

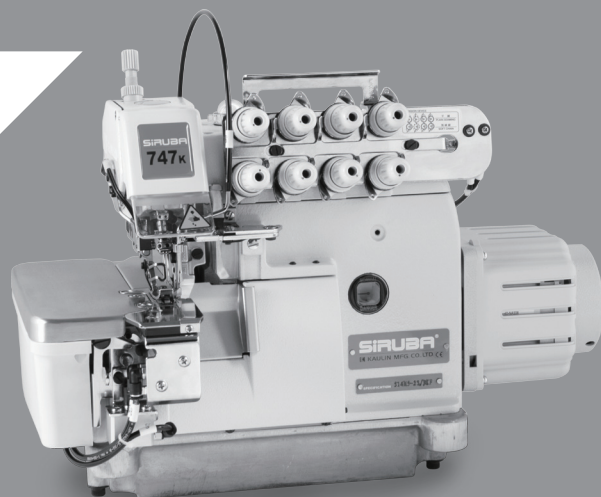
SIRUBA

ORIGINAL



使用說明書與零件圖

INSTRUCTION BOOK & PARTS LIST






700K-BKF



危險水準的說明 Explanation of Dangerous Level

 危險 Dangerous	<p>如果忽視此標記而運行了錯誤的機械操作, 保養時肯定會引起當事者或第三者人員重傷或死亡</p> <p>Don't ignore the warning sign and don't proceed incorrect operation. Or it will cause the person or the third party seriously injured or dead during maintenance.</p>
 注意 Caution	<p>如果忽視此標記而運行了錯誤的機械操作, 保養時有可能會引起當事者或第三者人員受傷及造成設備損壞</p> <p>Ignoring this warning sign and proceed incorrect operation will cause the person involved or the third party wounded and equipment damaged during maintenance.</p>

警告圖案表示及表示標誌的說明 Explanation of Warning Signs and Labels

警告圖案表示 Warning Sign		運動部位, 謹防工傷事故 Moving part, beware of industrial accident
		高壓部位, 謹防觸電事故 High voltage, beware of electric shock
		高溫部位, 謹防燙傷事故 High temperature, beware of burns
指示標誌 Instruction Label		禁止 Prohibited
		地線的接線表示 Indication of ground wiring

一般安全事項說明

GENERAL SAFETY INSTRUCTIONS

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謹記於心。

- 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**
勿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。保持工作場所良好的照明。當有引發火災或爆炸危險時，勿使用電源工具。
- 3. 防範於電擊危害**
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**
絕不要用電線端拉扯機器，或是從插座猛拉電線來拔掉電線。使電線遠離熱源、油類或是尖銳物品。
- 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 cause injuries.
- 2. Consider environment's safety**
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 may 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 object.
- 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. 分開機器

當不使用機器時、維修前、以及更換配件時。

9. 避免誤啟動

不要以手指置於啟動開關上之後，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

所有的修理工作應該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"認證的按壓啟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. 在調整、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啟動而造成危害。

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

IMPORTANT SAFETY INSTRUCTIONS

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。

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. 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,請詳細閱讀其他有關說明書。此外,請妥為保存這本使用說明書,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,所有安全配備必需安裝就緒,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. 此符號代表高電壓易導致發生危險,以下情形,請先關閉電源或拔掉插頭:
 - (1)若需拆開電控箱蓋時,請先關閉電源五分鐘後,才能拆開電控箱蓋,以避免誤觸電壓造成危險。
 - (2)穿針線、線導片、天平等以及更換梭子時。
 - (3)更換針板押具、送具、頂針片、喇叭、車布導板,以及其他附屬配件時。

-  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. Hazardous Voltage will cause injury, please turn off the power switch or disconnect it for any one of the circumstances of the followings:
 - (1) Turn off the main switch and wait for 5 minutes, before opening this cover to protect yourself from danger.
 - (2) When threading needle(s), adjusting thread Take-up(s), thread guide(s), and/or replacing bobbin(s).
 - (3) When replacing needles, presser feet, needle plates, feed dogs needle guard, folder, cloth guides and other parts or accessories.

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



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或配件及注意機器電源是否已開啟, 以免導致人員受傷。



10. 維修、修改及調整等工作, 需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需予以消除, 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。



14. 機器使用一段時間, 必需定期清理。

- (4) When repairing,
- (5) When the operator leaves the working place or leaves the machine unattended.
- (6) 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 hose 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. To ensure the best performance, periodically clean the machine is necessary.


 15. 為使機器能正常操作及減少噪音，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，且插頭必需插在有接地線的之插座上。


 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. 修改或變更機器必需依照安全規定及標準，同時採取有效的安全措施，本公司不承擔任何因私自修改或變更機器所引起損壞之責


19. 警告標誌以兩種符號標示：


 (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) 必需特別注意事項
a. 絕對不可在移開皮帶蓋，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

 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


 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. Please keep your hair, fingers and cloths 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. 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。



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. 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，必需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。



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. 當放置或抬起機頭時，小心勿將手置於機器中，以免導致人員受傷。



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. 為了避免機器突然啟動而引起可能意外，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。



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. 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，為了避免機器突然啟動而引起可能意外，故請關掉機器電源。



g. For machines 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。



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









- 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。



- 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

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做好接地作業。
-  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。

WARNING

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 ground.
-  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.



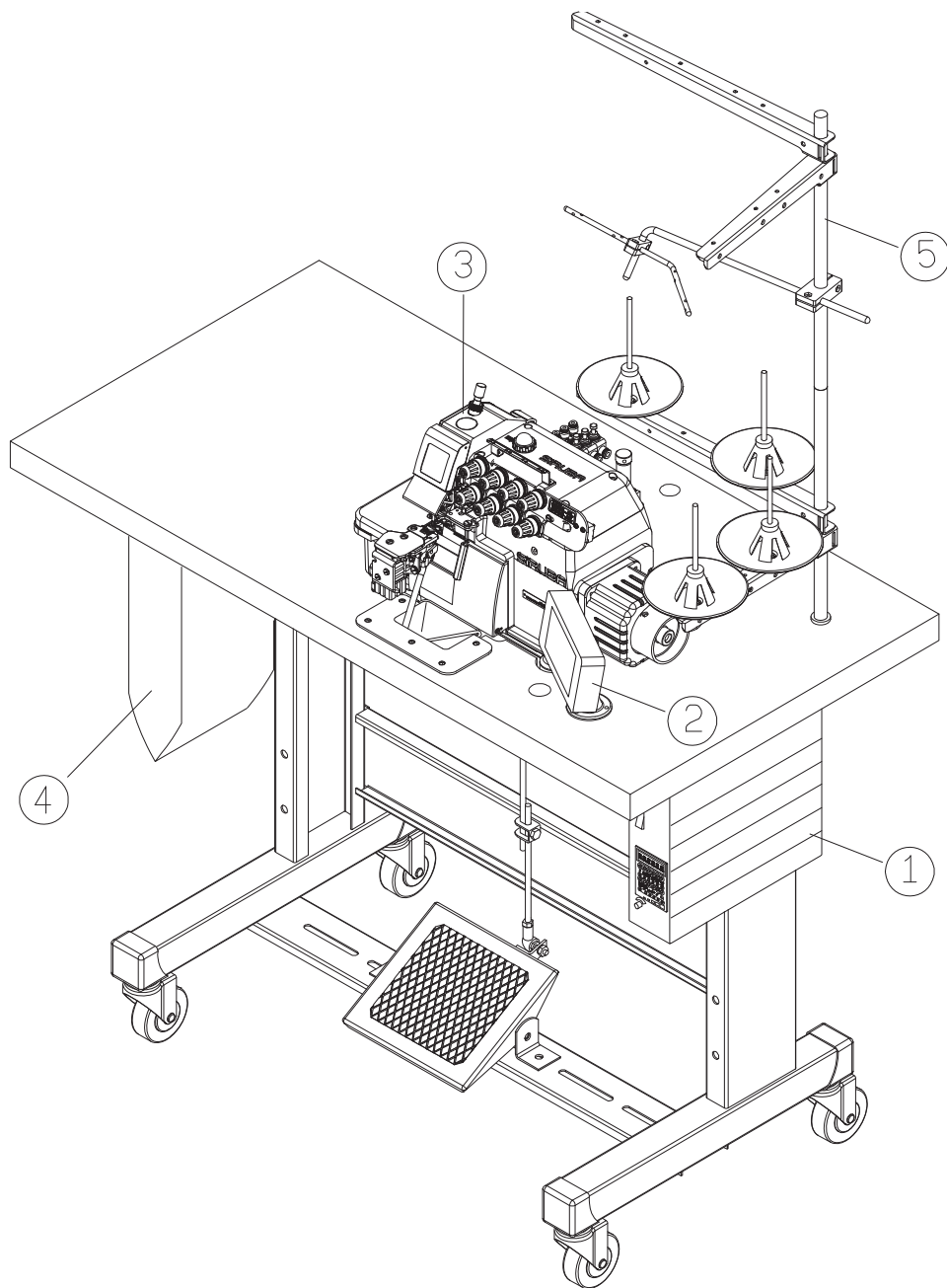
Warning :

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.

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I. 各部件名稱/Part Names



- ① 控制箱 / Operation Box
- ② 操作盒 / Operation Padel
- ③ 機體/Machine
- ④ 吸風集塵裝置 / Dust collecting suction device
- ⑤ 線架 / Thread Frame

II. 安裝與調整 / Installation and Adjustment

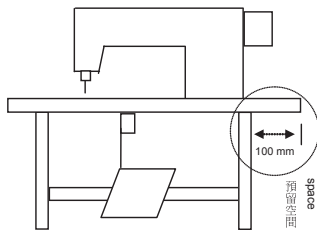
(1).馬達的安裝：請參閱各車頭製造廠之說明書。

Motor installation: Please refer to the machine head's instruction.

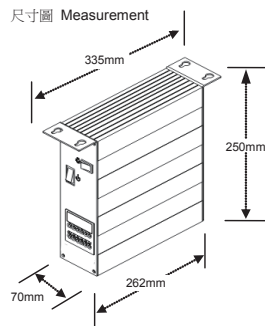
(2).控制箱的安裝：

Control Box Installation:

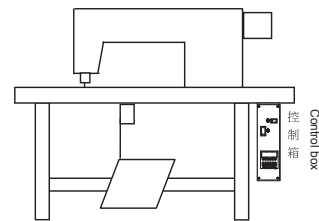
a).桌板右側面須預留 100 mm 以上空間
Leave 100 mm space at right



b).將控制箱鎖裝於桌板下方
Mounting under the working table



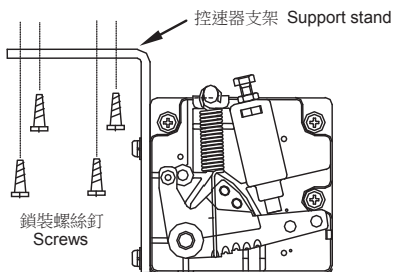
c).安裝後示意圖
Installation layout



(3).控速器的安裝：

Speed Control Unit Installation:

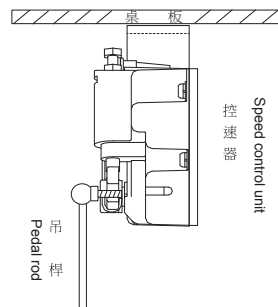
a).控速器與其支架座
Speed Control Unit



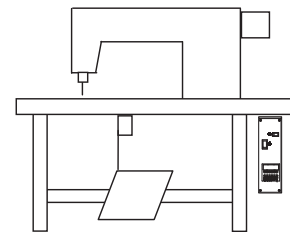
鎖裝螺絲釘時，需以螺絲起子全程鎖裝。

Always use screwdriver to tightly secure screws

b).保持在吊桿成直線下，將控速器連座鎖於桌板下方
Keep rod in vertical, secure the unit under the table



c).安裝後示意圖
Installation layout



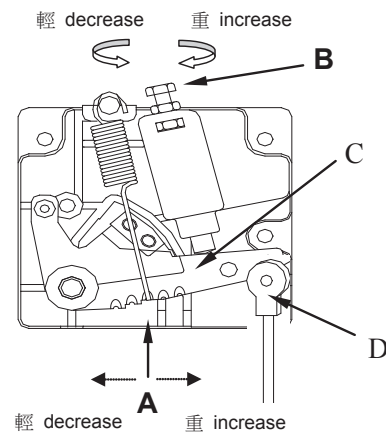
(4).控速器前/後踏力量的調整：

Adjust the speed control unit:

控速器各部位名稱：如右圖示

Components of the speed control unit: see figure

- A：前踏力量彈簧 / Spring for toeing forward force adjustment
- B：後踏力量的調整螺栓 / Bolt for heeling backward force adjustment
- C：踏板旋臂 / Treadle / Pedal arm
- D：腳踏吊桿 / Pitman Rod for Treadle / Pedal



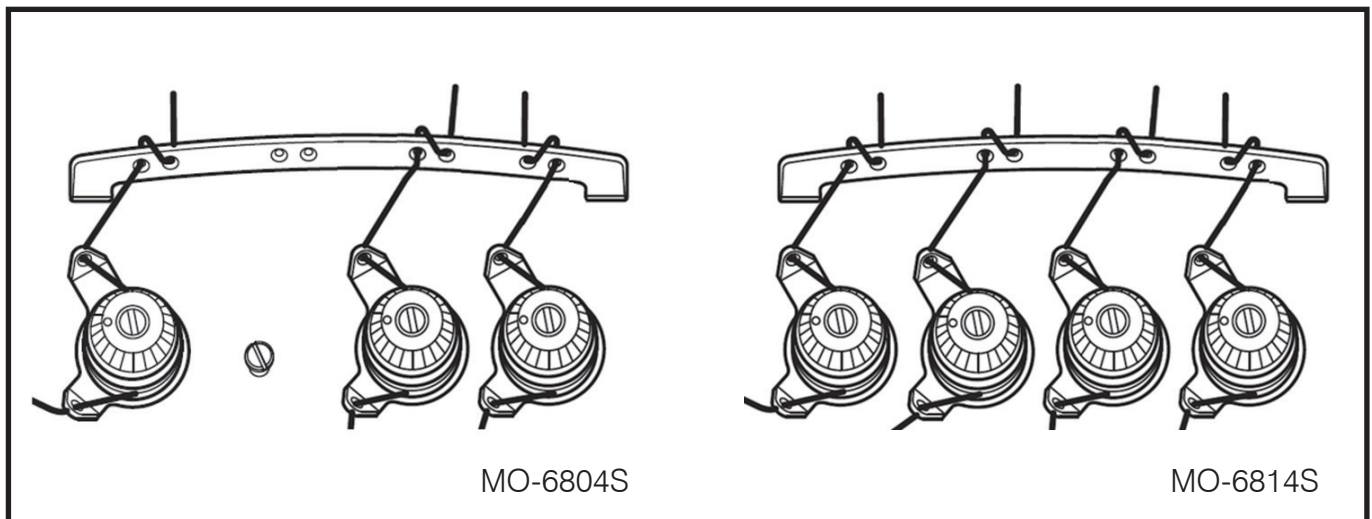
調整需求 Term of adjustment		調整結果 Adjustment result
1	踏板前踏力量的調整 Toeing forward force adjustment	當彈簧 A 愈向右側勾時，表示力量愈重。 Spring A move to right = force increased. 當彈簧 A 愈向左側勾時，表示力量愈輕。 Spring A move to left = force decreased.
2	踏板後踏力量的調整 Heeling backward force adjustment	當螺栓 B 愈向上 ↶ 時，則後踏力量愈輕。 Bolt B turn ↶ = force decreased. 當螺栓 B 愈向下 ↷ 時，則後踏力量愈重。 Bolt B turn ↷ = force increased.
3	踏板行程長短的調整 Treadle stroke adjustment	當吊桿 D 向右側孔鎖裝時，表示行程較長。 Rod D secure at right = stroke is longer. 當吊桿 D 向左側孔鎖裝時，表示行程較短。 Rod D secure at left = stroke is shorter.

(5) 關於穿線：

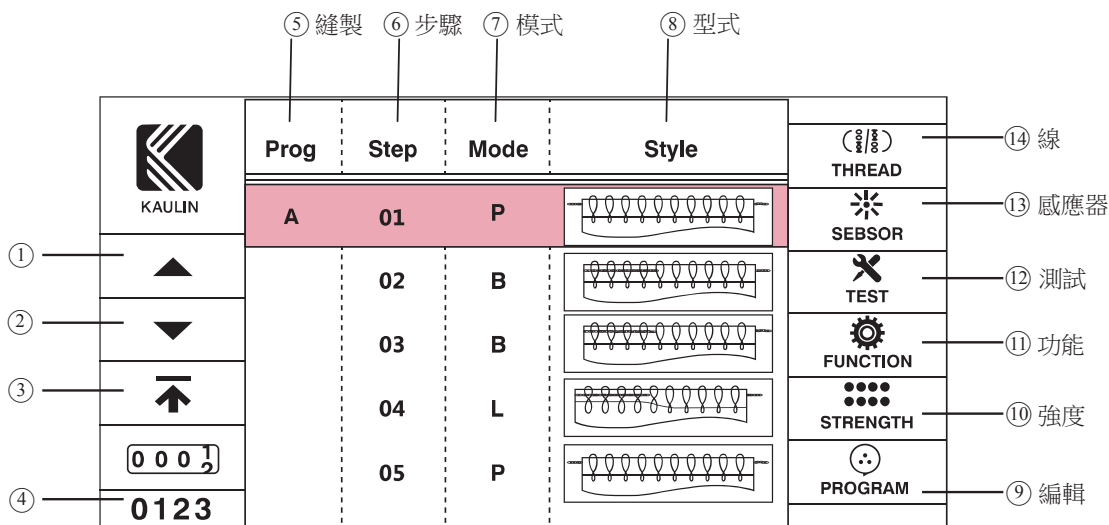
Tips for threading:

如果勾針常脫落，請以以下過兩孔的方式穿線。

If looper threads drop out frequently, please change threading by going through two holes, as below pictures.



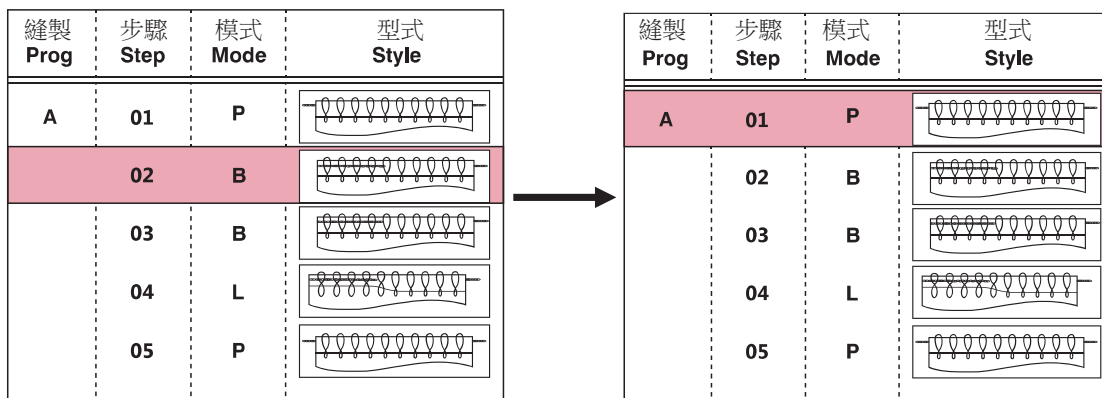
III. 縫製畫面 / Sewing screen




①  螢幕光棒上移鍵 / Shift upward

說明：每按一次上移鍵，光棒則返回上一階。

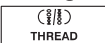
Description: To go to the previous step when press shift upward key.



注意!

按此鍵，縫製模式由 Step 02 (B) 返回 Step 01 (P) 或者由 Step 05 (P) 返回 Step 04 (L) 時，必須在沒有布料的狀態下，踩下踏板或者按下空線鍵重置鍵 ，進行空線鍵重置動作。若縫製模式由 step4 (L) 返回 step3 (B) 時，不必進行空線鍵重置動作。

CAUTION!

If the sewing mode returns to Step 01 (P) from Step 02 (B) or to Step 04 (L) from Step 05 (P) when press shift upward key, be sure to press the machine treadle once with no fabric under the sensor or press  thread key in order to proceed with the sewing operation. When the sewing mode returns to Step 03 (B) from Step 04 (L), there is no need to press treadle or the thread key.

- ②  螢幕光棒下移鍵 / Shift downward

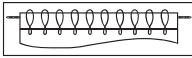
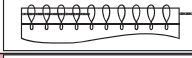
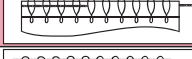

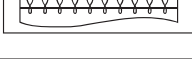
說明：每按一次下移鍵，光棒則往下一階。

Description: To go to the next step when press shift downward key.

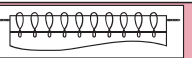
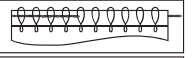
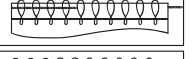


- ③  回到縫製模式Step 01 / return to the first step

說明：按此鍵後會回到縫製模式 Step 01。



Description: Press key to return to the first step (sewing mode).

縫製 Prog	步驟 Step	模式 Mode	型式 Style
A	01	P	
	02	B	
	03	B	
	04	L	
	05	P	



→

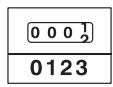
縫製 Prog	步驟 Step	模式 Mode	型式 Style
A	01	P	
	02	B	
	03	B	
	04	L	
	05	P	

注意!

按此鍵 ，縫製模式將由 Step 03 (B) 返回 Sep 01 (P)，必須在沒有布料的狀態下，踩下踏板或者按下空線鍵重置鍵 ，進行空線鍵重置動作。


CAUTION!

If the operation type (sewing mode) changes by pressing  key, be sure to press the machine treadle once with no fabric under the sensor or press  thread key before starting a sewing operation.

- ④  計數器 / Counter

說明：縫製物計數用，按此鍵 3 秒可重置計數器。

Description: fabric counting. Press the button 3 seconds to reset the counter.

- ⑤  縫製工程 / Programs

說明：縫製工程,共 A~Z 26 個工程。

Description: the sewing programs, a total of 26 types (A~Z).

- ⑥  縫製段數 / Steps

說明：縫製段數, 共有 20 段。

Description: sewing number of step, a total of 20 steps.

⑦



縫製模式 / Sewing mode

說明：顯示縫製模式,共有 5 種縫製模式(B、P、R、S、L)。

Description: displays a type of sewing mode, a total of 5 sewing modes(B、P、R、S、L).

⑧



縫製圖形 / Sewing patterns

說明：顯示各種縫製模式的圖形。

Description: all kinds of sewing patterns.

⑨



編輯畫面 / Programming key

說明：按此鍵後進入到編輯畫面。

Description: to enter the programming screen.

⑩



鬆線緊度調整鍵 / Strength key

說明：按此鍵會切換到鬆線緊度調整畫面。

Description: to adjust the sewing performance after replacing the needle or threading the machine.

⑪



參數設定鍵 / Function key

說明：按此鍵會切換到參數設定畫面。

Description: press this key, it will switch to the parameter setting mode.

⑫



輸出裝置測試鍵 / Device test key

說明：按此鍵時會進入輸出裝置測試畫面。

Description: press key into the solenoid valve test screen.

⑬



電眼布料檢知器 / Fabric detecting sensor

說明：當有檢出到有布料時，由原先淡紅色變成深紅色。

Description: When sensor detected the fabric, the original light red would change to dark red.

⑭



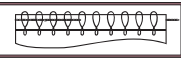
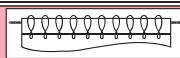
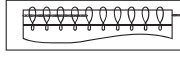
空線鍵重置鍵 / Thread key


說明：執行空線鍵重置的動作。


Description: To perform a SET UP operation.


例1. 當工程 B (縫製模式為倒回縫 B) 變更為工程 A (縫製模式為基本縫 P) 時，夾線裝置還殘留著工程 B 的空線鏈。


When the kind of Prog is changed from B (its first step is backlatching) to A (its first step is plain seaming), the thread chains is still remaining in the clamp for backlatching operation of the Prog B.

縫製 Prog	步驟 Step	模式 Mode	型式 Style
B	01	B	
A	01	P	
	02	B	

變更為工程 A 後就開始縫紉，即使縫製模式為基本縫 (P)，縫出來還是倒回縫 (B)。為了進行基本縫 (P)，必須踩下踏板或者按下空線鏈重置鍵 ，取掉夾線裝置內的空線鏈。

With the thread chain held in the clamp, the machine performs the Backlatching operation even if the plain seaming is to be performed as the first step. To carry out the plain seaming, press  thread key or the machine treadle so that the thread chain is released from the clamp to get the machine ready for plain seaming.

例2. 當空線鏈沒有被夾線裝置夾住時，則無法完成倒回縫 (B) 的動作，必須下一次縫紉前，踩下踏板或者按下空線鏈重置鍵 ，進行空線鏈重置動作。

As the thread chain is not held with the clamp, a backlatching operation cannot be performed. Press  thread key or the machine treadle once with toe. The machine gets activated and the thread chain is held in the clamp for the next operation.

⑤ **No.** 參數代碼 / Parameter no.

說明：參數代碼。

Description: parameter no.

⑥ **Description** 參數名稱 / Parameter name

說明：只顯示該縫製模式相關的參數,無關的參數不顯示,下表為縫製模式和參數的關係表:

Description: show only the sewing mode related parameters unrelated parameters are not displayed. The following table shows the sewing modes and parameters of the relationship table:

No.	Parameter name 參數名稱	P	B	R	S	Pc	Bc	Rc	Sc	L
03	SC Start Count SC 開始計數	V	V	V	V					V
04	SC Start (Condensed) SC 開始(密縫)					V	V	V	V	
05	SC End Count SC 結束計數	V	V			V	V			V
06	Chain Return Cnt 鏈線返回計數		V	V	V		V	V	V	V
13	MS Start Counter MS 開始計數器					V	V	V	V	
14	MS Counter MS 計數器					V	V	V	V	
16	RS STOP Counter RS 停止計數器			V				V		
17	RS Counter RS 計數器			V				V		
21	Special BLSC Cnt 特規 BLSC 計數				V				V	
22	Loose BL Counter 鬆弛 BL 計數器									V
25	Clamp 夾具	V	V	V	V					V
26	Length 長度	V	V	V	V					V
27	C Clamp C 夾具					V	V	V	V	
28	C Length C 長度					V	V	V	V	

⑦ **Value** 參數設定值 / Parameter value

說明：參數設定值

Description: parameter value

⑧ **+
-** 參數值調整鍵 / Parameter value ADJ. key

說明：調整參數值用。

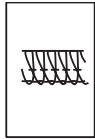
Description: to modify the parameter value.

⑨ **▲
▼** 參數選擇鍵 / Parameter select key

說明：選擇參數用。

Description: to select parameters.

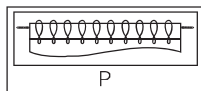
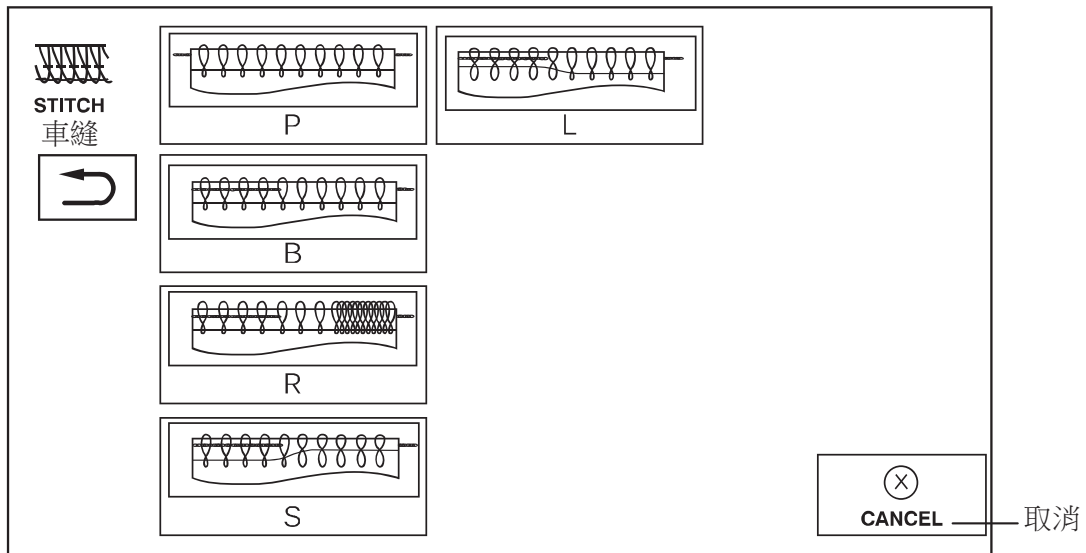
⑩



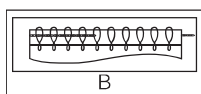
縫製模式選擇鍵 / Sewing mode select key

說明：進入縫製模式選擇畫面,縫製模式選擇畫面如下圖所示：

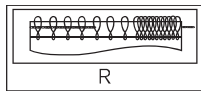
Description: Enter sewing mode select screen, sewing mode select screen shown below:



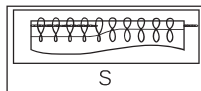
：基本縫 / Plain seaming



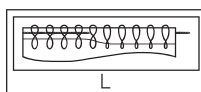
：包線頭 / Backlatching



：包線頭+返回縫 / Backlatching+Reverse stitching




：特殊包線頭/ Special backlatching



：開始縫鬆弛包線頭/ Loose backlatching




：刪除縫製模式 / Delete sewing mode

- ⑪  縫製段數選擇鍵 / Step select key

說明：切換縫製段數用。


Description: to switch Step.

- ⑫  縫製工程選擇鍵 / Programs select key

說明：切換縫製工程用,共 A~Z 26 個工程。

Description: to switch Program, a total of 26 types (A~Z).

V. 參數設定畫面 / Parameter setting screen

	② No.	③ 說明 Description	④ 值 Value
① 功能 	01	PL MODE PL 模式	A
	02	PL TIME PL 時間	100
	03	SC Start Count SC 開始計數	2
	04	SC Start SC 開始	2
	05	SC End Count SC 結束計數	2
	▲		+
	▼		-

①  返回鍵 / Return key


說明：返回到縫製畫面。

Description: back to the sewing screen.

②  參數代碼 / Parameter no.


說明：參數代碼。

Description: parameter no.

③  參數名稱 / Parameter name


說明：顯示參數名稱。

Description: sew parameter name.

④  參數設定值 / Parameter value


說明：參數設定值。

Description: parameter value.

- ⑤  參數值調整鍵 / Parameter value ADJ key

說明：調整參數值用。

Description: to modify the parameter value.

- ⑥  參數選擇鍵 / Parameter select key

說明：選擇參數用。

Description: to switch parameter.

參數表 1/5 / Parameter List 1/5

NO.	參數名稱 Description	設定值範圍 Range of values	值 Val.	參數的功能說明 Description of the parameters	屬性 Pty.	Oper	Mech
01	PL MODE PL 模式	0=Manual / 1=Auto	A	手/自動抬壓腳 PL(presser foot lift)	獨 exclusive	V	V
02	PL TIME PL 時間	50~2000	150	自動抬壓腳的延遲時間 Presser foot timer(ms)	獨 exclusive	V	V
03	SC Start Count SC 開始計數	0~99	2	設定B、P、R、S啟縫時從空線環變為基本縫的針數。 In each mode of B, P, R and S, set the stitch at which the thread chain mode is changed to the plain seaming mode at the start of sewing	獨 exclusive	V	V
04	SC Start (Condensed) SC 開始(密縫)	0~99	2	設定 Bc,Pc,Rc,Sc 啟縫時從空線環變為基本縫的針數。 In each mode of Bc, Pc, Rc, and Sc, set the stitch at which the thread chain mode is changed to the plain seaming mode at the start of sewing.	獨 exclusive	V	V
05	SC End Count SC 結束計數	0~98	2	設定從縫紉完的基本縫變為空線環時針數 To set the stitch at which the plain seaming mode is changed to the thread chain mode at the end of sewing	獨 exclusive	V	V
06	Chain Return Cnt 鏈線返回計數	1~99	4	設定返回夾空線環的針數 To set the stitch when the thread chain clamp returns home.	獨 exclusive	V	V
07	End Count 結束計數	1~99	35	設定在縫紉完後布料從感應器抽出時,縫紉機自動停止,針板中間爪(雙針)後退的針數 To set the stitch when the machine stops automatically and the needle plate chaining-off finger (on 2-needle machine) retracts after the fabric has gone through the sensor light.	獨 exclusive	V	V

參數表 2/5 / Parameter List 2/5

NO.	參數名稱 Description	設定值範圍 Range of values	值 Val.	參數的功能說明 Description of the parameters	屬性 Pty.	Oper	Mech
08	Start Mode 開始模式	M / A	M	選擇縫紉機啟動的自動/手動 Select the sewing machine to start automatic / manual	獨 exclusive	V	V
09	Machine Start Tr 機器開始踏板	50~2000	50	縫紉機自動啟動時踩下縫紉機踏板,在返回到中間位置後,設定幾秒後啟動縫紉機的時間 To set the time interval from the pressed treadle is released to when the machine starts running.	獨 exclusive	V	V
10	Item Change with 項目切換	Mech / Oper	Mech	<ul style="list-style-type: none"> ●"Mech":用維修人員等級的參數設定畫面 Mechanic level parameter setting screen ●"Oper":用操作人員等級的參數設定畫面 Operator level parameter setting screen 	共 sharable	V	V
11	Reserve 保留	0 / 1		保留 Reserve	共 sharable		V
15	Reverse Seam 倒縫	Off / On	On	選擇返回縫功能的 ON/OFF reverse stitching mode is set to ON/OFF	共 sharable		V
16	RS STOP Counter RS 停止計數	0~99	2	設定當布料從布料感應器下抽出後,縫紉機縫幾針才停下來 To set the stitch at which the machine stops after the fabric comes off from the fabric detection sensor.	獨 exclusive		V
17	RS Counter RS 計數	0~99	10	設定將布料翻轉後,再縫紉多少針數 / Enter the number of reverse stitches after turning over the fabric.	獨 sharable		V
18	Mesh Counter Set 網眼布計數設定	Off / On	Off	縫紉網眼布料時設定為 ON Select ON when sewing a mesh fabric	共 sharable		V
19	Mesh Counter 網眼布計數	0~99	3	設定通過網眼孔部分的針數 Set this stitch when sewing mesh fabrics	獨 exclusive		V
20	Chain BlowRearTr 空線鏈返回	50~1500	400	設定空線鏈返回狀態氣壓應吹出多少時間 (ms) Adjust the time interval for blowing the thread chain at the end of sewing depending on how the thread chain returns smoothly	獨 exclusive		V

參數表 3/5 / Parameter List 3/5

NO.	參數名稱 Description	設定值範圍 Range of values	值 Val.	參數的功能說明 Description of the parameters	屬性 Pty.	Oper	Mech
21	Special BLSC Cnt 特規 BLSC 計數	0~99	10	縫製模式 S 或 Sc 時,啟縫幾針時解除鬆線功能 Set the stitch at which the thread releasing stops from the start of sewing on S or Sc mode.	獨 exclusive		V
22	Loose BL Counter 鬆弛 BL 計數	0~99	30	做緊身褲等的鎖縫工序時,將開始縫橡筋部的接縫設定到線鏈壓線處的計數器; 縫製模式 L,啟縫時從空線環變為基本縫的針數. In sewing mode of L, set the stitch at which the thread chain mode is changed to the plain seaming mode at the start of sewing	獨 exclusive		V
23	Set Up Selection 設置選擇	SW / Pedal / SW&Pedal	SW	對於設置動作,可選擇由”設置開關”、”腳踏 板”或”設置開關&腳踏板”進行設置 SW:to perform a SET UP operation by “THREAD”key Pedal:to perform a SET UP operation by pedal SW&Pedal: to perform a SET UP operation by “THREAD”key or pedal	共 sharable		V
24	PL Selection PL 選擇	H&P / P / H	P	H&P:啟用一般踏板和立作業踏板 pedal support standard pedal and twinning P: 啟用一般踏板 support standard pedal H: 啟用立作業踏板 support twinning pedal	共 sharable		V
25	Clamp 夾具	0 / 99	15	縫製模式為 B,R,S,L 時,布料啟縫處發生收縮 或殘留空線鏈時需要進行設定. In each mode of B, R, S and L, Set this counter when a fabric tends to shrink at the start of sewing or when the thread chain knots tend to be produced in backlatching operation.	獨 exclusive	V	V
26	Length 長度	0 / 99	20	縫製模式為 B,R,S,L 時,倒回縫空線鏈長度的 設定 In each mode of B, R, S and L, to set the backlatching thread chain length	獨 exclusive	V	V

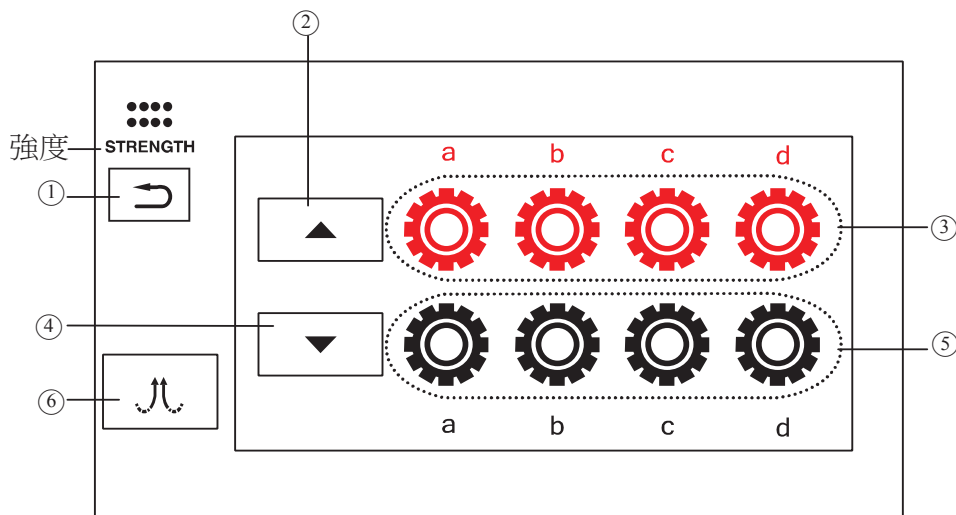
參數表 4/5 / Parameter List 4/5

NO.	參數名稱 Description	設定值範圍 Range of values	值 Val.	參數的功能說明 Description of the parameters	屬性 Pty.	Oper	Mech
29	Reserve 保留	0 / 1		保留 Reserve	獨 exclusive		V
30	Reserve 保留	0 / 1		保留 Reserve	獨 exclusive		V
31	Reserve 保留	0 / 1		保留 Reserve	獨 exclusive		V
32	Reserve 保留	0 / 1		保留 Reserve	獨 exclusive		V
33	P NS CNT	1~99	20	P和Pc模式時,設定在縫紉完後布料從感應器抽出時,縫紉機自動停止的針數 In sewing mode P&Pc, to set the stitch when the machine stops automatically after the fabric has gone through the sensor light.	獨 exclusive		V
34	P NS TEN	1~99	10	P 和 Pc 模式時,設定在縫紉完後布料從感應器抽出時,縫紉多少針數後做夾線動作 In sewing mode P&Pc, to set the stitch when the clamp works automatically after the fabric has gone through the sensor light.	獨 exclusive		V
35	P SE CNT	1~99	1	P和Pc模式時,設定在縫紉完後布料從感應器抽出時,縫紉機自動車縫多少針數,再執行“Param33.(P NS CNT)”的針數 In sewing mode P&Pc, set the stitch after the fabric has gone through the sensor light, sewing machines, automatic sewing how many stitches, and then execute the “Param33.(P NS CNT)”	獨 exclusive		V
36	Buzzer On-Off 蜂鳴器 On-off	Off / On	On	按鍵聲的開啟或關閉 To set buzzer on or off	共 sharable	V	V
37	Safety switch 安全開關	NO / NC / off	off	設定安全開關為“常開式”,“常閉式”或禁用 To set safety switch normal open. normal close or no use	共 sharable	V	V
38	Restore default 儲存預設值	nop / run	nop	回復出廠設定值 Restore parameter default value	共 sharable	V	V
39	LCD auto pwr off LCD 自動斷電	Off / On	Off	LCD 一分鐘自動斷電功能開啟或關閉 LCD minute automatically power-off function is turned on or off	共 sharable	V	V

參數表 5/5 / Parameter List 5/5

NO.	參數名稱 Description	設定值範圍 Range of values	值 Val.	參數的功能說明 Description of the parameters	屬性 Pty.	Oper	Mech
40	LCD brightness LCD 亮度	0~99	99	LCD 亮度設定 To set LCD brightness	共 sharable	V	V
41	Motor Speed 馬達速度	500 ~ 9999	4000	縫製最高速度設定(spm) sewing maximum speed	共 sharable		V
*42	Position 定位	0 ~ 359	0	伺服馬達上定位角度調整 Servo motor up-position angle adjustment	共 sharable		V
43	Reserve 保留	0 / 1		保留 Reserve	共 sharable		V
44	Reserve 保留	0 / 1		保留 Reserve	共 sharable		V
45	Reserve 保留	0 / 1		保留 Reserve	共 sharable		V

VI. 鬆線緊度調整畫面 / Elastic adjustment screen



- ①  返回鍵 / Return key


說明：返回到縫製畫面。

Description: back to the sewing screen.

- ②  上排鬆緊裝置動作 / To activate top row elastic device

說明：按此鍵時，上排鬆緊裝置動作，可做線張力調整用。

Description: press this key, activate top row elastic device, can be use as thread tension adjustment.

- ③  上排鬆緊裝置 / Top row elastic device

說明：上排鬆緊裝置，"a" 與 "b" 為直縫線用，"c" 與 "d" 為環縫線用。

Description: top row elastic device, "a" and "b" for line sewing, "c" and "d" for link sewing.

- ④  下排鬆緊裝置動作 / To activate bottom row elastic device


說明：按此鍵時，下排鬆緊裝置動作，可做線張力調整用。

Description: press this key, activate bottom row elastic device, can be use as thread tension adjustment.

- ⑤  下排鬆緊裝置 / Bottom row elastic device

說明：下排鬆緊裝置，"a" 與 "b" 為直縫線用，"c" 與 "d" 為環縫線用

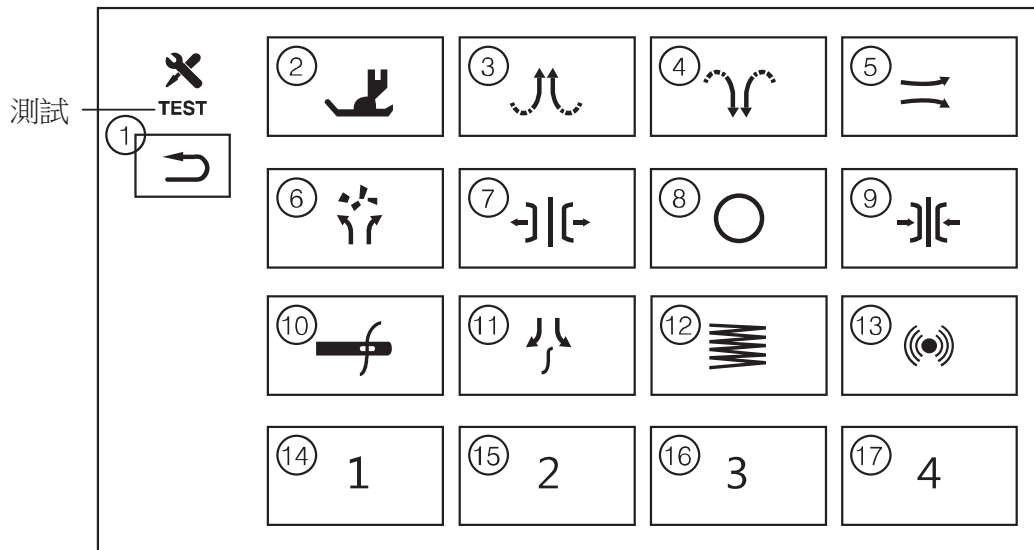
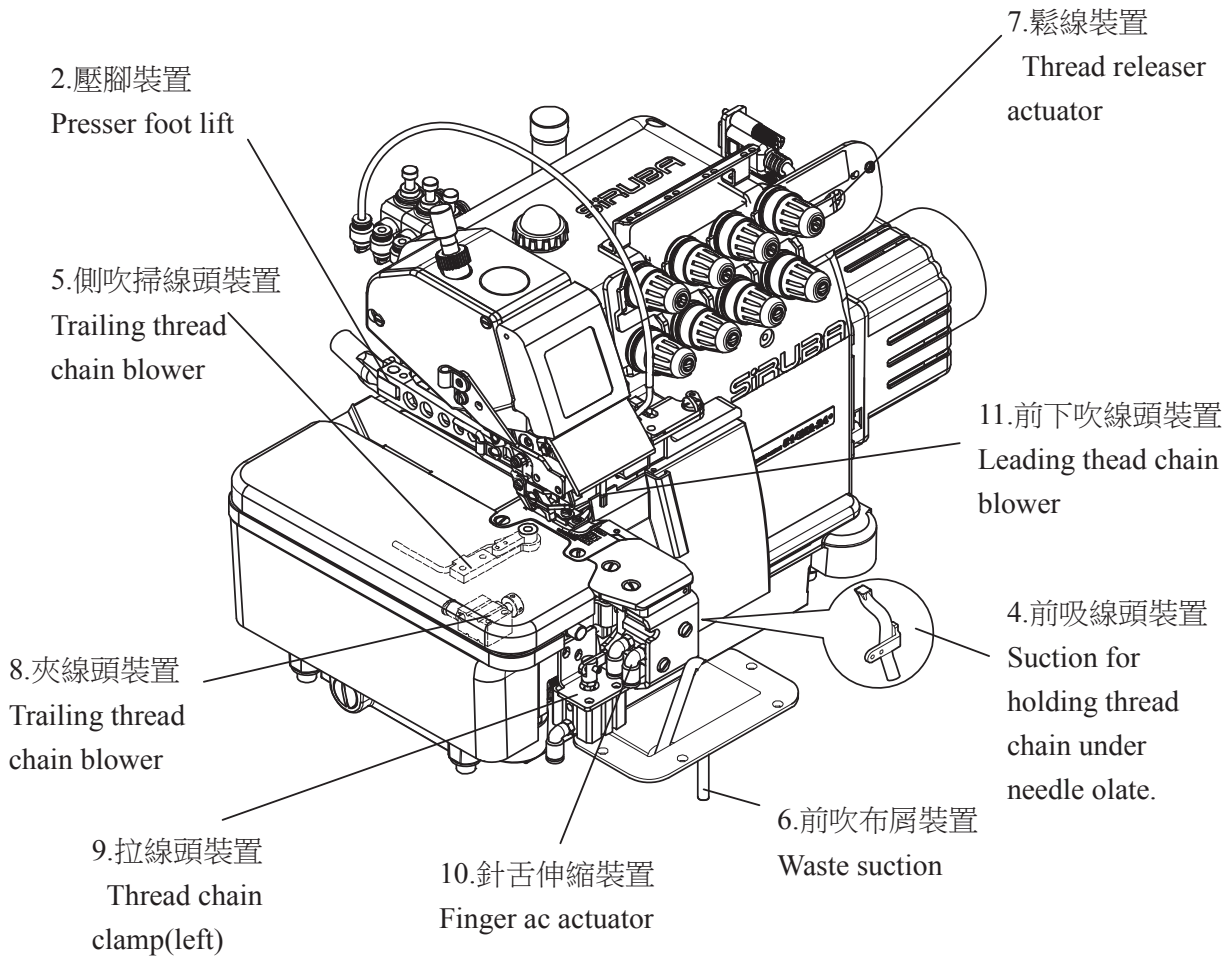
Description: bottom row elastic device, "a" and "b" for line sewing, "c" and "d" for link sewing.

- ⑥  後吸風切線裝置 / Thread rear suction device



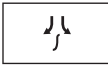


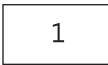
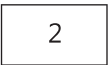
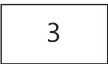

說明：啟動或關閉後吸線頭裝置功能

Description: turn on or turn off thread rear suction device

VII. 裝置測試畫面 / Solenoid valve test screen

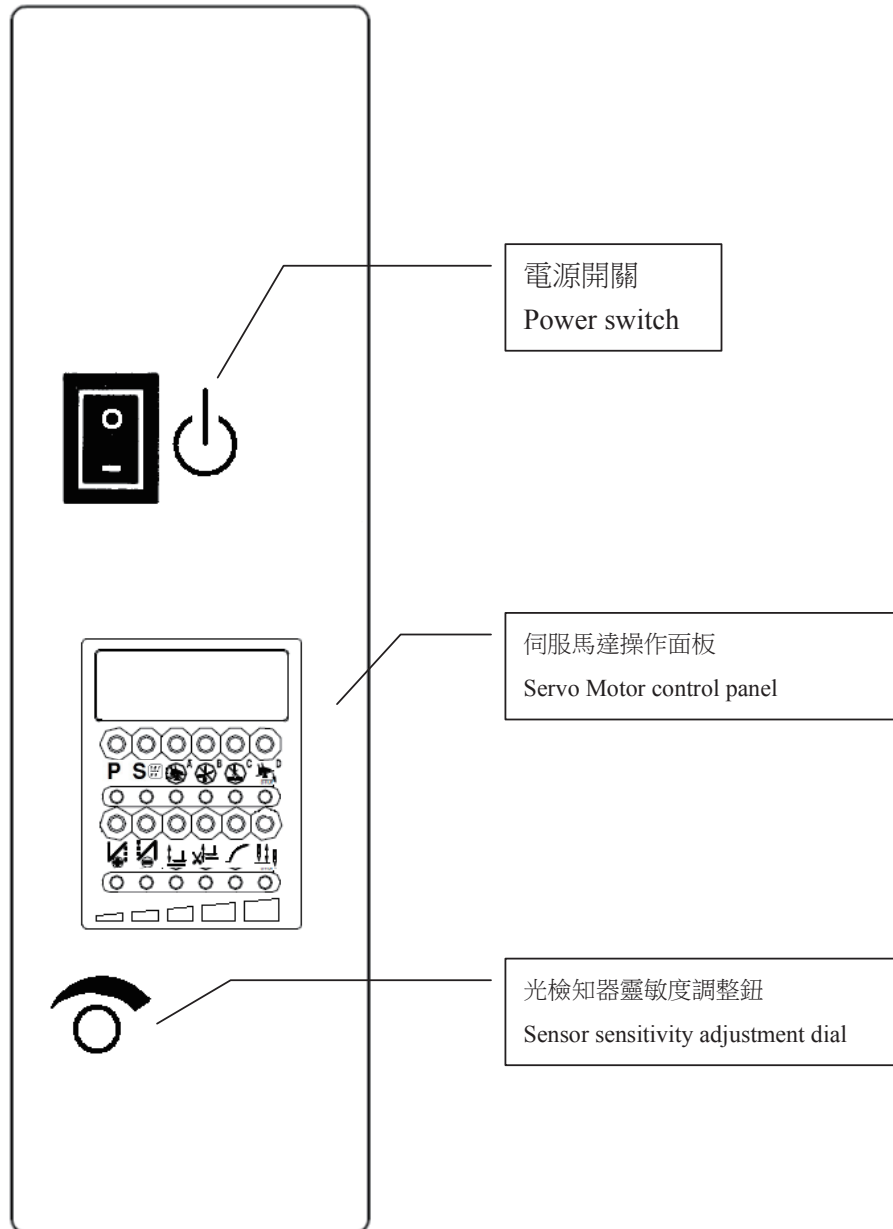


- ①  返回鍵 / Return key
說明：返回到縫製畫面。
Description: back to the sewing screen.
- ②  押腳裝置 / Presser foot lifter
說明：押腳功能測試鍵。
Description: check presser foot function.
- ③  後吸風切線裝置 / Chain cutter rear suction
說明：後吸線頭裝置測試鍵。
Description: check chain cutter suction function.
- ④  前吸線頭裝置 / Suction for holding thread chain under needle plate
說明：前吸線頭裝置測試鍵。
Description: check suction for holding thread chain function.
- ⑤  側吹掃線頭裝置 / Trailing thread chain blower
說明：側吹線頭裝置測試鍵。
Description: check trailing thread chain blower function.
- ⑥  前吹布屑裝置 / Waste suction
說明：前吹布屑裝置測試鍵。
Description: check waste suction function.
- ⑦  鬆線裝置 / Thread releaser actuator
說明：鬆線裝置測試鍵。
Description: check thread releaser actuator function.
- ⑧  夾線頭裝置 / Thread chain clamp(right)
說明：開孔裝置測試鍵。
Description: check thread chain clamp(right) function.

- ⑨  拉線頭裝置 / Thread chain clamp(left)
說明：夾線裝置測試鍵。
Description: check thread chain clamp(left) function.
- ⑩  針舌伸縮裝置 / Finger actuator
說明：編織桿裝置測試鍵。
Description: check finger actuator function.
- ⑪  前下吹線頭裝置 / Leading thread chain blower
說明：前吹線頭裝置測試鍵。
Description: check leading thread chain blower function.
- ⑫  送具上下 / the upper or bottom feed dog
說明：密縫裝置測試鍵。
Description: check cylinder for condensed stitching function.
- ⑬  蜂鳴器裝置 / Buzzer
說明：蜂鳴器裝置測試鍵。
Description: check buzzer function.
- ⑭  1 保留 / Reserve
- ⑮  2 保留 / Reserve
- ⑯  3 保留 / Reserve
- ⑰  4 保留 / Reserve

VIII. 控制箱說明 / Description of the control box

前視圖 / Front side



後視圖 / Rear side

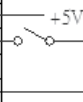
ENCODER	
1	+5V
2	UP
3	DOWN
4	A PHASE
5	B PHASE
6	R
7	S
8	T
9	0V

SYNCHRONIZER	
1	---
2	+5V
3	DOWN
4	0V
5	NO SYNC.
6	---
7	UP
8	ENC

LEVER	
1	+12V
2	START
3	VC
4	FRONT
5	VC1
6	BACK
7	KNEE SW.
8	TM
9	0V

OPERATION BOX	
1	+12V
2	---
3	T1out
4	R1in
5	---
6	---
7	T2out
8	R2in
9	0V

SENSOR		
1	+5V	+5V
2	INB	PSD
3		---
4	0V	0V


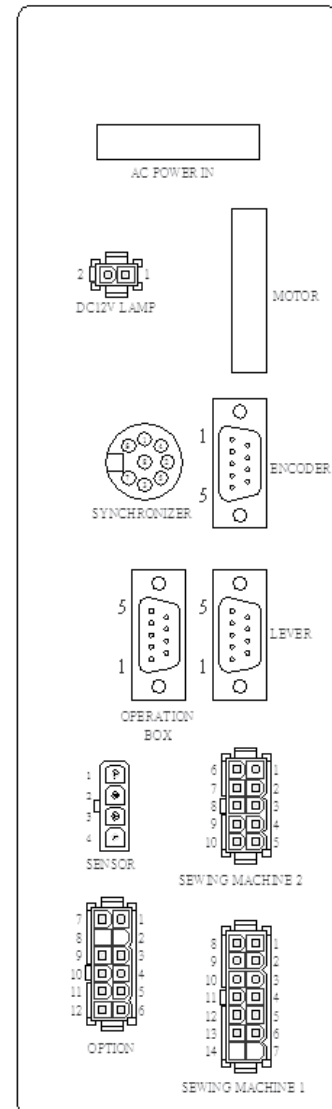


SEWING MACHINE 1			
1	OA	側吹線頭 Trailing thread chain blower	MT
8	+24V	+24V	
2	OB	前吸線頭 Suction for holding thread chain	MY
9	+24V	+24V	
3	OC	後吸線頭 Chain cutter suction	MR
10	+24V	+24V	
4	OD	前吹線頭 Leading thread chain blower	ML
11	+24V	+24V	
5	O2	前吹布屑 Waste suction	NCL
12	+24V	+24V	
6	O7	密縫 Condensed stitching	OT
13	+24V	+24V	
7		---	
14		---	

SEWING MACHINE 2			
1	O1	開線頭孔 Thread chain clamp-R	OP
6	+24V	+24V	
2	OF	押腳 Presser Foot lift	MP
7	+24V	+24V	
3	O3	夾線 Thread chain clamp-L	HP
8	+24V	+24V	
4	O4	鬆線 Thread releaser actuator	O4
9	+24V	+24V	
5	O5	編織桿 Finger actuator	O5
10	+24V	+24V	

OPTION			
1	O6	OUTPUT1	O6
7	+24V	+24V	
2		---	
8		---	
3	IN4	INPUT1	
9	0V	0V	
4	IN5	INPUT2	
10	0V	0V	
5	INL	INPUT3	
11	0V	0V	
6	INF	FL INPUT	
12	0V	0V	

DC+12V LAMP		
1	0V	0V
2	+12V	+12V

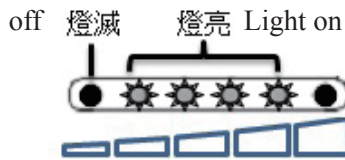



IX. 光檢知器靈敏度調整 / Sensor sensitivity adjustment

- 1 開啟電源 / Turn on the power

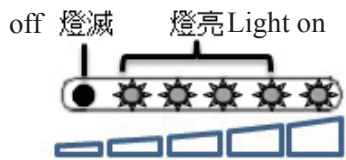
- 2 調整**旋鈕 1**，直至紅色信號燈 4 個燈亮

Turn sensitivity adjusting **dial 1** clockwise or counterclockwise until the fourth lamp of red lamps is lit.



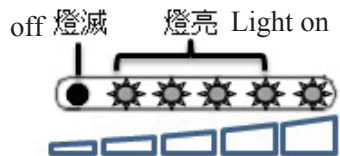
- 3 調整**旋鈕 1**，往順時鐘方向慢慢旋轉，直至紅色信號燈第 5 個燈亮

Turn **dial 1** clockwise slowly until the fifth red lamp is lit.



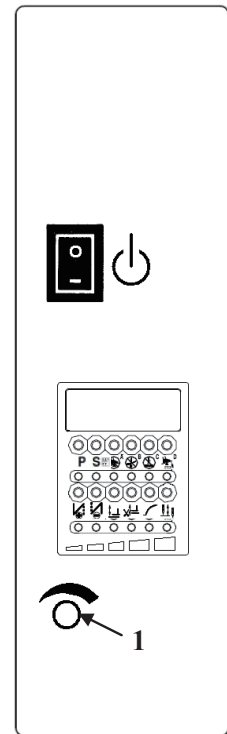
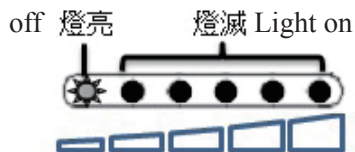
- 4 確認無布料時，紅色信號燈是否全部亮，橘色信號燈是否熄滅。

Check that orange lamp is turned off and all the red lamps are lit with no fabric under the sensor.

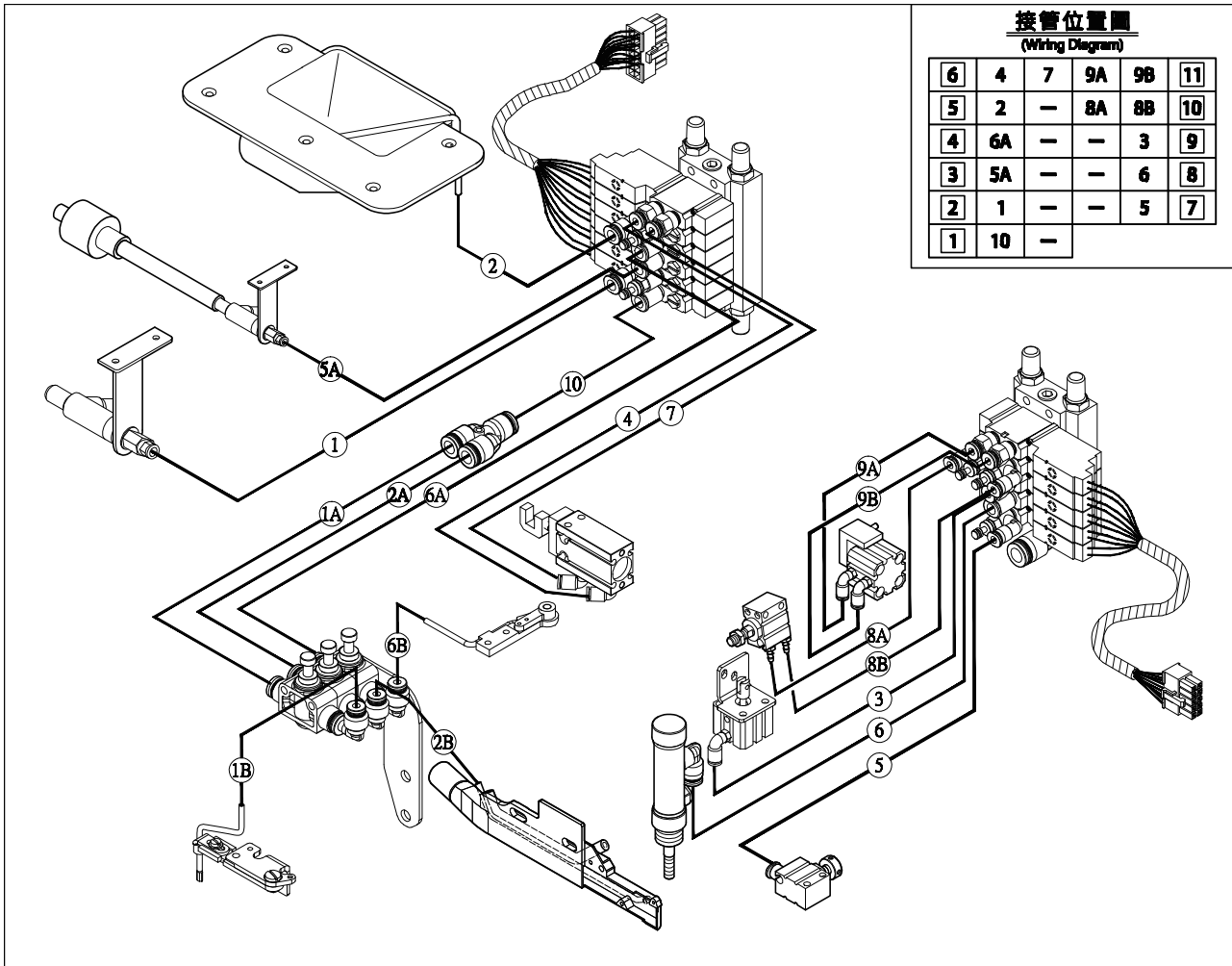


確認有布料時，紅色信號燈是否全部熄滅，橘色信號燈是否燈亮。

Check that orange lamp is lit and all the red lamps are turned off with fabric under the sensor.



X. 接管圖 / Wiring diagram



接管位置圖
(Wiring Diagram)

6	4	7	9A	9B	11
5	2	-	8A	8B	10
4	6A	-	-	3	9
3	5A	-	-	6	8
2	1	-	-	5	7
1	10	-	-	-	-

XI. 提示代碼和錯誤代碼 / Tip Code list and Error Code list

操作盒用: / For operation box:

提示代碼 Tip Code	顯示訊息 Message	說明 Comment
E098	successfully saved	出廠參數值儲存成功。 Factory preset value saved successfully.
E099	please reboot	已回復出廠參數值,請重啟電源。 Has returned to factory preset value, please restart the power.

操作盒用: / For operation box:

錯誤代碼 Error Code	顯示訊息 Message	說明 Comment
E100	No response from front panel	操作盒和控制箱無法互相通信,請檢查操作盒的連接線是否插好或插錯接口。 Operation box can not communicate to control box, please check the operation box cable is plugged in or plugged into the wrong connector.
E201	Power off	關閉電源, 在操作盒螢幕未完全消失前再開啟電源的話, 集會出現此錯誤代碼。請在操作盒螢幕完全消失後, 再重新開啟電源。 When thrunning on the main switch before operation box completely blacked out during the last main switch turning off action, E201 will be shown and operation box can't be operated. Please always turn on the main switch after operation box blackout.

控制箱用: / For control box:

錯誤代碼 Error Code	故障原因 Cause of the problem	說明 Comment
ER0.4	<p>1. 電源 ON 時，主電壓檢知過高時。</p> <p>2. 插錯電壓或供應電壓過高時。</p> <p>1. When power on, detected high voltage.</p> <p>2. Connect the wrong voltage, too high.</p>	<p>馬達與車頭出力將全部關閉成無動作狀態。</p> <p>請檢查 AC 電源電壓是否正確或是否超過使用規定的額定電壓。</p> <p>*如控制箱為 AC 220V 系統, 請勿使用 AC 380V 的電源, 否則 LED 於送電 2 秒後出現 ER0. 4 的故障碼。如果持續送入 380V 電源, 則主基板上的電解電容(C3,C4) 會在一段時間內爆裂, 並造成電源入力的保險絲 (F1、F2) 熔斷。</p> <p>請檢查主基板組控制回路機能是否異常。</p> <p>Motor and machine will be shutting down.</p> <p>Please check the AC power. (Too high)</p> <p>* If control box is AC 220V system, don't use the AC 380V power voltage, otherwise the LED will display ER0. 4 after 2 second of power ON. If continue supply the 380V power, the electrolytic capacitors (C3,C4) of main board will burst open over a period of time and cause the fuses (F1,F2) of power input open circuit.</p> <p>Please check the main pc board.</p>
ER0.7	<p>1. 馬達插頭配線接觸不良導致不轉時。</p> <p>2. 定位器(傳感器)信號異常時。</p> <p>3. 定位器(傳感器)為單一觸發信號型式，而參數設定不符合時。</p> <p>4. 車頭機構鎖死或馬達皮帶輪異物捲入卡住。</p> <p>5. 加工物過厚，馬達扭力不足無法貫穿時。</p> <p>1. Bad connection at the motor connector.</p> <p>2. Synchronizer (sensor) signal error.</p>	<p>馬達與車頭出力將全部關閉成無動作狀態。</p> <p>請檢查馬達本身或馬達插頭配線等信號是否異常。</p> <p>請檢查定位器(傳感器)信號是否異常。</p> <p>請檢查車頭是否卡住或干涉轉動困難。</p> <p>Motor and machine will be shutting down.</p> <p>Please check the motor or motor connectors' connection.</p> <p>Please check the Synchronizer (sensor) and its signal.</p> <p>Please check machine head to see if objects stuck in the motor pulley, or rotate not smoothly.</p>

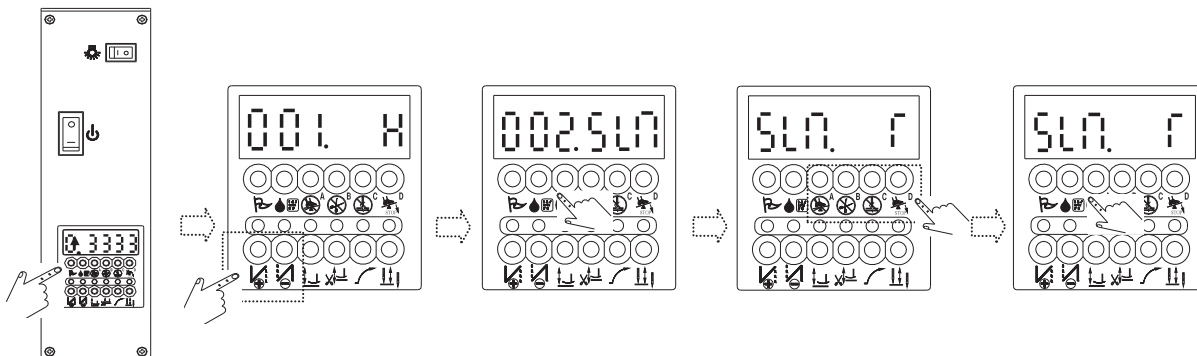
	<p>3. Synchronizer is a single position type, and parameter set wrong type.</p> <p>4. Machine locked or object stuck in the motor pulley.</p> <p>5. Sewing material is too thick.</p>	
<p>ER0.9</p>	<p>1.車頭線圈（或電磁閥）短路時。</p> <p>2.驅動車頭電磁閥之功率電晶體迴路有故障。</p> <p>1. Machine solenoid shorted.</p> <p>2. Main board's power transistor is faulty.</p>	<p>馬達可正常運轉，但車頭出力與操作盒之定針式樣縫製功能將全部關閉成無效。</p> <p>請檢查車頭電磁閥(或線圈)之迴路是否短路。</p> <p>請檢查主基板組之各功率驅動電晶體是否故障。</p> <p>Motor still can run, but all output signals and Operation box's pattern sewing function will be invalid.</p> <p>Please check machine's solenoids.</p> <p>Please check all the power transistors which related to solenoid.</p>

XII. 如何使用參數 / How to access parameter

(1). 如何使用【參數模式 A】: (可用參數碼: 1 - 46)

How to access 【Parameter Mode A】: (Available parameter codes : 1 ~ 46)

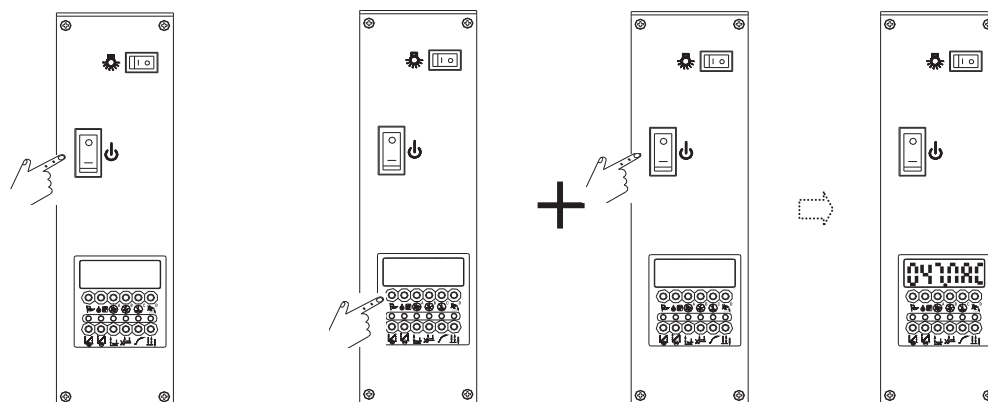
- | | | |
|---|---|--|
| <p>a. 在【標準模式】下按下按鈕 P 會帶你進入第一個參數碼【模式A】的【001.H】</p> <p>a. Under 【Normal mode】 press key P will take you into the first parameter code 【001.H】 of 【Mode A】</p> | <p>b. 按 或 得到需要的參數。例: 【002.SLM】</p> <p>c. 按 S 進入【參數值】</p> <p>b. Press or to get the parameter needed. e.g 【002.SLM】</p> <p>c. Press S to enter 【parameter value】</p> | <p>d. 在此範圍, 按 鈕調整參數值</p> <p>e. 按下 S 來儲存參數值。</p> <p>d. In this area, press key to make value adjustment.</p> <p>e. press S key to save the value.</p> |
|---|---|--|



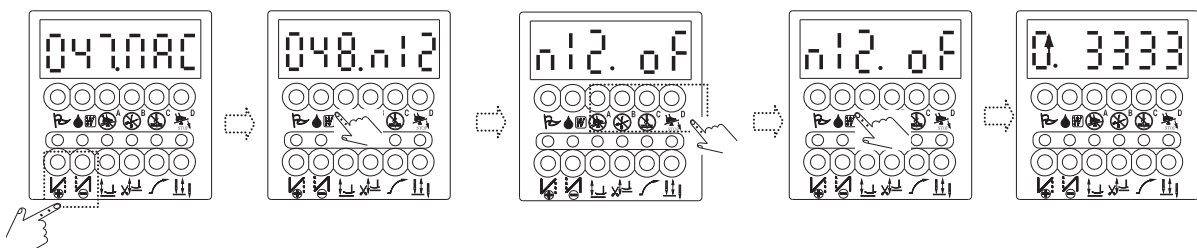
(2). 如何使用【參數模式 B】: (可用參數碼: 1~122)

How to access 【Parameter Mode B】: (Available parameter codes : 1 ~ 122)

- | | |
|---|---|
| <p>a. 關閉電源</p> <p>a. Turn off the power</p> | <p>b. 按住 P 鈕, 並打開電源使用第一參數碼【參數模式 B】的【047.MAC】</p> <p>b. Press hold P key and tum on the power to access the first parameter code 【047.MAC】 of 【parameter mode B】</p> |
|---|---|

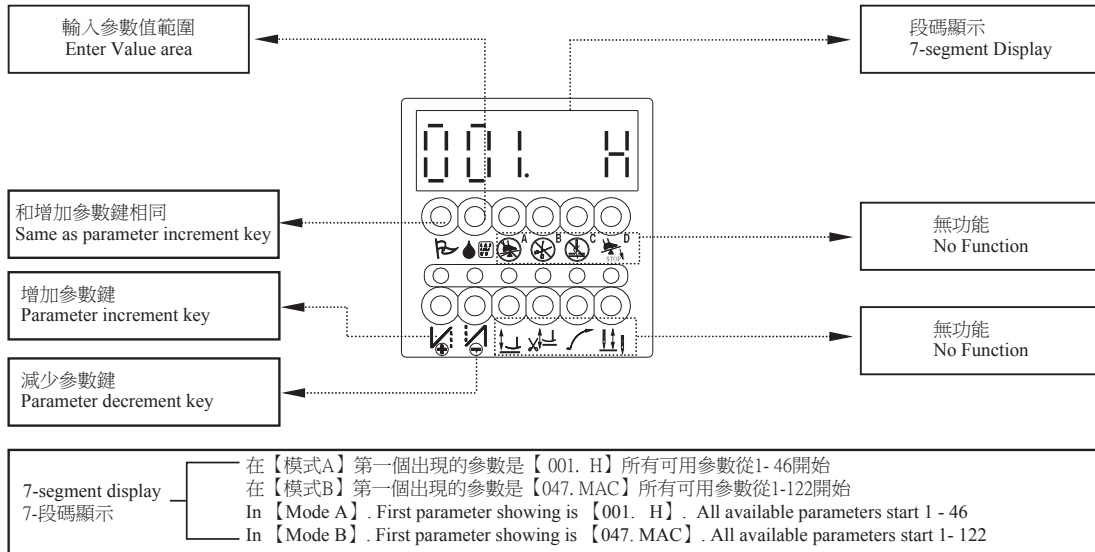


- | | | |
|---|---|--|
| <p>c. 按下 或 鈕以取得參數碼【048.N12】</p> <p>d. 用按鈕輸入【參數值】</p> <p>c. Press or key to get the parameter code 【048.N12】</p> <p>d. Use key to enter 【parameter alue】</p> | <p>e. 在此範圍, 按下這些鈕 調整參數值</p> <p>f. 按下 S 儲存參數值</p> <p>e. In this area, press those key to make value adjustment</p> <p>f. Press S key to save the value</p> | <p>註1. 壓下 S 按鈕後, 會回到【標準模式】</p> <p>註2. 例: 平縫車</p> <p>Note 1. After pressing S key, it will go back to 【Normal Mode】</p> <p>Note 2. Example: on Lockstitch machine</p> |
|---|---|--|



(3). 【參數模式 A 和 B】的主要功能(以下範例)

Key functions in the 【Parameter Mode A and B】 (example as the following)



(4). 如何使用【參數值】並調整設定

How to access the 【Parameter Value】 and adjust the setting

第1步: 確認你欲調整的參數碼 (細節參照參數表)

第2步: 照著說明來使用參數範圍並叫出參數碼

第3步: 開始調整參數值

(使用 和 鍵選擇功能。速度、計時和角度設定可根據以下設定：【參考001.H 設定值】)

Step 1 : Confirm the parameter code you want to make adjust. (see the parameter table for detail)

Step 2 : Follow the instruction to access parameter area and call out the parameter code.

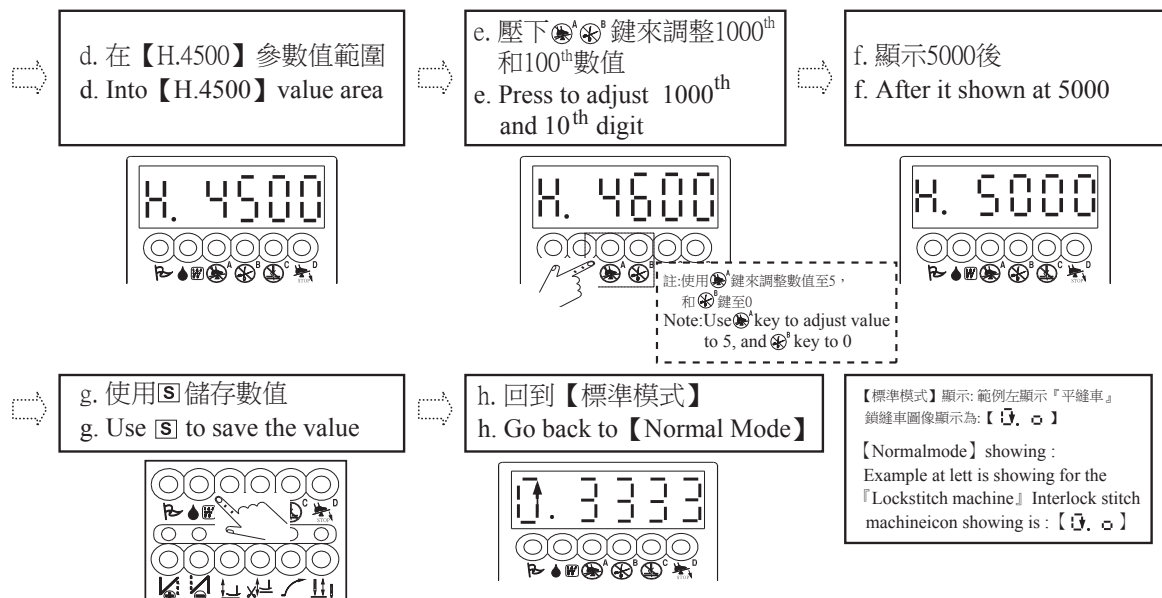
Step 3 : Start making adjust parameter value.

(Function selection use key and to make change. Speed, timing and angle setting can be set as the following : 【001.H】 value setting for your reference)

(A). 如何提高默認值 / How to increase the default value :

例: 工廠默認值設定【H. 4500】提高至【H. 5000】

Example : Factory default setting 【H. 4500】 increase to 【H. 5000】

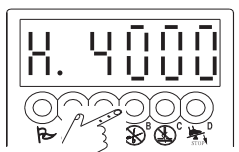


(B).如何降低默認值 / How to decrease the default value:

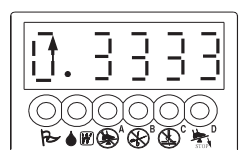
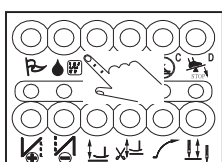
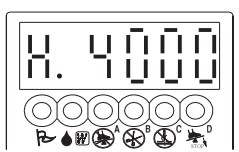
例：工廠默認值設定【H. 4500】降低至【H. 4000】

Example : Factory default setting 【H. 4500】 decrease to 【H. 4000】

- ⇒ d. 在【H.4500】參數值範圍
d. Into 【H.4500】 value area
- ⇒ e. 按  回到0
e. Press  to make return at 0







- ⇒ f. 顯示4000或任何要求數值後
f. After it shown at 4000 or any desire
- ⇒ g. 使用 **[S]** 儲存數值
g. Use **[S]** to save the value
- ⇒ h. 回到【標準模式】
h. Go back to 【Normal Mode】



(5).【參數值】中A B C D 鍵的數值設定

Value setting for A, B, C, D keys in the 【Parameter Value】

按鍵 / KEY	 A	 B	 C	 D
名稱 / TERMS	數值 / VALUE			
速度 IN TERMS OF SPEED	1000 spm	100 spm	10 spm	1 spm
角度 IN TERMS OF ANGLE	-----	100°	10°	1°
計時 IN TERMS OF TIMING	1000 ms	100 ms	10 ms	10 ms
功能 IN TERMS OF FUNCTION	-----	-----	功能轉換 FUNCTION SWAP	功能轉換 FUNCTION SWAP
<ul style="list-style-type: none"> 除了功能選擇鍵，其他鍵皆會由0至9轉換數值 Other than the function selection, each press of the key will start change the value from 0 to 9. 				

註：數值轉換後，按壓 **[S]** 按鍵以儲存數值，否則關機後數值就會遺失

Note : After value changed, press key **[S]** to save the value, otherwise they will lost after turning power off

XIII. 一般參數表 / General parameter table

模式 Mode	參數碼 Parameter Code	參數功能 Parameter Function	範圍 / 選擇 Range / Selection	描述 / 註記 Description / Note
A	001. H	最快車縫速度 (spm) Maximum sewing speed (spm)	50~9999	最快速度調整 Maximum speed adjustments
	004. N	鎖縫車啟動後套結速度或持續縫製速度(spm) Start Back-Tacking speed or Constant-Stitch speed for the interlock stitch machine(spm)	50~8000	鎖縫車啟動後套結速度或持續縫製的速度調整 Speed adjustment for start back-tacking or constant-stitch sewing in the interlock stitch machine
	005. V	最終後套結速度 (spm) End Back-Tacking speed (sprn)	50~8000	最終後套結的速度調整 Speed adjustment for End Back-Tacking
	006. B	套結速度 (spm) Bar-Tacking speed (spm)	50~8000	套結速度調整 Speed adjustment for Bar-Tacking
	007. S	慢啟動速度 (spm) Slow Start speed (spm)	50~2000	慢啟動速度調整 Speed adjustment for Slow Start
	008. SLS	慢啟動的針數 Number of Stitches for the Slow Start	0~99	慢啟動的針數設定 Number of Stitches setting for Slow Start
	009. A	自動持續針縫速度或自動啟動測試速度(spm) Automatic Constant-Stitch sewing speed or Auto-start testing speed(spm)	50~8000	自動持續針縫速度調整 註:只有設置在【037. SMP】的『A』時有效 Speed adjustment for Automatic Constant-Stitch sewing Note: Valid only when the 【037. SMP】 set on 『A』
	010. ACD	自動最終後套節車縫 (可使校正針縫功能無效化) Automatic End Back-Tacking sewing (Can invalidate the Stitch Correction function)	ON / OFF	開啟: 在持續針縫的最後接縫後, 會自動執行最終後套 結車縫功能。 註: 開啟後針縫校正便無效 關閉: 最終接縫後, 自動最終後套結不會執行, 但可人 工踩踏執行。 註: 在隨意車縫情況下有針縫校正功能, 但參數必 須設置在【011.RVM】的『B』 ON: After last seam of Constant-Stitch sewing, it will automatic execute the End Back-Tacking sewing function. Note: When turned on, the stitch-correction is invalid OFF: Automatic End Back-Tacking will not execute after last seam, but can be done by pedal manually Note: The Stitch-Correction is valid in Free sewing, but the parameter 【011.RVM】 must set on 『B』
	011. RVM	後套結模式選擇 Back-Tacking Mode selection	J / B	J: JUKI 模式 (不管機器關閉或運轉中, 按TB開關可啟動反電磁) B: BROTHER 模式 (只有再機器運轉時, 按TB開關可啟動反電磁) J: JUKI mode (Press TB switch will activate the reverse solenoid when either machine is stopped or running) B: BROTHER mode (Press TB switch will activate the reverse solenoid only when machine is running)
	040. WON	接帶功能選擇 Wiper function selection	ON / OFF	開啟: 接帶有效 關閉: 接帶無效 ON: Wiper valid. OFF: Wiper invalid.
041. TM	切刀功能選擇 Trimmer function seiection	ON / OFF	開啟: 切刀有效 關閉: 切刀無效 ON: Trimmer valid. OFF: Trimmer invalid.	
045. SP	車縫速度 Sewing speed	0~8000	顯示當下車縫速度 Showing the current sewing speed.	
046. DIR	馬達旋轉方向 Direction of motor rotation	CW / CCW	CW: 順時鐘 CCW: 逆時鐘 CW: Clockwise. CCW: Counterclockwise.	

模式 Mode	參數碼 Parameter Code	參數功能 Parameter Function	範圍 / 選擇 Range / Selection	描述 / 註記 Description / Note
B	060.L	低速 (spm) Low speed (spm)	50~500	低速的速度調整 Speed adjustment for Low speed
	061.T	切刀速度 (spm) Trimmer speed (spm)	50~500	切刀的速度調整 Speed adjustment for Trimmer
	064.FO	自動抬壓腳全時間設置 (ms) Full-On time setting for Automatic Foot Lifter (ms)	0~990	全時間自動抬壓腳活動時間調整 Timing adjustment for Full-On time of Automatic Foot Lifter actives
	065.FC	自動抬壓腳的負載循環 (%) Duty-Cycle setting for Automatic Foot Lifter (%)	10~90	調整負載循環的AFL (協調好可減少過熱) Adjustment for Duty-Cycle of AFL (Fine tuning can reduce the over heating)
	066.FD	運轉延遲時間設置 (ms) Running-Delay time setting (ms)	0~990	自動抬壓腳運轉延遲的時間調整 Running-Delay time adjustment for the Automatic Foot Lifter
	070.HHC	半腳踏版時，取消自動抬壓腳 Cancel Automatic Foot Lifting when Half-Heeling the pedal	ON / OFF	開啟: 半腳踏版沒有抬壓腳功能 (只有全踏踏板可啟動抬壓腳) 關閉: 半腳踏版有抬壓腳功能 ON : Pedal half heeling without foot lifting function (only full heeling can activate Foot Lifer) OFF : Pedal half heeling with foot lifting function
	075.SFM	安全開關模式 Safely switch mode	NC / NO	NO : 正常開啟 NC : 正常關閉 NO : Means Normal Opened NC : Means Normal Closed
	083.T2	修剪時間 (ms) Trimming timing (ms)	0~990	修剪時間調整 Adjustment for trimming timing
	087.L2	張力釋放時間 (ms) Tension release timing (ms)	0~1500	張力釋放時間調整 Adjustment for tension release timing
	093.W2	接帶時間 (ms) Wiper timing (ms)	0~9990	接帶時間調整 Adjustment for wiper timing
	119.DD	馬達驅動模式 Motor drive mode	ON / OFF	開啟: 馬達直接驅動機頭 關閉: 馬達用皮帶驅動機頭 ON : Motor drive machine head directly OFF : Motor drive machine head with belt
	121.ANU	電源開啟針自動向上 Needle goes up automatically as power turned on	ON / OFF	開啟: 電源開啟，針自動往上移動 關閉: 無用 ON : Power turned on , needle goes up position automatically OFF : No Use
122.HL	最快速度上限 Upper limit of maximum speed	50~9999	馬達最快速度設置 The motor's maximum speed setting	

報廢流程

DEMOLITION PROCEDURE

1. 當機器需要被淘汰與報廢時，有一些基本規則必須採納、遵守以保護環境及公眾健康。
2. 所有的機器零組件必須依照下列分類來區分開：
 - (1) 所有護套、可伸縮軟管及塑膠或非金屬零件。
 - (2) 電器零件：開關、照明器具等。
 - (3) 絕緣材料：石棉、彈性／可伸縮橡膠片。
 - (4) 金屬：含鐵金屬、銅、青銅與黃銅、其他各種金屬。
3. 以此方法，所有材質可以正確的淘汰，回收再利用或鎔解為可再使用或再處理而不至於危害環境。

1. When the machine needs to be eliminated and demolished, certain basic rules must be observed to protect the environment and public health.
2. All machine components must be divided according to categories as the followings:
 - (1) All sheathes, flexible hosing and plastic or non-metal components.
 - (2) Electricity components: switches, or lighting components.
 - (3) Insulation materials: rock wool, and flexible rubber strips.
 - (4) Metals: ferrous metals, copper, bronze and brass, various.
3. In this way, all materials can be eliminated correctly, recycled, or melted down for reuse or disposed of so that they do not harm the environment.

SIRUBA

TABLE
CUT - OUT

Series

700K

Item Code

700K-T4

Subclass / Remark

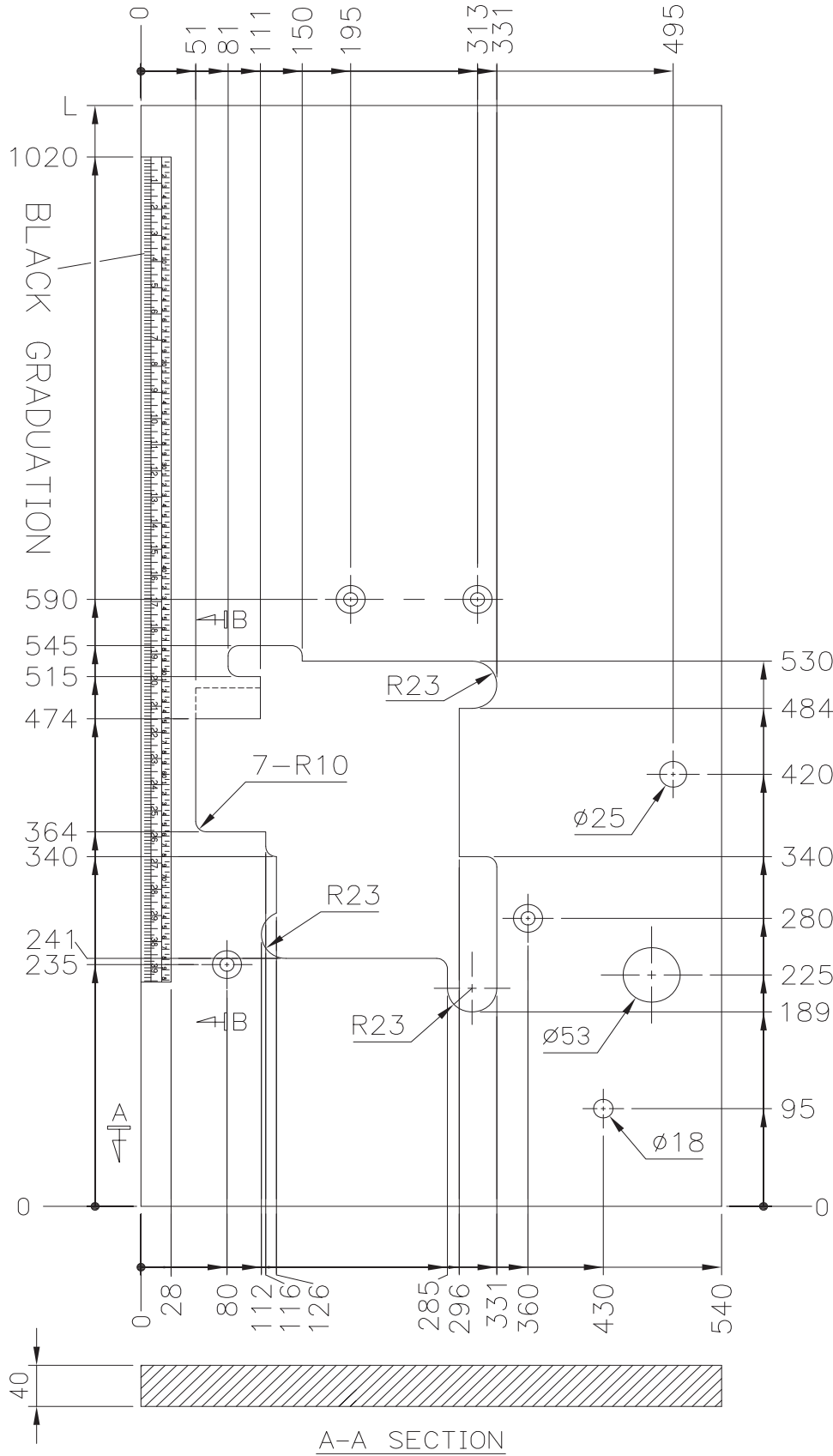
FOR BKF

Mounting

Non-submerged

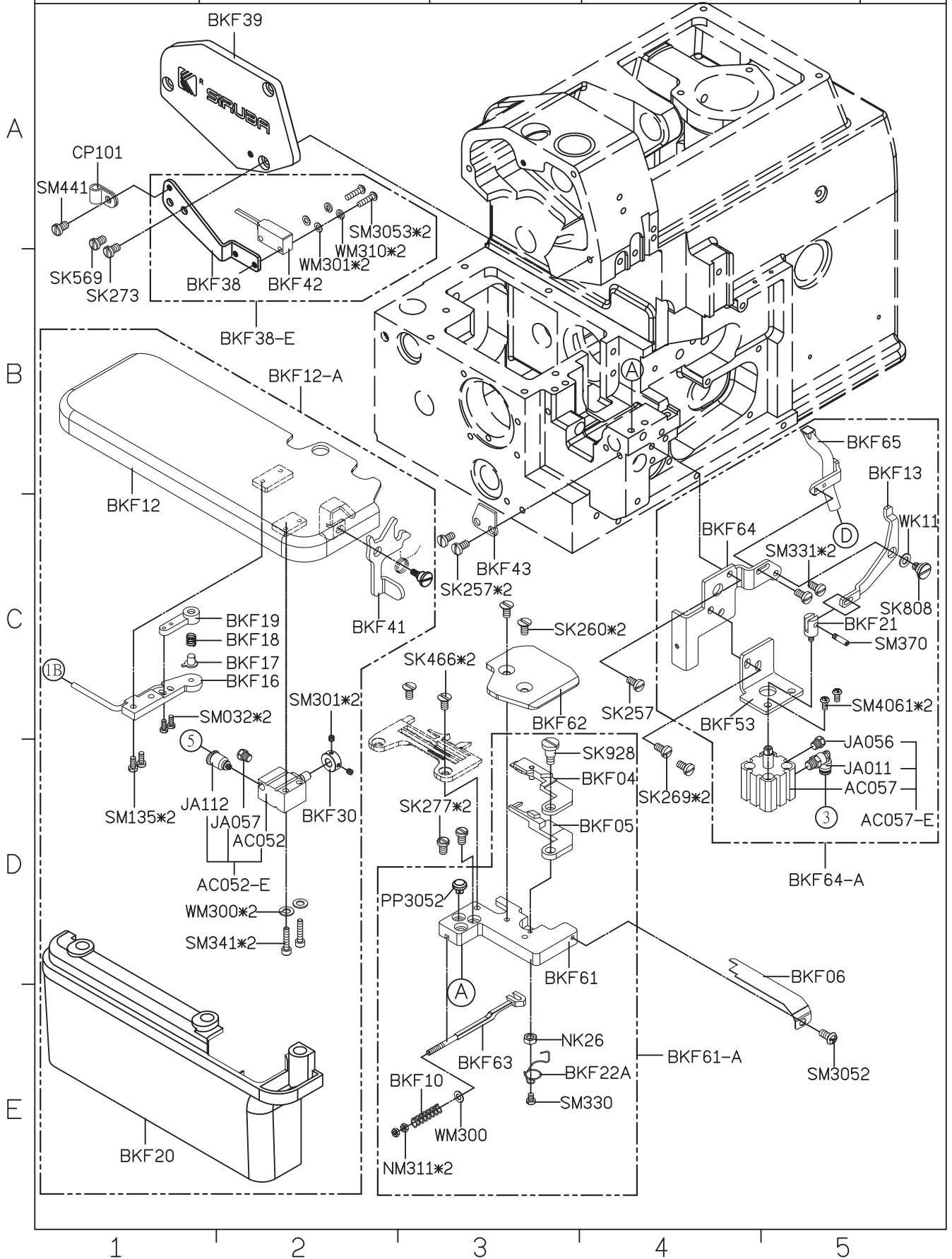
Date

2015/10/19

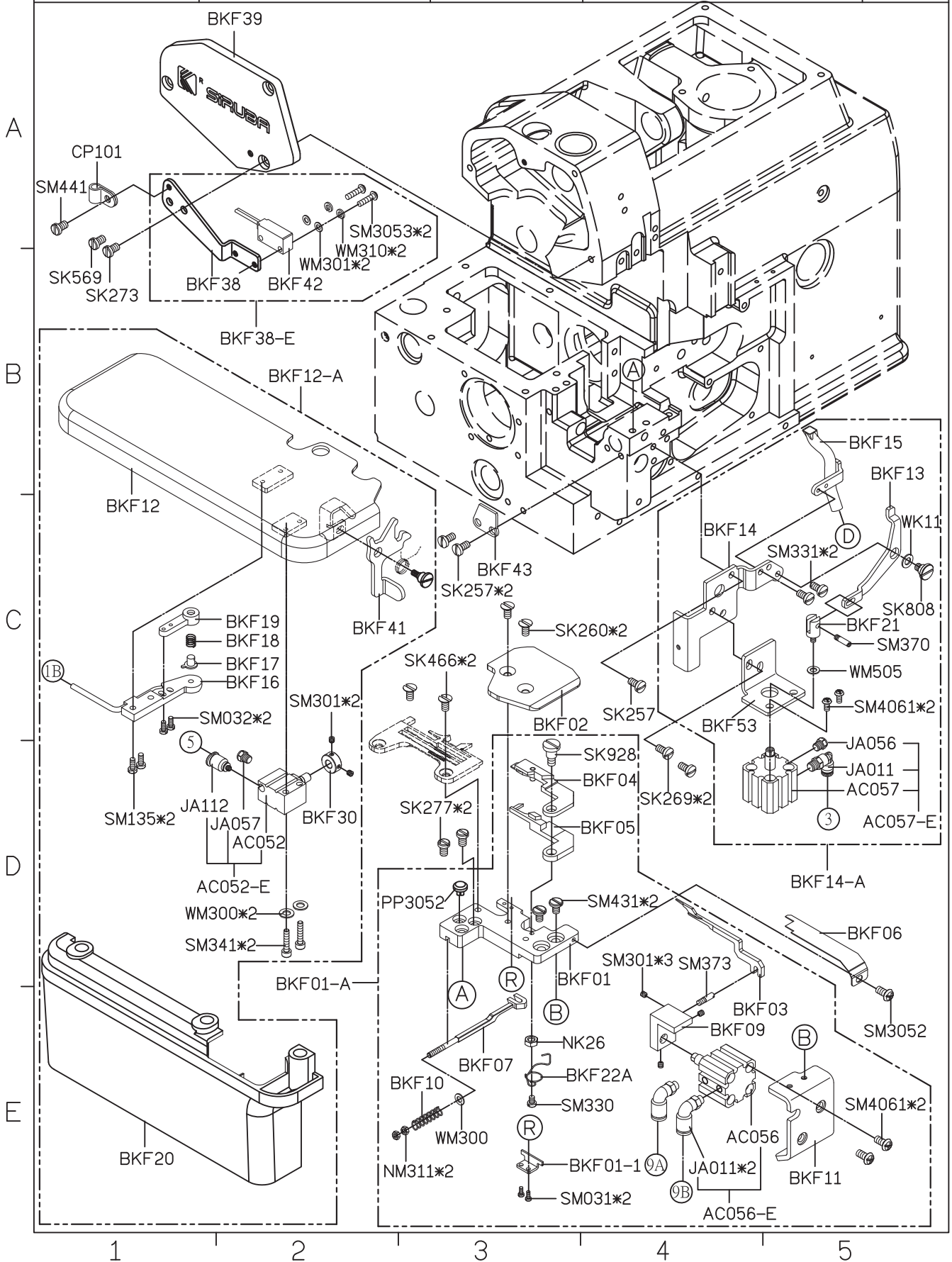


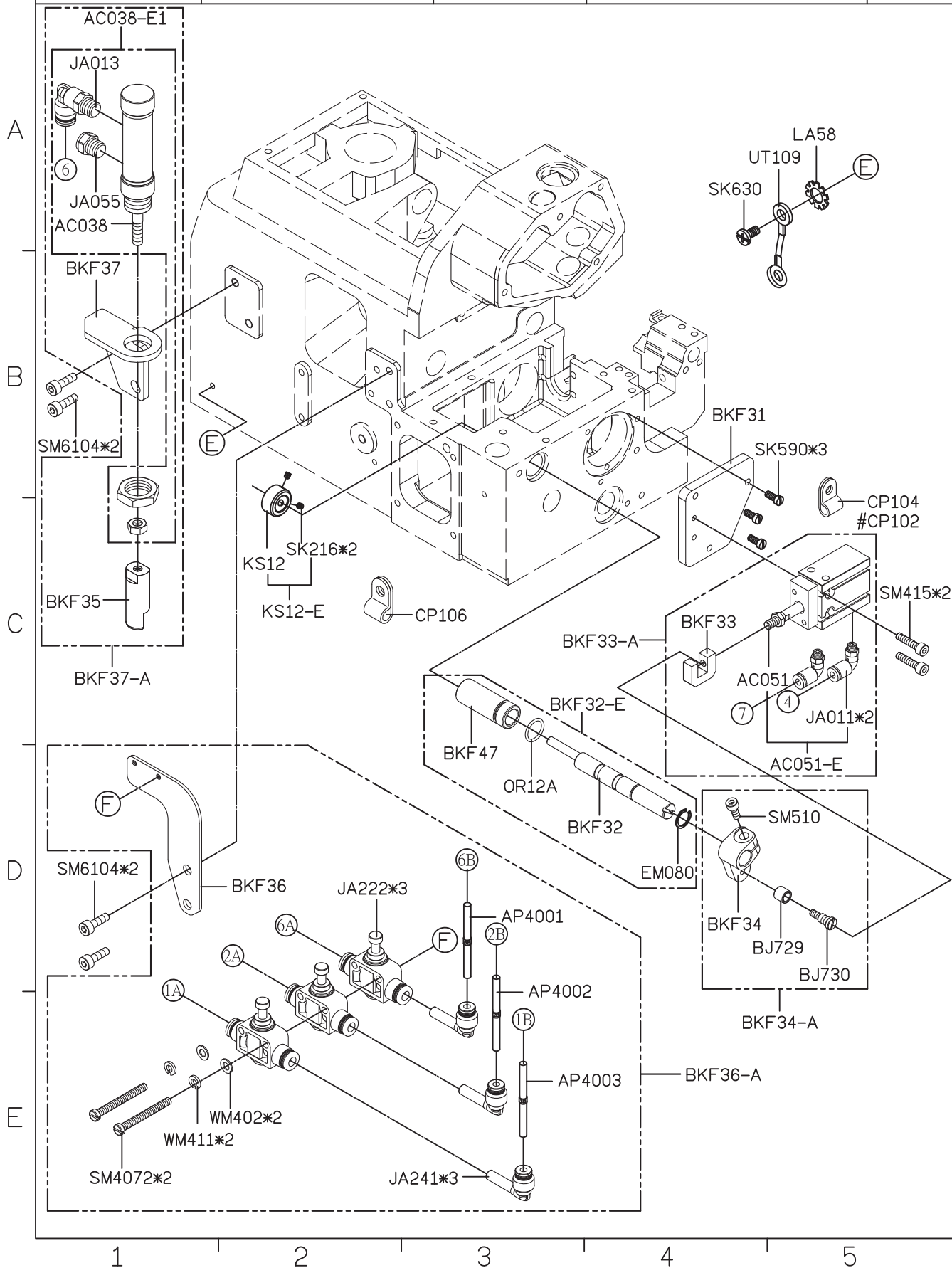
單位/UNIT:mm
所有尺寸公差/TOLERANCE:±2
長度(L):1070/重量(W):10.5kg±5%
長度(L):1200/重量(W):11.5kg±5%

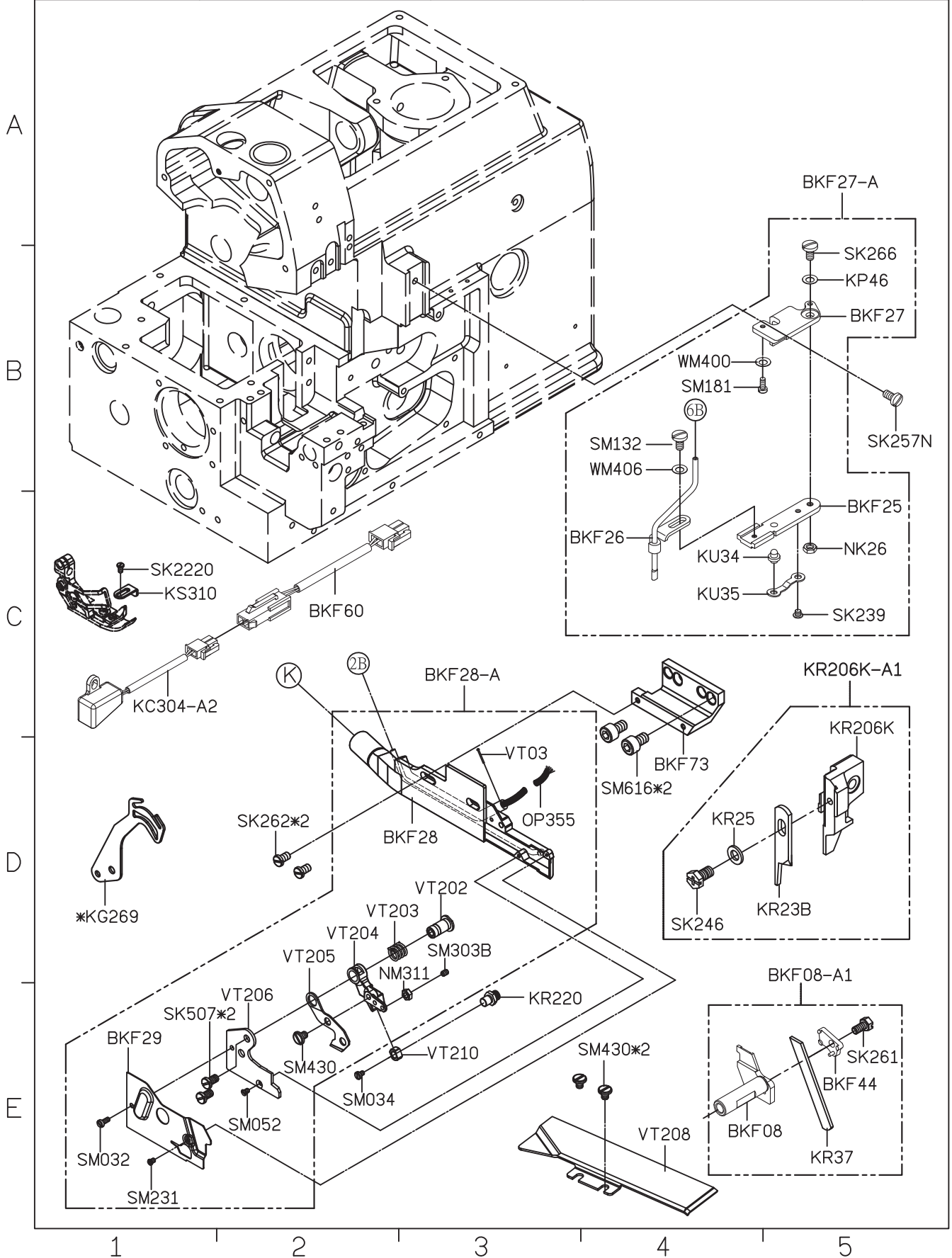
SIRUBA GAGE PARTS LIST		Series		Remark										Page	Date
		700K/700KT		FOR BKF										1 / 1	2015/04/16
機型 Model	針板 Needle Plate	送具 Feed Dog	送具 Feed Dog	送具 Feed Dog	押具 Presser Foot	上送具 TopFeed Dog	衝程 Crank	大心 Crank Shaft	針釐 Needle Clamp	夾子 Coller	勾針連桿座 Upper Looper Holder	上勾針 Upper Looper	下勾針 Lower Looper	針 Needle	
737K	504M5-03/BKF	E263	D210	D217	H204	P202-5A	-	KJ206-E	KD201K	KG231K-E	KJ204	KJ236	LP225	KL202	DCX27#11
	504M5-04/BKF	E264	D210	D217	H204	P202-5A	-	KJ206-E	KD201K	KG231K-E	KJ204	KJ236	LP225	KL202	DCX27#11
	504M5-05/BKF	E265	D210	D217	H204	P202-5A	-	KJ206-E	KD201K	KG231K-E	KJ204	KJ236	LP225	KL202	DCX27#11
747K	514M5-23/BKF	E248K	D203	D217	H240	P202-3A	-	KJ203-E	KD201K	KG242K-E	KJ234K	KJ208	LP226	KL202	DCX27#11
	514M5-24/BKF	E247K	D203	D217	H240	P202-4A	-	KJ203-E	KD201K	KG242K-E	KJ234K	KJ208	LP226	KL202	DCX27#11
747KT	514H-3-23/BKF	E248K	D203	D217	H240	P606-A	D554	KJ203-E	KD201KA	KG242K-E	KJ234K	KJ208	LP227	KL202	DCX27#11
	514H-3-24/BKF	E247K	D203	D217	H240	P607-A	D554	KJ203-E	KD201KA	KG242K-E	KJ234K	KJ208	LP227	KL202	DCX27#11



SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700K	BKF	For 747K	2/11
				Date
				2016/4/12







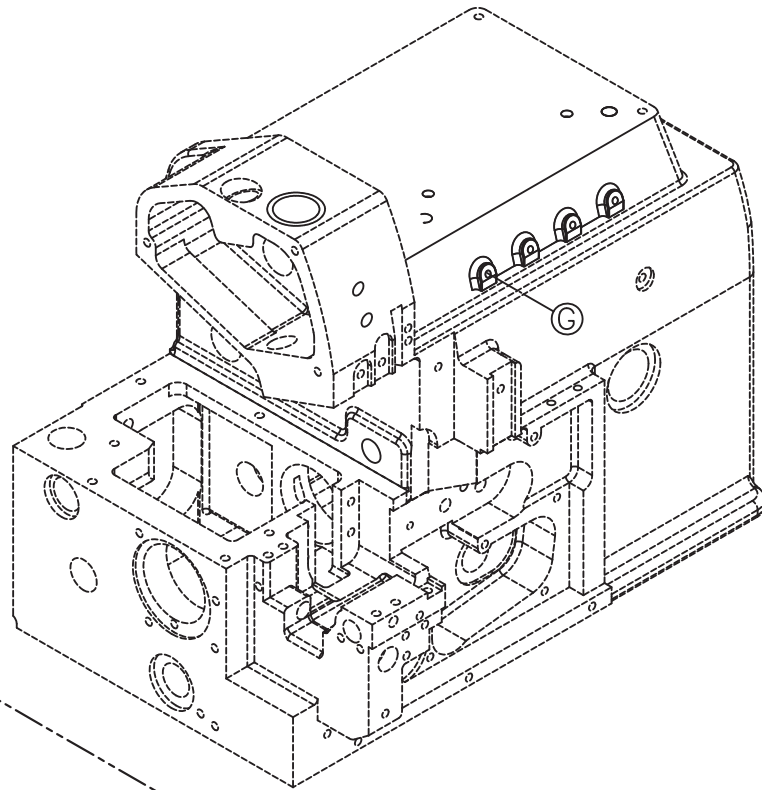
A

B

C

D

E



BKF23-A3

BKF45

AC055

JA209*2

AC055-E

8A

8B

SK262*2

KC98

BKF46

WM300*2

SM3056*2

SK405*2

G

BKF23

BKF24

KG02E

KG265

KG04K-G

KG04K-Y

KG09F*6

KG03K*6

KG264*6

KG07K*12

KG08*6

KG06K*6

KG02E

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KG68

KG04K-R

KG68*2

KG04K-G1

KG04K-Y1

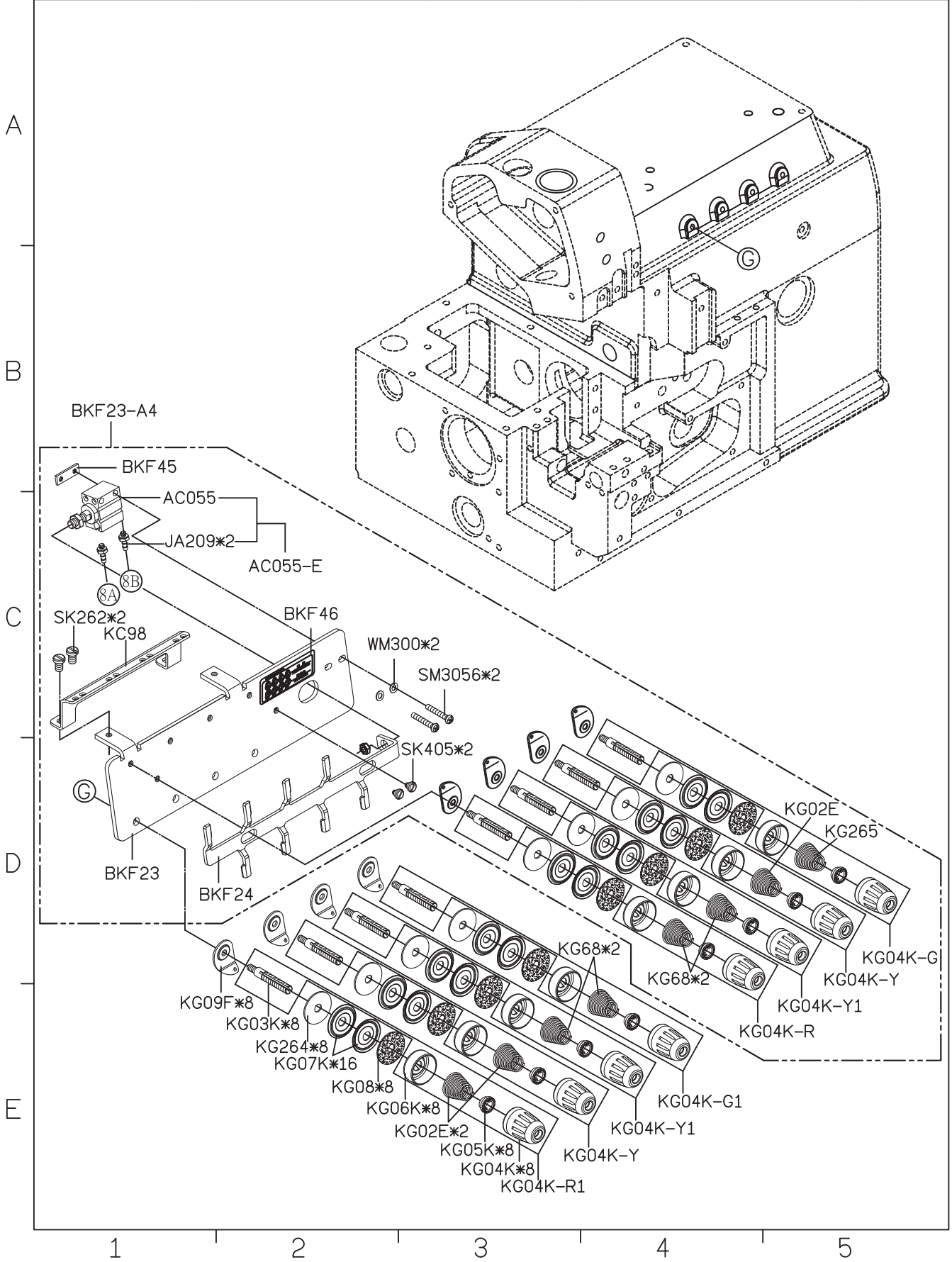
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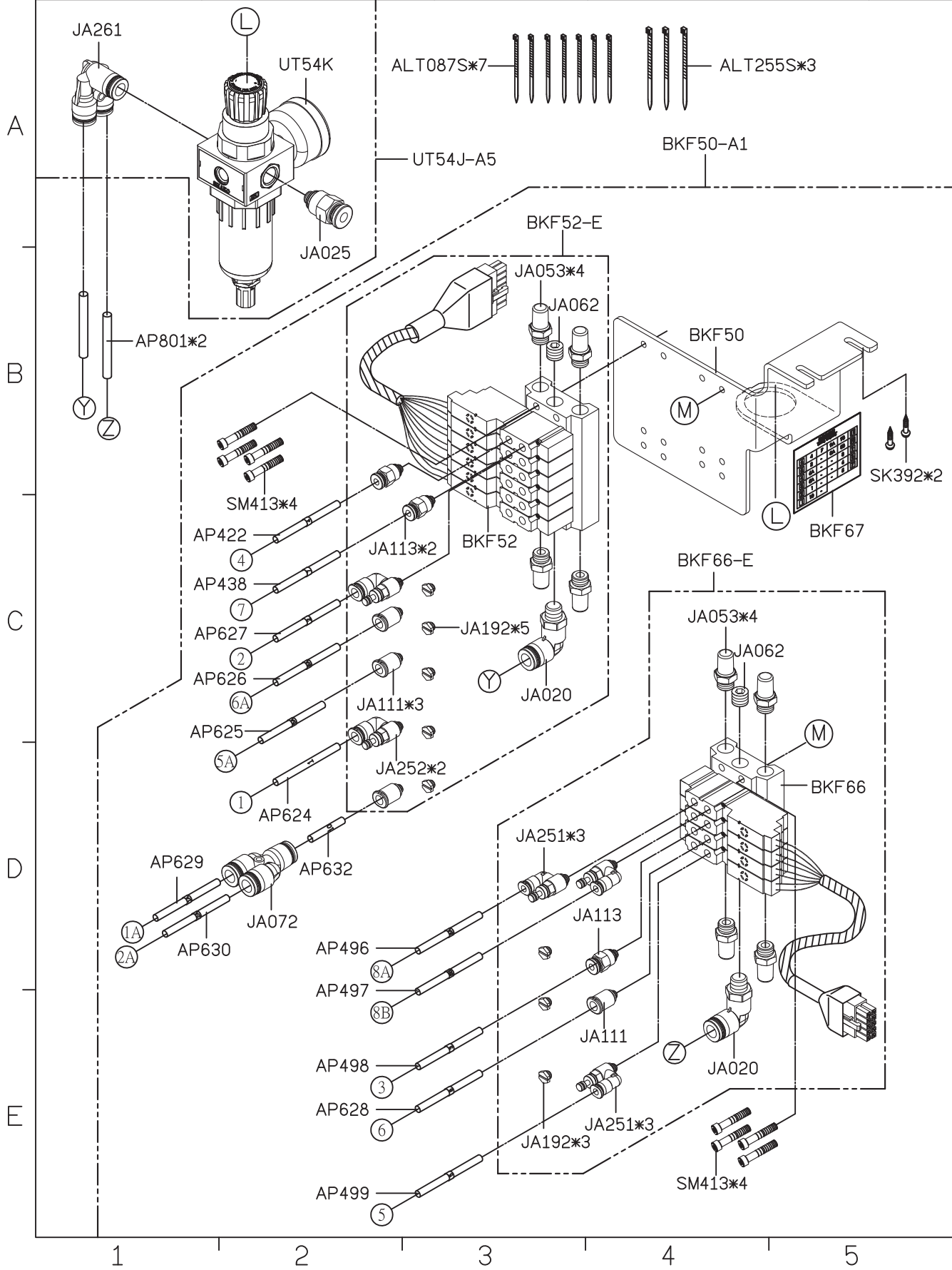
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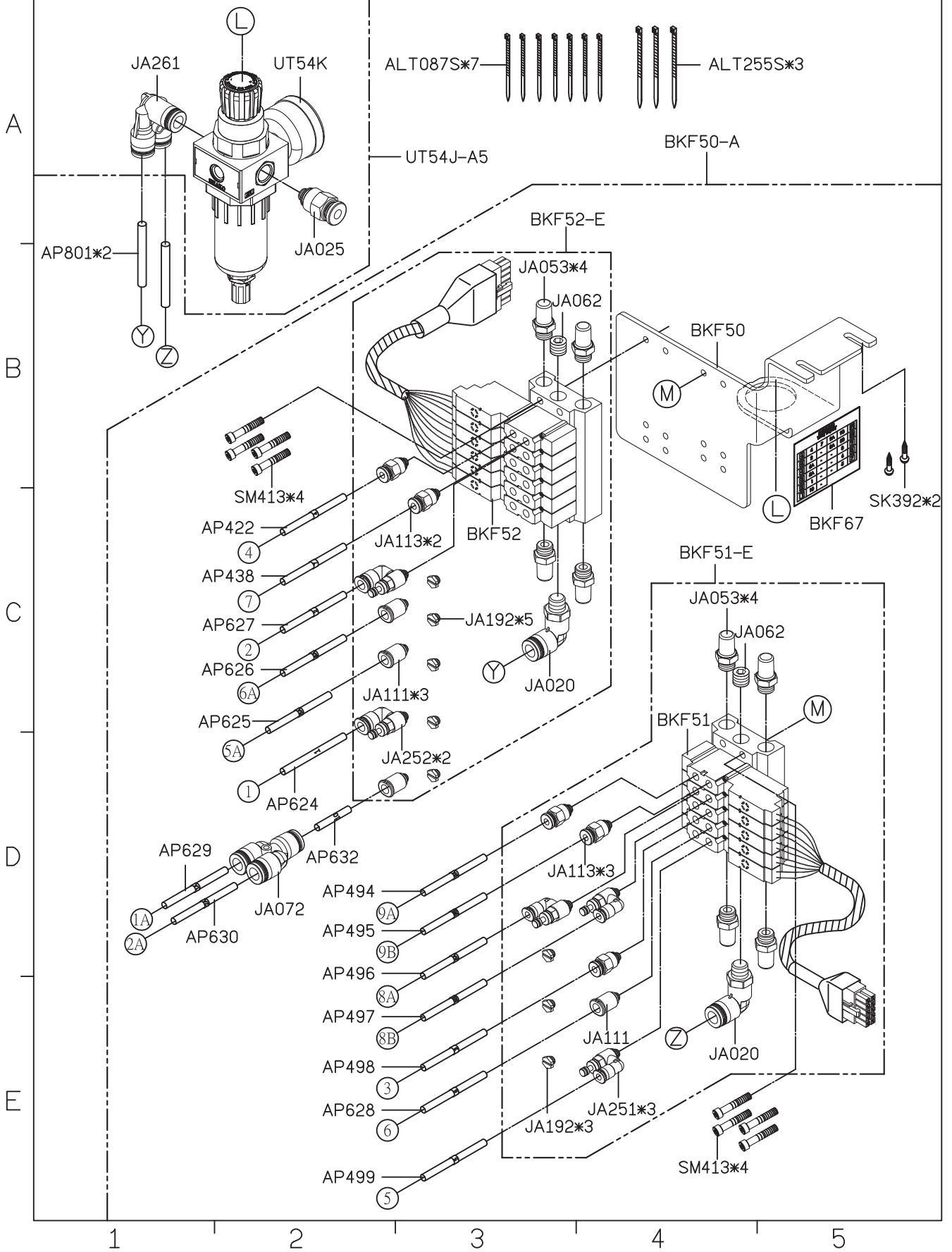
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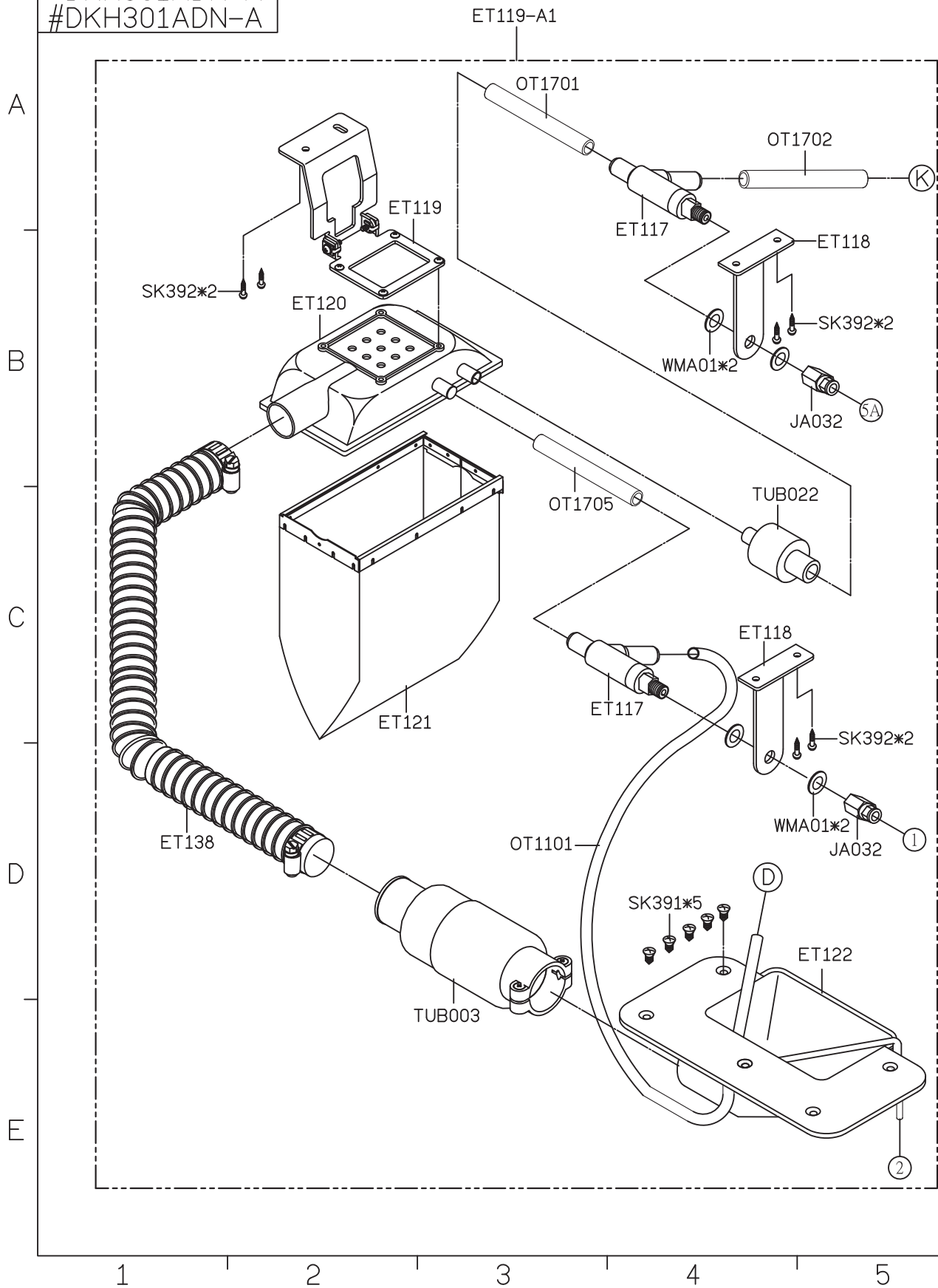
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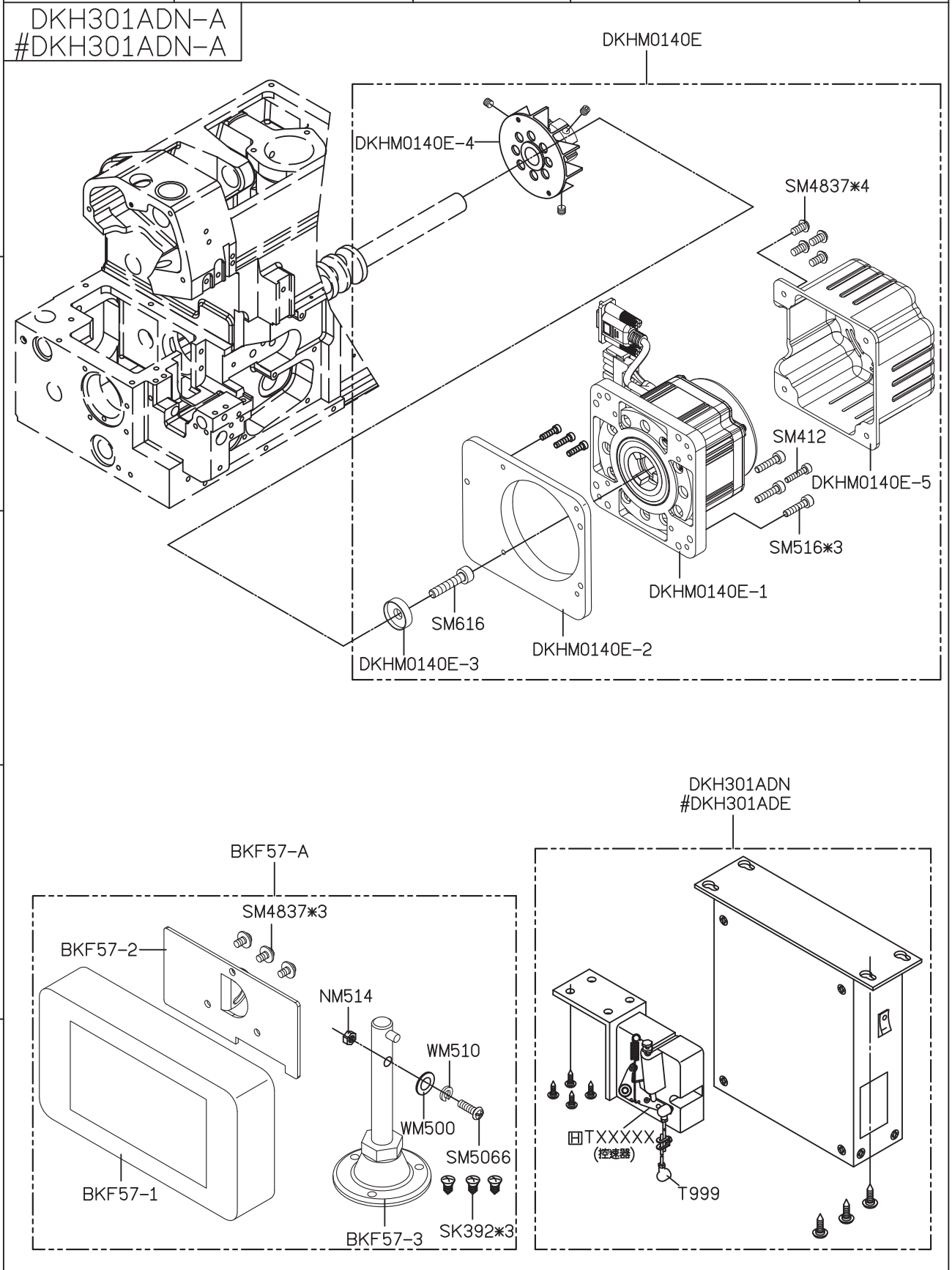


SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700K	BKF		9/11
				Date
				2015/9/9

DKH301ADN-A
 #DKH301ADN-A



SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700K	BKF	#For CE	10/11
				Date
				2016/4/12



SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700K	BKF		11/11
				Date
				2015/9/9

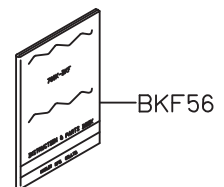
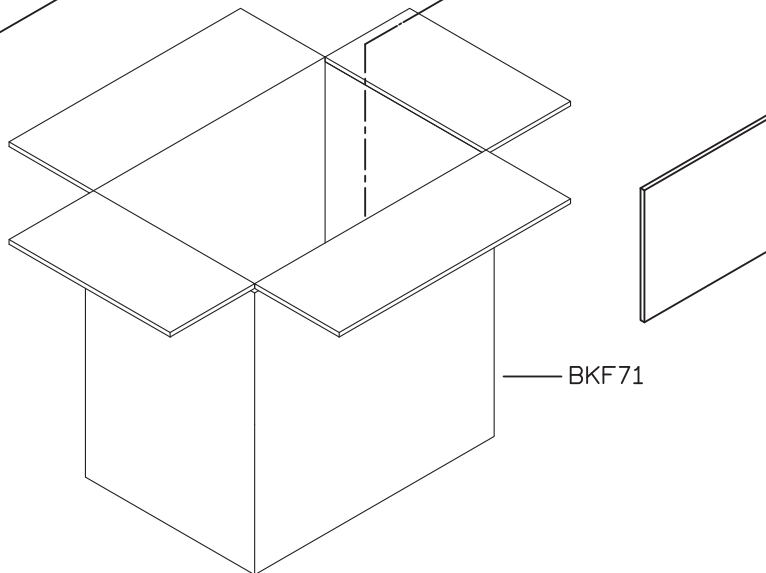
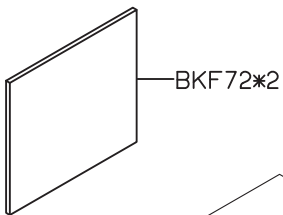
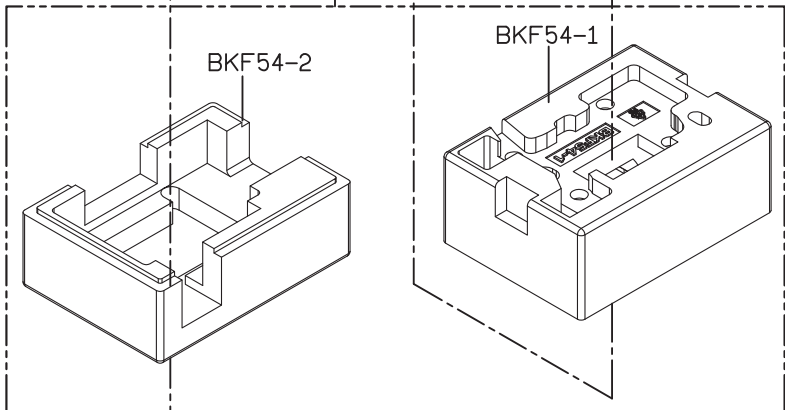
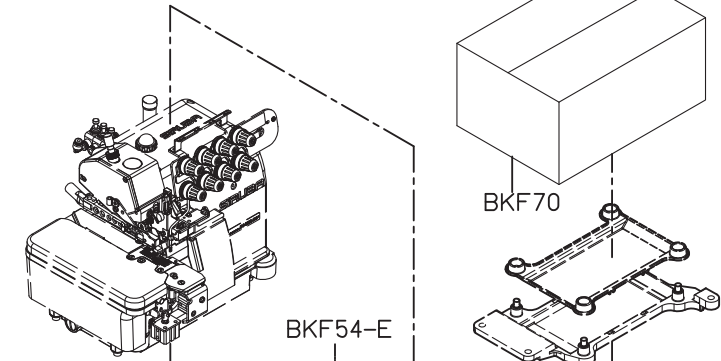
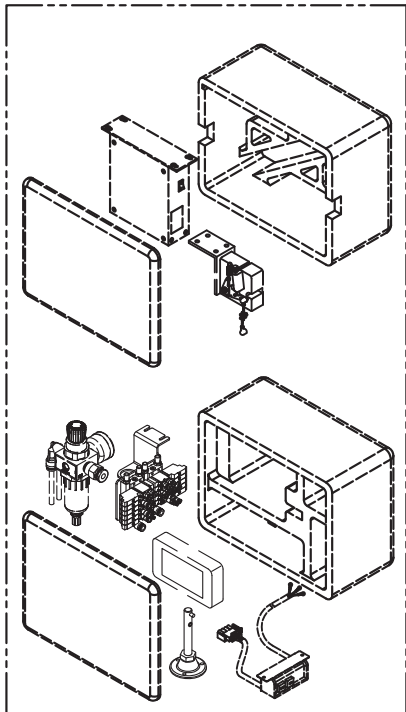
A

B

C

D

E



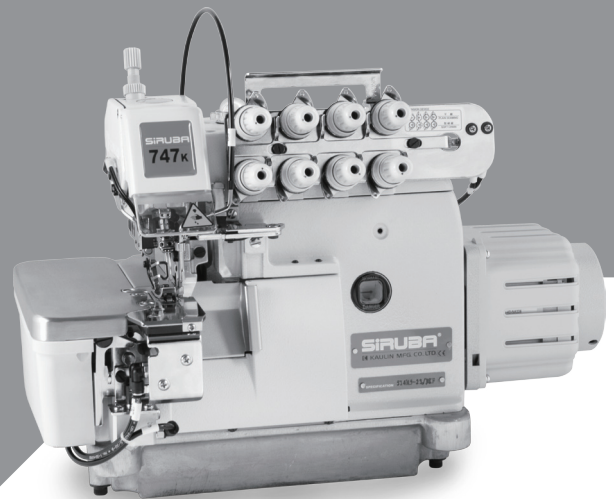
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高林股份有限公司
KAULIN MFG. CO., LTD.

由於對產品的改良及更新，本產品使用說明書中與零件圖之產品及外觀的修改恕不事先通知！
The specification and/or appearances of the equipment described in this instruction book & parts list are subject to change because of modification which will without previous notice.
BK56.JUN.2019