

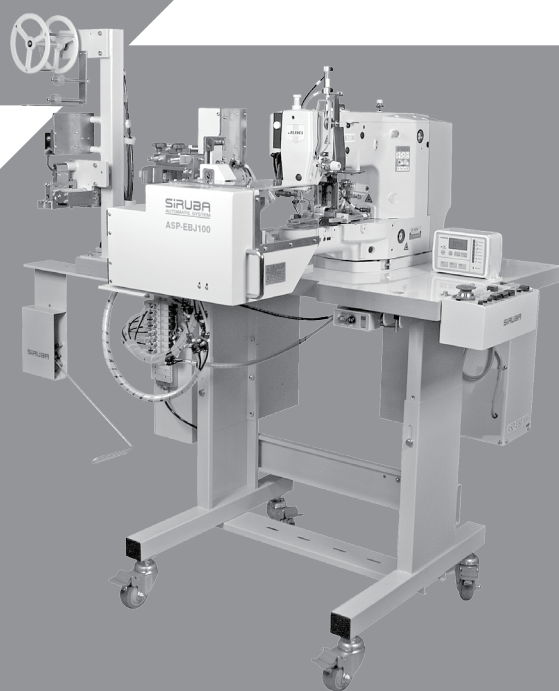
SIRUBA

ORIGINAL

使用說明書與零件圖

INSTRUCTIONS BOOK & PARTS LIST

■ ASP-EBJ100



ENGLISH

ENGLISH



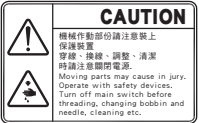

GENERAL SAFETY INSTRUCTION











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 listed in this manual may cause severe injury or even death, and damage to the property.

Explanation of warning indications and labels.

	<p>CAUTION HIGH VOLTAGE</p> <p>Do not open the cover of control box within 10 minutes after turn off the power.</p>		<p>HIGH SPEED MOTION POSITION</p> <p>In case of industrial accident</p>
	<p>CAUTION HIGH SPEED MOVING PARTS</p> <p>PREVENT FROM WORK-RELATED INJURIES</p>		<p>HIGH SPEED MOTION POSITION</p> <p>In case of industrial accident</p>

PICTORIAL WARNING INDICATION		PICTORIAL WARNING INDICATION	
	<p>There is a risk of injury if contacting a moving section.</p>		<p>Be aware that holding the sewing machine during operation can hurt your hands.</p>
	<p>There is a risk of electrical shock if contacting a high-voltage section.</p>		<p>There is a risk of entanglement in the belt resulting in injury.</p>
	<p>There is a risk of a burn if contacting a high-temperature section.</p>		<p>There is a risk of injury if you touch the button carrier.</p>
	<p>Be aware that eye de ciency can be caused by looking directly at the laser beam.</p>	INDICATION LABEL	
			<p>The correct direction is indicated.</p>
	<p>There is a risk of contact between your head and the sewing machine.</p>		<p>Connection of a earth cable is indicated.</p>

SAFETY PRECAUTIONS

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 is missing or contaminated, replace with a new one at soon.

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.
9. Fail to obey instructions above may cause severe injury or death to the operators.

PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

1. Transportation

- (1) When you 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.
- (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.

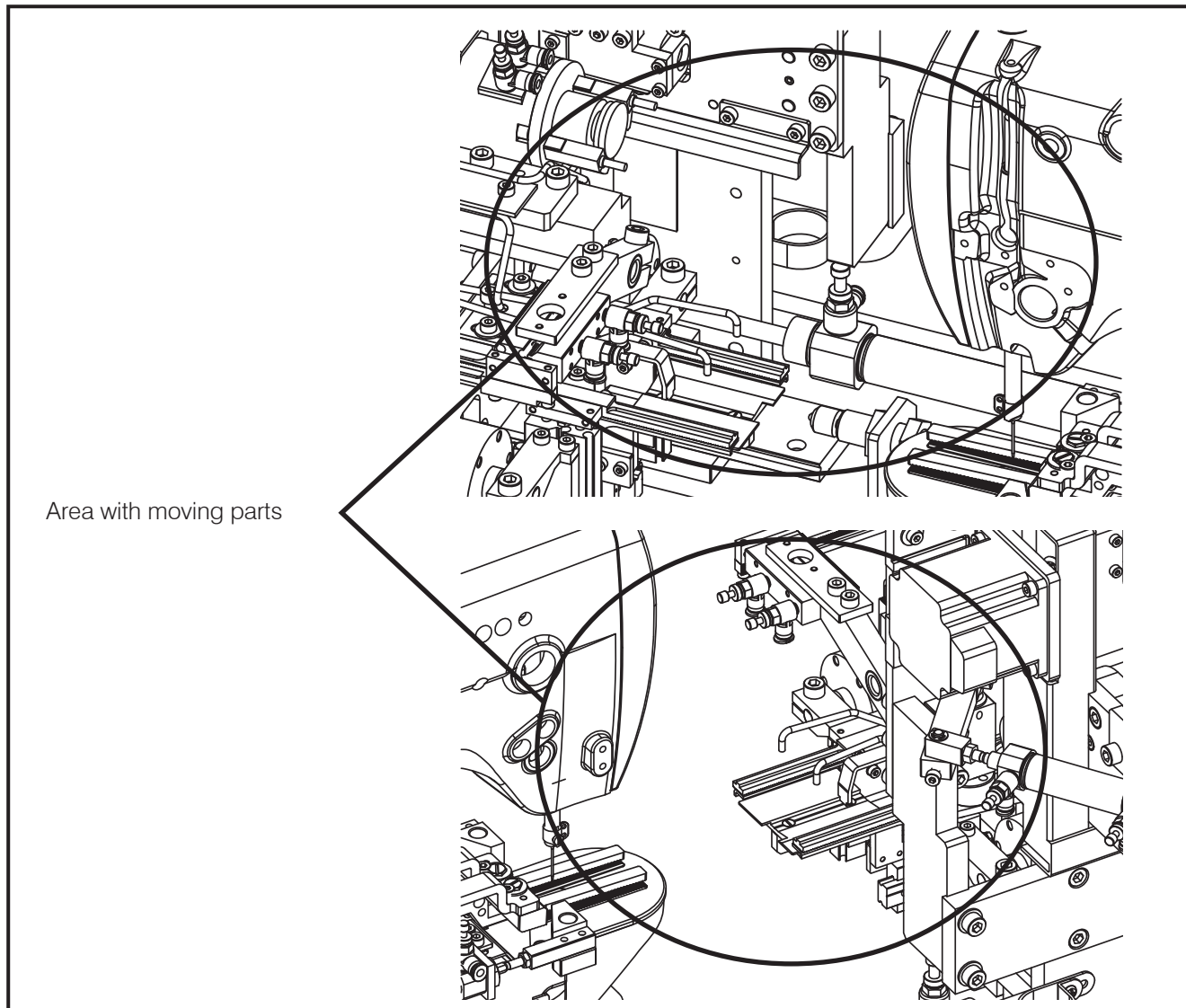
8. Working Environment

- (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 $5^{\circ}\text{C} \sim 35^{\circ}\text{C}$, 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.

SAFETY INSTRUCTION FOR EBJ SERIES

Parts moving area

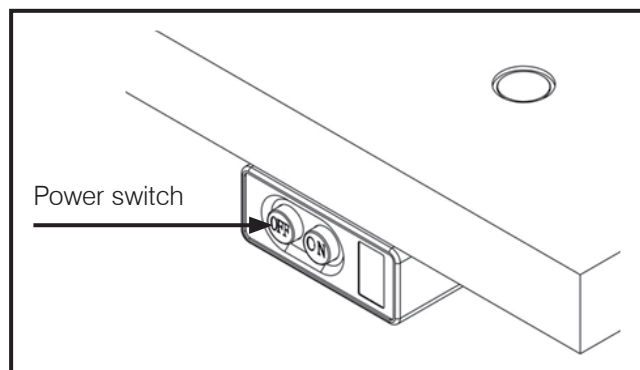
Always keep the moving area clean and free from any object.



Power Switch

Always turn off the power when:

1. Performing service.
2. When the machine is left unattended between works.

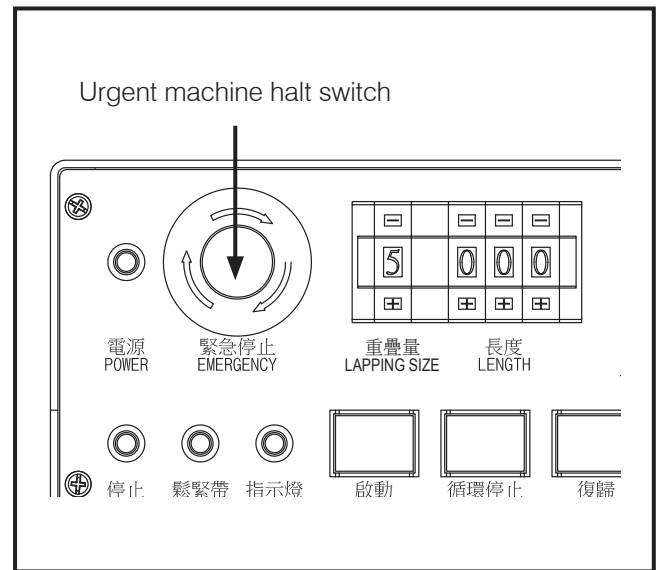


EMG Stop

1. When there is an emergency, press EMERGENCY stop to stop the machine.
2. It is strongly advised to press EMERGENCY stop before turning off the power.

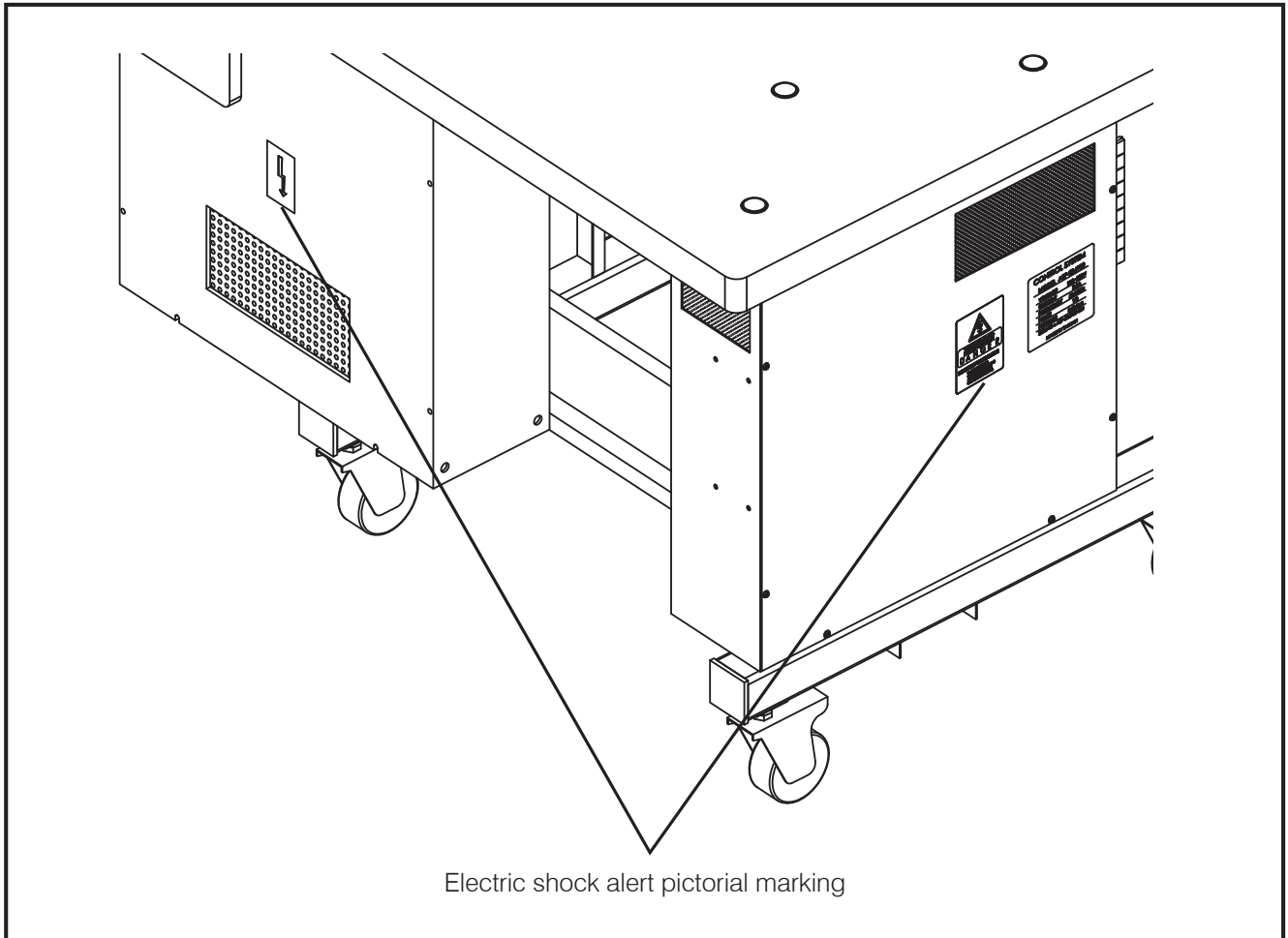
Resume to work by turning on the power and release EMERGENCY stop.

This is an insurance to insure the operator is paying enough attention to operation



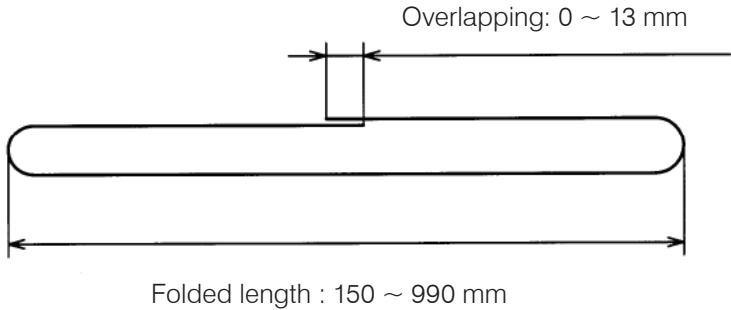
Power Cabinet

Only certified engineers or technicians are allow to open the power cabinet for service purpose. Turn off the power and disconnect the power source when performing service.



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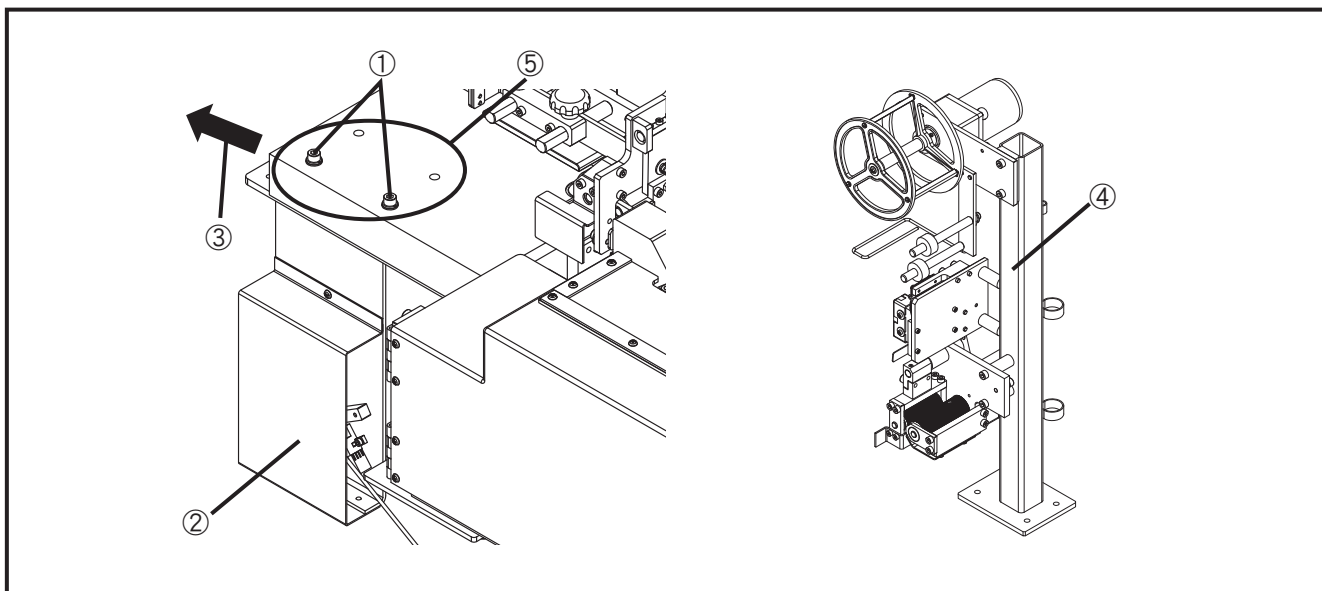
SPECIFICATION

Model	ASP-EBJ100	ASP-EBJ100S
Type of Needle	DP x 5 # 14	
Sewing Speed	2500 rpm (max)	
Output Capacity	Varies per stitches i.e. thread patter 172 stitches : 9 sec/cycle	
Band Width	20 ~ 50 mm	
Power	Single phase; 220V +/-10%; 50/60Hz	
Pneumatic	0.5 Mpa	
Air Consumption	30 L/min	
Sewing Size	 <p>Overlapping: 0 ~ 13 mm</p> <p>Folded length : 150 ~ 990 mm</p>	
Band Folding	Folded length: 150 ~ 990 mm (total length: 300 ~ 1980 mm) Overlapping: 0 ~ 13 mm	

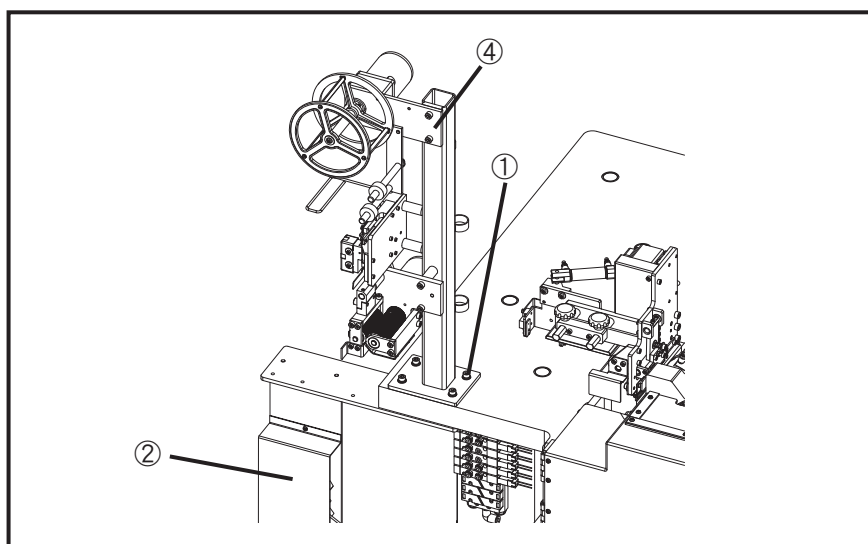
INSTALLATION

※ For safety issue, we strongly advise to have 2 technicians work together to install.

1. Unscrew screws ①, and move the Band Feeding Detector ② outward. (move with caution, do not damage the wire of the detector)
2. Install Band Feeder System ④ onto the table, matching to the position ⑤.



3. Apply screws to join the Band Feeder System ④ and Band Feeding Detector ②.
4. Connect all plugs and make sure they are secured.



5. Check the height of the Auto Kit

Before connecting the power and air, press the band clamber to avoid bumping into other parts ①.

Push the feeding plate ② toward the sewing machine until the surface ③ is the even with the needle plate ④.

When ③ is lower than ④ (more than 0.3mm), or ③ is higher than ④ (more than 0.5mm), loosen the screw ⑤, and adjust screw ⑥ for the proper height.

6. Pneumatic:

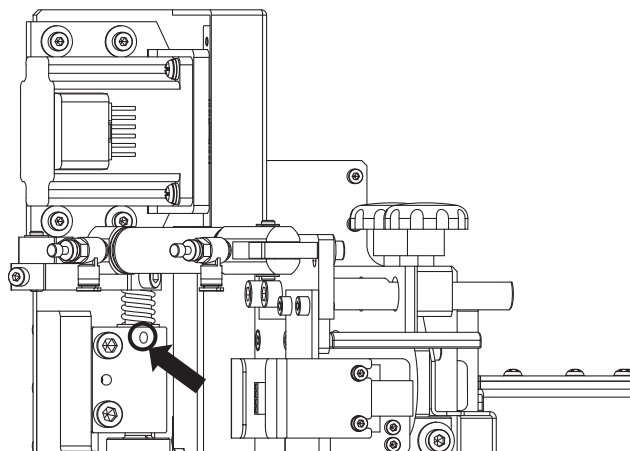
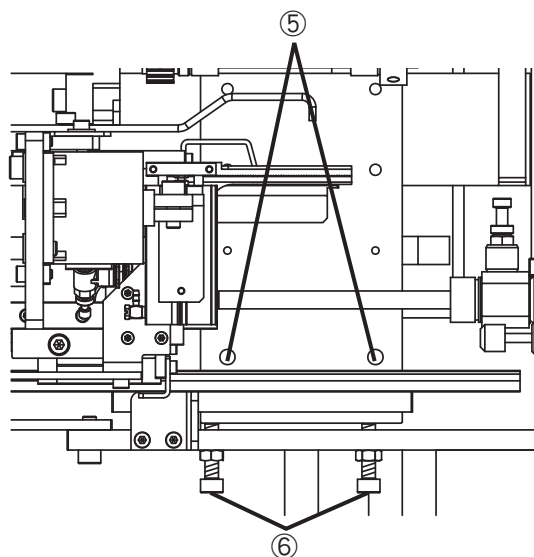
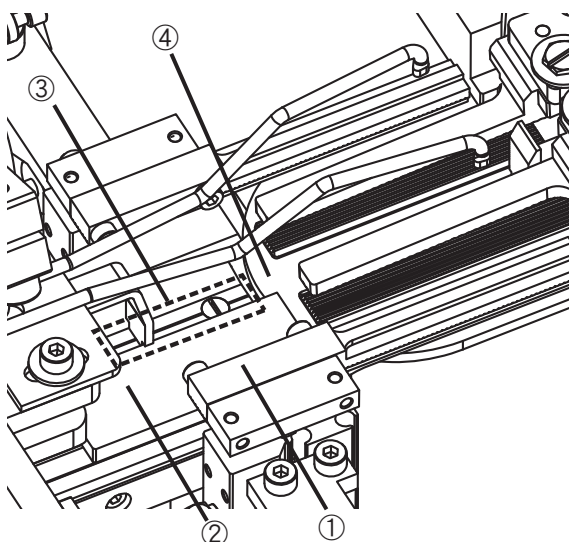
Set the air pressure at 0.5Mpa.

7. Power:

The power input must be in good quality in less than 10% fluctuation. The grounding must be connected properly.

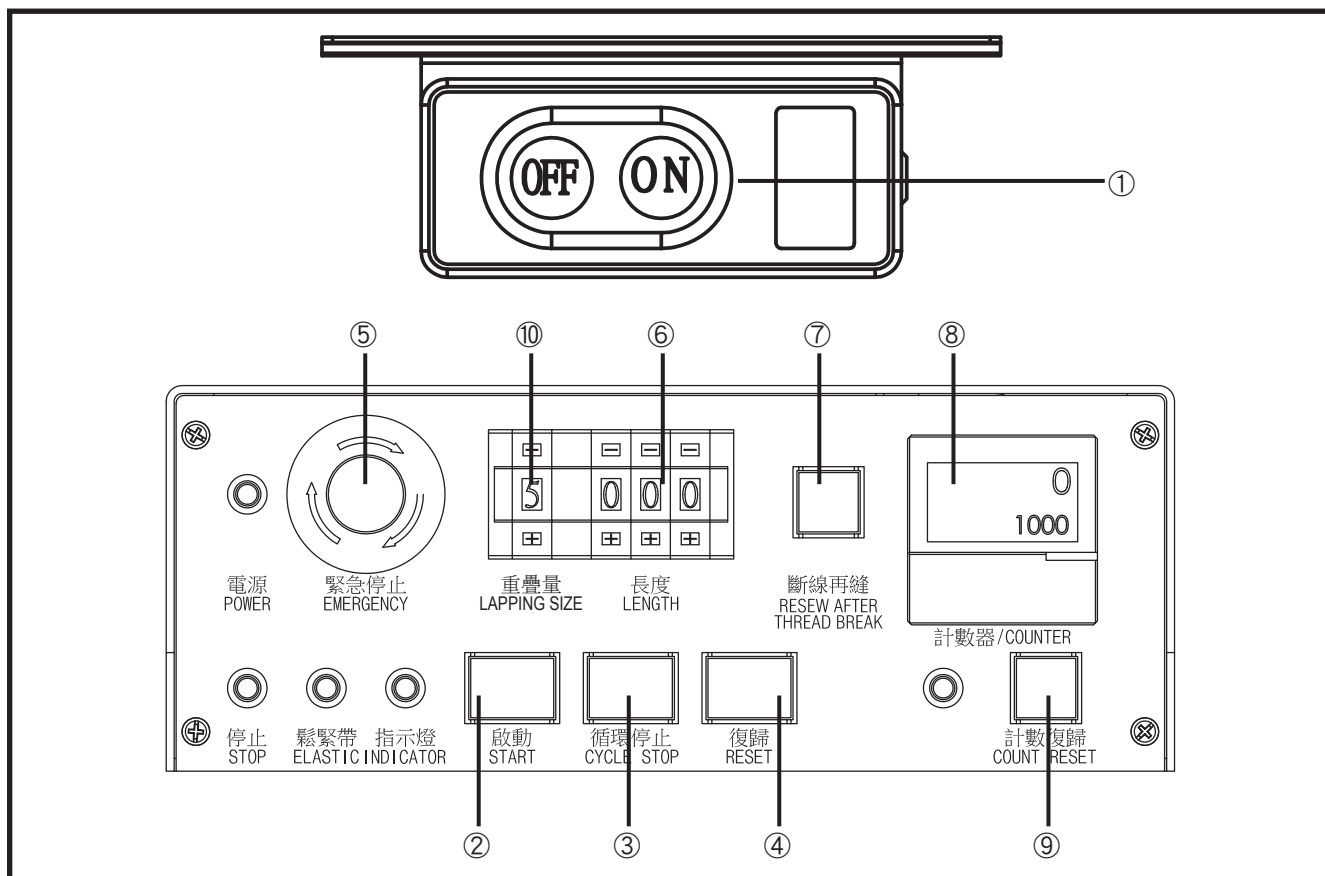
8. Lubrication:

- (1) For the lubrication of the sewing machine, please refer to the sewing machine manual.
- (2) For the cutter shaft (as shown below), please lightly apply oil regularly.



CONTROL PANEL

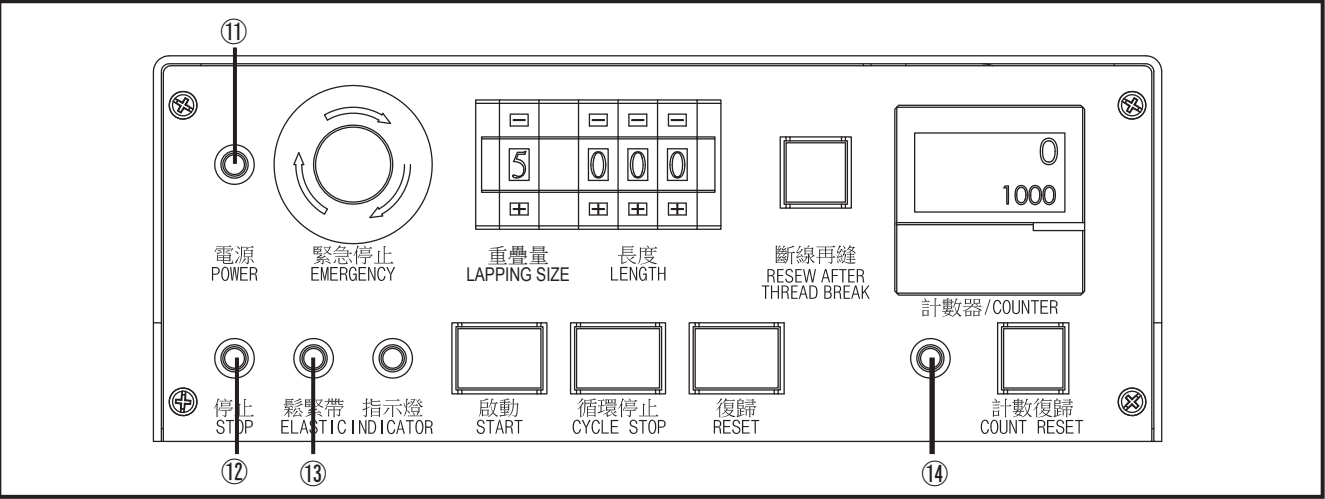
1. Setting Button



Item	Description
① POWER Switch	To turn on/off the power
② START (green)	1. To start the work cycle (Auto Mode) (p.14) 2. To start work cycle continuously. (p.15) 3. In Auto mode, to run one band circling move. (p.23)
③ Stop (yellow)	1. To stop the machine. (p.15) 2. To complete one work cycle only (p.15)
④ RESET (blue)	1. To offset the error alarm. 2. Press for 3 seconds to reset the band starting position. 3. To control Presser Foot when only sewing machine works alone.
⑤ EMERGENCY (red)	Press to stop the machine immediately for safety issue. Rotate the switch to release. (p.15)
⑥ LENGTH	To set the length of the finished product (p.13)
⑦ RESUME	To resume the work after threading interruption
⑧ COUNTER	1. To set the target production amount. 2. To count the number of production. 3. Applicable as counter for under thread. ※1
⑨ COUNT RESET	To reset the counter value to "0". (p.21)
⑩ OVERLAP	To set the overlapping area. Value "5" as reference position. (p.13, 16, 17, 18)

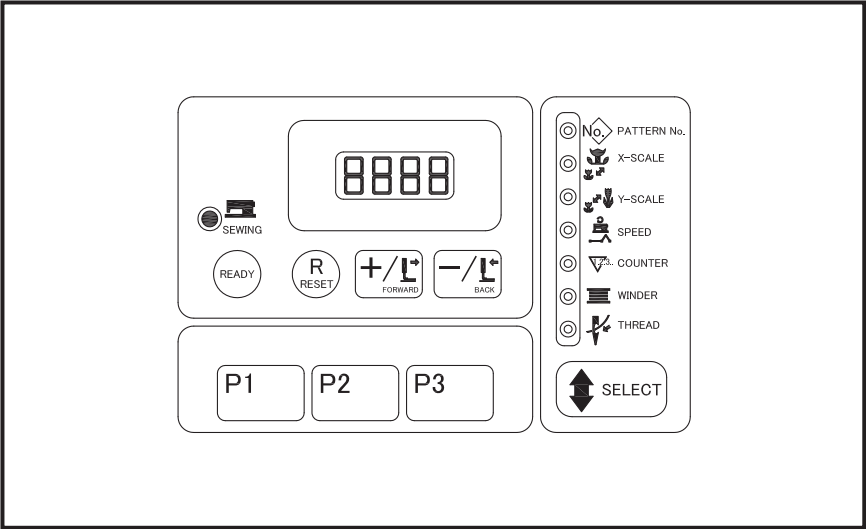
※1: to set the consumption of under thread as a service reminder.

2. Indicator



Item	Description
⑪ POWER	1. On when the power is ON 2. Auto Kit works alone mode 3. Starting one work cycle
⑫ STOP	1. On when EMG STOP pressed. 2. When complete a band circling operation continuously
⑬ BAND	1. On when there is no band supply . 2. On when there is a joint seam in band 3. On when feeding fails
⑭ COUNTER	On when reaching the target value.

3. Panel of Sewing Machine
Please refer to the operation
instruction of the sewing
machine.



FEEDING THE BAND

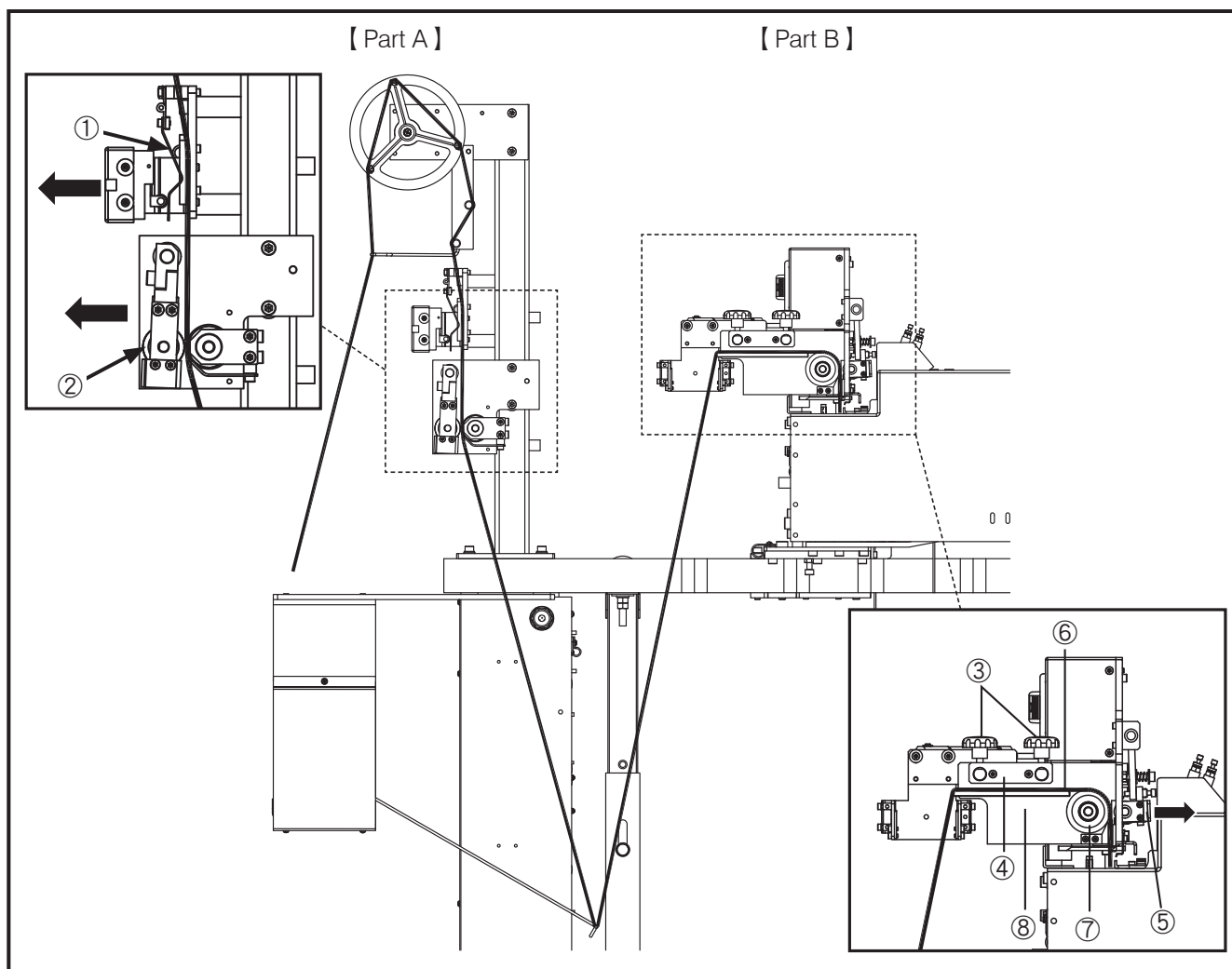
※ **Caution:** a band with wrinkle or rumple may cause quality issue or even damage to the machine.

Part A.

Open the induce plate ① and supporting roller ② . Insert the band through. (*1)

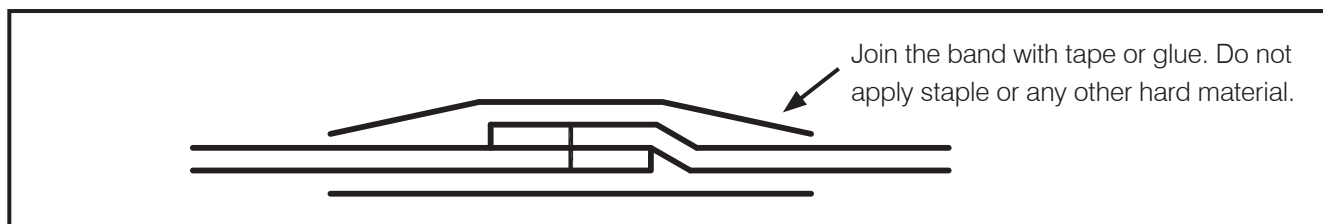
Part B.

1. Insert the band onto the table ④ and through the rail ⑥ , adjust the knobs ③ to set the band width.
2. Release the supporting roller ⑤ to allow the band going into the rollers ⑦ . (*2) Check if the band aligns with the wall ⑧ closely. Then turn on the power. (p.10)



Note: *1: To join bands for feeding, please refer to illustration as below.

*2: It is good enough as long as the front end of the band is clamped. No need to force in.

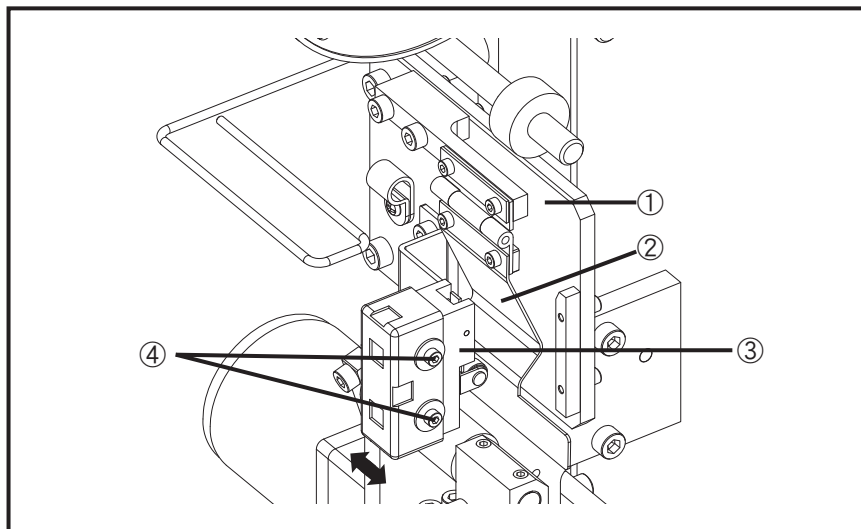


SETTING THE BAND

It is necessary to adjust for the 1st work or when working with bands with different width or thickness.

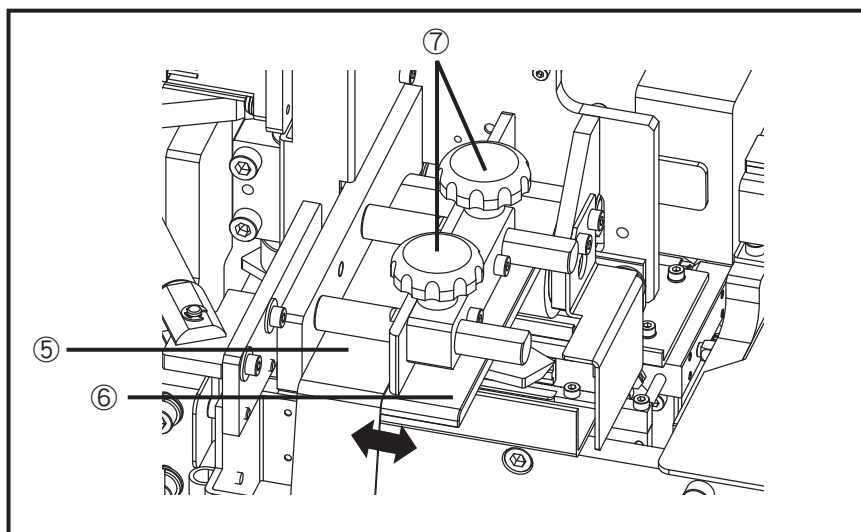
1. To adjust induce plate sensing range:

When the band goes through the wall ① and the induce plate ②, you may need to change the limit switch sensing distance accordingly by adjusting the distance between the inducing plate ② and the limit switch ③. Loosen the screws on the limit switch ④, move the limit switch to adjust the limit switch active range. (about 2 times of the band thickness)



2. To adjust the rail:

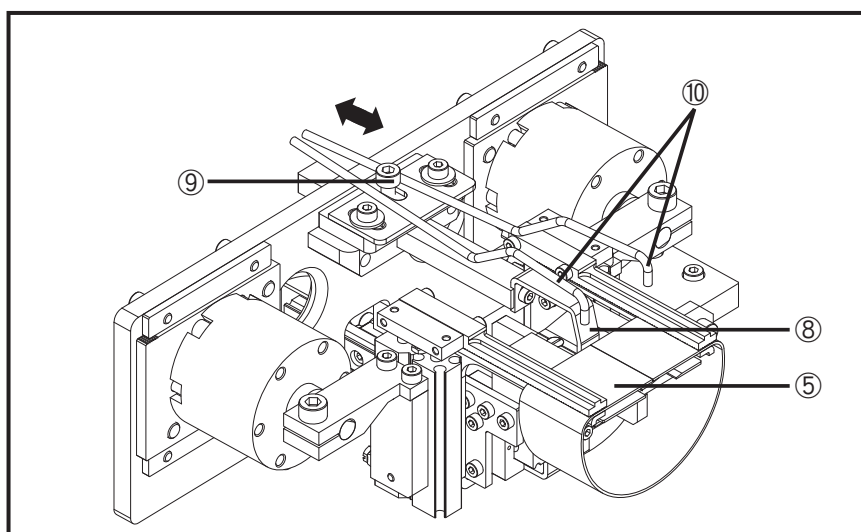
Loosen the 2 knobs ⑦, the distance should be good enough for the band to go through (1mm wider than the band width). Tighten the knobs ⑦ when finish.



3. To adjust the ready for sewing position

The edge of the band ⑤ should align with the push pin ⑧. Loosen the screw ⑨ and adjust the push pin to the edge of the band. Tighten screw ⑨.

4. If you find the band curling, adjust the direction of air blower ⑩ until the band ⑤ is flat and even.

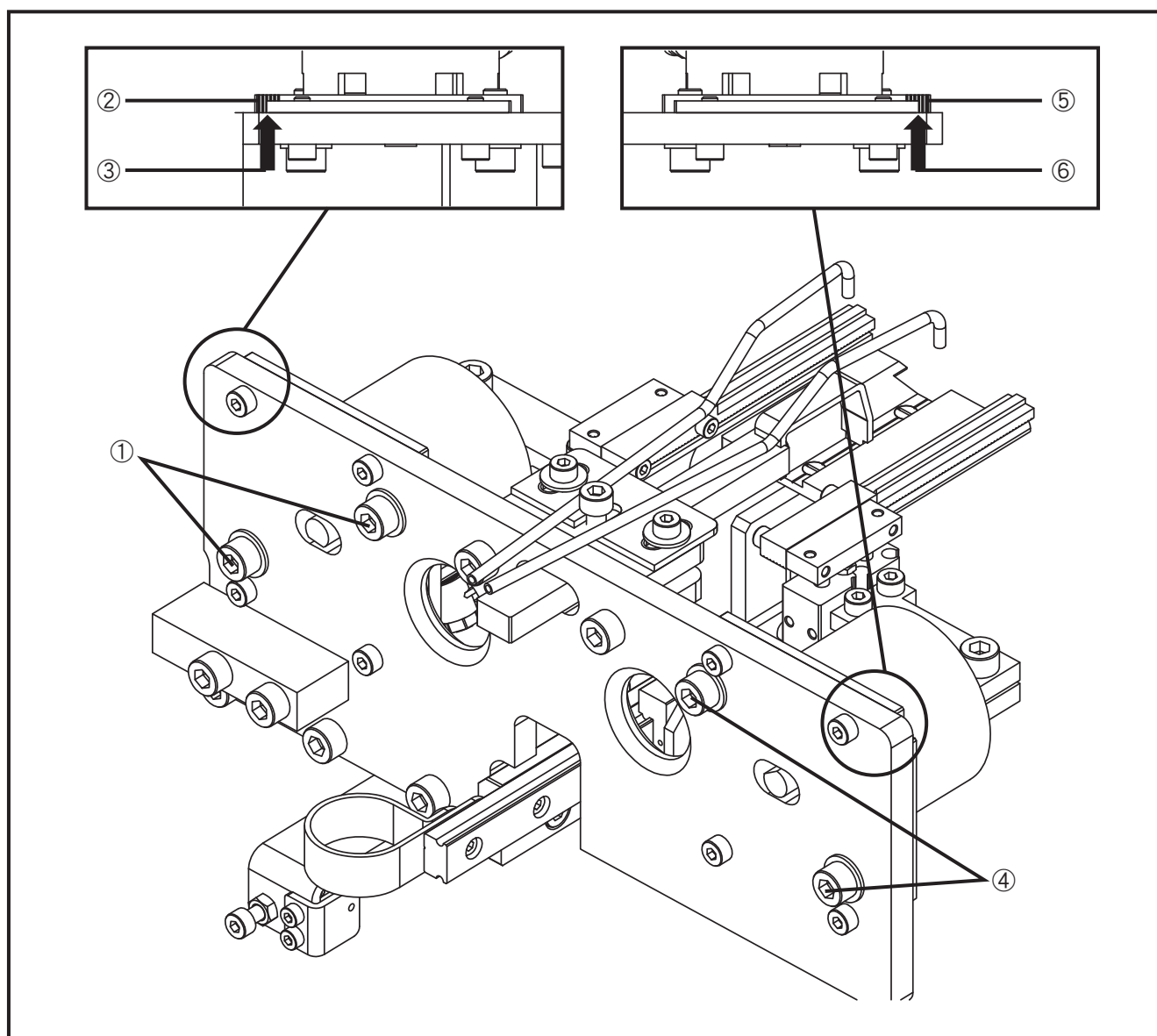


SETTING THE BUTTED SEAM AND OVERLAPPING AREA

Part 1: Initial Mechanical Setting (Preset done by maker. No need to apply step 1~5 unless a significant overlapping difference, i.e. greater than 11mm).

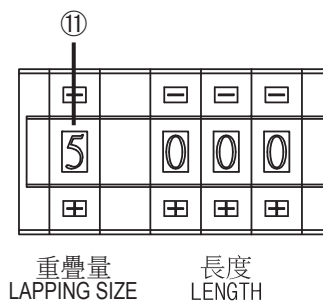
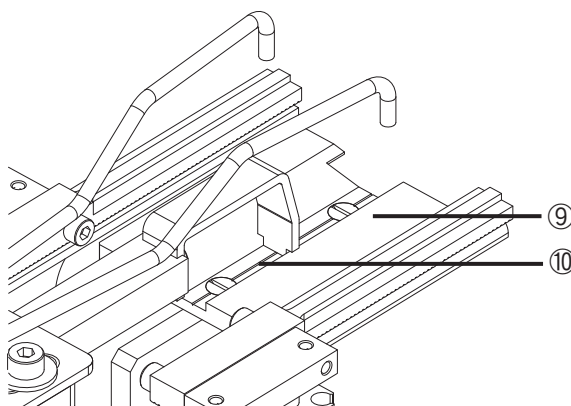
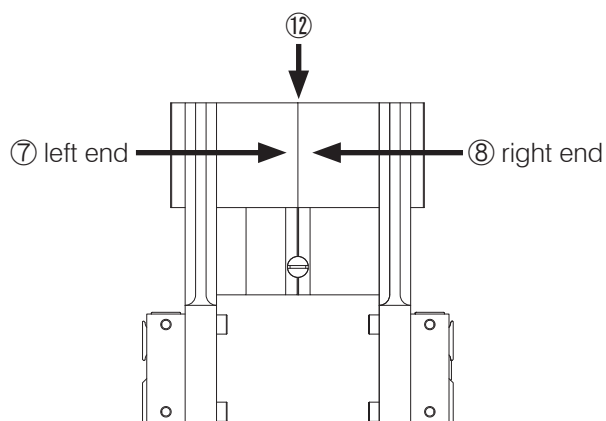
For general operation setting, simply go to control panel setting (Part 2)

1. Loosen screw ①, move the left cylinder seat ② position to the desired position. (default value set to the 3rd red mark ③).
2. Loosen screw ①, move the right cylinder seat ⑤ position to the desired position. (default value set to the 3rd red mark ⑥).
3. Turn on the machine, and press START.
4. The 2 ends of the band (⑥ / ⑦) should meet at the center red line ⑨ of the feeding plate. If not, repeat step 1 and 2 to adjust accordingly.
5. All the mechanical parts are set and tested in our factory before delivery.



Part 2: Overlapping setting for operation.

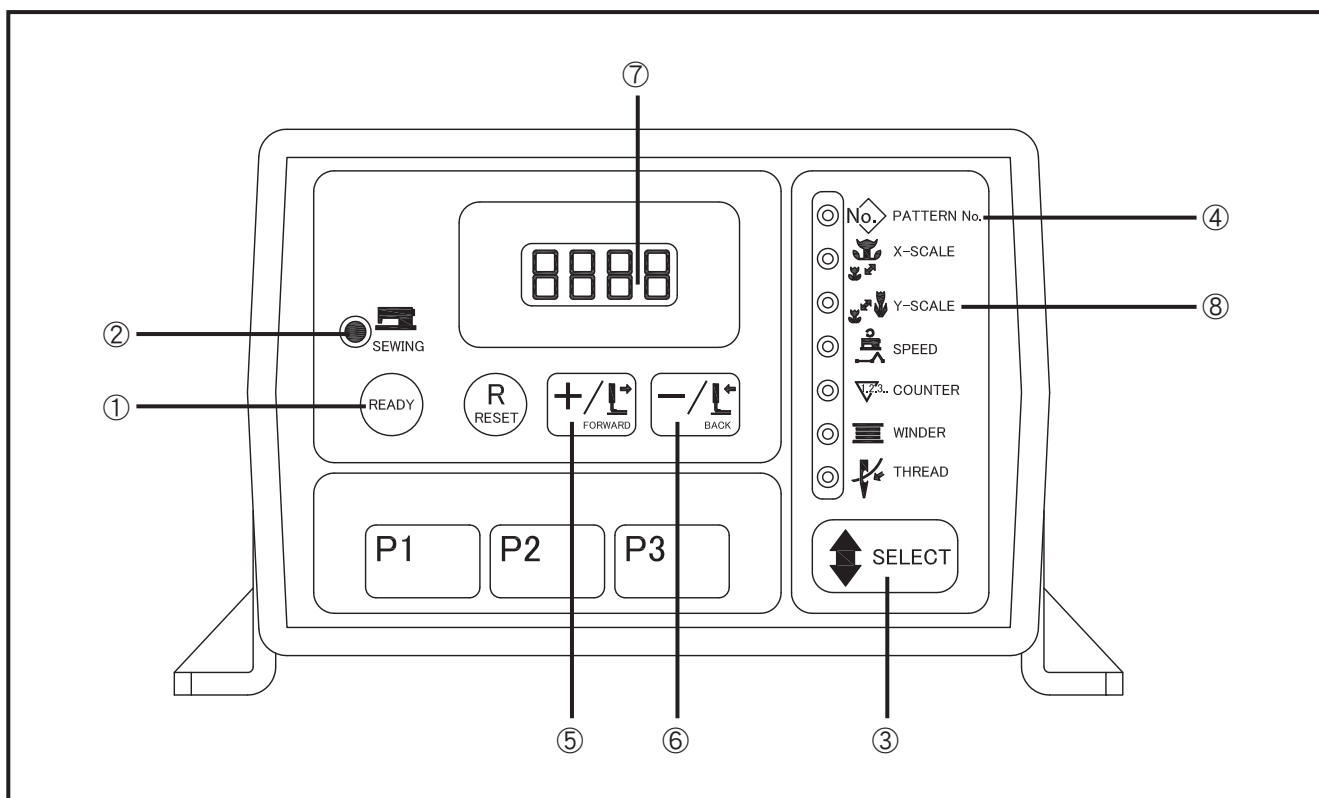
6. When band circling is ready for sewing, the band's left end ⑦ and right end ⑧ should align with the red line ⑩ on the feeding plate ⑨.
7. On the control panel, the OVERLAPPING setting ⑪ refers to how the 2 ends of the band join together. In general, the setting value "5" means 2 ends join even at the center red line ⑫.
8. To increase the overlapping area, increase setting value of OVERLAPPING ⑪ (max 9). To decrease the overlapping area or to widen the gap between 2 ends, decrease the value (min 1).



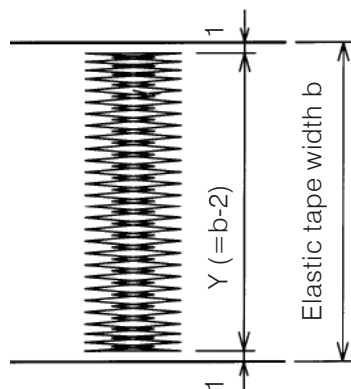
AUTO MODE

Part 1: Setting Sewing Pattern:

1. Turn on the power.
2. On the sewing machine control panel, press READY ① , and then the SEWING indicator ② goes off.
3. Press SELECT ③ to select PATTERN NO. ④ .
Press +/FORWARD ⑤ or -/BACKWARD ⑥ to select the pattern. Selection shown on the display ⑦ .
4. Press SELECT ③ to select Y-SCALE ⑧ .
Press +/FORWARD ⑤ or -/BACKWARD ⑥ to adjust the Y ratio. Selection shown on the display ⑦ . Adjust the ratio according to the final output.
5. Press READY ① again, and then the SEWING ② should come ON.



Sewing Pattern List



No.	Stitch diagram	Number of stitches	Sewing size	
			Length width	Cross width
1		33	0	20
2		39	0	25
3		45	0	30
4		51	0	35
5		57	0	40
6		63	0	45
7		69	0	50
8		75	0	55
11		38	3	20
12		46	3	25
13		52	3	30
14		60	3	35
15		66	3	40
16		72	3	45
17		80	3	50
18		86	3	55
21		57	5.2	20
22		69	5.2	25
23		77	5.2	30
24		88	5.2	35
25		96	5.2	40
26		109	5.2	45
27		113	5.2	50
28		125	5.2	55

No.	Stitch diagram	Number of stitches	Sewing size	
			Length width	Cross width
31		71	6.4	20
32		87	6.4	25
33		98	6.4	30
34		111	6.4	35
35		127	6.4	40
36		139	6.4	45
37		151	6.4	50
38		163	6.4	55
41		172	9	20
42		212	9	25
43		252	9	30
44		284	9	35
45		324	9	40
46		356	9	45
47		396	9	50
48		428	9	55

1. Example of Y-SCALE setting

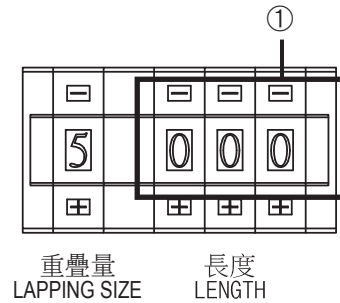
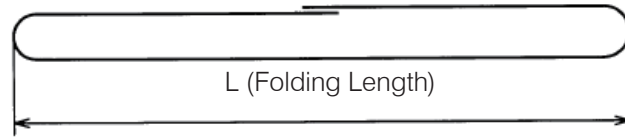
To work with a band width 34mm, applying pattern listed above

(1) Select pattern No. 35.

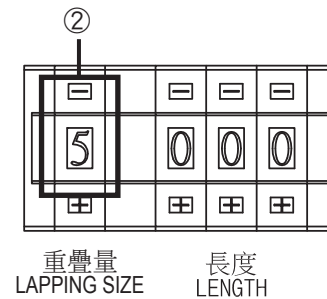
(2) ???????

Part 2: Start working with Auto Mode:

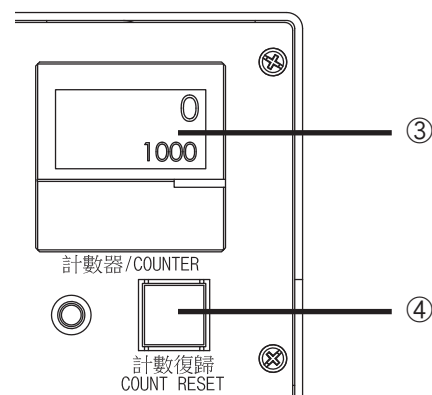
1. Feed the band (refer to the chapter of Feeding The Band)
2. Set the band length.
 - (1) Go the LENGTH ① on the control panel for setting. The effective setting range is 150~990 (mm). Value under 150 is taken as 150.
Note: the value is the folding length only. The total length is Lx2 mm.
 - (2) The LENGTH setting is only a reference. The actual length may be different due to the material or quality of the band. You can adjust the setting based on the difference.



3. Set the overlapping area.
 - (1) Go to the OVERLAP ② on the control panel.
 - (2) Input the value for overlapping setting. The default reference should be "5". The bigger the input value, the greater the overlapping area.

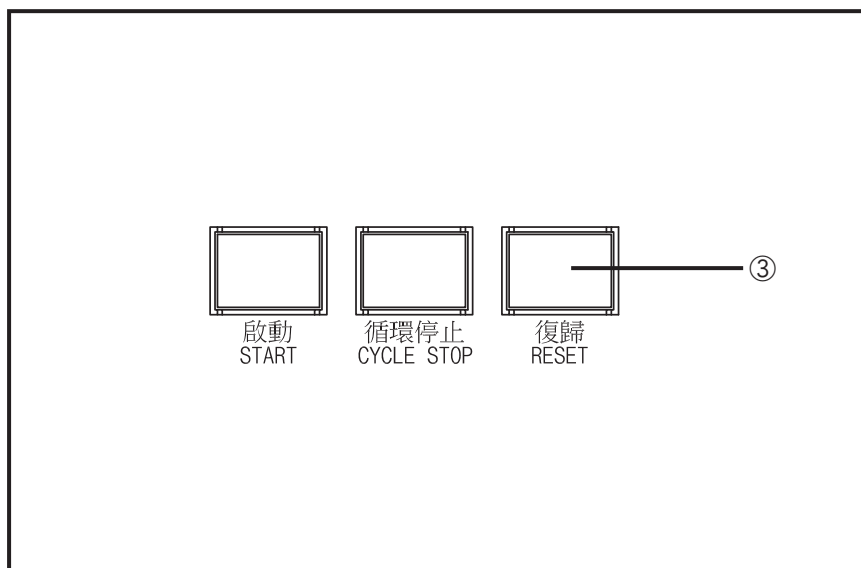


4. Set the work piece counter.
 - (1) Go to the COUNTER ③ on the control panel.
 - (2) Press COUNT RESET ④ first. Then input the value for the work piece you want to complete in this operation.
 - (3) When the work output reaches the number you input, the machine stops.



5. Reset the starting position of the band. (when there is an interruption.)

- (1) The setting of band starting position will run automatically when you turn on the power first time.
- (2) In case of reloading the band or resuming from an interruption, to make sure the circling band length is correct, press and hold RESET ③ for 2~3 seconds. The machine will cut off a short band and to restart the measuring.

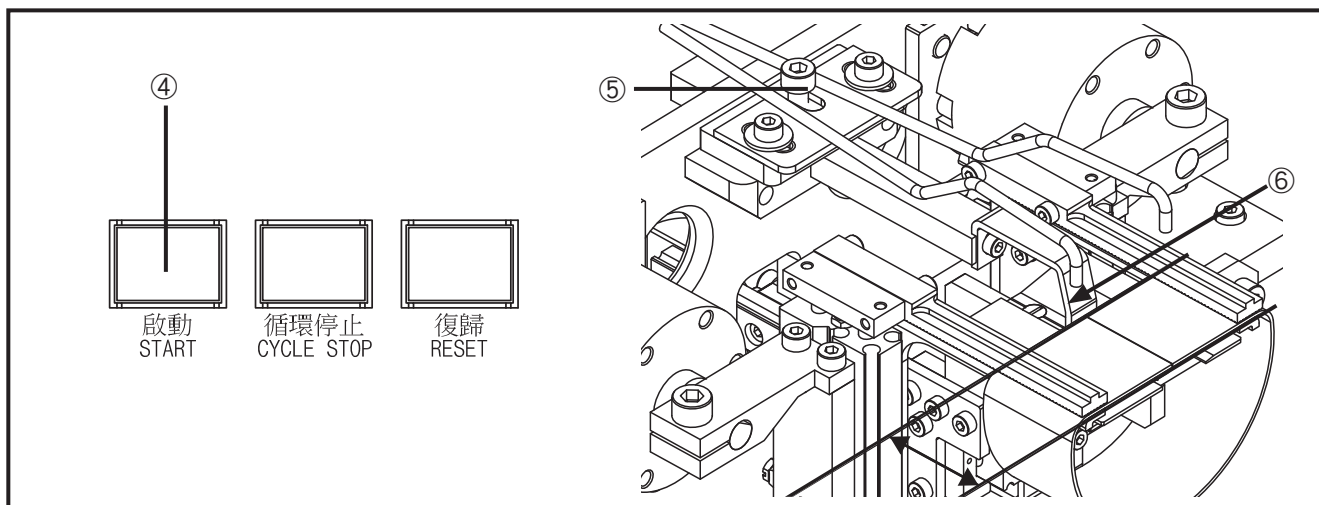


6. Auto (Continuous) operation.

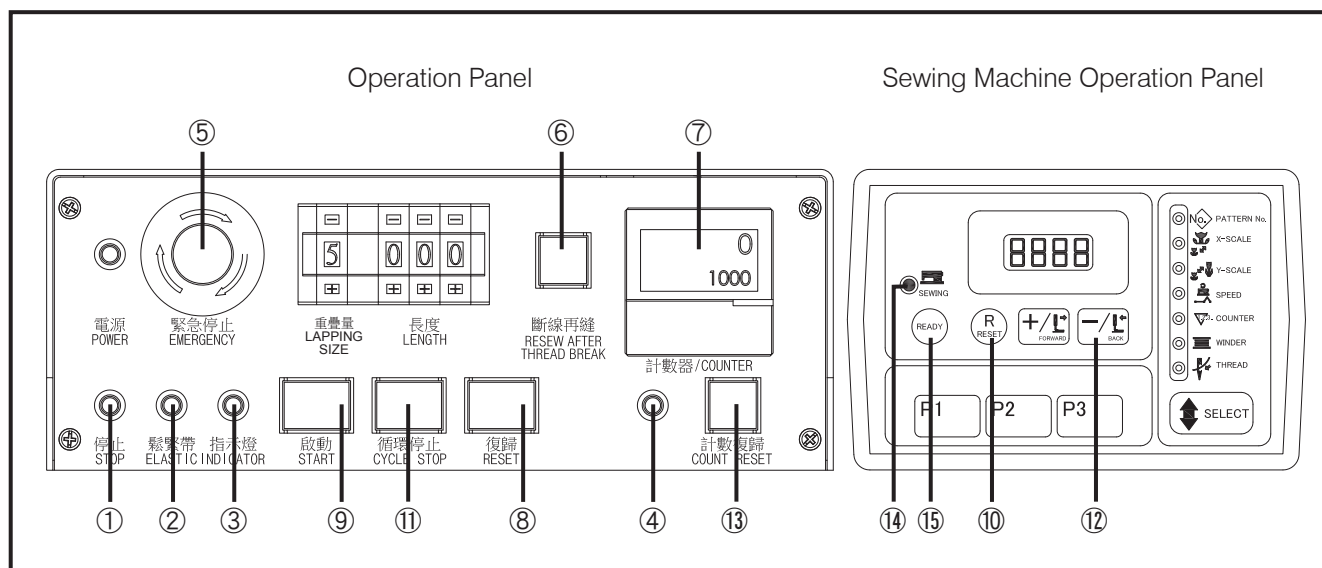
- (1) Press START ④ . The machine will pull out the band and form a circle to the ready for sewing position. Then it pauses.
- (2) Check if the overlapping matches the setting you have done previously.
- (3) Press START ④ again to complete the sewing. The machine will run continuously until it completes the target quantity.
- (4) Press CYCLE STOP ⑤ , the machine will stop after the current cycle completes.
- (5) To stop the operation immediately, press EMERGENCY ⑥ . The indicator STOP ⑦ will be on. To resume the operation, please refer to the chapter TROUBLE SHOOTING.

7. Single Cycle operation.

- (1) Press START ④ . The machine will pull out the band and form a circle to the ready for sewing position. Then it pauses.
- (2) Check if the overlapping matches the setting you have done previously.
- (3) Press CYCLE STOP ⑤ to complete the work cycle. And the machine stops later.



TROUBLE SHOOTING



Indicator	Status	Description	Solution
STOP ①	ON	EMERGENCY ⑤ pressed	A1
BAND ②	ON	1. Band runs out. 2. Bad joint detected	A2 A3
	Flashing	1. Feeding malfunctions 2. Problem other than devices, i.e. band falls off.	A4 A5
COUNTER ④	ON	Work reaches the setting target	A6
STOP ① THREAD ③	Both Flashing	Sewing machine is not ready.	A7
STOP ① BAND ②	Both Flashing	Limit Switch malfunctions	A8

Solution A1: To disarm Emergency

1. Release EMERGENCY stop ⑤ by rotating and pulling up.
2. Press RESET ⑧ to turn off indicator STOP ① .
3. Press START ⑨ to restart the work, or to resume the work from an interruption.
4. Pressing EMERGENCY stop ⑤ when:
 - 4-1. Power ON, machine is in ready or stand-by situation. Follow step 1~3 to restart.
 - 4-2. Band is circled and ready for sewing: Sewing interrupts and stops. Error code E5 shows on sewing machine panel. Following step 1~2 and go to the sewing machine panel.
 - (1) Press R (RESET) ⑩ to cut the thread.
 - (2) Press R (RESET) ⑩ again to remove the defective band.
 - (3) Follow step 3 to resume the operation.

Solution A2: To reload the band

1. Take off the remaining band. Do not press RESET beforehand.
2. Press RESET ⑧ to set the machine back to origin position.
3. Reload the band. The indicator BAND ② should go off then.
4. Press and hold RESET ⑧ to allow the machine to detect and set the starting position.
5. Press START ⑨ to restart the operation.

Solution A3: To offset the joint jam

1. Cut off the joint area.
2. Press RESET ⑧ to disarm the indicator BAND ② .
3. Press START ⑨ to complete the work with the remaining band before the joint.
4. The machine will stop and BAND ② goes ON because running out of band. Follow solution A2 to continue the operation.

Solution A4: To offset the Feeding Malfunction.

1. Remove the jammed band.
2. Reload the band.
3. Press RESET ⑧ to set the machine to origin position. The indicator BAND ② goes OFF.
4. Press and hold RESET ⑧ to allow the machine to detect and set the starting position.
5. Press START ⑨ to restart the operation.

Solution A5: To disarm feeding problem other than devices.

1. Fix the falling and other issue. Reload the band to the proper position.
2. Follow solution A4 to resume the operation.

Solution A6: To reset the counter

1. Press COUNT RESET ⑬ . Indicator COUNTER ④ goes OFF.
2. Press START ⑨ to restart the operation.

Solution A7: To make the machine in ready.

1. On the sewing machine panel, when changing the setting, if the SEWING ⑭ is not ON, press READY ⑮ to set the sewing machine in ready condition.
2. Activate the Under Thread Counter on the sewing machine panel. When it sets to 0, the machine will pause (refer to page 44 in the sewing machine operation manual). Exchange the under thread and press R (RESET) ⑩ .
3. Press RESET ⑧ . The indicator STOP ① will go OFF.
4. Press START ⑨ to restart.

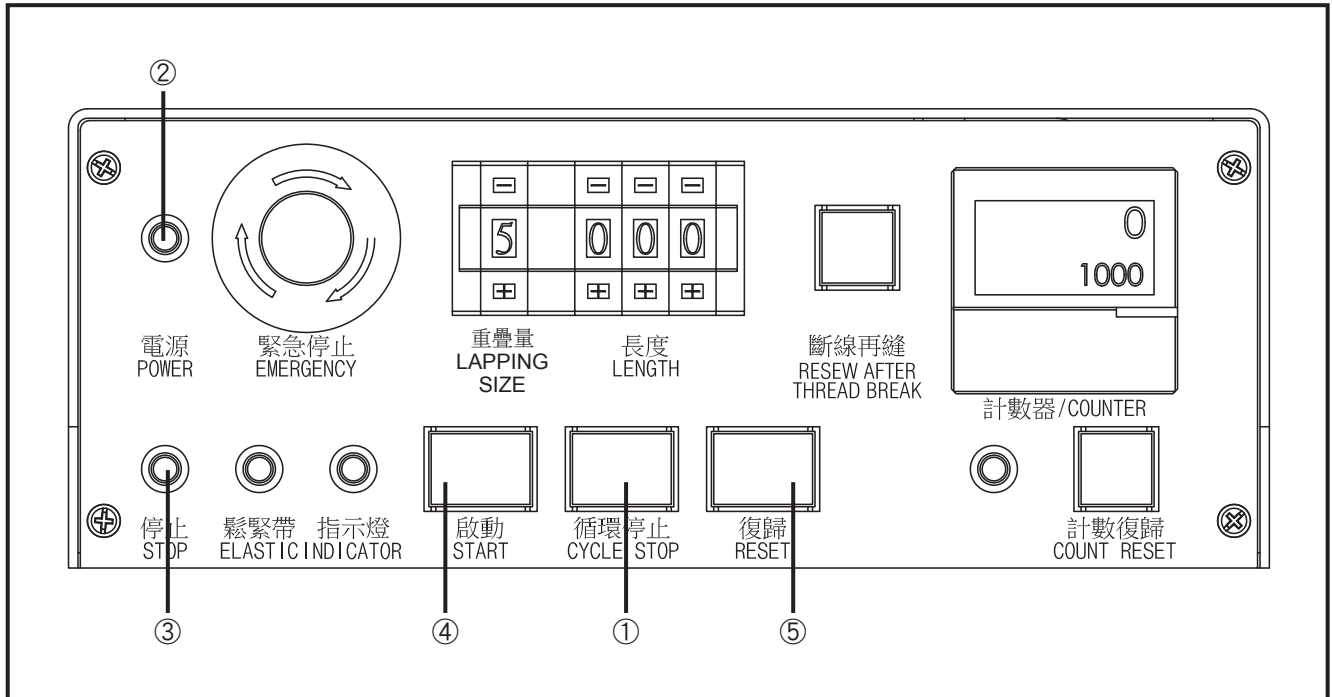
Solution A8: To fix the Limit Switch malfunctions.

1. Disconnect the air supply.
2. Turn off the main power.
3. Check the Limit Switch.

There are 2 limit switches on the feeding moving cylinder and puller hook individually.

Turn off the valve, and turn on the power. Push or pull the cylinder and hook to check if the indicator of the limit switch goes ON. Adjust the position of those two devices and check the limit switch again. If the devices are in position, but the indicator does not go ON, then replace a new limit switch.

TESTING MODE



A. To complete one work cycle.

To make sure all the movement timing and the devices' positions.

1. Press and hold CYCLE STOP ①, and turn on the power at the same time.
2. Check if the indicator POWER ② and STOP ③ are blinking together.
3. Press CYCLE STOP ①. The machine should stop at the very beginning position.
4. Press START ④ to go step by step. The machine will complete the circling and get to the ready for sewing position.
5. Check the band circling, press CYCLE STOP ① to deliver the band into the sewing area.
Press RESET ⑤ to abort the operation.
6. Press START ④ to complete the sewing step by step. Machine goes back to ready position when it completes.
To continue the operation, go back to step 3.

B. Sewing Machine runs solely.

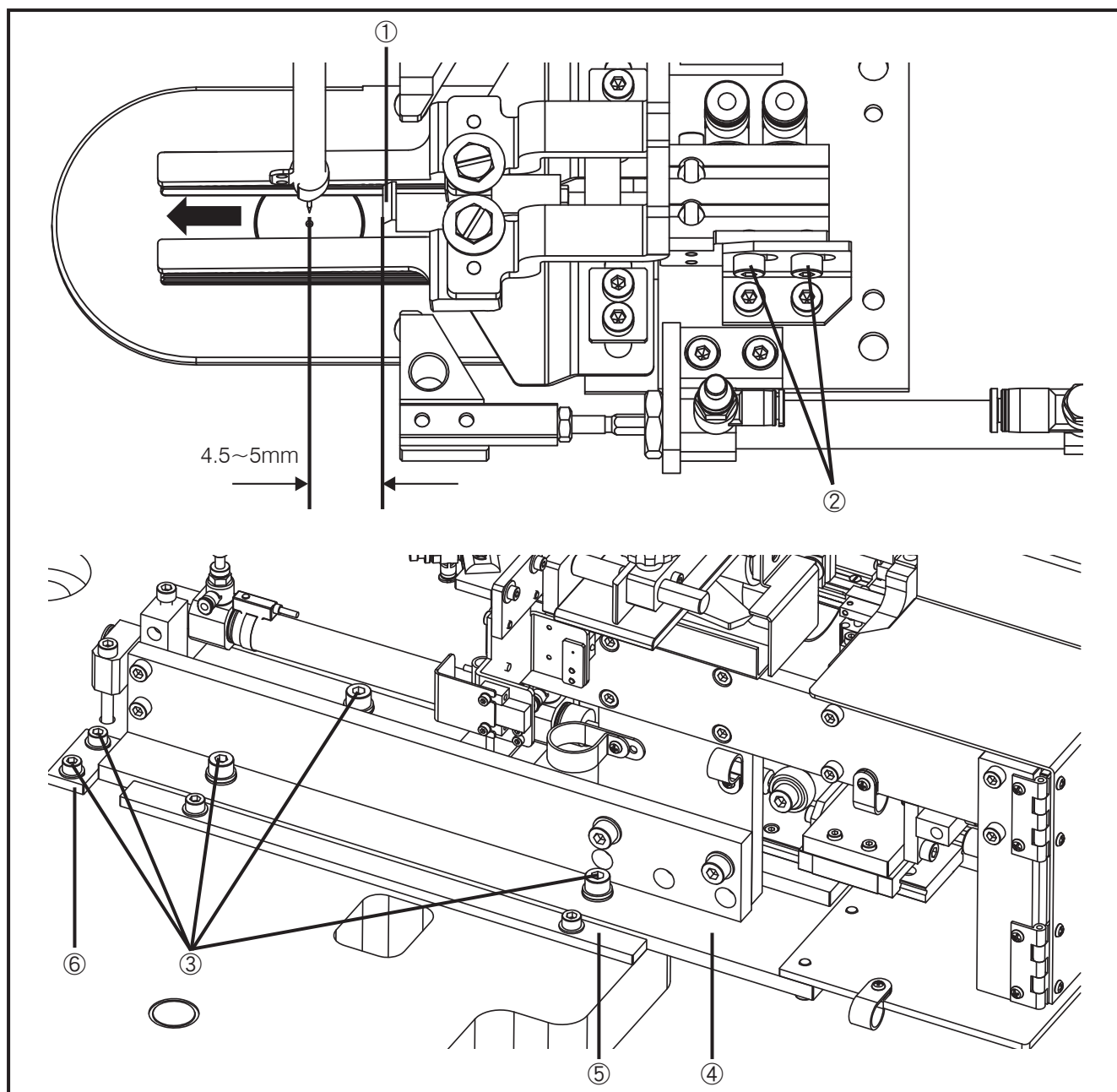
Machine stops while only the sewing machine runs alone.

1. Press START ④ and turn on the power at the same time.
2. Check if the POWER ② is blinking.
3. Feed in the band manually to the presser foot for trial sewing.
4. Press RESET ⑤ to lower the presser foot. Press RESET ⑤ again to lift up the presser foot.
5. Press START ④ to start operation.

SERVICE & MAINTENANCE

A. Band & Band Feeder Position

1. Disconnect the air supply. Loosen the Screw ② to adjust the distance between Band Locator ① and Needle Holder to be 4.5 ~ 5mm.
2. When the band reaches the presser foot, the inner side of the band should align with the Locator ① . Refer to Testing Mode to verify the position. Check if there is a gap (less than 0.5mm) between the circled band and locator ① .
3. When the Locator ① pressed and holds the band, the work will be pulled up, causing a breaking thread or poor sewing. You may need to adjust the Band Feeder position.
4. To adjust the Band Feeder: Loosen 5 screws ③ . Move the Base ④ along with the Inductor ⑤ . After the adjustment, tighten the 3 screws on the Base ④ . Fix the Rear Board ⑥ of the Band Feeder onto the Base ④



B. Correct the variance of band joining.

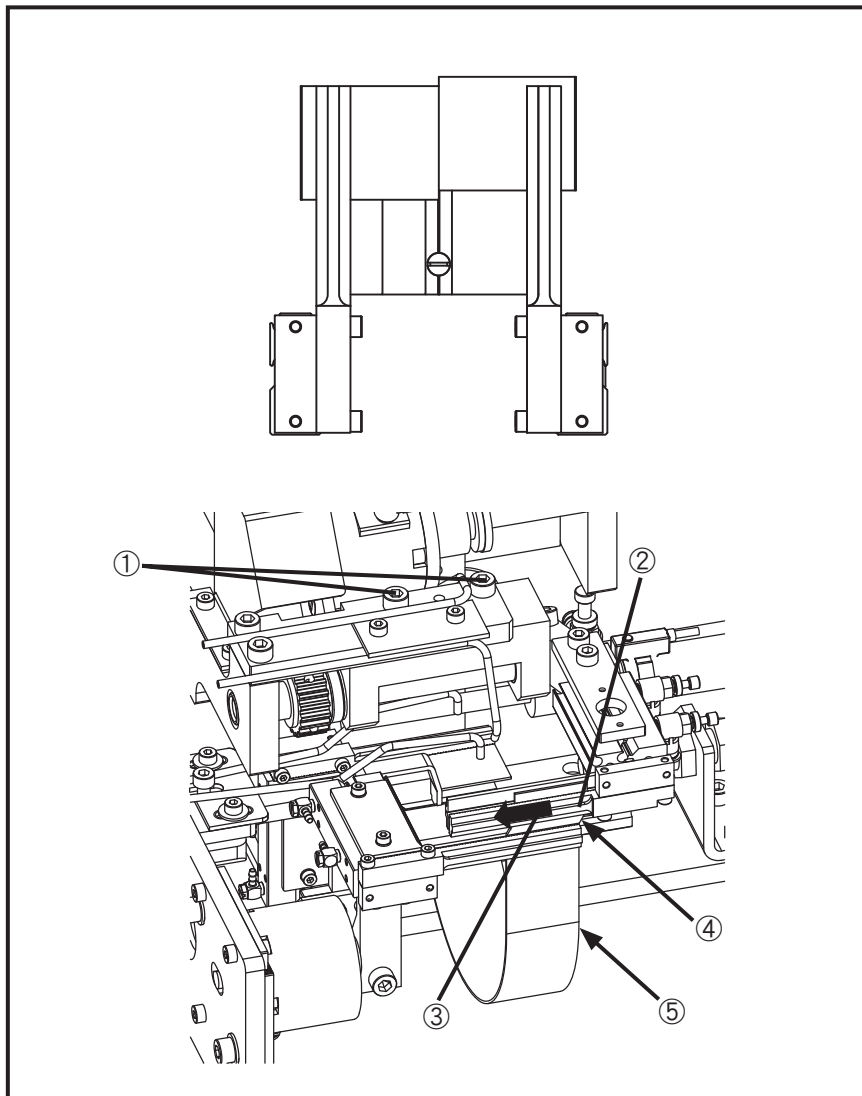
1. When the right end of the circled band strays inward. (as shown below in the left):

Loosen screw ① . Move the Band Clipper ② outward (direction 3).

2. When the right end of the circled band strays outward :

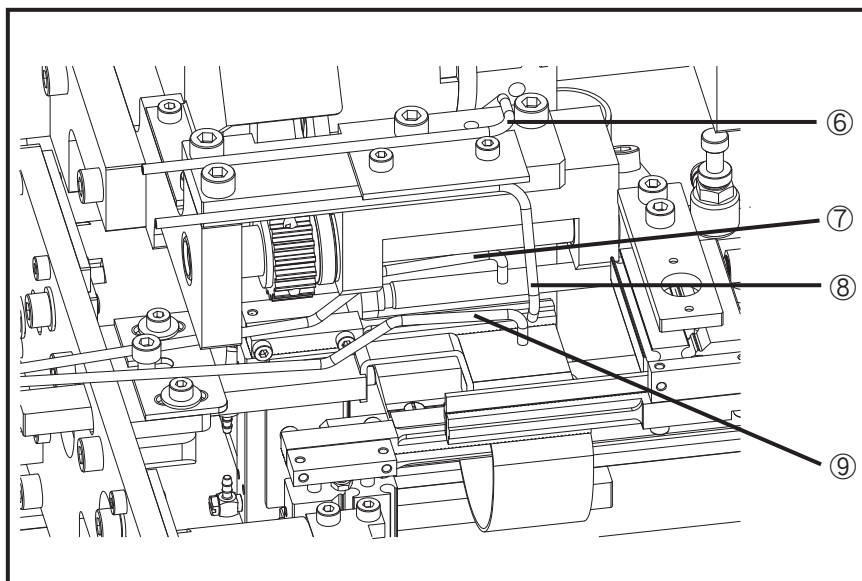
Loosen screw ① . Move the Band Clipper ② inward.

3. As shown below in the right, adjust the clipper position according to the deformation of the band joint ④ , ⑤ . Check from the side of the band.



C. Intensity of air blow

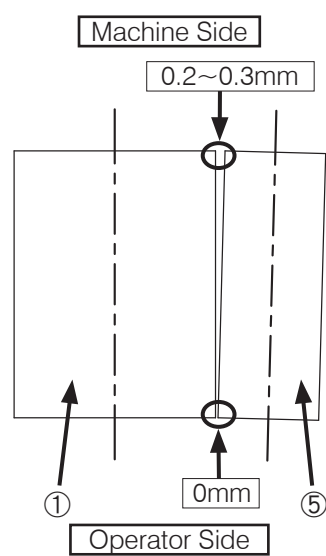
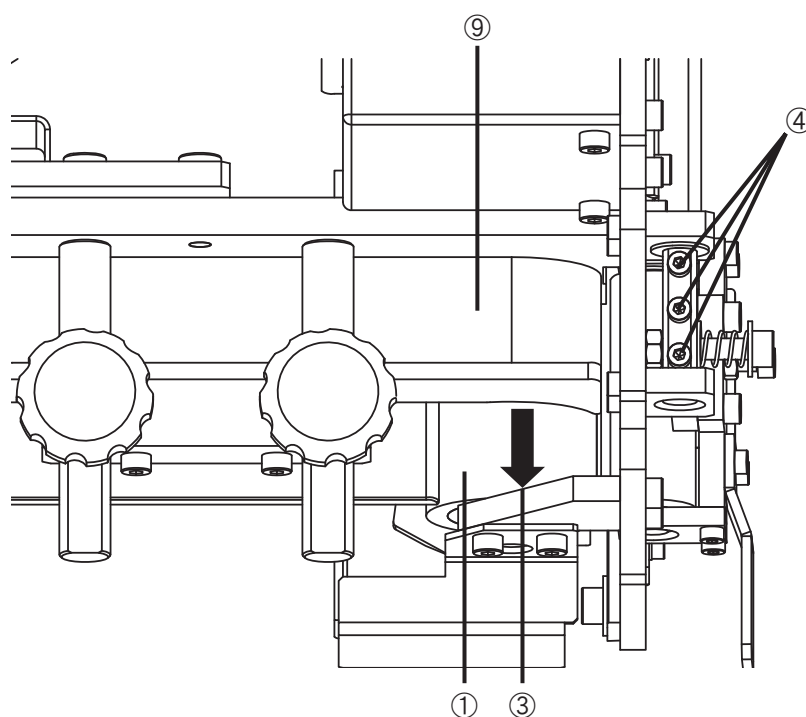
The intensity of air blower ⑥ ~ ⑨ varies according to the work request. Adjust the throttle valve individually if needed.



D. Feeding Roller

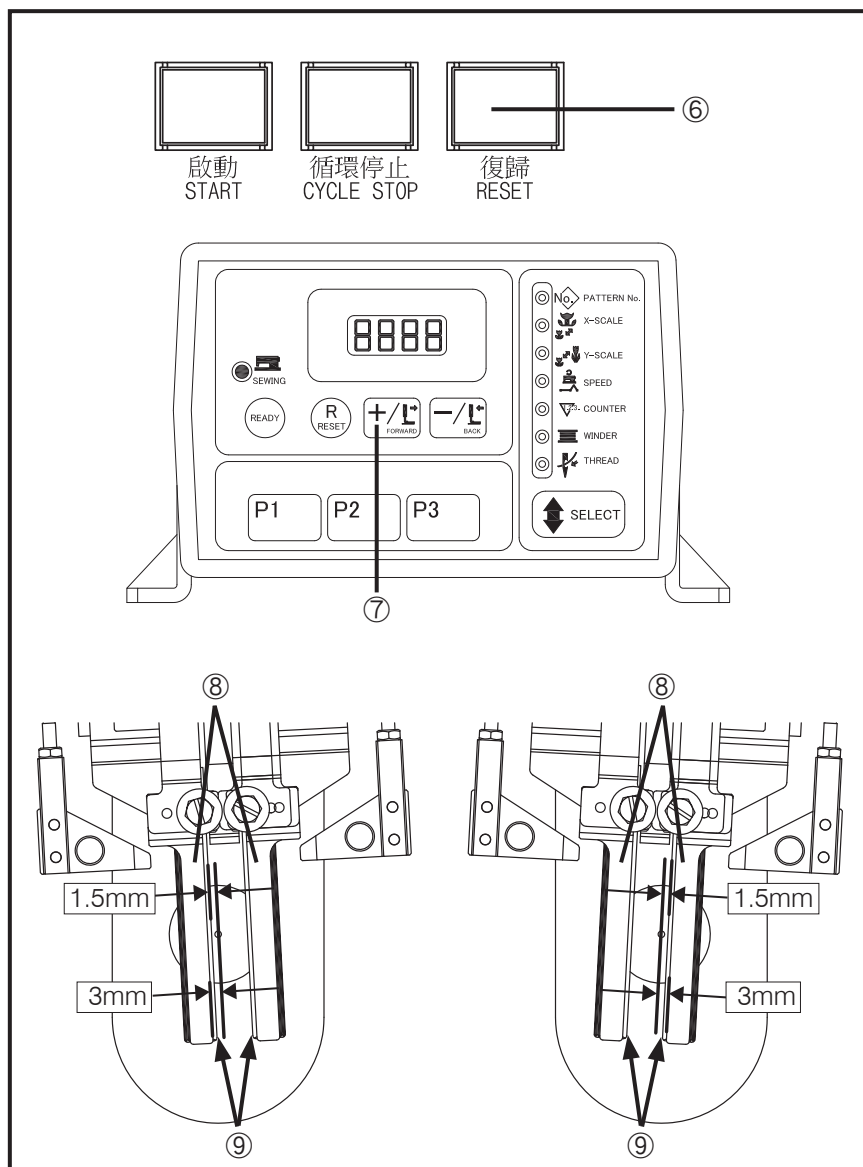
You need to adjust the Feeding Roller ① when the band on the feeding roller moves outward.

1. Loosen screws ④
2. Adjust the Aux Roller ⑤ . Refer to the illustration as shown in the right below.



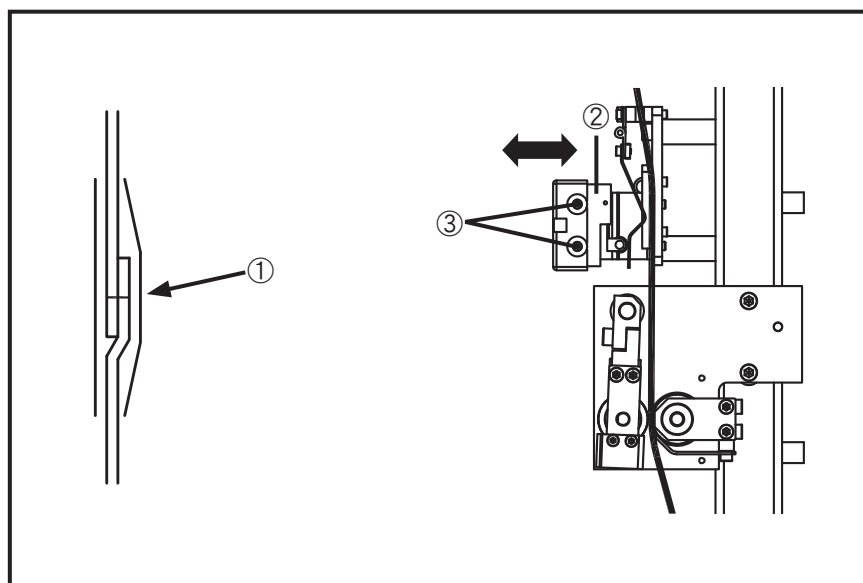
E. Presser Foot and Fabric Plate

1. Uninstall the needle. Enter the sewing machine solely running mode. (Testing Mode B)
2. Set sewing pattern
3. Press RESET ⑥ to lower the presser foot.
4. Press +/FORWARD ⑦. Move the Presser Foot ⑧ or Fabric Plate ⑨ to the limit of either side. Spare the distance between the Needle Center and Fabric Plate ⑨ to be 1.5mm.
5. The inner of Presser Foot ⑧ should be 1.5mm farther than the inner of Fabric Plate ⑨. (3mm from the needle center)
6. Adjust the Presser Foot and Fabric Plate individually.



F. Joint Seam Sensor

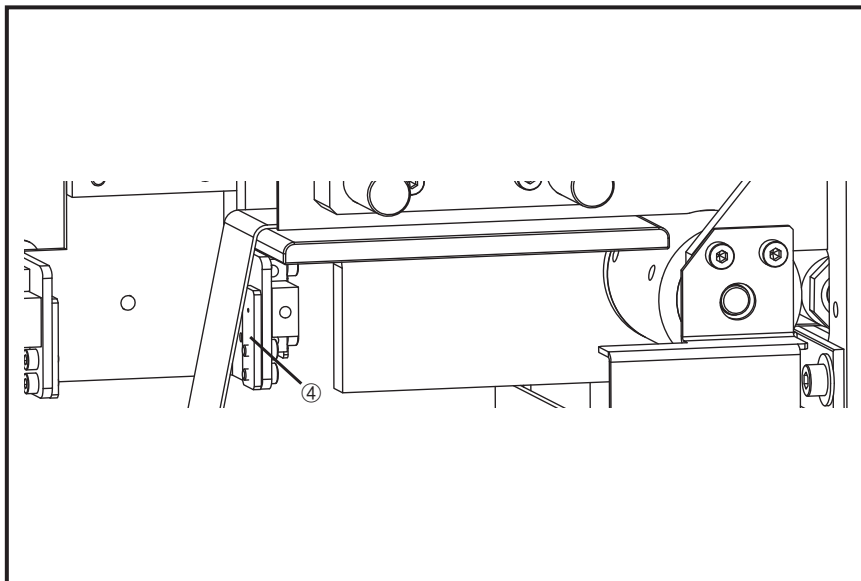
1. Loosen screws ③
2. When ① passes the joint seam sensor, adjust the switch ② horizontally until the sensor activated.



G. Band Remaining Sensor

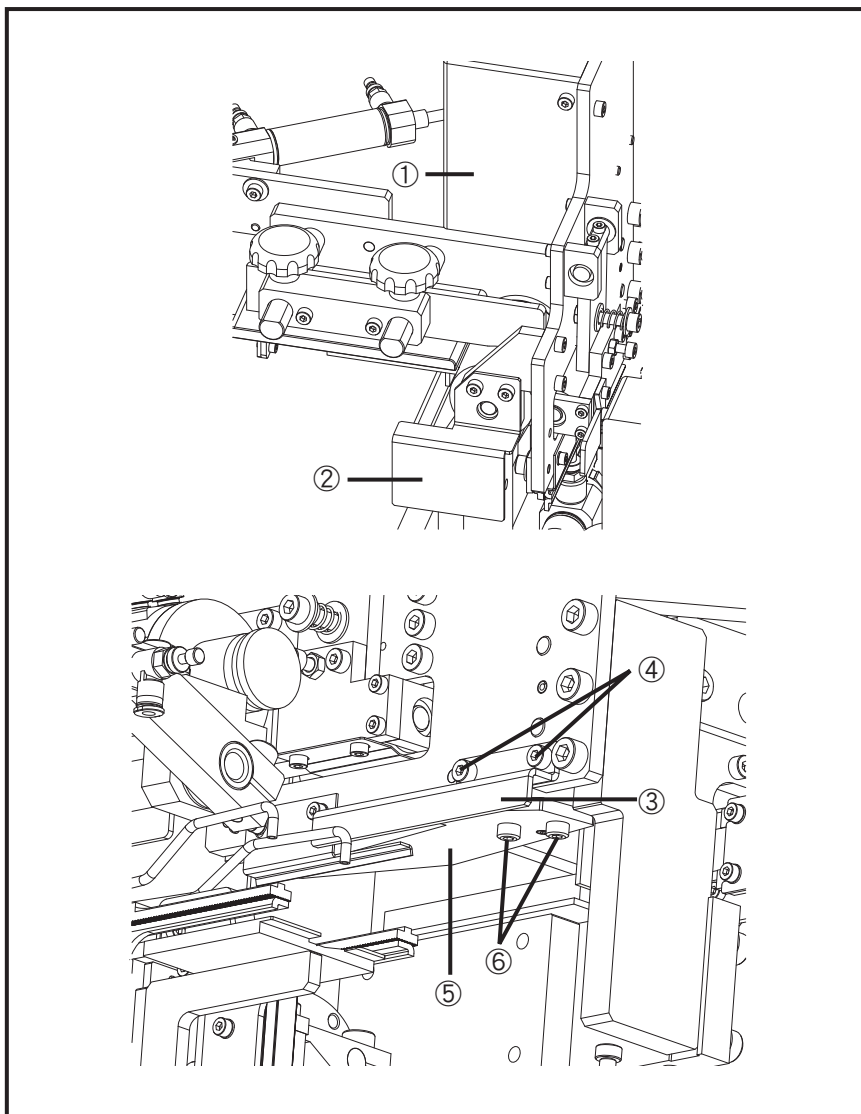
When the band material is white or thin enough to allow the light going through, there might be a mis-reading. Then you need to adjust the sensor accordingly.

1. Turn on the power.
2. Insert the test band into the sensor.
3. Relocate the sensor ④ (tilting) to lower the sensitivity.
4. Check the indicator of sensor (on the right of the sensor). The indicator goes ON when there is no band.

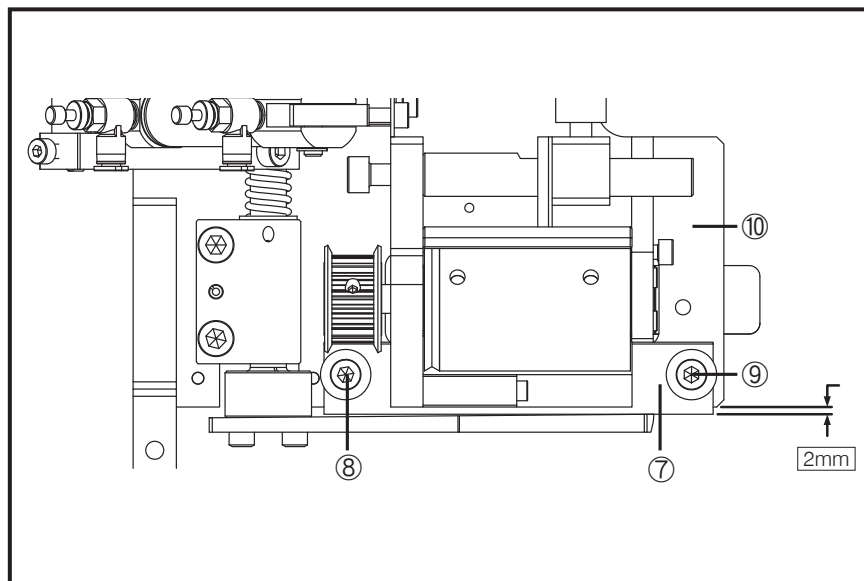


H. Cutter

1. Uninstall the cover ① and ② .
2. Loosen screw ④ to remove the cover ③ .
3. Remove the screws ⑥ to change the Moving Cutter ⑤ .

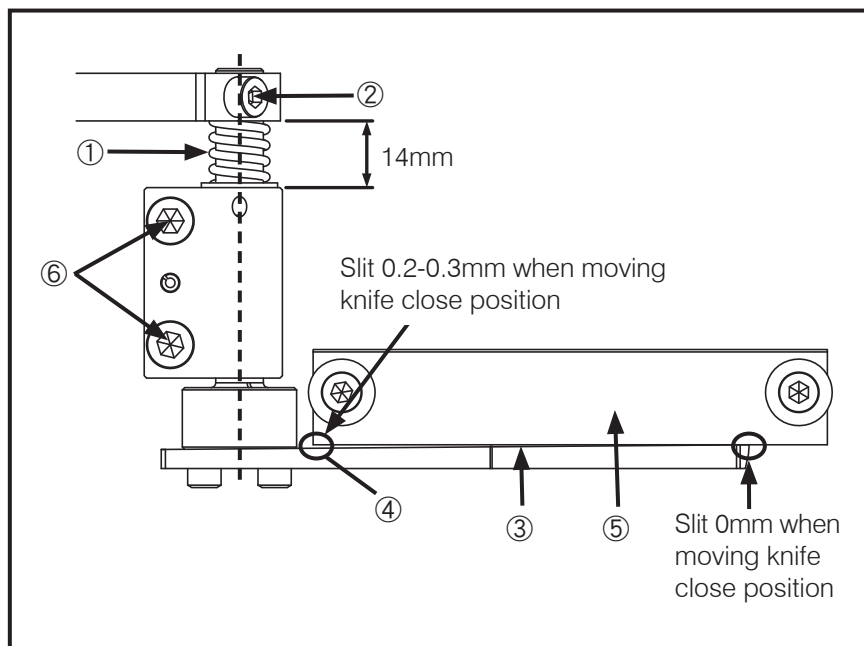


4. Remove the screws ⑧ , ⑨ to change the Fixed Cutter ⑦ .
5. The blade of Fixed Cutter ⑦ should be 2mm lower than BASE ⑩ .

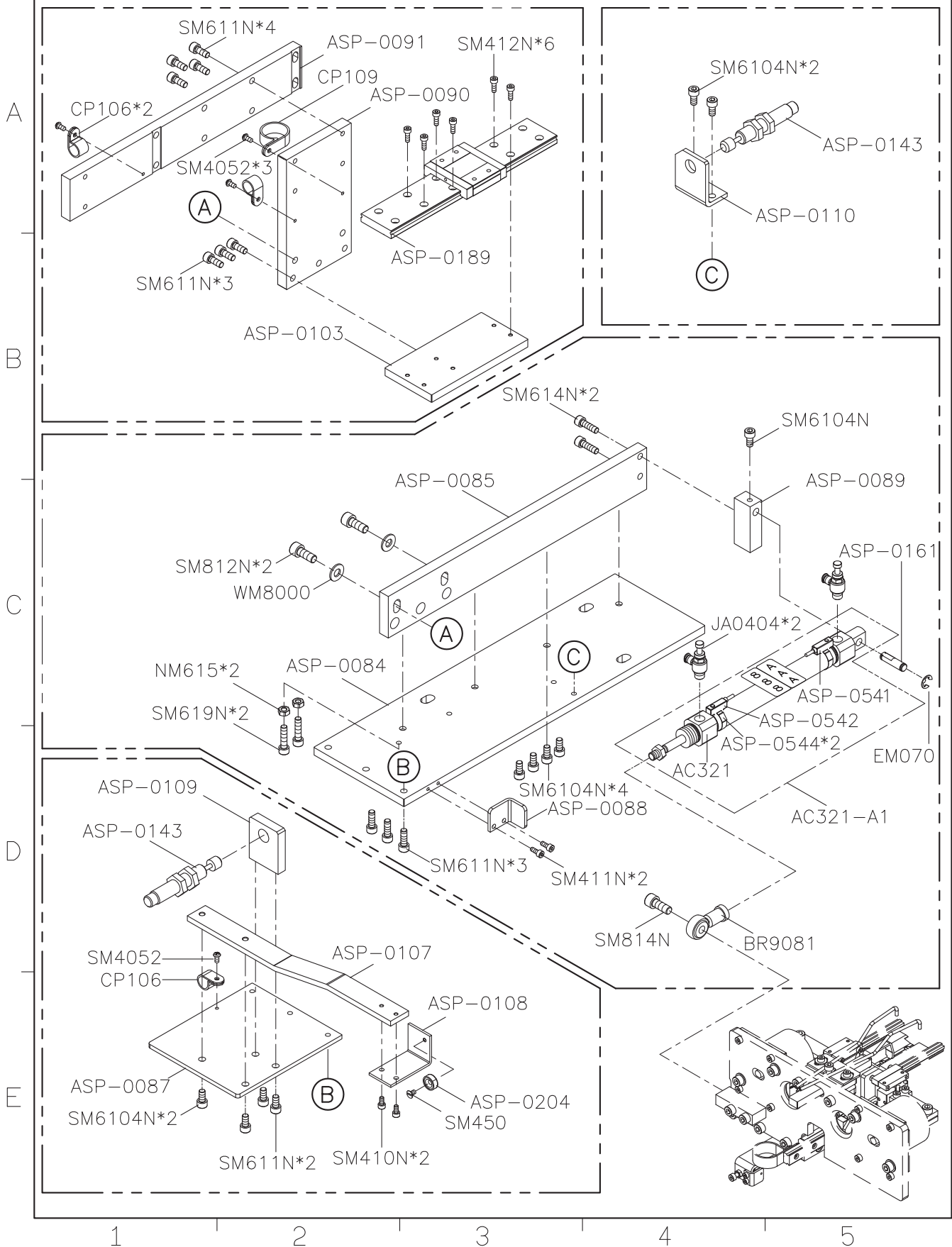


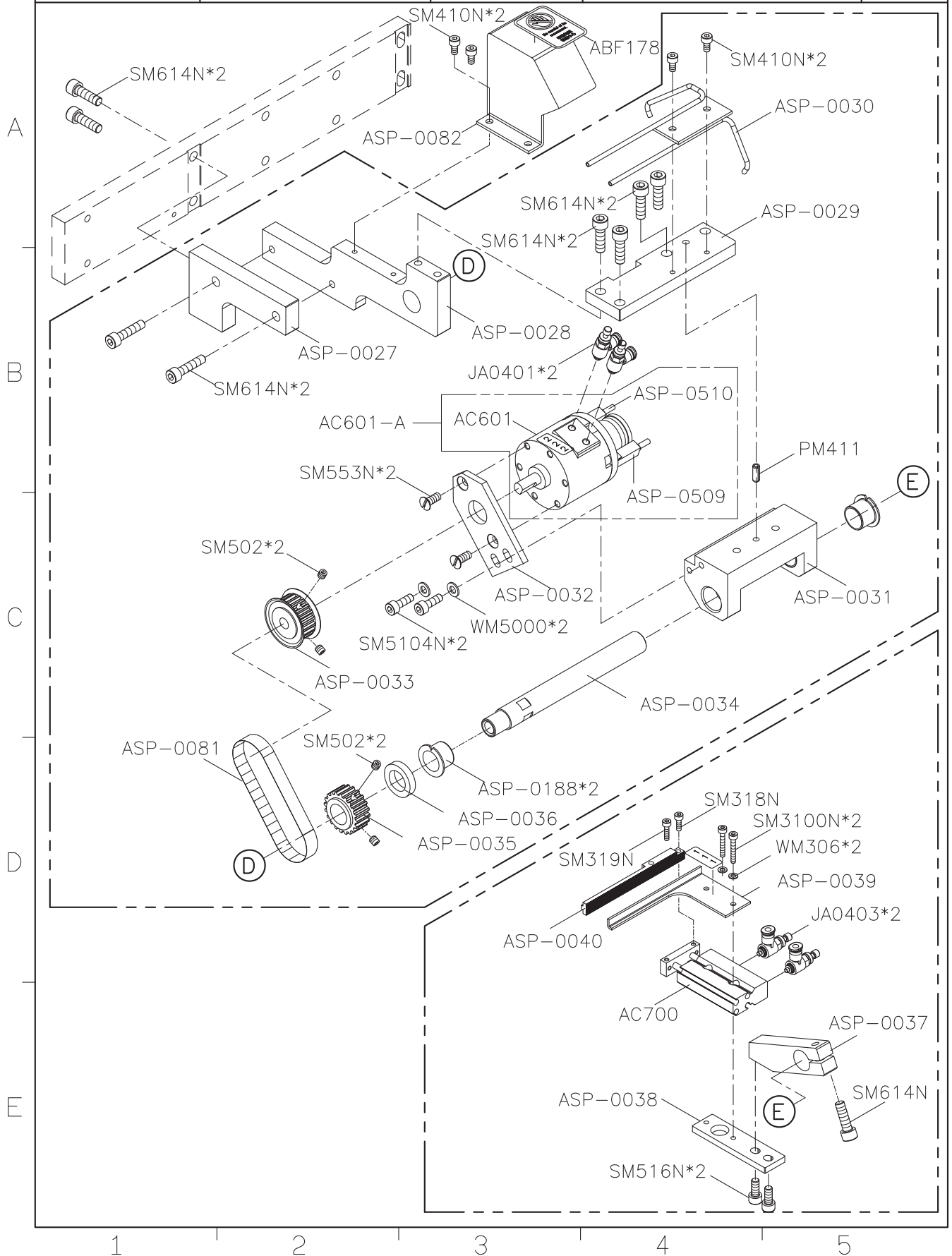
To adjust the cutters:

6. As shown below, the Steel Rod ① is 14mm. (loosen screw ② to adjust the meshing pressure.
7. Loosen screw ⑥ to adjust the Gap ④ between the Moving Cutter ③ and the Fixed Cutter to be 0.2 ~ 0.3mm.
8. If the Gap ④ is too big, it will cause poor cutting and damage the cutters.

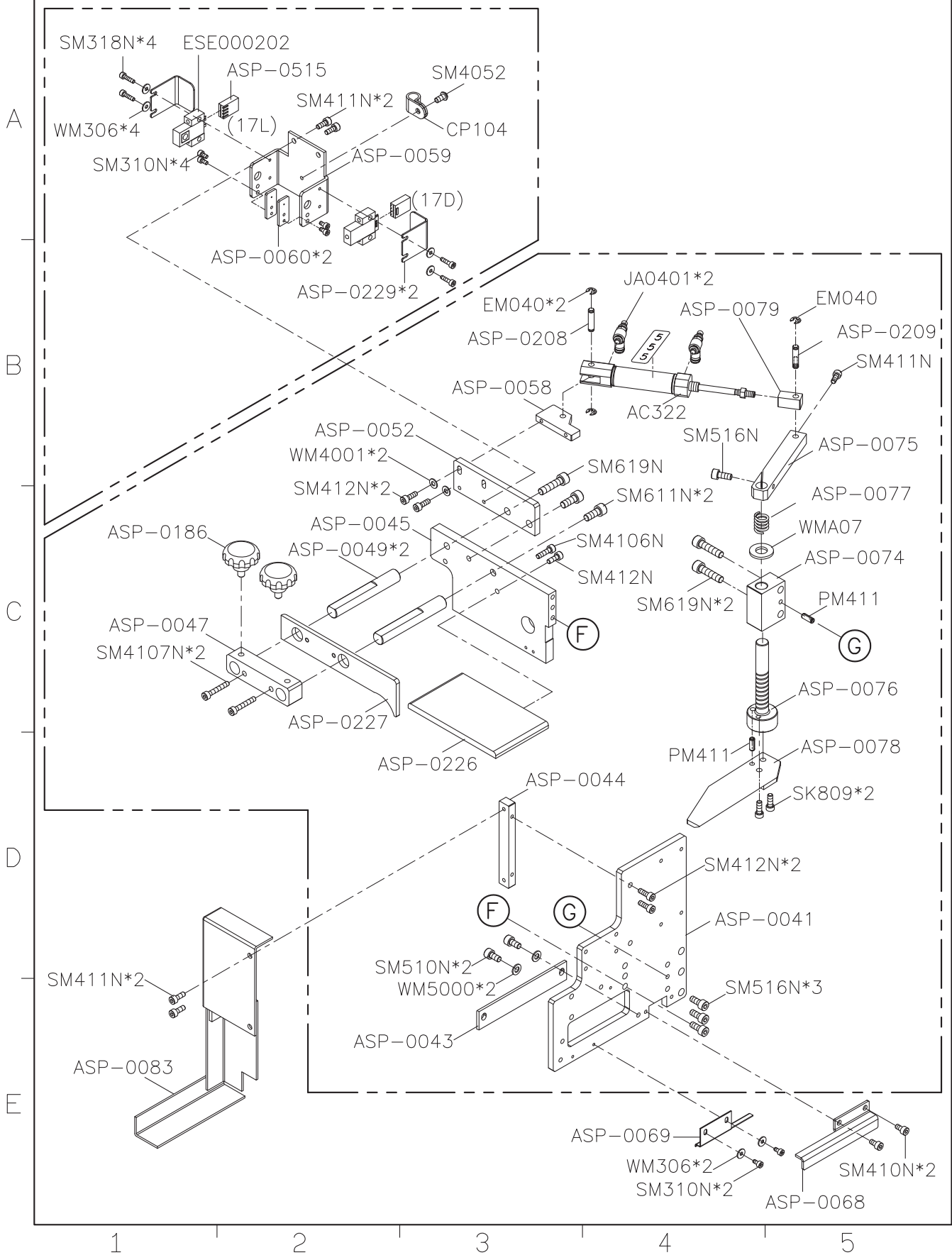


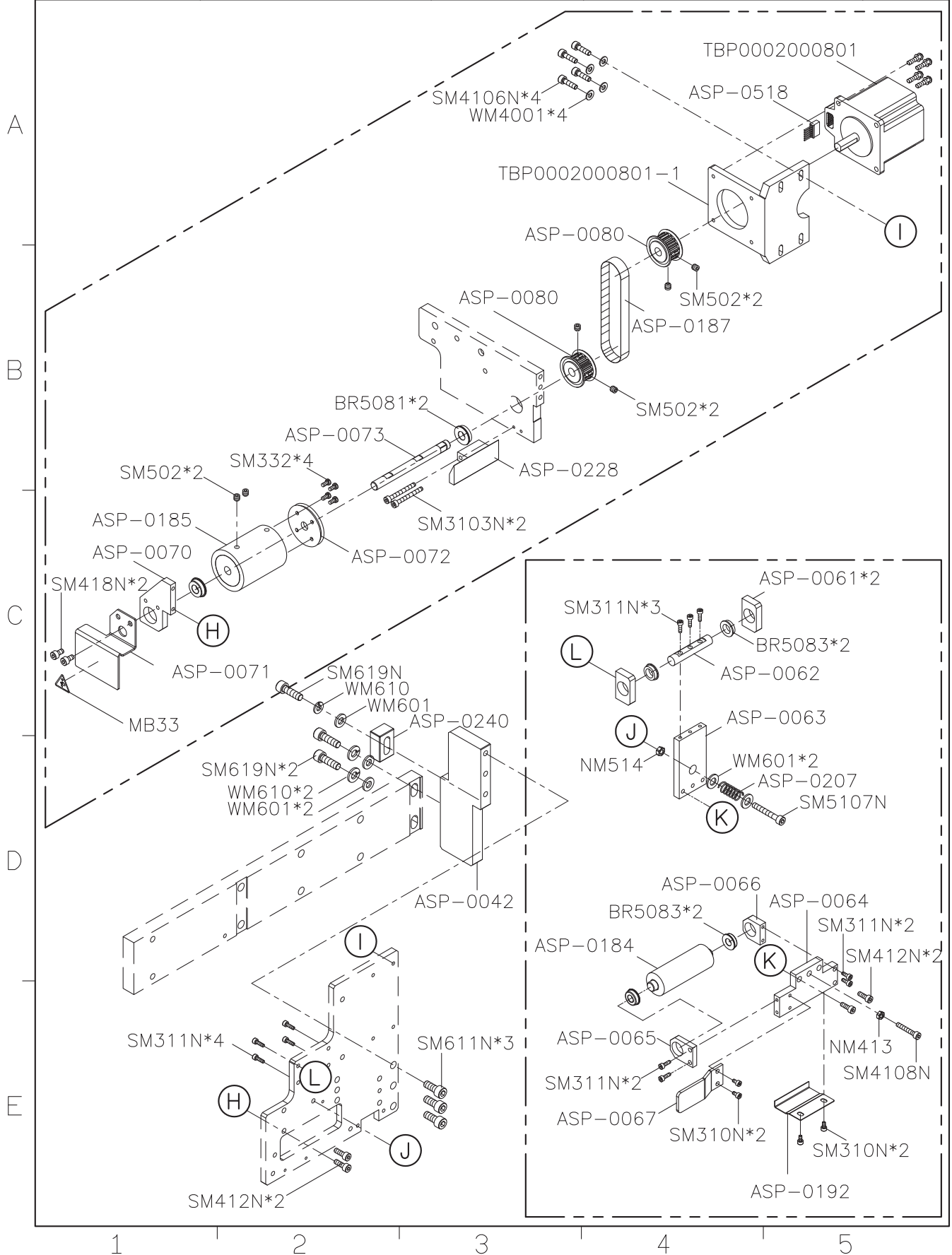
SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
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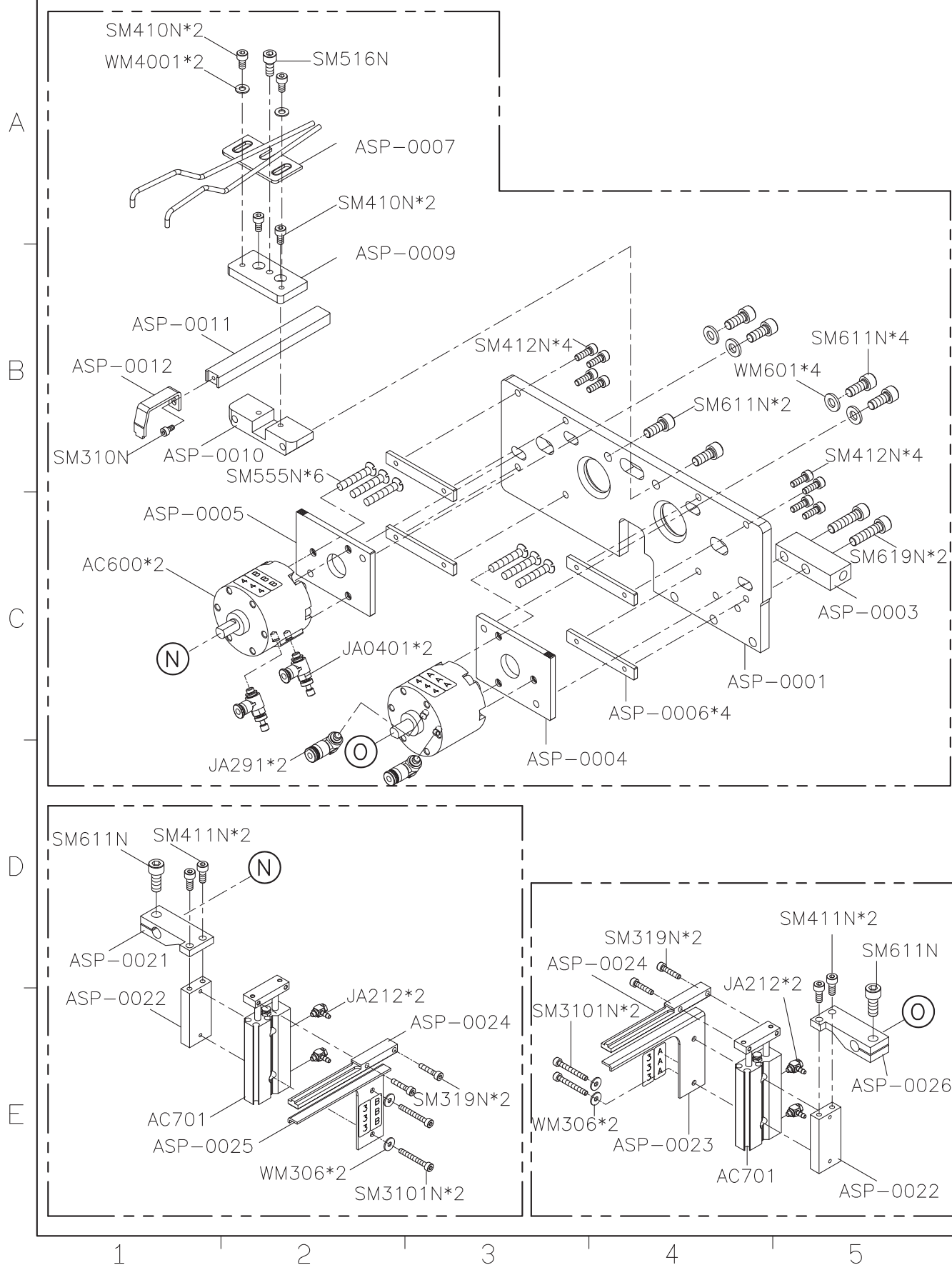


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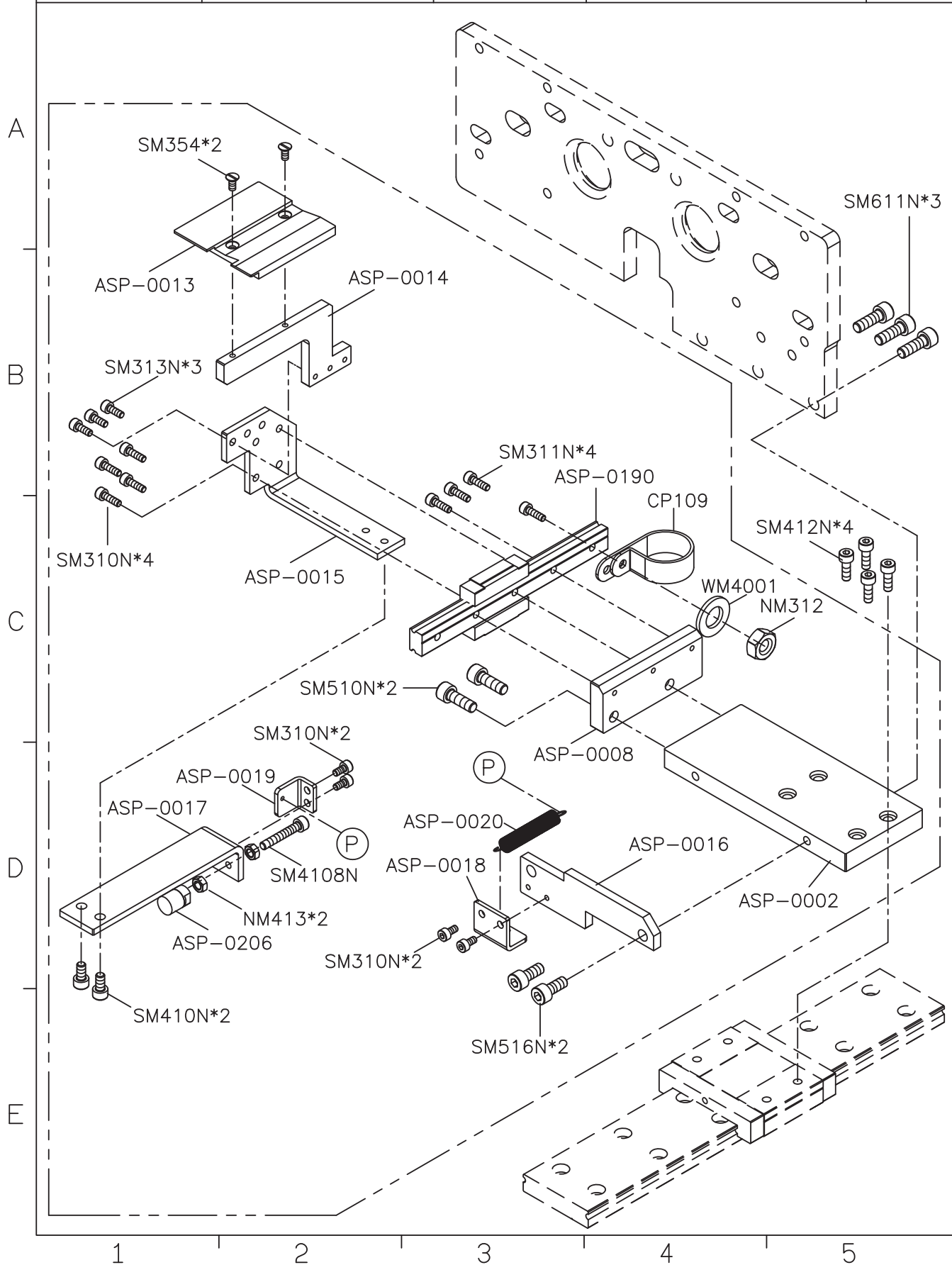


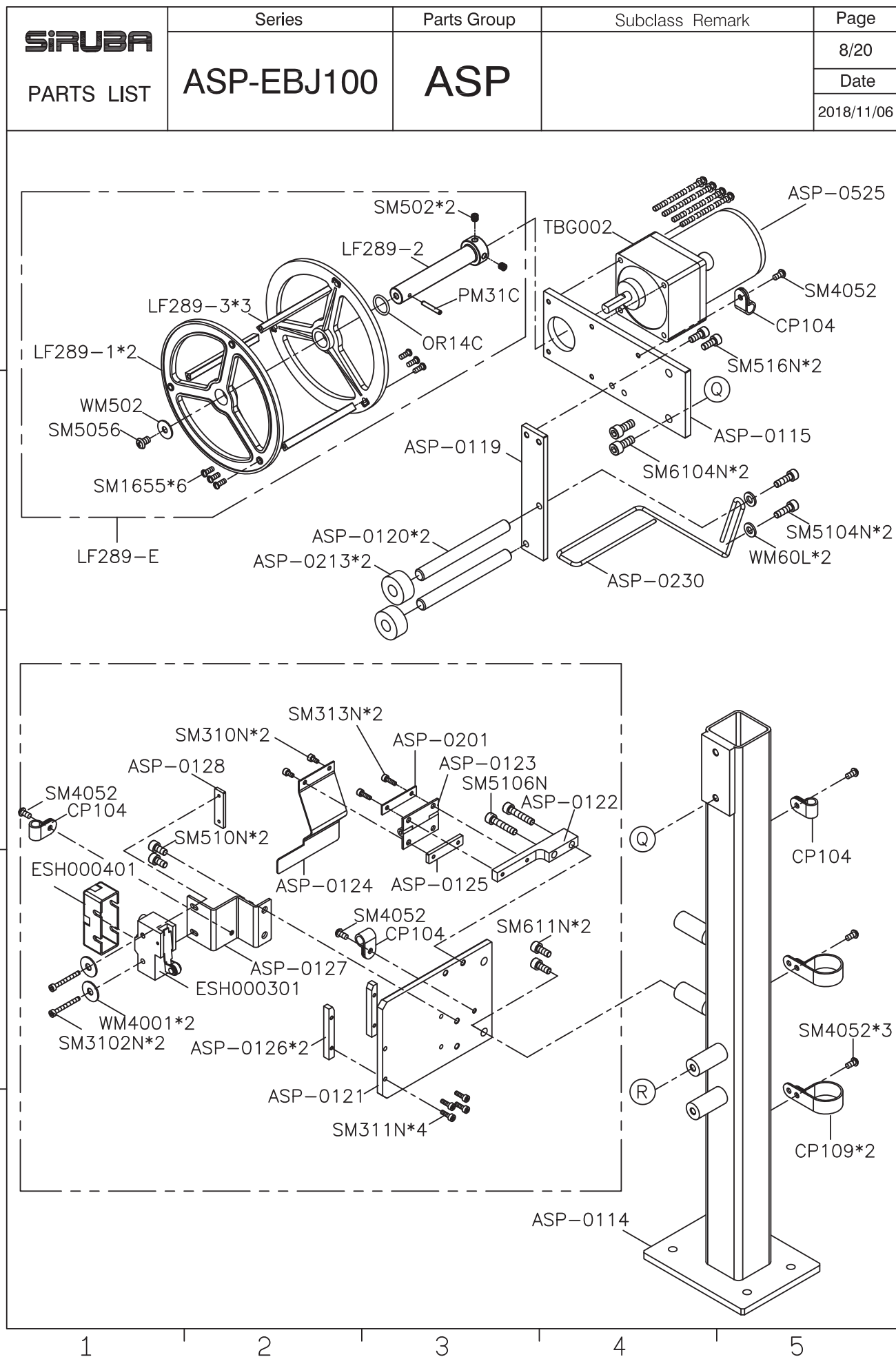


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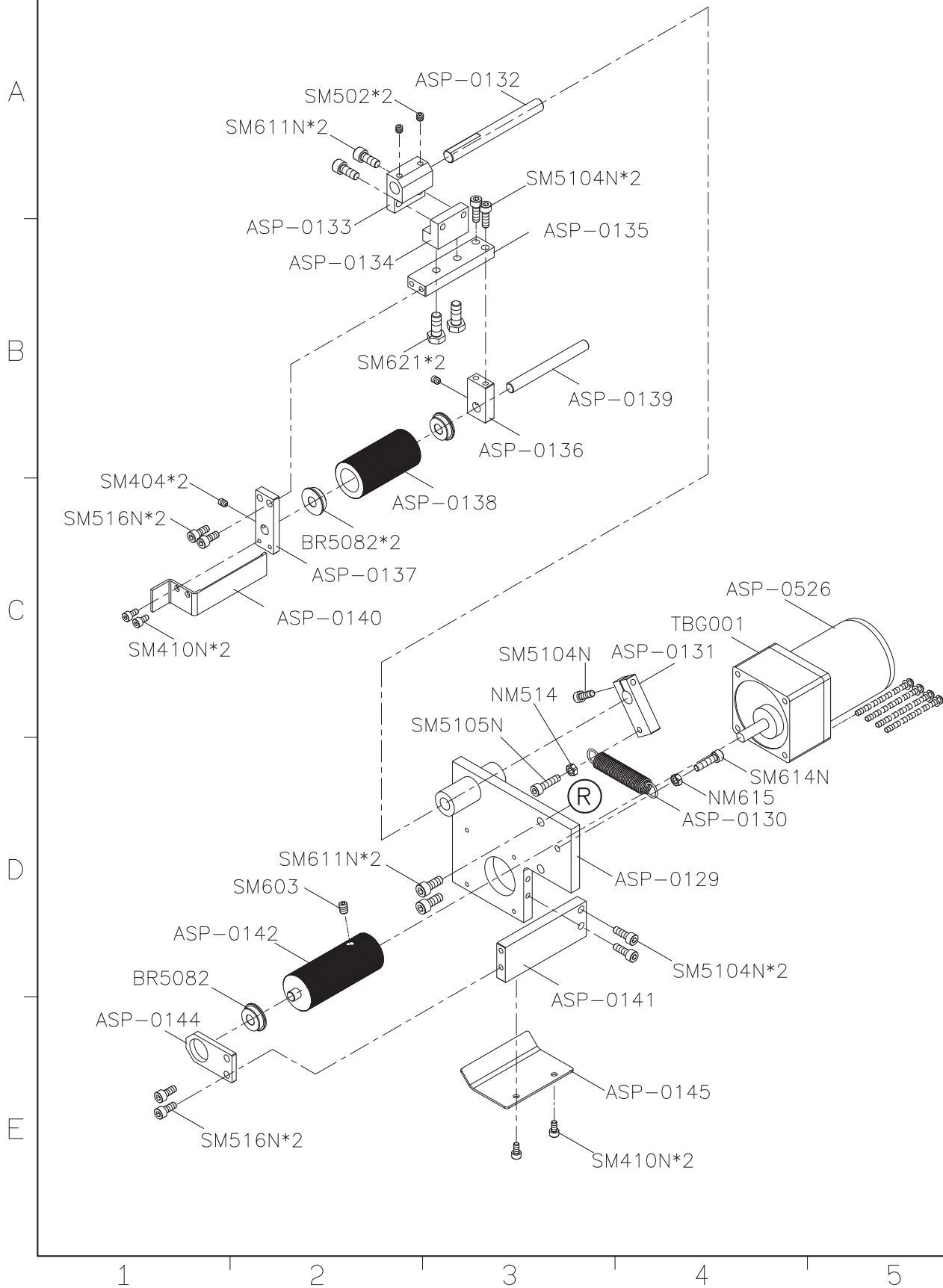


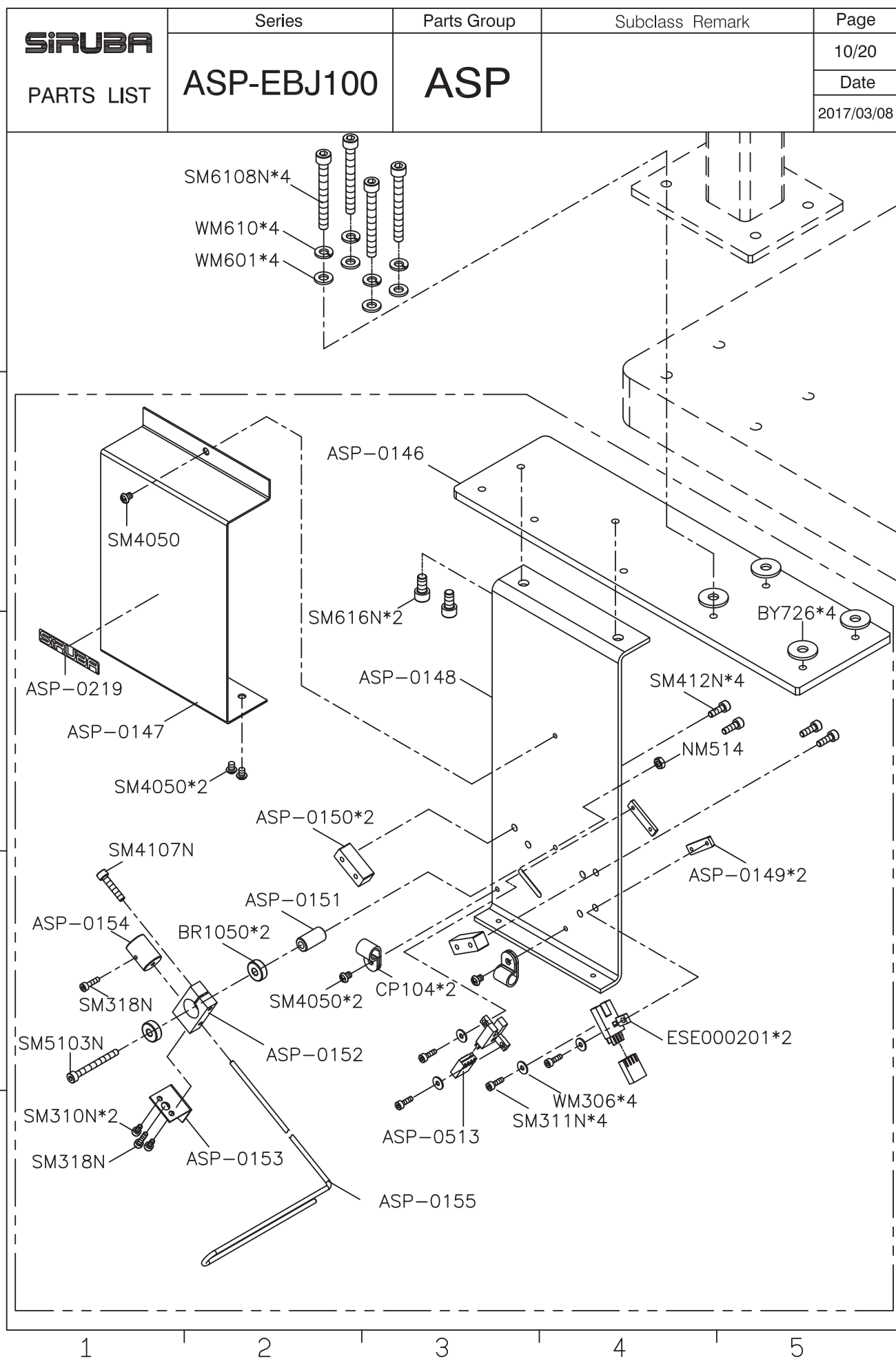
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				2015/11/02





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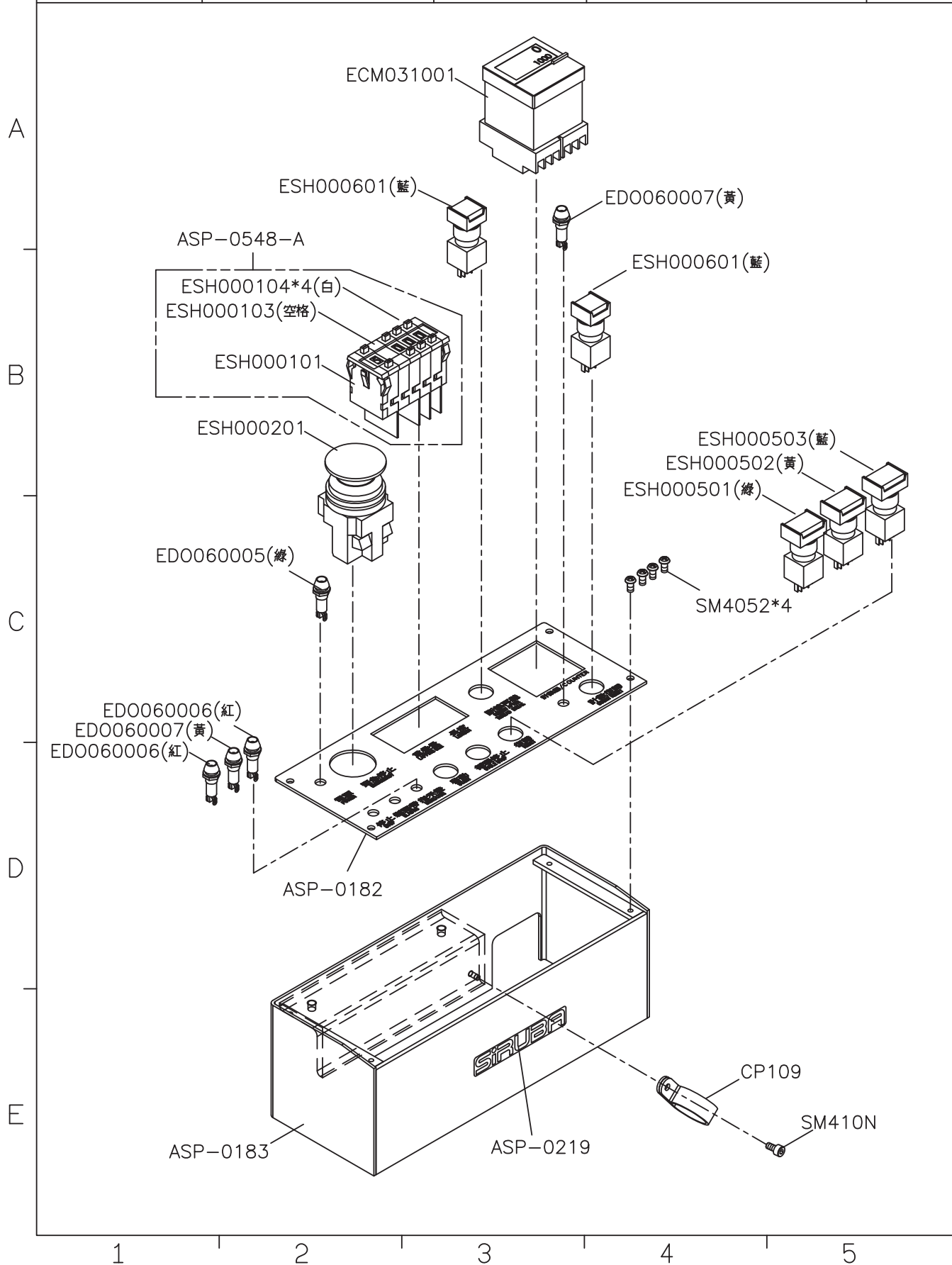
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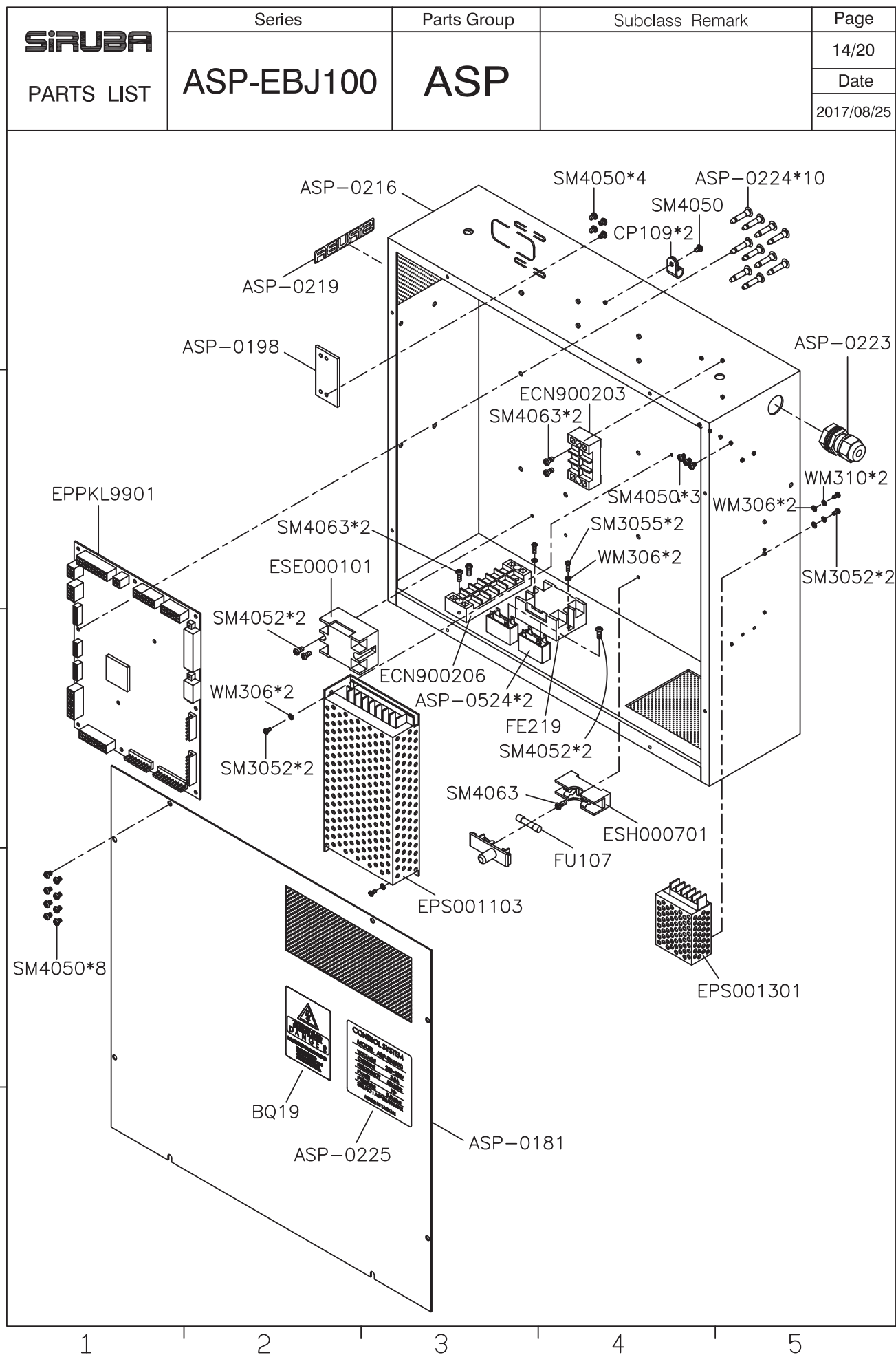
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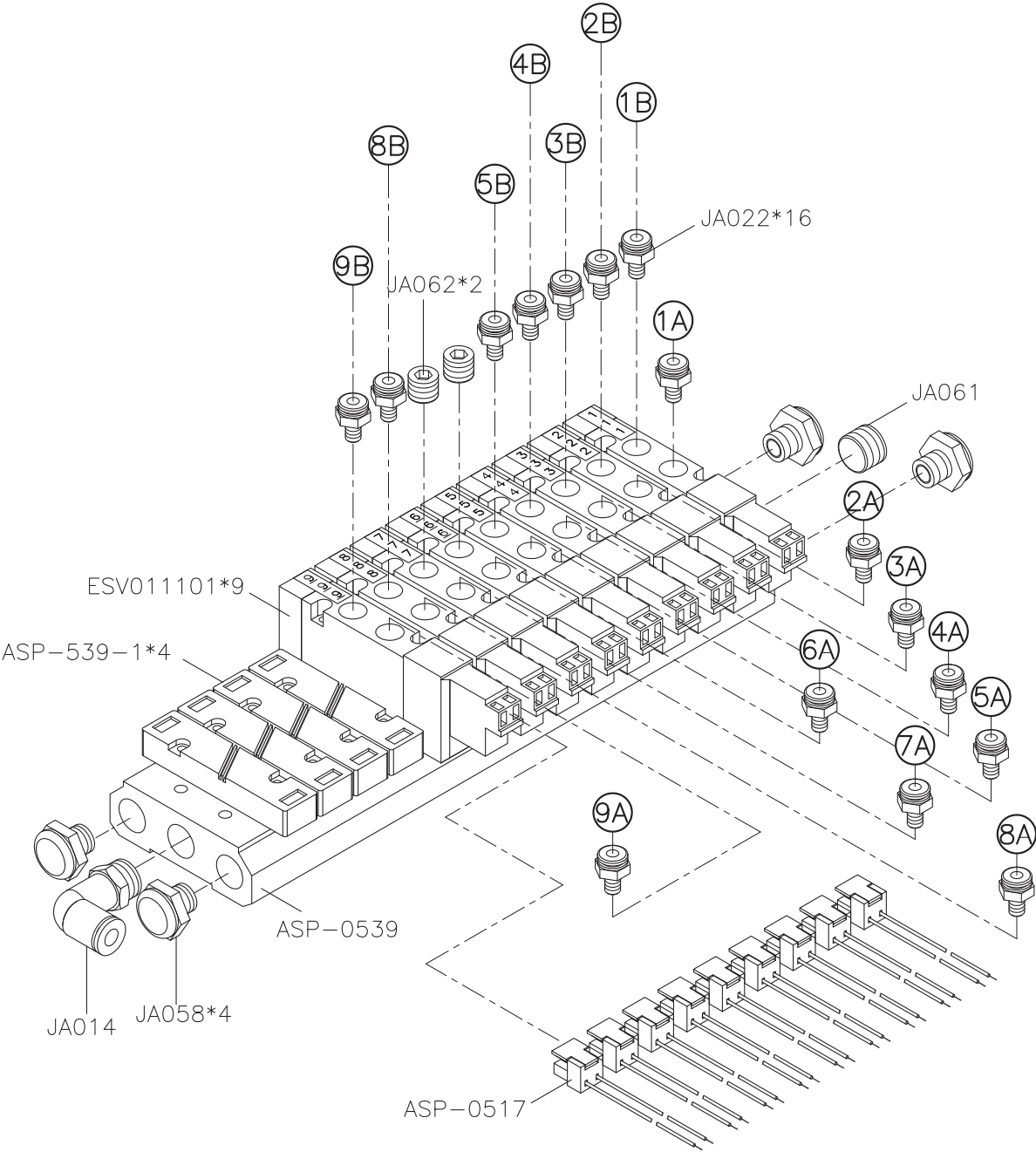
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<div> <div>SIRUBA</div> <div>PARTS LIST</div> </div>	Series	Parts Group	Subclass / Remark	Page
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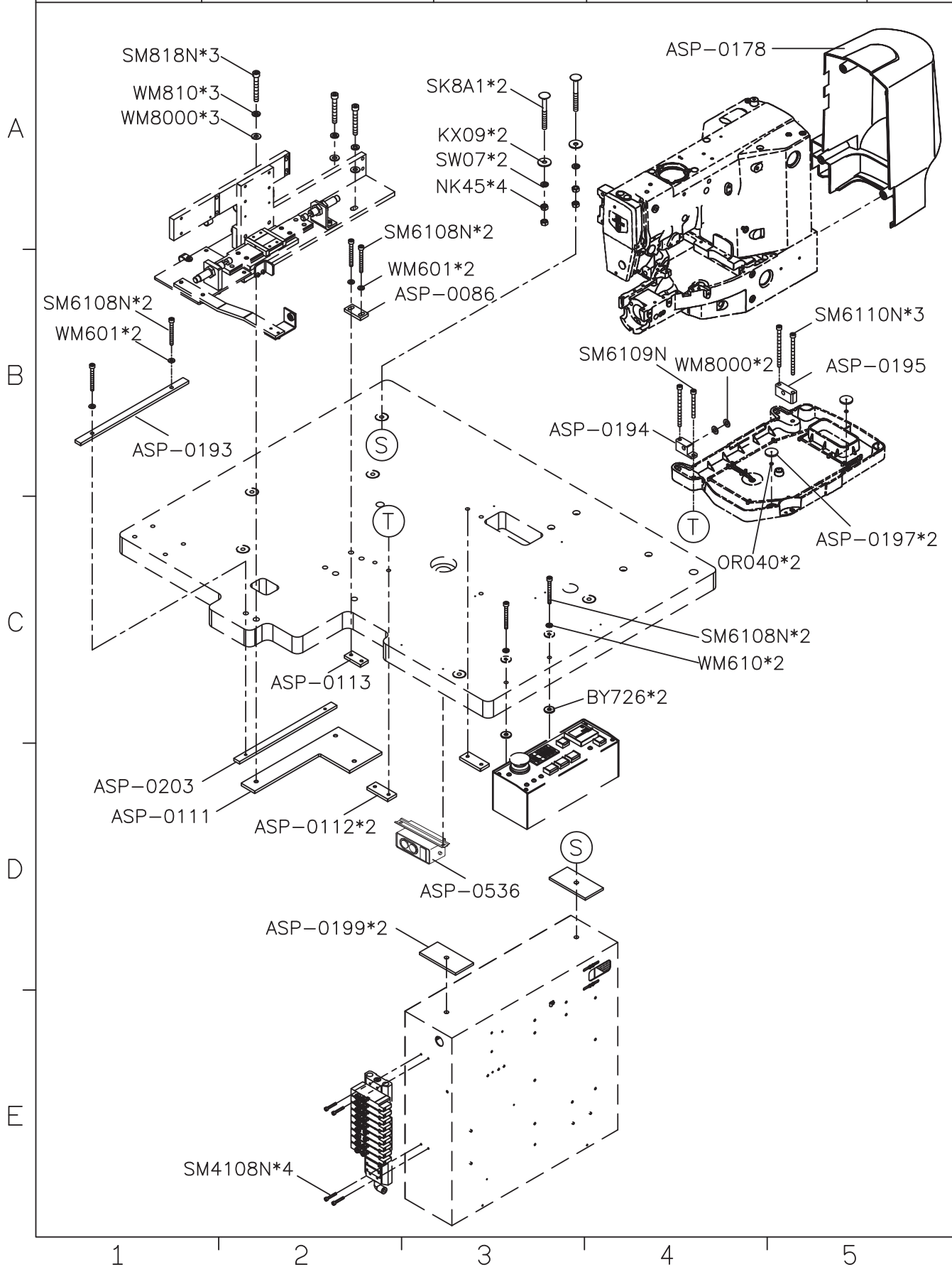
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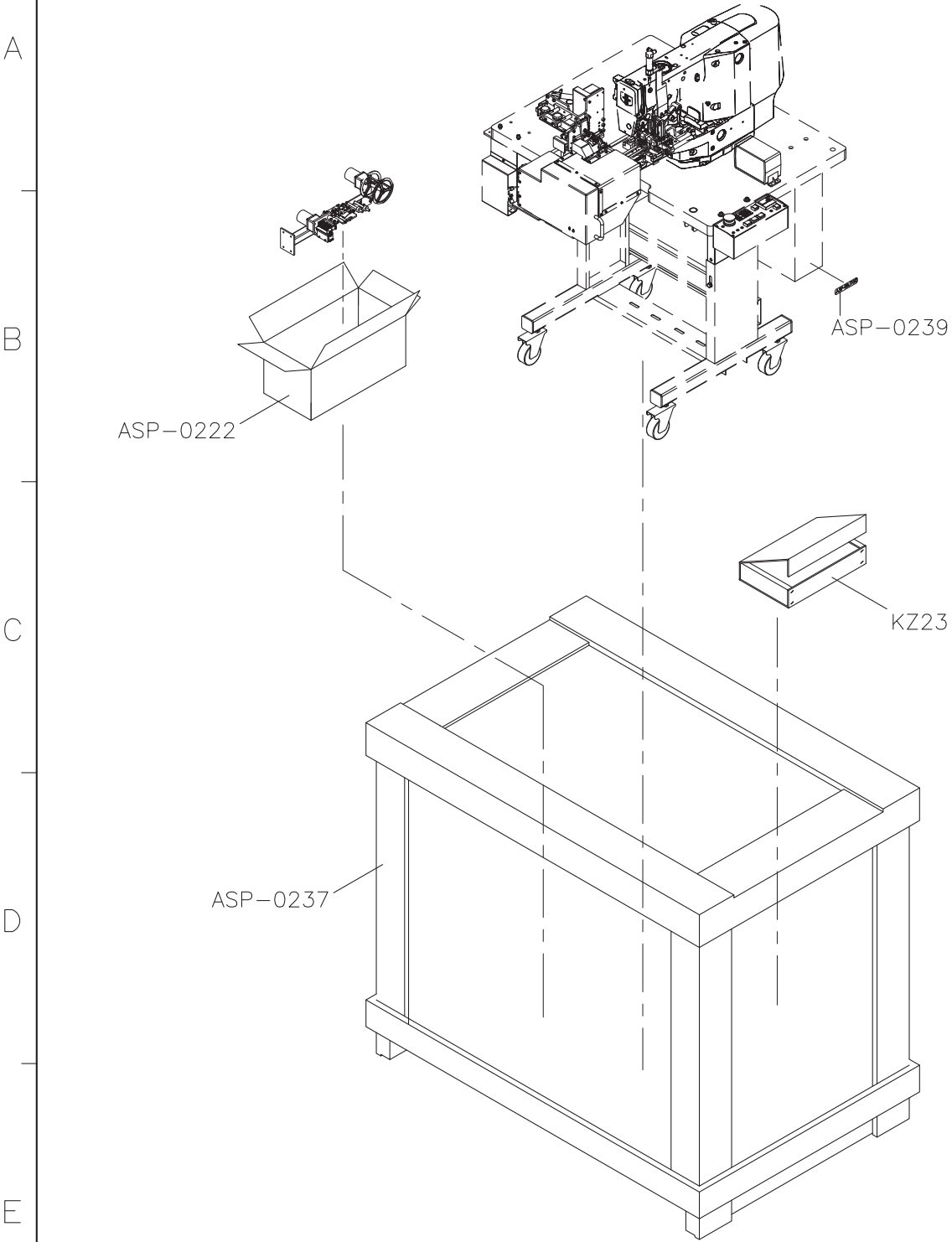
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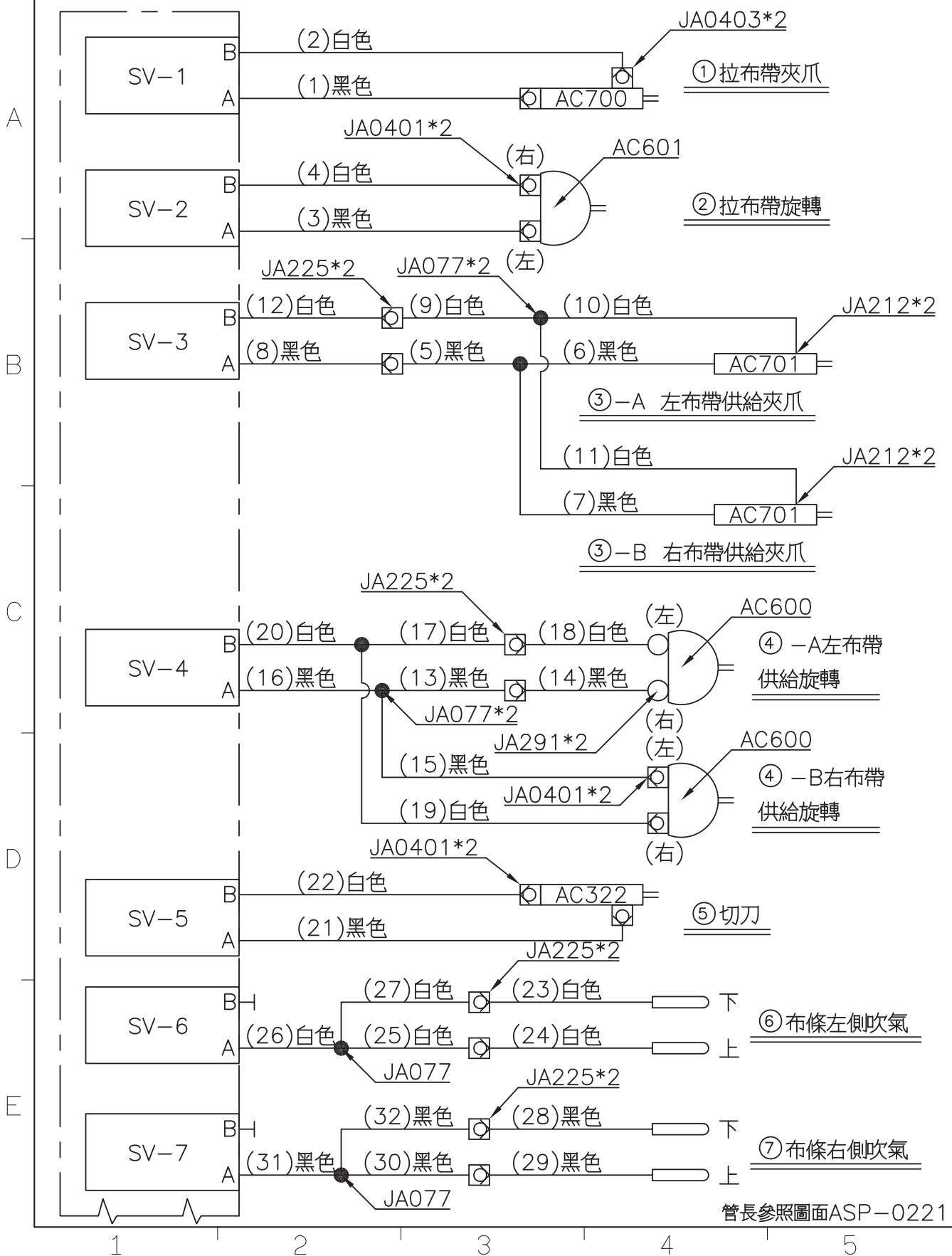
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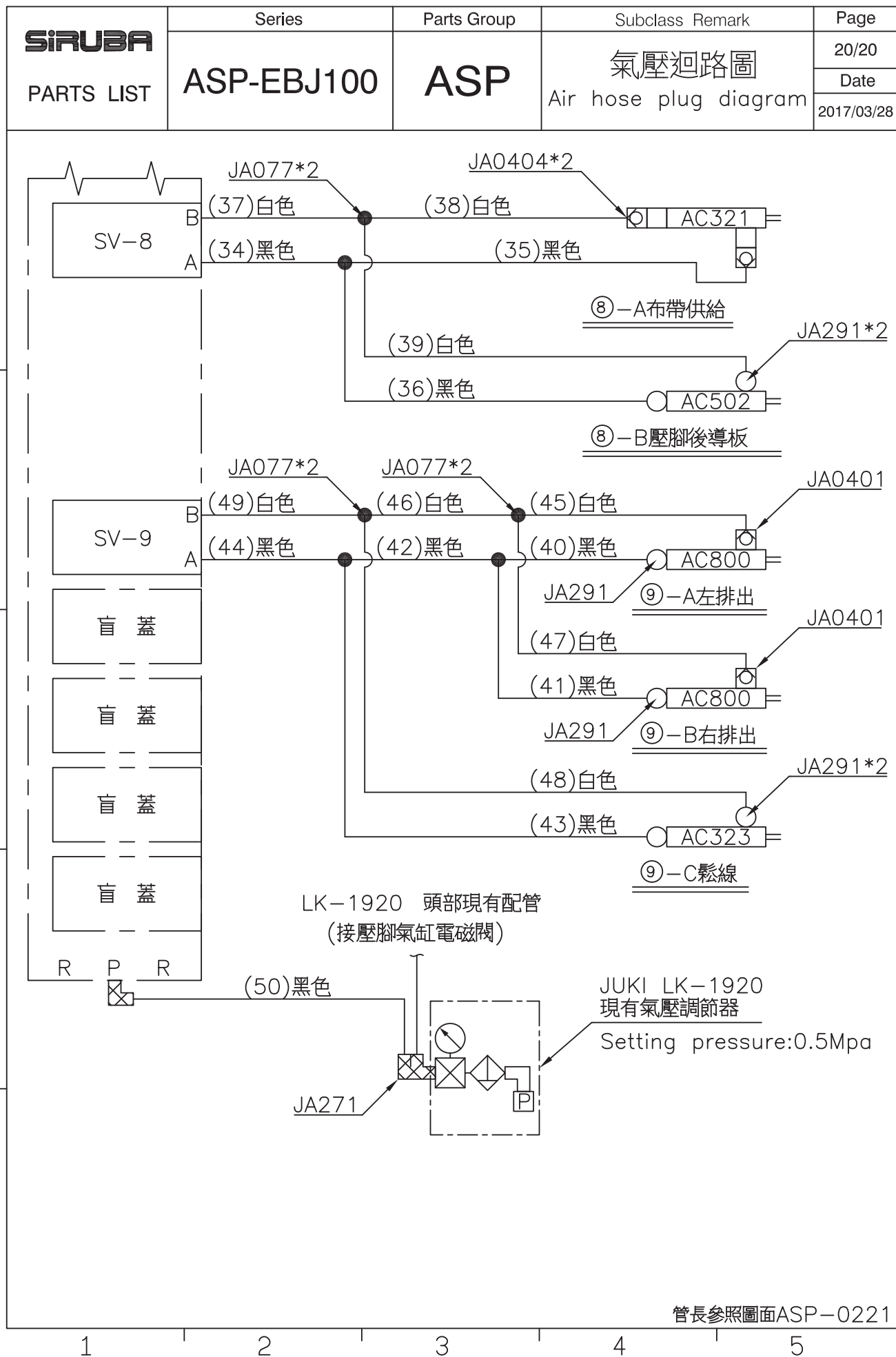


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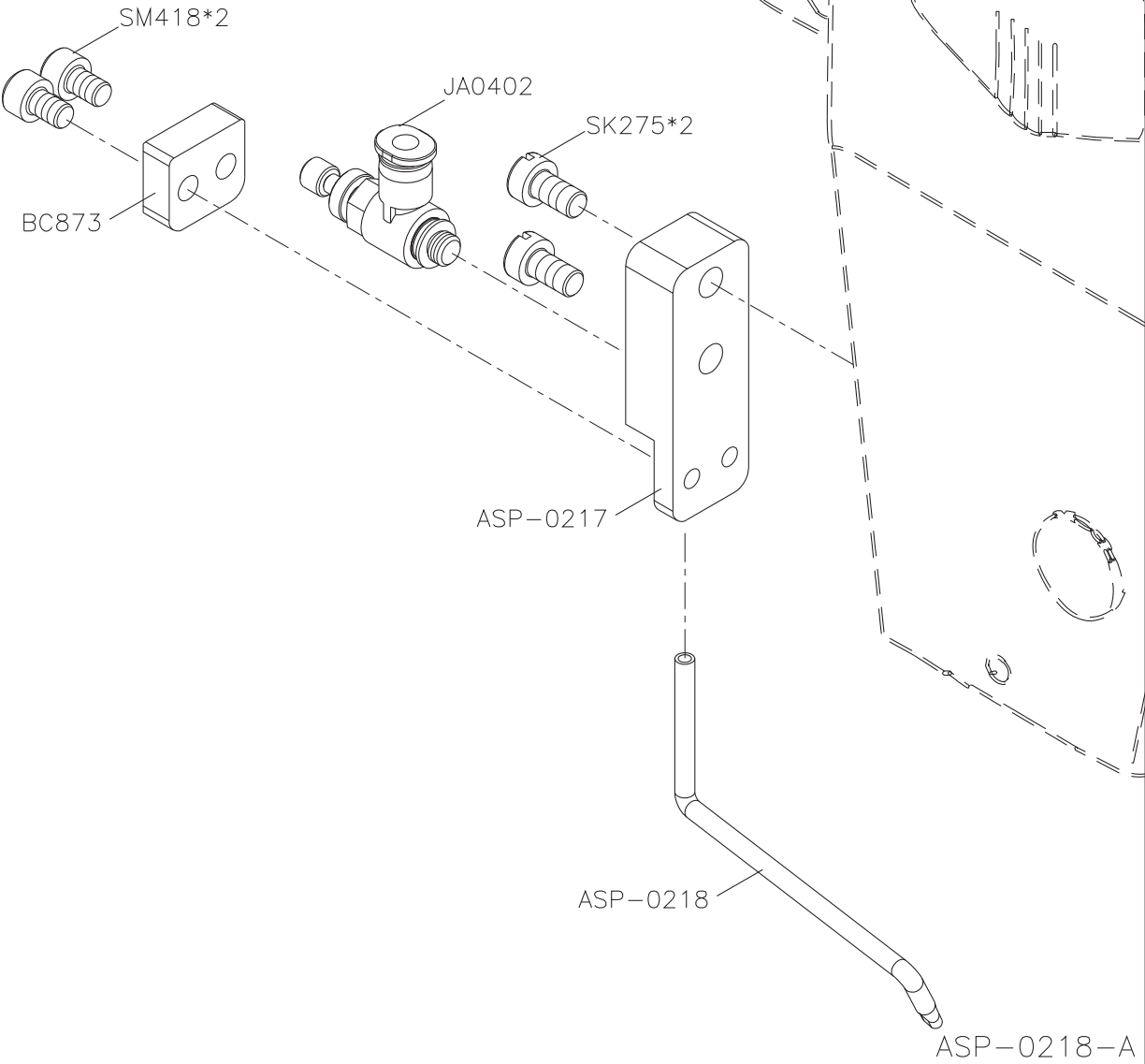
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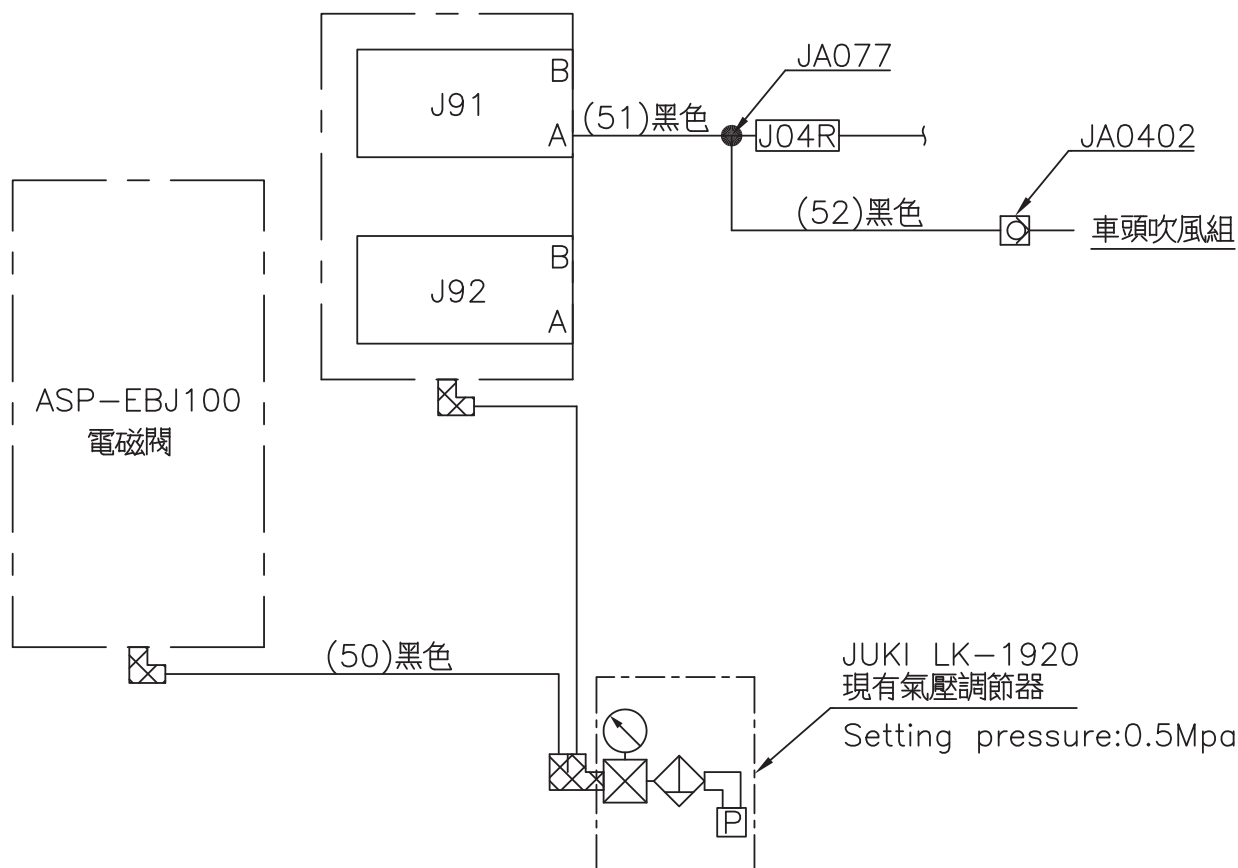
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管長參照圖面ASP-0221

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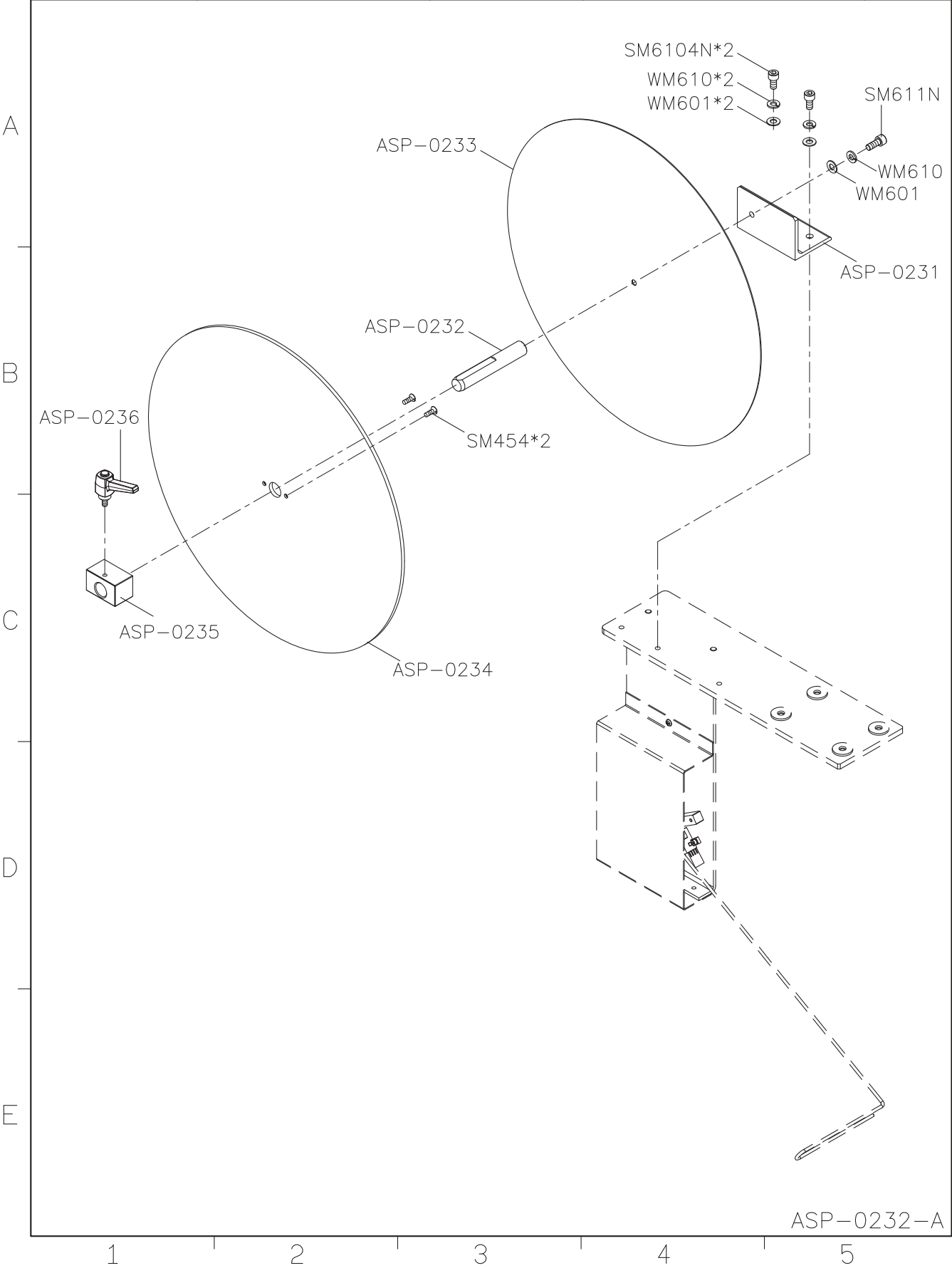
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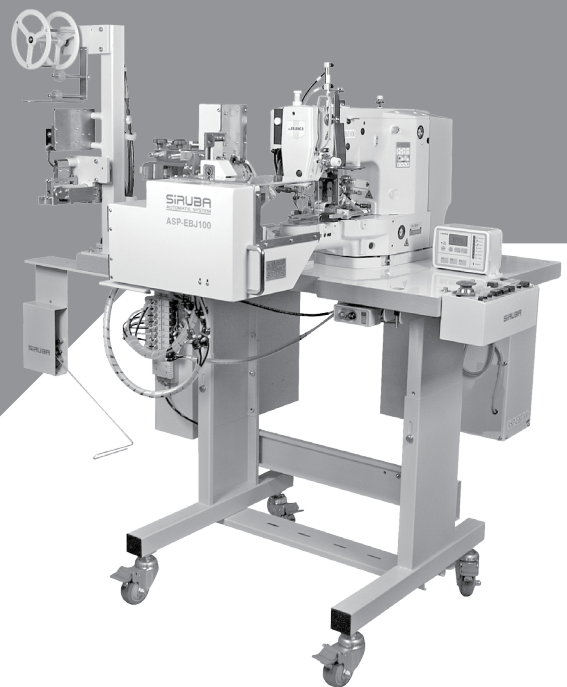
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SIRUBA CHOOSE PARTS 選配圖	Series	Parts Group	Subclass / Remark	Page
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KAULIN MFG. CO., LTD.

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.
ASP-EBJ100.OCT.2018