

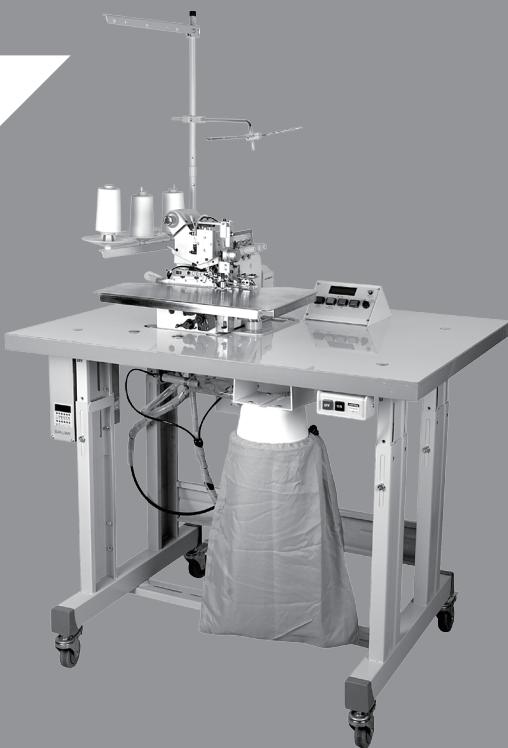
SiRUBA® Sew Reach

使用說明書與零件圖

INSTRUCTION BOOK & PARTS LIST

ASK-ESG100

CE



危險水準的說明 Explanation of Dangerous Level

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

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

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

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規格

SPECIFICATIONS

本說明書僅以 ASK-ESG100 說明

Only describe ASK-ESG100 in this manual

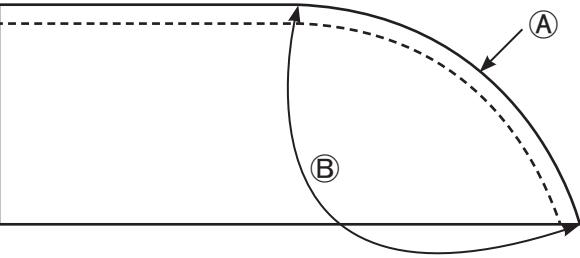
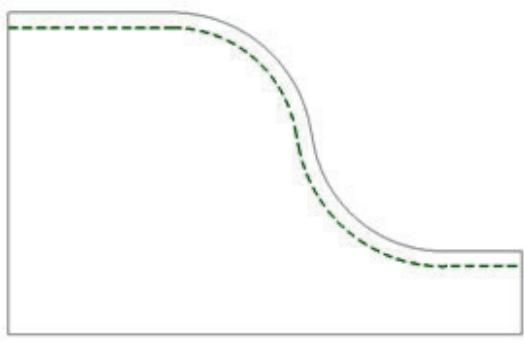
1. 產品規格 (表 1)

1. Product Specification(Table1)

機種別 Machine Type	ASK-ESG100
搭載機頭	SIRUBA 737K
電源電壓 Power Voltage	單相 220V 定格 ±20% 50/60Hz Single Phase 220V Rated ±20% 50/60Hz
空氣壓力 Air pressure	0.5 Mpa
布料 Cloth	平織布 plain weave
布料重量 Cloth weight	10 盎司以上 10 ounces or more
差動比 Differential ratio	0.7~2.0
包邊寬度 Cover edge width	4、4.8、5.6 mm
壓腳上升量 Presser foot rise amount	6mm
針 Needle	DC X 27 (#11)

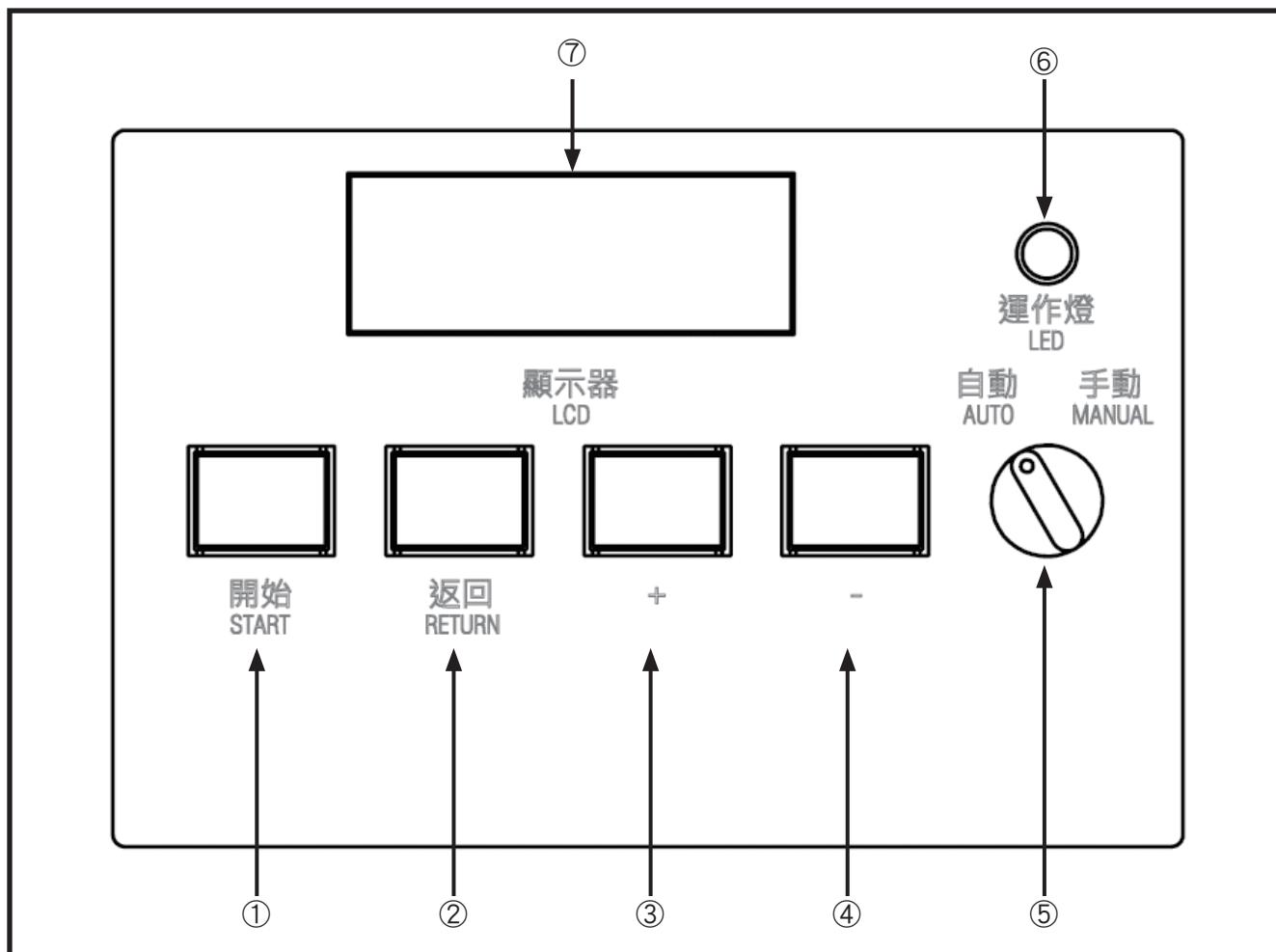
2. 布料形狀 (圖表 1)

2. Cloth Shape(Chart1)

適用形狀 Available Shape	不適用形狀 Unavailable Shape
	
A 尺寸 : R50mm 以上 B 尺寸 : 90~180° A size : R50mm or more B size : 90~180°	

按鍵說明

KEY DESCRIPTION



項目 Item	名稱 Name	說明 Description
①	開始 Start	自動模式下： 1. 啟動自動縫製。 2. 長按 3 秒後 進入 u 參數。 3. 儲存參數設定值。
②	返回 Return	In automatic mode: 1. Start automatic sewing 2. Long press 3 seconds to enter the u parameter 3. Save the parameter settings
③	+	跳出參數模式 Jump out of parameters
④	-	選擇參數，調整參數模式或數值 Select the parameter, adjust the parameter or value
⑤	模式切換 Mode Crossover	選擇參數，調整參數模式或數值 Select the parameter, adjust the parameter or value
⑥	運作燈 Operating Lights	可選擇自動模式或手動模式 Optional automatic mode or manual mode
⑦	液晶顯示 Lcd	燈亮再縫製模式 Lamp lights up in sewing mode
		顯示參數內容 Display the contents of the parameter

操作說明

OPERATING INSTRUCTION

a. 自動模式：

※ 進入縫製：



將開關選至自動
Select the switch
to auto

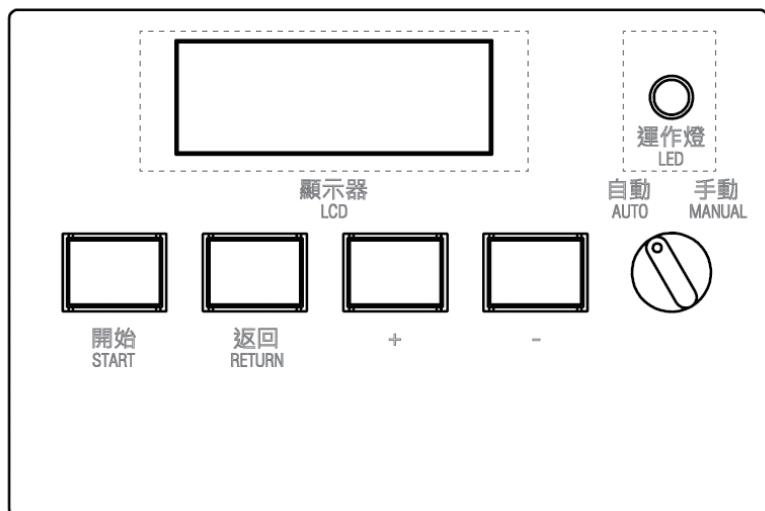
按開始鍵
Press the
start key

當運作燈亮起和 LCD 顯示動作模式，即
可縫製

When the operation light is on and LCD
shows the action mode can be sewn

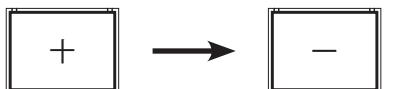
a. Automatic mode

※ Enter sewing



※ 回復初始值：

(只可在自動模式下)



同時按下 + 和 – 鍵
Press the + and – keys at
the same time

※ Reply to the initial value
(Only in automatic mode)

Reset Data

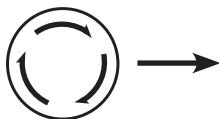
畫面顯示 Reset Data
The screen displays reset
data

※ 緊急停止：

當機台在縫製時，發生斷針、斷線、運作時
發生故障情形，按下此鍵可立即停止所有動
作。

※ Emergency stop

When the machine in the sewing process
broke broken, the operation of the failure
situation, press this button to immediately
stop all actions.



緊急停止鍵
Emergency stop key

Stop
Press Reset

畫面顯示停止
The screen display stop

→ + → -

故障排除後，按下返回鍵和 + 鍵 (但
之前設定的值不會改變)
After troubleshooting, press the
return key and the + key(the
previously set value will not change)

Reset 過後，若緊急停止鍵未解除，液晶顯示
Stop Need to Release 提醒操作者未解除此按
鍵，待解除後才可繼續操作。

After reset, if the emergency stop button is
not released, the LCD is displayed stop need
to release.

Remind the operator did not release this
button, to be released before the operation.

參數項目

PARAMETER ITEM

U 參數 U Parameter		預設值 Default	範圍 Range
1	Pattern // 樣式選擇 pattern choose	P01	P01~P15
2	Rotary Solenoid // 模式選擇 Mode selection	Rotary on	Rotary on、 Rotary off
3	Choice St Mode // 直角圓弧邊選擇 Right angle arc edge selection	Curve	Curve、 Straight、C.S.
4	Ending Air Blow // 前吸風切線針數 before the suction wind tangent stitch quantity	10	1~100 st
5	Rotary_ONTime () // 電磁鐵啟動時間 electromagnet turn on time	45	5~100 ms
6	Rotary_OFFTime () // 電磁鐵停止時間 electromagnet turn off time	20	5~100 ms
7	Curve Sti. No // 圓弧角針數 arc angle stitch quantity	35	0~100 st
8	Thread Release // 圓弧角延遲鬆線針數 arc angle delay loose thread stitch quantity	35	0~100 st
9	Straight Sti. No // 直角針數 straight angle stitch quantity	3	0~100 st
10	Straight T. RLS // 直角延遲鬆線針數 straight angle delay loose thread stitch quantity	35	0~100 st
11	Air Blow Start // 後吸風延遲切線針數 after suction wind delay tangent stitch quantity	0	0~100 st
12	Blow Period // 後吸風切線針數 after suction wind tangent stitch quantity	50	0~100 st
13	Reset U All Data // 清除所有樣式 U 參數設定 Clear all pattern U parameter settings	No	Yes、No

M 參數 M paramete		預設值 default	範圍 range
1	Standby Time // 自動等待時間 standby time	150	100~1500 ms
2	Solenoid Lag // 旋轉機構延遲啟動時間 rotating mechanism delay start time	500	100~1500 ms
3	Motor Lag // 車縫延遲啟動時間 sewn delay start time	500	100~1500 ms
4	Ply Gap 車縫間隔針數 sewn interval stitch quantity	30	0~100 st
5	Stop Lag // 車縫停止延遲時間 sewn stops the delay time	200	1~250 ms
6	LCD Bright // LCD 省電模式 LCD power saving mode	auto off	auto off、on、off
7	Press Foot Down // 壓腳延遲啟動下壓時間 (只限在電磁鐵關閉模式) Presser Foot delay start push downtime (for Rotary off mode)	1000	100~1500 ms
8	Suction Period // 前吸風切線時間 (只限在電磁鐵關閉模式) before the suction wind tangent time (for Rotary off mode)	600	100~1500 ms
9	Suction Lag // 後吸風切線時間 (只限在電磁鐵關閉模式) after suction wind tangent time (for Rotary off mode)	1500	100~1500 ms
10	T. RLS Period // 鬆線時間 (只限在電磁鐵關閉模式) loose thread time (for Rotary off mode)	400	100~1500 ms
11	Press Foot Lift Lag // 壓腳抬起延遲時間 (只限在電磁鐵關閉模式) presser foot lift up delay time(for Rotary off mode)	200	100~1000 ms
12	Reset Data Reg // 清除 M 參數設定 Clear M parameter settings	No	Yes、No
13	Rotary Test // 電磁鐵測試 electromagnet test		

參數說明

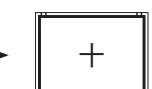
PANAMETER INTRODUCTION

U 參數

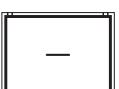
(1) U01 樣式選擇



長按開始鍵三秒
Long press start key for 3 seconds



按 +、- 項目選擇
Press the +,- select key



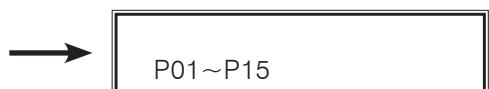
→

Parameter U

(1) U01 pattern choose



按開始鍵
Press the start key



選擇樣式組數，共 15 組
Choose a set of styles, a total of 15 groups



按開始鍵
Press the start key



按返回鍵回主畫面
Press the return key to return to the main screen

(2) U02 模式選擇

(2) U02 Mode selection



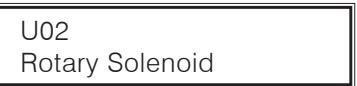
長按開始鍵三秒
Long press start key for 3 seconds



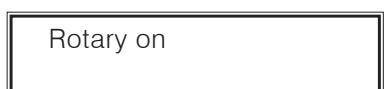
按 +、- 項目選擇
Press the +,- select key



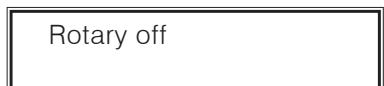
→



按開始鍵
Press the start key



or



按 +- 選擇鍵選擇 Rotary On
或 Rotary Off

Press the +- select key to
select Rotary On or Rotary Off

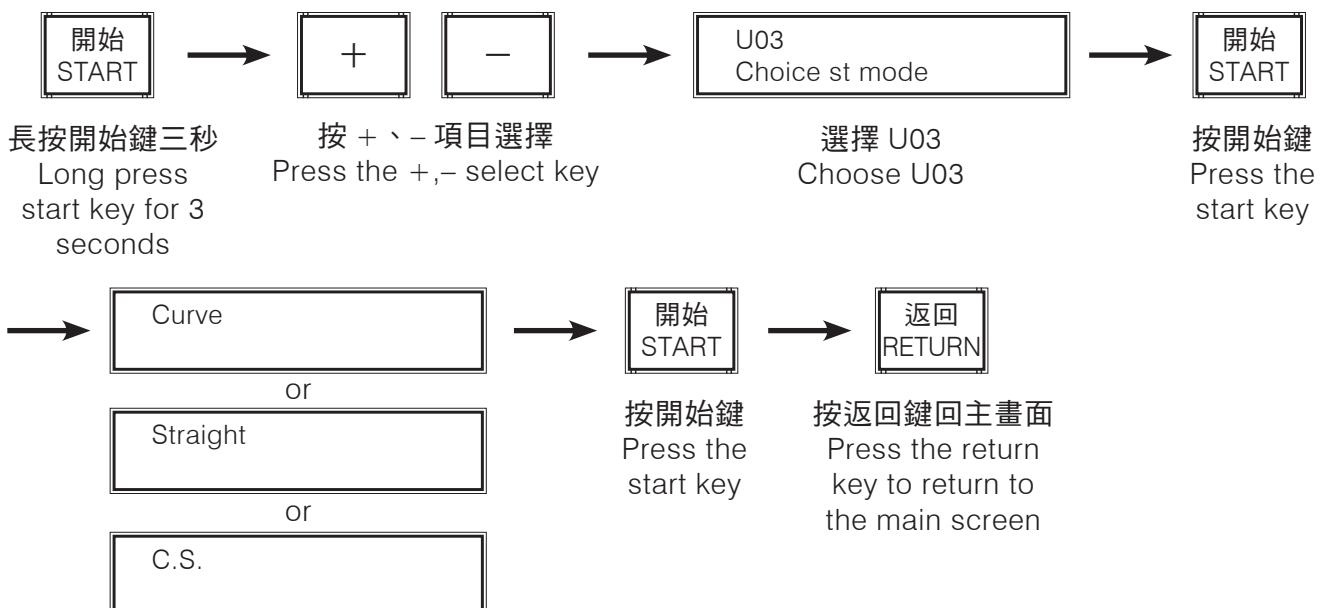


按開始鍵
Press the start key



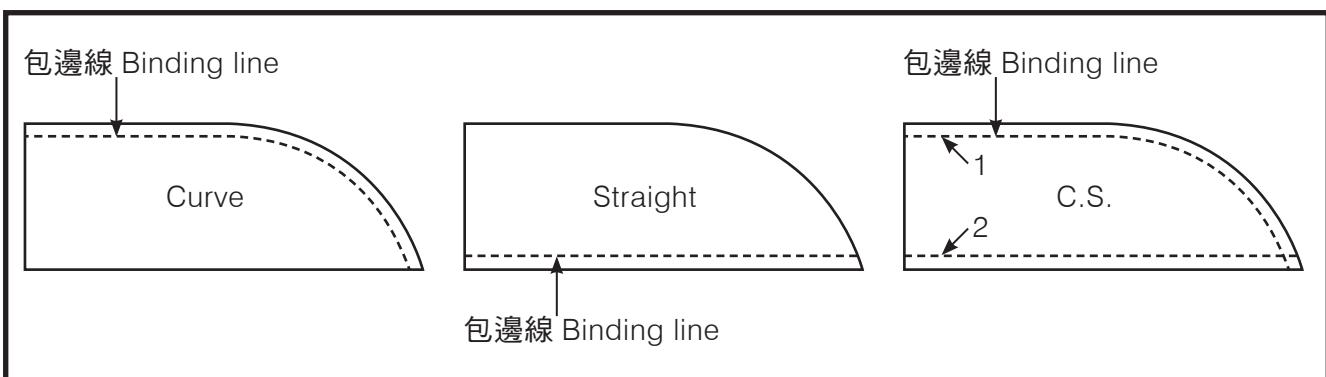
按返回鍵回主畫面
Press the return key to return to the main screen

(3) U03 直角圓弧邊選擇

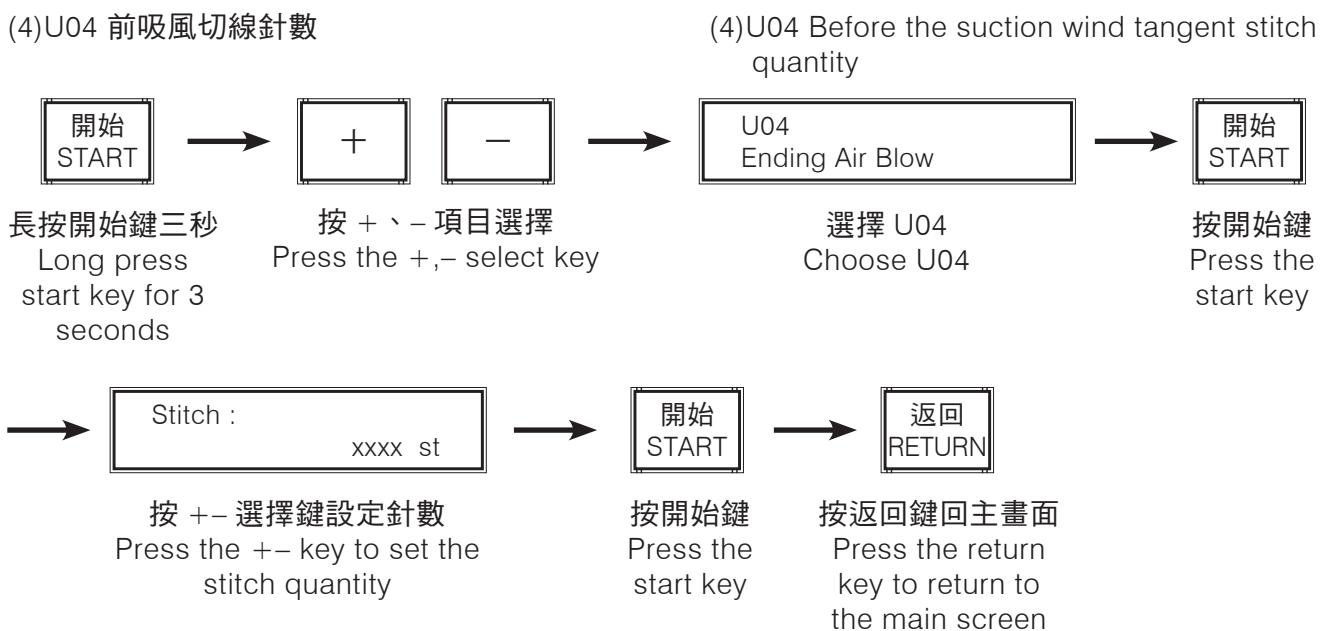


按 +- 選擇鍵選擇 Curve 或 Straight 或 C.S.

Press the +- select key to select curve or straight or C.S.

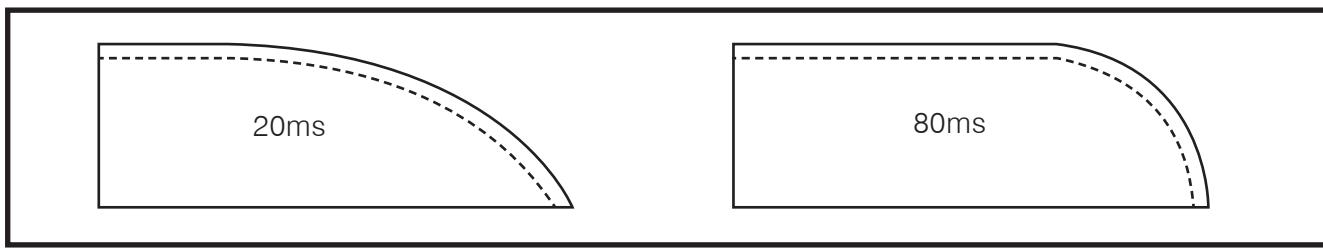
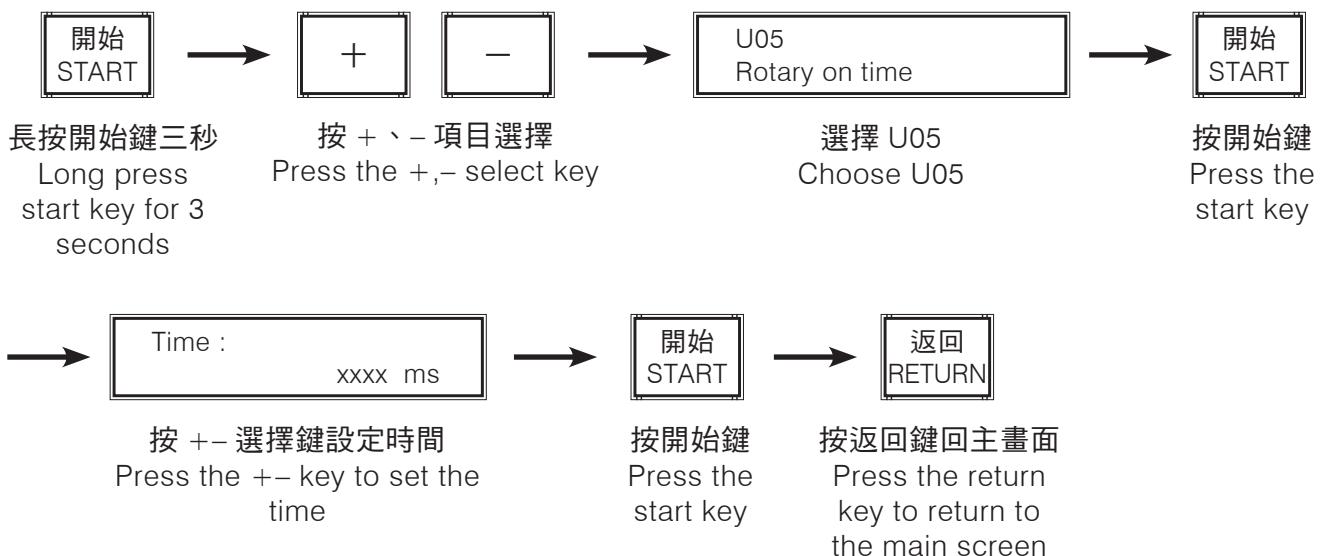


(4) U04 前吸風切線針數

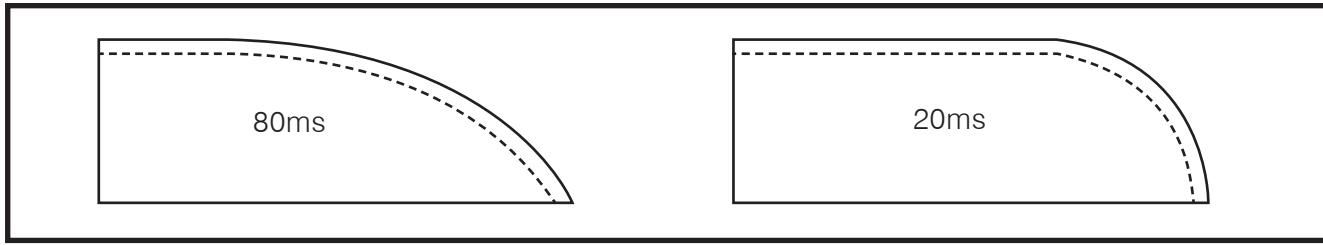
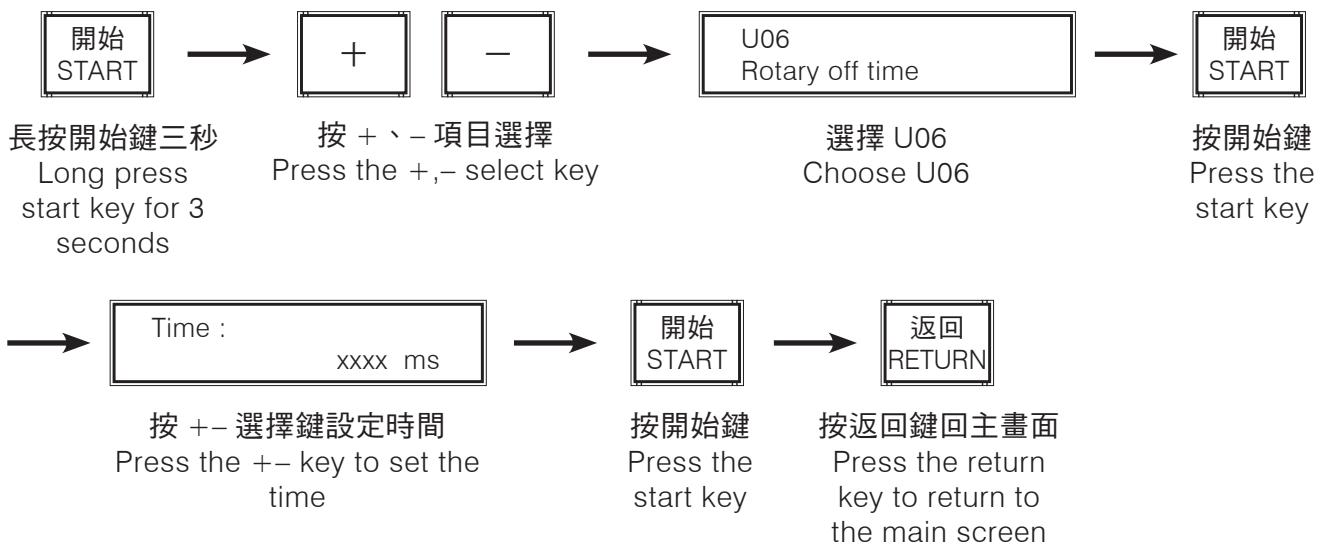


(4) U04 Before the suction wind tangent stitch quantity

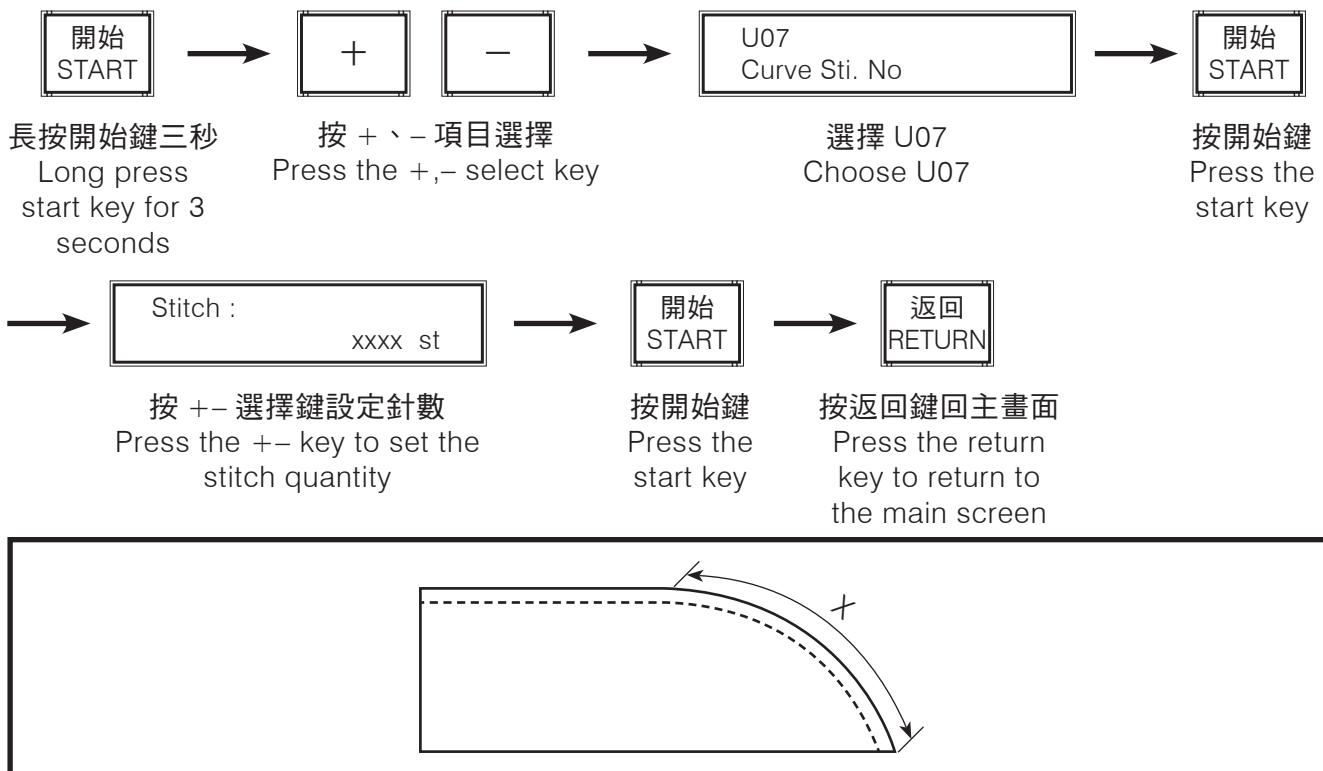
(5)U05 電磁鐵啟動時間



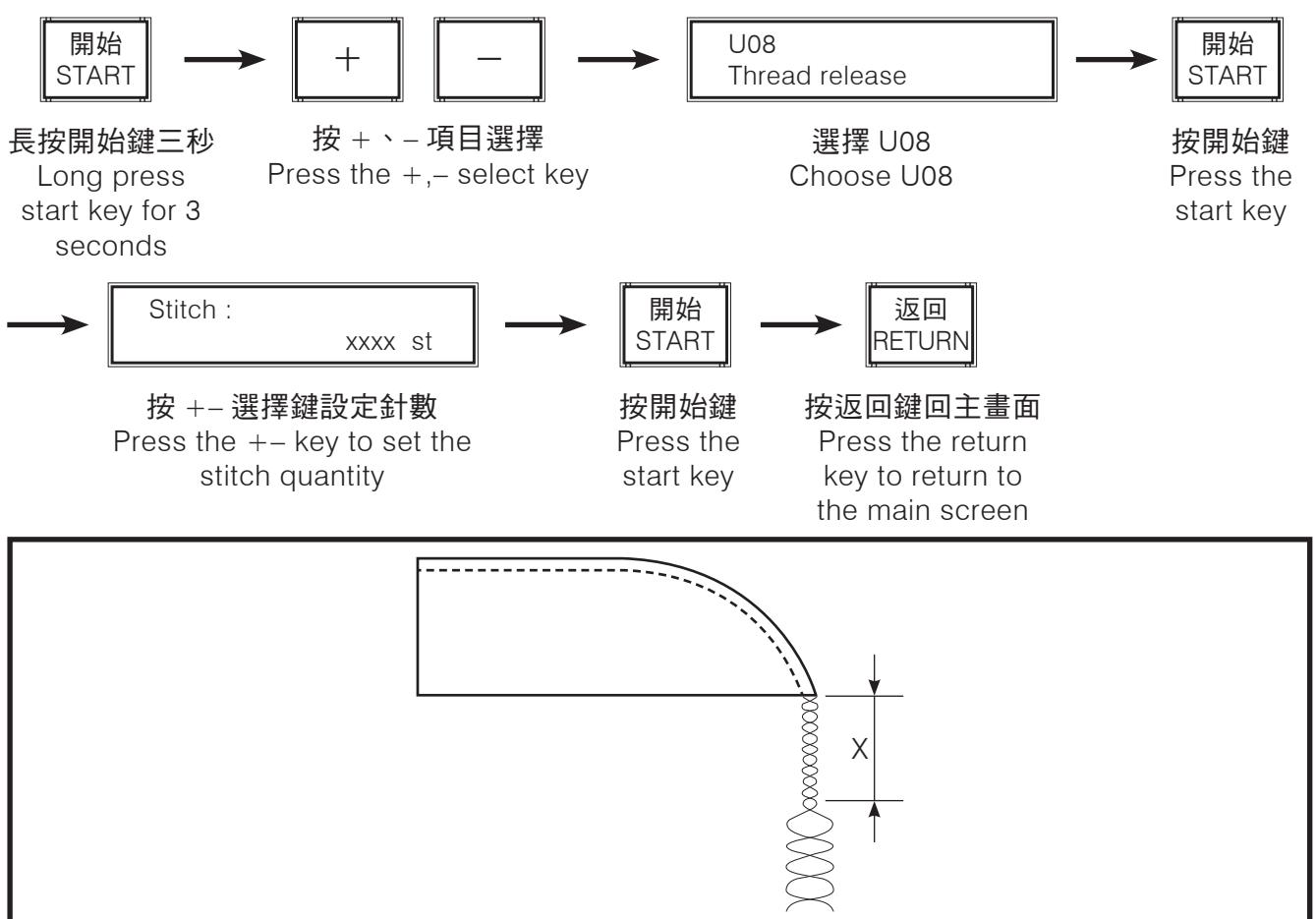
(6)U06 電磁鐵停止時間



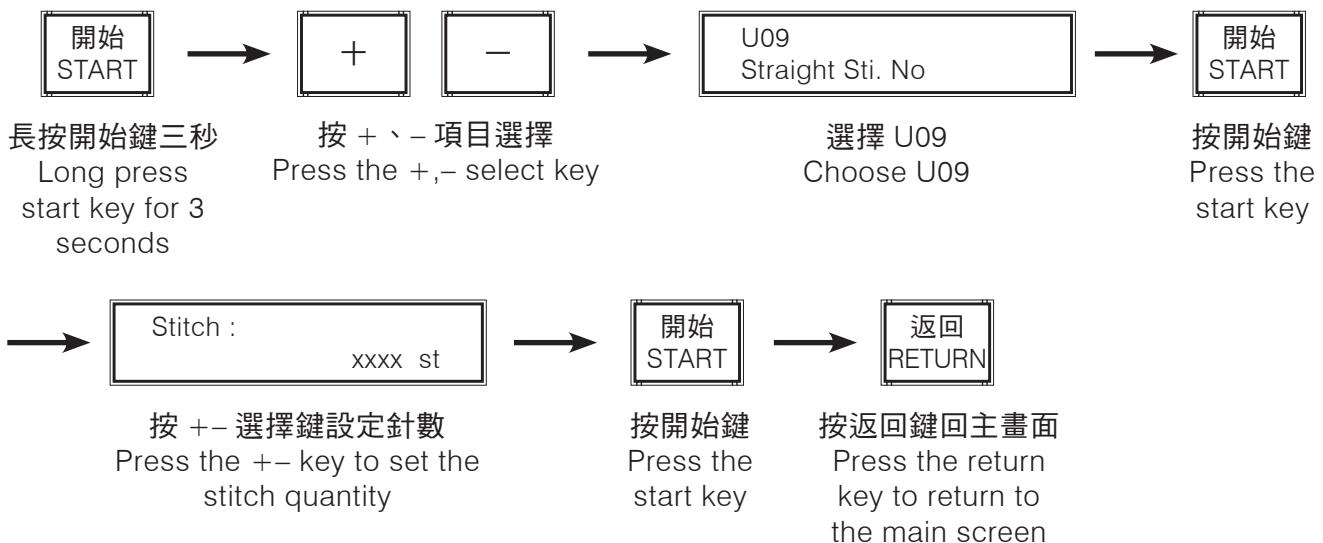
(7)U07 圓弧角針數



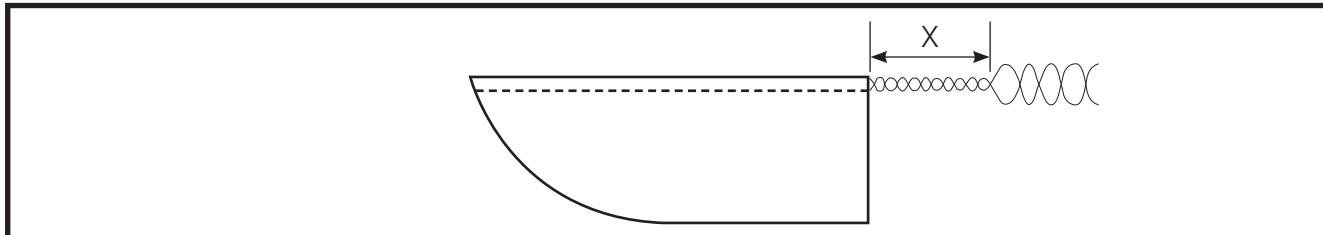
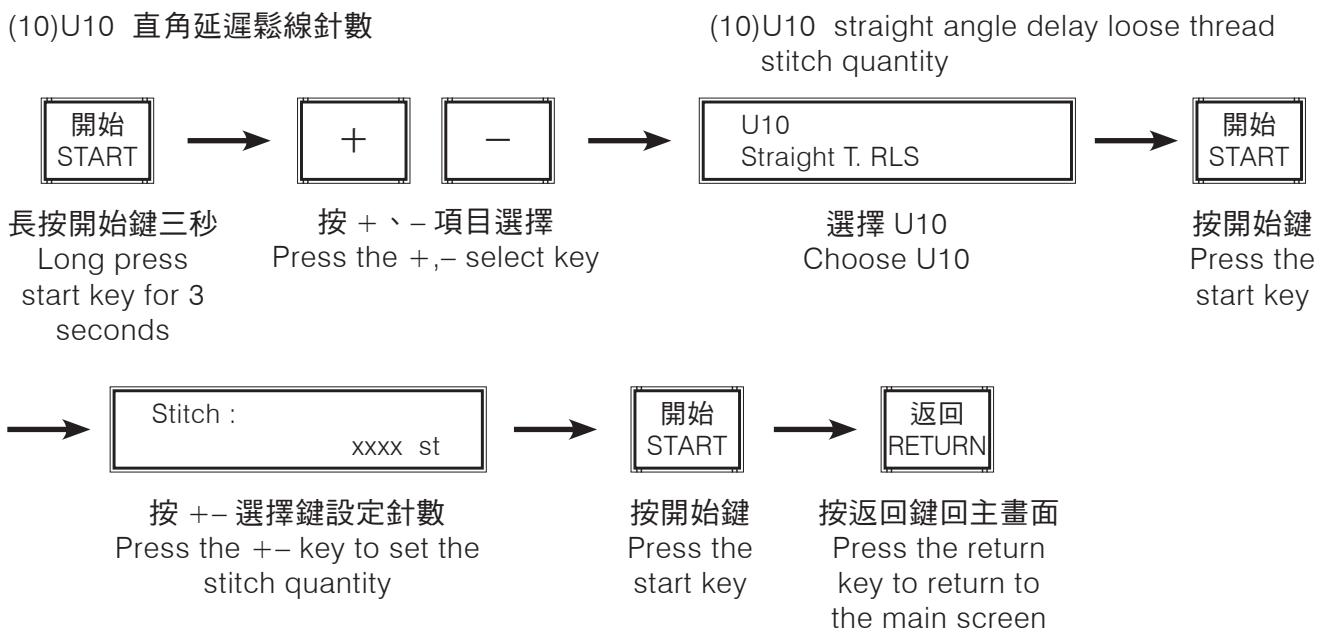
(8)U08 圓弧角延遲鬆線針數



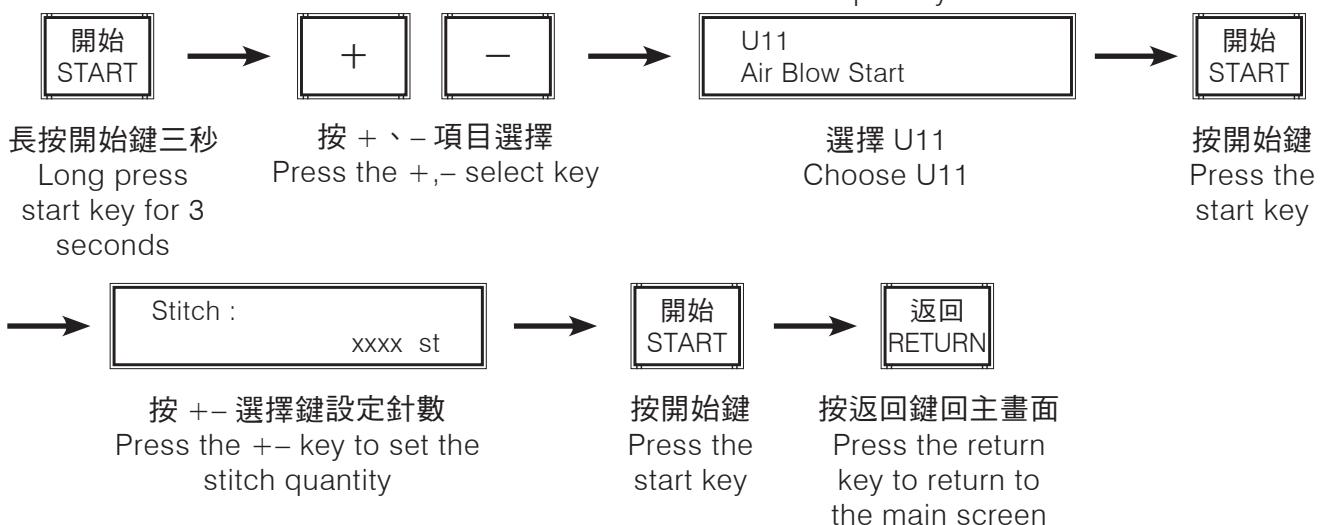
(9)U09 直角針數



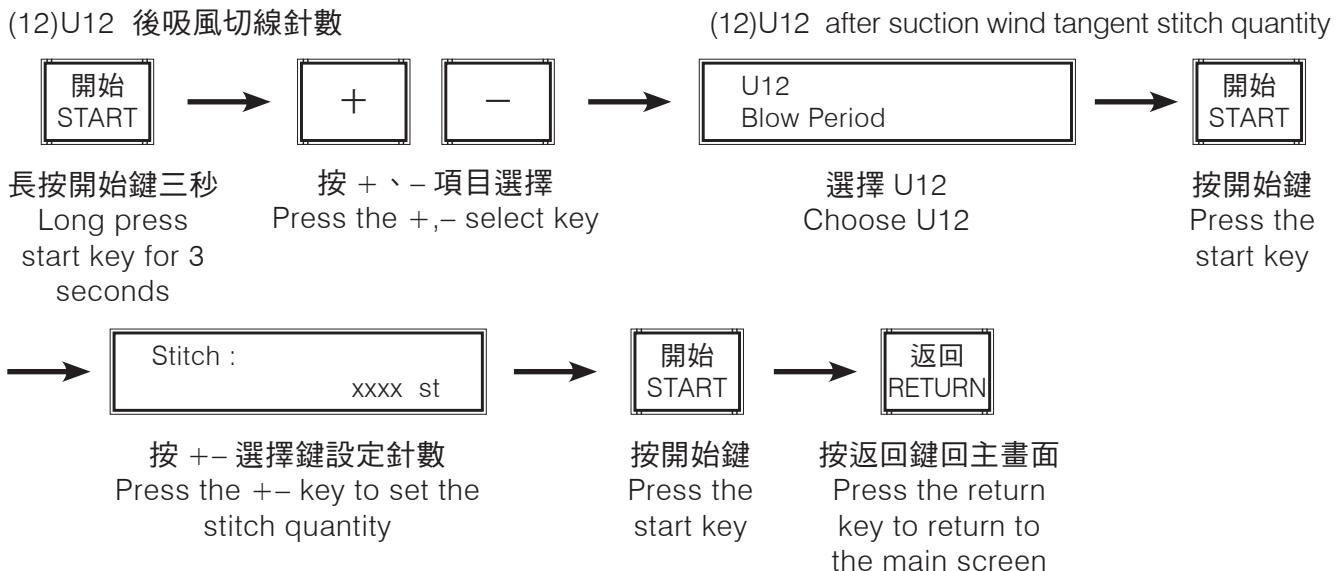
(10)U10 直角延遲鬆線針數



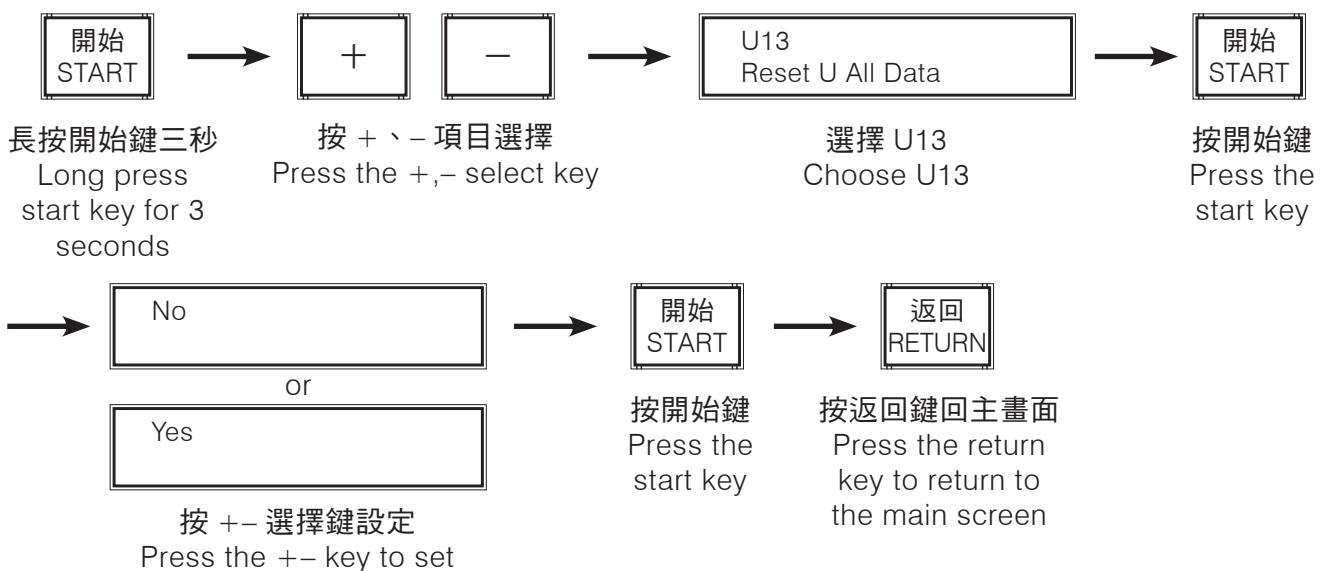
(11)U11 後吸風延遲切線針數



(12)U12 後吸風切線針數



(13)U13 清除所有樣式 U 參數設定



M 參數

(1)M01 自動等待時間



長按開始鍵與 + 鍵三秒
long press start key
and + key at the same
time for 3 seconds



按 +、- 項目選擇
Press the +,- select key

Parameter M

(1)M01 standby time

M01
Standby Time

選擇 M01
Choose M01



按開始鍵
Press the
start key



按 +、- 選擇鍵設定時間
Press the +- key to set the
time



按開始鍵
Press the
start key



按返回鍵回主畫面
Press the return key to
return to the main screen

(2)M02 旋轉機構延遲啟動時間

(2)M02 Rotating mechanism delay start time



長按開始鍵與 + 鍵三秒
long press start key
and + key at the same
time for 3 seconds



按 +、- 項目選擇
Press the +,- select key

選擇 M02
Choose M02



按開始鍵
Press the
start key



按 +、- 選擇鍵設定時間
Press the +- key to set the
time



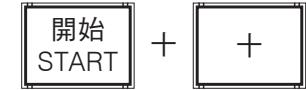
按開始鍵
Press the
start key



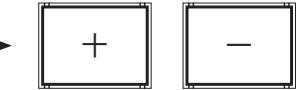
按返回鍵回主畫面
Press the return key to
return to the main screen

(3)M03 車縫延遲啟動時間

(3)M03 sewn delay start time



長按開始鍵與 + 鍵三秒
long press start key
and + key at the same
time for 3 seconds



按 +、- 項目選擇
Press the +,- select key

選擇 M03
Choose M03



按開始鍵
Press the
start key



按 +、- 選擇鍵設定時間
Press the +- key to set the
time

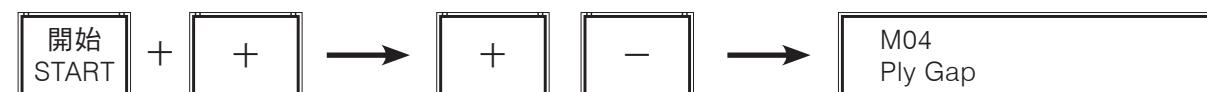


按開始鍵
Press the
start key



按返回鍵回主畫面
Press the return key to
return to the main screen

(4) M04 車縫間隔針數



長按開始鍵與 + 鍵三秒
long press start key and + key at the same time for 3 seconds

按 +、- 項目選擇
Press the +,- select key

選擇 M04
Choose M04

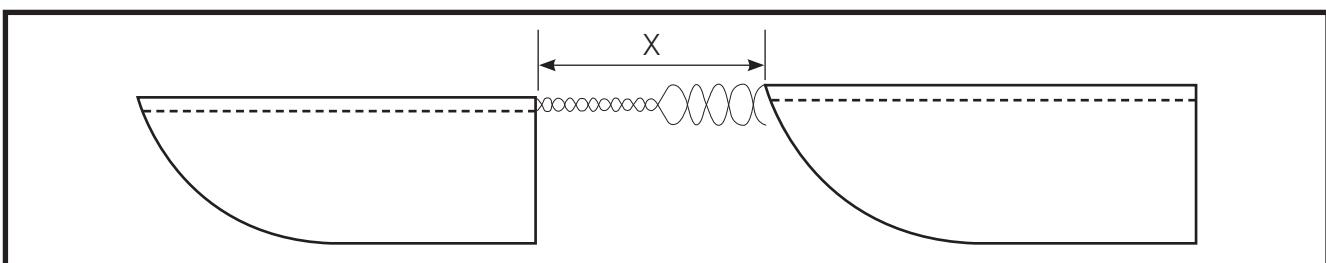


按開始鍵
Press the start key

按 +- 選擇鍵設定時間
Press the +- key to set the time

按開始鍵
Press the start key

按返回鍵回主畫面
Press the return key to return to the main screen



(5) M05 車縫停止延遲時間



長按開始鍵與 + 鍵三秒
long press start key and + key at the same time for 3 seconds

按 +、- 項目選擇
Press the +,- select key

選擇 M05
Choose M05



按開始鍵
Press the start key

按 +- 選擇鍵設定時間
Press the +- key to set the time

按開始鍵
Press the start key

按返回鍵回主畫面
Press the return key to return to the main screen

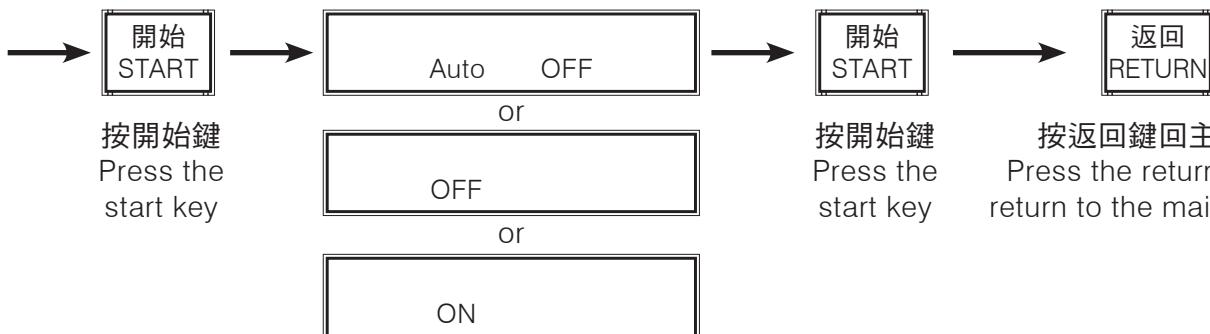
(6) M06 LCD 省電模式



長按開始鍵與 + 鍵三秒
long press start key
and + key at the same
time for 3 seconds

按 +、- 項目選擇
Press the +,- select key

選擇 M06
Choose M06



按開始鍵
Press the
start key

Auto OFF

or

OFF

or

ON

開始
START

返回
RETURN

按開始鍵
Press the
start key

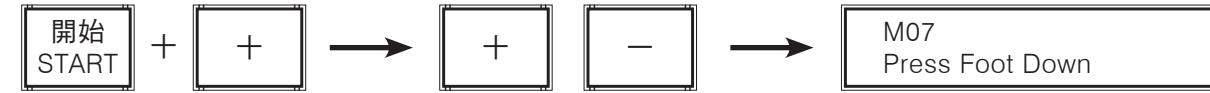
按返回鍵回主畫面
Press the return key to
return to the main screen

按 +、- 選擇鍵選擇 ON、OFF
或 Auto OFF

Press the +,- select key to
select ON or OFF or Auto OFF

(7) M07 壓腳延遲啟動下壓時間 (只限在電磁鐵
關閉模式)

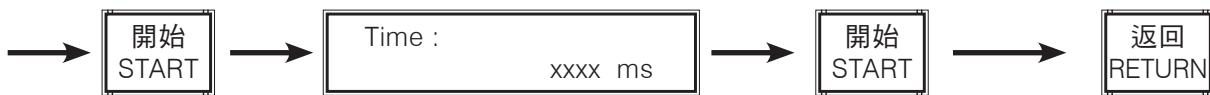
(7)M07 Presser Foot delay start push
downtime (for Rotary off mode)



長按開始鍵與 + 鍵三秒
long press start key
and + key at the same
time for 3 seconds

按 +、- 項目選擇
Press the +,- select key

選擇 M07
Choose M07



按開始鍵
Press the
start key

按 +、- 選擇鍵設定時間
Press the +,- key to set the
time

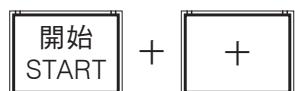
開始
START

返回
RETURN

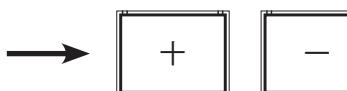
按開始鍵
Press the
start key

按返回鍵回主畫面
Press the return key to
return to the main screen

(8)M08 前吸風切線時間 (只限在電磁鐵關閉模式)

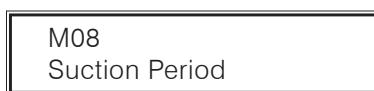


長按開始鍵與 + 鍵三秒
long press start key and + key at the same time for 3 seconds



按 +、- 項目選擇
Press the +,- select key

(8)M08 before the suction wind tangent time (for Rotary off mode)



選擇 M08
Choose M08



按開始鍵
Press the start key



按 +– 選擇鍵設定時間
Press the +- key to set the time

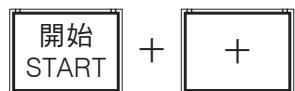


按開始鍵
Press the start key



按返回鍵回主畫面
Press the return key to return to the main screen

(9)M09 後吸風切線時間 (只限在電磁鐵關閉模式)



長按開始鍵與 + 鍵三秒
long press start key and + key at the same time for 3 seconds



按 +、- 項目選擇
Press the +,- select key

(9)M09 after suction wind tangent time (for Rotary off mode)



選擇 M09
Choose M09



按開始鍵
Press the start key



按 +– 選擇鍵設定時間
Press the +- key to set the time

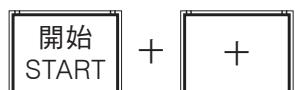


按開始鍵
Press the start key

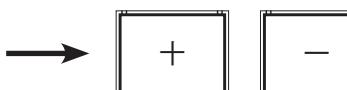


按返回鍵回主畫面
Press the return key to return to the main screen

(10)M10 鬆線時間 (只限在電磁鐵關閉模式)



長按開始鍵與 + 鍵三秒
long press start key and + key at the same time for 3 seconds



按 +、- 項目選擇
Press the +,- select key

(10)M10 loose thread (for Rotary off mode)



選擇 M10
Choose M10



按開始鍵
Press the start key



按 +– 選擇鍵設定時間
Press the +- key to set the time

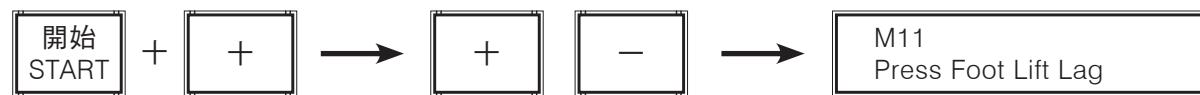


按開始鍵
Press the start key



按返回鍵回主畫面
Press the return key to return to the main screen

(11)M11 壓腳抬起延遲時間 (只限在電磁鐵關閉模式)



長按開始鍵與 + 鍵三秒
long press start key and + key at the same time for 3 seconds

按 +、- 項目選擇
Press the +,- select key

選擇 M11
Choose M11



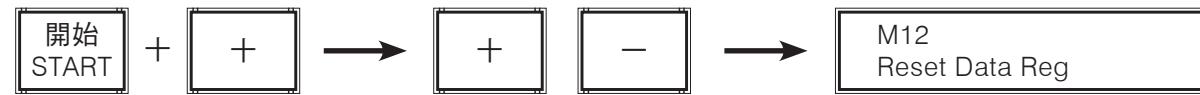
按開始鍵
Press the start key

按 +- 選擇鍵設定時間
Press the +- key to set the time

按開始鍵
Press the start key

按返回鍵回主畫面
Press the return key to return to the main screen

(12)M12 清除 M 參數設定



長按開始鍵與 + 鍵三秒
long press start key and + key at the same time for 3 seconds

按 +、- 項目選擇
Press the +,- select key

選擇 M12
Choose M12



按開始鍵
Press the start key

或
or
Yes

按開始鍵
Press the start key

按返回鍵回主畫面
Press the return key to return to the main screen

按 +- 選擇鍵選擇 No 或 Yes
Press the +- select key to select No or Yes

(13)M13 電磁鐵測試



長按開始鍵與 + 鍵三秒
long press start key and + key at the same time for 3 seconds

按 +、- 項目選擇
Press the +,- select key

選擇 M13
Choose M13



按開始鍵
Press the start key

按開始鍵
Press the start key

按返回鍵回主畫面
Press the return key to return to the main screen

(11)M11 壓腳抬起延遲時間 (只限在電磁鐵關閉模式)

(11)M11 presser foot lift up delay time(for Rotary off mode)



選擇 M11
Choose M11



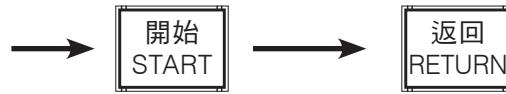
按開始鍵
Press the start key

按返回鍵回主畫面
Press the return key to return to the main screen

(12)M12 Clear M parameter settings



選擇 M12
Choose M12

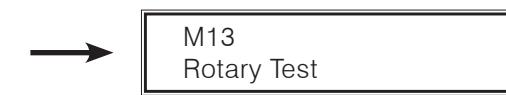


按開始鍵
Press the start key

按返回鍵回主畫面
Press the return key to return to the main screen

按 +- 選擇鍵選擇 No 或 Yes
Press the +- select key to select No or Yes

(13)M13 electromagnet test



選擇 M13
Choose M13

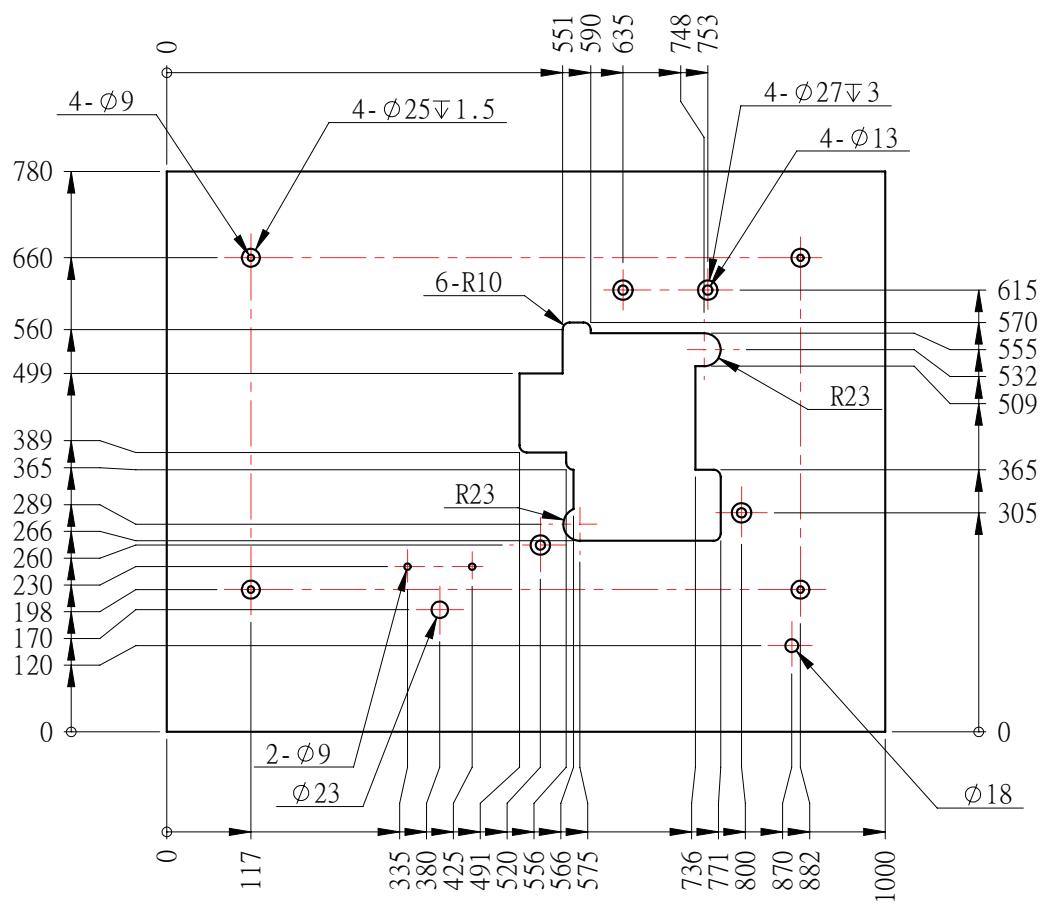


按開始鍵
Press the start key

按返回鍵回主畫面
Press the return key to return to the main screen

SIRUBA PARTS LIST	Series	Parts Group	Subclass	Remark	Page
	ESG	ASK-0025			1 / 1
					Date
					2017/3/29

A



C

D

E

1 2 3 4 5

SiRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	ESG	操作盒	ASK-0020-A	1 / 9
				Date
				2017/3/29

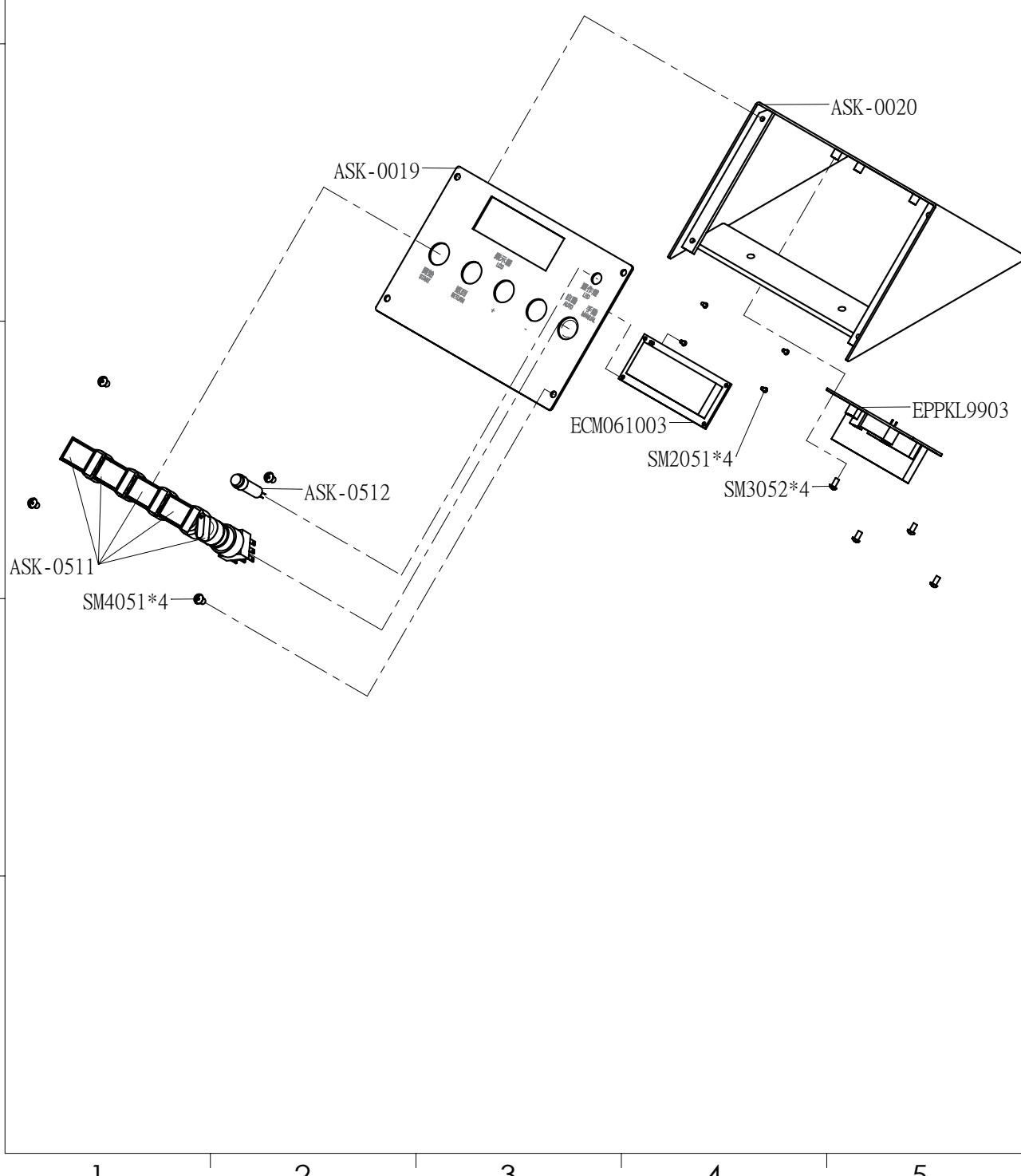
A

B

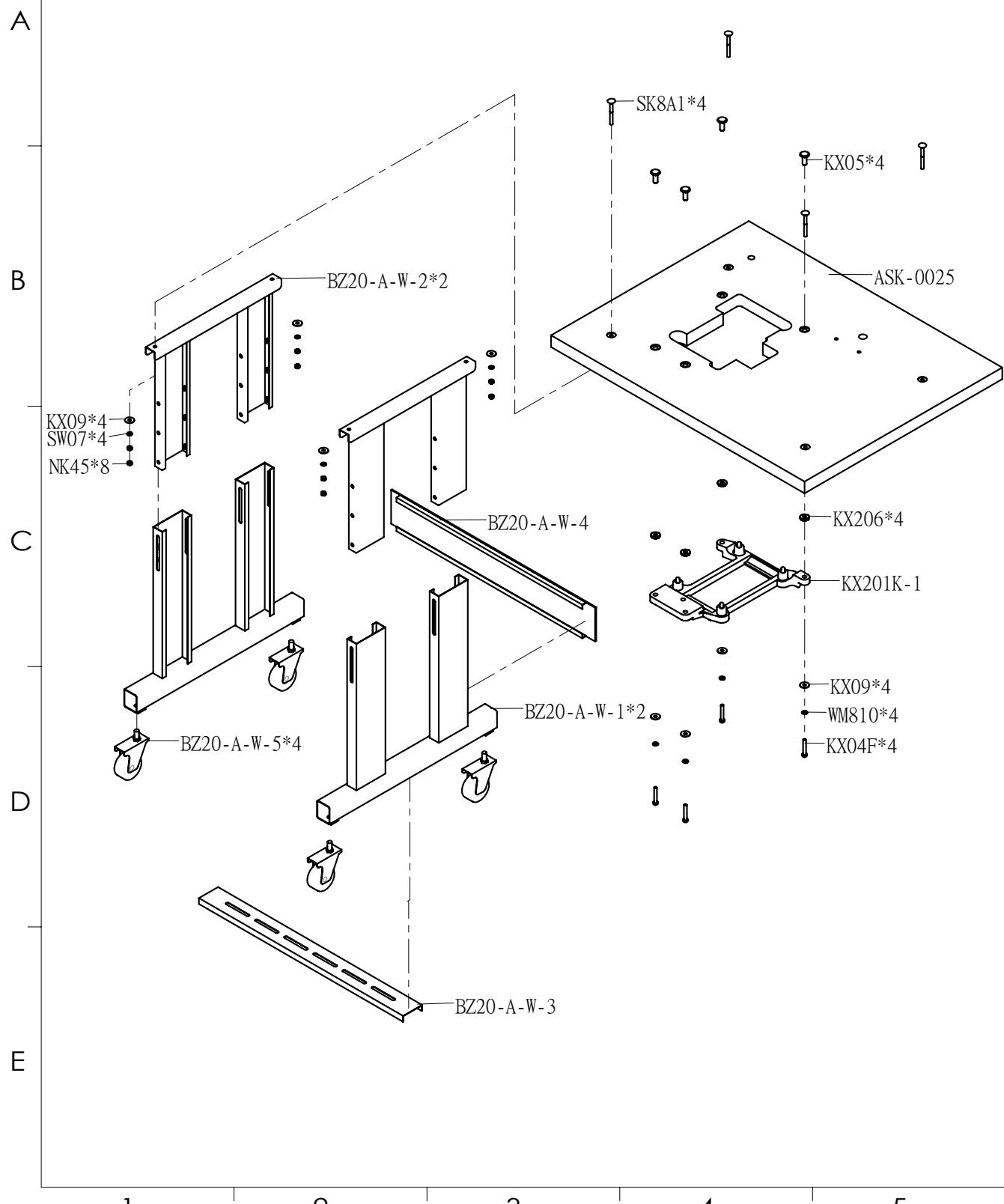
C

D

E



PARTS LIST	Series	Parts Group	Subclass	Remark	Page
	ESG100	桌板腳架組	ASK-0025-A	2/9	
				Date	
				2017/3/29	



SiRUBA PARTS LIST	Series	Parts Group	Subclass	Remark	Page
	ESG	布蓋板組	ASK-0023-A	3 / 9	
				Date	
				2017/3/29	

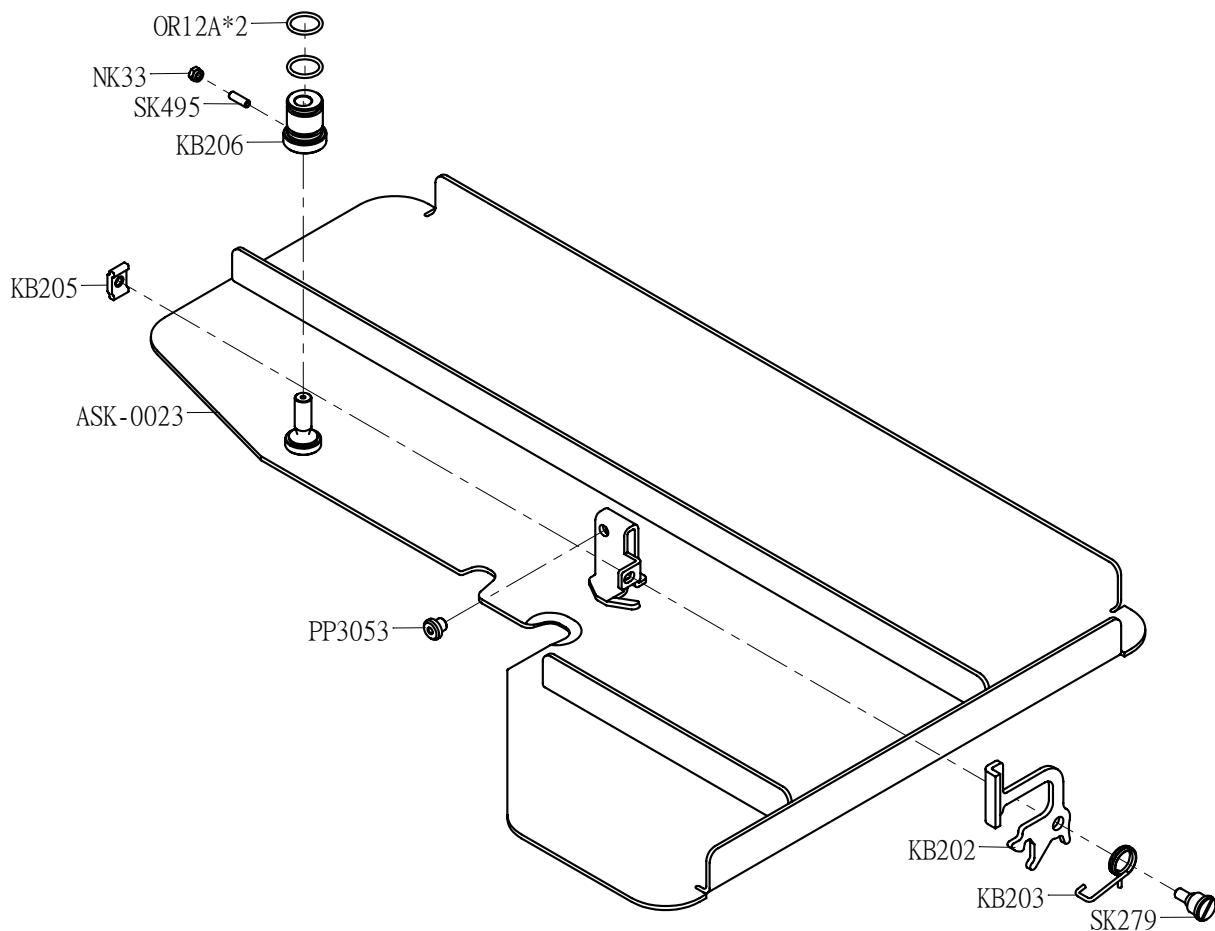
A

B

C

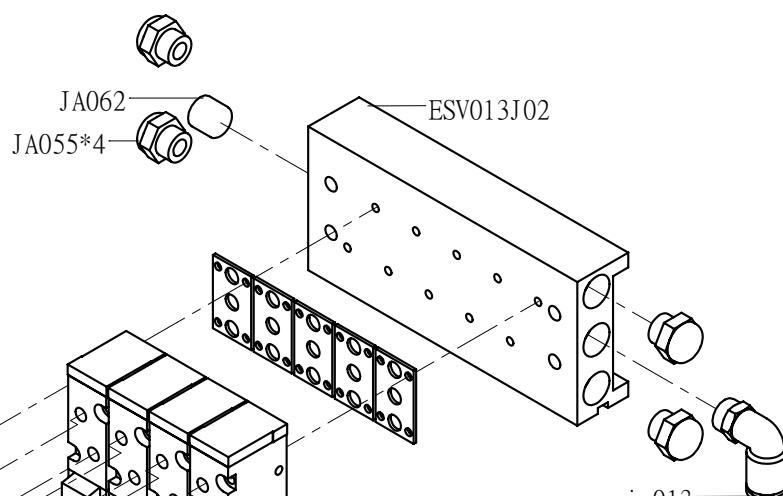
D

E

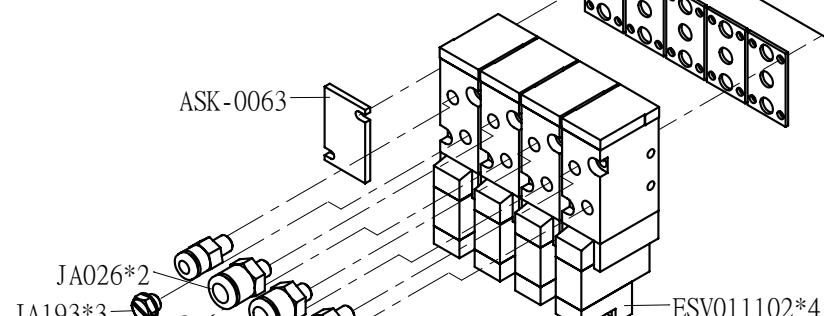


PARTS LIST	Series	Parts Group	Subclass	Remark	Page
	ESG	電磁閥組	ASK-0063-A	4 / 9	
				Date	
				2017/3/29	

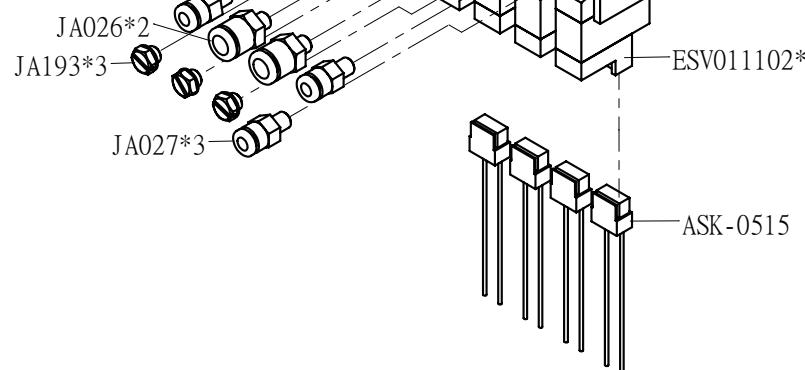
A



B



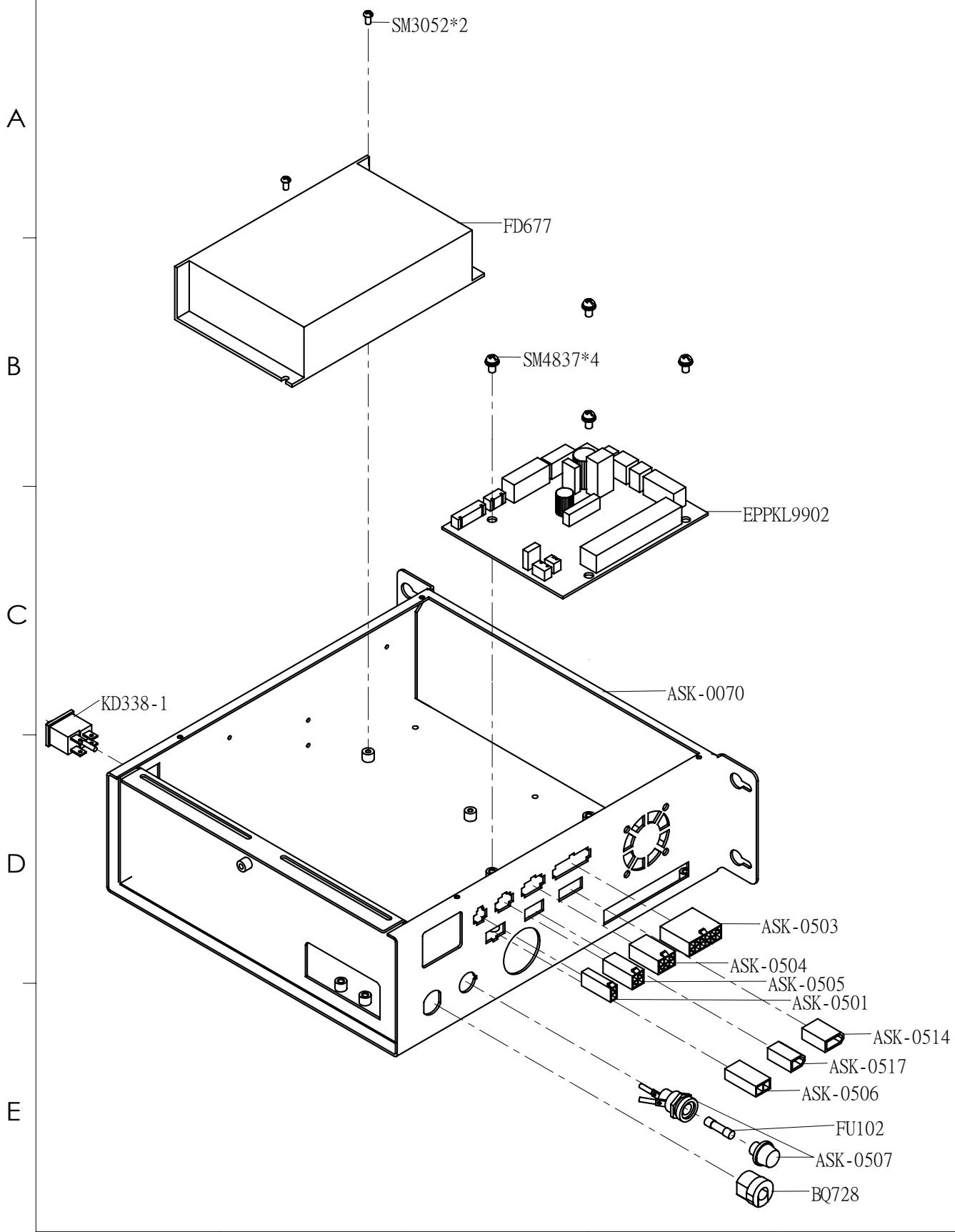
C



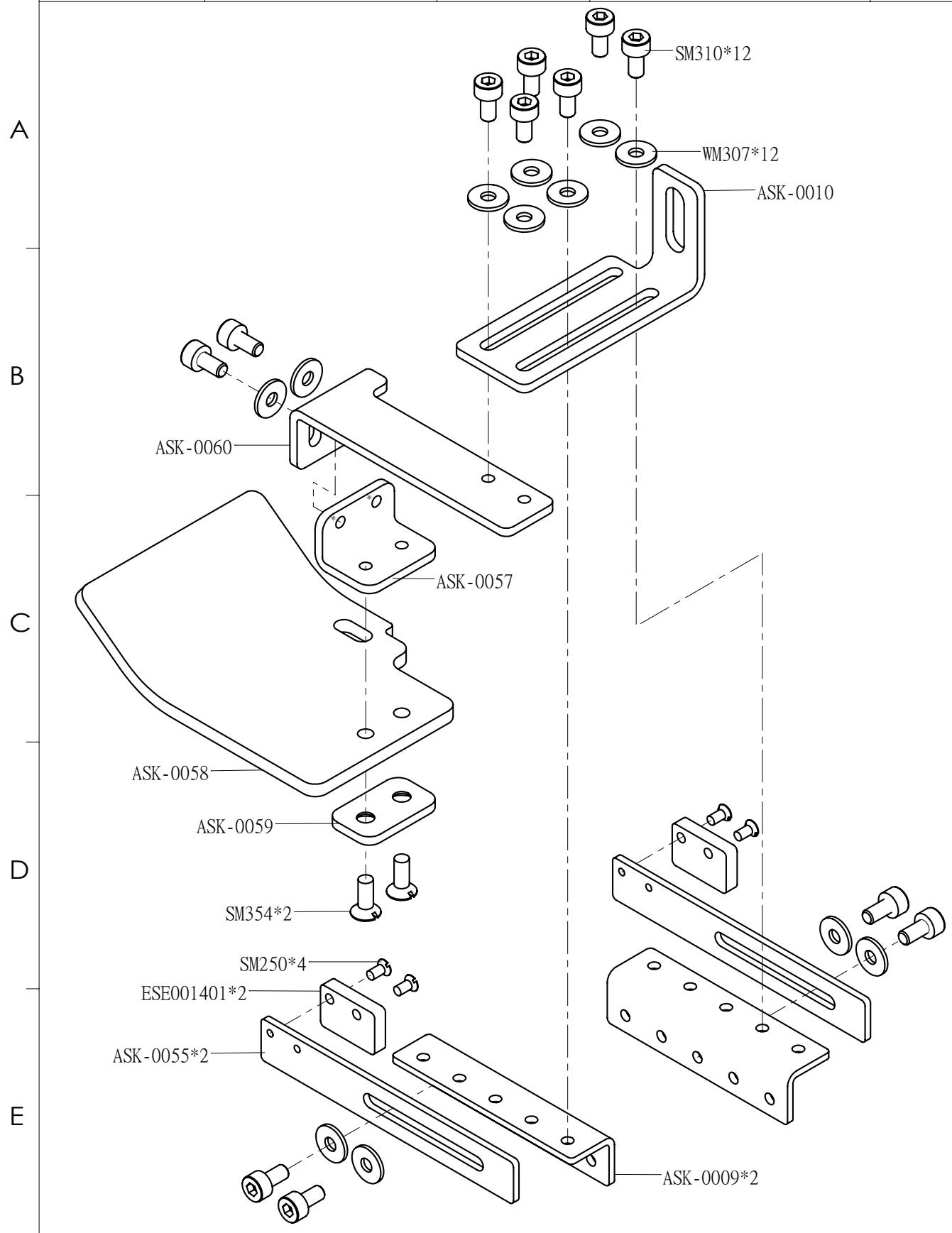
D

E

PARTS LIST	Series	Parts Group	Subclass	Remark	Page
	ESG	電控箱組	ASK-0501-A	5 / 9	
				Date	
				2017/3/29	

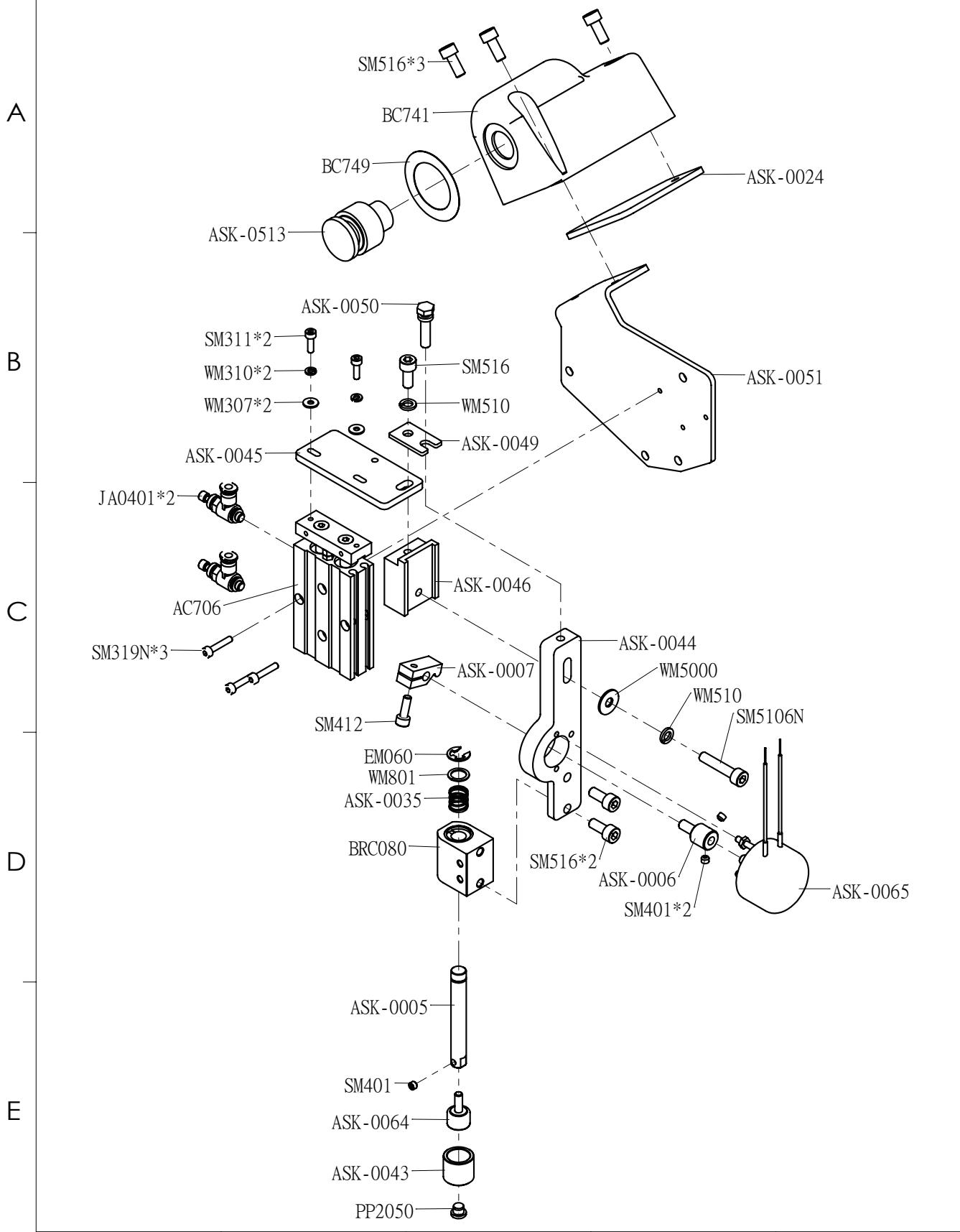


PARTS LIST	Series	Parts Group	Subclass	Remark	Page
	ESG	SENSOR組	ASK-0010-A	6 / 9	
				Date	
				2017/3/29	

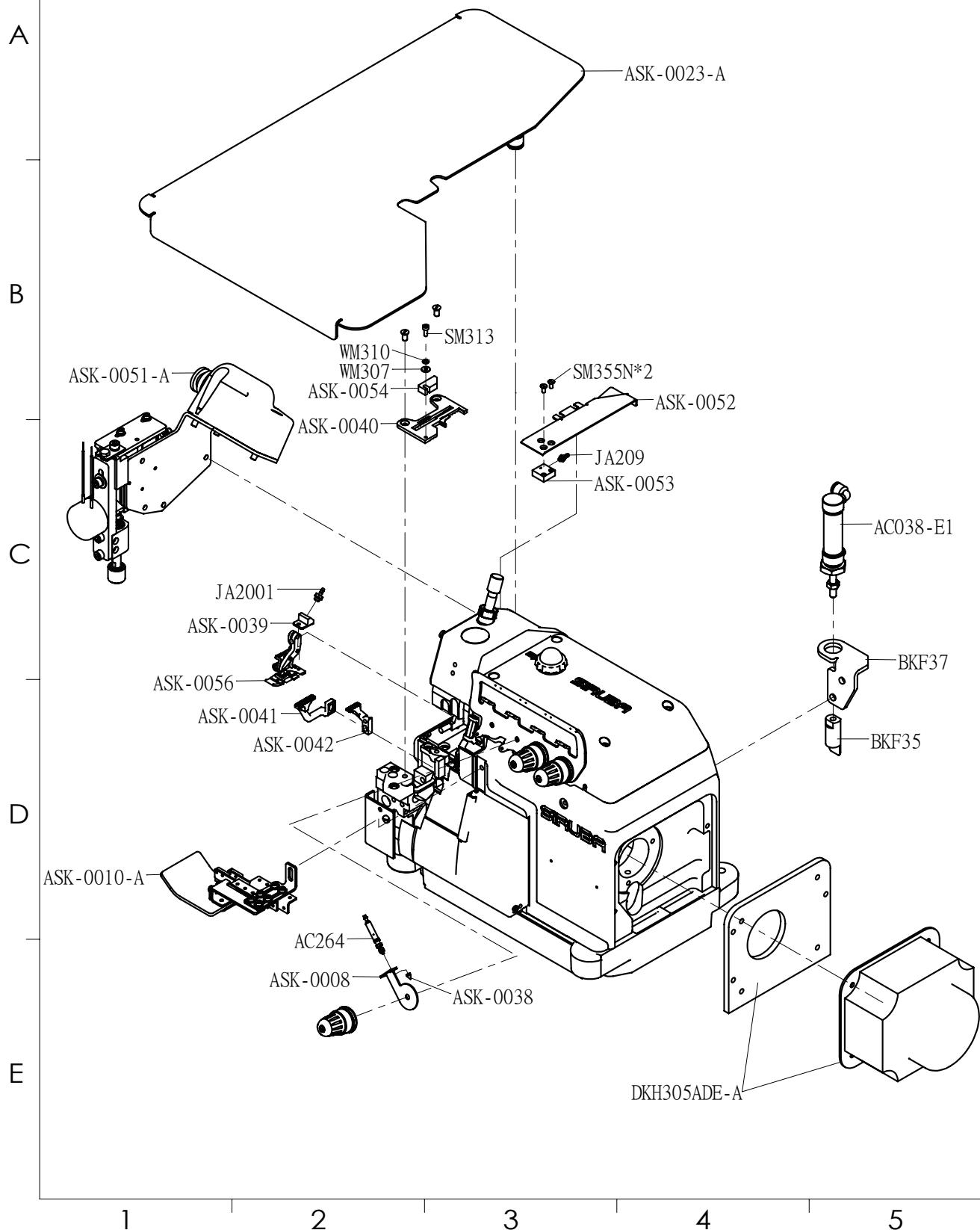


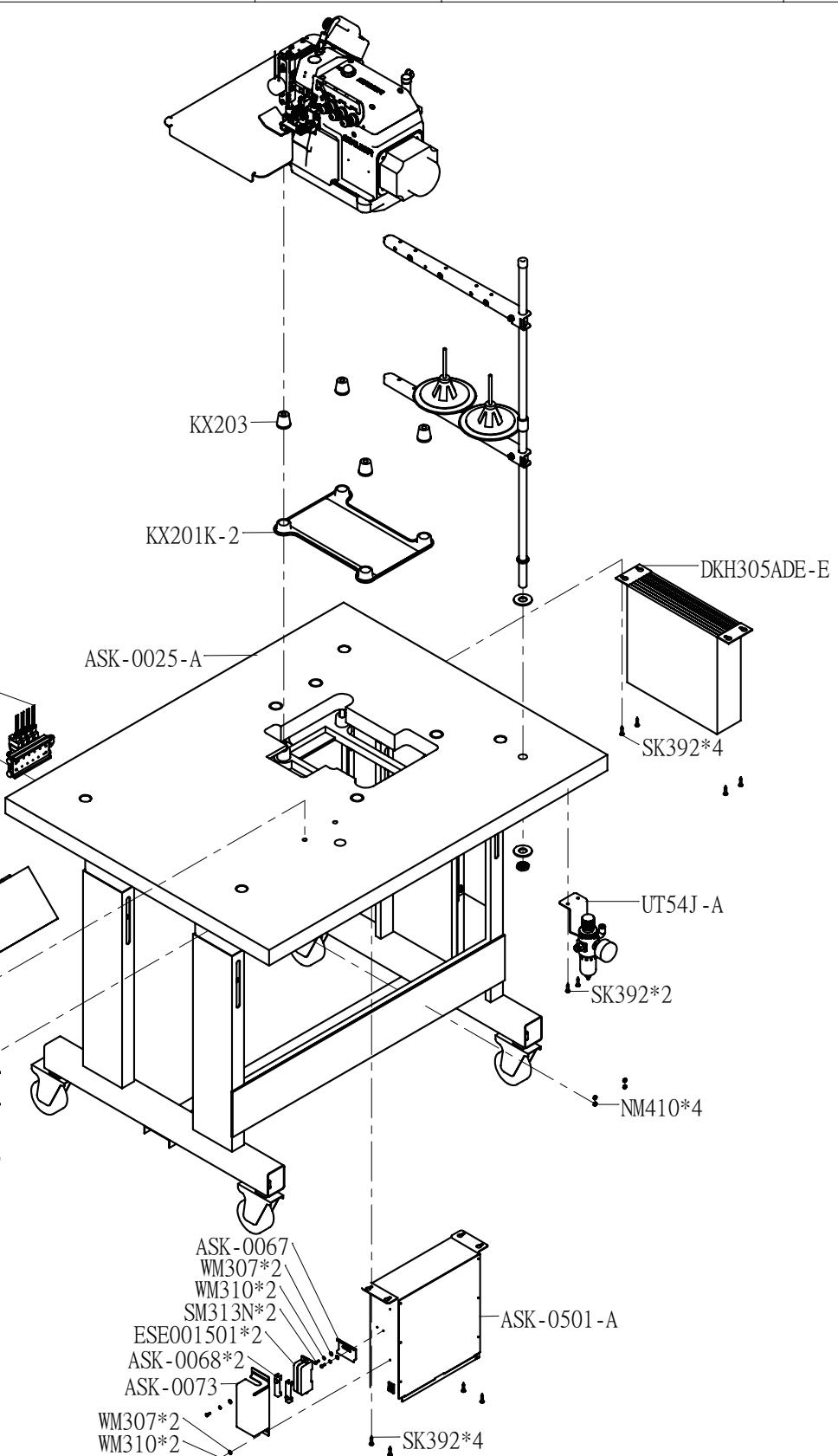
1 2 3 4 5

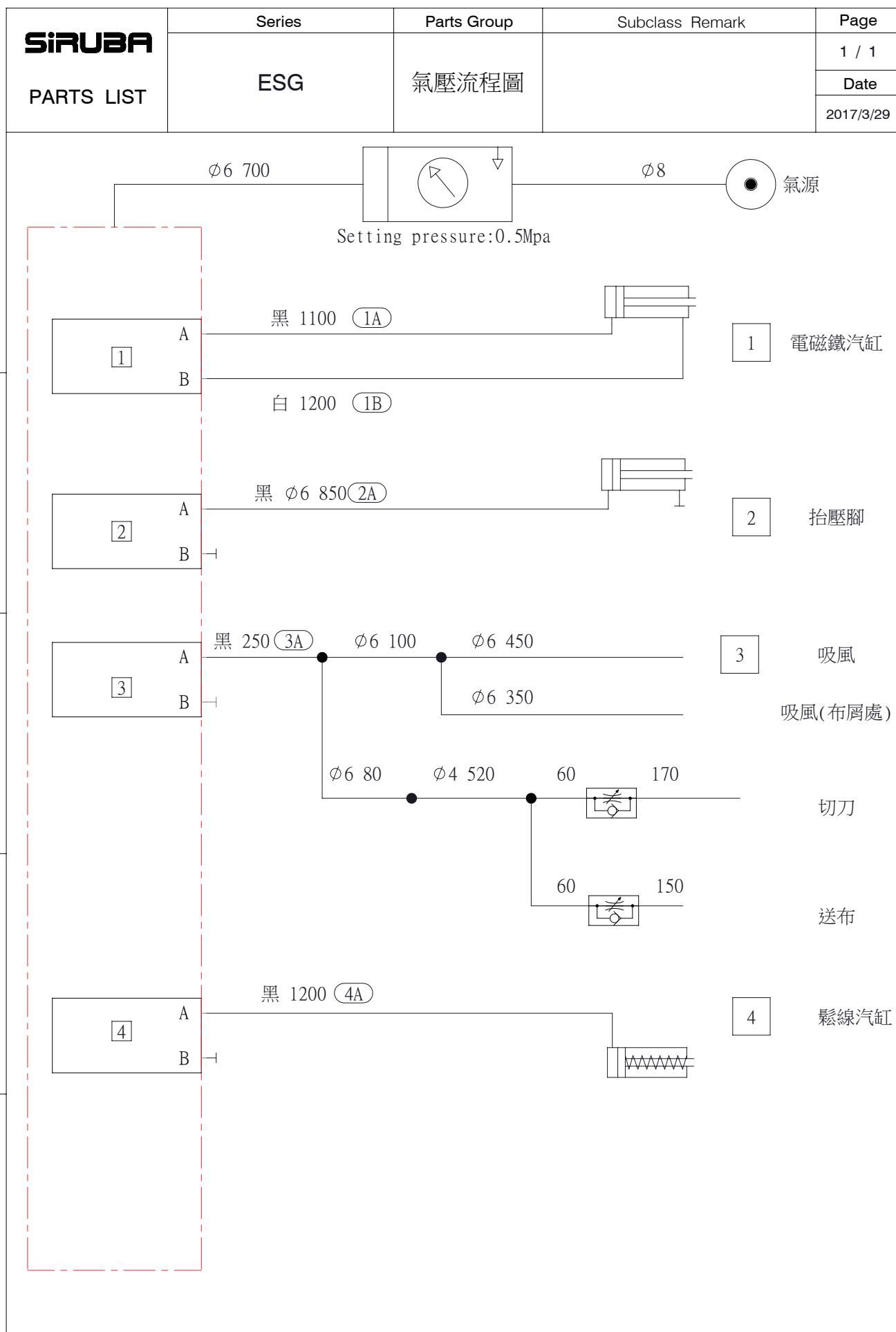
PARTS LIST	Series	Parts Group	Subclass	Remark	Page
	ESG	緊急按鈕組 ASK-0051-A			7 / 9
					Date
					2017/3/29



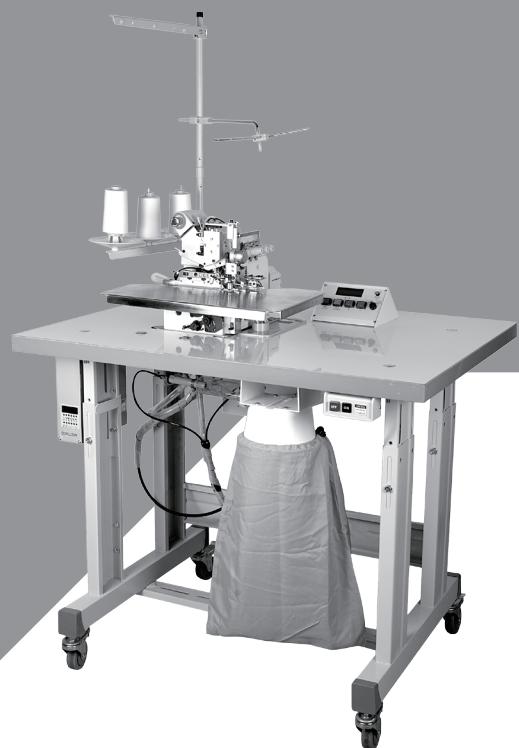
SiRUBA PARTS LIST	Series	Parts Group	Subclass	Remark	Page
	ESG	車頭			8 / 9
					Date
					2017/3/29



PARTS LIST	Series	Parts Group	Subclass	Remark	Page
	ESG	ESG			9 / 9
					Date
					2014/07/15
A					
B					
C					
D					
E					



1 2 3 4 5



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 and parts list
are subject to change because of modification without previous notice
ASK-ESG100.APR.2017