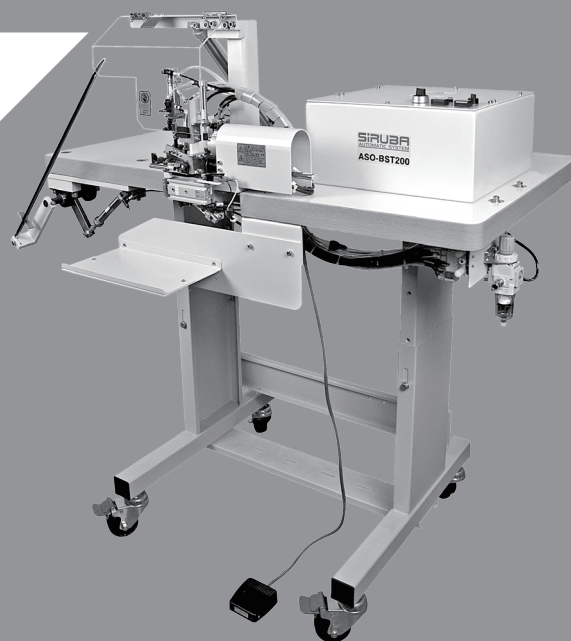


SIRUBA[®] Sew Reach

使用說明書與零件圖

ORIGINAL INSTRUCTIONS BOOK & PARTS LIST

■ **ASO-BST200**



CE

重要安全聲明

•感謝客戶您購買本公司產品

為安全且正確地使用本產品 ASO-BST200，請詳細閱讀以下注意事項後再實施操作。

1. 在使用本機器前，請先詳讀說明書內容，必須遵守說明書的指示與規定。
2. 此設備的使用，由經過適當訓練的操作人員實行。
3. 在使用本機器時，若發現異常或故障，應立即停止使用，並切除電源，以進行妥善修理。
4. 嚴格禁止對本機器進行改造和變更。本公司對改造或變更過的機器不予保固，若因此造成危害，本公司將不負任何賠償責任。

•危險

為杜絕觸電事故必須遵守以下安全措施。

1. 安裝本機器時，必須確實做好接地動作。
2. 對本機器的電氣做定檢與維修，都必須由具有資格的電氣技術人員執行，或專家的監督指導下進行。

•警告

為了杜絕觸電、火災、燒損或對人的傷害，必須遵守以下安全措施。

1. 本機器在有電壓的狀態下，絕對禁止人員接觸通電之機件。
2. 本機器若需要做零件更換或進行維修時，應將電源切換至 OFF 狀態。

SAFETY INSTRUCTIONS

•Thank you for purchasing our company's products.

For your safety and using our product ASP-BST100 properly, please read the instructions below deliberately, then start operating the machine.

1. Before using the machine, you must follow the instructions and rules.
2. The operators must be well trained.
3. If you found some abnormal phenomena or the machine malfunction, you should stop using the machine at the moment and cut the power off, in order to do the proper repair.
4. Strictly forbid to do the extra transformation or alteration. We do not have the warranty to the machine which had been transformed or altered. Therefore, our company will be irresponsible for any compensation if the machine has caused any danger.

•Hazards

In order to prevent from the electric shock, you must to obey the safety measure below.

1. While install the machine, make sure you have do the grounding.
2. The electric routine inspection and maintenance of the machine have to be done by the electric technical personnel who qualified or under the expert's supervision.

•Alert

You must to obey the safety measure below, in order to prevent from the electric shock, fire accident, burning loss, or human body injured.



1. Absolute forbid workers to touch the machine's parts while the machine is in a voltage state.
2. If the machine's parts need to be changed or do the maintenance, you should switch the power off.

3. 當本機器不能正確工作時，應立即停止操作機器。該機器有必要進行修理、電氣或機器方面的調整時，需要和本公司的代理商或直接與本公司聯繫商談，採取合適的解決措施。
4. 本機器的維修、調整須經由適當訓練的技術員或專業人員進行。維修時，需使用本公司所指定的更換零件。
5. 一般的保修檢查，要由經過適當訓練的人來進行。
6. 在維修或保養各式氣缸或氣壓相關連動機構時，務必將供應氣源的接頭拔下，在氣壓完全切斷的狀態方可進行。不過，只限於受過適當訓練的技術人員或專業人員進行調整和運行確認時例外。
7. 該機器準備啟動前，所有的保護蓋必須安裝定位至機器上。
8. 本機器的內部裝置和控制箱裡不能殘積金屬粉末和灰塵，要定期打掃。
9. 本機器在運行當中，所有可動部分都絕對不可用手觸碰，或身體（包括頭髮、衣服類）靠近。
10. 絕對不可用濕手操作，可能造成觸電等重大傷害發生。
11. 警告提示如次頁圖案，請務必遵守。

3. While the machine cannot operate properly, you should stop operating it immediately. If the machine has the necessity to repair, or do the electric and machine adjustment, you should contact with our factors, or contact us directly, then take the proper resolution.
4. The machine's maintenance and adjustment need to be done by well- trained technician or professional. You need to use the specific parts from our company while under maintenance.
5. The repair within the warranty need to be repair by the worker who well trained.
6. While doing the repair or maintain variety of cylinders and pneumatic actuator associated, you must unplug the supply air source connector before you do the repair and maintenance. However, it could be only done by the well- trained technician or professional.
7. Before ready to start the machine, all of the protective covers need to be on the position of the machine.
8. The inner device and the control box of the machine need to be regularly cleaned, in case of any dust or metal filings remains in the machine.
9. While operating the machine, do not use your hands to touch or let your body to close (including hair or clothes) all of the movable parts.
10. Do not use the wet hands to operate the machine, it might cause electric shock or other major injured.
11. Please be sure to follow the alert pictorial markings by next page.

警告圖案表示

INDICATED THE ALERT PICTORIAL MARKINGS

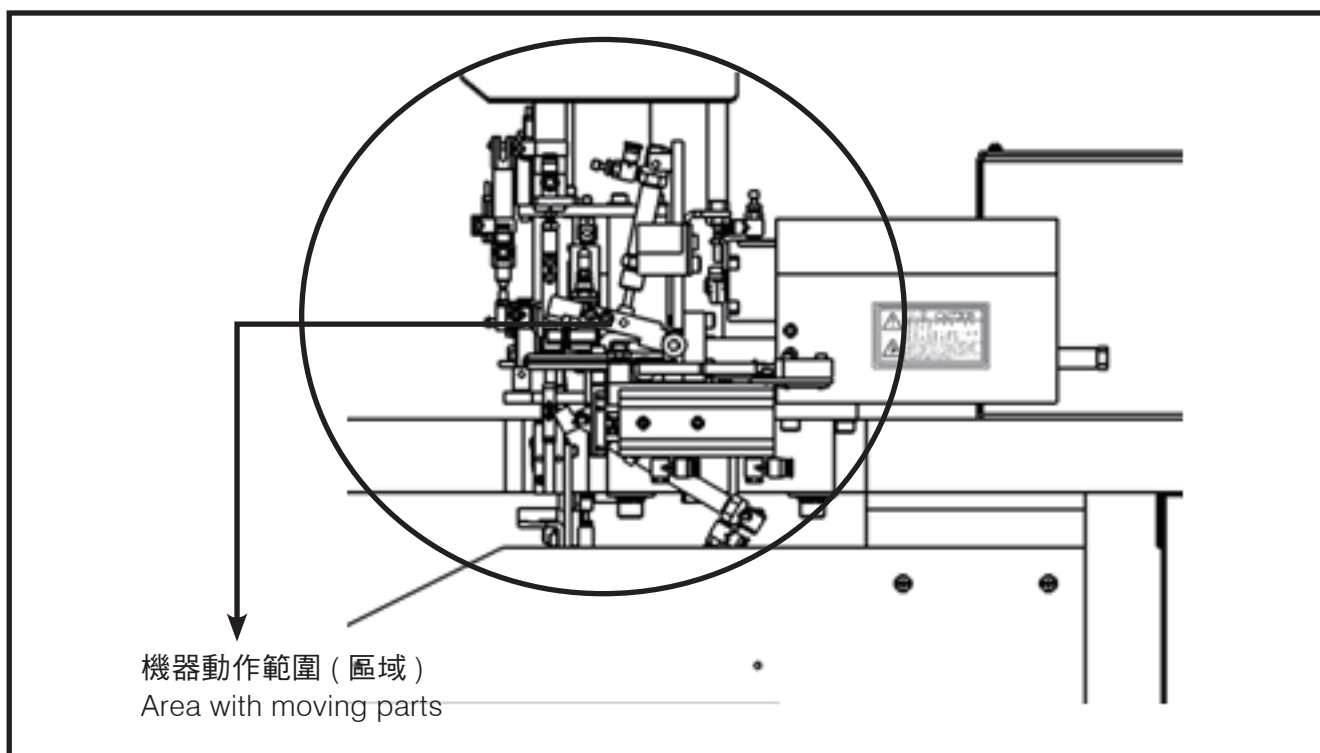
<p>高壓部位 HIGH-VOLTAGE POSITION</p>	 <p>高壓電危險 DANGER</p> <p>注意-請關閉電源10分鐘後始可打開此蓋 TO OPEN THIS COVER: TURN OFF POWER SUPPLYING AND WAIT MORE THAN 10 MINUTES BEFORE OPENING.</p>	<p>務必關閉電源 10 分鐘後始打開電控箱蓋子 Be sure to turn off the power and wait till 10 minutes before opening the control box's cover.</p>
<p>高速運動部位 HIGH SPEED MOTION POSITION</p>	 <p>CAUTION</p> <p>機械作動部份請注意裝上保護裝置 穿線、換線、調整、清潔時請注意關閉電源。 Moving parts may cause in jury. Operate with safety devices. Turn off main switch before threading, changing bobbin and needle, cleaning etc.</p>	<p>謹防工傷事故 In case of industrial accident</p>
<p>高速運動部位 HIGH SPEED MOTION POSITION</p>	 <p>Be careful of its movement. 移動快速 敬請小心</p>	<p>謹防工傷事故 In case of industrial accident</p>
<p>高速運動部位 HIGH SPEED MOTION POSITION</p>		<p>謹防工傷事故 In case of industrial accident</p>

安全注意事項

SAFETY INSTRUCTIONS

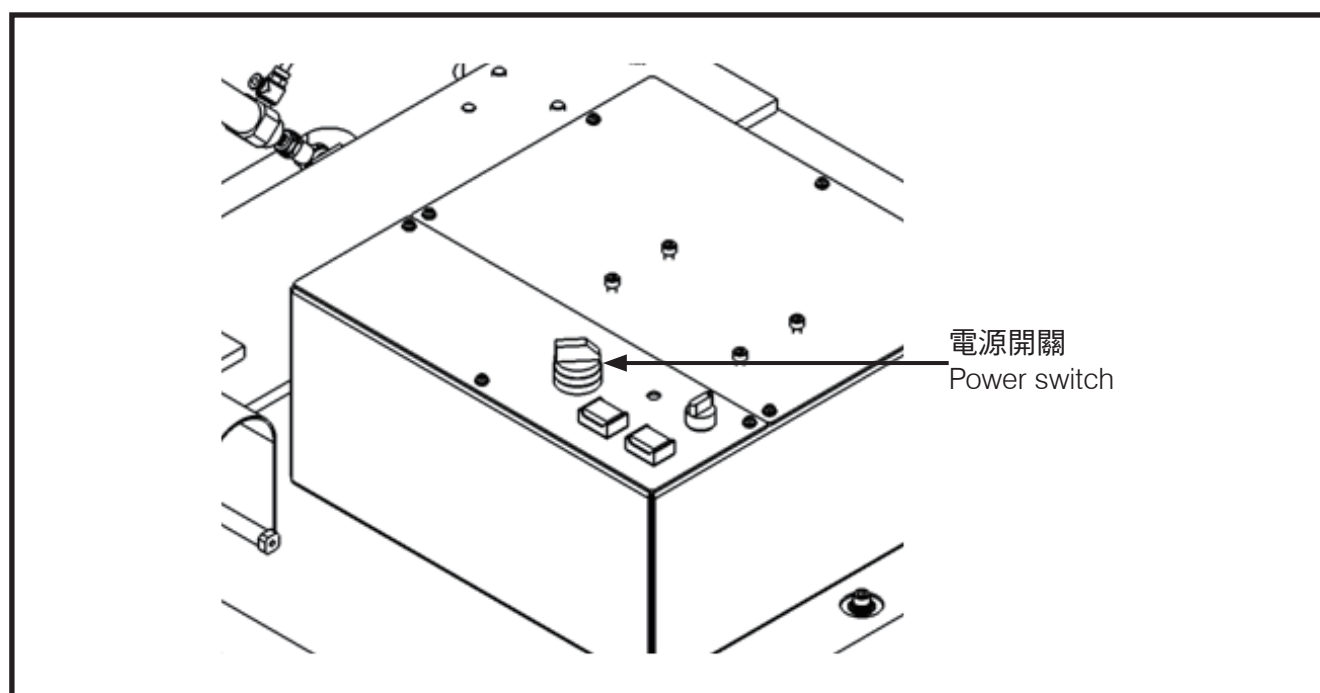
1. 當機器運作中時，請勿將手指等放入機器動作範圍內。

1. Do not put a finger or any other object in the area where there are moving parts while the machine is working.



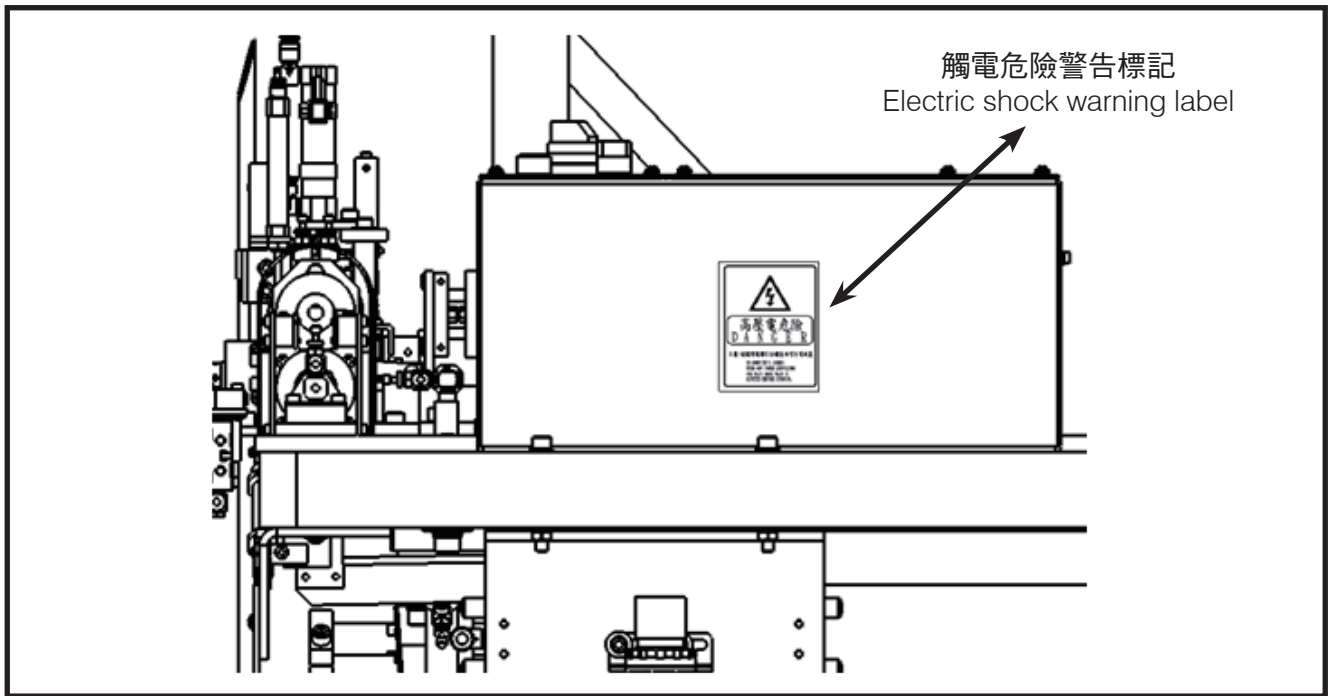
2. 為了保修檢修卸掉罩蓋時，必須將電源切到 OFF。

2. Be sure to turn off the power switch when the cover is removed for an inspection.



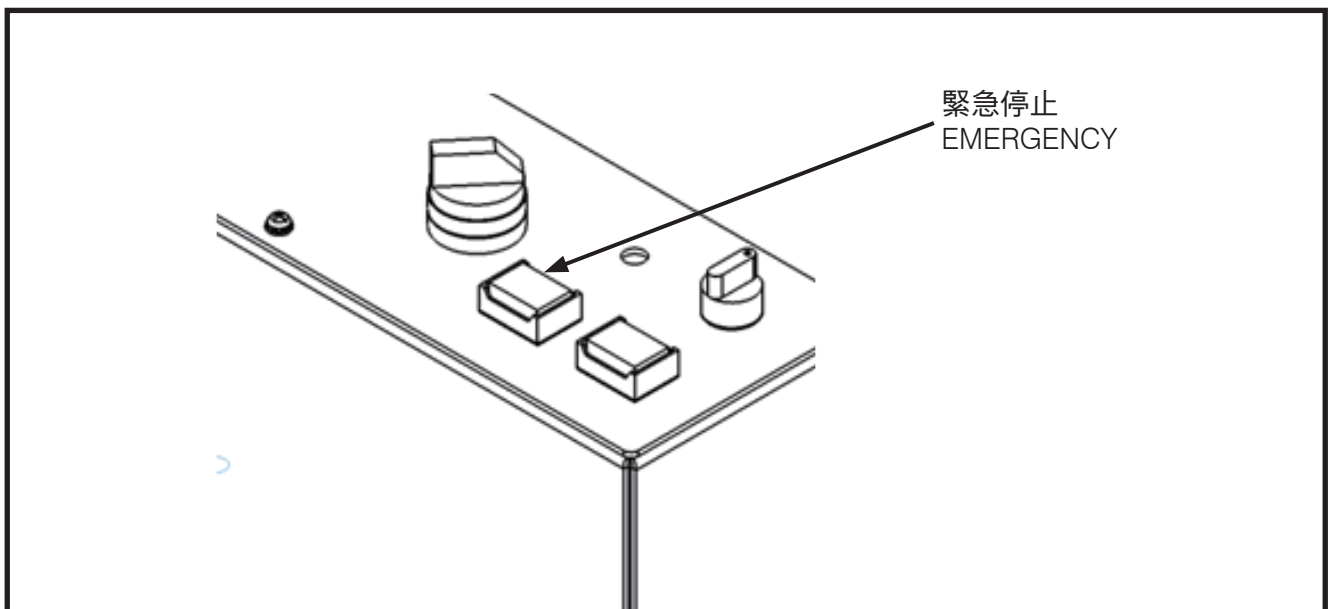
3. 對危及人體的高壓電處，貼有觸電危險警告標記。在貼有本警告的電器控制部位而需要保修、檢修時，打開罩蓋僅能由專業的電氣技術人員進行。

3. An electric shock warning label is affixed where there is high voltage electric terminal which is dangerous to the human body. Nobody except a special electrician should open the cover to inspect a control box with a warning label.



4. 機器運轉時，有必要馬上停止機器的時候，請將緊急停止開關轉到 OFF。

4. If there's a necessity to stop the machine right away while machine operating, you could press the urgent machine halt switch to switch the power off.



5. 電源線、氣壓管線需確實固定安置，不可散落在地面，以免人員絆倒而發生危險。
6. 為了生命安全，在任何情況下，不可將電源地線拔掉運轉機器。
7. 打雷時，為了安全要停止作業，切斷電源。
8. 離開機器工作地點時或工作結束後一定要將電源開關轉到 OFF。
9. 機器運轉下，不可卸下罩蓋類。

5. Power cord and pneumatic cord should be settled, in order to prevent people from stumbling.
6. For safety do not operate the machine when it is not earthed.
7. When there is lightning, stop the machine and pull out the plug for safety.
8. Turn off the power switch when you are not near the machine or after the operation is finished.
9. Do not operate the machine with the covers off.

索引	INDEX	頁 /PAGE
規格	SPECIFICATION	1
操作開關	OPERATION SWITCHES	2
動作流程	OPERATION PROCEDURES	3
運轉	OPERATION	4
裝帶與始動	INSTALL THE STRAP AND START	
自動停止與解除	AUTO-STOP AND RELIEVE	
調整式 8 字環持環器的調整	ADJUSTMENT OF ADJUSTABLE 8-SHAPED FEEDING HOLDER	5
問題的原因與對策	DEFECTIVE PHENOMENAS' REASONS AND SOLUTIONS	7
配線	WIRING PICTURES	9
配管	PIPING PICTURES	10

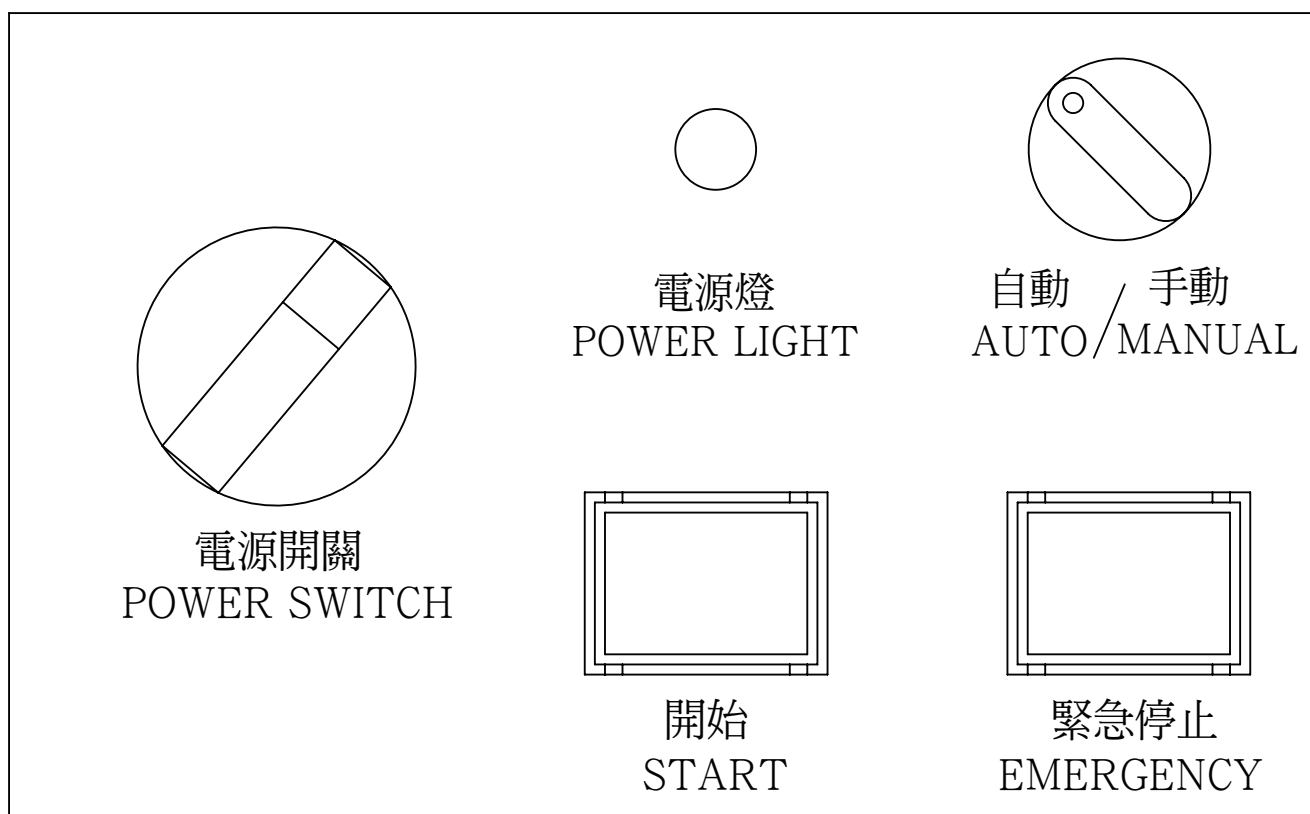
規格

SPECIFICATION

型 號 Model	ASO-BST200
電 源 Power source	單相／3相200～240V 50／60Hz Single-phase / 3-phase 200～240V 50／60Hz
氣 壓 Air pressure	0.5 MPa (5kgf/cm ²)
寬 度 Width	7mm ～ 18mm (量規交換式)
空氣消耗量 Air consumption	30L / 分 30L / min
生產能力 Productive capability	一條四秒 (日產量為 5800 條) 4 secs / per strap, 5800 straps / per day.
機器尺寸 Machine size	寬 1050 × 長 770 × 高 1300mm machine size width 1050 × Length 770 × height 1300mm
完成尺寸 Finish product size	200 ～ 600mm (調節器長度 50mm) 200～600mm (The length of regulator is 50mm)

操作開關

OPERATION SWITCHES



開關名稱 Name	功能 Function
緊急停止 EMERGENCY	<ol style="list-style-type: none"> 作業全部停止。再按便可以取出帶子。 自動停止後按開關可取出帶子。 待機狀態時按開關，就可與 2 相同。 <ol style="list-style-type: none"> Whole motions stop, the strap could be withdrawn when press it again. Press the switch could withdraw the strap after Auto-stop. When the machine at stand-by mode, press the switch then could be the same with process "2".
開始 START	<ol style="list-style-type: none"> 回復待機狀態。 單獨動作運轉時，動作只進行一步。 <ol style="list-style-type: none"> Return to the stand-by mode. When one-shot mode has been started, the procedure will be advanced only one step.
單獨動作開關 Separate action switch	<p>轉換為單獨動作運轉。</p> <p>Switch to one shot operation mode.</p>

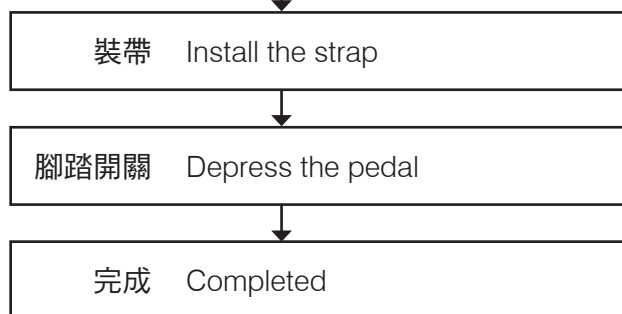
注) 待機狀態即帶子已裝上狀態。

Stand-by mode means the strap has been installed.

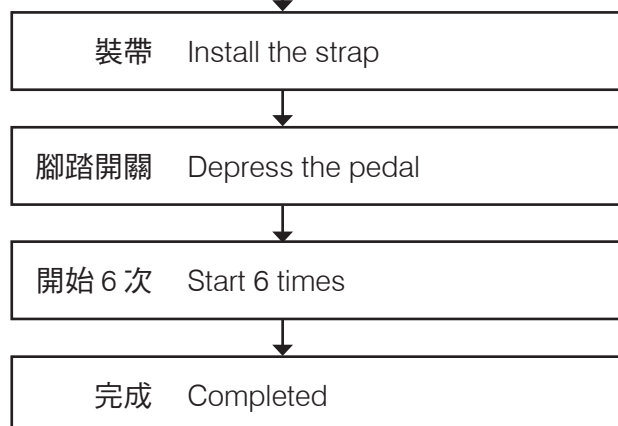
動作流程

OPERATION PROCEDURES

自動模式 Auto-operation mode



手動模式 Manual operation mode



運轉

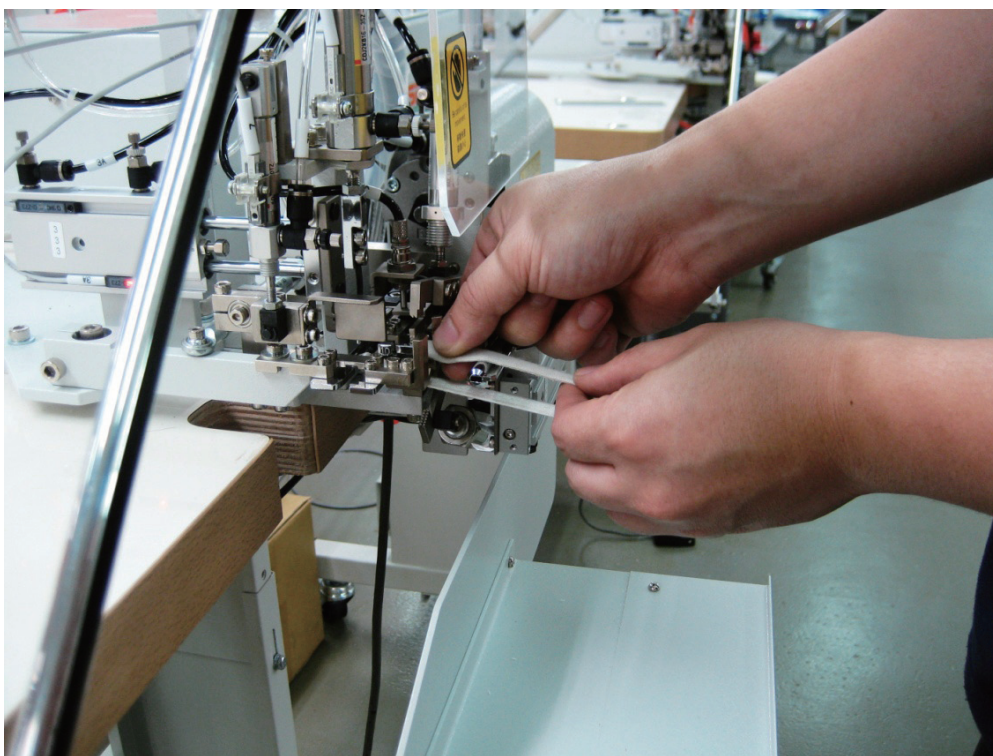
OPERATION

1. 裝帶與啟動

用左手輕輕拉直帶子，踩動腳開關。

1. Install the strap and start

Stretching the strap lightly with left hand and depress the pedal.



2. 自動停止與解除出現以下情況時，自動停止。

a. 穿帶板無法降至最低。

b. 取帶完成開關無法打開。

解除方法

1) 按緊急停止開關，取出帶子。

2) 按啟動開關。

持續發生自動停止時，請參照 4 頁「4. 問題、原因、對策」

2. When some situations happend as below, the Auto-stop mode will be switched.

a. The strap thread plate could not reach to the lowest position.

b. Strap withdraw stick could not raise.

Solutions to relieve

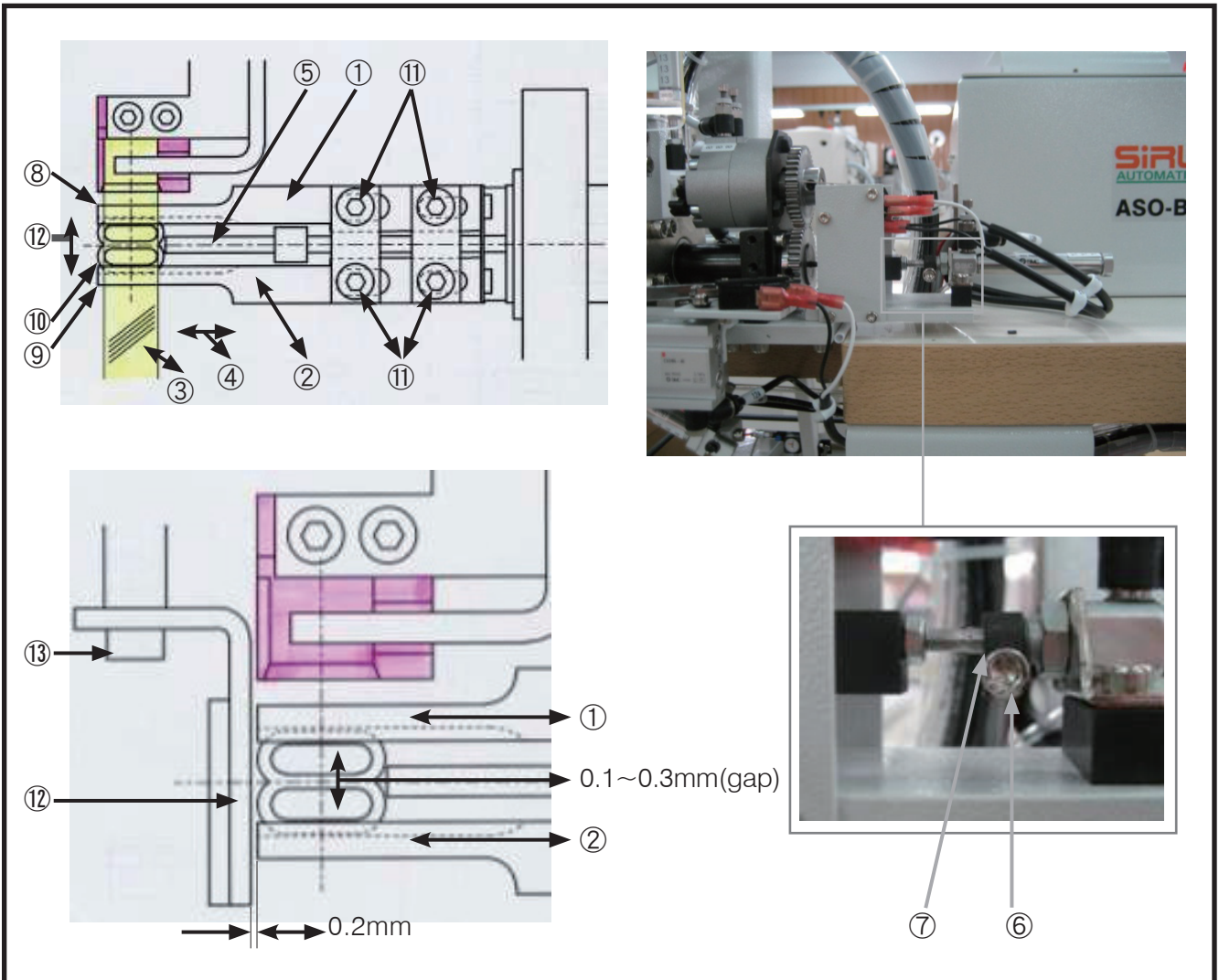
1) Press the "Emergency stop" switch and withdraw the strap.

2) Press the "Start" switch.

If the Auto-stop situation still happened, please refer to the page 4. "Defective Phenomenas' Reasons and Solutions".

調整式 8 字環持放器的調整

ADJUSTMENT OF ADJUSTABLE 8-SHAPED FEEDING HOLDER



1. 將 8 字環送入調整式 8 字環持放器①②中。
2. 當 8 字環與帶子③中心線一致時，各部位的關係如下：
 - a) 箭頭④的方向
將導杆⑤的前端接觸到 8 字環的右端。(調整) 鬆動螺絲⑥、調整制動裝置⑦的位置。持放器①②前端⑧⑨對準 8 字環的左端。(調整) 鬆動 4 顆螺絲①，將持放器①②順箭頭④的方向移動。

1. Put 8-shaped buckles into adjustable 8-shaped feeding holder ①②.
2. When 8-shaped buckles consistent with the central line of strap ③, the relationships with each parts are as belows:
 - a) The direction of arrow symbol ④.
Let the front and of stick ⑤ touch the right side of 8-shaped buckles. (Adjust) Loosen the screw ⑥, adjust the position of device ⑦. The front end ⑧⑨ of feeding holder ①② aim at the left side of 8-shaped buckles. (Adjust) Loosen 4 screws ①, move the feeding holder ①② along to the arrow symbol ④.

b) 箭頭⑫方向：

要使 8 字環的中心與棒⑤的中心線相一致。

（調整）鬆動 4 顆螺絲⑪，將持放器①②向箭頭⑫的方向移動。

8 字環與置放器①②之間，朝箭頭 方向，設定出 0.1 ~ 0.3mm 的余富

（調整）鬆動螺絲，將持環器①②向箭頭方向開關進行調整。

3. 持環器①②端部⑧⑨和導板⑫之間，設定 0.2mm 的縫隙。

（調整）鬆動 2 顆螺絲 調整導板⑫的位置。

b) The direction of arrow symbol ⑫.

Let the central part of 8-shaped buckles consistent with the central line of the stick ⑤.

(Adjust) Loosen the 4 screws , move the feeding holder ①② along to the arrow symbol .

Between 8-shaped buckles and feeding holders ①②, along to arrow symbol ⑫ need to set up 0.1~0.3mm gap.

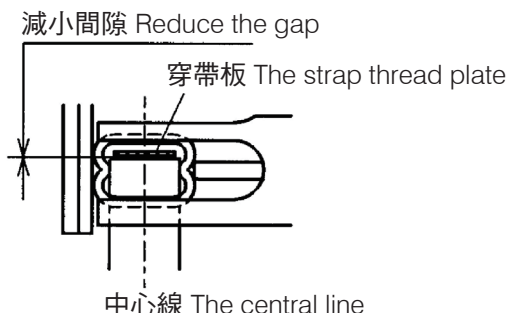
(Adjust) Loosen screw ⑪, move the feeding holder ①② along to the arrow symbol ⑫.

3. Set up 0.2 mm gap between the end part ⑧⑨ of feeding holder ①② and board ⑫.

(Adjust) Loosen 2 screws ⑬ and adjust the position of board ⑫.

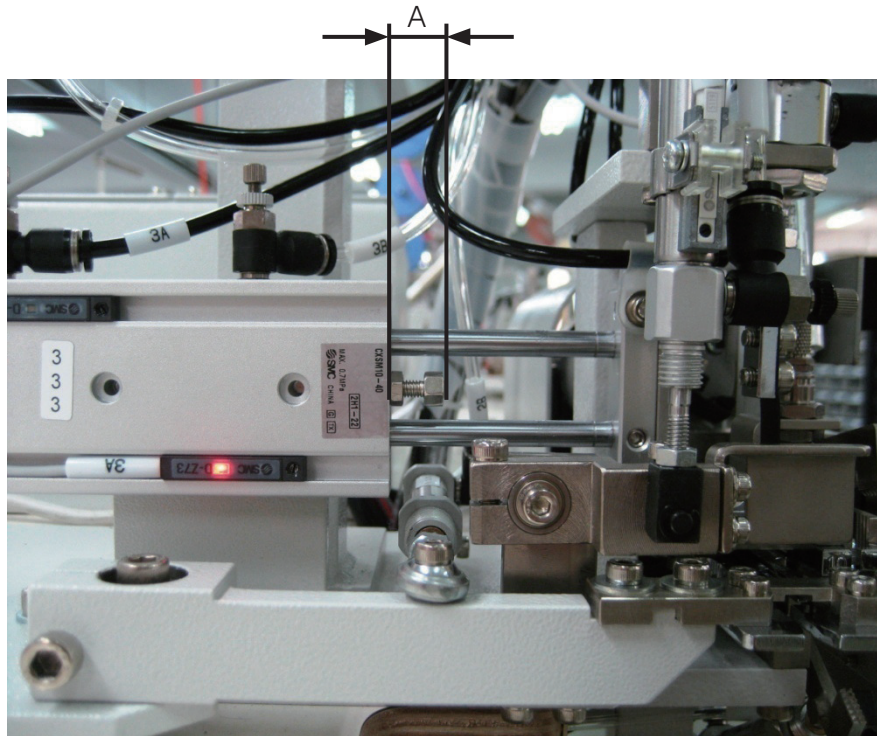
問題的原因與對策

DEFECTIVE PHENOMENONS'
REASONS AND SOLUTIONS

現象 Phenomenon	原因 Reason	對策 Countermeasure
1. 帶子無法通過 (第一次穿帶) 1. The strap could not through. (First time)	a. 帶子接觸不良 a. The strap contact defective	用左手將帶子拉置，開始起動 3 頁「3. 運轉」參照 Stretch the strap with left hand and start. Refer to P.3 (3.0 perations)
	b. 穿帶板的位置不正 b. Incorrect position of the strap thread plate.	1) 將帶子和穿帶板的中心線對齊。(左右) 2) 將穿帶板靠近 8 環中心處 (前後) 1) Let the strap align the central line of the strap thread plate. (Left and right) 2) Let the strap thread plate close to the central of 8-shaped buckles (front and back) in order reduce the gap.  (提示：帶子只可裝入 8 環一側，將穿帶板降至最低位置後找中心線。) (PS. The strap could only thread one side of the 8-shaped buckles. Let the strap thread plate reach to the lowest position and find the central line.)
	c. 穿帶用導帶部分過長 c. The front part of the strap is too long.	移動帶子拈頭旋轉裝置的抑制器長度 A (照片 1) 伽長。 Moving the device A in order to increase the length (Photo 1).
2. 帶子無法通過 (第一次穿帶通過) 帶子拈引裝置無法捉到帶子拈頭。 2. The strap could not through. The grabber cannot catch it.	a. 帶子頭裝入有問題 a. The front part of the strap installed incorrect.	將帶子頭靠拈引裝置接收裝置的裡側後再 開動機器。 Move the strap more inside then start the machine.
	b. 帶子頭的長度過短。 b. The front part of the strap is too short.	減短帶子拈引移動旋轉抑制器的長度 A (照片 1)。 Moving the device A in order to reduce the length (Photo 1).
3. 調節器規格長度小於 50mm 3. The length regulator is within 50 mm	調節器長度的調整不適。 The length of regulator is incorrect.	按規格式樣的長度調整 (照片 2)。 According to the specification to adjust the length (Photo 2).

〔照片 1〕 調整穿帶子部位的長度 Adjust the length of strap through part (Photo 1).

A 放長，穿帶處則短。 A put it longer, the through part will getting shorter.
A 放短，穿帶處則長。 A put it shorter, the through part will getting longer.

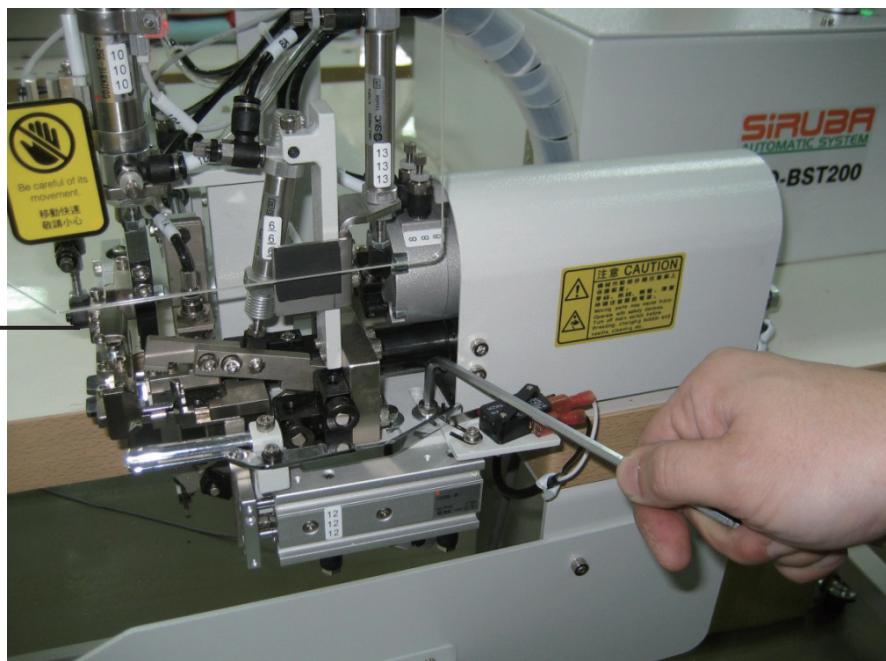


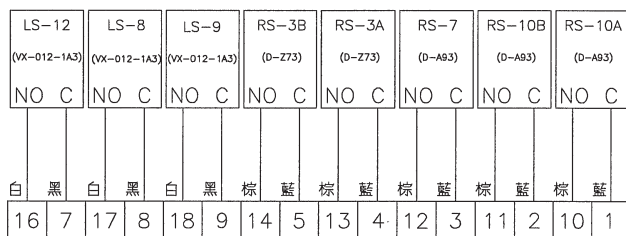
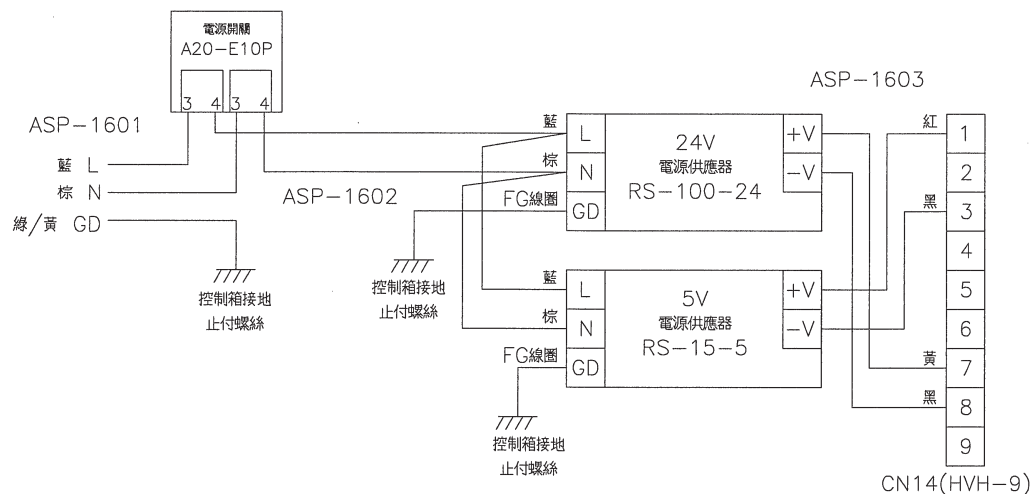
〔照片 2〕 調節器的長度調整 Adjust the length of regulator (Photo 2).

可變短
Become shorter

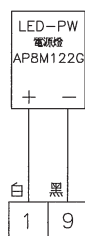


可以變長
(向身體方向拉)
Become longer
(Pull toward to the body)

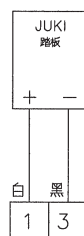




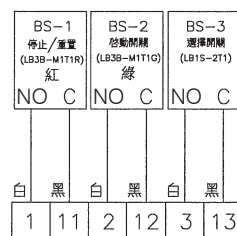
ASP-1604 CN11(6657R1-18)



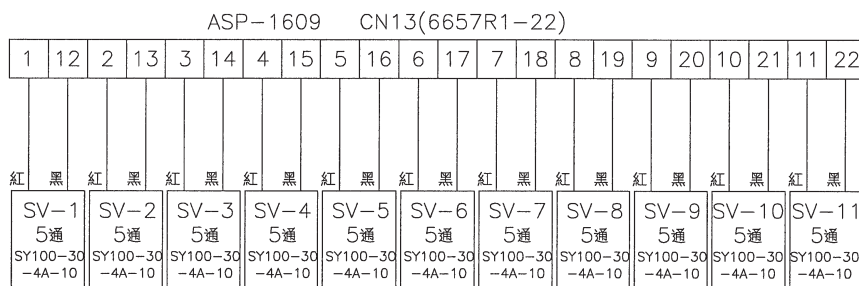
CN12
(6657R1-16) ASP-1607



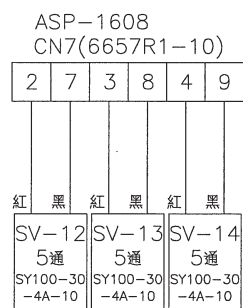
CN5
(6657R1-4) ASP-1606



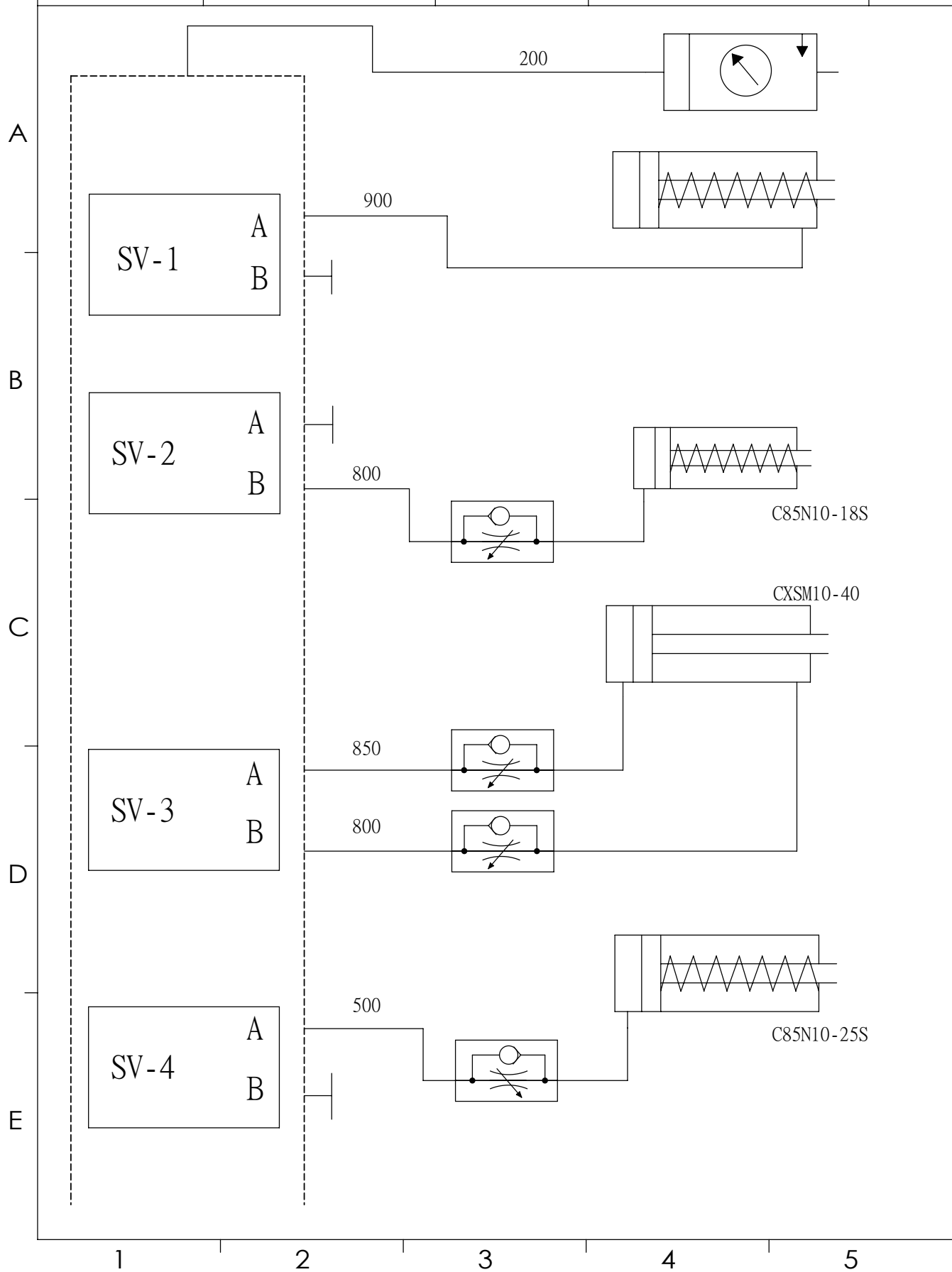
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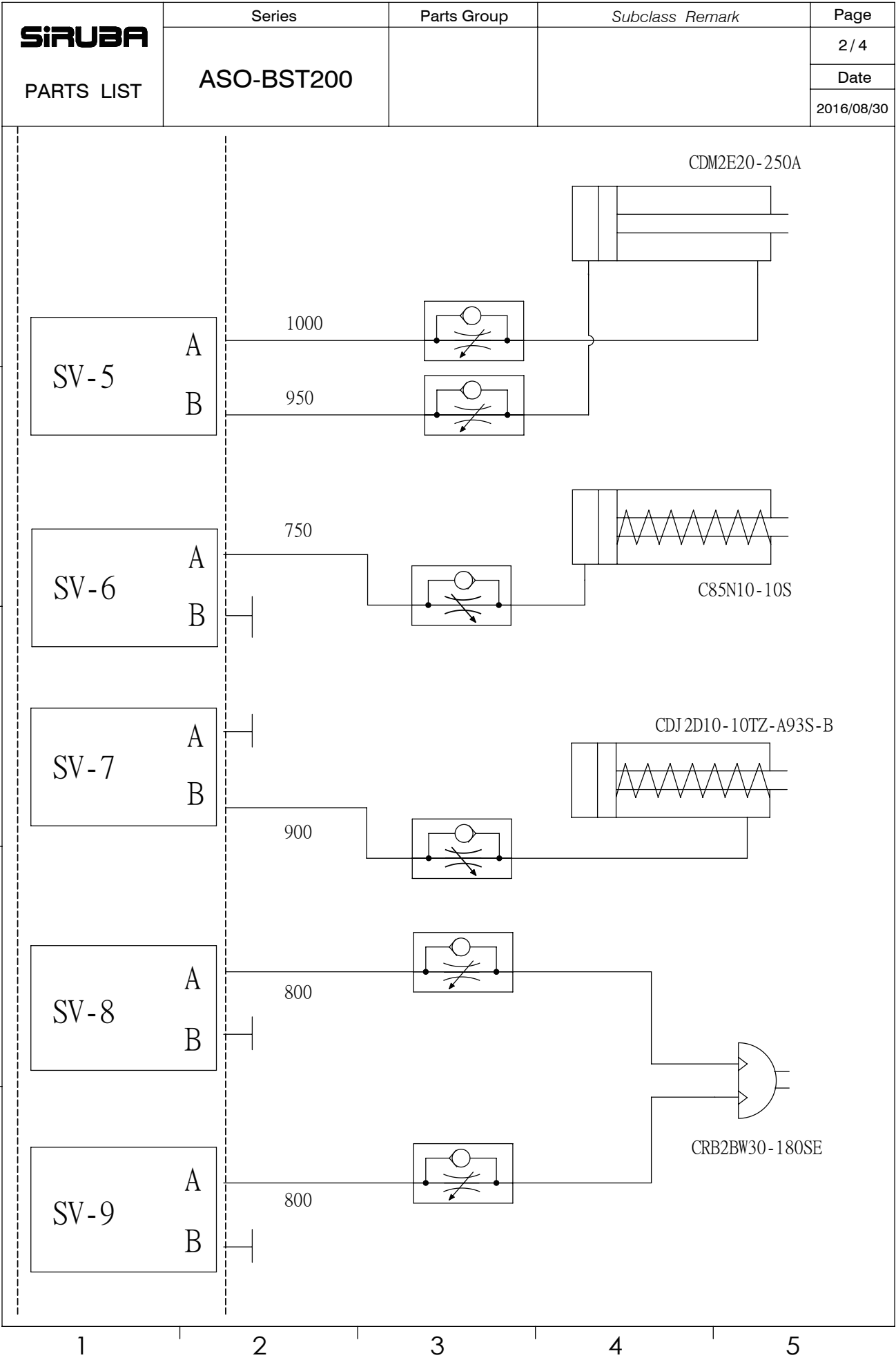


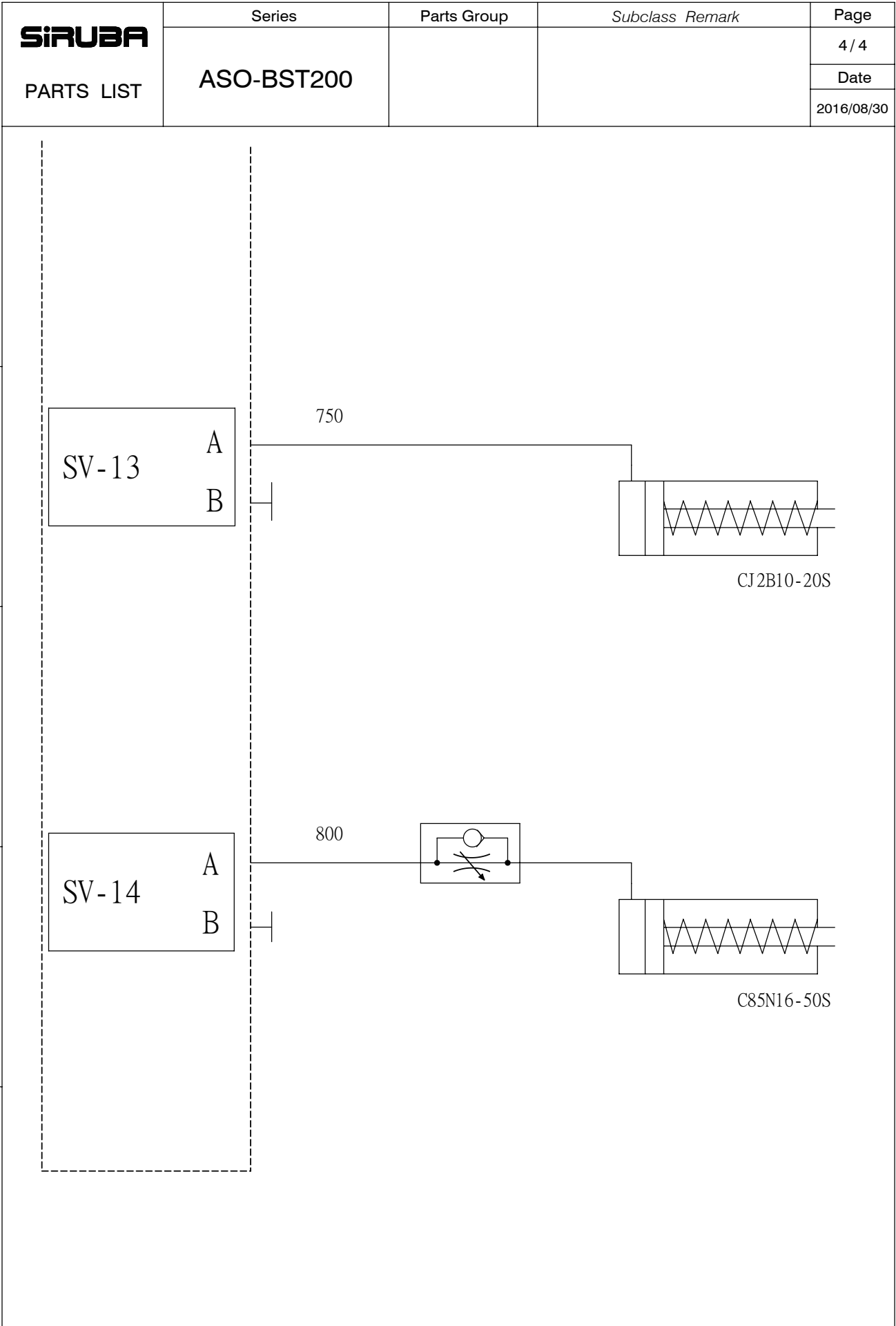
ASP-1609 CN13(6657R1-22)



ASP-1608
CN7(6657R1-10)









 **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 the equipment described in the instruction book are subject to
change because of modification with out previous notice
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