

SIRUBA

使用說明書與零件圖

INSTRUCTIONS BOOK & PARTS LIST

■ CM006S



溫馨提醒 A WARM REMINDER

請儘快下載 SIRUBA APP，並將您的機器註冊，以便獲得原廠的保固。APP 還提供多項有用的資訊。

please register your Siruba machine online or through Siruba App at once, as to gain the full warranty protection. You may also acquire more useful information through Siruba APP.



安全警示 GENERAL SAFETY INSTRUCTION

有關於縫紉機、自動化機構，以及其他輔助設備（以下統稱為機器），在工作中無可避免會接近機器移動區域，也就有伴隨著潛在風險。因此，我們強烈要求操作者，維修技師一定要先仔細閱讀並瞭解本操作手冊的內容。安全指示係包含了某些未載於規格書上的加裝配件。現場管理者有責任要求所有操作者要閱讀並瞭解機器的操作與注意事項。未能確實遵守本手冊所記載的事項，將可能導致機器的損害，或是人員的傷亡。

警告標示說明

For the sewing machine, automatic mechanic system, and auxiliary devices (hereinafter referred as "machine"), it is inevitable to conduct work near moving parts of the machine. This means that there is always a potential risk from the moving parts. Operators actually operating the machine and service technicians performing maintenance and repair are strongly advised to read and understand fully the following instructions in advance. The safety instructions include items which are not listed in the specifications of your product. It is the manager/supervisor's responsibility to have their fellow workers fully understand before operation. Fail to follow the instructions may cause damage to properties, severe injury or even death.

Explanation of warning indications and labels.

	<p>高壓電危險 在機器關機後十分鐘內，勿開啟電控箱。</p> <p>HIGH VOLTAGE DANGER Do not open the power cabinet within 10 minutes after the power off.</p>		<p>零部件移動區 勿接近，以避免人員受傷。</p> <p>Machine moving area! Stay away and keep clear to avoid injury.</p>
	<p>零部件高速移動區 勿接近，以避免人員受傷。</p> <p>High speed moving area! Stay away and keep clear to avoid injury.</p>		

標告標示說明 WARNING LABELS		標告標示說明 WARNING LABELS	
	<p>機器零部件移動區，勿接近，以避免人員損傷。 A risk of cut and injury from moving parts. Stay away and keep clear.</p>		<p>請注意，在操作過程中握住縫紉機會傷到您的手。 Be aware that holding the sewing machine during operation can hurt your hands.</p>
	<p>有電，危險。 A risk of electric shock. Stay away and keep clear.</p>		<p>小心被機械捲件受傷！ There is a risk of entanglement in the belt resulting in injury.</p>
	<p>高溫度區！危險，勿靠近。 A risk of burn from the high temperature area. Stay away and keep clear.</p>		<p>如果觸摸按鈕托架，可能會造成人身傷害。 There is a risk of injury if you touch the button carrier.</p>
	<p>強光！勿直視，以避免眼睛受傷。 Avoid direct eye contact with the laser beam or other light source.</p>	<p>一般安全標示 GENERAL SAFETY INDICATIONS</p>	
	<p>小心頭部撞擊！ A risk of injury to head from upper contact. Apply proper protection (helmet) and keep clear.</p>		<p>機器運行方向 The correct direction is indicated.</p>
			<p>電氣接地位置標示 Grounding connection as indicated.</p>

安全須知

SAFETY PRECAUTIONS

危險

意外事件將會導致人員受傷甚至死亡，也會造成財產的損害。當有必要進行電控系統的檢修時，務必要關閉電源，並等候至少5分鐘以上才能打開電控箱 / 操作箱，以避免電擊。

注意

1. 基本預防

- (1) 在操作前務必先閱讀操作手冊與其他機器電件的說明書，請妥善保存操作手冊與說明書以便隨時查閱。
- (2) 這些注意措施包含了機器上加裝，但未列在規格書上的項目。
- (3) 務必要戴護目鏡與手套，以避免破損零件所帶來的傷害。
- (4) 有裝戴心臟調節器的人員，請先詢問醫護人員有關注意事項。

2. 安全裝置與警告標示

- (1) 操作前要檢查，並確認所有的安全設施有妥善安裝且運作正常。
- (2) 若安全設施因維修需要而移動，在機器重新啟動操作前，請確認安全設施有重新安裝回原位，並且運作正常。
- (3) 機器上的安全警告標示要保持完整與可辨視。如果有污損或遺失，請儘以更新。
- (4) 未能確實遵守安全規範，將會導致人員受傷，甚至影響生命安全。

3. 應用與修改

- (1) 嚴格禁止機器使用在非原始設計用途。也禁止以任何不是操作手冊上記載的方式來操作機器。
- (2) 嚴格禁止修改機器。任何未經原廠許可的變動將不在保固範圍內。
- (3) 機台一經修改變動，本公司將不擔負財務損失，人員傷亡的責任。

4. 教育與訓練

- (1) 工廠主管人員有義務提供機台使用人（操作者 / 維修者）相關的教育訓練。良好的教育訓練不僅可以避免造成人員傷害，也可以避免財產的損失。
- (2) 操作人員操作機器之前，都必需接受過良好的訓練。
- (3) 機器的維修保養必須由合格的技師執行。

5. 必須關閉電源的情況：

如何關閉電源：按壓下緊急停止開關（如果機器有配置的話），關閉電源，拔除電源線。

- (1) 當機器出現異常時，按下緊急停止開關（如果有配置），關閉電源。
- (2) 為了避免機器突然起動造成意外，在操作機器前，要先確定機器電源關閉，再行開啟電源。
- (3) 當檢查或清潔機器時，關閉電源，並確定機器已完全停止運作。
- (4) 當維修機器時（如更換或調整零件），要關閉電源，並確定機器已完全停止運作。

6. 拔除電源線時，務必要抓住電源插頭，而非抓住電源線，以避免斷裂，電擊，甚至火災。

7. 當機器停止運作，且無人看管時，要關閉電源。

8. 萬一停電或電力供應出現不穩，關閉電源，以避免意外發生。

Danger

An accident means " to cause personal injury or death, or damage to property. "

When it is necessary to perform service on electrical parts, be sure to turn the power off and wait for 5 minutes or more before opening the power cabinet/box in order to avoid electrical shock.

Caution

1. Basic precaution

- (1) Read the manual and other papers supplied with accessories of the machine before operation. Keep the manual and papers at hand for quick reference.
- (2) The content of this section includes items which are not listed in the specification of your product.
- (3) Always wear safety goggles and gloves to avoid accident caused by parts breakage.
- (4) For those who use a heart pacer, please consult the medical specialist first.

2. Safety devices and warning labels

- (1) Check to ensure all safety devices are correctly installed in place and properly before operation.
- (2) If any of the safety devices is removed for service cause, please be sure to replace it back to position and verify that it works normally before resuming operation.
- (3) Always keep the warning labels adhered on the machine clearly visible. If any of the labels missing or contaminated, replace with a new one at soon.
- (4) Fail to obey instructions above may cause severe injury or death to the operators.

3. Application and modification

- (1) It is prohibited to use the machine for any application other than its original intention, or in any manner other than that prescribed in the instruction manual.
- (2) Never modify or alter the machine. Any unauthorized change of the specification will not be covered by the warranty.
- (3) Our company assumes no responsibility/liability to damages, injuries, or death resulting from the machine which has been modified or altered.

4. Education and training

- (1) The plant managers/supervisors are obliged to provide education and training to operators and service technicians. A good education/training plan not only avoids personal injury but also prevent damage to the property.
- (2) Only a well-trained operator is allowed to operate the machine.
- (3) Only a certified technician is allowed to perform service to the machine.

5. Situations that you must turn off the power

Turning off the power: press EMG Stop (if there is one), switch off the power, and remove the power plug from the outlet.

- (1) When there is a failure or abnormality, press EMG Stop (if there is one), switch off the power.
- (2) To prevent accident resulting from abrupt start of the machine, before operating the machine, always turn off the power and switch on again.
- (3) When cleaning or inspecting the machine, make sure the machine stops completely after turning off the power.
- (4) When performing service (i.e. changing of adjusting any component), make sure the power is off and the machine stops completely.

6. Remove the power plug by holding the plug section instead of the cord to avoid electrical shock, leakage, or fire accident.

7. Turn off the power whenever the machine is left unattended between works.

8. In case of a power failure or black out, turn off the power to avoid damage or accident.

在不同階段的注意事項

PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

1. 運輸

- (1) 當搬運或移動機器時，請考量機器重量，選擇安全合適的方式。請參考機器規格。
- (2) 採取足夠的安全防護，以避免機台在搬運或移動中掉落。
- (3) 為避免意外，運送時不要重覆使用包裝材料。

2. 拆箱

- (1) 在拆箱前，檢查機器是否平穩放置，並採用適當的工具維持拆箱過程的穩定。
- (2) 進行拆箱時，遵循外箱上的指示，小心外箱上的釘子或碎片。

3. 安裝：

3A. 桌板與腳架

- (1) 採用原廠的桌板以確保機器得到足夠的保護與支撐。如果在安裝或維修時，需要暫時將機器置放於物件上，請確定該物件有足夠的支撐力。
- (2) 如果桌板有裝置滾輪，滾輪需要有煞車鎖定機構，而且在操作與維修時，煞車機構必需鎖定。

3B. 電線與管路

- (1) 電線與管路的材質必需符合規範與需求。
- (2) 電線與管路不能夠有折彎或壓迫。移動的零配件上，電線與管路需有至少 30mm 以上的預留量。
- (3) 接線時不能有跳火。
- (4) 所有接頭都必需確實固定。當拆除時，務必要抓住接頭本體。

3C. 接地

- (1) 接地是必需的。且需由合格的技師來施工。
- (2) 在操作前需確認接地有確實。

3D. 馬達

- (1) 馬達的選用，必需符合規範與需求。
- (2) 如果馬達為皮帶傳動，務必要安裝保護措施以避免捲入危險。

4. 在開始操作前

- (1) 在開啟電源前，確認所有接頭，電線，管路都完好無損，確實連結。
- (2) 檢查皮帶輪的轉向與標示為同一方向。
- (3) 確認腳架滾輪都已鎖定。
- (4) 保持作業範圍淨空。

5. 在操作中

1. Transportation

- (1) When lift or move the machine, please take the machine weight into consideration and apply a safe manner. Refer to the specification for the information you need for transportation.
- (2) Apply sufficient safety measures when lifting or moving the machine to avoid falling or dropping.
- (3) To avoid unexpected accident, do not reuse the packing material for transportation.

2. Unpacking

- (1) Before proceeding to unpacking, check the balance of the machine and apply necessary tools to hold the proper position.
- (2) When unpacking, follow the instruction printed on the cartoon. Be careful of the nails and chips when unpacking from a wooden rack.

3. Installation:

3A. Table and Stand

- (1) Only adopt a qualified genuine table and stand to assure the holding support. In case you need to leave the machine on a surface temporarily for service, make sure the surface is strong enough to hold the weight.
- (2) If casters are applied to the table stand, adopt casters with a locking mechanism only and lock them well to secure the machine during the operation and service.

3B. Cable and Wire

- (1) The cables and wires must comply with the specification and requirement.
- (2) The cables and wires shall be free from bending or extra force. Reserve a free space of at least 30mm between cables/wires and the moving parts.
- (3) Do not apply starburst connection when wiring.
- (4) All connectors must be fixed securely. And always hold the connector body when removing it.

3C. Grounding

- (1) Grounding is necessary and must be done by a certified technician. (2) Check and ensure the grounding is secured before operation.

3D. Motor

- (1) The motor must comply with the specification and requirement.
- (2) If there is a belt in the motor transmission, adopt or apply a proper protector to avoid entangling.

4. Before Operation

- (1) Before turning on the power, make sure all the connectors, cables, and wires are free from damage, dropout, or looseness.
- (2) Check and make sure the pulley rotation follows the same direction as labels.
- (3) Make sure all the stand casters are locked or fixed in position.
- (4) Keep the working area clean from obstacles.

5. During Operation

- (1) Always keep your fingers, hair, or clothing away from the moving components and moving area. Do not place your personal belongings on the machine.

- (1) 注意手、頭髮、衣服不在機件移動範圍。不要將個人物品置放於機器上。
- (2) 機器會高速運作。保持雙手遠離移動機件範圍。機器完全停止前不要靠近。
- (3) 在移動物件或重新設定機器時，注意不要被機器或零件撞擊。
- (4) 避免突然起動造成意外，在檢查或維修馬達或皮帶時，務必關閉電源並確認機器完全停止。
- (5) 機器停止時，伺服馬達是無聲的。注意要關閉電源以免突然起動。
- (6) 永遠保持電控箱的風扇與氣道淨空。

6. 潤滑

- (1) 請依照說明書指示，選用合格的油脂來潤滑機件。
- (2) 如果油品接觸到眼睛或身體，立即以清水沖洗。如有不適，立即尋求醫護人員協助。
- (3) 如果油品不慎進入身體，立即尋求最近的醫療協助。

7. 維修保養

- (1) 只有合格的技師或工程師能夠進行維修服務，包含機器調整與修理。只採用原廠的零件進行更換。如果採用非原廠零件，或是因不當維修 / 調整所造成的傷害，本公司將不負任何責任。
- (2) 只有合格的技師或認證的工程師才能對電控系統進行維修或保養。
- (3) 當對氣動原件（如氣缸）進行維修保養時，務必先拔除風源，並將氣體完全洩除，以避免突然啟動。
- (4) 在調整或更換部件後，檢查所有螺絲是否鎖固。
- (5) 定期清潔是必需的。在清潔前務必先關閉電源，並確認機台完全停止。
- (6) 如果運作異常或不良，立即停止操作並關閉電源。聯絡授權經銷商或我們公司以尋求技術協助。
- (7) 當保險絲故障，立即關閉電源，找出故障原因並予以排除後，更換同規格的新的保險絲。
- (8) 定期檢查與清潔風道，電線與管路。

8. 工作環境

- (1) 機器必需不用電磁波干擾。
- (2) 電源供應必需良好且穩定。電壓波動不得超過 10%。
- (3) 隨時檢查空壓的壓力與品質。如果氣源不穩定，請安裝合適器材以改善。
- (4) 機器操作環境，室溫 5°C ~ 35°C，相對濕度 35%~85%。
- (5) 為了保護電子元件與安全起見，當有劇烈氣溫變化而導致凝水時，立即關閉並拔除電源，並靜候至完全乾燥為止。
- (6) 為了安全起見，當有打電或閃電時，請停止操作，關閉並拔除電源。
- (7) 勿在機器週遭使用電視或收音機，以避免干擾。
- (8) 依當地法令規範，在操作中採取必要的防護。
- (9) 關於包裝材料、潤滑油品，以及機器（含零配件）的丟棄，請依各地政府法規的規範執行。

- (2) The machine is designed to run at high speed. Always keep your hands away from the moving area. Do not resume the work cycle until the machine stops completely.
- (3) Be careful not to be caught by the machine or components when removing or resetting the machine.
- (4) To avoid accident caused by abrupt start, when performing service on the motor or belt, make sure the power is off and the machine stops completely.
- (5) A servo motor is silent as the machine stops. Be sure to turn off the power to avoid an abrupt start. (6) Always keep the fan and airway of the power cabinet clean from any obstacle.

6. Lubrication

- (1) Apply only qualified oil and grease onto the parts as instructed in the manual.
- (2) If the lubricant contacts your eye or body, wash it off immediately. Consult a medical care if necessary.
- (3) If the lubricant goes into your body accidentally, go to the nearby medical care immediately.

7. Service

- (1) Only a certified engineer/technician is allowed to perform service to the machine, including adjusting and repairing. Use only genuine parts for replacement. Our company assumes no responsibility/liability for any accident caused by improper repair or adjustment, or the use of any parts other than genuine one.
- (2) Only a certified technician or authorized engineer is allowed to repair or maintenance the electric system.
- (3) When performing service to air-driven parts, like an air cylinder, first disconnect the air supply and expel the air completely to avoid abrupt start.
- (4) Check all screws and nut are fixed well after adjusting and replacement.
- (5) A periodical cleaning is necessary. Make sure the power is off and the machine stops completely before cleaning.
- (6) If the machine functions poorly or abnormally, stop the operation and turn off the power. Contact the authorized dealers or us to request for a technical service support.
- (7) When there is a fuse failure, turn off the power, find out the cause of the failure and apply solution to it, then replace with a new one with the same spec.
- (8) Periodically check and clean the fan airway and the cable/wiring.

8. Working Environment

- (1) The machine should be free from the affection of electro-magnetic wave.
- (2) The power supply should be in good and reliable condition, the fluctuation of rated voltage should be less than 10%.
- (3) Always check the air pressure and quality. Some extra device might be needed if the supply is not reliable.
- (4) The machine is designed to be used with ambient temperature 5°C ~ 35°C, relative humidity 35%~85%.
- (5) To protect the electronic components and for safety cause, when there is a frost resulting from a dramatic temperature rise, disconnect the power and wait until it dry completely.
- (6) For safety cause, when there is a thundering or lightening, stop the operation and disconnect the power supply.
- (7) Do not use TV or radio nearby the machine as to avoid interference.
- (8) Apply necessary protection during operation. Follow applicable regulations set by local administration.
- (9) For disposal of packages, lubricant, and product, please follow the applicable regulations set by local administration.

1. 確定電源 Confirm the power source :

機器電源分為110v,220v,380v,50hz/60hz及1p3p等各式電源，三相機器請注意馬達轉向，順時針方向為正確方向，不對時，請對換其中兩條電源(接地線不可使用)。

Machine power supply supports the following types 110v, 220v, 380v (50hz/60hz). For the three-phase machines please watch for the spinning direction of motors, must be clockwise; if wrong, please exchange two cords among the three.(except the ground line).

2. 機器啟動前 Before you switch on the machine remember to refill oil first :

A. 請先加油：a油杯 P4-10 (亦可打開磨刀裝置整組P5-13直接加油至滑塊P4-60及刀台P4-57)

Use the P4-10 cup; or you can also open the knife-grinder assembly, P5-13, then refill directly into slider, P4-60, and blade plate, p4-57.

B. 磨刀齒輪前蓋螺絲處 P6-08 加油。

Knife-grinder wheel gear; The front covers the screw P6-08 to make sure to whet the knife bracket P7-17 at above fixed-point.



P4-10 油杯
P4-10 oil cup



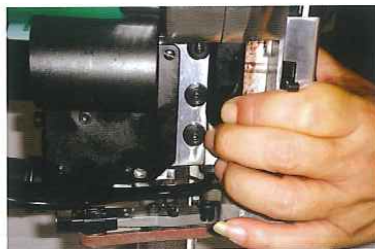
P6-08磨刀齒輪前
P6-08 knife-grinding gear



確定磨刀托架 P7-17 在上方定點
Confirm the knife holder, P7-17, is right on the above fixed point.

C. 左手往內按住磨刀橡膠輪把手P6-17，右手啟動電源，至機器馬達轉數達到全速。關閉電源再開電源，暖機作用數次，空轉約5-10分鐘，試磨刀，開始使用。(長時間未使用機器，動作亦同)

The left hand to inner press down to whet a handle knob in knife rubber P6-17, the right hand turns on the power supply, turn off the machine motor after spinning reaches the full speed. Repeat this procedure several times, for about 5~10 mintues, then try to whet the knife and start using the machine; Redo this procedure if you



左手往內按住P6-17把手
Left hand to inner press down
the handle knobs P6-17



右手啟動電源
The right hand starts the power
supply.



試磨刀
Try to whet the knife.

3. 直刀裁剪機基本常識 Common knowledge on Straight Knife Cutter :

1. 機器保養：每日加機油，油杯及磨刀齒輪前蓋螺絲處，每星期大小管(大1小2)及左右後輪各加一滴油，磨刀托架座內每月加(黃油)。底盤輪不得加油，裁機請勿使用針車油，確記加油，但不得過量。

The machine maintenance: refill the engine oil, oil cup and the screw in front of the knife wheel gear cover everyday; for the tubes (1 big, 2 small) and rear wheels to fill a drop of oil each every week, refill

grease inside of knife bracket every month. The bedrock round can not refill oil, cutting the machine to please do not use needle oil on the cutters, remember to refill but can not be too much.



大小管 P6-06/05
Size tube P6-06/05 in knife bracket



左右後輪 P7-39/40
Left & right rear wheel, P7-39/40



磨刀托架座 P7-16
Whet a P7-16

每日使用後利用工具P9-2清除刀削 (P8-02) 雜物，每星期利用空壓機清除機器表面棉絮及打開前小蓋 P5-32清除鳳梨心P5-09前雜物。

Make use of the tool clearance P9-2 knife to pare the miscellaneous articles (P8-02) or objects after the usage everyday; and use an air compressor to clean the machine every week. Machine surface waste cotton and open the ex miscellaneous articles or objects in small cover in front clearance P5-32 pineapple heart P5-09.

2. 確定刀片裝上並鎖緊P4-59，無刀片時請勿磨刀，磨刀時不可關閉電源

Make sure the blade is installed well and screw P4-59 tightly. Please do not whet the knife, without the razor blade installed. Do not turn off the power while whetting the knife.

3. 刀片不利時請按磨刀把手 (前蓋上方P5-16) 磨刀，普通鋼約1-2次，高速鋼約7-8次，磨刀卡住時請把磨刀卡筭 (P5-23)，往上提(前蓋左側)，再按磨刀把手即可。

When the blade becomes dull: Press the handle knob P5-16 to whet the knife; Try it about 1-2 times for common steel, about 7-8 times for high speed steel. If the knife get stocked then please take the quoin (P5-23) and lift upwards, (the front covers the left side), Press again to whet knife handle knob then.



清除刀削雜物



確定刀片裝上並鎖緊



磨刀卡住時卡筭往上提



打開大管內螺絲



刀片最底部調整



刀刃調整

4. 刀片角度調整 Blade angle adjustments :

- I. 刀片最底部調整(砂帶位置太高刀尖磨不到，太低會把刀尖磨成斜形)
Adjustment of razor blade bottom (the sand bring the too high point of a knife in position and can not whet, too low Will whet the point of a knife circular)
- II. 調整方式：把磨刀托架P7-17放在最上方定點，打開大管塑膠套P5-01，拿插削插入大管P6-06孔內固定住鳳梨心，打開螺絲P5-02插入工具P9-07，順時針方向轉一圈磨刀裝置提高1/32吋，逆時針時下降，依所需高度調整，調好後鎖緊螺絲，退回插削取出工具試磨，(刀片底部磨上顏色)
Adjustment method: take to whet the knife bracket P7-17 to put in the topmost and square fixed-point; Open to take care of the plastics a P5-01 greatly, take to insert to pare to insert into the big tube holes P6-06ses to live the pineapple heart fixedly; Opening the screw P5-02 inserts into the tool P9-07, clockwise turn a the turn whets the knife to equip the exaltation; 1/32 inches of, go against the hour hand to decline at present, adjust according to the height needed, lock the tight screw after tuning up, send back; Insert to pare to take out the tool to try to whet,(the razor blade bottom whet to apply color);
- III. 標準位置：把磨刀托架放至最低位置時，刀片下死點要在砂帶上方，依布類調整刀刀寬度。
When standard position in pair of whet the knife bracket to put to the lowest position, razor blade next the dead center want to bring in the sand above; The knife blade adjusts.
- IV. 刀刀調整，標準磨刀角度(薄料時右斜角要大於左斜角，1: 2/3，)；刀刀標準為1.8mm:1.2mm亦可(中厚物刀刀標準2.0mm:2.0mm)
the standard whets the knife angle(thin anticipate the right oblique angle is wanted to be big in left oblique angle,1: 2/3,); The knife blade is standard for the 1.8 mms:1.2 mms also can(win the thick thing knife blade the standard 2.0 mms:2.0mms); Adjust the knife blade width according to cloth,
- V. 調整方式：取出工具P9-08插入蹄鐵，往後調整斜角愈大，往前調整斜角愈小。
Adjustment method, take out the tool P9-08 to insert into the hoof iron, hereafter; The adjustment oblique angle is more big, adjusting the more small, in oblique angle toward the front.

5. 更換刀片 Change the razor blade :

- I. 先把裁機打橫(開關向上)平放於桌上，將馬達後蓋螺絲P2-31往內壓，按順時針方向轉動，刀片鎖刀螺絲P4-59轉動至磨刀托架上方，插入鎖刀板手P9-03往逆時針方向轉動，即可取出刀片，
To take to cut the machine to beat first horizontal (the switch heading ups) place levelly in the table, cover the screw after the motor; P2-31 to inside press, press clockwise turn to move, the razor blade locks the knife screw P4-59 to turn to move to go to whet the knife; The bracket is above, inserting into the lock knife plank hand P9-03 to go against the hour hand direction to turn to move, can immediately take out the razor blade,
- II. 裝上刀片後，盡量往上頂(刀片較短者不可)及向刀削方向拉緊，鎖上鎖刀螺絲，再按馬達後蓋螺絲往內壓轉動刀片，查看刀片在刀削中是否平順，
After packing the razor blade, as far as possible and upwards crest(shorter in razor blade can't) and pare the direction to tense to knife, lock; Lock the knife screw, then cover the screw after pressing motor to inside press to turn to fight with weapons the slice, look into the razor blade to pare in the knife; Medium whether favoring,
- III. 裝上新砂帶，使用前試磨砂帶，(換刀片時請清理刀削內雜物)
Pack the new sand to bring, the usage tried to whet the sand to bring the before. (While changing the knife the slice please tidy up the knife to pare inside the miscellaneous articles or objects)



馬達後蓋螺絲



砂帶及刀片種類



更換砂帶

6. 更換砂帶 Changing the sand band :

- I. 裁剪布料不同時，請使用不同砂帶，厚布使用80 #砂帶，一般請使用100#砂帶，薄布使用120#砂帶

To cut the cloth different, please use the different sand to bring, the thick cloth uses 80# sand to bring, Please generally to use 100# sand to bring, the thin cloth uses 120# sand to bring the cloth of thin,

- II. 布料薄，刀刃光亮，布料厚，刀刃可粗，塑膠類使用波刀使用細砂帶。

The knife blade is shining, The cloth is thick, the knife blade is thick, a knife in plastics usage uses the thin sand to bring the.

- III. 更換砂帶動作，把磨刀托架上之後輪P7-39/40往前按，取出砂帶換上新品，把砂帶安裝於前後輪間，經蹄鐵P7-27/32及刀片中間。

Method to change the sand band: take to whet the knife bracket up after a P7-39/40, presses toward the front, taking out the sand to bring to change. Ascend the new article, bring the sand to install in front and back round, through the hoof iron P7-27/32 and razor blades in the center.

7. 調整磨刀托架中心點 Adjust the knife bracket central point :

- I. 把磨刀托架移至適當位置，打開刀柱後導板P7-07，鬆開托架安定器P7-12(左右)

Pair of to whet the knife bracket to move to the appropriate position, leading after opening the knife column; Plank P7-07, loosen to open the bracket to stabilize the machine P7-12 (or so),

- II. 取出蹄鐵磨刀托架上方螺絲P7-35(左右)插上工具P9-09(工具前端與刀柱微微接觸)，將安定器與刀柱微微接觸，鎖緊安定器，兩邊，取出工具裝上螺母，鎖緊刀柱後導板，將磨刀托架移至最上方。

Take out the hoof iron to whet the knife bracket above; The silk P7-35 (or so) puts on the tool P9-09 (tool head and knife column tiny and tiny contact), will stabilize the machine; And knife column tiny and tiny contact.

Lock the tight stability machine, both sides, take out the tool to pack the screw hat, lock the tight knife; Lead the plank after the column, will whet the knife bracket to move to the topmost and square.



調整磨刀托架
adjustment whets the knife
bracket



左蹄鐵上方螺絲調整
Left hoof iron above the screw
adjustment



更換磨刀橡膠輪
changes to whet the knife rubber
round

8. 砂帶跳帶調整 Whet the knife bracket at above :

磨刀托架在上方時，夾臂P6-35會把左右蹄鐵分開，另左蹄鐵(大)上方螺絲P7-25應與刀片緊緊接觸，距離太遠會跳帶，蹄鐵螺絲P7-24應鎖緊，以防止蹄鐵移動。

Clip the arm P6-35 and will separate the or so hoof iron. Another left hoof iron (big) Above the screw P7-25 should is tight with razor blade to get in touch with tightly, the distance will jump to bring the hoof iron screw too far; The P7-24 should lock tightly, in order to prevent the hoof iron moves.

9. 更換磨刀橡膠輪 Change to whet a: in knife rubber :

更換磨刀橡膠輪，鬆開面具螺絲(4顆)及刀柱後導板螺絲，取出整組磨刀裝置，半按磨刀把手P5-16，將四角心P6-03/04轉為正平面，插入把手固定四角心，取出工具按住磨刀橡膠輪，往順時針方向取出磨刀橡膠輪，換上新品，按反方向動作裝回整組磨刀裝置即可。

- I. To lead the plank screw after loosening open the mask screw(4) and knife columns, take out whole The set whets the knife device,
- II. The half presses to whet the knife handle knob P5-16, turning four Cape heart P6-03/04ses as the positive flat surface,
- III. Inserting into the handle knob fixes four Cape hearts, taking out the tool to press down to whet the knife rubber round,
- IV. To clockwise take Pay to whet the knife rubber round, make replace with a new part, press opposite side action to pack to return to whole set to whet the knife to equip then

10. 裁機故障及維修方法 When the cutting machine breaks down and maintenance method :

Symptom :	Causes & Resolutions :
The motor does not work. (with humming noise)	<ol style="list-style-type: none"> 1. Cover the screw P2-31 after the motor to inside press, can't turn to move the hour: The knife pares inside have the miscellaneous articles or objects (Have the humming noise a hour) processing method: the clearance knife pares the miscellaneous articles or objects(usually is to stick to the gum quality thing) Or the knife a P4-57 and a P4-60s choked to death: processing method: Maintain or replace with a new part. 2. Can turn to move: hull inside the motor contain miscellaneous articles or objects processing method: clearance miscellaneous articles or objects, Starting the switch (platinum) P2-19 wears away Processing method: the platinum part brings to whet with the sand even, adjust to play Reed or replace with a new part. Leaving the heart switch(flying saucer) P2-21 wears away Processing method: adjust the spring coil slice, or replace with a new part.
The motor does not work. (without humming noise)	<ol style="list-style-type: none"> 1. The motor can't turn to move 1.Did not connect the power supply: processing method: put on the power supply. 2. Switch damages P4-16s: processing method: change the switch. 3. Get in touch with bad: electric wire and cut the machine plug P3-01/02 copper stick damage Processing method: replace with a new part.
The motor parking is nasty to stop or making strange noise	<ol style="list-style-type: none"> 1. Whet a P7-17 in knife not at position: Processing method: whet the knife to put to the fixed position
The machine emits smoke.	<ol style="list-style-type: none"> 1. Start bad: processing method: maintain to start the switch P2-19/21 2. The switch contact is bad. processing method: change new 3. The motor coil is damp: processing method: dry
The razor blade bottom splits.	<ol style="list-style-type: none"> 1. The knife pares inside have the miscellaneous articles or objects: processing method: the clearance knife pares the miscellaneous articles or objects inside the P8-02 The razor blade is sharp please use carefully(our company fully protects the gloves to sell medium, security check essential)
The motor does not start smoothly.	<ol style="list-style-type: none"> 1. Whetting the knife equips too below: processing method: take to whet the knife device to push to the fixed position (with humming noise) 2. Motor inner part contain miscellaneous articles or objects: processing method: internal miscellaneous articles or objects in clearance motor 3. The knife pares inside have the miscellaneous articles or objects: processing method: the clearance knife pares the miscellaneous articles or objects or changes the new article

The motor does not start smoothly.	<ol style="list-style-type: none"> Internal oil hardening in bearings: processing method: warm machine or replace with a new part. The usage oil is not appropriate: processing method: use 30# lubricant The electric voltage is too low: processing method: quantity electric voltage The electric wire is wrong or too long: processing method: change the electric cord.
The machine starts the voice big	<ol style="list-style-type: none"> A P4-57 in knife or knife a heart P4-56s exhaust: Processing method: maintain or replace with a new part. A P4-60 exhausts: processing method: maintain or replace with a new part. Bearings P4-47 or bearings heart damages P4-46s: processing method: replace with a new part.
The machine vibrates too greatly	<ol style="list-style-type: none"> The knife set or knife set hearts exhaust: processing method: maintain or replace with a new part. Connecting the bar P4-50 exhausts: processing method: replace with a new part. A P8-14 in bottom wears away: processing method: replace with a new part. .Bearings or bearings heart damage: processing method: replace with a new part.
The machine stops the fore shock to move	<ol style="list-style-type: none"> The razor blade pack too low: processing method: pack the razor blade method according to the standard. A bedrock in bottom leaves to cut the plank is too high: processing method: change the bottom round
Whetting the knife device cans not lets go	<ol style="list-style-type: none"> Whetting a P6-24 in knife rubber wears away: processing method: maintain or replace with a new part. Whetting the knife rubber round is stained with the oil: processing method: wipe to sweep Spring coil damages P6-27s: processing method: processing method: replace with a new part.
Whetting the knife device falls in	<ol style="list-style-type: none"> Whetting the knife equip to have no butter inside the wheel gear and the stalk of s: processing method: add the butter
Whetting the knife voice adds high	<ol style="list-style-type: none"> Whetting the knife rubber round transforms: processing method: replace with a new part. The wheel gear P6-14/16/42 wears away: processing method: replace with a new part. Should refill oil to refill oil, size tube and back round: processing method: refill oil
Clip the cloth	<ol style="list-style-type: none"> Knife tongue damages P8-04s: processing method: replace with a new part. Lose to whet the knife function: processing method: adjust to whet the knife to equip The bubble cotton clips the cloth: processing method: add paper every 5 layer bubble cottonses
The razor blade slices not next	<ol style="list-style-type: none"> The sand brings to wear away: processing method: change the sand to bring The sand brings to touch not go to: processing method: adjust screw The razor blade to whet to the bottom: processing method: change the razor blade Whet the knife angle inaccuracy: processing method: adjust the hoof iron Knife under carry to wear away the inaccuracy: processing method: adjust the pineapple heart the height
Pressing the feet P5-44 can't let go of	<ol style="list-style-type: none"> Inner part contain miscellaneous articles or objects: processing method: clearance miscellaneous articles or objects Press the feet column flection: processing method: adjust to press the feet column or replace with a new part.

發生狀況	故障原因及處理方式
<p>馬達無法轉動 (有嗡嗡聲時)</p> <p>馬達無法轉動 (無嗡嗡聲時)</p> <p>馬達停車急停或有怪聲</p>	<p>1. 馬達後蓋螺絲P2-31往內壓，無法轉動時:刀削內有雜物或刀台P4-57及滑塊P4-60卡死 處理方式:清除刀削雜物(通常為黏膠物質) 處理方式:維修或換新品</p> <p>2. 可以轉動:馬達內殼有雜物 處理方式:清除雜物 啟動開關(白金)P2-19磨損 處理方式:白金部份用砂帶磨平，調整彈簧片，或更換新品 離心開關(飛碟)P2-21磨損 處理方式:調整彈簧片，或更換新品</p> <p>1. 未接電源:處理方式:插上電源</p> <p>2. 開關P4-16損壞 處理方式:更換開關</p> <p>3. 接觸不良:電線及裁機插頭P3-01/02銅棒損壞 處理方式:換新品</p> <p>1.磨刀座P7-17不在定位 處理方式:磨刀座放至定位</p>
<p>機器冒煙</p>	<p>1. 啟動不良 處理方式:維修啟動開關P2-19/21</p> <p>2. 開關接觸不良 處理方式:換新</p> <p>3. 馬達線圈潮濕 處理方式:烘乾</p> <p>4. 馬達起動線損毀 處理方式:換馬達線圈</p>
<p>刀片底部斷裂</p>	<p>1. 刀削內有雜物 處理方式:清除刀削P8-02內雜物 刀片鋒利請小心使用(本公司備有保護手套出售中，安全檢查必備)</p>
<p>馬達啟動不良 (轉速不正常)</p>	<p>1. 磨刀裝置太下面 處理方式:把磨刀裝置推至定位</p> <p>2. 馬達內部有雜物 處理方式:清除馬達內部雜物</p> <p>3. 刀削內有雜物 處理方式:清除刀削雜物或換新品</p> <p>4. 軸承內部油硬化 處理方式:暖機或換新品</p> <p>5. 使用油不當 處理方式:使用30#潤滑油</p> <p>6. 電壓太低 處理方式:量電壓</p> <p>7. 電線太細或太長 處理方式:更換電線</p>
<p>機器啟動聲音大</p>	<p>1. 刀台P4-57或刀台心P4-56損耗 處理方式:維修或換新品</p> <p>2. 滑塊P4-60損耗 處理方式:維修或換新品</p> <p>3. 軸承P4-47或軸承心P4-46損壞 處理方式:換新品</p>
<p>機器震動太大</p>	<p>1. 刀台或刀台心損耗 處理方式:維修或換新品</p> <p>2. 連桿P4-50損耗 處理方式:換新品</p> <p>3. 底輪P8-14磨損 處理方式:換新品</p> <p>4. 軸承或軸承心損壞 處理方式:換新品</p>
<p>機器停止前震動</p>	<p>1. 刀片裝的太低 處理方式:按標準裝刀片方法</p> <p>2. 底輪底盤離裁板面太高 處理方式:更換底輪</p>
<p>磨刀裝置放不下</p>	<p>1. 磨刀橡膠輪P6-24磨損 處理方式:維修或更換新</p> <p>2. 磨刀橡膠輪沾到油 處理方式:擦拭清潔</p> <p>3. 彈簧P6-27損壞 處理方式:更換新品</p>
<p>磨刀裝置落下</p>	<p>1. 磨刀裝置內齒輪和螺軸無黃油 處理方式:加黃油</p>
<p>磨刀聲音加高</p>	<p>1. 磨刀橡膠輪變形 處理方式:更換新品</p> <p>2. 齒輪P6-14/16/42磨損 處理方式:更換新品</p> <p>3. 應加油處加油，大小管及後輪 處理方式:加油</p>
<p>夾布</p>	<p>1. 刀舌P8-04損壞 處理方式:更換新品</p> <p>2. 失去磨刀作用 處理方式:調整磨刀裝置</p> <p>3. 泡棉夾布 處理方式:每5層泡棉加一張紙</p>
<p>刀片不利</p>	<p>1. 砂帶磨損 處理方式:更換砂帶</p> <p>2. 砂帶碰不到 處理方式:調整螺絲</p> <p>3. 刀片已磨至底部 處理方式:更換刀片</p> <p>4. 磨刀角度不正確 處理方式:調整蹄鐵</p> <p>5. 刀片下端磨損不正確 處理方式:調整鳳梨心高度</p>
<p>壓腳P5-44無法放下</p>	<p>1. 內部有雜物 處理方式:清除雜</p> <p>2. 壓腳柱彎曲 處理方式:調整壓腳柱或更換新品</p>

SIRUBA

PARTS LIST

Series

CM006S

Parts Group

01

Subclass Remark

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Date

2023/11/2

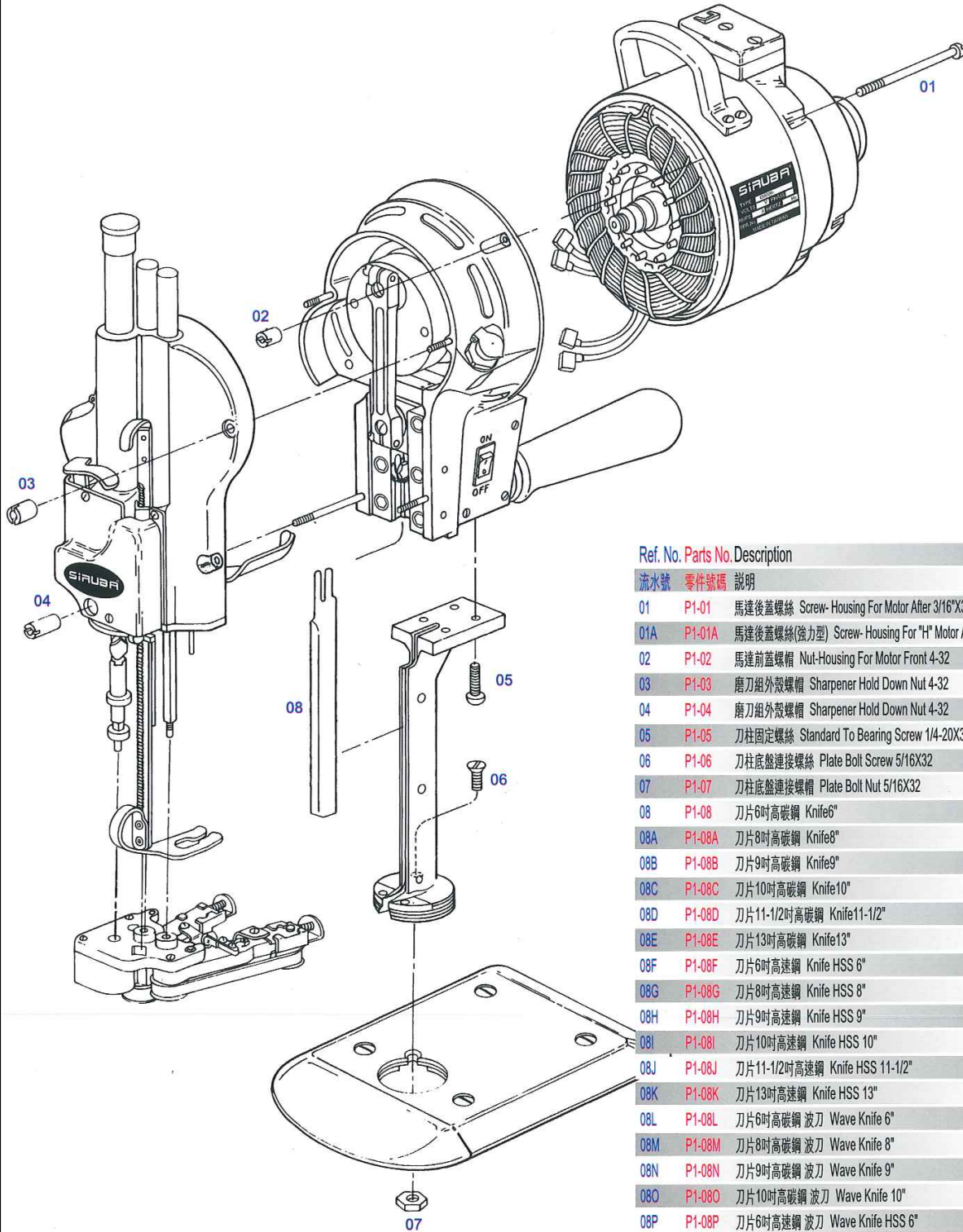
A

B

C

D

E



Ref. No. Parts No. Description

流水號	零件號碼	說明	備註
01	P1-01	馬達後蓋螺絲 Screw- Housing For Motor After 3/16"X32	4
01A	P1-01A	馬達後蓋螺絲(強力型) Screw- Housing For "H" Motor After 3/16"X32	4
02	P1-02	馬達前蓋螺帽 Nut-Housing For Motor Front 4-32	4
03	P1-03	磨刀組外殼螺帽 Sharpener Hold Down Nut 4-32	3
04	P1-04	磨刀組外殼螺帽 Sharpener Hold Down Nut 4-32	1
05	P1-05	刀柱固定螺絲 Standard To Bearing Screw 1/4-20X3/4	4
06	P1-06	刀柱底座連接螺絲 Plate Bolt Screw 5/16X32	1
07	P1-07	刀柱底座連接螺帽 Plate Bolt Nut 5/16X32	1
08	P1-08	刀片6吋高碳鋼 Knife6"	
08A	P1-08A	刀片8吋高碳鋼 Knife8"	
08B	P1-08B	刀片9吋高碳鋼 Knife9"	
08C	P1-08C	刀片10吋高碳鋼 Knife10"	
08D	P1-08D	刀片11-1/2吋高碳鋼 Knife11-1/2"	
08E	P1-08E	刀片13吋高碳鋼 Knife13"	
08F	P1-08F	刀片6吋高速鋼 Knife HSS 6"	
08G	P1-08G	刀片8吋高速鋼 Knife HSS 8"	
08H	P1-08H	刀片9吋高速鋼 Knife HSS 9"	
08I	P1-08I	刀片10吋高速鋼 Knife HSS 10"	
08J	P1-08J	刀片11-1/2吋高速鋼 Knife HSS 11-1/2"	
08K	P1-08K	刀片13吋高速鋼 Knife HSS 13"	
08L	P1-08L	刀片6吋高碳鋼 波刀 Wave Knife 6"	
08M	P1-08M	刀片8吋高碳鋼 波刀 Wave Knife 8"	
08N	P1-08N	刀片9吋高碳鋼 波刀 Wave Knife 9"	
08O	P1-08O	刀片10吋高碳鋼 波刀 Wave Knife 10"	
08P	P1-08P	刀片6吋高速鋼 波刀 Wave Knife HSS 6"	
08Q	P1-08Q	刀片8吋高速鋼 波刀 Wave Knife HSS 8"	
08R	P1-08R	刀片9吋高速鋼 波刀 Wave Knife HSS 9"	
08S	P1-08S	刀片10吋高速鋼 波刀 Wave Knife HSS 10"	

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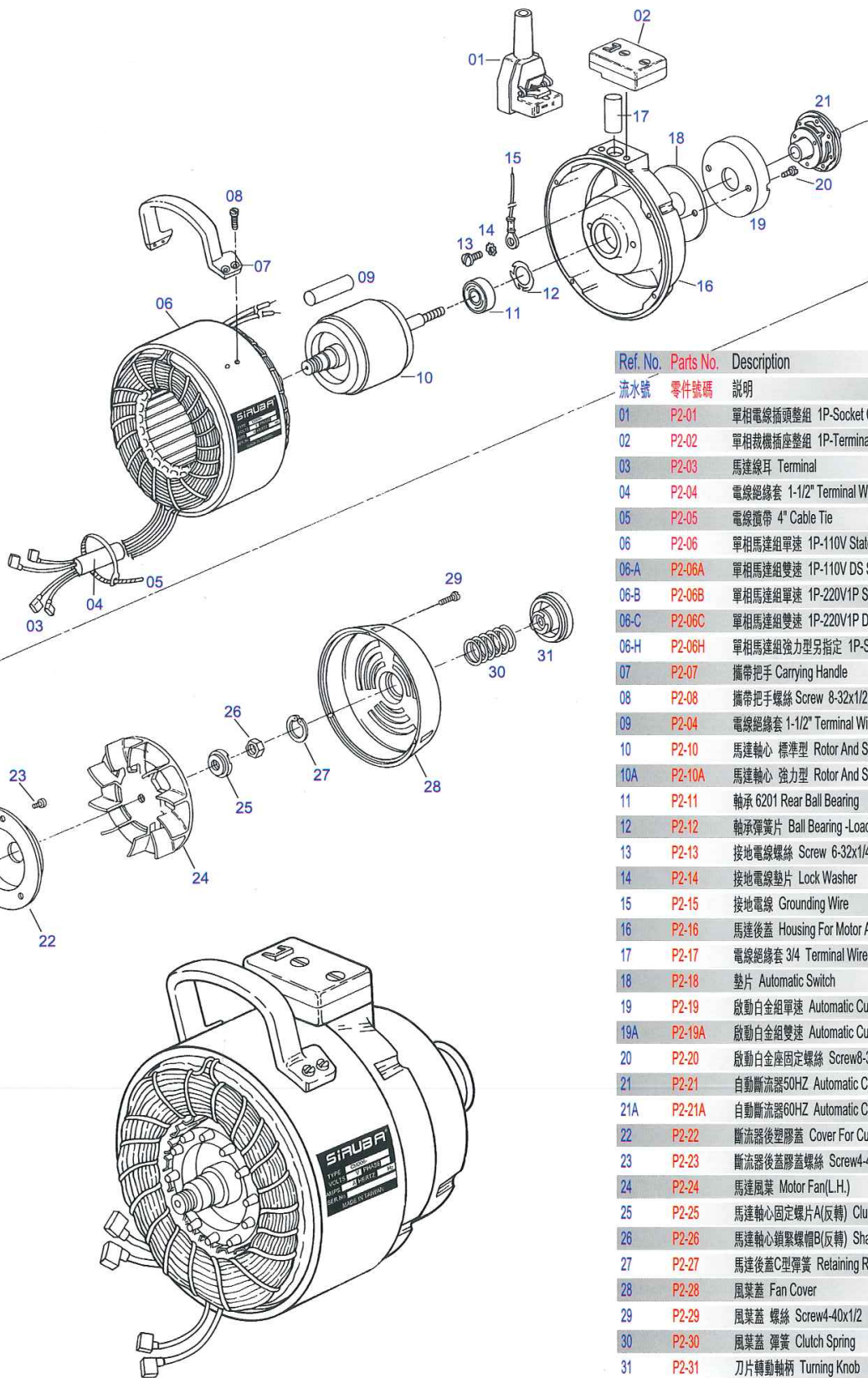
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Ref. No.	Parts No.	Description	備註
流水號	零件號碼	說明	
01	P2-01	單相電線插頭整組 1P-socket Complete	1
02	P2-02	單相截機插座整組 1P-Terminal Block Complete	1
03	P2-03	馬達線耳 Terminal	4
04	P2-04	電線絕緣套 1-1/2" Terminal Wire Tubing	1
05	P2-05	電線帶 4" Cable Tie	1
06	P2-06	單相馬達組單速 1P-110V Stator With Band	1
06-A	P2-06A	單相馬達組雙速 1P-110V DS Stator With Band	1
06-B	P2-06B	單相馬達組單速 1P-220V1P Stator With Band	1
06-C	P2-06C	單相馬達組雙速 1P-220V1P DS Stator With Band	1
06-H	P2-06H	單相馬達組強力型另指定 1P-Stator With Band(H)	1
07	P2-07	攜帶把手 Carrying Handle	1
08	P2-08	攜帶把手螺絲 Screw 8-32x1/2	4
09	P2-04	電線絕緣套 1-1/2" Terminal Wire Tubing	1
10	P2-10	馬達軸心 標準型 Rotor And Shaft	1
10A	P2-10A	馬達軸心 強力型 Rotor And Shaft (H)	
11	P2-11	軸承 6201 Rear Ball Bearing	1
12	P2-12	軸承彈簧片 Ball Bearing -Loading Spring Washer	1
13	P2-13	接地電線螺絲 Screw 6-32x1/4	1
14	P2-14	接地電線墊片 Lock Washer	1
15	P2-15	接地電線 Grounding Wire	1
16	P2-16	馬達後蓋 Housing For Motor After	1
17	P2-17	電線絕緣套 3/4" Terminal Wire Tubing	1
18	P2-18	墊片 Automatic Switch	1
19	P2-19	啟動白金組單速 Automatic Cutout Switch	1
19A	P2-19A	啟動白金組雙速 Automatic Cutout Switch (DS)	1
20	P2-20	啟動白金座固定螺絲 Screw8-32x3/8	2
21	P2-21	自動斷流器50HZ Automatic Cutout	1
21A	P2-21A	自動斷流器60HZ Automatic Cutout	1
22	P2-22	斷流器後蓋膠蓋 Cover For Cutout	1
23	P2-23	斷流器後蓋蓋蓋螺絲 Screw4-40x1/4	3
24	P2-24	馬達風葉 Motor Fan(L.H.)	1
25	P2-25	馬達軸心固定螺片A(反轉) Clutch Nut	1
26	P2-26	馬達軸心鎖緊螺帽B(反轉) Shaft Lock Nut	1
27	P2-27	馬達後蓋C型彈簧 Retaining Ring	1
28	P2-28	風葉蓋 Fan Cover	1
29	P2-29	風葉蓋 螺絲 Screw4-40x1/2	3
30	P2-30	風葉蓋 彈簧 Clutch Spring	1
31	P2-31	刀片轉動軸柄 Turning Knob	1

SIRUBA

PARTS LIST

Series

CM006S

Parts Group

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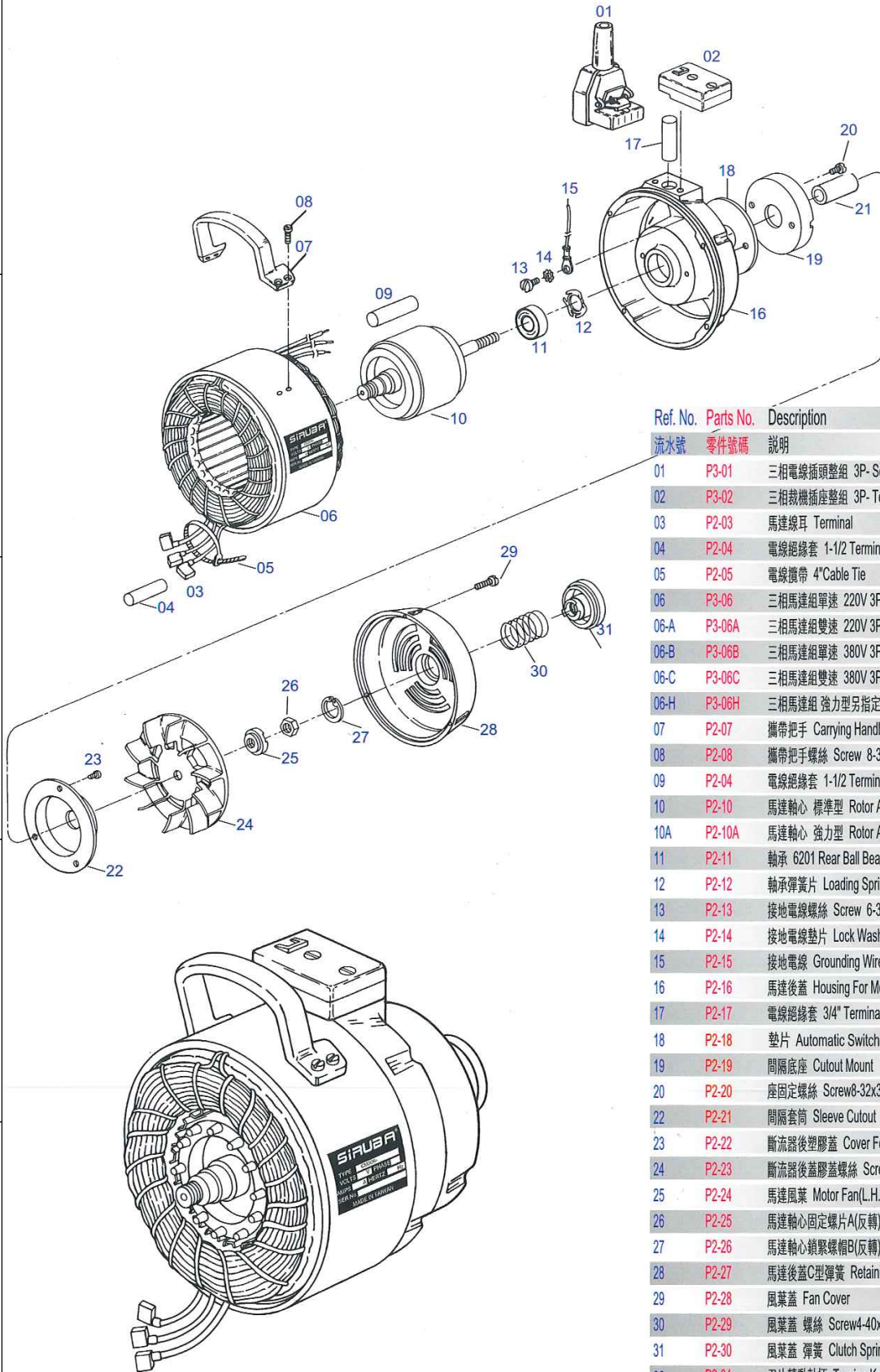
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Ref. No.	Parts No.	Description	備註
流水號	零件號碼	說明	
01	P3-01	三相電線插頭整組 3P- Socket Complete	1
02	P3-02	三相截機插座整組 3P- Terminal Block Complete	1
03	P2-03	馬達線耳 Terminal	4
04	P2-04	電線絕緣套 1-1/2 Terminal Wire Tubing	1
05	P2-05	電線纜帶 4"Cable Tie	1
06	P3-06	三相馬達組單速 220V 3P -Stator With Band	1
06-A	P3-06A	三相馬達組雙速 220V 3P DS-Stator With Band	1
06-B	P3-06B	三相馬達組單速 380V 3P -Stator With Band	1
06-C	P3-06C	三相馬達組雙速 380V 3P DS -Stator With Band	1
06-H	P3-06H	三相馬達組 強力型另指定 3P-Stator With Band(H)	1
07	P2-07	攜帶把手 Carrying Handle	1
08	P2-08	攜帶把手螺絲 Screw 8-32x1/2	4
09	P2-04	電線絕緣套 1-1/2 Terminal Wire Tubing	1
10	P2-10	馬達軸心 標準型 Rotor And Shaft	1
10A	P2-10A	馬達軸心 強力型 Rotor And Shaft (H)	1
11	P2-11	軸承 6201 Rear Ball Bearing	1
12	P2-12	軸承彈簧片 Loading Spring Washer	1
13	P2-13	接地電線螺絲 Screw 6-32x1/4	1
14	P2-14	接地電線墊片 Lock Washer	1
15	P2-15	接地電線 Grounding Wire	1
16	P2-16	馬達後蓋 Housing For Motor After	1
17	P2-17	電線絕緣套 3/4" Terminal Wire Tubing	1
18	P2-18	墊片 Automatic Switch	1
19	P2-19	間隔底座 Cutout Mount	1
20	P2-20	座固定螺絲 Screw8-32x3/8	2
22	P2-21	間隔套筒 Sleeve Cutout	1
23	P2-22	斷流器後塑膠蓋 Cover For Cutout	1
24	P2-23	斷流器後蓋塑膠蓋螺絲 Screw4-40x1/4	3
25	P2-24	馬達風葉 Motor Fan(L.H.)	1
26	P2-25	馬達軸心固定螺片A(反轉) Clutch Nut	1
27	P2-26	馬達軸心鎖緊螺帽B(反轉) Shaft Lock Nut	1
28	P2-27	馬達後蓋C型彈簧 Retaining Ring	1
29	P2-28	風葉蓋 Fan Cover	1
30	P2-29	風葉蓋 螺絲 Screw4-40x1/2	3
31	P2-30	風葉蓋 彈簧 Clutch Spring	1
32	P2-31	刀片轉動軸柄 Turning Knob	1

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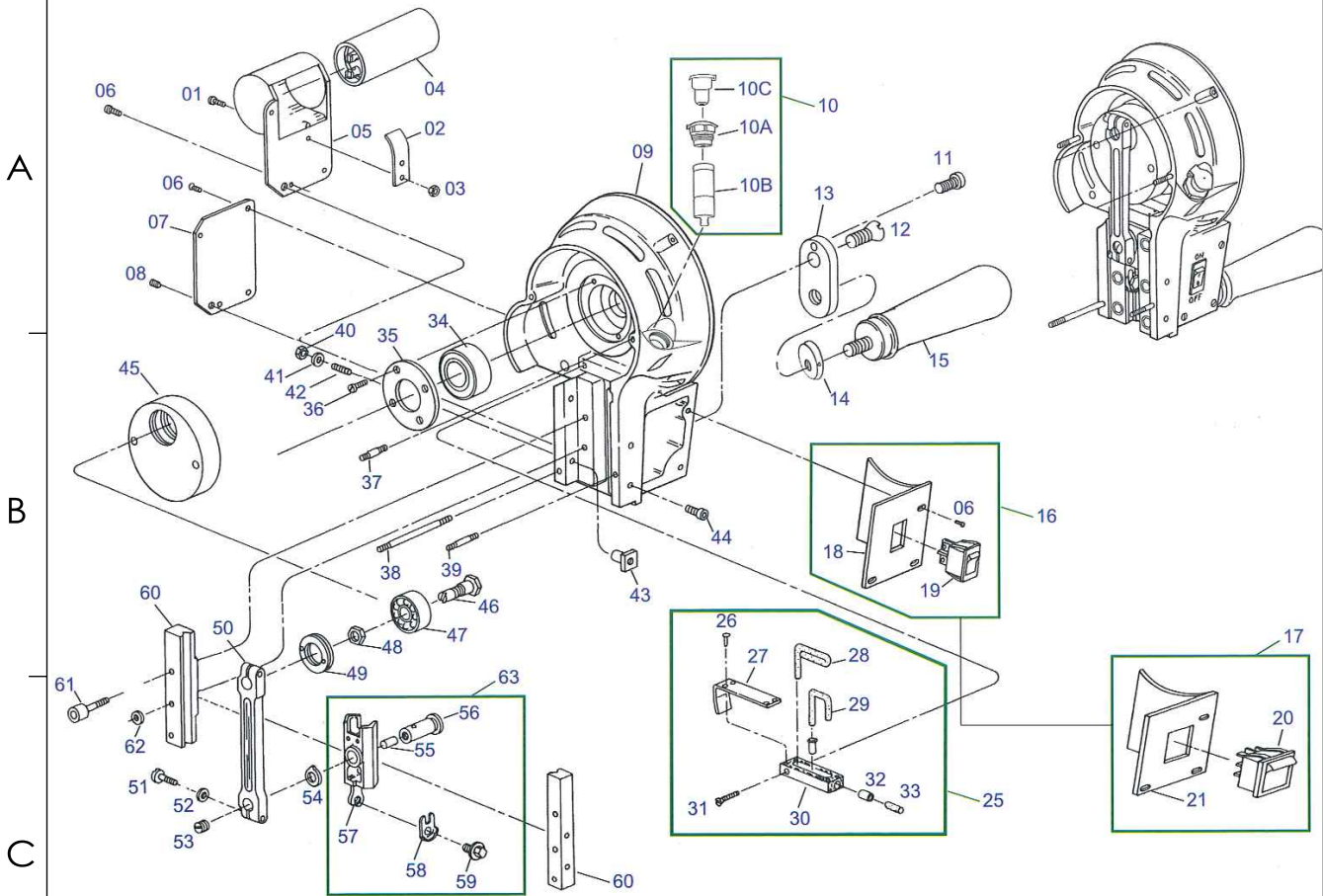
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Ref. No	Parts No.	Description	Quantity
流水號	零件號碼	說明	備註
01	P4-01	螺絲 Screw 8-32x3/8	3
02	P4-02	電容器固定片 Spring For Capacitor	1
03	P4-03	電容器固定螺帽 Stop Nut 8-32	1
04	P4-04	電容器單速 110V Capacitor	1
04	P4-04A	電容器強力型 110V H-Capacitor	1
04	P4-04B	電容器單速 220V Capacitor	1
04	P4-04C	電容器強力型 220V H-Capacitor	1
05	P4-05	電容器蓋 Capacitor Cover	1
06	P2-23	螺絲 Screw 4-40x1/4	7
07	P4-07	開關蓋 Switch Cover	1
08	P4-08	開關蓋螺絲 Screw For Switch Cover 1/4x32	1
09	P4-09	馬達前蓋 Housing For Motor Front	1
10	P4-10	油杯整組 Oil Pan Device	1
10A	P4-10A	油杯鎖 Cock Ring	1
10B	P4-10B	油杯 Oil Pan	1
10C	P4-10C	油杯蓋 Oil Pan Cover	1
11	P4-11	把手內六角螺絲 Screw For Handle Bracket 1/4x20x3/4	1
12	P4-12	把手托架螺絲 Screw For Handle Bracket 3/8x24x1/2	1
13	P4-13	把手連接托架 Handle Bracket	1
14	P4-14	把手固定螺帽 Nut For Handle Bracket	1
15	P4-15	把手 Handle	1
16	P4-16	單相開關整組單速 Switch-1p(Complete)	1
16A	P4-16A	三相開關整組單速 Switch3p(Complete)	1
17	P4-17	單相開關整組雙速 Switch-1p-DS(Complete)	1
18	P4-18	單相開關整組膠蓋單速 Switch Plate	1
19	P4-19	單相開關單速 Switch-1p-DS	1
19A	P4-19A	三相開關單速 Switch-3p	1
20	P4-20	單相開關雙速 Switch-1p-DS	1
21	P4-21	單相開關整組膠蓋雙速 Switch Plate-DS	1
22	P4-22	LED 專用蓋	1
23	P2-23	LED 燈	1
24	P4-24	LED 電線	1
25	P4-25	油槽整組 Oiling Device	1
26	P4-26	油槽螺絲 #2-56x1/8 Screw	4
27	P4-27	油槽蓋 Oiler Tube Cover	1
28	P4-28	油繩 1/8"x2" Oil Felt Wicking	1
29	P4-29	油繩 1/8"x1" Oil Felt Wicking	1
30	P4-30	油管 Oil Tube	1
31	P4-31	螺絲 4-40x3/4 Screw	1
32	P4-32	油管栓 Oil Tube Clear	1
33	P4-33	油繩 1/8"x.44 Oil Felt Wicking	1
34	P4-34	軸承 Ball Bearing 6203	1
35	P4-35	軸承蓋 Ball Bearing Retainer	1
36	P4-36	螺絲 6-32x5/16" Screw	4
37	P4-37	上螺絲榫 Stud Upper	2
38	P4-38	下左螺絲榫 Stud Lower L.H.	1
39	P4-39	下右螺絲榫 Stud Lower R.H.	1
40	P4-40	滑塊螺帽 Nut For Guide Screw 10-32	3
41	P4-41	滑塊調整墊片 Washer	3
42	P4-42	滑塊調整螺絲 Guide Adjustment Screw 10-32x3/4	3
43	P4-43	滑塊調整螺帽 Guide Adjustment Nut 10-32	3
44	P4-44	螺絲 8-32x3/8 Screw Socket Head	3
45	P4-45	飛輪 Crank 1-1/2 Stroke	1
46	P4-46	軸承心 Shaft For Ball Bearing	1
47	P2-11	軸承 Ball Bearing 6201	1
48	P4-48	軸承心螺帽 Lock Nut For Shaft	1
49	P4-49	軸承蓋 Crank Ball Bearing Lock Nut	1
50	P4-50	連桿 Connecting Rod 1-1/2 Stroke	1
51	P4-51	連桿螺絲 Connecting Rod Screw 8-32x11/16	2
52	P4-52	防震墊圈 Shake Proof Washer	2
53	P4-53	刀台心油棉栓 Wrist Pin Plug 1/4-28	1
54	P4-54	連桿墊片 Connecting Rod Washer	1
55	P4-55	刀台心油棉 Wrist Pin Felt Pad	1
56	P4-56	刀台心 Wrist Pin	1
57	P4-57	刀台十字頭 Cross Head	1
58	P4-58	鎖刀螺絲墊片 Knife Look Washer	1
59	P4-59	鎖刀螺絲 Knife Look Bolt	1
60	P4-60	滑塊 Guides 1-1/2 Stroke L.H.&R.H.	1
61	P4-61	滑塊固定螺絲 Guide Hold Down Screw 10-24	6
62	P4-62	滑塊固定墊片 Guide Washer	6
63	P4-63	刀台整組 Cross Head Device	1

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PARTS LIST

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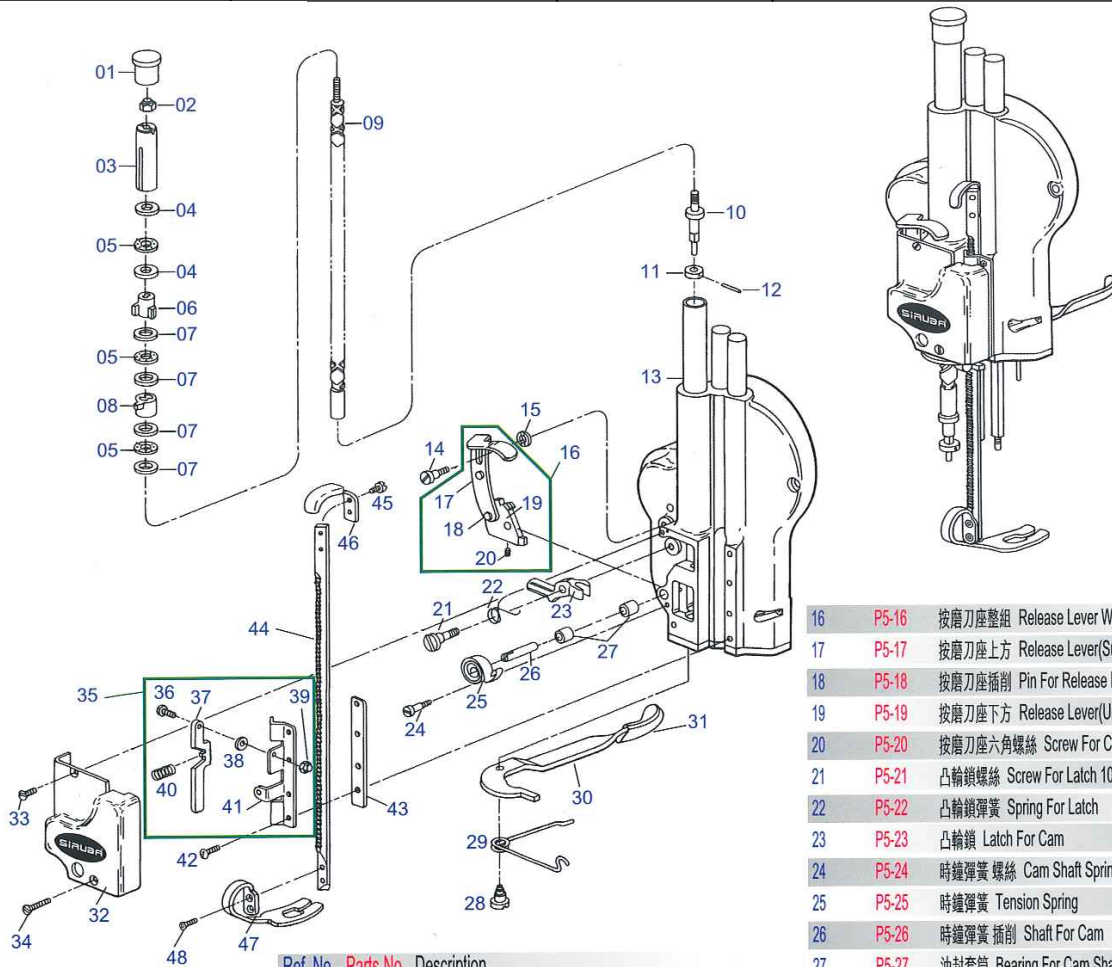
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Ref. No.	Parts No.	Description	備註
流水號	零件號碼	說明	
01	P5-01	大管螺帽 Cap For Tube	1
02	P5-02	鳳梨心止動螺絲 Nut Elastic 10-32	1
03	P5-03	調整螺絲 (8,10,11 1/2,13)1-1/4" Adjustment Screw	1
03A	P5-03A	調整螺絲 (7,9") 2-1/4" Adjustment Screw	1
03B	P5-03B	調整螺絲 (6")3-1/4" Adjustment Screw	1
04	P5-04	鳳梨心墊片(薄) Thrust Washer Upper Nut	2
05	P5-05	鳳梨心軸承墊片 Washer Ball Bearing	3
06	P5-06	鳳梨心反轉螺絲 L.H. Nut For Screw Shaft	1
07	P5-07	鳳梨心墊片(厚) Washer Flat	4
08	P5-08	鳳梨心正轉螺絲 R.H. Nut For Screw Shaft	1
09	P5-09	鳳梨心8吋以下 Screw Shaft With Extension 6"-8"	1
09A	P5-09A	鳳梨心9,10吋 Screw Shaft With Extension 9"-10"	1
09B	P5-09B	鳳梨心11 1/2吋 Screw Shaft With Extension 11-1/2"	1
09C	P5-09C	鳳梨心13吋 Screw Shaft With Extension 13"	1
10	P5-10	鳳梨心延長螺絲(反轉) Extension For Screw Shaft	1
11	P5-11	鳳梨心延長螺絲 套筒 Collar Lower	1
12	P5-12	鳳梨心延長螺絲 插銷 Roll Pin For Collar	1
13A	P5-13A	磨刀組外殼 Sharpener Housing With Bushing 6"-8"	1
13B	P5-13B	磨刀組外殼 Sharpener Housing With Bushing 9"-10"	1
13C	P5-13C	磨刀組外殼 Sharpener Housing With Bushing 11-1/2"	1
13	P5-13	磨刀組外殼 Sharpener Housing With Bushing 13"	1
14	P5-14	按磨刀座螺絲 Screw For Release Lever 8-32	1
15	P5-15	按磨刀座墊片 Spring Washer For Release Lever	1

16	P5-16	按磨刀座整組 Release Lever With Cam Complete	1
17	P5-17	按磨刀座上方 Release Lever(Supra)	
18	P5-18	按磨刀座插銷 Pin For Release Lever	
19	P5-19	按磨刀座下方 Release Lever(Under)	
20	P5-20	按磨刀座六角螺絲 Screw For Cam 10-32x3/8	1
21	P5-21	凸輪鎖螺絲 Screw For Latch 10-24	1
22	P5-22	凸輪鎖彈簧 Spring For Latch	1
23	P5-23	凸輪鎖 Latch For Cam	1
24	P5-24	時鐘彈簧 螺絲 Cam Shaft Spring Washer 6-32	1
25	P5-25	時鐘彈簧 Tension Spring	1
26	P5-26	時鐘彈簧 插銷 Shaft For Cam	1
27	P5-27	油封套筒 Bearing For Cam Shaft 5/16x3/16x6mm	2
28	P5-28	提腳把手螺絲 Pressure Foot Lever Screw 8-32	1
29	P5-29	提腳把手彈簧 Spring For Pressure Foot Lever	1
30	P5-30	提腳把手 Pressure Foot Lever	1
31	P5-31	提腳把手塑膠套 Vinyl Cover For Handle	1
32	P5-32	小前蓋 Cover For Cam	1
33	P5-33	小前蓋 左上螺絲 Screw # 6-32 x 5/16	1
34	P5-34	小前蓋 右下螺絲 Screw # 6-32 x 3/4	1
35	P5-35	押腳柱卡筍整組 Pressure Foot Look Bracket Complete	1
36	P5-36	押腳柱卡筍 螺絲 Screw For Knife Guard Lock 6-32x1/2	1
37	P5-37	押腳柱卡筍 螺帽 Lock For Pressure Foot	1
38	P5-38	押腳柱卡筍 墊片 Washer For Lock Bracket	1
39	P5-39	押腳柱卡筍 螺帽 Nut Self Lock 6-32	1
40	P5-40	押腳柱卡筍 彈簧 Spring For Pressure Foot Lock	1
41	P5-41	押腳柱卡筍座 Pressure Foot Lock Bracket Complete	1
42	P4-24	押腳柱卡筍座 螺絲 Screw # 6-32 x 3/8	4
43	P5-43	押腳柱 後墊片 Spacer For Knife Guard Lock Bracket	1
44	P5-44	押腳柱6-8吋 Pressure Foot Rod 6"-8" Knif	1
44A	P5-44A	押腳柱9-10吋 Pressure Foot Rod 9"-10 " Knife	1
44B	P5-44B	押腳柱11-1/2吋 Pressure Foot Rod 11-1/2" Knife	1
44C	P5-44C	押腳柱13吋 Pressure Foot Rod 13" Knife	1
45	P5-45	押腳耳 螺絲 Screw # 6-32 x 1/16	2
46	P5-46	押腳耳 Lift Handle For Knife Guard Lock	1
47	P5-47	押腳 Pressure Foot Shoe All Strokes	1
48	P5-48	押腳螺絲 Screw For Pressure Foot Shoe 6-32x1/4	2

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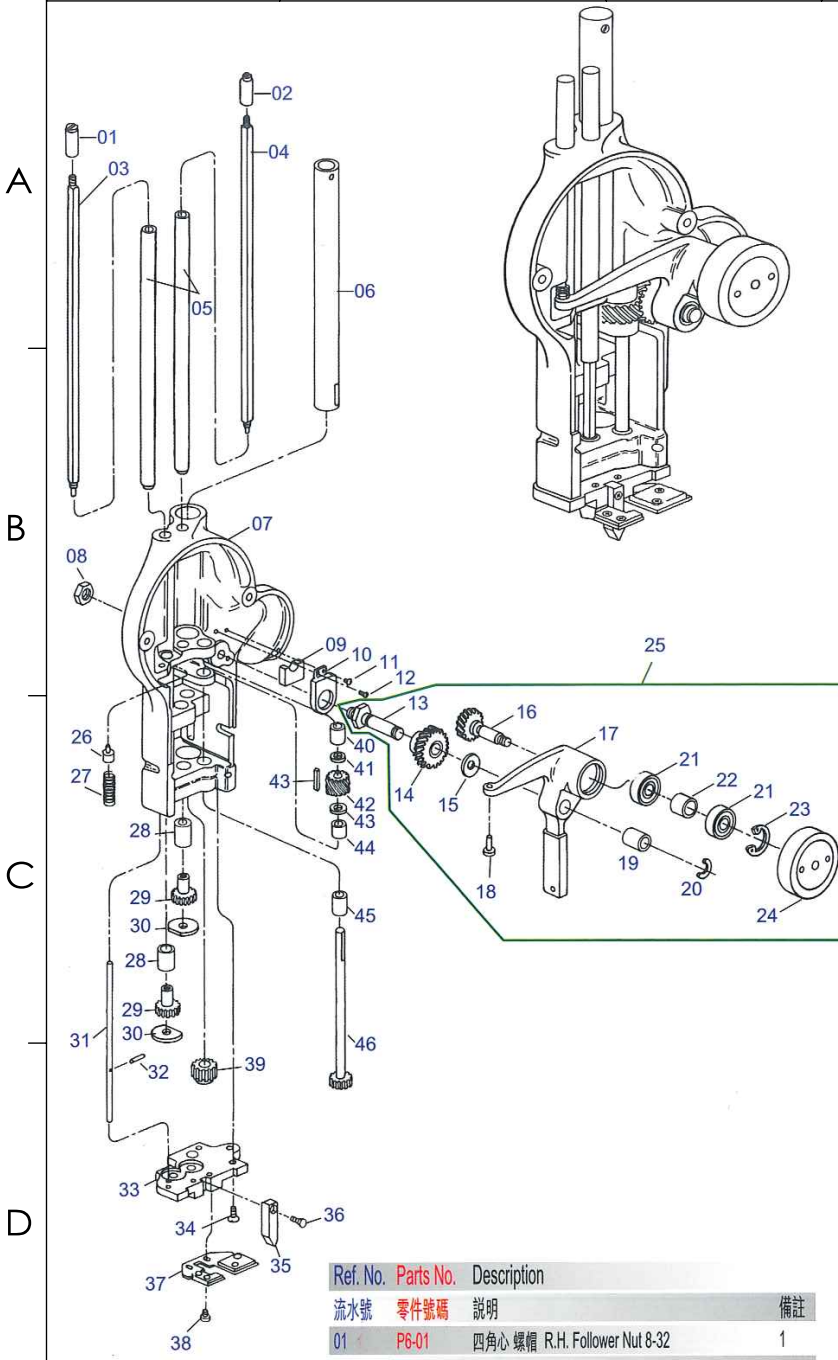
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SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	CM006S	06		1 / 1
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05C	P6-05C	小管 13" KnifeTube For (S)Square Shaft	2
06	P6-06	大管 6"-8" KnifeTube(L) For Square Shaft	1
06A	P6-06A	大管 9"-10" KnifeTube(L) For Square Shaft	1
06B	P6-06B	大管 11 1/2" KnifeTube(L) For Square Shaft	1
06C	P6-06C	大管 13" KnifeTube(L) For Square Shaft	1
07	P6-07	磨刀組外殼(空) Sharpener Housing(Only)	1
08	P1-07	齒輪心螺帽 Lock Nut For Shaft	1
09	P6-09	小油棉 Felt Pad For Cross Head	1
10	P6-10	小油棉蓋 Oil Retainer-Idler Gear	1
11	P6-11	小油棉蓋螺絲 Screw 4-40x1/8	1
12	P6-12	小油棉蓋螺絲 Screw 4-40x3/16	1
13	P6-13	齒輪心 Shaft For Crank	1
14	P6-14	大齒輪 Idler Gear Bushing	1
15	P6-15	齒輪墊片 Thrust Washer	1
16	P6-16	齒輪及軸 Gear And Shaft	1
17	P6-17	磨刀組殼(火腿) Bell Crank Only	1
18	P6-18	磨刀組(火腿)插削 Pin For Bell Crank	1
19	P6-19	油封套筒 Bearing For Bell Crank 7/16x5/16x18mm	1
20	P6-20	磨刀組(火腿)小C型夾 Retaining Ring For Shaft	1
21	P6-21	軸承 Ball Bearing 608 For Crank	2
22	P6-22	油封套筒 Spacer For Ball Bearing 7/16x5/16x11.4mm	1
23	P6-23	磨刀組(火腿)大C型夾 Retaining Ring For Ball Crank	1
24	P6-24	磨刀輪 Slow Speed Driver Assembly	1
25	P6-25	磨刀組(火腿)整組 Bell Crank Complete	1
26	P6-26	磨刀組外殼插削 Pin For Sharpener Housing	1
27	P6-27	磨刀彈簧 Spring For Ball Crank	1
28	P6-28	油封套筒 Bearing For Gear 7/16x5/16x12mm	2
29	P6-29	凸齒輪 Spur Gear	2
30	P6-30	凸齒輪墊片 Thrust Washer For Bottom Plate	2
31	P6-31	磨刀彈簧柱 Push Rod	1
32	P6-32	磨刀彈簧柱插削 Roll Pin For Push Rod	1
33	P6-33	磨刀組外殼下方墊片 Bottom Plate, Sharpener Housing	1
34	P6-34	磨刀組外殼下方墊片螺絲 Screw 8-32x3/8	3
35	P6-35	跨鐵分開插削 Spreader Pin	1
36	P6-36	跨鐵分開插削螺絲 Screw 6-32x1/2	1
37	P6-37	油棉墊片 Oil Pad & Holder	1
38	P6-38	油棉墊片螺絲 Screw 6-32x3/16	2
39	P6-39	齒輪型套筒 Bearing For Screw Shaft	1
40	P6-40	油封套筒 Bearing For Drive Shaft (Upper) 3/8x1/4x3/8	1
41	P6-41	墊片 Thrust Washer	2
42	P6-42	渦波齒輪 Spiral Gear	1
43	P6-43	齒輪插削 Key For Gear	1
44	P6-44	油封套筒 Bearing For Drive Shaft 3/8x1/4x1/4	1
45	P6-45	油封套筒 Bearing For Drive Shaft (Lower) 3/8x1/4x1/2	1
46	P6-46	齒輪及齒輪桿 Drive Shaft With Gear	1

Ref. No.	Parts No.	Description	備註
流水號	零件號碼	說明	
01	P6-01	四角心 螺帽 R.H. Follower Nut 8-32	1
02	P6-02	四角心 螺帽(反牙) L.H. Follower Nut 8-32	1
03	P6-03	四角心(上方正轉) 6"-8" Knife R.H. Square Shaft	1
03A	P6-03A	四角心(上方正轉) 9"-10" Knife R.H. Square Shaft	1
03B	P6-03B	四角心(上方正轉) 11 1/2" Knife R.H. Square Shaft	1
03C	P6-03C	四角心(上方正轉) 13" Knife R.H. Square Shaft	1
04	P6-04	四角心(上方反轉) 6"-8" Knife L.H. Square Shaft	1
04A	P6-04A	四角心(上方反轉) 9"-10" Knife L.H. Square Shaft	1
04B	P6-04B	四角心(上方反轉) 11 1/2" Knife L.H. Square Shaft	1
04C	P6-04C	四角心(上方反轉) 13" Knife L.H. Square Shaft	1
05	P6-05	小管 6"-8" KnifeTube (S)For Square Shaft	2
05A	P6-05A	小管 9"-10" KnifeTube(S) For Square Shaft	2
05B	P6-05B	小管 11 1/2" KnifeTube (S)For Square Shaft	2

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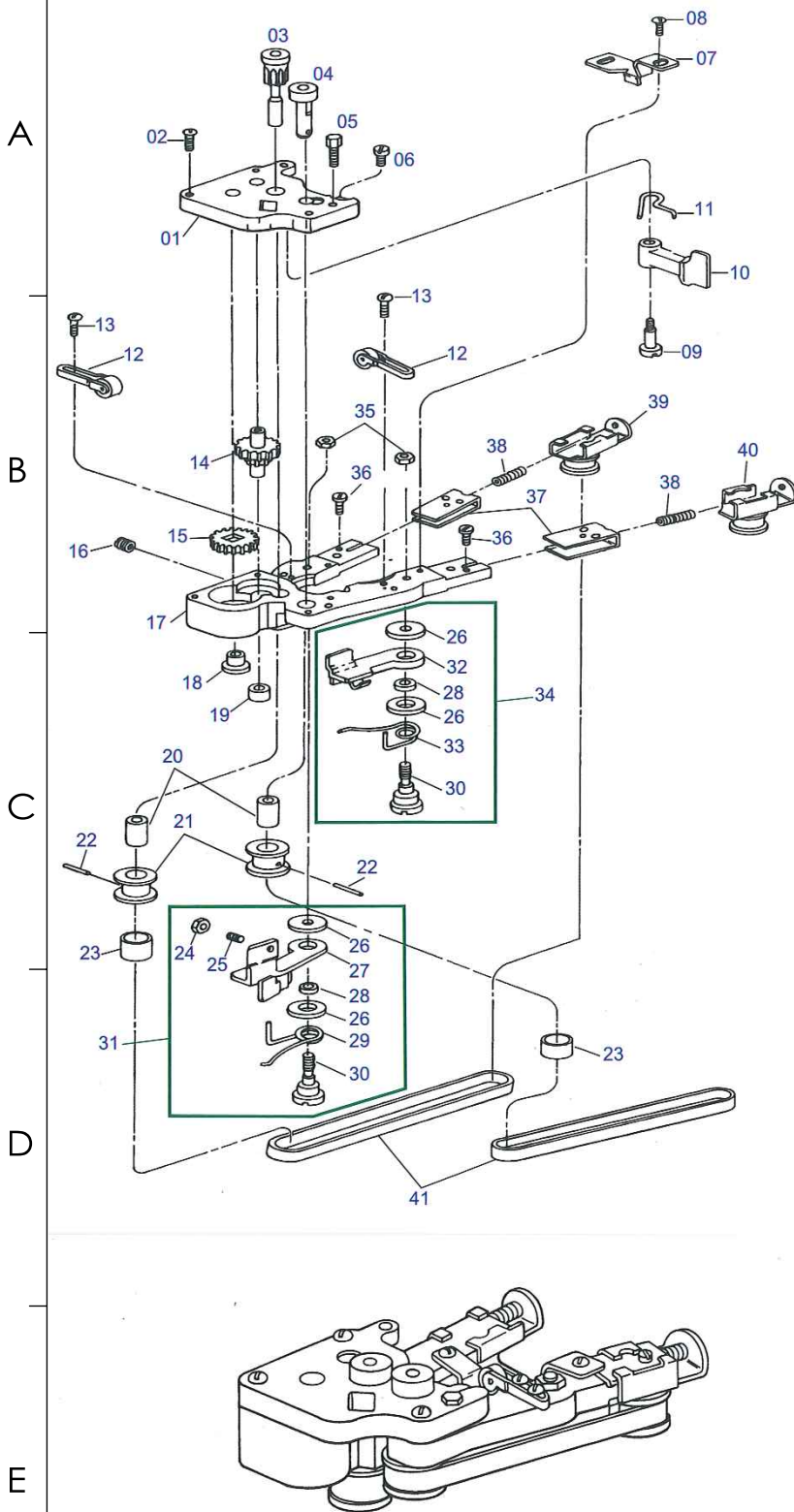
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01	P7-01	磨刀托架上方墊片 Gear Cover	1
02	P7-02	磨刀托架墊片螺絲(左側) Screw 6-32x1/2	3
03	P7-03	四角心下方螺絲 R.H. Shaft Extension	1
04	P7-04	四角心下方螺絲(反轉) L.H. Shaft Extension	1
05	P7-05	磨刀托架上方墊片螺絲(磨刀停車點) Adjusting Screw 10-32	1
06	P7-06	磨刀托架上方墊片螺絲(右側) Screw 6-32x3/8	1
07	P7-07	刀柱後導板 Guide Back Of Standard	1
08	P6-38	刀柱後導板螺絲 Screw 6-32x3/16	2
09	P7-09	提鐵分隔器螺絲 Screw For Clamping Arm 8-32	1
10	P7-10	提鐵分隔器 Clamping Arm For Shoe	1
11	P7-11	提鐵分隔器彈簧 Spring For Arm	1
12	P7-12	刀柱安定器 Stabilizer Assembly	2
13	P7-13	刀柱安定器螺絲 Screw 4-40x5/16	4
14	P7-14	四角心下方齒輪 Intermediate Gear	1
15	P7-15	鳳梨心下方齒輪 Gear On Screw Shaft	1
16	P7-16	黃油口螺絲 Oil Hole Plug 1/4x32	1
17	P7-17	磨刀托架(含套筒) Lower Gear Bracket(+Bearing)	1
17A	P7-17A	磨刀托架(整組) Lower Gear Bracket(Complete)	1
18	P7-18	凸型套筒 Bearing For Screw Shaft	1
19	P5-27	套筒 Bearing For Intermediate Gear	1
20	P7-20	油封套筒 Bearing For Shaft Extension3/8x1/4x14mm	2
21	P7-21	前輪 Front Pulley For Belt	2
22	P7-22	前輪插銷 Roll Pin For Pulley P-13-21	2
23	P7-23	前輪橡膠圈 Neoprene Band For Pulley	2
24	P7-24	大跨鐵固定螺帽 Nut 8-32	1
25	P7-25	大跨鐵調整螺絲 Stop Screw L.H. Shoe 8-32x5/16	1
26	P7-26	跨鐵墊片 Washer ,Shoe	4
27	P7-27	大跨鐵(L) Sharpener Shoe(Only)	1
28	P7-28	墊片襯套 Bushing For Sharpener Shoe	2
29	P7-29	大跨鐵彈簧(L) Sharpener Shoe Spring	1
30	P7-30	跨鐵螺絲 Screw For Sharpener Shoe 10-32	2
31	P7-31	大跨鐵整組(L) Sharpener Shoe(Complete)	1
32	P7-32	小跨鐵(S) Sharpener Shoe(Only)	1
33	P7-33	小跨鐵彈簧(S) Sharpener Shoe Spring	1
34	P7-34	小跨鐵整組(S) Sharpener Shoe(Complete)	1
35	P7-35	提鐵螺帽 Nut For Sharpener Shoe Screw 10-32	2
36	P7-36	後輪螺絲 Screw 4-36x3/16	2
37	P7-37	後輪墊片 Wear Plate	2
38	P7-38	後輪彈簧 Spring For Pulley Slide	2
39	P7-39	左後輪(面向面具) L.H. Slide With Pulley	1
40	P7-40	右後輪(面向面具) R.H. Slide With Pulley	1
41	P7-41	砂帶(標準) Abrasive Belts (#100)	2
41B	P7-41B	砂帶(細) Abrasive Belts (#120)	2
41C	P7-41C	砂帶(粗) Abrasive Belts (#80)	2

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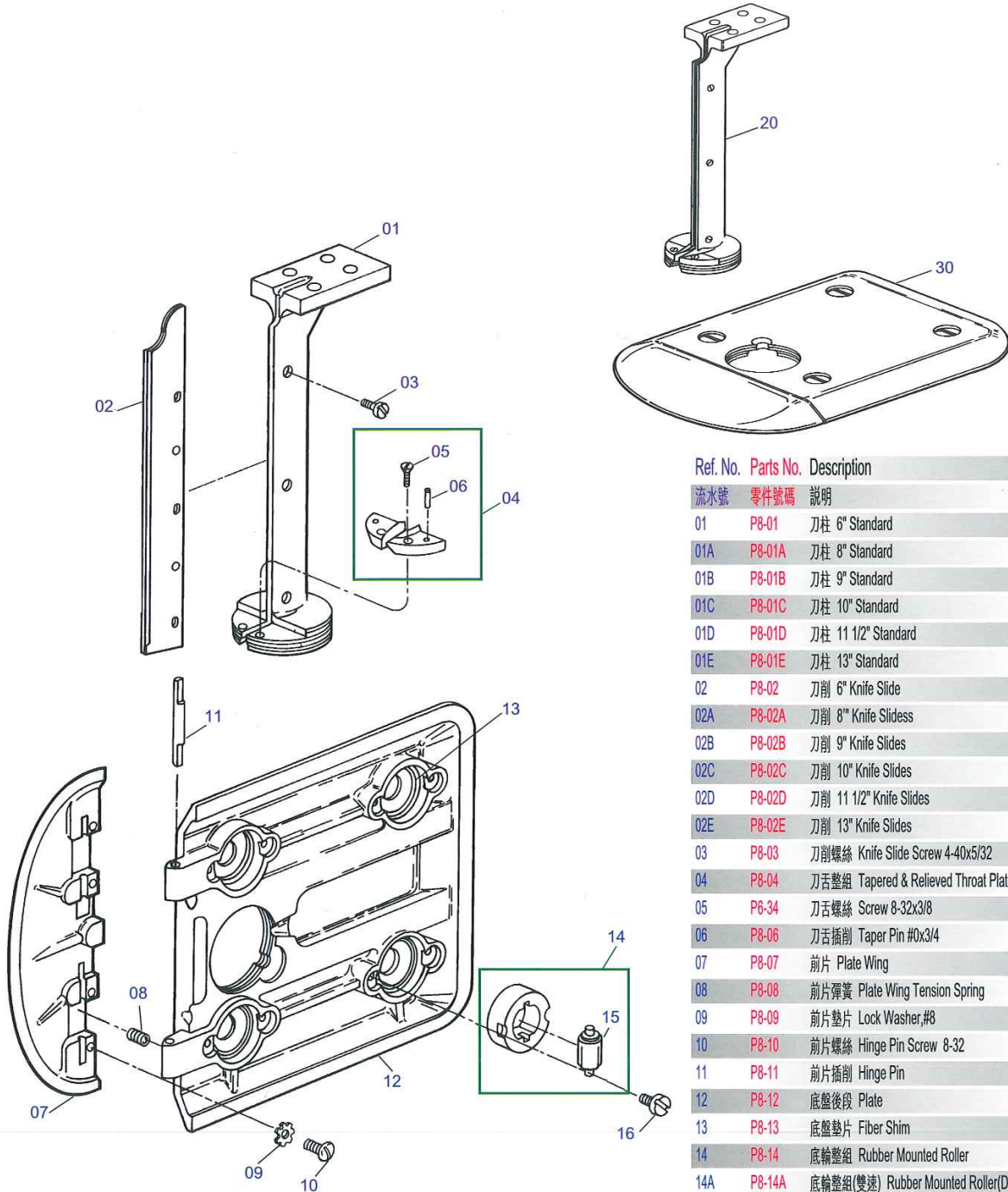
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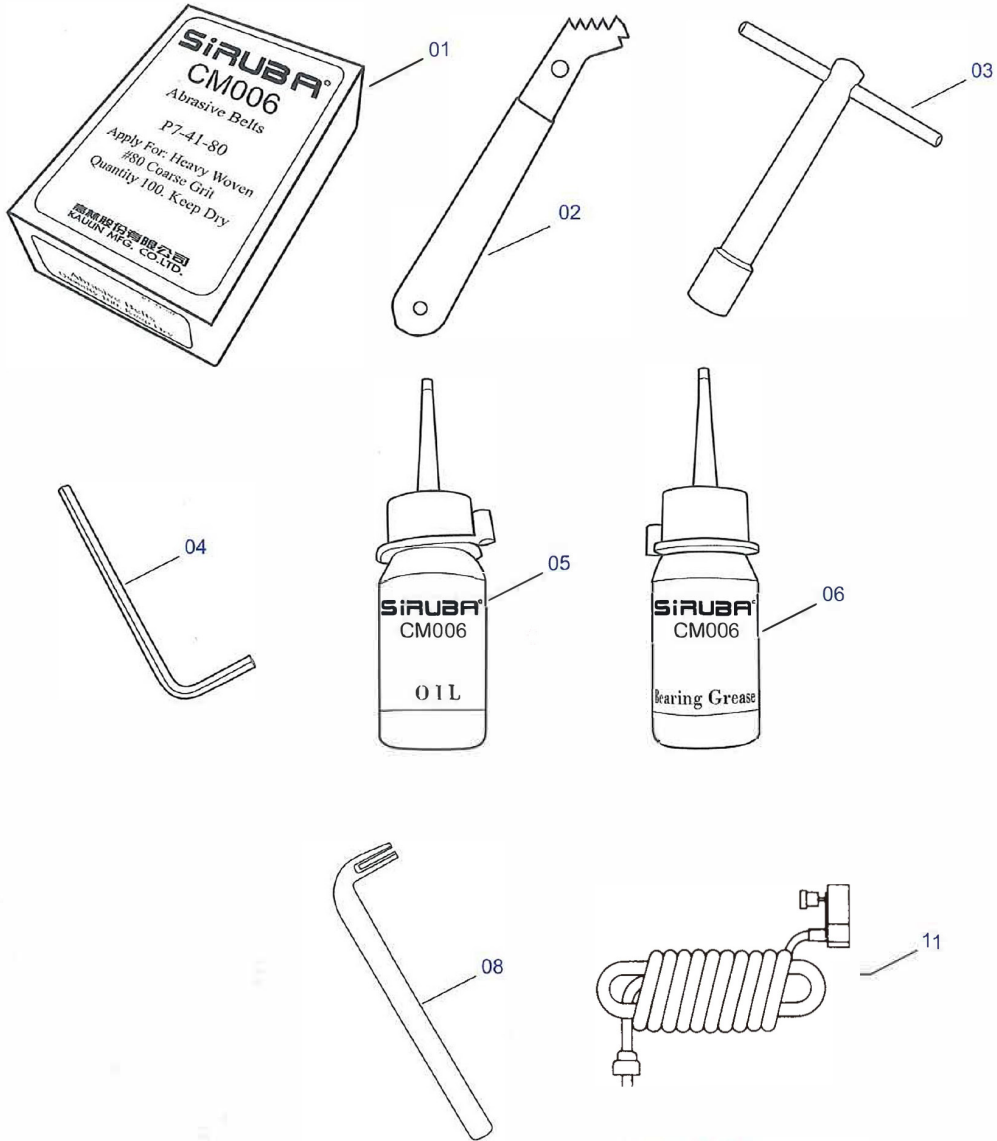


Ref. No.	Parts No.	Description	備註
01	P8-01	刀柱 6" Standard	1
01A	P8-01A	刀柱 8" Standard	1
01B	P8-01B	刀柱 9" Standard	1
01C	P8-01C	刀柱 10" Standard	1
01D	P8-01D	刀柱 11 1/2" Standard	1
01E	P8-01E	刀柱 13" Standard	1
02	P8-02	刀削 6" Knife Slide	1
02A	P8-02A	刀削 8" Knife Slidess	1
02B	P8-02B	刀削 9" Knife Slides	1
02C	P8-02C	刀削 10" Knife Slides	1
02D	P8-02D	刀削 11 1/2" Knife Slides	1
02E	P8-02E	刀削 13" Knife Slides	1
03	P8-03	刀削螺絲 Knife Slide Screw 4-40x5/32	3-4
04	P8-04	刀舌整組 Tapered & Relieved Throat Plates Assembly	1
05	P6-34	刀舌螺絲 Screw 8-32x3/8	2
06	P8-06	刀舌插削 Taper Pin #0x3/4	2
07	P8-07	前片 Plate Wing	1
08	P8-08	前片彈簧 Plate Wing Tension Spring	2
09	P8-09	前片墊片 Lock Washer,#8	4
10	P8-10	前片螺絲 Hinge Pin Screw 8-32	4
11	P8-11	前片插削 Hinge Pin	2
12	P8-12	底盤後段 Plate	1
13	P8-13	底盤墊片 Fiber Shim	6
14	P8-14	底輪整組 Rubber Mounted Roller	1
14A	P8-14A	底輪整組(雙速) Rubber Mounted Roller(DS)	1
15	P8-15	底輪軸 Roller Shell	4
16	P8-16	底輪螺絲 Clamp Screw 6-32x5/32	8
20	P8-20	刀柱 6"整組 Standard (Complete)	1
20A	P8-20A	刀柱 8"整組 Standard (Complete)	1
20B	P8-20B	刀柱 9"整組 Standard (Complete)	1
20C	P8-20C	刀柱 10"整組 Standard (Complete)	1
20D	P8-20D	刀柱 11 1/2"整組 Standard (Complete)	1
20E	P8-20E	刀柱 13"整組 Standard (Complete)	1
30	P8-30	底盤整組 Plate (Complete)	1

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Ref. No.	Parts No.	Description	備註
流水號	零件號碼	說明	
01	P9-01	砂帶 80#100#120#Abrasive Belts	1盒
02	P9-02	刀削清潔工具 Slot Cleaner	1
03	P9-03	鑷刀片螺絲起子 Knife Bolt Wrench	1
04	P9-04	押腳螺絲六角板手 Wrench For Shoe Screw 機油	1
05	P9-05	Lubricant	1
06	P9-06	黃油(牛油) Bearing Grease	1
* 07	P9-07	T型板手刀片高低調整工具 T Type Socket Wrench	1
* 08	P9-08	L型板手蹄鐵調整工具 L Type Socket Wrench	1
* 11	P9-11	電源線 Electric Cord Complete	1

* 可另行採購



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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.
SD-07AB01.NOV.2023