	1
S10A	S3-S10-001A0	組件, 新檢知器	Synchronizer only	1
200	C5-S10-C01-2	定位板架軸	Fixing position block rod	1
200-1	C5-S10-C01-3	定位軸	Fixing position shaft	1
200-2	D2M0407008B3	螺絲M4×8半圓頭十字一字	Screw M4×8	1
201	D2A4000016C2	螺絲5/32"×5/8鐵板牙大扁頭	Screw 5/32"×5/8"	4
202	D2M0508006A6	螺絲M5×6方頭內六角	Screw M5×6	1
203	C5-S10-C01A1	定位板(新)	Fixing position block	1
204	S218K18100	零組件, E7腳踏開關組	Knee switch complete	1
E7	S3E7-00100	組件, MC E7開關	Switch E7	1
204-1	C5ECV24400	馬達桿	Motor rod	2
205	D2M0508015FX	螺絲M5×15外六角	Screw M5×15	4
206	C5E7-01200	滑塊	Treadle rod clamp	2
207	S218K18400	零組件, E8膝動開關組	Treadle rod switch complete	1
E8	S3E8-00100	組件, MC E8開關	Switch E8	1
208	C5E8-001A1	定車板塊(新)	Knee switch mounting complete	1
209	C5E8-00200	開關鐵架	Knee switch mounting rod	1
210	D2A4700019C2	螺絲3/16×3/4鐵板牙大扁頭	Screw 3/16×3/4"	4
211	S218K18800	零組件, MCA18K控制面板組	Control panel complete	1
P30	S3P30-00100	組件, P30控制面板(MCA18K)	P30 control panel only	1
212	D3M06101005A	螺母M6	Nut M6	1
213	C518K19000	下腳桿	Control panel stand	1
214	B8TFU10200	螺母 3/4"×16W	Nut 3/4"×16W	1
215	S3TFU10400	組件, 上送夾座組	Control panel mounting clamp	1
216	D4B1110615	彈簧華司M6	Corrugated washer M6	1
217	D2M0610020A6	螺絲M6×20方頭內六角	Screw M6×20	1
218	S218K19500	零組件, MCA 18控制箱	Control box complete	1
219	C518K19600	步進馬達驅動器	Stepping motor driver	1
220	D4B1060308	彈簧華司M3	Corrugated washer M3	4
221	D2M0305006C3	螺絲M3×6大扁頭十字一字	Screw M3×6	4
222	D4B1060308	彈簧華司M3	Corrugated washer M3	1
223	D2M0305006B3	螺絲M3×6半圓頭十字一字	Screw M3×6	1
224	C518K20100	插頭	Plug	1
225	C518K20200	插頭	Plug	1
226	C518K20300	電源箱蓋	Control box cover	1
227	D2M0305006C3	螺絲M3×6大扁頭十字一字	Screw M3×6	8
228	D2M0305006C3	螺絲M3×6大扁頭十字一字	Screw M3×6	2
229	D4B1060308	彈簧華司M3	Corrugated washer M3	2
230	C518K20700	電源供應器	Main power supply	1
231	C518K20800	插頭	Plug	1
232	C518K20900	插頭	Plug	1
233	C518K21000	插頭	Plug	1
234	C518K21100	插頭	Plug	1
235	C518K21200	插頭	Plug	1
236	C518K21300	插頭	Plug	1
237	C518K21400	插頭	Plug	1
238	C518K21500	插頭	Plug	1
239	C518K21600	插頭	Plug	1
240	C518K21700	插頭	Plug	1
241	D2M0305006C3	螺絲M3×6大扁頭十字一字	Screw M3×6	4
242	D4B1060308	彈簧華司M3	Corrugated washer M3	4
243	C518K22000	控制箱電路板	Circuit board	1

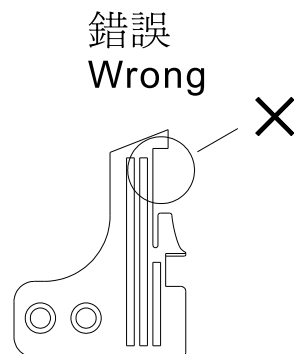
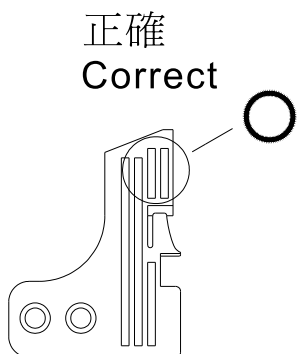
圖號 Fig. No.	電腦編號 Computer Code	中文名稱 Description	英文名稱 Description	數量 Qty
244	C518K22100	插座	Socket	1
245	C518K22200	插座	Socket	1
246	C518K22300	插座	Socket	1
247	C518K22400	插座	Socket	1
248	C518K22500	插座	Socket	1
249	C518K22600	插座	Socket	1
250	C518K22700	插座	Socket	1
251	D2M0407025A6	螺絲M4×25方頭內六角	Screw M4×25	4
252	D4B1070410	彈簧華司M4	Corrugated washer M4	4
253	C518K23000	電源指示燈	Power lamp	1
254	C518K23100	風扇40×40×20	Fan 40*10*20	1
255	D3M08071002A	螺母M8×0.75	Nut M8×0.75	1
256	C518K23300	電源箱	Control box housing	1
257	D2M0407008B3	螺絲M4×8半圓頭十字一字	Screw M4×8	4
258	C5PL-C1404	口字架	Bracket	1
258-1	D2A4000019C2	螺絲 5/32"×3/4鐵板牙大扁頭	Screw 5/32"×3/4"	4
259	C5C1401000	空壓管φ2.5×4mm	Polyamide tubingφ2.5×4mm	8
260	C818K23700	紮帶固定座ATM-1	Air hose retainer ATM-1	3
261	D2M0305006C3	螺絲M3×6大扁頭十字一字	Screw M3×6	3
262	C518K23900	電磁閥五連座	Valve base	1
263	C518K17300	電磁閥	Valve	3
263-1	C518K04900	彎接頭SPL-4-M5	Elbow connection SPL-04-M5	3
264	D4B1070410	彈簧華司M4	Corrugated washer M4	4
265	D2M0407020A6	螺絲M4×20方頭內六角	Screw M4×20	4
266	C518K17200	電磁閥電線	Valve plug	3
267	D3PFHB-143	螺母 (調壓表附件)	Nut	1
268	D2M0407008B3	螺絲M4×8半圓頭十字一字	Screw M4×8	1
269	E618K26900	調壓表固定座	Air regulator base	1
270	D2M0407008B3	螺絲M4×8半圓頭十字一字	Screw M4×8	1
271	C5PL-A1405	直接頭管徑φ6，牙口1/8PT	Straight connection SPC-06-01	2
272	E618K27200	調壓錶濾水器 AFR-1500	Presser regulator / water filter	1



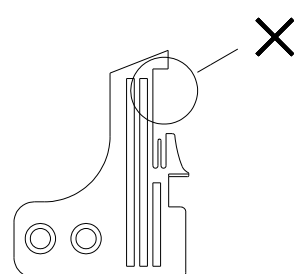
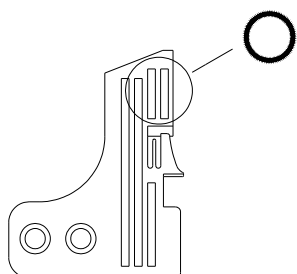
注意：本送帶機必須使用下列規格的針板

Attention: This metering device must be operated with the following type of needle plate.

三線包縫車用  
One needle overlock



四線包縫車用  
Two needle overlock



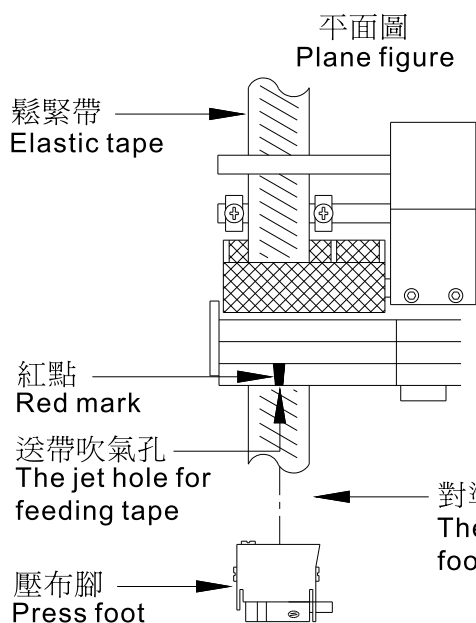
重要：放入鬆緊帶的正確位置

Important :The position for inserting elastic tape.

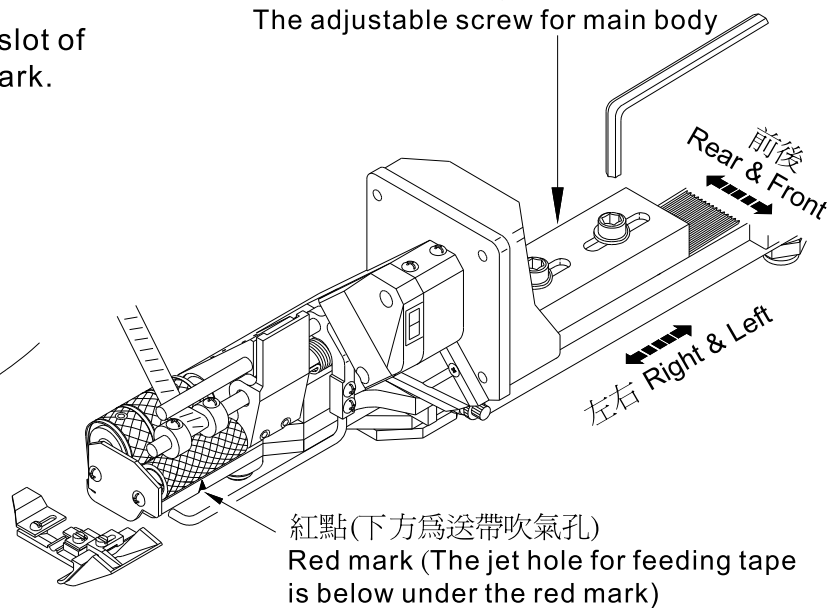
必須調整主機的紅點對準壓布腳入帶口的中央  
(送帶用吹氣孔是在紅點的下方)

Make sure the center of inserting slot of press foot should meet the red mark.  
(The hole is under the red mark)

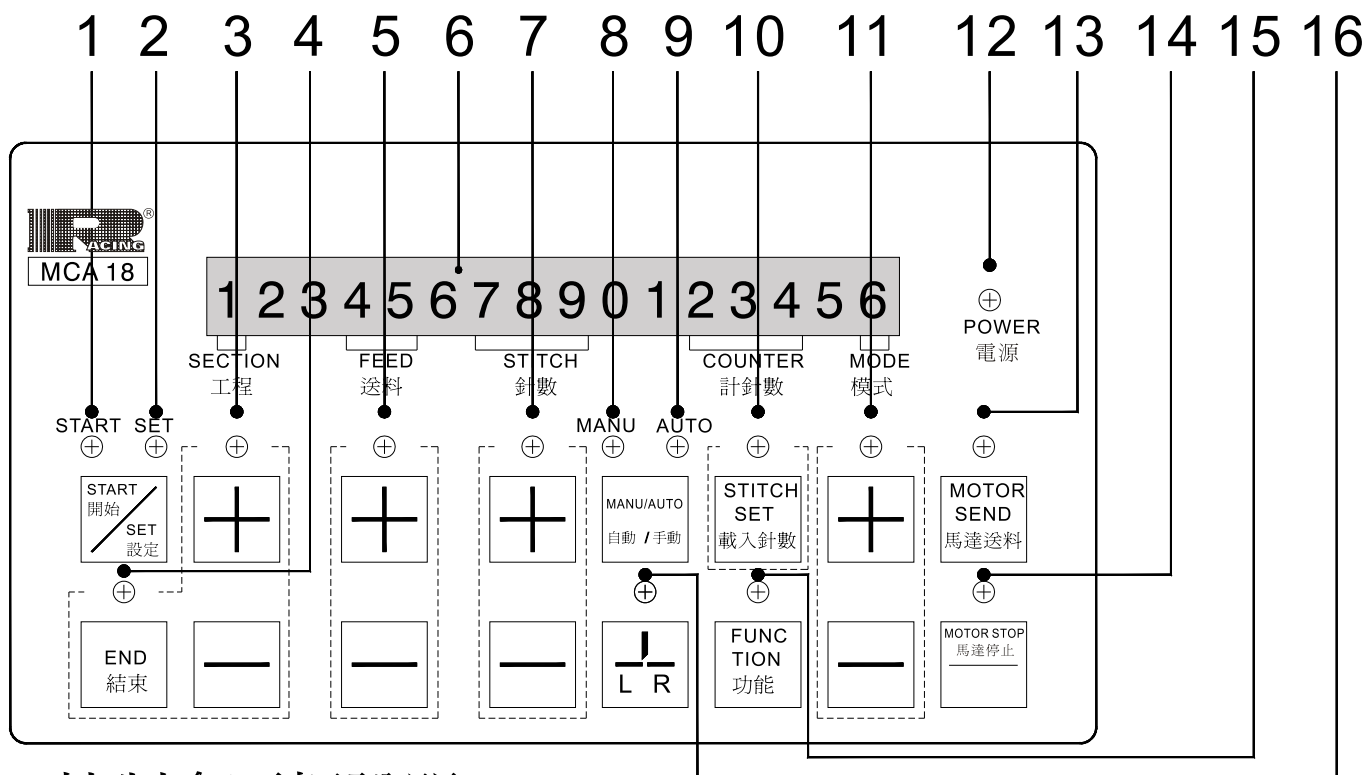
鬆開螺絲可調整主機架的位置  
The adjustable screw for main body



對準壓布腳入帶口的中央  
The center of inserting slot of press foot should meet the red mark.



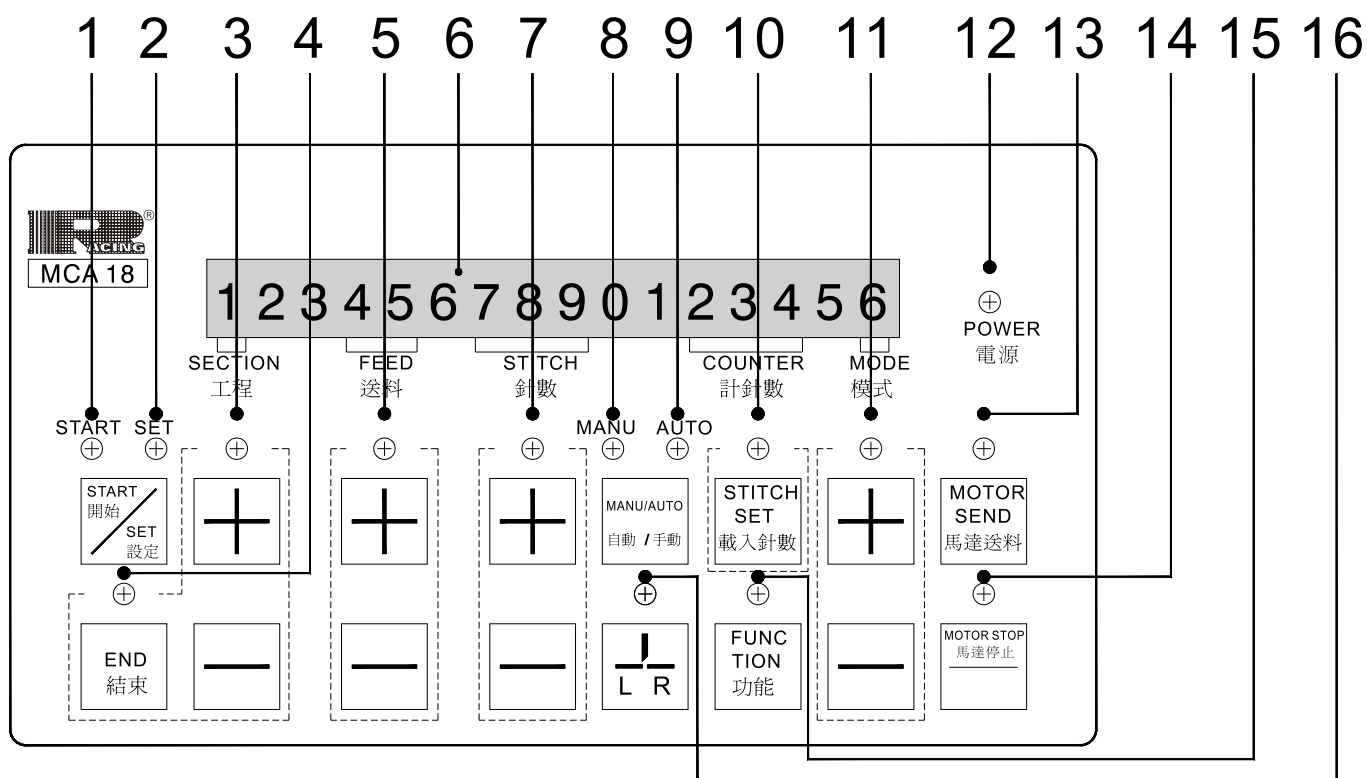
# 控制盒面板說明



## 控制盒面板說明

- 1 開始 (循環開關): 回復啓始狀態
- 2 設定 (循環開關): 進入設定修改狀態
- 3 工程: ① 模式: 有5組 (■, A~D) 可設定工程段數 1~18段  
② 模式: 有22組 (E~Z) 可設定工程段數 1~9 段
- 4 結束: 設定工程結束
- 5 送料: 每針送料長度設定 00~99, 每增加1 = 0.025MM
- 6 視窗: 顯示現在狀態
- 7 針數: 設定工程所需要的針數 0~999 (手動時則不顯示)
- 8 手動: 用手動開關進入下一工程
- 9 自動: 設定針數累計到達時依序進入下一車縫工程
- 10 載入針數: 在試縫完成後可將計數器內所顯示的數字 (針數) 載入 "針數" 的視窗內作為該工程的針數設定 (注意! 原針數會被覆蓋掉)
- 11 模式: 可儲存27組 (A~Z, ■) 不同工程內容資料 (請參照第24頁)  
(進入功能模式內時另有用途, 請參照功能鍵內容說明第 19~20頁)
- 12 電源: 燈亮時控制鍵才可操作 (開關在控制箱)
- 13 馬達送料: 按此鍵時馬達運轉, 可便於插入鬆緊帶用
- 14 馬達停止: 在 START 時按此鍵馬達停止運轉 (再按功能鍵, 能測出縫紉機的轉速)
- 15 功能: 按此鍵時可提供各種縫製需要的功能設定 (請參考功能鍵說明第19~20頁)
- 16  $\frac{L}{R}$ : 按此鍵時可於工程段數間切刀 (例: 縫褲口的左右邊, 請參考第23頁操作說明)

# The manual of the control panel

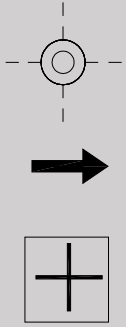


## Instruction of the control box

- 1 START ( Circulating switch ) : Return to the status of the beginning.
- 2 SET ( Circulating switch ) : Enter to the modified status.
- 3 SECTION: ① Mode : 5 modes ( ■ 、 A~D ) can be setting the section from 1~18.  
② Mode : 22 modes ( E~Z ) can be setting the section from 1~9.
- 4 END: Press this key to end the setting.
- 5 FEED: To set the distance of each stitch when feeding from 00~99.  
( 00=0mm . For each additional one = 0.025mm.)
- 6 Data panel: Indicate the data status.
- 7 STITCH : To set the stitches from 0~999 for the need section.
- 8 MANU: During the manual condition, using the manual bottom to enter the next section.
- 9 AUTO: During the stitch are executed, the machine will automatic progress into the next section.
- 10 STITCH SET: After complete the sewing test, press this key to duplicate the testing result of stitches to enter the setting of the next stitches section.
- 11 MODE: Use this key can memory up to 27 modes. ( From A ~Z, ■ ) ( Refer to the page 24 )  
( For the detail, please refer to the functional guide in page 19~20. )
- 12 POWER: Unable to operate unless this indicate lights in on. ( Switch is on the control box. )
- 13 MOTOR SEND: Press this key to start the motor for easily insert the elastic tape.
- 14 MOTOR STOP: During the Start lamp is lighting, press this key to stop the motor.  
( Press "FUNCTION" key to check the R.P.M. figure. )
- 15 FUNCTION: Press this key to set the functional for all sewing type.  
( Please refer to the functional guide in page 19~20. )
- 16  $\frac{L}{R}$  : Press this key to trim during each sections. ( For example : When sewing the both side of the under pants. Please refer to the operating guide on page 23. )

# 記號說明

# Icon indicators in this manual



- 1. LED亮  
LED on
- 2. 操作程序  
Operation procedure
- 3. 增加數值  
Increase Number



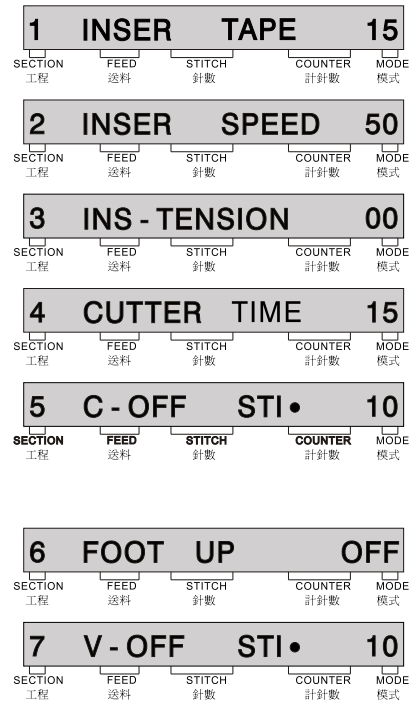
- 4. 減少數值  
Decrease Number
- 5. 切刀後, 前往下段未完工程  
After cut, program will go on the next running section.

## 功能一 內容: 按 "功能" 鍵, 即可進入 "功能一" 修改設定

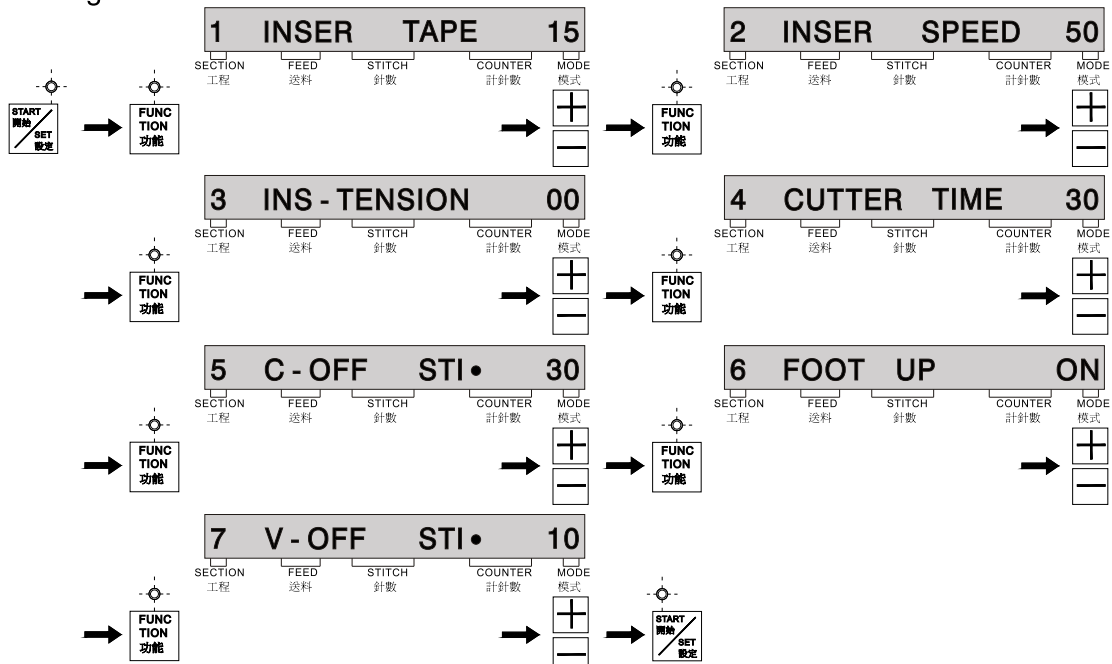
### Context of Function 1 : Press "FUNCTION" bottom to enter "Function 1" setting

- 1 送帶長度 (00=35mm 每增加 1=1mm 99=134mm)  
Length of inserting tape  
( 00 = 35mm Every 1 unit = 1mm up to 99 units = 134mm )
- 2 進帶速度 (00=50mm 每增加 1=1.9mm 99=238.1mm)  
Speed of inserting tape  
( 00 = 50mm Every 1 unit = 1.9mm up to 99 units = 238.1mm )
- 3 始縫時鬆緊帶回拉 (00=0mm 每增加 1=0.35mm 99=34mm)  
Pull back length during beginning sewing.  
( 00 = 0mm Every 1 unit = 0.35mm up to 99 units = 34mm )
- 4 切刀吻合時間 (00 = 0.1秒 每增加 1=0.005秒 99=0.6秒)  
Cutter timer  
( 00 = 0.1 sec. Every 1unit = 0.005 sec. Up to 99 units = 0.6sec. )
- 5 切刀後完成尚未車縫鬆緊帶所需的針數 (00=0針 99=99針)  
(當針數到達後, TR鬆線裝置及吸風裝置將會啟動, TR專用)  
Setting stitches to complete the ending tape sewing after cutting the tape.  
( 00 = 0 stitch up to 99 = 99 stitches )  
( The TR device and Vacuum will be active, for TR device only. )
- 6 選擇 " ON " 時, 縫製工程完成後壓腳將自動提升  
Presser foot will be lifted up automatically after complete the operation during "ON" Statue.
- 7 始縫時, 自動切線刀之吸風裝置動作針數設定 (00=0針 99=99針) (TR專用)  
Vacuum activates stitch at beginning sewing. (For TR device only )  
( 00 = 0 stitch up to 99 = 99 stitches )

#### 視窗 Panel




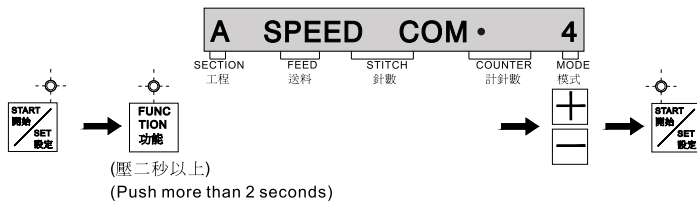
### 操作說明 Operation guide



功能二 內容：按 " 功能 " 鍵二秒不放，即可進入 " 功能二 " 修改設定  
 Context of Function 2 : Keep pressing "FUNCTION" bottom more than 2 sec. to enter "Function 2" setting

- A. 送料補償：因車速不同所造成的送帶值誤差 (車速愈快針目會愈大)  
 A. Compensation : Tape feeding may be uneven caused by different sewing speed.  
 ( More speed may cause bigger stitch )

 操作說明  
 Operation guide

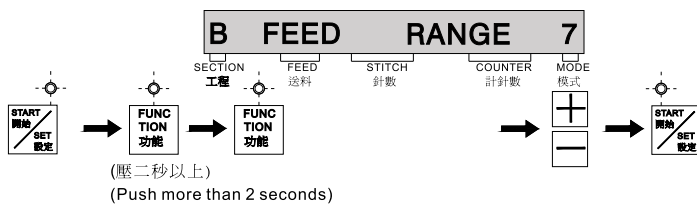


補償表  
 Compensation list \* 出廠設定  
 Pre-Programmed

馬達轉速 R.P.M. 模式編號 Mode	3000	4000	5000	6000
0	00	00	00	00
1	00	00	01	01
2	00	00	01	01
3	00	01	01	01
* 4	00	01	01	02
5	00	01	02	02
6	01	02	03	04
7	01	03	05	07
8	01	04	07	10
9	01	04	08	11

- B. 送料範圍：依車縫針目大小，更改送料範圍  
 B. Feed Range : Depend on different stitch length to set the proper Feed Range.

 操作說明  
 Operation guide

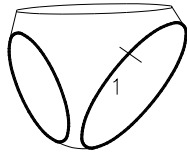


送料範圍表  
 Feed Range list \* 出廠設定  
 Pre-Programmed

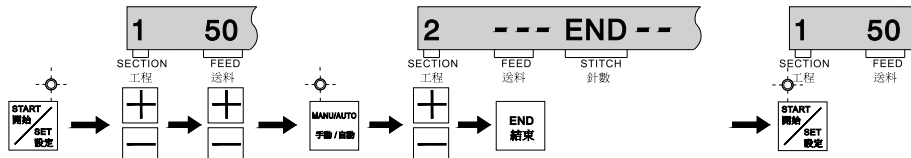
模式編號 Mode	送料範圍 / 每針 Feed Range / Per Stitch
0	0.2mm~1.2mm
1	0.4mm~1.4mm
2	0.4mm~2.4mm
3	0.6mm~2.6mm
4	0.6mm~3.1mm
5	0.8mm~3.3mm
6	1.0mm~3.5mm
* 7	1.1mm~3.6mm
8	1.2mm~3.7mm
9	1.3mm~3.8mm

# 使用說明 (本說明內容將由簡單漸進複雜方式) Operation guide (From easy to complex)

例一：單一工程  
Example 1: Single section for manual



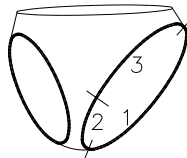
操作說明  
Operation guide



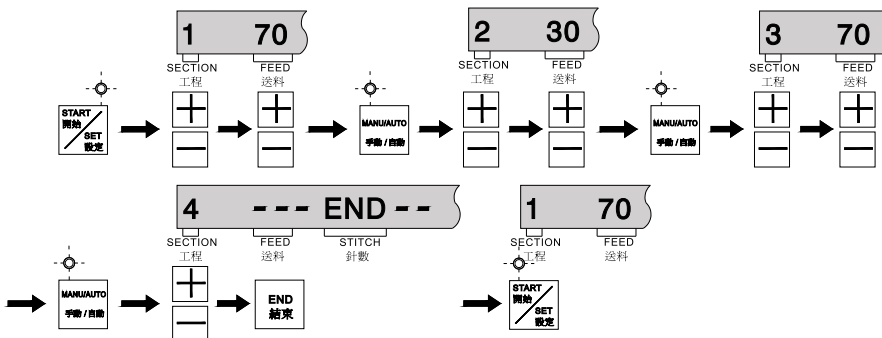
例一  
Example 1

工程 SECTION	送料 FEED	針數 STITCH
1	50	-

例二：一,二,三段工程均為手動  
Example 2: All three sections are manual



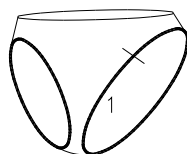
操作說明  
Operation guide



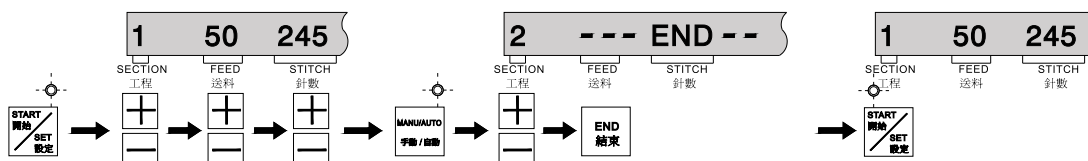
例二  
Example 2

工程 SECTION	送料 FEED	針數 STITCH
1	70	-
2	30	-
3	70	-

例三：單一工程為自動  
Example 3: Single section for auto



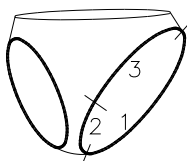
操作說明  
Operation guide



例三  
Example 3

工程 SECTION	送料 FEED	針數 STITCH
1	50	245

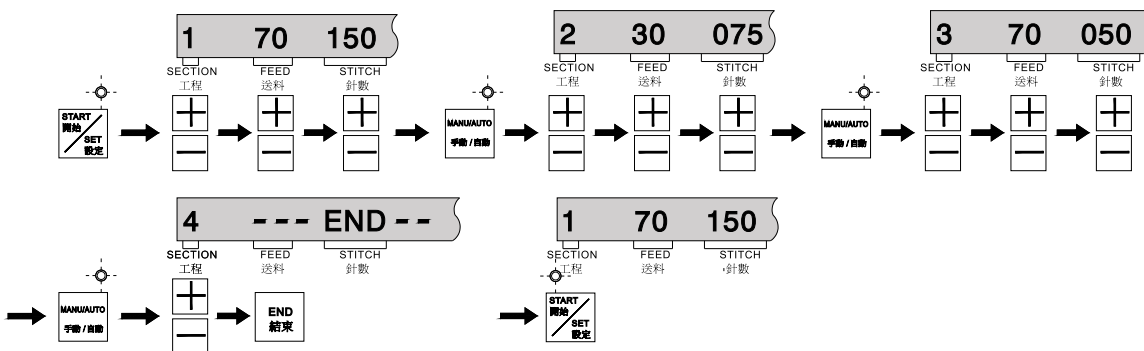
例四：一,二,三段工程均為自動  
 Example 4 : All three sections are auto



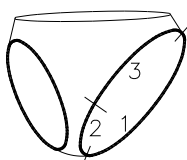
例四  
 Example 4

工程 SECTION	送料 FEED	針數 STITCH
1	70	150
2	30	75
3	70	50

操作說明  
 Operation guide



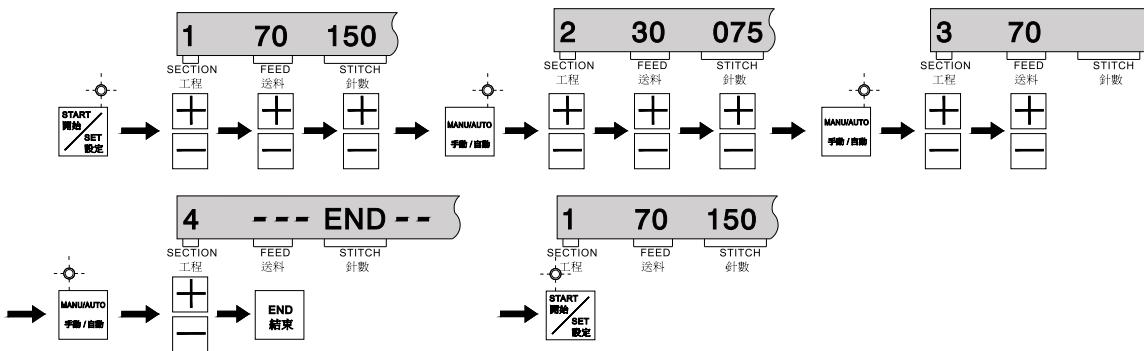
例五：第一,二段工程為自動;第三段工程手動  
 Example 5 : Section 1,2 are auto; section 3 is manual



例五  
 Example 5

工程 SECTION	送料 FEED	針數 STITCH
1	70	150
2	30	75
3	70	-

操作說明  
 Operation guide

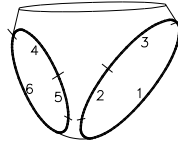


- 例六: 1.褲口左右兩邊縫製  
 2.工程內容資料儲存於 "A" 模式  
 3.第1,2,4,5工程為自動  
 4.針車啓動後馬達自動回拉(註一)  
 5.切刀後30針壓腳自動提升及自動進帶(註二)

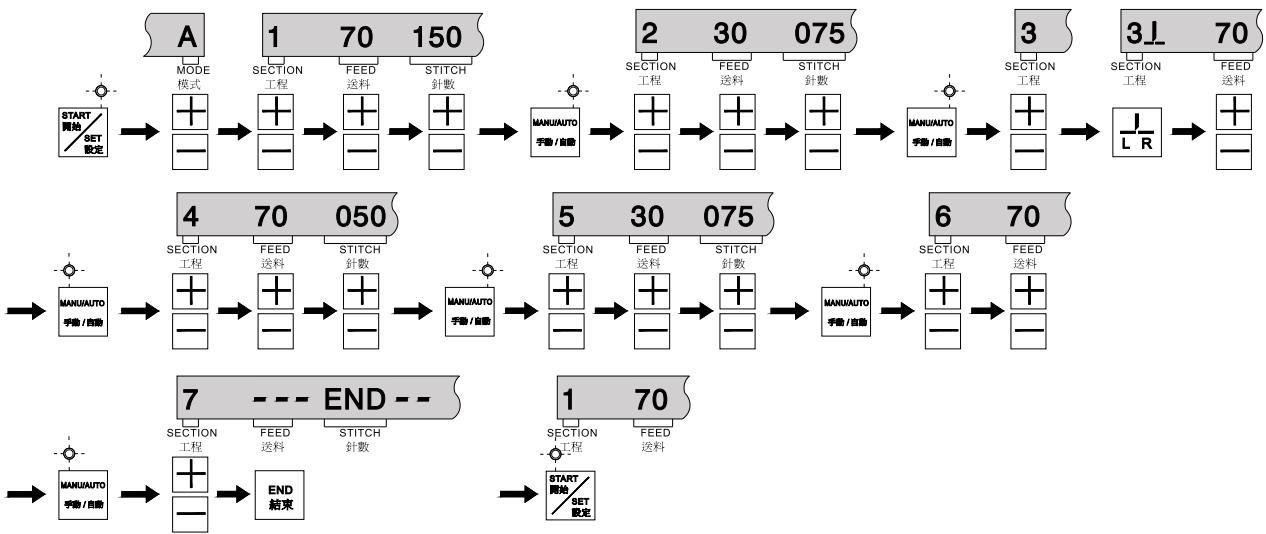
例六  
Example 6

工程 SECTION	送料 FEED	針數 STITCH
1	70	150
2	30	75
3	70	-
4	70	50
5	30	75
6	70	-

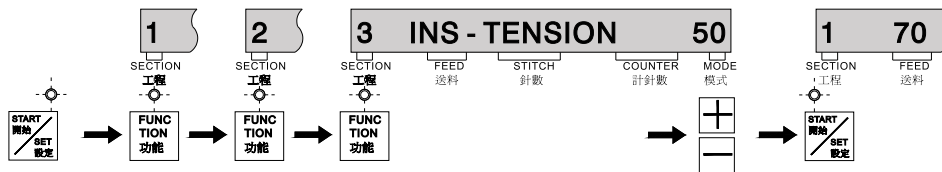
- Example 6: 1. Sewing two leg openings of slips  
 2. Section data stored in "A" mode  
 3. Section 1,2,4,5 are auto  
 4. Auto pull back after starting the machine ( Remark 1 )  
 5. Auto lifting and feeding after cutting and 30 stitches ( Remark 2 )



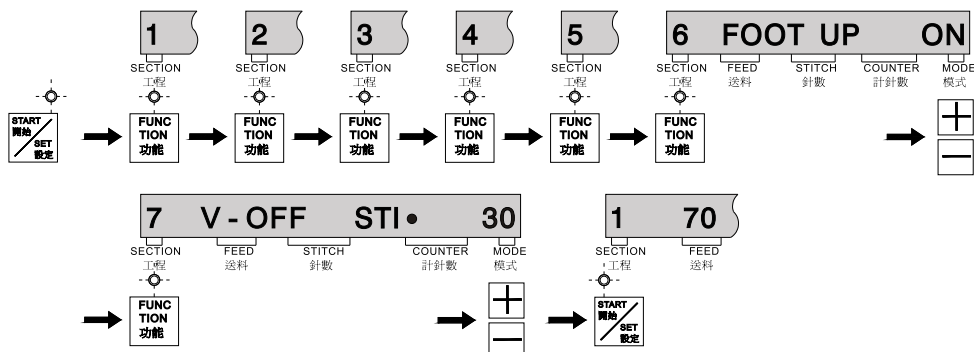
操作說明  
Operation guide



操作說明 (本例設定註一)  
Operation guide ( Remark 1 )



操作說明 (本例設定註二)  
Operation guide ( Remark 2 )





# 模式 MODE

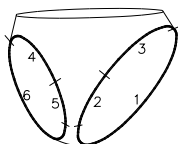
功能說明：此功能提供使用者記憶27組不同的車縫模式，使用者可快速選擇事先所儲存記憶的模式，毋需重新設定

Description : This function provides user to memory up-to 27 different sewing modes. User can rapidly switch the MODE which is already set. No necessary to resetting again.

例七：車縫不同樣式時，模式切換，模式A切換到模式B  
Example 7: To switch the MODE from MODE A to MODE B

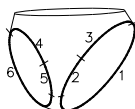
例七  
Example 7

模式 A  
MODE A



工程 SECTION	送料 FEED	針數 STITCH
1	70	150
2	30	75
3	70	-
4	68	30
5	28	56
6	68	-

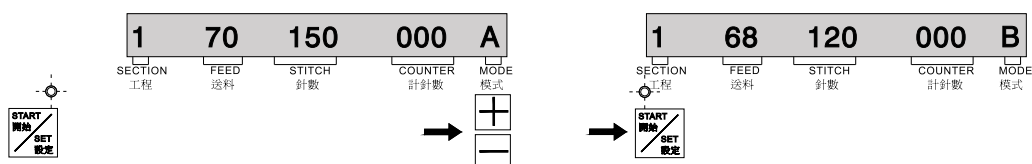
模式 B  
MODE B



工程 SECTION	送料 FEED	針數 STITCH
1	68	120
2	27	64
3	67	-
4	65	24
5	25	48
6	66	-



## 操作說明 Operation guide



## 故障排除

### SOLUTION FOR ERROR FUNCTION

現 象	原 因	解 決 方 法
送帶機異常振動	1.送帶機與縫紉機銜接的螺絲鬆弛	1.參照第 2 頁重新固定
送帶數值 99 仍然過緊	1.送料範圍數值選擇過小,宜增加數值	1.參照第 20 頁設定
送帶數值 00 仍然過鬆	1.送料範圍數值選擇過大,宜減少數值	1.參照第 20 頁設定
送帶機無動作	1.電源未接妥善 2.線路系統斷路  3.控制系統故障	1.參照第 3 頁設定 2.參照第 3 頁檢查各線路插座與插頭接腳是否鬆脫 3.通知維修人員進行更換維修
螢幕不顯示	1.面板故障	1.通知維修人員進行更換維修
模式數值無法記憶	1.記憶體故障	1.通知維修人員進行更換維修
送帶不順	1.送帶位置或裝置不當 2.吹氣孔氣量不足或位置不當	1.參照第 16 頁重新固定 2.參照第 16 頁固定調整

保固期限：壹年，日期如無法查證時以出廠日期起18個月為準確（不含時規皮帶）

Situation	Reason	Solution
Vibration	1. Fixed screw loosen.	1. Refer to the page 2
99 still too tight	1. Feed range value is too small, please increase the value.	1. Refer to the page 20
00 Still too loose	1. Feed range value is too large, please decrease the value.	1. Refer to the page 20
No single	1. Power is not connecting properly. 2. Connecting line is break.  3. Electronic control system error.	1. Refer to the page 3 2. Refer to the page 3, please check the pin of connecting plug or socket are not loose. 3. Please call the technician to maintain
Blank panel	1. Panel out of order.	1. Please call the technician to maintain
Cannot memory the Mode	1. Memory out of order.	1. Please call the technician to maintain
Inserting tape difficulty	1. Wrong position for the tape or the main device. 2. The air jet hole is in the wrong position or too less jet air.	1. Refer to the page 16 2. Refer to the page 16

Warranty: One year, or 18 months after manufactured date. (Timing belt is not under warranty)

