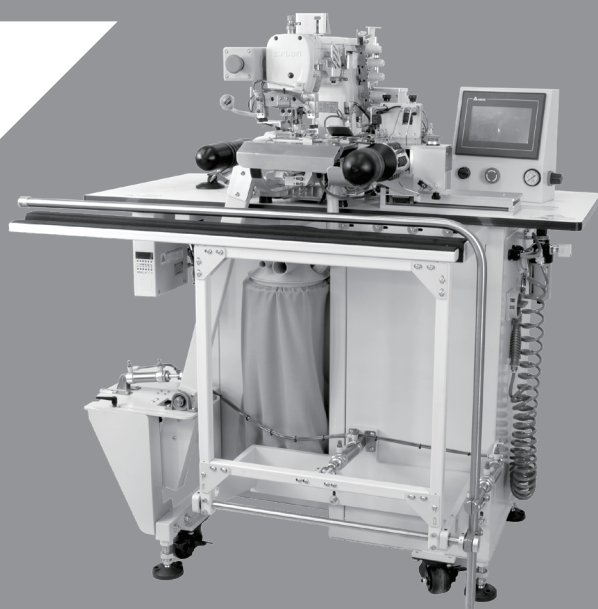


SIRUBA

使用説明書

INSTRUCTIONS BOOK

■ASC-TBH200



前言

歡迎使用本公司產品，製衣行業的正確投資選擇！

本說明書為本公司新研發的“卷下擺包縫機”產品參考手冊，請認真閱讀此手冊以更好的運用本公司產品！

在操作設備請仔細閱讀本說明，並且請注意以下要求：

- 1：用戶操作前必須可靠接地，保證人身安全！
- 2：非專業人士請勿拆卸控制箱；
- 3：控制箱與電機遠離強磁高輻射環境；
- 4：不要在過熱環境中作業（作業時環境溫度：-20°C~50°C）；
- 5：不要在過於潮濕環境中作業（作業時環境濕度：20%~90%）；
- 6: (1) 本設備出廠時默認為 220V 的電源電壓【220v 接入供電時額定電壓 為 200V~240V 之間】
(2) 如需使用 110V 電控：【110v 接入供電時電壓穩定在 (100V~120V) 之間（需要通過開關電源切換）】

通過扳動紅鍵來切換電源

Switch the power supply by turning the red key



Preface

Welcome to use our products, it is the right investment choices in garment industry!

The user manual is for our newly developed "Auto Hemming for Cylinder Bed Overlock Machine with thread cutting" products reference manual, Please read this manual carefully, hope it can give you useful help!

Before reading the manual, please note the following requirements:

- 1: The user must be reliably grounded before operation to ensure personal safety!
- 2: Non-professionals do not disassemble the control box;
- 3: The control box and the motor are far away from the strong magnetic and high radiation environment;
- 4: Do not work in an overheated environment (ambient temperature during operation: -20°C~50°C);
- 5: Do not work in an excessively humid environment (humidity during operation: 20%~90%);
- 6: (1) The default power supply voltage of this device is 220V when it leaves the factory [The rated voltage is between 200V and 240V when 220V is connected to the power supply]
(2) If you need to use 110V electric control: [When 110V is connected to the power supply, the voltage is stable between (100V~120V) (need to switch through the switching power supply

安全叮囑：

- 1：電機接通時請不要把腳放在腳踏板上
- 2：本產品請專業人士安裝調試
- 3：嚴禁在通電時打開控制箱與電機端蓋
- 4：換針，穿線或更換底線時請關閉電源
- 5：安裝，拆卸維修時請關閉電源
- 6：翻抬縫紉機時請關閉電源
- 7：使用本產品請遠離高頻電磁波和電波發射器等，以免所產生的電磁波干擾伺服驅動器而發生錯誤動作。

保修策略：

- 1：本產品自購買起免費保修1年，終身維護。保修期內除人為損壞外出現的任何質量問題可聯繫售後。
- 2：未經本公司同意自行拆卸，改裝造成損壞將不給於保修。
- 3：但凡出現無法解決的問題可以聯繫本公司。

Safety requirement:

- 1: Do not put your feet on the pedals when the motor is switched on.
- 2: Let professionals to install and debug this product .
- 3: Do not open the control box and the motor cover when energized
- 4: Please turn off the power when changing the needle,threading or replacing the bottom line
- 5: During installation and removal service, please turn off the power
- 6: Please turn off the power when turn lift sewing machine
- 7: Use this product, please stay away from high-frequency electromagnetic wave and wave transmitter, so as to avoid the electromagnetic wave interference servo driver and wrong action.

Warranty policy:

- 1、 Since from the purchase of this product, the free 1-year warranty, lifetime maintenance. During the warranty period,any quality problems the product will be free repaired, except artificial damage.
- 2、 Without our consent disassemble or modify, the damaged will not give in warranty.
- 3、 Whenever find the problem can not be solved, you can contact with our company.

目錄

content

繙縫機介紹

安全注意事項

1、安裝

2、機器部件的零件說明

3、顯示屏常用操作介紹

4、如何使用機器

5、機器位置調整說明

6、操作參數說明表

7、故障情況與故障代碼解析

8、裝箱單

Hemming sewing machine introduction

Safety precautions

1、Install

2、Description of machine parts

3、Introduction of display screen common operation

4、How to using machine

5、Adjust the machine position

6、Operating Parameter Description

7、Troubleshooting and Error code analysis

8、Packing list

安全措施

感謝您購買本設備，在開始操作任何程序之前，請仔細閱讀本手冊，
然後正確、安全地使用設備。

將本手冊放在方便的地方，以便在需要時快速查閱。

1、介紹

- 本手冊描述了安全使用本裝置的說明。
- 在開始任何程序之前，仔細學習本手冊並充分了解如何操作、檢查、調整和節省人力維護裝置。
- 在使用工業縫紉機時，您總是在靠近運動部件（例如，針）的位置執行操作。因此您必須記住，您可以很容易的觸碰到它們。為了防止事故發生，您必須正確使用我們提供的安全產品。
- 所有使用自動裝置的人員必須認真學習本手冊和縫紉機使用說明書，並在任何程序開始前採取必要的安全措施。

1. Introduction

- This manual describes the instructions for using this unit safely.
- Study this manual very carefully and understand fully how to operate, check, adjust and maintain the labor saving unit before beginning any of the procedures.
- You always perform operations close to moving parts such as needles when using industrial sewing machines. Therefore you have to keep in mind you could easily touch them. To prevent accidents, it is essential that you use the safe products supplied by SIRUBA correctly.
- All the people who will use automatic unit must study this manual and the instruction manual for sewing machines very carefully and then take necessary safety measures before beginning any of the procedures.

為了安全起見，一定要認真並仔細的學習。

2、危險，警告和注意事項的指示

為防止事故，我們的產品和本手冊中使用了顯示危險程度的事故、指示（符號和/或標誌）。

請仔細研究內容並遵循說明。

指示標籤很容易就能找到。

當它們被染色或被移除時，請貼上新的標籤

如果需要新標籤，請聯繫我們的銷售辦事處

請使用那些能夠吸引使用者註意的符號、標誌和/或信號詞。

Be sure to study very carefully for safety

2. Indications of dangers, warnings and cautions

To prevent accidents, indications (symbols and/or signs) which show the degree of danger are used on our products and in this manual.

Study the contents very carefully and follow the instructions.

Indication labels should be found easily.

Attach new labels when they are stained or removed.



Contact our sales office when new labels are needed.

Symbols, signs and/or signal words which attract users' attention.

Symbols and messages

符號和信息

 <p>危險 DANGER</p>	<p>表示对生命或肢体的直接危害</p>	<p>Indicates an immediate hazard to life or limb.</p>
 <p>警告 WARNING</p>	<p>表示对生命或肢体的潜在危险</p>	<p>Indicates a potential hazard to life or limb.</p>
 <p>注意 CAUTION</p>	<p>表示可能导致伤害或损坏的错误</p>	<p>Indicates a possible mistakes that could result in injury or damage.</p>

	<p>操作機器和／或自動裝置時，務必參照說明節。</p>	<p>Be sure to follow the instructions when you operate the machine and／or labor saving device.</p>
	<p>千萬不要這樣做。</p>	<p>Never do this.</p>

安全注意事項

應用與目的

本設備被設計用於，根據您的需要來提高質量和生產量。

因此，切勿將該設備用於可能會破壞上述目的的應用。



情況

使用本設備時的某些情況可能會影響其壽命、功能、性能和安全性。

為安全起見，在以下情況下，請勿使用本設備。

1、不要在有噪音的物體附近使用設備，如高頻焊機等。

2、請勿在含有化學物質的空氣中使用或保存該裝置，也不要將該設備直接暴露在化學品下。

3、請勿在高溫或陽光直射下將設備放在室外。

4、請勿在可能影響設備的高濕度或環境溫度下使用該設備，

5. 當電壓波動範圍大於額定電壓的 $\pm 10\%$ 時，不得使用本裝置。

6. 不要在不能正確獲得控制電機規定電源電壓的地方使用該裝置。

7、不要在無法正確獲得設備規定的氣壓供應的地方使用。

Safety precautions

Applications, purpose

The automatic unit is designed to increase quality and productivity according to your needs.

Therefore never use the device for the applications, which may defeat the above purpose.



Circumstances

Some circumstances when you are using the automatic unit may affect its life, function, performance, and safety.

For safety, do not use the automatic unit under the circumstances below.

1. Do not use the device near objects, which make noise such as a high-frequency welder, etc.

2. Do not use or store the device in the air, which has vapor from chemicals, or do not expose the device to chemicals.

3. Do not leave the device outside, in high temperatures or the direct sun.

4. Do not use the device in high humidity or ambient temperatures, which may affect them.

5. Do not use the device on the condition that the voltage fluctuation range is more than $\pm 10\%$ of the rated voltage.

6. Do not use the device at the place where the supply voltage specified for the control motor cannot be properly obtained.

7. Do not use the device at the place where the air supply specified for the device cannot be properly obtained.

8、不要將設備暴露在水中。



安全措施

(1) 對自動裝置進行維護時的安全預防措施。

- 在進行檢查、修理、清潔自動裝置、關閉電源、從電源插座上斷開電源插頭並按下機器旋鈕以確保機器停止運行。

如果必須在通電的情況下對機器和/或自動裝置進行維護，請務必小心，因為機器和/或設備可能會意外啟動。

為防止誤操作引起的事故，應建立自己的安全操作程序並遵照執行。



- 只有訓練有素的人員才能進行日常維護和/或修理機器和/或設備。
- 請勿自行修改機器和設備。
※請諮詢當地的銷售業務或代表進行修改。

8.Do not expose the device to the water.



Safety measures

(1) Safety precautions when you perform maintenance on the automatic unit.

- When performing maintenance such as when checking, repairing, cleaning the automatic unit, turn off the power, disconnect the power plug from the outlet and press the machine treadle in order to make sure the machine does not run.

If you have to perform maintenance on the machine and/or automatic unit with the power on, always be careful because the machine and/or device could start operating unexpectedly.

To prevent accidents caused by incorrect operation, you should establish your own procedures for safe operation and follow them.



- Only well-trained people should perform routine daily maintenance and/or repair the machine and/or device.
- Do not modify the machine and device yourself.
米 Consult your local SIRUBA' sales office or representative for modification.



(2) 操作設備之前

在操作設備之前，檢查主軸箱、機器裝置和設備，確保它們沒有任何損壞和/或缺陷。

如果有，請立即修理或更換任何有缺陷的零件。

(3) 培訓

為防止事故發生，操作人員和服務/維護人員應具備各適當的安全操作知識和技能



(2) Before operating the device

Before operating the device, check the machine head, machine unit and device to

f so, repair or replace any defective parts immediately.

(3) Training

To prevent accidents, operators and service / maintenance personnel should have proper knowledge and skill for safe operation.



請勿自行修改設備。
高林不承擔因改裝而引起的一切責任。

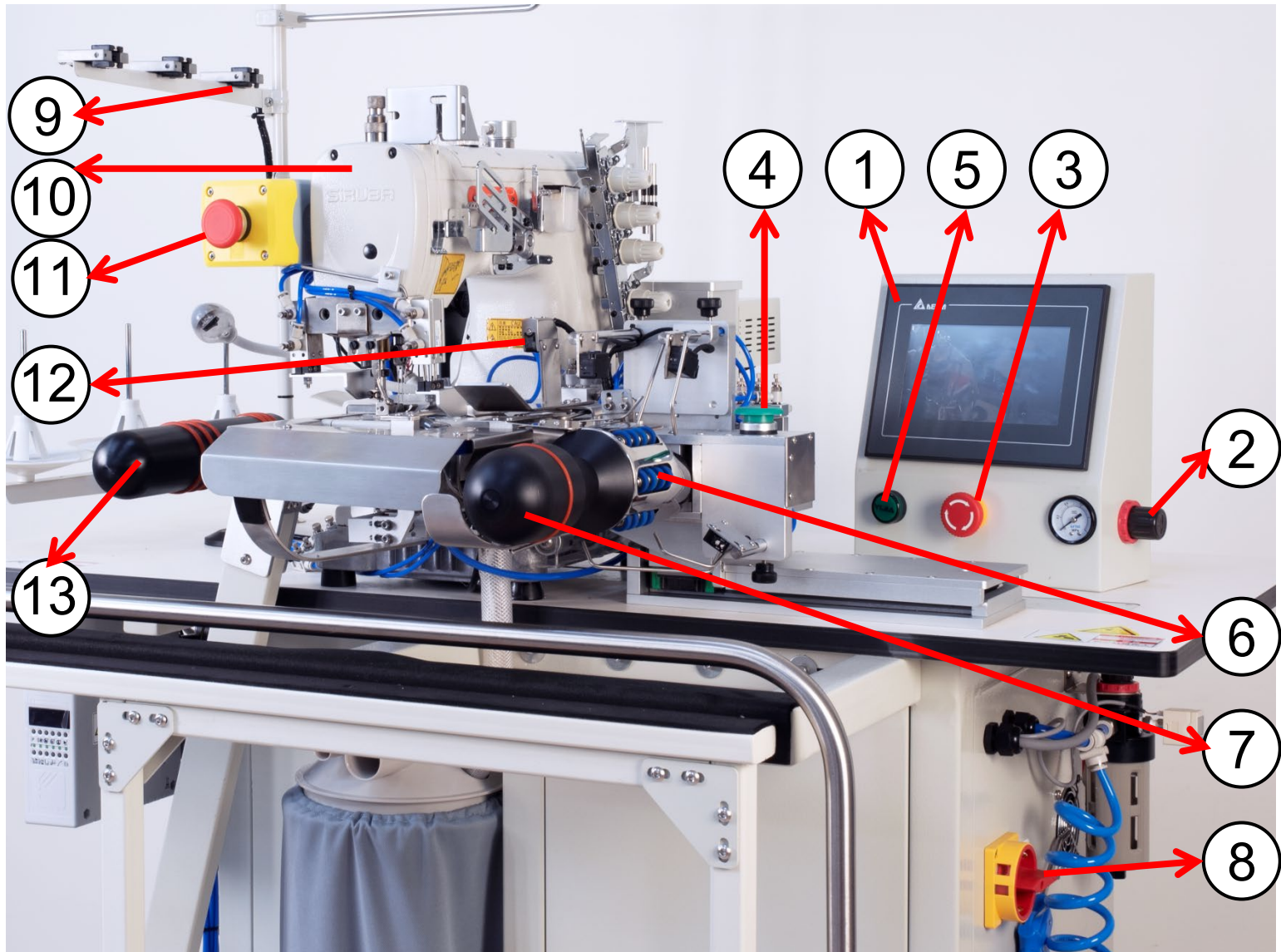


Do not modify the equipment by yourself.

SIRUBA does not assume all the responsibility caused by the refit.

一、安裝

1、Install



1	人機交互 HMI	8	電源開關 Power switch
2	撐開氣閥 Air support valve	9	斷線感測器 Wire break sensor
3	急停按鈕 Emergency button	10	縫紉機頭 Sewing machine head
4	啟動按鈕 Start up button	11	停止按鈕 Stop button
5	信號指示燈 Signal indicator	12	距離感測器 Distance sensor
6	導布輪 Cloth guide wheel	13	後輪 Rear wheel
7	前輪 Front wheel		

總功率：0.9-1KW/h

Total power：0.9-1KW/h

二、機器部位的零件說明

2、Description of machine parts

序號 NO	零件位置調整 Part position adjustment	功能說明 Function description
1		距離傳感器，檢測縫紉骨位置，起針和結束時發信號 The distance sensor detects the position of the sewing bone, and signals the start and end of sewing.
2		重線傳感器，檢測重線的時候的位置 The repeat line sensor detects the position of the repeat line
3		對邊傳感器，檢測卷邊時布料的大小和它是否對齊 Anti-edge sensor to detect the size and alignment of the fabric when it is rolled
4		布料傳感器，檢測有無布料 Cloth sensor to detect whether there is any cloth

5		<p>啟動開關，開始起縫的時候的動作開關 Start the switch to start the action switch when sewing</p>
6		<p>急停開關，遇到緊急需要停止的時候的開關 Emergency stop switch, in case of emergency need to stop the switch</p>
7		<p>電源啟動開關 Power start switch</p>
8		<p>吹氣大小時間控制 A 第一卷邊吹氣 B 第二卷邊吹氣 C 第三卷邊吹氣 D 第四切布幫助吹氣 E 第五倒骨幫助吹氣 Blowing size time control A first edge blowing B second edge blowing C third edge blowing D fourth cut cloth to help blow air E the fifth bone helps to blow air</p>
9		<p>導向輪限位傳感器，用於左右位置切換的位置限制 Guide wheel limit sensor for left and right position switch position limit</p>

三、顯示屏常用操作介紹

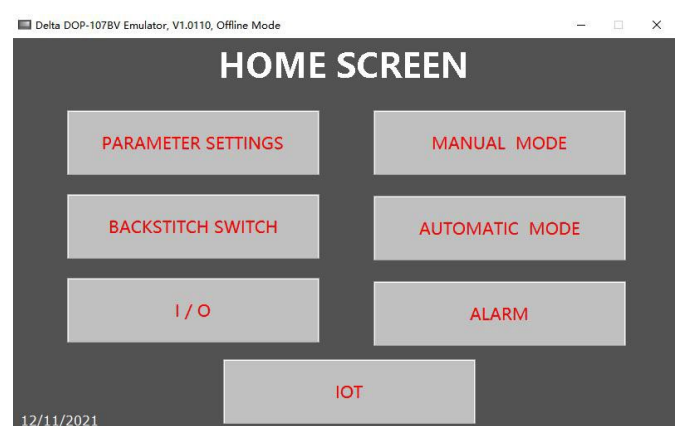
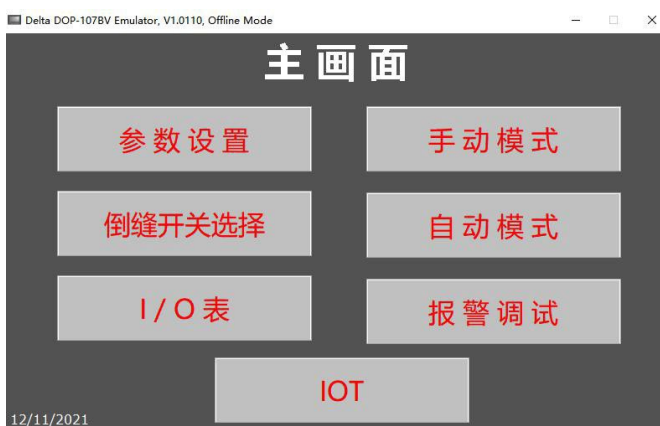
3、 Introduction of display screen common operation



首先選擇語言，有中文，英文，泰文，葡萄牙文。（根據版本的不同，語言類型也會隨之更改。）

First choose the language, Chinese, English, Thai, Portuguese.
(Depending on the version, the language type changes.)

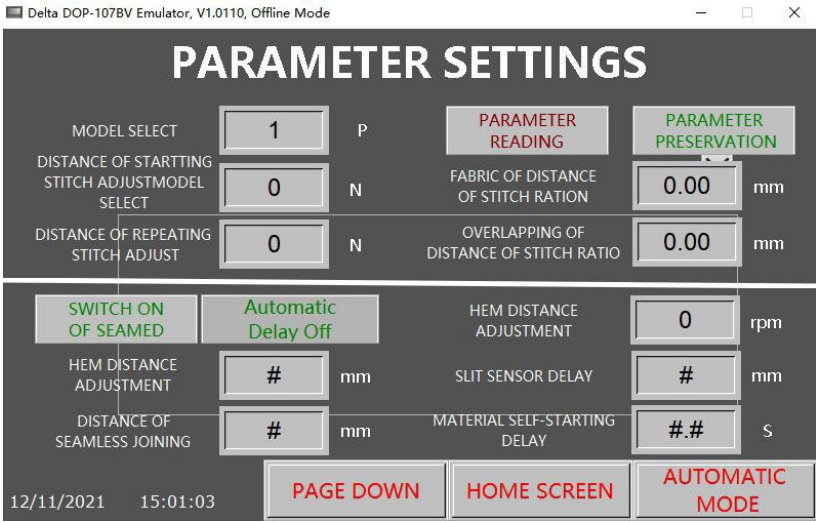
進入參數設置
Enter Parameter Settings



然後自由調整
And then adjust it freely.
參數的詳細說明請參照操作說明參數表。(P18)



輸入數值並點擊保存即可將數據保存到對應款號之中。
Enter the value and click Save to save the data to the corresponding model number




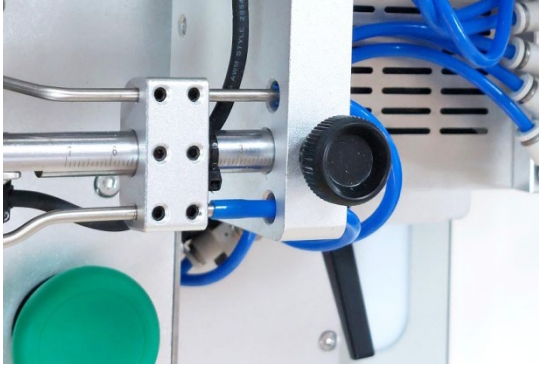


四、如何使用機器

4、How to use a machine

- 1、連接氣源與電路，按壓電源開關。
 - 2、檢查觸摸屏上信號燈與各個傳感器信號燈是否正常，若能夠正常接收信號輸入並顯示為正常：可通過查看電路板上的 PLC 來判斷傳感器是否有信號輸入。
 - 3、選擇所需要的語言進入主畫面；進入參數設置，一般默認已有調適好的參數，但是需要與實際加工的布料配合來修改數據。
 - 4、進入手動模式，確認各個功能正常動作。
 - 5、確保無誤後，進入自動模式。
 - 6、套上需要縫製的布料，撐開輪檢測到布料後會自動撐開。
 - 7、按下啟動按鈕，開始空轉檢測骨位。
 - 8、第一次檢測到骨位後，起縫。
 - 9、第三次檢測到骨位後，切換成低速並準備停止工作。
 - 10、縫製結束後，收料架動作將布料推出。
 - 11、若出現停轉、設備報警的現象，請斷電重啟：若故障始終存在，請聯繫廠家售後進行機器維護。
- 1、 Connect the air source to the circuit and press the power switch.
 - 2、 Check whether the signal lights on the touch screen and the signal lights of each sensor are normal. If the signal input can be received normally and displayed as normal; you can check whether the sensor has a signal input by checking the PLC on the circuit board.
 - 3、 Select the desired language to enter the main screen; enter the parameter setting, generally there are already debugged parameters by default, but the data needs to be modified in conjunction with the actual processed fabric.
 - 4、 Enter manual mode and confirm the normal operation of each function.
 5. After ensuring correctness, enter the automatic mode.
 6. Put on the fabric to be sewn, and the spreading wheel will automatically expand after detecting the fabric.
 7. Press the start button to start idling to detect the stock position.
 8. After the stock position is detected for the first time, start sewing.
 9. After the stock position is detected for the third time, switch to low speed and prepare to stop working.
 10. After sewing is finished, the material receiving rack moves out the fabric.
 - 11、 If there is a stall or equipment alarm, please power off and restart; if the fault persists, please contact the manufacturer for after-sales maintenance of the machine.

五、機器位置調整說明

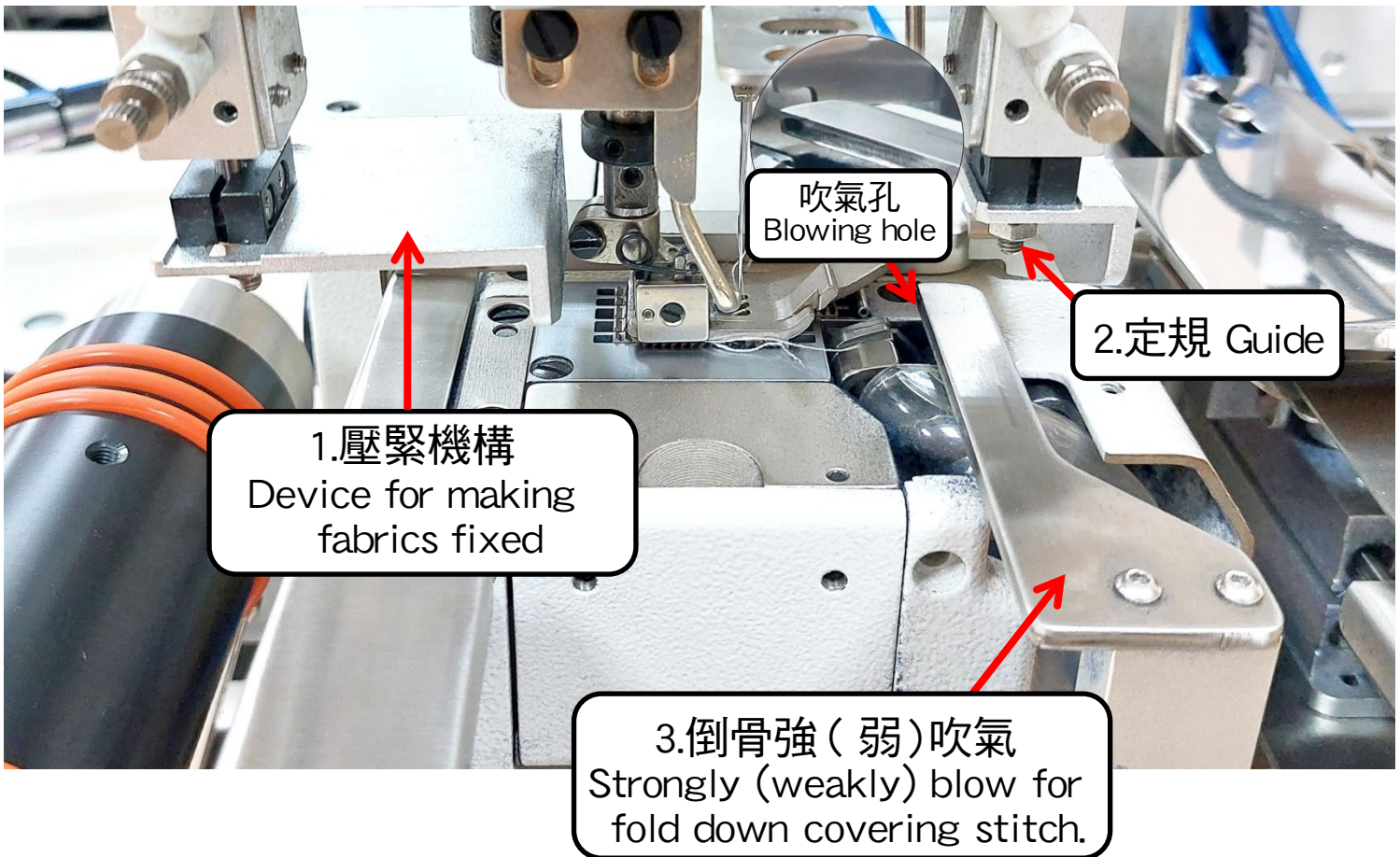
5:The device adjust description

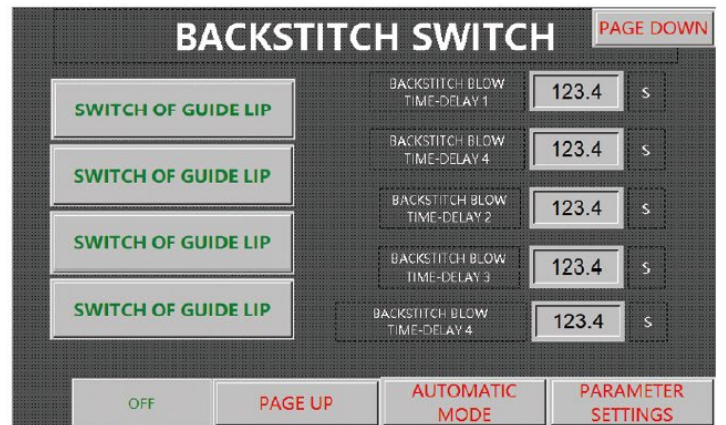
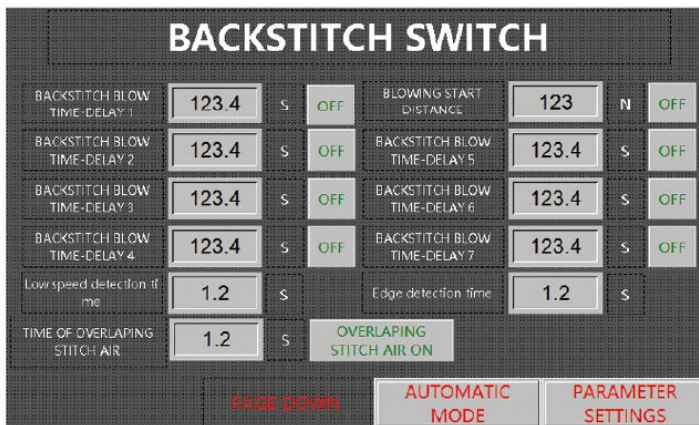
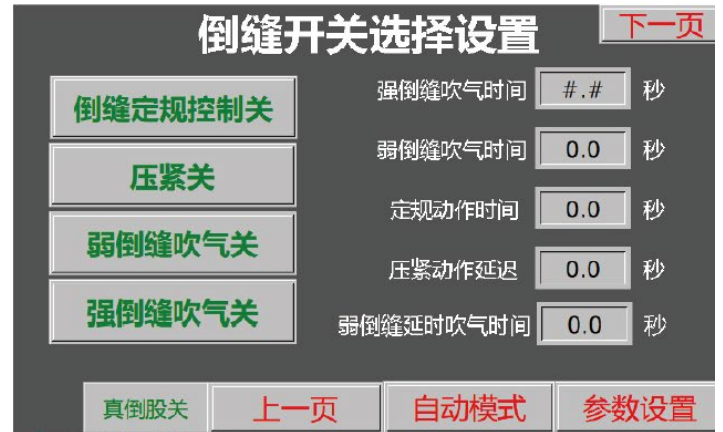
	<p>對重線傳感器的位置可以通過後方的旋鈕進行細微調整。</p> <p>The position of the sensor can be slightly adjusted by the knob at the rear.</p>
	<p>對邊傳感器的精度根據實際生產的需求來調整大小，但盡量不要調整位置。</p> <p>The accuracy of the sensor is adjusted according to the actual production demand, but try not to adjust the position.</p>
	<p>無布傳感器，縫製時光點始終照在布料上，一旦漏出就表示縫製即將結束。</p> <p>Sensor, the sewing time point is always on the cloth, once it leaks out, it means the sewing is about to end</p>
	<p>整個機架可以通過扭鬆扳手後左右調整。</p> <p>The whole frame can be adjusted left and right after loosening the wrench.</p>

一體式收料機構
Integrated material receiving mechanism



吹氣倒骨位機構：
Device for folding down covering stitch. :





以上作圖為假倒骨，右圖為真倒骨；

The above drawing is a false stock inversion, the picture on the right is a real stock inversion;

左圖為假倒骨，可以選擇多骨位，例如：倒縫吹氣延時 1 定義為倒縫時吹氣的時間長短；其它參數均為同一定義；

The drawing is fake inverted strands, and multiple strands can be selected. For example, the air blowing delay 1 of the reverse stitching is defined as the length of the air blowing during the reverse stitching; Other parameters are the same definition;

右圖為真倒骨：強倒縫吹氣時間，例如設置1S，則可以定義為強倒縫吹氣時間為 1 秒，1 秒過後自動關閉；

The picture on the right shows the real inversion: the blowing time of strong reverse seam. For example, if 1S is set, it can be defined as the blowing time of strong reverse seam as 1 second, and it will automatically close after 1 second;

6、操作參數說明表

6、 Operating Parameter Description Table

1、技術員系統參數列表：

1、 List of system parameters for technicians

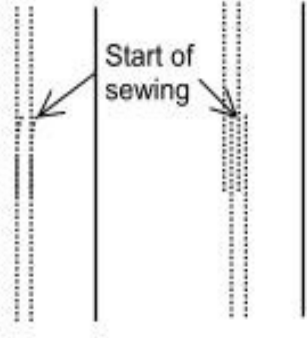
序號 list	功能說明 Function description	參數默認值 Function parameter default values	參數範圍 Function parameter ranges	參數說明 Parameter description
1	款號選擇 MODEL SELECT	1	0-99 款/P	用於不同款號數據的記憶在機器裡面 The memory used for data of different models is in the machine
2	起針位置調整 DISTANCE OF STARTTING STITCH ADJUST	4	0-300 針/N	起針的位置調整 Adjust the starting position
3	重線位置調整 DISTANCE OF REPEATING STITCH ADJUST	40	0-300 針/N	重線針數的針數調整 Adjust the number of stitches for rethreading
4	收邊距離調整 HEM DISTANCE ADJUSTMENT	1000	100-10000 mm	空捲時候的捲邊距離 Unrolled edge distance
5	無縫重線距離 DISTANCE OF SEAMLESS JOINING	600	100-999mm	無縫時候的重針針數 The number of repeated stitches when seamless
6	過縫傳感器延時 Over seam sensor delay	300	200-1000 mm	輪子開始旋轉到傳感器檢測到骨縫時的無效旋轉距離 Invalid rotation distance when the wheel starts to rotate until the sensor detects the seam
7	收料架收料時間 TIME OF COLLECTING FABRIC TWO	1.0	0.2-5 秒/S	收料架收料時間 Receiving rack receiving time

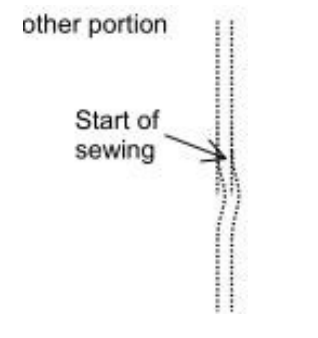
8	送料針碼比例 FABRIC OF DISTANCE OF STITCH RATION	2.4	0-5 mm	送料時，機器與裝置的針碼比例，機器針跡加大，比例也要加大 Machine to device needle size ratio, machine stitch increase , The proportion should also be increased
9	重線針碼比例 OVERLAPPING OF DISTANCE OF STITCH RATION	2.4	0-5 mm	重線時，機器與裝置的針碼比例，機器針跡加大，比例也要加大 The speed of the rear tug when rewiring.
10	收邊速度調整 SPEED OF BOTTOM	1200	400-3000 HZ	空捲的時候滾輪的速度 The speed of the rear wheel when the coil is empty
11	切線後拖動距離 DISTANCE AFTER CUTTING	50	1-600 mm	切線結束後拖布滾輪運行的長度 The running length of the mop roller after the tangent ends
12	重線吹氣時間 TIME OF OVERLAPPING STITCH AIR	0.4	0.0-1.0 秒/S	重線時候下吹氣防止切壞布料 Blow down when rewiring to prevent cutting of fabric
13	切刀停 Cutter stop time	300	1-999 mm	當檢測到骨位，一段距離後切刀停止 When the femoral position is detected, the cutter stops after a certain distance
14	導向輪擺動距離 Swing distance of guide wheel	60	0-120 mm	機器工作時導向輪左右擺動的距離使布料到壓腳下保持寬度一致 When the machine works, the guide wheel swings from side to side to keep the width of the cloth consistent with the press foot
15	定規一/二 guide	90	1-200 mm	用於穩定折邊，當有布傳感器露出時開始一段距離後定規一/二回撤 Used for fold down covering stitch. The guides exit automatically after the sewing is completed.
16	有料自啟延時 Delay of material self starting	1	0.2-10 秒/S	有布傳感器檢測到有布後計時時間到機器自動動作，不用再按按鈕 After the cloth sensor detects the cloth, the timing time reaches the automatic action of the machine. No more pressing the button
17	有縫功能開 Seamed function opening	開 OPEN	開/關 OPEN/OFF	在衣服沒有骨縫時，按下有縫功能開關後，該參數起作用，指將布料放入後行動一定距離後開始縫制 When there is no seam in the clothes, press the button of seam function, this parameter will take effect, which means that the cloth will be put in and start sewing after a certain distance

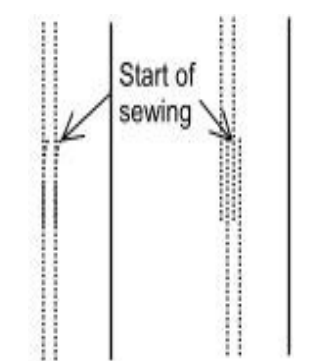
18	切線後拖動速度 DISTANCE AFTERSPDDE	200	1-500r/min	切線結束後拖布滾輪運行的速度 The running speed of the mop roller after thread trimming
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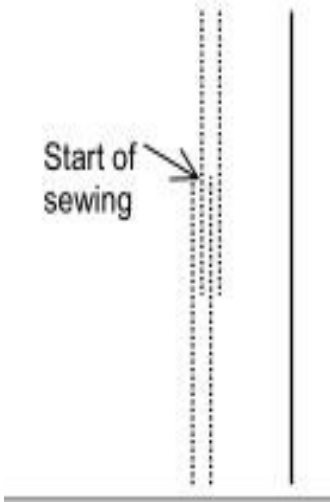
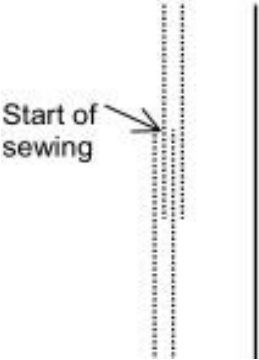
七、故障情況與錯誤代碼解析

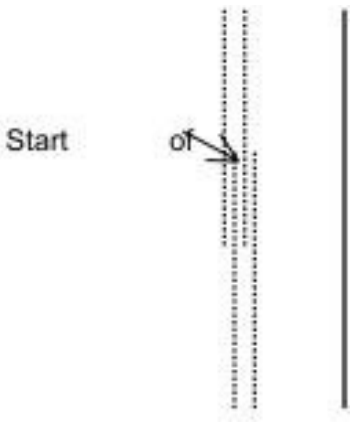

7:Troubleshooting and Error code analysis

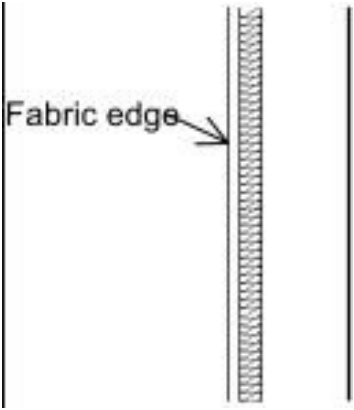
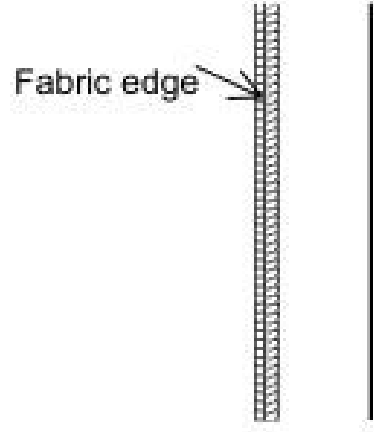
序號 list	現象 issues	原因 reason	補救措施 action
1	<p>重接線不良 Poor rewiring 起始縫紉時折邊寬度要比其他部分窄。</p> <p>The width of the hem is narrower than other parts at the beginning of sewing.</p> 	<p>滾輪速度與機器速度不匹配。 The roller speed doesn't match to the machine speed.</p> <p>由於前輪速度慢導致織物向左偏移。 The fabric shifts to the left because of the front roller speed is slow.</p> <p>因為導布器和折邊擋板間隙過大，導致下擺寬度不穩定。 Hem width isn't stable because of the clearance between fabric guide and hem guide is too much.</p>	<p>調整前後滾輪的速度，與機器速度匹配。 Adjust the front and rear roller speed to the machine speed.</p> <p>增加前輪速度。 increase the front roller speed.</p> <p>正確的調整導布器和擋板的間隙。 Adjust the clearance between fabric guide and hem guide properly.</p>

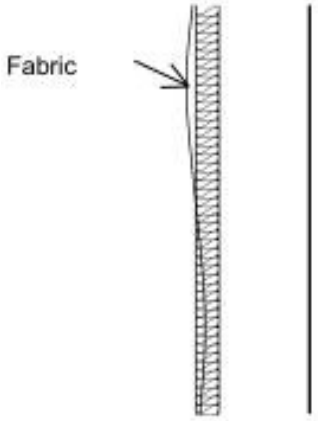
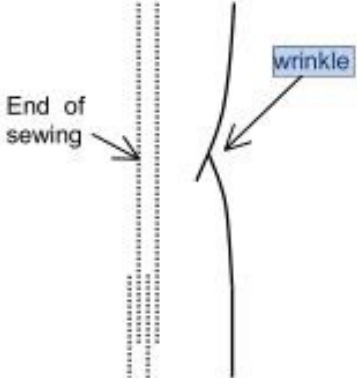
2	<p>重接縫不良 起始縫紉時過骨縫不順</p> 	<p>前後滾輪速度低於機器速度。 The front and rear roller speed are slower than machine speed.</p>	<p>增加前後輪的轉速。 Increase both roller speed.</p>
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3	<p>重接線不良 Poor rewiring 起始縫紉時折邊寬度要比其他部分窄。 The width of the hem is narrower than other parts at the beginning of sewing.</p> 	<p>滾輪速度與機器速度不匹配。 The roller speed doesn't match to the machine speed.</p> <p>由於前輪速度太快，織物向右偏移。 The fabric shifts to the right because of the front roller speed is too fast.</p> <p>由於導布器和折邊擋板間隙過大，導致下擺寬度不穩定。 Hem width isn't stable because of the clearance between fabric guide and hem guide is too much.</p>	<p>調整前後滾輪的速度，與機器速度匹配。 Adjust the front and rear roller to the machine speed.</p> <p>降低前滾輪速度。 Decrease the front roller speed.</p> <p>正確的調整導布器和擋板的間隙。 Adjust the clearance between fabric guide and hem guide properly.</p>
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<p>4</p>	<p>重接縫不良 起始縫紉時折邊寬度要比其 他部分寬。</p> 	<p>前後滾輪速度高於機器速 度。 The front and rear roller speed are faster than machine speed.</p> <p>由於重線傳感器的位置過於 左側，織物向左偏移。 The fabric shifts to the left because of the fabric edge sensor position is left side too much</p>	<p>降低前後滾輪的速度。 Decrease the both roller speed.</p> <p>向右調整傳感器的位置。 Change the position of sensor to the right.</p>
<p>5</p>	<p>重接線不良 結束縫紉時的折邊寬度比其 他部分寬。</p> 	<p>前後滾輪速度高於機器速 度。 The front and rear roller speed are faster than machine speed.</p> <p>由於對邊傳感器的位置過於 右側，織物向右偏移。 The fabric shifts to the right because of the fabric edge sensor position is right side too much</p>	<p>增加重線針碼比例 Increase both roller speed.</p> <p>向左調整傳感器的位置。 Change the position of sensor to theleft.</p>

<p>6</p>	<p>重接縫不良 起始縫紉時折邊寬度要比其 他部分窄。</p> 	<p>前後滾輪速度高於機器速度。 The front and rear roller speed are slower than machine speed.</p> <p>由於對邊傳感器的位置過於左側，織物向左偏移。 The fabric shifts to the right because of the fabric edge sensor position is right side too much</p>	<p>減少重線針碼比例 Increase both roller speed.</p> <p>向右調整傳感器的位置。 Change the position of sensor to the left.</p>
<p>7</p>	<p>折邊寬度不穩定</p> 	<p>由於導布器和折邊擋板間隙過大，導致下擺寬度不穩定 Hem width isn' t stable because of the clearance between fabric guide and hem guide is too much.</p>	<p>正確的調整導布器和擋板的間隙。 Adjust the clearance between fabric guide and hem guide properly.</p>

<p>8</p>	<p>縫紉冒邊 折邊後布料多於折邊寬度</p>  <p>Fabric edge</p>	<p>縫紉機切布刀位於縫紉機最左邊機針左側。 The repeat line sensor position is right too much.</p>	<p>向右調整縫紉機切布刀位置。 Change the position of sensor to the left.</p>
<p>9</p>	<p>縫紉空邊 折邊後布料少於折邊寬度</p>  <p>Fabric edge</p>	<p>縫紉機切布刀位於縫紉機最左邊機針右側。 The repeat line sensor position is left too much.</p>	<p>向左調整縫紉機切布刀位置。 Change the position of sensor to the right.</p>

<p>10</p>	<p>縫紉折邊不穩定 布料折邊大小不穩定</p>  <p>The diagram shows a vertical strip of fabric on the left with a wavy, uneven edge. An arrow points to this edge with the label 'Fabric'. To the right of the fabric is a straight vertical line representing a stable edge.</p>	<p>由於對邊傳感器安裝位置不當，無法識別織物。 The fabric couldn ' t be controlled because of the The distance sensor position is too low.</p> <p>由於傳感器靈敏度不足，無法正常識別布料。 The fabric couldn ' t be because of presser of The distance sensor is too week.</p>	<p>調整對邊傳感器到正確位置。 Change the position of The distance sensor.</p> <p>調整對邊傳感器的靈敏度。 Adjust the presser of The distance sensor.</p>
<p>11</p>	<p>縫製完成後布料出現扭曲，無法縫的整齊。</p>  <p>The diagram shows a vertical strip of fabric on the left with a straight edge. An arrow points to the end of the strip with the label 'End of sewing'. To the right, the fabric is shown with a sharp bend or 'wrinkle'. An arrow points to this wrinkle with the label 'wrinkle'.</p>	<p>前後滾輪速度與縫紉機不匹配。 The front and rear roller speed are faster than machine speed.</p> <p>定規動作的時間過早。 The hem guide timing is too fast.</p>	<p>調整針碼比例的參數。 Decrease the both roller speed.</p> <p>更改定規的參數。 Change parameter values.</p>

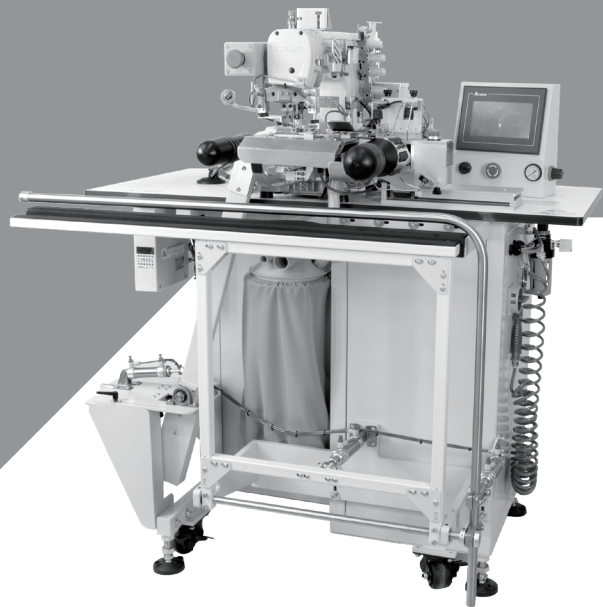
8、故障代碼解析 Error code analysis

故障代碼 Fault code	故障描述 Fault description	故障產生原因 Causes of failure	故障的解決方法 Fault solution
ER-03	斷線 break line	斷線 break line	檢查過線是否正常， 重新穿線 Check the thread and re-thread it
ER-04	斷線 break line	斷線 break line	檢查過線是否正常， 重新穿線 Check the thread and re-thread it
ER-05	斷線 break line	斷線 break line	檢查過線是否正常， 重新穿線 Check the thread and re-thread it
ER-06	斷線 break line	斷線 break line	檢查過線是否正常， 重新穿線 Check the thread and re-thread it
ER-07	斷線 break line	斷線 break line	檢查過線是否正常， 重新穿線 Check the thread and re-thread it

九、裝箱單

9、Packing list

名稱 Name	數量 Quantity
配件大禮包 Accessory package	1



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SGL-18U01.MAY.2023