

SIRUBA®

銀箭牌工業用縫紉機

INDUSTRIAL SEWING MACHINE

L918-BM1/BH1

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(MD), 2006/95/EC(LVD).

The undersigned, ROBERT TSAI, representing KAULIN MACHINERY AND ELECTRONIC INDUSTRIAL (NONGBO) CO., LTD. No. 16 Longtanshan Rd. Daqi Tw, Beilun District, Ningbo City, Zhejiang Province, P. R. China, manufacturer, Declares that the machine described hereafter:

Lockstitch Sewing Machine.

Model:L918

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 ISO 10821:2005, EN 60204-1:2006 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: Nov/11/2009

Signature: 

Qualification: R&D MANAGER

General Safety Instructions

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

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

1.Keep work area clean.

Cluttered areas and benches Invite Injuries.

2.Consider work area environment.

Do not expose power to rain. Do not use machine tools in damp or wet locations. Keep work area well lit.

Do not use power tools where there is risk to cause fire or explosion.

3.Guard against electric shock.

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

4.Keep children away.

Do not let visitors touch the tool or extension code.

5.Dress properly.

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

6.Do not abuse the cord.

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

7.Maintain machine with care.

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

8.Disconnect machine

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

9.Acoid unintentional starting.

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

10.Check damaged parts.

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

11.Warning.

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

12.Have your tool repaired by a qualified person.

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

Special Warning For Electric Connection!

1.Incorporate this machine only with "CE" certificate hold-to-run control device.

2.Follow the instruction manual device to install control device.

3.Always earth machine appropriately during operation.

4.Before adjustment, parts change or servicing must be sure to pull out the plug from socket to prevent the hazard of unintentionally start of machine.

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警告！

當使用這台機器，基本安全預防應恆被遵守，以減輕火災、電擊、或是個人傷害的風險。包含以下注意事項。在操作這台機器之前，請閱讀所有說明並且緊記於心。

1. 保持工作場所清潔

雜亂的環境與椅子會招引危害。

2. 考量工作場所環境

物暴露電源於雨水之中、勿在濕氣重的地方或潮濕的場所使用機械器具。保持工作場所良好整齊。當有引發火災或爆炸危險時，勿使用電源工具。

3. 免於電擊危害

避免身體接觸地線或是接地表面。（即：管線，發熱物體，以及冷凍庫）

4. 勿使孩童接近

不要讓訪客碰觸工具或是延伸管線

5. 適當的穿著

不要穿著寬鬆衣物或是穿戴珠寶，這可能被活動零件拉扯而導致危險。穿戴護髮套以包含住長髮。

6. 不要任意拉扯電線

絕不要用電源端拉扯機器，或是從插座猛拉電線來拔掉電線。使電線遠離熱源、油類或是尖銳邊緣。

7. 謹慎保養機器

遵從指示來添加潤滑油或是更換附件。定期檢測工具用線，如果有所損害，請使用合格的維修器具來修復。

Warning!

When using this machine, basic safety Precautions should always be followed to reduce the risk of fire, electric shock and personal injury, including the followings. Read all these instructions before operating this product and save these instructions.

1. Keep work area clean

Cluttered areas and benches invite injuries.

2. Consider work area environment

Do not expose power to rain. Do not use machine tools in damp or wet locations. Keep work area well lit.

Do not use power tools where there is risk to cause any fire or explosion.

3. Guard against electric shock

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

4. Keep children away

Do not let visitors touch the tool or extension code.

5. Dress properly

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

6. Do not abuse the cord

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

7. Maintain machine with care

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

8. **中斷機器電源**
當不使用機器時、維修前、以及更換配件時。
9. **避免誤啓動**
不要以手指置於啓動開關上之後，搬運一個已插入電源的工​​具。確定在插電之前，電源開關是關閉的。
10. **檢查損害零件**
在進一步使用器具之前，應該小心檢查並確認損傷的零件或是穿戴保護器具來確認零件會正確運轉並且呈現應有功能。
11. **警告**
除了在這本使用說明手冊中建議的功能之外，任何附件或是配件的使用，都可能會導致個人傷害的危險。
12. **由合格人員來修理事具**
所以修理工作應由合格的人員使用原始個別零件來作修理。

連接電源的特別警示

1. 只可與有“CE”認證的按壓啓動裝置連接這台機器。
2. 遵守此使用說明手冊來安裝控制裝置。
3. 在操作過程中，永遠保持機器適當的接地。
4. 再調整、更換零件、或是維修保養之前，必須確定將插頭由插座拔出，以預防任何機器意料之外的啓動而造成危害。

8. **Disconnect machine**
When not in use, before servicing and when changing accessories.
9. **Avoid unintentional starting**
Do not carry a plug-in tool with a finger on the switch. Ensure the power switch is off when plugging in.
10. **Check damaged parts**
Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function.
11. **Warning**
The use of any accessory or attachment, other than those recommended in this instruction manual, may present a risk of personal injury.
12. **Have your tool repaired by a qualified person**
Repairs should only be carried out by qualified persons using original spare parts.

SPECIAL WARNING FOR ELECTRIC CONNECTION!

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

重要安全事項說明

恭喜您購買本機器，為了使這台機器能獲得最佳功能以及安全的操作，務必請正確的使用這台機器，使用前請仔細閱讀使用說明書，希望您能長期使用它。請記得將此說明書放在容易取得的地方。



1. 當您使用機器時，除了以下事項外，請注意其他基本安全措施。



2. 使用機器前，除了這本使用說明書外，請詳細閱讀其他相關說明書。此外，請妥善保存此說明書，以便需要時可以隨時取閱。



3. 先確認機器是符合貴國安全規定及標準後，再使用機器。



4. 當機器完成操作準備時，所有安全配備必須安裝就緒，在缺少所述安全配備下操作是不被允許的，以免導致人員受傷。



5. 此機器應由受過適當訓練之操作員操作。



6. 為了安全，我們建議您配戴安全眼鏡。



7. 以下情形，請先關閉電源或拔掉插頭：

(1) 穿針線、導線片、天平等以及更換梭子時。

(2) 更換針、壓具、針板、送具、頂針片、喇叭、車布導板，以及其他附屬配件時。

IMPORTANT SAFETY INSTRUCTION

For operating safely and getting the best functions of this machine, you must operate it correctly. Please read and follow the instructions of this manual, and keep it at hand for future references. We are confident that you will enjoy this machine as much as we enjoy manufacturing it.



1. Instead of the following instructions, when you use this machine, please pay attention to the basic safety measures.



2. Before using this machine, please read this manual and all related instructions. In addition, please keep this manual for future needs.



3. Before using this machine, please ascertain that it conforms with safety standards and regulations of your country.



4. When the machine is ready for operation, all the safety equipments must be ready. Operate this machine without the specified safety devices is not allowed.



5. This machine must be operated by a properly trained operator.



6. For your own safety, we suggest you wearing goggles.






7. Please turn off the power switch or disconnect it for any one of the circumstances of the followings:


(1) When threading needle(s), adjusting thread Take-up(s), thread guide(s), and/or replacing bobbin(s).


(2) When replacing needles, presser feet, needle plates, feed dogs, needle guards, horns, cloth guides and other parts or accessories.


- (3) 維修工作時。
- (4) 離開工作場所或工作場所無人看顧時。
- (5) 若使用離合器馬達而無煞車片裝置時，必須待馬達完全停止。


 8. 假如不慎讓機器及配件使用之油或油脂，接觸到眼睛、皮膚或誤食時，請立刻以水清洗接觸部位及就診。


 9. 請勿擅自碰觸運轉中之零件及配件及注意機器電源是否已開啓，以免導致人員受傷。


 10. 維修、修改及調整等工作，須由受過適當訓練的技師或熟手為之。維修時只許使用指定之零件。


 11. 一般維修及檢查工作必須由受過適當訓練的人員為之。


 12. 電子零件維修及保養工作必須由資深的電子技師為之，或由非常熟練的人員檢查及指導，當發現零件損壞時，請立刻停止機器運轉。


 13. 在做裝有氣動式零件（例如氣缸）機器的維修及保養工作前，機器連接空壓機及高壓空氣必須予以關閉及卸除，機器中殘存高壓氣體必須予以消除，此外調整及性能檢查只能由受過適當訓練的技師或熟手為之。


- (3) When repairing.
- (4) When the operator leaves the working place or leaves the machine unattended.
- (5) If clutch motors without brake pads are used, must wait until the motor stops completely.


 8. If grease, oil, or any fluid contacts your skin or eyes by any chance, please wash the contacted area completely with clean water and consult a doctor. Or, swallow any fluid mistakenly, consult a doctor immediately.






 9. Do not touch any functioning parts and devices. Always attend to whether power switch is on or off before operating in order to prevent anyone from getting hurts.

 10. Qualified technicians are required for adjustment, modification, and repair. Only use assigned parts for replacement.

 11. Routine maintenance and service must be performed by well trained persons, or qualified technicians.

 12. Maintain and check the electronic parts must be done by qualified electrician or well-trained persons. If any electronic part damaged or malfunctioned, stop the machine immediately.

 13. The air house has to be detached from the machine and the compressor or air supply has to be cut off before repairing and servicing the machine equipped with pneumatic parts such as an air cylinder. Qualified technicians or well-trained persons are required for adjustment and repairs.

-  14. 機器使用一段時間，必須定期清理。
-  15. 為使機器能正常操作以及減少噪音，機台務必平放地上，機器避免在強烈噪音的環境下操作。
-  16. 選用適當的電源插頭，並由電子技師將其安裝在機器上，且插頭必須插在接地線之插座上。
-  17. 機器只允許被使用於指定用途上，其他用途是不允許的。
-  18. 修改或變更機器必須依照安全規定及標準，同時採取有效的安全措施或變更機器所引起損壞之責。






19. 警告提示以兩種符號標示：



- (1) 對操作員或服務人員之傷害危險，也為了避免觸電之危險，請勿打開馬達電器箱之外蓋，也不要觸摸電器箱裡面之零件。



- (2) 必須特別注意事項
- a. 絕對不可在移動皮帶蓋，手指保護蓋或安全配件後，進行機器操作，以免導致人員受傷。

-  14. To ensure the best performance, periodically clean the machine is necessary.
-  15. In order to operate properly and to reduce the noise, please place the machine flat and level on the ground. Avoid operating the sewing machine at a noisy surrounding.
-  16. Select a proper power plug and install it by an electrician. Please connect the power plug to a grounded receptacle.
-  17. This machine can only be used for the designed purpose. Other uses of this machine are not allowed.
-  18. Any modification or conversion made on this machine must be conformed with the safety standards and regulations. Precaution is necessary. No responsibility will our company take for damages caused by any modification or conversion of this machine without permission.

19. Two safety warning signs are applied as warning signs:



- (1) For the safety of operators and service persons, please don't open the cover of any electronic control boxes of motor or other devices and don't touch any components inside to avoid electrical shock hazards.



- (2) Always keep in mind:
- a. Please never operate this machine without belt cover, finger guard or any safety device to avoid physical injury.



- b. 為了避免被機器纏住，當機器運轉中，您的手、頭髮及衣服，需遠離手輪，皮帶及馬達；此外這些部位周圍不可放置任何物品，以免導致人員受傷。



- c. 當您打開電源開關後或機器已在運轉中，絕不可將您的手放在針的下方或針線控線桿外蓋中，以免導致人員受傷。



- d. 當機器運轉中，梭頭高速轉動，為了避免對手可能引起之傷害，必須確定您的手保持遠離梭頭附近。此外，當更換梭子時，確定電源開關已關閉，以免導致人員受傷。



- e. 當放置或抬起機器時，小心勿將手置於機器中，以免導致人員受傷。



- f. 為了避免機器突然啓動而引起可能意外，當機頭傾斜或移開皮帶蓋及皮帶時，請關掉機器電源，以免導致人員受傷。



- g. 如果您的機器是配置伺服馬達，機器於靜止狀態時，馬達是不會產生噪音的，為了避免機器突然啓動而引起可能意外，故請關掉機器電源。



- b. Please keep your hair, fingers and clothes away from the hand wheel, V belt and motor while the machine is in operation, as well as never put anything near these parts, to prevent the risk of injuries by tangled into them.



- c. Please never put your fingers under the needle(s) or in the thread take-up cover to prevent physical injuries when you turn on the power switch or operate the machine.



- d. While the machine is in operation, the hook rotates at a high speed. Please keep your hands away from the area of hook to prevent any potential injury to your hands. In addition, please make sure to turn off the power of the machine while changing bobbins.



- e. Be careful and do not place your fingers inside the machine when placing or lifting the machine head to avoid possible physical injuries.



- f. Please turn off the power before tilting the machine head or removing the belt cover and the V belt to avoid possible accidents due to abrupt start of this machine.



- g. For machine equipped servo motors, the motors do not produce noise while the machines are at rest. Therefore, please turn off the power of this machine to avoid possible accidents due to abrupt start of the machine.



h. 為了避免觸電之危險，請絕不要在移開電源接地線後操作機器。



i. 為了避免觸電或電子零件損壞而引起之可能意外，請先切斷電源，再插上或拔掉插頭。



h. Never operate the sewing machine after the ground wire is removed to avoid electrical shock hazards.



i. Please turn the power switch off before connecting or disconnecting the power plug to prevent possible accidents due to electric shock or damaged electronic components.

特別事項

WARNING

為了避免機器故障及損壞，請先確定以下事項：



1. 當您安裝好機器後，做第一次機器操作前，請徹底清潔機器。



2. 清除運送途中累積之灰塵及溢出之油脂。



3. 確定電壓及馬達相數（單相或三相）安裝正確。



4. 確定電源插頭正確地接上電源。



5. 當使用電壓與標示電壓不同時，請勿使用機器。



6. 確定機器轉動方向是否正確。



警告：

在操作或調整本書中所提到之各步驟前，請先將電源關掉，以免因為機器突然啟動造成之意外。

Please confirm the followings to avoid malfunction or damage to this machine.



1. After installing the machine, and before the first operation, please clean it completely.



2. Clean all dust and overflowed oil during transportation.



3. Confirm that the voltage and the phase (single or 3 phase) of motor are set correctly.



4. Confirm that the power plug is correctly connected to the power supply.



5. Never use the machine when the local voltage type is different from the marked voltage on the nametag attached on the machine.



6. Confirm that the rotating direction of the machine pulley is correct.

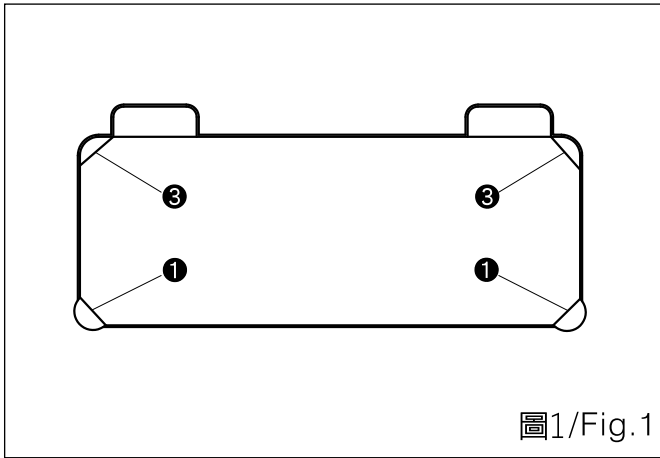


Warning:

Before doing any operation or any adjustment described later in this manual, please turn the power off to prevent accidents caused by abrupt start of the sewing machine.

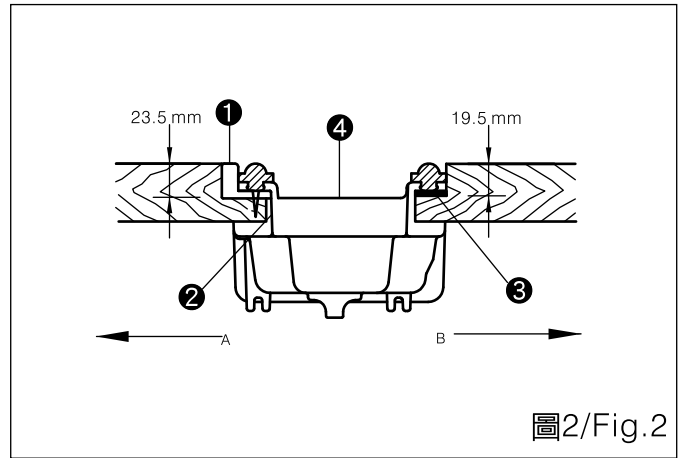
油盤安裝

1. 油盤必須放置於桌板凹槽中之四角。(圖 1)
2. 用下圖所示之釘子②，將兩個橡皮墊①固定於 A 邊(操作具方向)，再用底質為橡膠之膠帶將兩個緩衝墊③固定於 B 邊(有鉸鍊的方向)，然後再將油盤④放上。(圖 2)



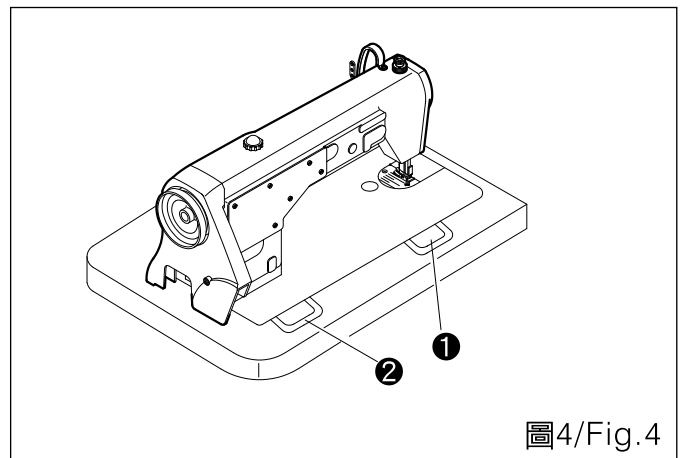
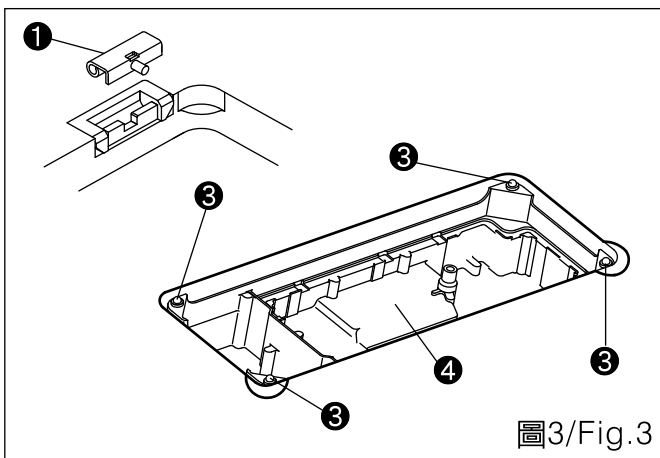
OIL PAN INSTALLATION

1. The corners of the oil pan has to place on the four corners at the cut groove of the machine table (Fig.1)
2. Use nails ② as illustrated to fix two rubber seals ① on side A (the operator's side). Use rubber based adhesive to fix two cushion ③ seats on the living side (side B). Place oil pan ④ on the fixed seals. (Fig.2)



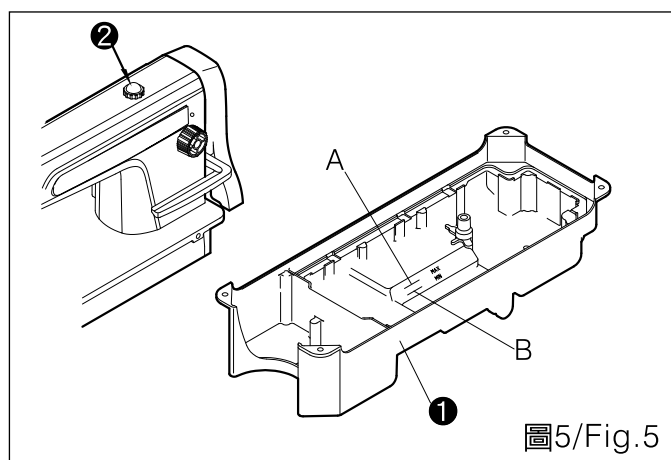
3. 在將機頭放進四個角的緩衝墊③之前，先將鉸鍊①裝進機座兩個固定孔中，再將機頭安裝於桌板相對裝有橡膠墊②之二個開口中。(圖 3、4)

3. Place the hinge ① into the two fixing holes before placing the machine head onto the four cushions ③ of the desk. Then, install the machine head onto the machine bed that has two openings with rubber cushion ② of each. (Fig. 3, 4)



1. 潤滑說明 (圖 5)

- (1) 使用專用油注入油盤中，液面到高點 A。
- (2) 當液面低於低點 B 時，再添加所指定之潤滑油。
- (3) 如果潤滑正常，當機器操作中，你可以從油盤 2 中看到噴油現象。
- (4) 當新機器第一次運轉，或經過一段時間未使用，前 10 分鐘試車之轉速，請保持在 3000 到 3500SPM 之間。

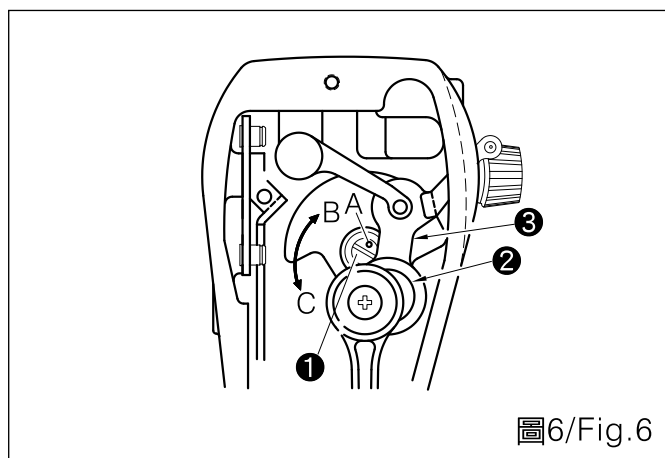


2. 針棒 / 挑線桿供油量之調整 (圖 6)

- (1) 由調整栓①調整針棒曲柄② / 挑線桿③之供油量。
- (2) 將調整栓①順著 B 方向調整，使 A 點靠近針棒曲柄②，則供油量減少。
- (3) 將調整栓順著 C 方向調整，使 A 點離開針棒曲柄②，則供油量增加。

1.Oil lubrication instruction (Fig.5)

- (1) Fill the oil pan with specified oil up to high mark A.
- (2) If the oil level is lower than the low mark B, refill the oil pan with the specified oil.
- (3) You will see oil splashing via oil sight window 2 if the lubrication functions is well when machine runs.
- (4) When running the machine at first time or after a period of time, please run your machine at 3000 to 3500 SPM for about 10 minutes.



2. Oil supply adjustment for needle bar/ thread take-up lever (Fig. 6)

- (1) Turning adjust pin ① to adjust the supplied oil volume to the needle bar crank ② and the thread take-up ③ .
- (2) To decrease supplied oil amount, turn the adjust pin ① in direction B to make the mark A close to the needle bar crank ② .
- (3) To increase the supplied oil amount, Turn the adjust pin ① in direction C to make the mark A away from the needle bar crank ② .

縫紉機的安裝位置

3. 梭頭油量（噴油量）之調整

(1) 油量確認試紙。約 25mm × 70mm，可使用任何材質之試紙。（圖 7）

(2) 確認油量位置。將試紙靠緊油盤壁，將油量確認試紙置於梭頭下方。（圖 8）

① 梭頭 ② 紙 ③ 油盤
④ 梭觸點 ⑤ 底座 ⑥ 襯套

當進行第 (2) 步驟時，移開滑板並非常小心，勿使手指觸及梭頭。

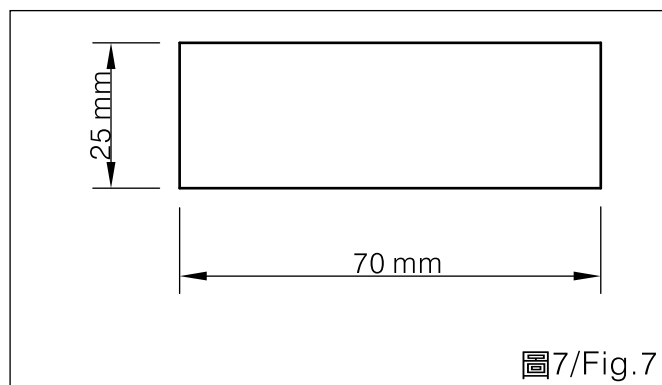
4. 注意事項：

(1) 如機器尚未充分熱機，請先將機器空轉 3 分鐘暖車。

(2) 在機器運轉中，將油量確認試紙置於梭頭下方。（圖 8）

(3) 確認油盤油量（油面）介於「高」與「低」刻度間。

(4) 必須在 5 秒鐘內完成確認油量之動作（用手錶測時間）。



5. 適當油量顯示範例（圖 9）

梭頭噴油量約 1mm 適當油量（小）

L818-H: 3mm

L818-M: 1.5mm

L818-L: 0.5mm

THE INSTALLATION POSITION

3. Adjust the oil amount of the hook (oiling Amount).

(1) Oil splashing test paper is about 25mm × 70mm. Any material of test paper is accepted. The material will not affect results. (Fig. 7)

(2) Confirm the oil amount. Place the test paper under the hook and fit the paper closely against to the wall of the oil pan. (Fig. 47)

① HOOK ② PAPER ③ OIL PAN
④ TOUCHING ⑤ BASE ⑥ BUSHING

When doing step (2), carefully remove the sliding plate and do not touch the hook with fingers.

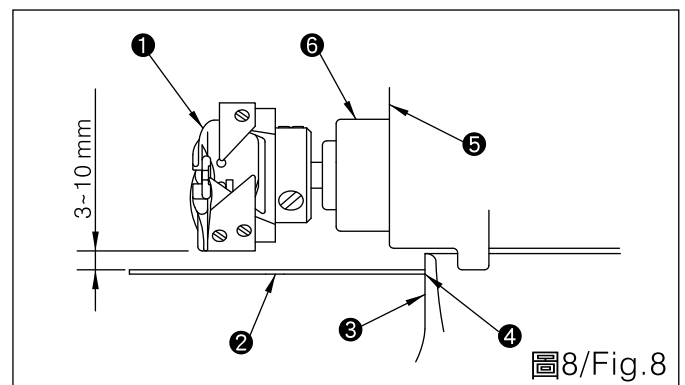
4. Attentions:

(1) If the machine doesn't warm up enough, please run the machine 3 minutes idly.

(2) While the machine is running, place the oil splashing test paper under the hook. (Fig. 8)

(3) Confirm that the height of the oil level in the oil pan falls between "HI" and "LOW".

(4) Oil splashing observation test should be completed in 5 seconds. (Use a watch to check the time used.)



5. A sample of observations indicate the appropriate oil amount. (Fig. 9)

Oil amount in the hook (small) as shown is approximated 1mm.

L818-H: 3mm

L818-M: 1.5mm

L818-L: 0.5mm

梭頭噴油量約 2mm 適當油量 (大)

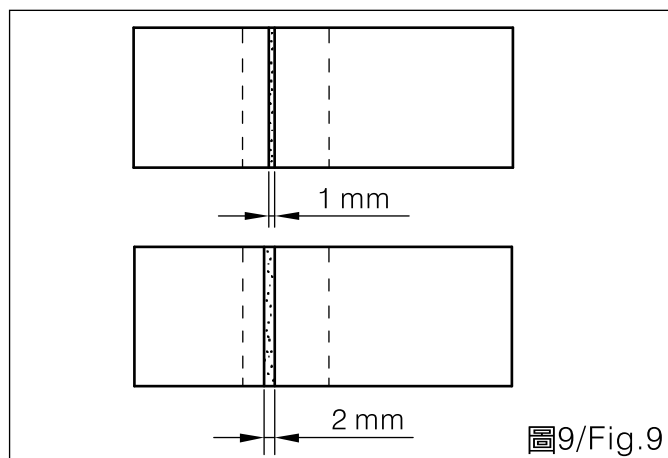
L918-H:6mm

L918-M:3mm

L918-L:1mm

(1) 油量顯示範例必須根據車縫布料與程序加以調整，切勿使梭頭油量過多或過少。油量過少，梭頭將卡住 (梭頭將發熱) ；油量過多，車縫物將可能沾染油污。

(2) 調整梭頭油量，油量必須達到 3 次測試都相同 (在 3 張試紙上) 。



OIL amount in the hook (large) as shown is approximated 2mm

L918-H:6mm

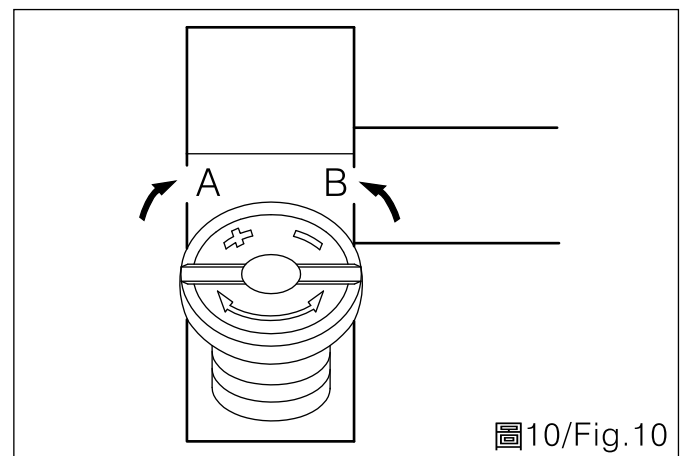
L918-M:3mm

L918-L:1mm

(1) The amount of oil in the hook (ref. to the sample shown on Fig. 9) should be Adequately adjusted according to the sewing materials and processed.

Insufficient amount of oil will cause the hook to cease and overheat. Excess amount of oil may cause the sewing product stained with oil.

(2) Adequate adjustment should be reached in the way that same oil splashing observation will be collected in 3 ties on separate paper.



梭頭油量調整

1. 轉動裝在梭頭傳動大心上之油量調整螺絲，轉向 "+" 號方向 (順著 A 方向) 油量增加；轉向 "-" 號方向 (順著 B 方向) 油量減少。(圖 10)

2. 梭頭油量適當調整後，將機器空轉 30 秒，以重新檢查確認梭頭油量。

ADJUSTING THE AMOUNT OF OIL IN THE HOOK

1. The oil amount adjustment screw is mounted on the hook driving shaft. Turn the screw counter clockwise toward "+" direction (A direction) to increase the amount of oil supplied in the hook. Turn the screw clockwise toward "-" direction (B direction) to reduce the amount of oil supplied in the hook. (Fig. 10)

2. After the amount of oil in the hook is properly adjusted, run the machine idly for 30 seconds to do oil splashing observation test to reconfirm the amount of oil in the hook.

針的安裝

請依線規格及布料選用正確型號的針。先關掉電源，再開始安裝針。（圖 11）

1. 轉動手輪使針棒位於行程最高點。
2. 放鬆螺絲②並握住針①，使其針頸內弧部份 A 正確面向右方 B。並檢視針之長溝 C 確實面向左 D。
3. 依箭頭方向，將針插入針鑿並插到底。
4. 確實鎖緊螺絲②。

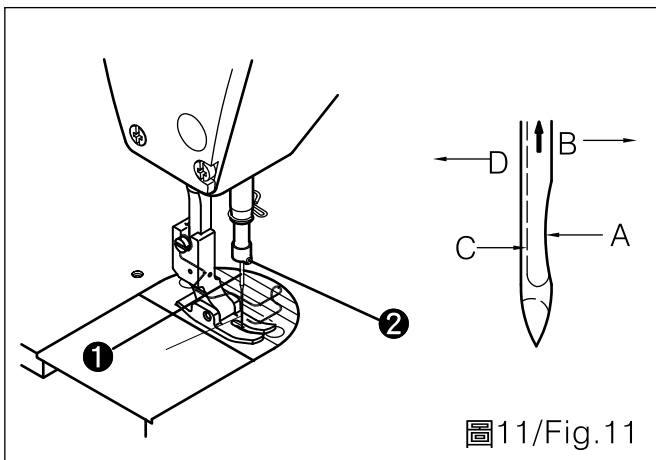


圖11/ Fig. 11

INSTALLING THE NEEDLE

Choose a right needle size according to the type of the thread and the type of the material used. Turn the power off before placing the needle. (Fig. 11)

1. Turn the hand wheel to raise the needle bar to its highest position.
2. Loosen screw ②, and hold the needle ① with its indented side A facing exactly to right in direction B, and make sure that long groove C of the needle is facing exactly to the left in direction D.
3. Place the needle into the hole on the needle bar all the way to the end of the hole in the arrow direction.
4. Firmly lock screw ②.

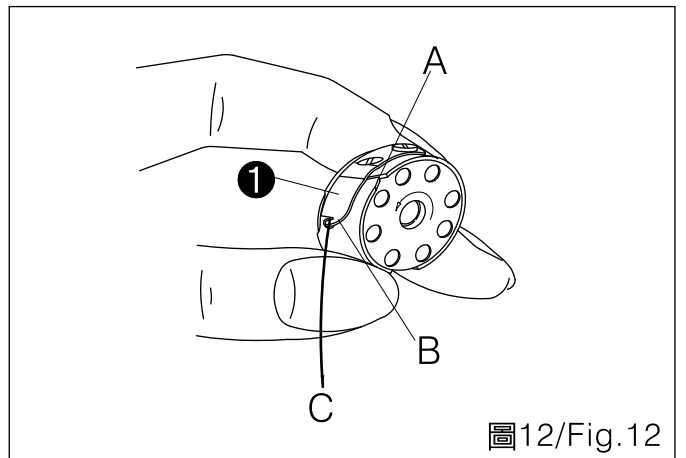


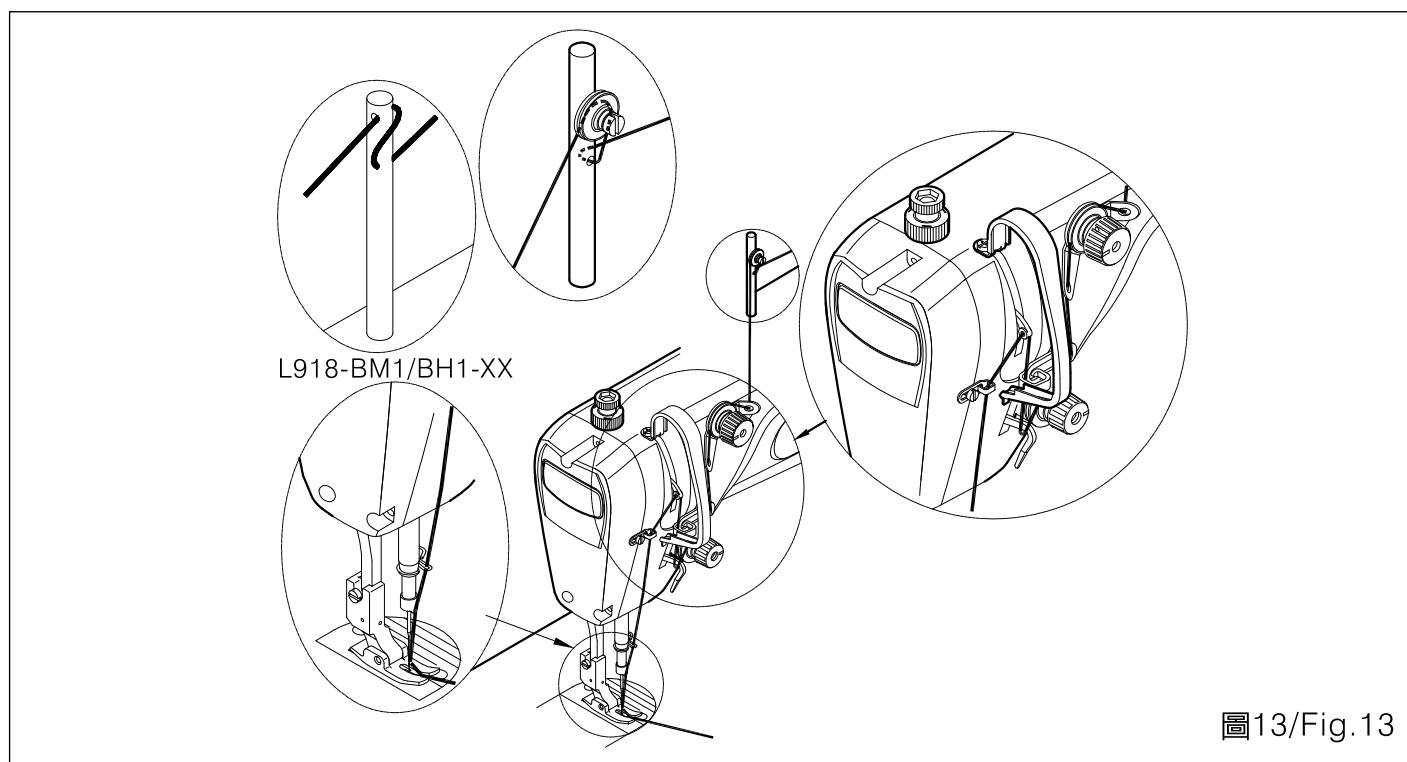
圖12/ Fig. 12

梭子之安裝

1. 安裝梭子於梭殼中，使捲線方向為如圖示方向。（圖 12）
2. 將針線穿過縫隙 A 處，並朝 C 方向拉線，如此，針線將穿過壓力彈簧①，並由 B 處缺口穿出。
3. 當向 C 拉線時，梭子是順著箭頭所指方向轉動。

SETTING THE BOBBIN

1. Set the bobbin in the bobbin case in the way that the thread wound direction is clockwise. (Fig. 12)
2. Pass the thread through thread slit A, and pull the thread in direction C. The thread will be pulled under the tension spring ① and will be pulled out from notch B.
3. Be sure the bobbin rotates in the direction as the arrow shows when thread is pulled toward C.

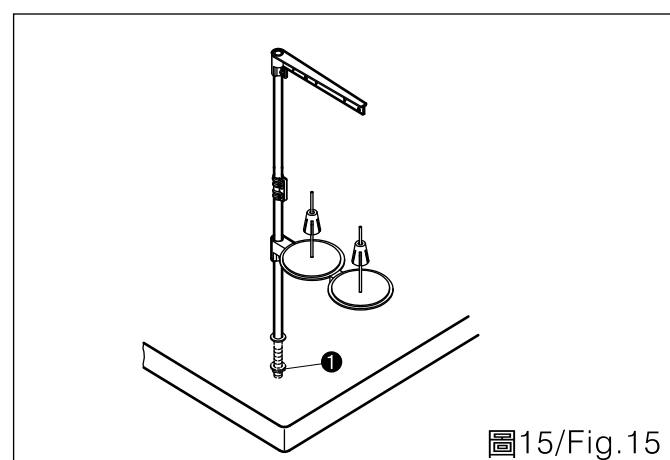
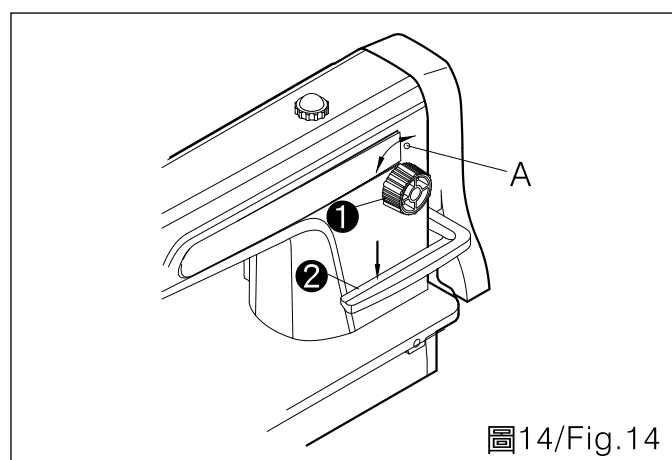


針距調整

STITCH LENGTH ADJUSTMENT

1. 依箭頭指示方向轉動縫距調整鈕①，並將所需數字對準標點 A。（圖 14）
2. 調整鈕上刻度單位是公厘。
3. 當要調整縫距時，轉動縫距調整鈕①，同時將搖桿②往下壓。

1. Turn stitch length dial ① as the arrow indicates to have the desired number align with mark A on the machine (Fig. 14)
2. The calibration on the dial is millimeters.
3. Press the feed lever ② down and turn the stitch length adjustment dial ① to change stitch length.



線架安裝

1. 安裝線架組，並將其插入桌板孔(圖15)。
2. 鎖緊螺帽①，以固定線架。

THREAD STAND ASSEMBLY

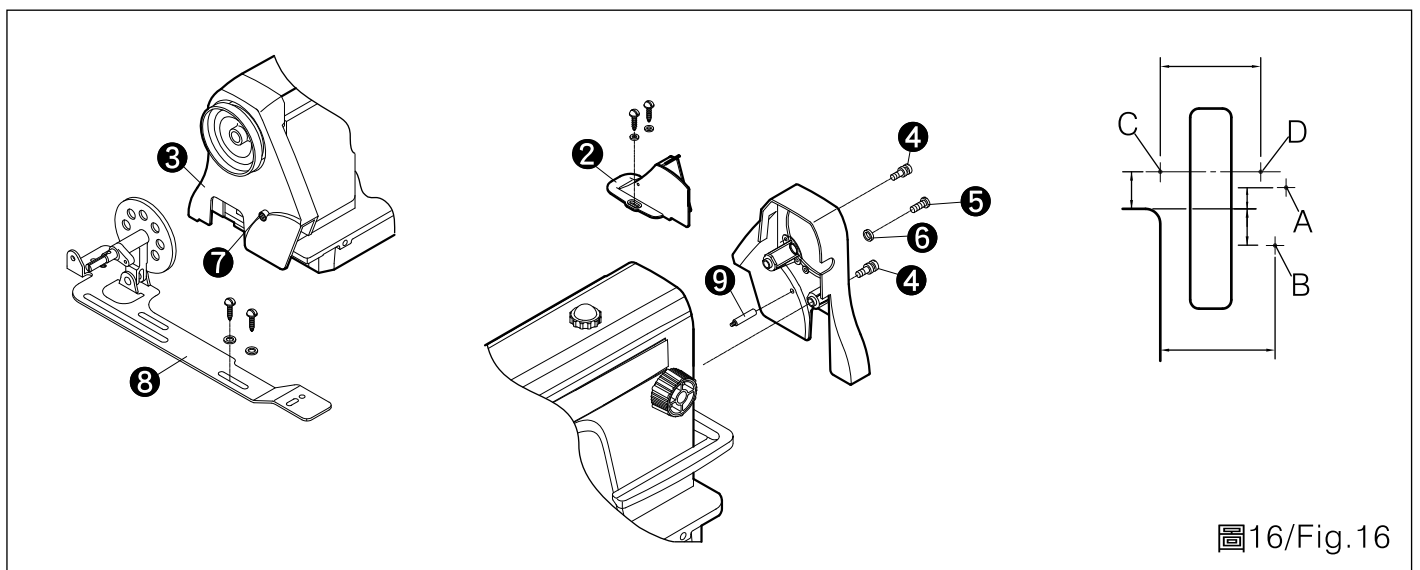
1. Assemble the thread stand set before installing. Place the thread stand set onto the hole on the table top. (Fig. 15)
2. Fix the thread stand with a nut ① locked under the table top.

皮帶蓋及梭子捲線器之安裝

1. 在桌上鑽四個定位孔 A、B、C、D。(圖16)
2. 將皮帶蓋支撐桿裝入栓孔中。
3. 將皮帶蓋③傾斜，由手輪後方成對角線裝上手輪。
4. 將皮帶蓋②，放在 C、D 兩定位孔上。
5. 用④，⑤螺絲及⑥墊片，將皮帶蓋固定於機體上並鎖緊。
6. 將⑦裝上皮帶蓋③。
7. 向後移動皮帶蓋②，使其橡膠觸及皮帶蓋③，以木螺絲及墊片，將皮帶蓋②固定。
8. 將梭子捲線器⑧固定於定位孔 A、B 上。

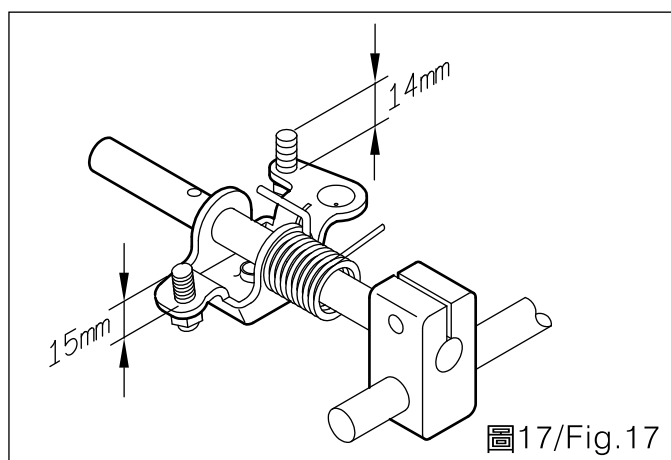
THE BELT COVER AND THE BOBBIN WINDER MOUNTING

1. Grinding holes A, B, C, D on the table top. (Fig. 16)
2. Insert the belt cover support into the bolt hole on the machine.
3. Tilt the belt cover ③ then you can install the hand wheel diagonally from the rear of the hand wheel.
4. Put belt cover ② on locating holes C and D.
5. Use screws ④, ⑤ and washer ⑥ to fix the belt cover on the machine body and lock the screws tightly.
6. Place the ⑦ to the belt cover ③.
7. Move the belt cover ② backward and have its rubber cushion touch the belt cover ③. Fix the belt cover ② by wooden screw and cushion.
8. Mount bobbin winder ⑧ to holes A and B on the table top.



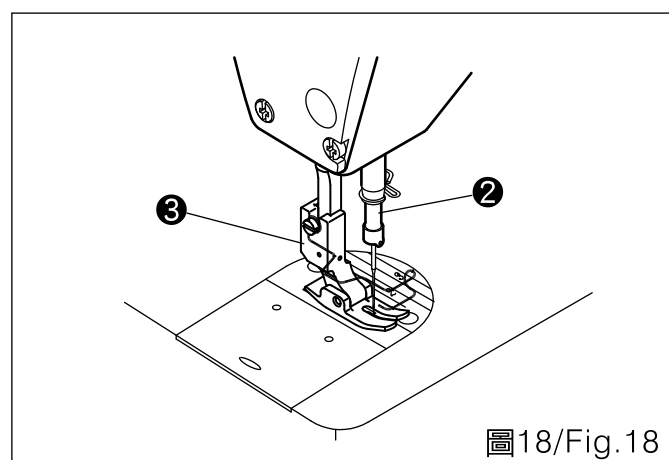
膝控壓具提升器之調整

1. 使用膝控壓具提升器，標準的壓具提升高度是 10mm。（圖 17、18）
2. 可以使用膝控壓具提升器調整螺絲①，將壓具提高至 13mm。
3. 當壓具調整高度超過 10mm 時，請確認針棒最底部②是否會觸及壓具③上部。



ADJUSTMENT OF KNEE-CONTROL PRESSER FOOT LIFTER

1. The standard lifting height is 10 mm by using knee-control presser foot lifter. (Fig.17, Fig.18)
2. V adjusting the screw ① at the knee controller, the presser foot can be lifted up to 13 mm.
3. When the presser foot is adjusted to be lifted over 10 mm, assure the bottom end of the needle bar ② in its lower position ③ does not hit the presser foot.



腳踏板之操作

腳踏板依以下四步驟操作：（圖 19）

1. 輕踩踏板，如 B，機器將以低速運轉。
2. 進一步重踩踏板前方時，如 A，機器以較高速運轉（如果預先設定有自動倒縫功能，機器將在完成倒縫後再高速運轉）。
3. 踏板恢復至原位置，如 C，機器暫停轉動（針在上或下）。
4. 將踏板完全向後踩，如 E，機器進行切線動作。

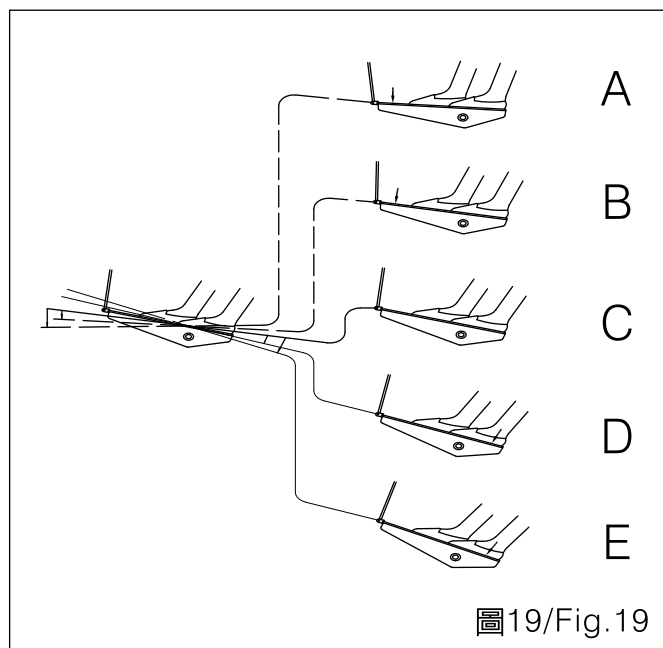
OPERATING THE PEDAL

The foot pedal is operated as the following 4 steps. (Fig. 19)

1. Lightly tread the front part of the foot pedal shown as B in Fig. 32, machine runs at low sewing speed.
2. Further, tread the front part of the foot pedal shown as A. Machine runs at high sewing speed. (The machine runs at high speed after it completes the backstitch if the automatic backstitch has been preset.)
3. Reset the pedal to its original position, shown as C. Machine will stop (with the needle up or down.)
4. Fully depress the back part of the pedal shown as E, so that machine trims threads.

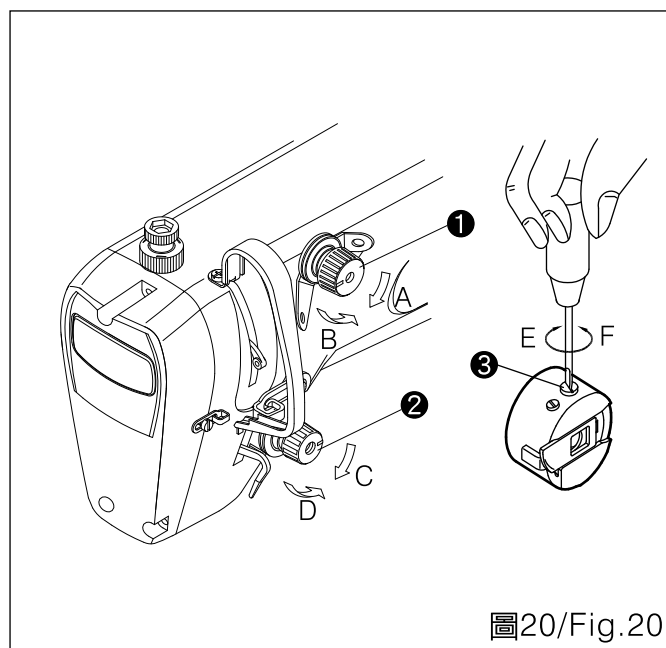
5. 注意事項：

- (1) 如果你的機器附有壓具自動提升器，機器停止與切線動作之間會多了一個步驟，即當你輕輕後踩腳踏板，如 D，壓具向上提升，再往下踩，執行切線動作。
- (2) 當倒縫動作執行時，如果將腳踏板回復到原位置，機器會在倒縫動作完成後才停止。
- (3) 即使機器在高速或低速中，只要立刻將腳踏板往後踩，它都會執行正常的切線動作。
- (4) 如果在機器執行切線動作後，即使立刻將腳踏板恢復原位置 C，機器仍將完成切線動作。
- (5) 當針停在下定位時，如果要將針上提，則將腳踏板後踩一次至 D 位置即可。



5. Attentions:

- (1) One extra step is given between the machine stop and thread trimming steps if your machine is equipped with the auto presser foot lifter. When you lightly depress the back part of the pedal, shown as D, the presser foot goes up. The thread trimmer actuates if you further tread the back part of the pedal.
- (2) Machine will stop after completing the backstitch if you relocate the pedal to its neutral position during executing the automatic backstitch.
- (3) Whether the machine is under high speed or low speed sewing, you can make the machine doing thread trimming any time by thread down the back part of the pedal to do so.
- (4) Even if you reset the foot pedal to its neutral position C immediately after the machine started thread trimming action, the machine will completely perform thread trimming.
- (5) When the machine stops and makes the needle located at the lower dead end, tread the back part of the foot pedal once to D if you want to bring the needle up.



針線梭線鬆緊度調整

1. 針線鬆緊度調整 (圖 20)

- (1) 依順時鐘方向 (A 方向) 轉動針線鬆緊控制鈕①, 切線後留在針頭之線量變短。
- (2) 依逆時鐘方向 (B 方向) 轉動針線鬆緊控制鈕①, 線量變長。
- (3) 依順時鐘方向 (C 方向) 轉動針線鬆緊控制鈕②, 針線鬆緊度變緊。
- (4) 依逆時鐘方向 (D 方向) 轉動針線鬆緊控制鈕②, 針線鬆緊度變鬆。

2. 梭線 (底線) 鬆緊度調整

- (1) 依順時鐘方向 (E 方向) 轉動鬆緊控制螺絲③, 底線鬆緊度變緊。
- (2) 依逆時鐘方向 (F 方向) 轉動鬆緊控制螺絲③, 底線鬆緊度變鬆。

NEEDLE THREAD/BOBBIN THREAD TENSION ADJUSTMENT

1. Needle thread tension adjustment (Fig. 20)

- (1) The left thread tail on the needle will be shorter after thread trimmed as you turn thread tension nut ① clockwise. (In A direction)
- (2) The left thread tail will be longer, as thread tension nut ① is turned counter clockwise (in B direction).
- (3) Increase the tension on needle thread by turning thread tension nut ② clockwise (in C direction).
- (4) Reduce the tension on needle thread by turning thread tension nut ② counter clockwise (in D direction).

2. Bobbin thread tension adjustment

- (1) The bobbin thread tension will be increased as tension adjust screw ③ is turned clockwise (in E direction).
- (2) The bobbin thread tension will be reduced as screw ③ is turned counterclockwise. (In F direction).

控線組彈簧調整

1. 控線組彈簧①行程調整 (圖 21)

- (1) 放鬆螺絲②。
- (2) 依順時鐘方向 (A 方向) 轉動鬆緊控制鈕③, 控線組彈簧行程將增加。
- (3) 依逆時鐘方向 (B 方向) 轉動鬆緊控制鈕③, 控線組彈簧行程將減少。

2. 控線組彈簧①拉力調整

- (1) 放鬆螺絲②, 同時將控線彈簧組⑤拆下。
- (2) 放鬆螺絲④。

THE THREAD TAKE UP SPRING ADJUSTMENT

1. Adjusting the stroke of thread take up spring ①. (Fig. 21)

- (1) Loosen screw ②.
- (2) The stroke of the thread take-up spring will be increased as the tension knob ③ is turned clockwise (in A direction).
- (3) The stroke will be decreased as the knob ③ is turned counter-clockwise (in B direction).

2. Adjusting the pressure of thread take up spring ①.

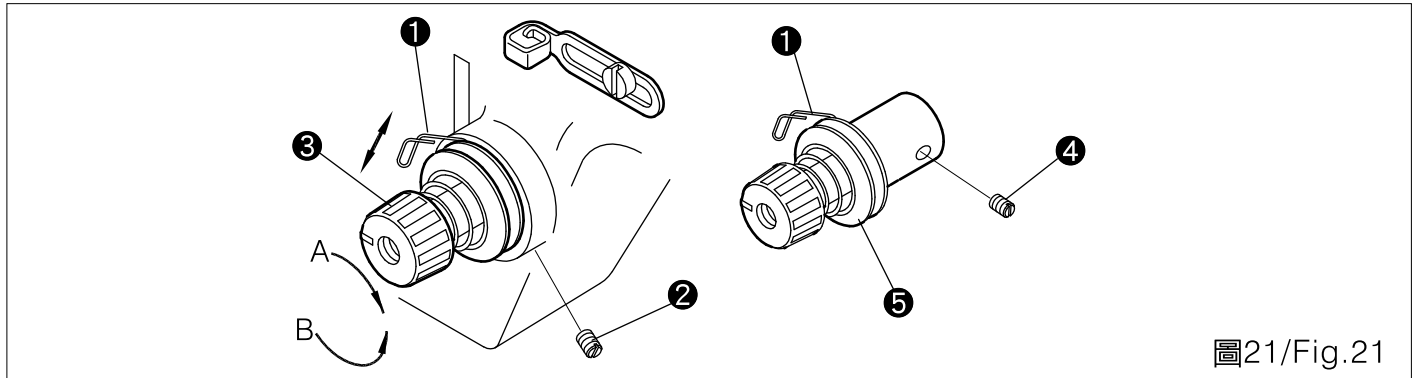
- (1) Loosen screw ②, and remove thread tension disks ⑤.
- (2) Loosen screw ④.

(3) 依順時鐘方向 (A 方向) 轉動鬆緊控線鈕③，控線組彈簧拉力將增加。

(4) 依逆時鐘方向 (B 方向) 轉動鬆緊控線鈕③，控線組彈簧拉力將減少。

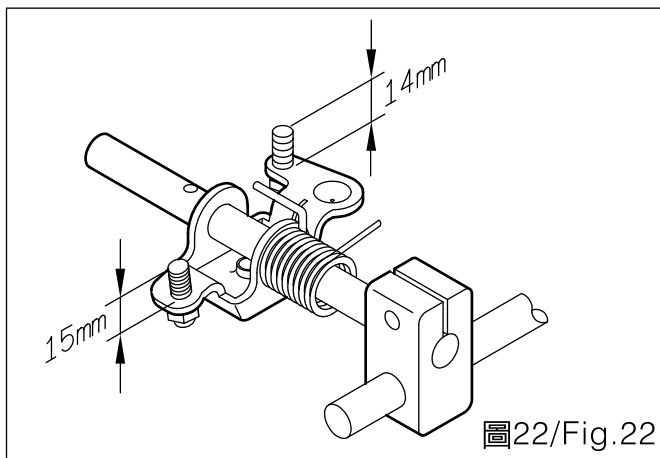
(3) The pressure will be increased as tension knob ③ is turned clockwise (in A direction).

(4) The pressure will be reduced as tension knob ③ is turned counter clockwise (in B direction).



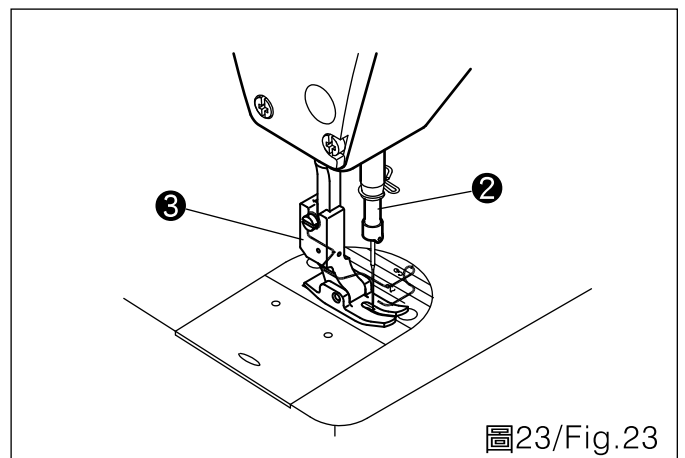
壓具提升桿

1. 將機器停止，順著 A 方向轉動壓具提升桿①。（圖 22）
2. 壓具往上提升約 5.5mm，並固定之。當順著 B 方向往下轉動壓具提升桿時，壓具將降回至原位置。



MANUAL PRESSER FOOT LIFTING LEVER

1. Stop the machine and turn the presser foot lifting lever ① up (in A direction) to keep it up. (Fig. 22)
2. The presser foot will remain at that position. Turn hand lifter lever ① down (in B direction) to release presser foot to its original position.



壓具壓力調整

1. 放鬆螺母②，依順時鐘方向 (A 方向) 轉動壓具壓力調整鈕①時，壓力增加。（圖 23）

ADJUSTING PRESSER FOOT PRESSURE

1. Loosen nut ②, turn presser spring regulator ① clockwise (in A direction) to increase the presser foot pressure. (Fig.23)

2. 依逆時鐘方向 (B 方向) 轉動壓具彈力調整鈕①時，壓力減少。
3. 調整完畢，鎖緊螺母②。一般布料壓具壓力調整鈕之調整壓力為 5kg，厚布料為 7kg。(依布料之厚薄，適當調整壓具之壓力，才能得最佳之車縫效果)

2. Turn presser spring regulator ① counter clockwise (in B direction) to reduce the presser foot pressure.
3. Lock nut ② after adjustment is done. For regular fabric, the normal pressure of the presser foot should be set at 5kg, for heavy fabric is 7kg. (To have the best sewing result, please adjust the proper presser foot pressure according to the material.)

送具時位調整

1. 放鬆偏心凸輪①上之②及③螺絲，再依箭頭或反箭頭方向轉動偏心凸輪①後，再鎖緊螺絲。(圖 24)
2. 一般標準調整，是當送具下降至針板面時，將送具齒端上緣及針之針孔上緣調整與針板上緣成一線。
3. 如果布料送料不足，將偏心凸輪依箭頭方向轉動，把送具時間提前。
4. 如欲增加車縫緊度，則將偏心凸輪依反箭頭方向轉動把送具時間延後。

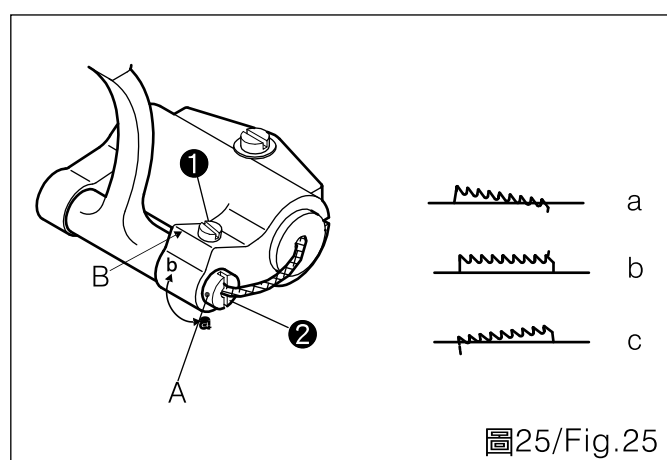
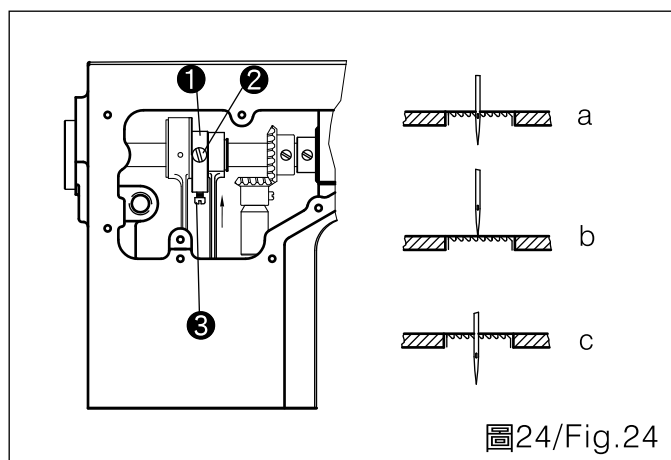
注意：
不可將偏心凸輪移動過大，以免可能引起斷針。

FEED TIMING ADJUSTMENT

1. Loosen screws ② and ③ on the feed eccentric cam ①, move the feed eccentric cam ① in the direction of the arrow or the opposite direction of the arrow, and lock the screws firmly. (Fig. 24)
2. The standard adjustment is to level the top surface of feed dog and the top end of needle eyelet with the top surface of needle plate when feed dog descends below the needle plate.
3. If the fabric fed is not enough, advance the feed timing by moving the feed eccentric cam in the arrow direction.
4. To increase stitch tightness, extend the feed timing by moving the feed eccentric cam in the opposite direction of the arrow.

Attention:

Please do not move the feed eccentric cam ① too far to avoid needle breakage.



送具傾斜度

1. 當在送料具軸上的 A 與 B 成一線時，送具之傾斜度即成水平狀態。（圖 25）
2. 為了避免車縫起皺，以螺絲起子放鬆螺絲①，將送具偏心軸②依箭頭方向轉動 90 度，可降低送具箭頭傾斜度 a。
3. 為了避免布料送料不足，將送具偏心軸②依箭頭反方向轉動 90 度可降低送具後傾斜度 c。（厚布料調整時）
4. 送具傾斜度調整過後，壓具高度會改變，所以送具傾斜度調整後須再檢查其高度。

送具高度

1. 送具出廠調整高度為突出針板面（圖 26）
一般形式：0.85~0.95mm
厚布料：1.0~1.2mm
薄布料：0.75~0.85mm
2. 如果送具太過突出，車薄布料時可能引起皺紋。
3. 送具高度調整：
(1) 放鬆曲柄①螺絲②。
(2) 上下移動送具座加以調整。

(3) 再鎖緊螺絲②。
4. 勿使滑塊③與曲柄①之開口部份銜接不緊，否則曲柄①之開口部分將會磨損。

ADJUST THE ANGLE OF TILT OF THE FEED DOG

1. When mark A on the feed bar shaft ② is aligned with mark B, the angle of the feed dog becomes horizontal. (Fig. 25)
2. To prevent fabric from puckering, loosen the screw ① by a screw driver and turn the feed dog eccentric shaft ② 90 ° in the direction of the arrow to reduce the front tilt angle of the feed dog.
3. To prevent uneven fabric feeding, please turn the feed dog eccentric shaft ② 90 ° opposite to the arrow direction. This could decrease the backward tilt angle of the feed dog "c". (While adjusting for the thick materials).
4. After adjusting the tilt angle of the feed dog, this will change the height of the feed dog. Therefore, please recheck its height after adjusting the tilt angle of the feed dog.

ADJUSTING THE HEIGHT OF THE FEED DOG

1. The original set height of the feed dog is to have it just emerges from the needle plate. (Fig.26)
Normal fabric: 0.85~0.95 mm
Heavy fabric: 1.0~1.2 mm
Thin fabric: 0.75~0.85 mm
2. For sewing the fabric, fabric puckering may result if the feed dog jut out too much.
3. To adjust the feed dog height:
(1) Loosen screw ② on crank ① .
(2) Move the feed bracket up and down to adjust to get the best position.
(3) Lock the screw ② securely.
4. The crank's ① opening will be worn out if the clamping pressure between roller ③ and crank ① is not enough.

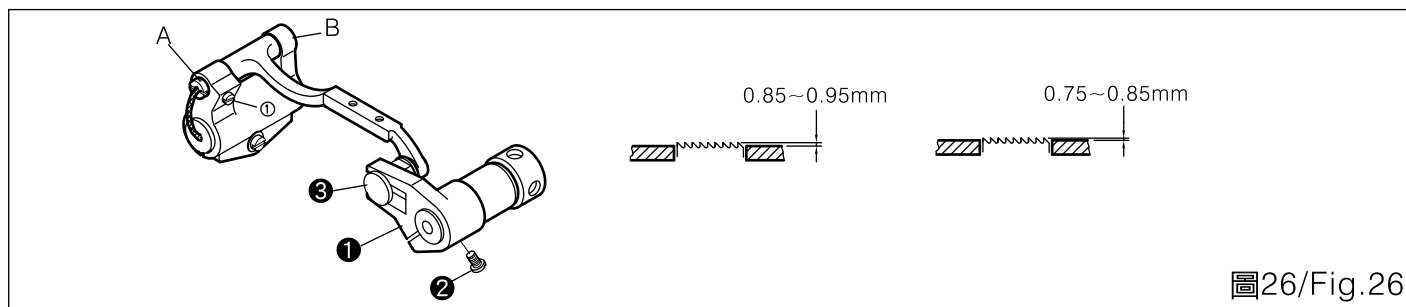


圖26/Fig.26

針與梭頭時位關係

1. 針與梭頭時位調整如下：轉動手輪使針棒降至最低點（下死點），並放鬆螺絲①。（圖 27）

(1) 調整針棒高度：

(DB 針) 將針棒②上之標線 A 對齊針棒下襯套③底部，然後鎖緊固定螺絲①。

(DA 針) 將針棒②上之標線 C 對齊針棒下襯套③底部，然後鎖緊固定螺絲①。

(2) 調整梭頭之位置：

(DB 針) 放鬆梭頭之 3 個固定螺絲，轉動手輪將針棒②上之標線 B 對齊針棒下襯套③底部。

(DA 針) 放鬆梭頭之 3 個固定螺絲，轉動手輪將針棒②上之標線 D 對齊針棒下襯套③底部。

(3) 經上述調整步驟後，將梭頭尖⑤與針中心④對齊，且車針與梭頭尖之間隙為 0.05~0.1mm 最為適當。

CORRELATION BETWEEN NEEDLE AND HOOK

1. The timing adjustment between needle and hook is: turn the hand wheel to lower the needle bar down to the lower dead point of its stroke, and loosen the screw ①. (Fig. 27)

(1) Adjusting the height of needle bar:

- (DB needle) Align the mark line A on needle bar ② with the bottom edge of needle bar lower bushing ③, and then tighten the setscrew ①.
- (DA needle) Align the mark line C on needle bar ② with the bottom edge of needle bar lower bushing ③, and then tighten the setscrew ①.

(2) Adjusting the position of the hook:

- (DB needle) Loosen the three setscrews on the hook, and turn the hand wheel to align the mark line B on ascending needle bar ② with the bottom edge of needle bar lower bushing ③.
- When a DA needle is used loosen the three setscrews on the hook, turn the hand wheel, and align marker line D on ascending needle bar ② with the bottom edge of needle bar lower bushing ③.

(3) After the adjustments mentioned above are done, align hook blade point ⑤ with the needle center ④. Keep it at the ideal clearance of 0.05~0.1 mm between the needle and the hook.

- 更換梭頭時，先確認其零件代號再更換。

注意：

如果梭頭尖與針之間隙少於詳載值，梭頭尖將會受損；如果間隙過大，將會引起跳針。

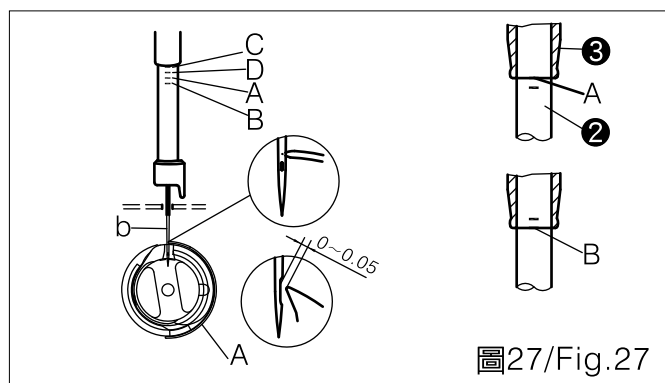


圖27/ Fig.27

- Specify the correct part number before replacing hooks.

Attention:

If the clearance between the hook tip and the needle is less than the identified value, the hook tip will be damaged. If the clearance is too wide, stitch skipping will occur.

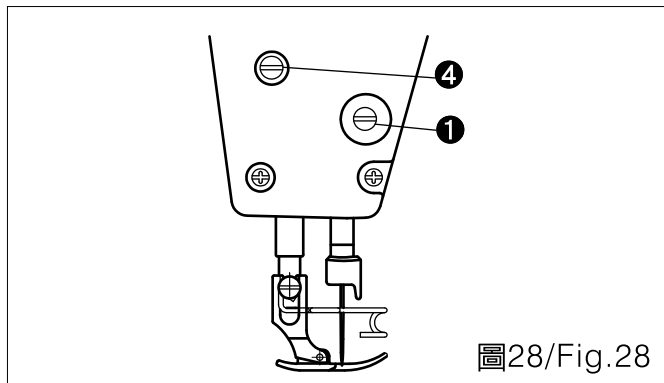


圖28/ Fig.28

壓具高度調整

- 放鬆固定螺絲①，並調整壓具高度及角度。（圖 28）
- 調整後，確實鎖緊固定螺絲①。

PRESSER FOOT HEIGHT ADJUSTMENT

- Loosen screw ①, and adjust the height of presser foot and its orientation. (Fig. 28)
- After adjustment, lock the screw ① securely.

停針位置調整

- 切線後，車針上定位。（圖 29）
 - 標準定針位置：針標準停止位置，將機頭上之標記 A 與手輪上之標記 B 對齊即可。
 - 停針時間調整：將車針停在最高點，放鬆螺絲①，在橢圓孔內調整螺絲。
 - 將螺絲往 C 方向轉動，車針停止時間提前。
 - 將螺絲往 D 方向轉動，車針停止時間延後。

NEEDLE STOP POSITION ADJUSTMENT

- Needle "UPPER" stop position after trimming. (Fig. 29)
 - Standard Stop Position: the standard needle stop point is simply to align the mark A on the machine head with the mark B on the hand wheel.
 - Timing Adjustment of Needle Stop: Stop the needle at its upper dead point, and then loosen the screw ① and adjust the screw in the elliptic hole.
 - Move the screw in direction C to advance the needle stop timing.
 - Move the screw in direction D to delay the needle stop timing.

2. 車針下定位 (圖 33)

當腳踏板前踩後，再回到原位置，車針之下停位置，將車針①停於最低點，放鬆螺絲②在橢圓孔內調整螺絲。

- (1) 將螺絲往 A 方向轉動，車針停止時間提前。
- (2) 將螺絲往 B 方向轉動，車針停止時間延後。

注意！以上調整：

1. 螺絲放鬆後，請勿操作機器。
2. 只放鬆螺絲，請勿拆下螺絲。

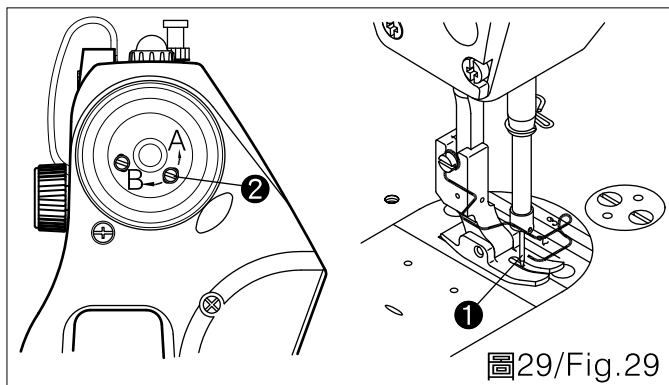


圖29/ Fig. 29

2. Needle "DOWN" stop position (Fig. 33)

When threading the pedal forward and returned to the neutral position, the needle DOWN stop position can be adjusted as the followings. Stop the needle ① at its lower dead point, and then loosen the screw ② and adjust the screw in the elliptic hole.

- (1) Move the screw in direction A to advance the needle stop timing.
- (2) Move the screw in direction B to delay the needle stop timing.

Attention! About above adjustments:

1. Do not operate the machine after screws are loosened.
2. Do not remove screw; only loosen the screw.

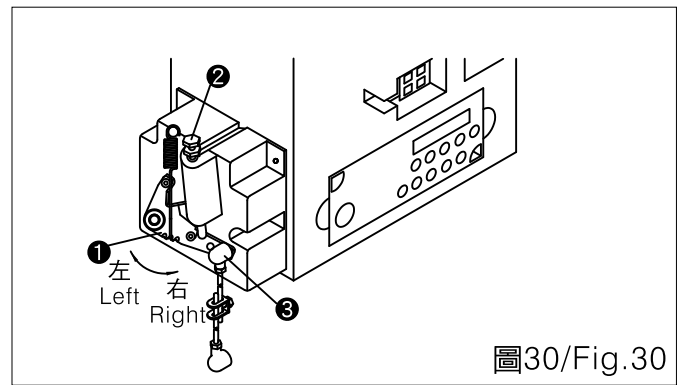


圖30/ Fig. 30

腳踏板壓力及行程

1. 腳踏板前踩位置的壓力調整。(圖 30)

- (1) 腳踏板壓力可經由改變腳踏板壓力調整彈簧①之安裝位置而改變。
- (2) 將彈簧勾移往左邊，壓力減少。
- (3) 將彈簧勾移往右邊，壓力增加。

2. 腳踏板後踩位置的壓力調整。

- (1) 壓力可經由調整螺絲②調整。

ADJUSTING THE TENSION ON PEDAL AND PEDAL STROKE

1. Adjusting the front part treading pressure of the pedal. (Fig. 30)

- (1) The pressure of the pedal can be adjusted by changing the mounting position of pedaling pressure adjust spring ① .
- (2) The pressure is reduced when moving the spring hook to left side.
- (3) The pressure is increased when moving the spring hook to right side.

2. Adjusting the rear part treading pressure of the pedal.

- (1) The rear part treading pressure of the pedal can be adjusted by driving the regulator screw ② .

動刀與固定刀的更換

調整時注意事項：

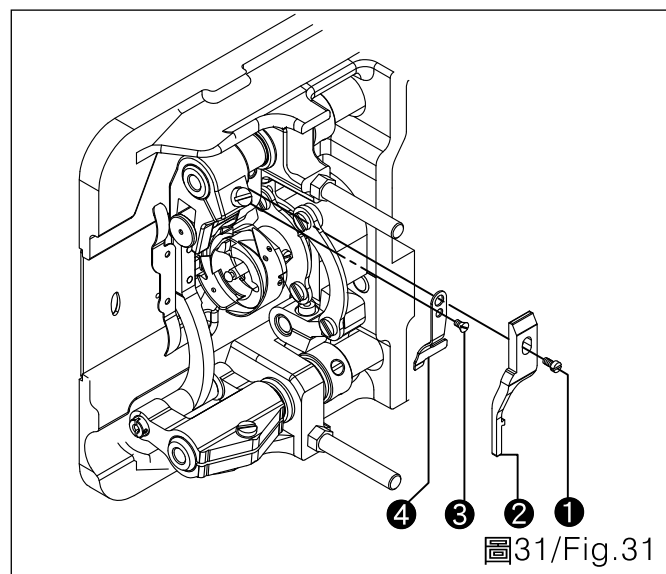
1. 更換零件時，為避免縫紉機動作傷人，請切斷電源。
2. 請使用 SIRUBA 公司指定更換零件。

1. 固定刀更換 (圖 31)

- (1) 將縫紉機頭向後傾斜。
- (2) 旋出螺絲①，取出旋梭定位器②。
- (3) 旋出螺絲③，取出定刀④。
- (4) 安裝順序與拆卸時步驟相反。

2. 固定刀刀刃的研磨方法 (圖 32)

如果固定刀的刃部受損或磨損，請將固定刀④如圖所示在油磨石⑤上研磨固定刀。



3. 更換動刀 (圖 33)

- (1) 取下機針，抬起壓腳。
- (2) 旋出螺絲①，取出針板②。
- (3) 將縫紉機頭部向後傾斜。
- (4) 回轉手輪使針桿位置升至最高。

REPLACING THE MOVABLE KNIFE AND FIXED KNIFE

Adjustment note:

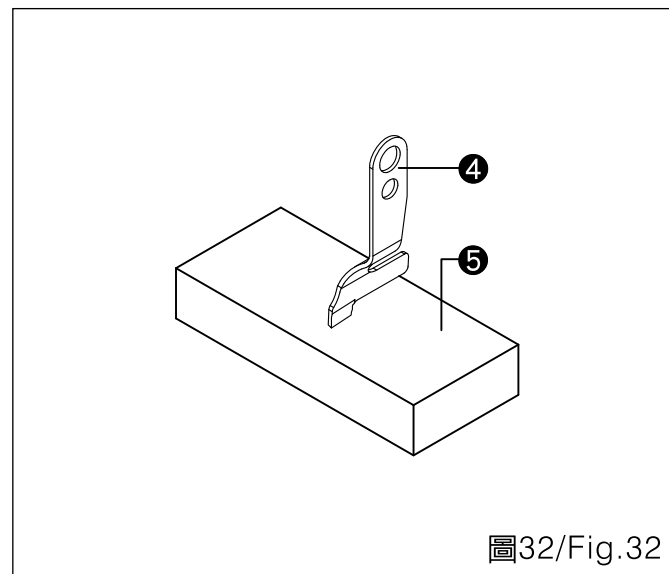
1. Turn off the power to avoid the operation Accident when replacing parts.
2. Please use designated parts by SIRUBA .

1. Replace the fixed knife (Fig.31)

- (1) Tilt the sewing machine head backward.
- (2) Loosen the screw ① and remove the hook locator ② .
- (3) Loosen the screw ③ and remove the fixed knife ④ .
- (4) The installing procedure is opposite to the removing procedure.

2. Sharpening the fixed knife blade (Fig.32)

If the fixed knife blade is worn out, please sharpen the fixed knife ④ on the oilstone ⑤ as figure shows.



3. Replacing the movable knife (Fig.33)

- (1) Remove the needle and lift the presser foot.
- (2) Loosen the screw ① and remove the needle plate ② .
- (3) Tilt the sewing machine head backward.
- (4) Turn the hand wheel to make the needle lever lift to the highest position.

(5) 將切線連桿③用手撥向箭頭方向，直至看到動刀螺絲④的位置。

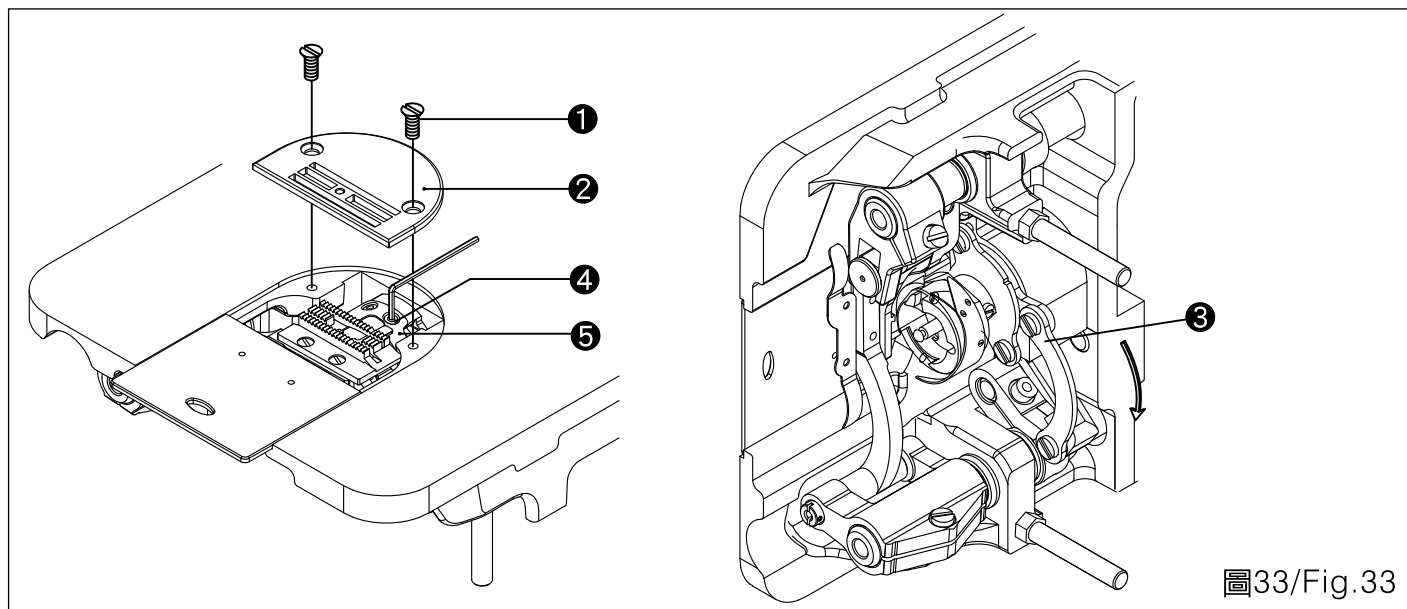
(6) 旋下兩顆螺絲，然後取出動刀⑤。

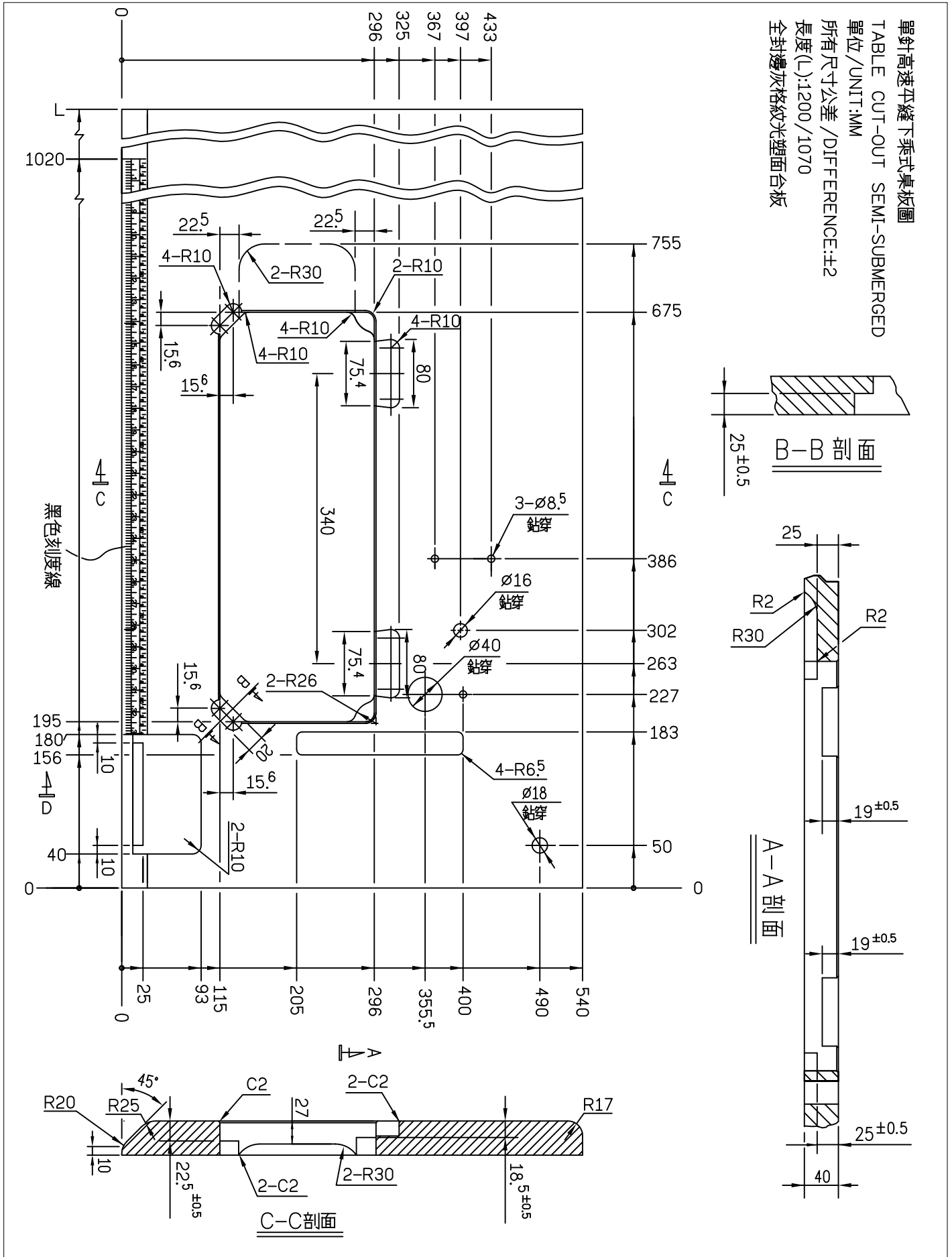
(7) 安裝順序與拆卸時步驟相反。

(5) Wipe the thread trimmer connecting rod ③ to the arrow pointed direction until the movable screw ④ can be seen.

(6) Loosen two screws and remove the movable knife ⑤ .

(7) The installing procedure is opposite to the removing procedure.







L918-BM1/BH1

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