

Elastic Band Joining Machine
A E J -5730-200
(FOR BUTTED SEAM / LAP SEAM)
Instruction Manual

Thank you for purchasing our product.
Please be sure to read this manual before using the AEJ-5730-200
and keep it within easy access.

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Important Safety Directions

Make sure to obey the following to use the A E J-5730-200 correctly and safely:

1. Basic safety measures including those in the next sec
2. Only properly-trained operators should operate this machine.
3. When the machine has any trouble or malfunction during operation, it has to be stopped immediately and restored properly.
4. No modifications or changes should be made. Elize will not be responsible for any modifications or changes which have been made by customers.

Danger

Obey the following safety rules to avoid danger of electric shock:

1. The machine should be earthed to ground. Be sure to plug into an outlet which is properly earthed.
2. Any electrical repair or inspection should be done under the supervision and direction of a qualified service engineer or specialist.

Warning

Obey the following safety rules to avoid any electric shock, fire, burning or damage to human body:

1. Never touch any parts or devices that are charged with electricity when the machine is turned on.
2. Turn off the power switch:
 - 2-1 when a part is replaced.
 - 2-2 when the machine is repaired.

Important Safety Directions

3. Do not try to operate the machine when it is not working properly.
When the machine needs repair or electrical and mechanical adjustment, please consult a dealer designated by our company or directly contact us for appropriate measures.
4. Repair or adjustment of the machine should be made by a properly-trained service engineer or specialist. For replacement parts, use parts which are designated by our company.
5. Regular maintenance and inspections should be done by a properly-trained engineer.
6. When the air pressure part of the air cylinder is repaired or inspected, the air supply socket should be removed from the air plug to shut off air pressure supply. However, this may not be necessary when repair or inspection is done by a properly-trained engineer or specialist.
7. All covers and lids should be replaced properly when the machine is operated.
8. Clean the machine periodically so that the machine body, motor and control box do not collect waste thread, waste cloth and dirt.
9. Neither touch any mobile parts with a finger or get yourself (including your hair and clothes) too close to the machine when the machine is working.
10. Never operate the machine with a wet hand.
11. Three warning signs are displayed as follows:



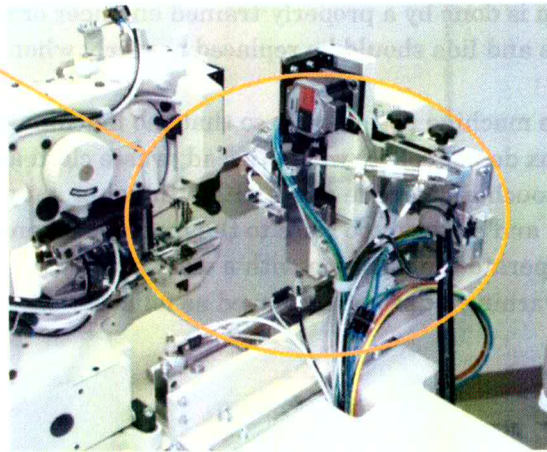
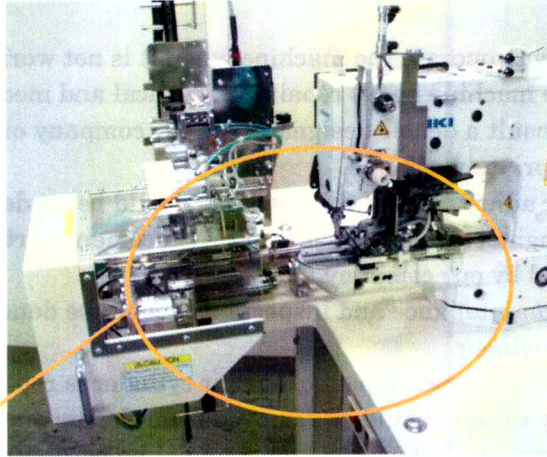
⚠ CAUTION
Moving parts may cause injuries.
<ul style="list-style-type: none">• Make sure that the machine is turned off when it is not in use.• Never operate the machine without the protecting cover.

⚠ WARNING
Hazardous voltage
<ul style="list-style-type: none">• When you inspect the machine, wait at least for 5 minutes after turning off the power until you take off the cover.

Precaution for Safety

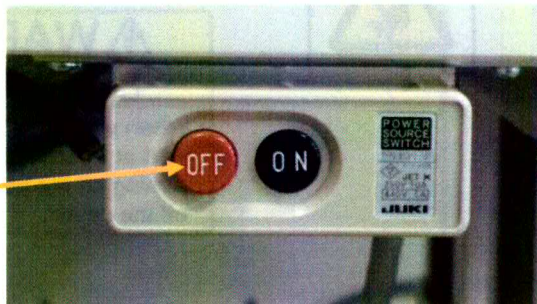
1. Do not put a finger or any other object in the area where there are moving parts while the machine is working.

Area with moving parts



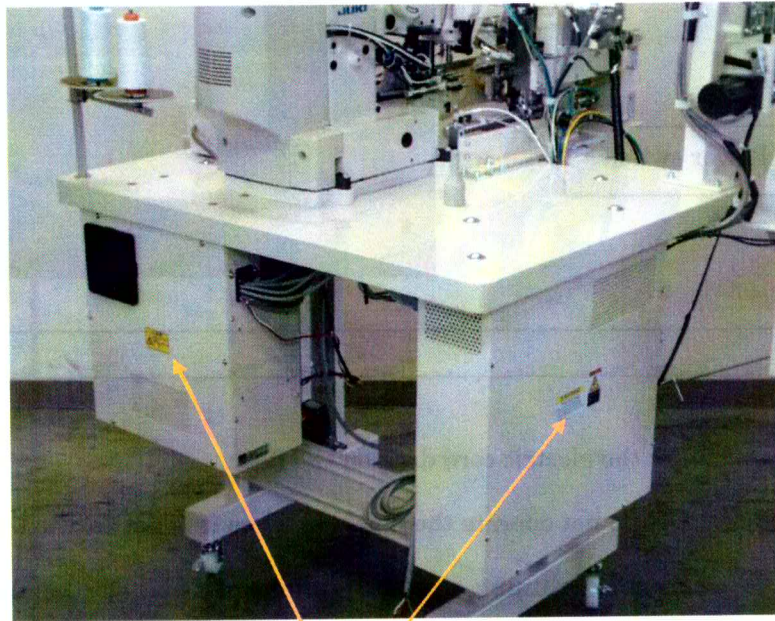
2. Be sure to turn off the power switch when the cover is removed for an inspection.

Power switch



Precaution for Safety

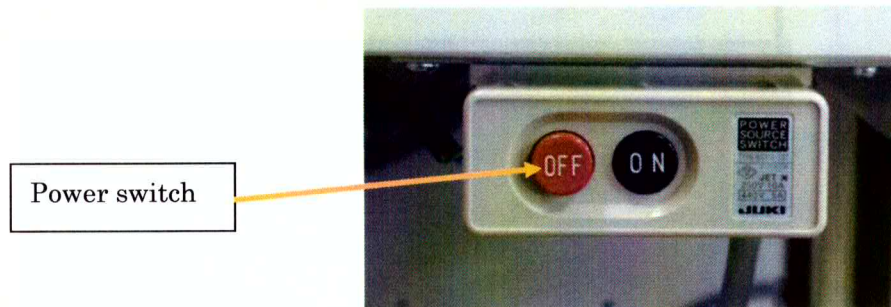
3. An electric shock warning label is affixed where there is high voltage electric terminal which is dangerous to the human body. Nobody except a special electrician should open the cover to inspect a control box with a warning label.



Electric shock warning label

Precaution for Safety

4. When it is necessary to stop the machine suddenly, turn on the power switch.



5. Do not let the electric cord drag on the floor.
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.

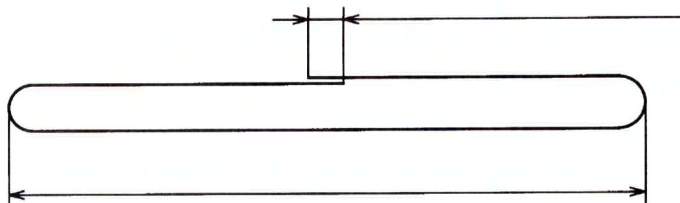
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1. SPECIFICATION

MODEL	AEJ-5730-200
SEWING MACHINE	JUKI ELECTRIC BAR TACKERR MACHINE LK-1920
NEEDLE	D P x 1 7
SEWING SPEED	2 5 0 0 r p m (MAX.)
CAPACITY OF PRODUCTION	DIFFERENT BY STITCHES EX.) 190 STITCHES PATTERN: 8 SEC./CYCLE
WIDTH OF ELASTIC BAND	2 0 m m ~ 5 0 m m
ELECTRICSOURCE	SINGLE/THREE PHASE 200~240V 50/60HZ 3.5A (MAX.) (MUTCH UP WITH ANY DISTINATIONS)
PNEUMATICAL PRESSURE	0. 5 M P a
CONSUMPTION OF AIR	3 0 0 /MIN.
DIMENSION	W 1 2 3 0 × L 1 0 3 0 × H 1 4 2 0 m m W 1 3 8 0 × L 1 0 3 0 × H 1 4 2 0 m m (ROLLED MATERIAL)
FINISHING SIZE	

LAPPING SIZE 0 (BUTTED) ~ 1 6 m m ※



FOLDING LENGTH 150-990MM(ELASTIC RING 300-1980MM ROUND)

※ CAUTION NORMAL SPECIFICATION SEWING PATTERN WIDTH:MAX.13MM

2. SETUP

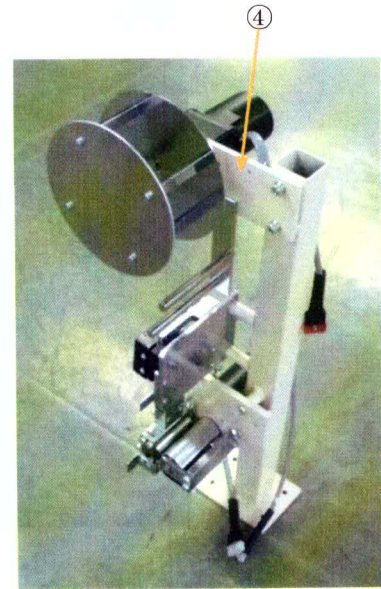
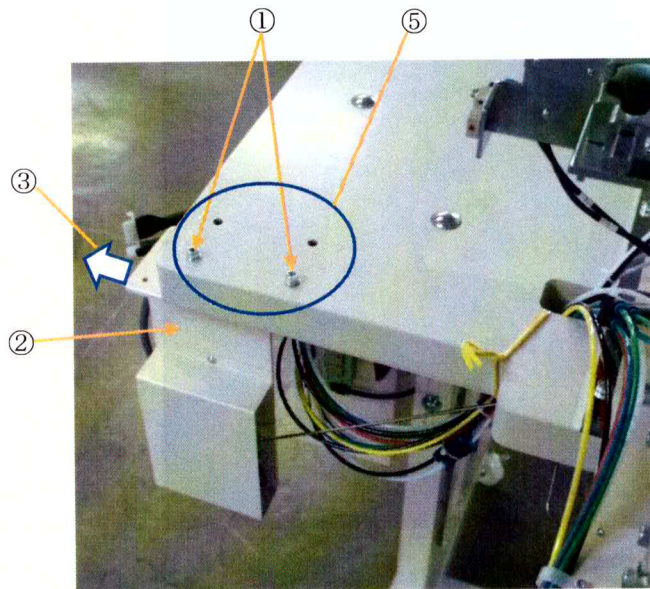
(CAUTION) SETUP OF THE MACHINE SHOULD ONLY MORE THAN ONE PERSON.

1) PUT OFF ① SCREW 2 PCS. ONCE TAKE OFF FEED DETECTING PART ②.

ONE PERSON SUPPORT FEED DETECTING PART ②, REMOVE TO DIRECTION OF ARROW

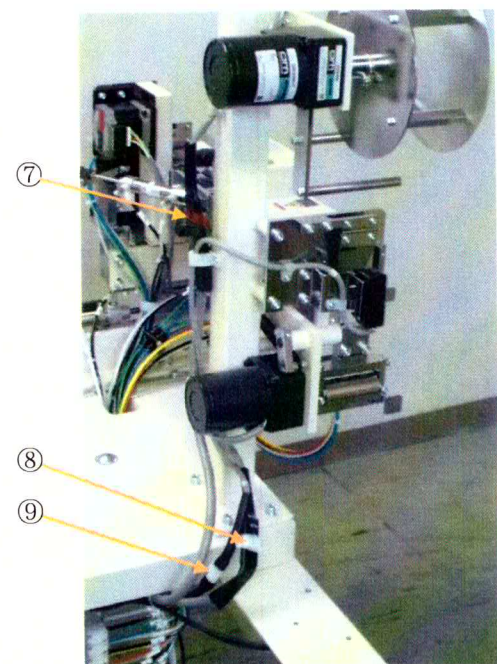
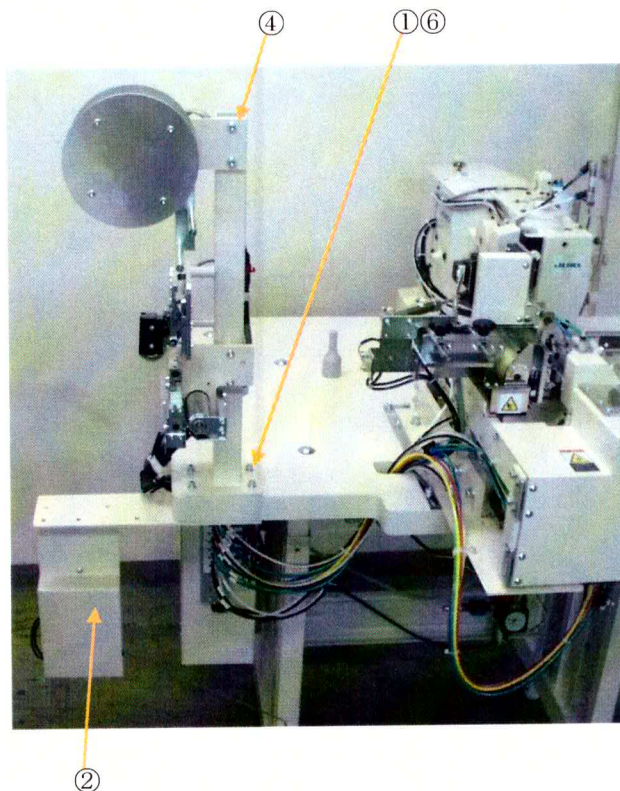
③. (DO NOT BREAK A CORD, FEED DETECTING PART)

2) PUT FEEDING PART ④ ONTO TABLE ⑤

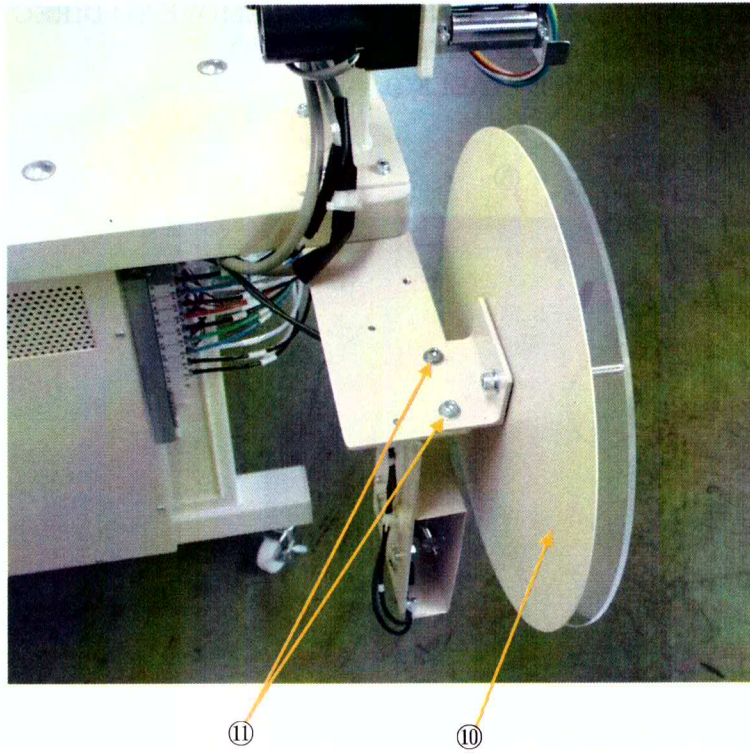


3) FIX UP FEED DETECTING PART ② WITH 4-PCS. OF SCREW WHICH ARE (PUT OF SCREW ① 2PDS. IN FIRST) AND (ACCESSORY : SCREW 2 PCS.)

4) HOOK UP CORD CONNECTOR ⑦⑧⑨

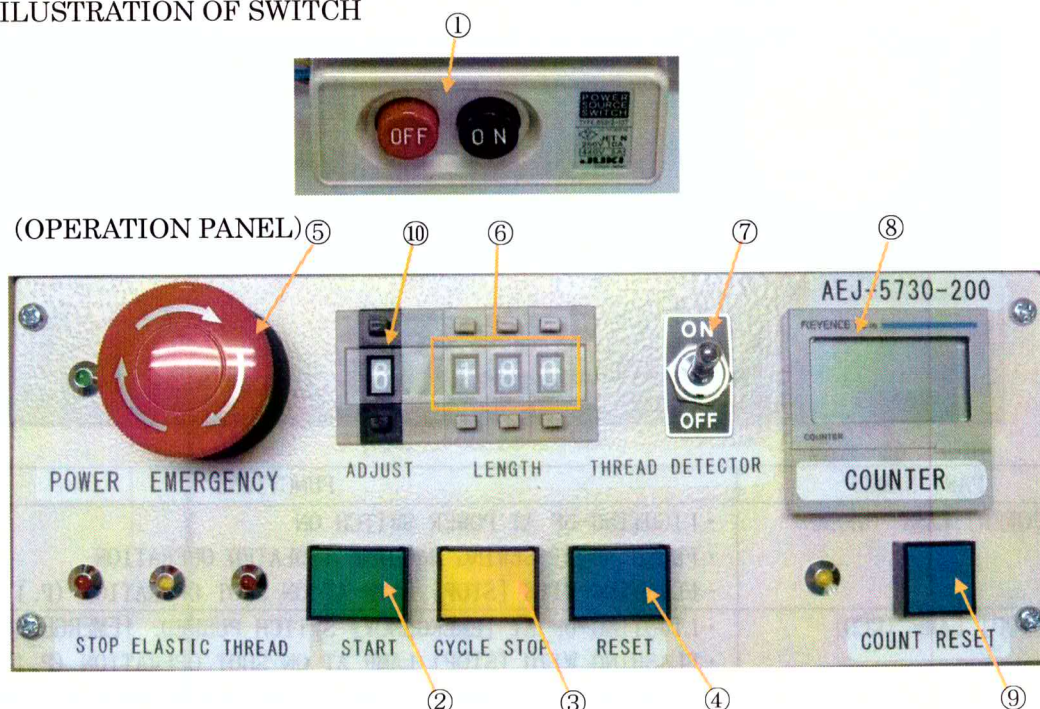


5) FIX UP ROLL HOLDER ⑩(OPTION) WITH SCREW⑪ AS FOLLOWING PHOTO.



3. OPERATION SWITCH

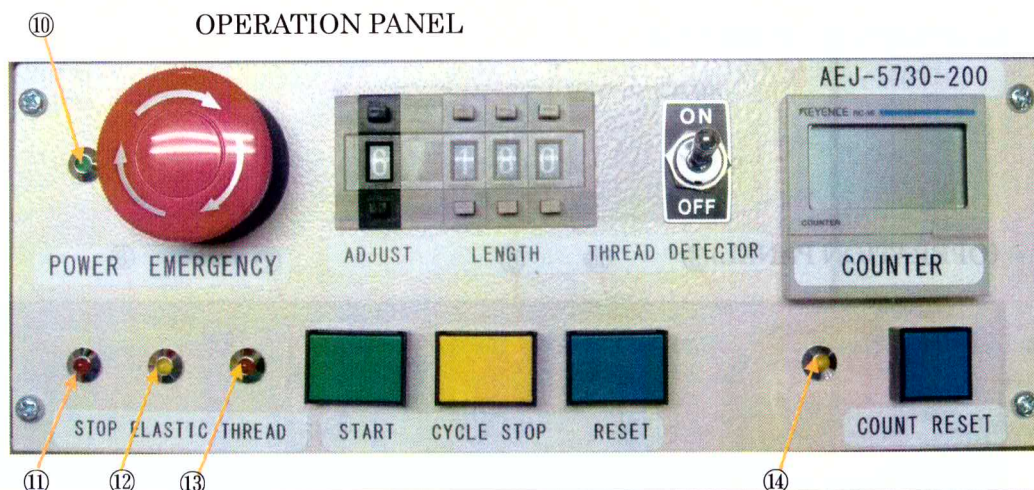
(1) ILLUSTRATION OF SWITCH



PART NAMES	FUNCTIONS
①POWER SWITCH	<ul style="list-style-type: none"> • PUT ON/OFF THE POWER
②「START」 SWITCH (GREEN)	<ul style="list-style-type: none"> • STARTING THE MACHINE (P. 10) • STARTING CONTINUOUS OPERATION OF THE MACHINE (P. 11) • MOTION OF ONE SHOT OPERATION (P. 17)
③ SEITCH, 「 CYCLE STOP 」 (YELLOW)	<ul style="list-style-type: none"> • STOP THE MACHINE CYCLE (P. 11) • SEWING 1 PDE. ONLY (P. 11)
④SEITCH, 「RESET」 (BLUE)	<ul style="list-style-type: none"> • CANCEL RELEASE OF ERROR • HOLD DOWN A BUTTION FOR OVER SECONDS, ;ELASTIC BAND FOREFRONT POSITIONING (P. 10) • UP AND DOWN A PRESSURE PLATE SEWING AT THE MACHINE ISOLATED OPERATION (P. 17)
⑤「EMERGENCY」 SWITCH (RED)	<ul style="list-style-type: none"> • EMERGENCY STOP THE MACHINE. TURN A BUTTON CLOCKWISE AND RELEASE LOCK. (P. 11)
⑥LENGTH SETTING SWITCH	<ul style="list-style-type: none"> • SETUP APRODUCT FINISH LENGTH (P. 10)
⑦ CHANGEOVER SWITCH, ; 「THREAD DETECTOR」	<ul style="list-style-type: none"> • CHANGEOVER THE UPPER THREAD BREAKAGE AUTO DETECT AND STOPDEVICE. (P. 14)
⑧「COUNTER」	<ul style="list-style-type: none"> • INDICATE PRODUCTION VOLUME (USABLE FOR THE UNDER THREAD COUNTER) ※ • STOP AUTOMATICALLY AT THE NUMBER OF COUNTS (UPPER NUMBER) COMETO BE AS SAME AS PRESET COUNTS (LOWER NUMBERS) (P. 14)
⑨COUNT RESET SWITCH (BLUE)	<ul style="list-style-type: none"> • RESET THE COUNT [0] OF THE [COUNTER] (P. 16)
⑩ADJUST SWING SWITCH	<ul style="list-style-type: none"> • FINE ADJUSTMENT OF FOREFRONT RIGHT-POSITION OF ELASTIC TAPE. STANDARD 「 5 」 (P. 10、 12)

※ CAUTION : USABLE LOWER THREAD COUNTER FUNCTION WHICH ON THE OPRATION BOX OF LK-1920. SETTING METHOD IS DISCRIBED BY INSTRUCTION MANUAL OF LK-1920 P.58. PLEASE REFER USAGE LK-1920 INSTRUCTION MANUAL P.44

(2) EXPLANATION OF INDICATOR LAMP



PART NAMES	FUNCTIONS
⑩ [POWER] LAMP (GREEN)	<ul style="list-style-type: none"> • LIGHTING-UP AT POWER SWITCH ON • FLASHING AT SEWING MACHINE ISOLATED OPERATION • FLASHING WITH [STOP] LAMP AT ON SHOT OPERATION (P.17)
⑪ [STOP] LAMP (RED)	<ul style="list-style-type: none"> • LIGHTING-UP AT [EMERGENCY] SWITCH PUSHED. 「EMERGENCY」 (P.14) • FLASHING WITH [STOP] LAMP AT ON SHOT OPERATION (P.17) • FLASHING WITH [THREAD] LAMP AT THE SEWING MACHINE START SIGNAL COME DOWN, HOWEVER THE SEWING MACHINE DO NOT BEROTATABLE. CONDITION. (P.14、16) • FLASHING WITH [ELASTIC] LAMP AT THE LIMIT SWITCH DEFECT IN THE DEVICE. (P.14、16)
⑫ [ELASTIC] LAMP (YELLOW)	<ul style="list-style-type: none"> • LIGHTING-UP AT FINISH UP THE ELASTIC TAPE (P.14、15) • LIGHTING-UP AT DETECTING THE ELASTIC SEAM JOINT (P.14、15) • FLASHING AT FEEDING DEFECT OF THE ELASTIC TAPE (P.14、15)
⑬ DETECTING SEAM JOINT AND OUT OF ELASTIC TAPE (RED)	<ul style="list-style-type: none"> • LIGHTING-UP AT DETECTING THREAD BREAKAGE. (AT THREAD DETECTOR SW/ON) (P.14、15) • FLASHING AT DEFECT OF THREAD TRIMMING (P.9、10)
⑭ COUNT UP LAMP	<ul style="list-style-type: none"> • LIGHTING-UP AT COUNTING UP (P.9、11)

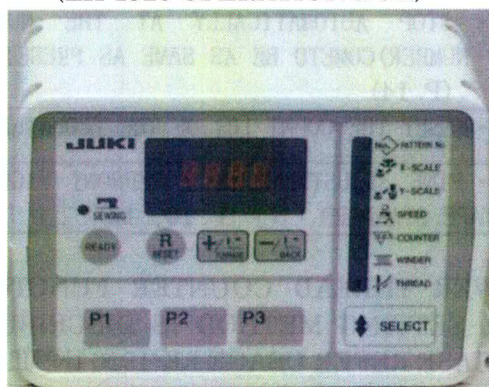
CAUTION) 1) EXPLANATION OF INDICATOR ⑪⑫⑬⑭ AND CANCEL RELEASE METHOD ARE REFER THE RELEVANT PAGE OF EACH LIST

2) PLEASE REFER THE RELEVANT PAGE OF LIST FOR SEWING MACHINE ISOLATED OPERATION AND ONE SHOT OPERATION METHOD.

(3) LK-1920 OPERATION BOX

• EXPLANATION OF THE OPERATION KEY AND INDICATOR LED ARE AS REFER THE INSTRUCTION MANUAL LK-1920

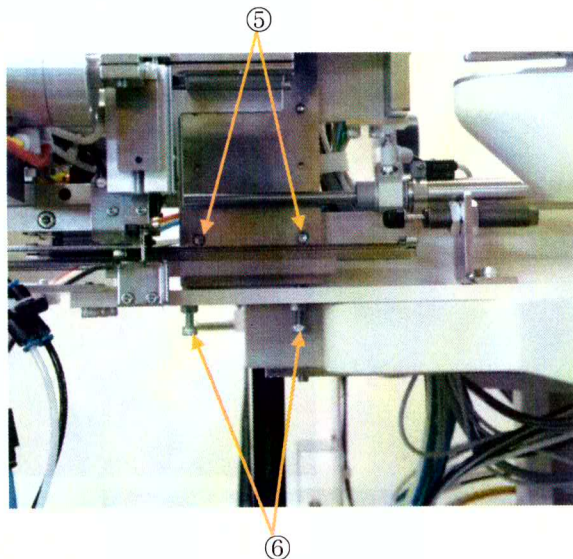
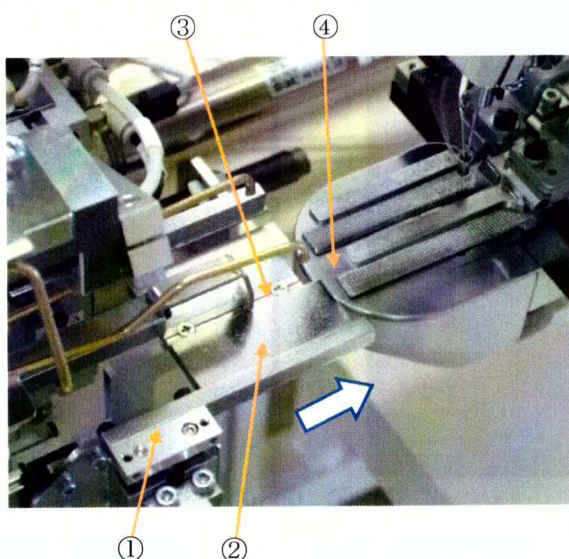
(LK-1920 OPERATION BOX)



4. PREPARATION FOR OPERATION

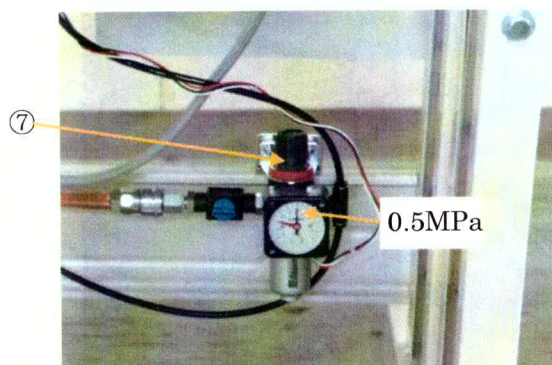
(1) CHECK THE DEVICE HEIGHT

MOVE ELASTIC TAPE SUPPLYING PART ① TO FORWARD BY HAND. CHECK THE SAME HEIGHT OF TAPE FORE-END SETTING PLATE② WHICH DRAWING RED LINE FACE AND SEWING MACHINE NEEDLE PLATE UPPER SURFACE.



(2) PNEUMATICALLY PRESSURE SETUP FILTER REGULATOR⑦ TO 0.5MPa (BLACK POINTER)

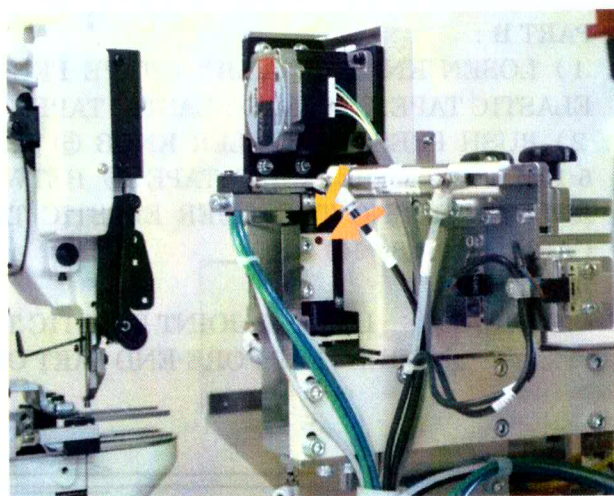
(3) POER SOURCE VOLTAGE APPLY $\pm 10\%$ OF RATED VOLTAGE GROUNDING THE EARTH CODE



(4) LUBRICATION

1) REFFER THE INSTRUCTION
MANUAL OF LK-1920 FOR SEWING
MACHINE LUBRICATION

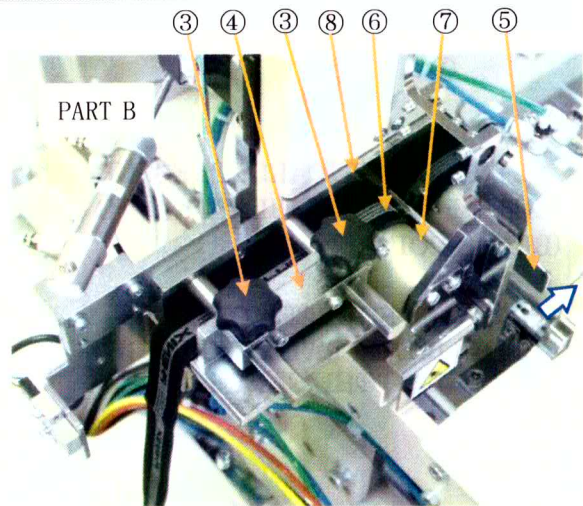
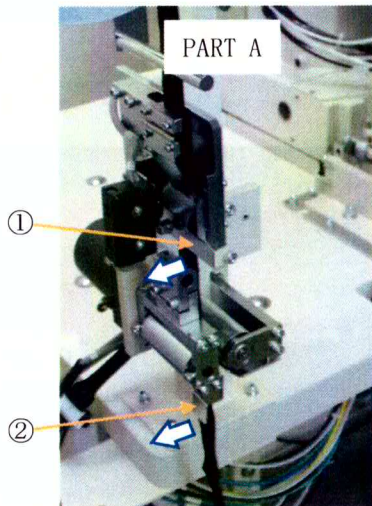
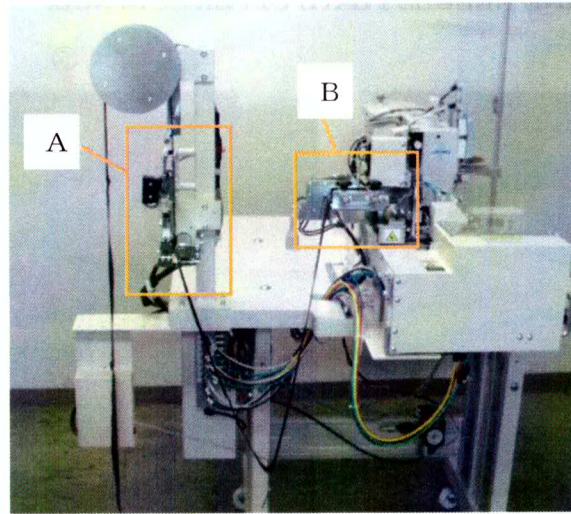
2) APPLY SMALL DRIP OF OIL TO
ARROW POINT (MOVING KNIFE
BUSHING) OF DEVICE, REGULARLY.



5. HOW TO LET INTO ELASTIC TAPE

CAUTION) DO NOT USE THE MATERIAL WHICH KEPT FOLDING LONG TIME CAUSE THE DEFECTIVE PRODUCT AND MACHINE TROUBLE.

LET INTO ELASTIC TAPE AS A FOLLOWING PHOTO



PART A :

PULL JOINT DETECTING PART KNOB ① AND FEEDING PART KNOB ② TO DIRECTION OF EACH ARROWS, AND LET INTO ELASTIC TAPE (*1)

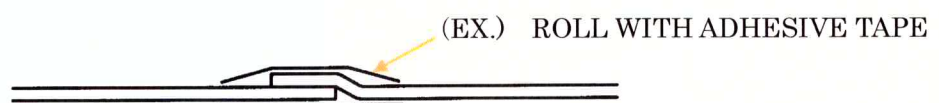
PART B :

1) LOSEN KNOB ③, ADJUST TAPE FEEDING GUIDE, FORWARD ④ TO WIDTH OF ELASTIC TAPE. LET INTO ELASTIC TAPE.

2) PUSH PRESSER ROLLER KNOB ⑤ TO DIRECTION ON ARROW. CLIP FORE-END 5-10MM (*2) OF ELASTIC TAPE ⑥ BETWEEN FEEDING ROLLER ⑦ AND PRESSER ROLLER. BRING TOGETHER ELASTIC TAPE ⑥ BACK SIDE AND FRAME ⑧ WITH CARE. → (P.8、10)

CAUTION) *1 : LAP AND JOINT ELASTIC TAPE JOINT PART AS BELOW

*2 ONLY LAP FORE-END PART OR ELASTIC TAPE. DO NOT LAP IN SURPLUS



6. OPERATION

☆BRIEF EXPLANATION OF OPERATION PROCEDURE.

• TURN ON THE POWER SWITCH. →STARTING INITIAL MOVEMENT (AUTOMATIC ELASTIC TAPE FOREFRONT POSITIONING ... ETC.)



• THE FIRST, SETUP SEWING PATTERN, ADJUSTMENT LENGTH OF ELASTIC RING AND OTHER SETTING. (P.8,9)



• PUSH START SWITCH (GREEN) → MACHINE SUSPENS BEFORE SUPPLYING ELASTIC RING TO UNDER THE PRESSERSTART



• CHECK SETTING ELASTIC RING POSITION, RIGHTLY. ADJUSTING AS NECESSARY. (P.10)



• AFTER CHECK ALL, PUSH A START SWITCH (GREEN : CONTINUOUS OPERATION START) OR CYCLE STOP SWITCH (YELLOW : STOP AFTER SEWING PRODUCT 1 PIECE ONLY). IF RETRACE ELASTIC TAPE SETTING STEP WITHOUT SEWING, PUSH REST SWITCH. (P.11)

(1) SEWING PATTERN NO. SETUP AND SEWING LENGTH ADJUSTMENT.

1) TURN OFF THE POWER SWITCH.

2) PUSH READY KEY ① ON THE OPERATION BOX OF LK-1920 AND SWITCH THE LIGHT OFF SEWING LED ②LAMP

3) PUSH SELECT KEY ③, DISPLAY PATTERN NO.

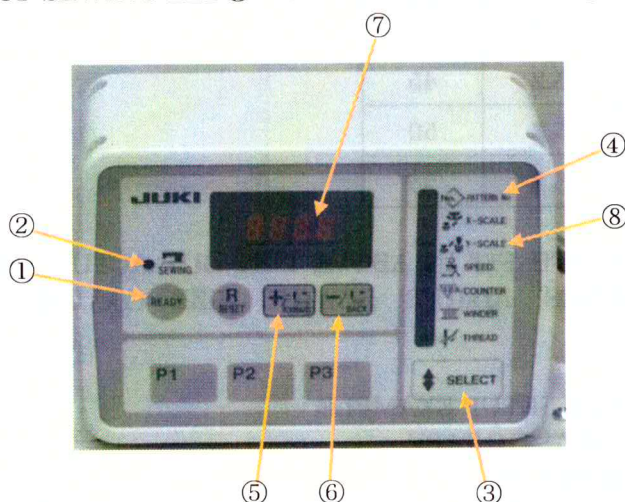
4) INDICATE PATTERN NO. OF ELASTIC WIDTH OR SIMILAR WIDTH PATTERN NO. TO PUSH +/- FORWARD KEY ⑤ OR -/BACK KEY ⑥

注) REFER THE NEXT PAGE EXAMPLE SEWING PATTERN. Y DIRECTION SIZE IS IN ANY 5MM. IF ELASTIC TAPE WIDTH IS NOT IN THE LIST OR MIDDLE OF EACH SIZE, SHOULD USE THE PATTERN EXPAND/REDUCE FUNCTION.




IN THE SAME WAY, ADJUST FINELY YNEAR SIDE POSITION.



5) FOR ADJUSTING THE LENGTH, INDICATE Y-SCALE⑧ ARTICLE, PUSH +/-FORWARD KEY ⑤ OR -/BACK KEY TO ADJUST Y-DIRECTION EXPAND OR REDUCE RETHIO.

6) LIGHTING-UP SEWING LED② TO PUSH READY KEY ①



• SEWING PATTERN EXAMPLE

NO	STITCH DIAGRAM	NUMBER OF STITCH	SEWING SIZE (MM)	
			LENGTH -WISE	CROSS- WISE
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 STITCH	SEWING SIZE (MM)	
			LENGTH -WISE	CROSS- WISE
31		71	6.4	20
33		87	6.4	25
34		98	6.4	30
35		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

WHEN ELASTIC TAPE WIDTH FIT IN ABOVE LIST BUT ACTUAL SEWING SIZE ARE DIFFERENT WITH ABOVE, ADJUST SEWING SIZE (Y) USE EXPAND/REDUCE FUNCTION.

• EXPAND/REDUCE RETHIO SETUP EXAMPLE

SEW 34MM WIDTH ELASTIC TAPE

1) PATTERN NO.: 24 SETUP

2) EXPAND/REDUCE RETHIO: SETUP 96-97% Y-SCHALE (DECIDE THE RETHIO AFTER CHECK SEWIN TEST RESULTS)

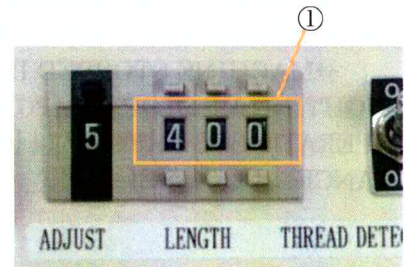
(2) FINISH LENGTH SETUP AND ADJUSTMENT

1) SETUP FINISH LENGTH [L] AS BELOW, ON LENGTH SETUP SWITCH① (MM).
VALIDITY OF SETUP RETHIO IS 150-999. IF THE RETHIO UNLESS THAN 150, SAME AS 150 SETUP RETHIO.

ELASTIC RING CIRCUMFERENTIAL LENGTH TO BE (2 X L) MM.

2) THIS RETHIO OF LENGTH SETUP SWITCH IS ABSOLUTELY TARGET INDICATION..
PLEASE CHECK AND ADJUST FINISH LENGTH SEWING WITH ACTUAL PRODUCT.

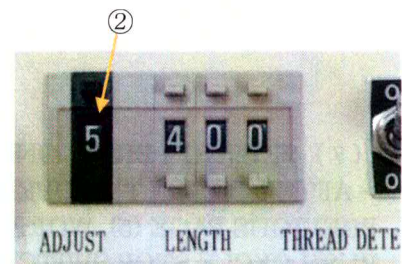
IF THE MATERIAL OF ELASTIC TAP HAS CHANGED, THE ACTUAL FINISH LENGTH WILL BE A DIFFERENCE WITH [L] SETUP RETHIO.



(3) ADJUST SETUP RETHIO

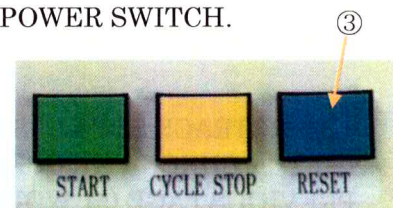
• ONLY WHEN IT IS ABSOLUTELY NECESSARY
ADJUST THE ELASTIC RING RIGHT FORE-END
POSTION, REGULATE THE RETHIO

THE FIRST, SETUP STANDARD [5]



(4) ELASTIC BAND FOREFRONT POSITIONING

• POSITIONING AUTOMATICALLY WHEN TURN ON THE POWER SWITCH.
• WHEN TAKES ELASTIC TAPE IN AND OUT FROM
FEEDING ROLLER, OPERATE AS BELOW FOR PURPOSE
OF ACCURACY POSITIONING OF ELASTIC TAPE
FOREFRONT.



HOLD DOWN RESET SWITCH③ FOR OVER A SECOND

→POSITIONED ELASTIC BAND FOREFRONT IN THE RIGHT PLACE. AT THIS TIME,
CLEAN AWAY ELASTIC FRAGMENT.

(5) STARTING

1) PUSH START SWITCH ④

→MACHINE SUSPEND BEFORE SUPPLYING
ELASTIC RING TO UNDER THE PRESSER.

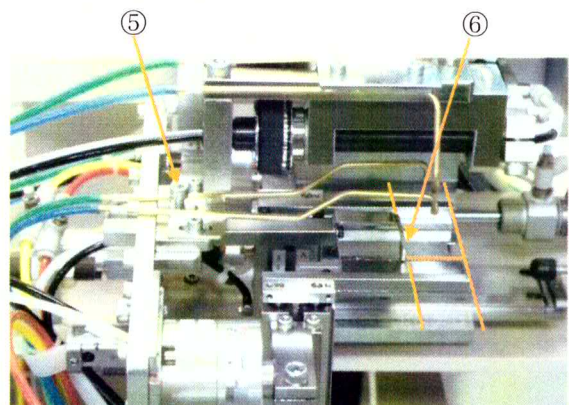
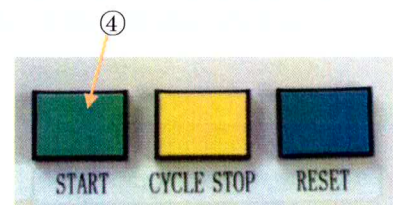
2) CHECK BUTTED OR LAPPED PART POSITION.

→ REFER P.12 FOR COPING STRATEGY IF SOME TROUBLES IN THE SETTING
POSITION.

3) THE FIRST, LOSEN UP SCREW⑤,
FIT IN TAPE EDGE FRONT GUIDE⑥
TO TAPE WIDTH

4) THEN, SELECT FOLLOWING OPERATION

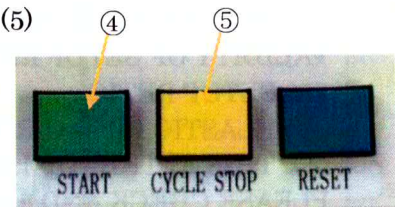
- CONTINUOUS OPERATION →⑥
- SEWING 1 PIECE ONLY →⑦
- RETRACE SETTING STEP AGAIN →⑧



(6) CONTINUOUS OPERATION

- OPERATING FOLLOWINS AFTER CHECK PREVIOUS PAGE (5)

- 1) PUSH START SWITCH ④
→PRODUCE A PRODUCT CONTINUOUSLY
- 2) PUSH CYCLE STOP SWITCH⑤ FOR STOP
→STOP THE MACHINE AFTER FINISHED PRODUCTING



- IN CASE OF STOP THE MACHINE URGENTRY,
PUSH EMERGENCY SWITCH⑥ PROMPLTY.

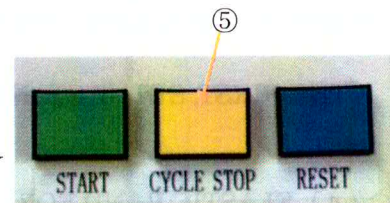
→MACHINE STOPPED IMMEDIATELY AND
LIGHTING-UP STOP LAMP⑦SUBSQENT OF
OPERATING IS REFER P.14 [INDICATE OF LAMP AND
CANCEL RELEASE]



(7) SEWING 1 PIECE ONLY.

- AFTER CHECK THE OPERATING METHOD OF
PREVIOUS PAGE (5), WORK FOLLOWS.
PUSH CYCLE STOP SWITCH

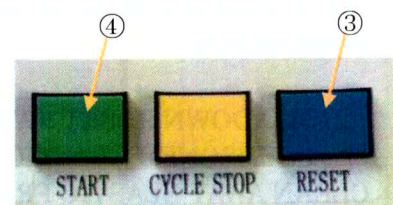
→STOP THE MACHINE AFTER SEWING 1 PIECE ONLY



(8) RETRACE SET ELASTIC RING.

- AFTER CHECK THE OPERATING METHOD OF
PREVIOUS PAGE (5), WORK FOLLOWS.

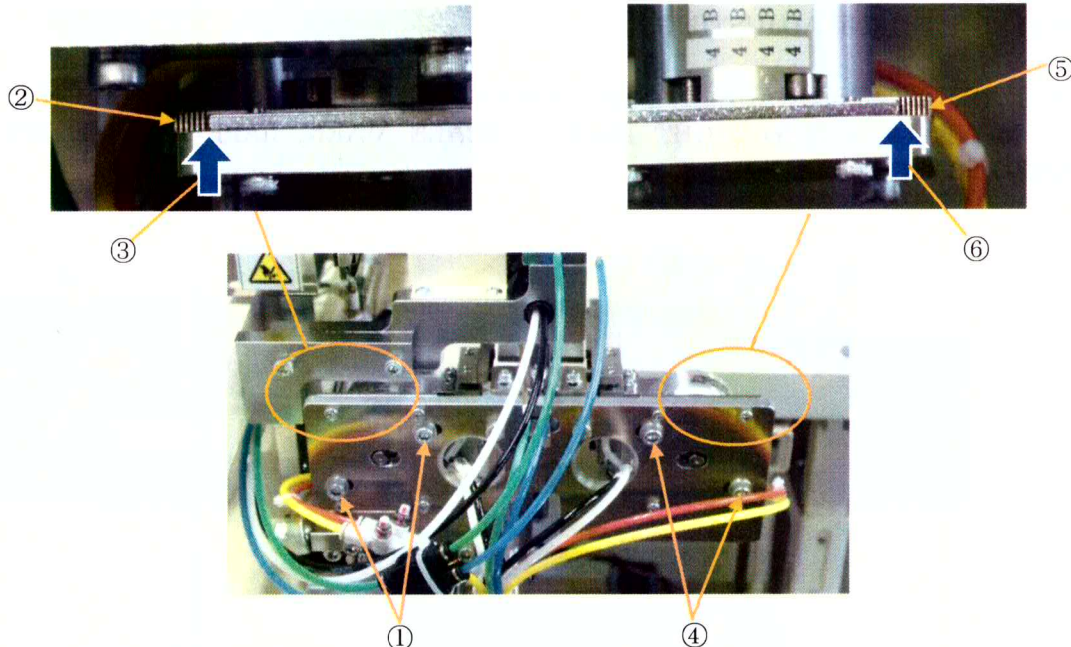
- 1) PUSH RESET SWITCH ③
→REMOVE THE POSITIONED ELASTIC RING.
- 2) PUSH START SWITCH ④
→SUPPLIED ELASTIC RING NEWLY AND SUSPEND AGAIN.



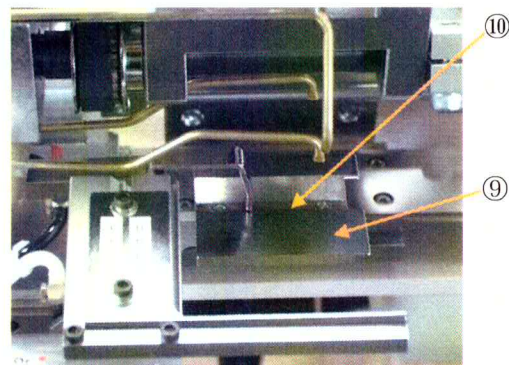
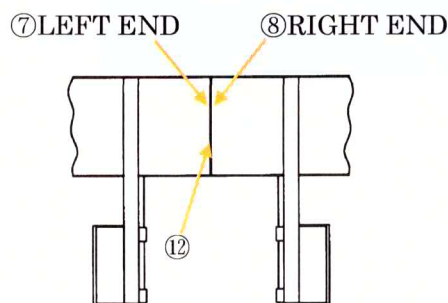
7. ADJUSTMENT FOR BUTTED SEAM AND LAPPED SEAM

(1) BUTTED SEAM ADJUSTMENT (DEVICE STANDARD ADJUSTING STEPS)

- 1) LOOSEN THE UP SCREW ① AND ALIGN RIGHT END SCRIBEING RED LINE OF LEFT HAND SUPPLYING ROTOR SETTING PLATE② WITH ARROW③ POSITION.
- 2) LOOSEN THE UP SCREW ④ AND ALIGN RIGHT END SCRIBEING RED LINE OF LEFT HAND SUPPLYING ROTOR SETTING PLATE⑤ WITH ARROW⑥ POSITION.



- 3) TURN ON THE POWER SWITCH AND PUSH START SWITCH.
- 4) WHEN THE MACHINE STOPPED UNDER THE ELASTIC RING WAS SET ON TAPE END SETTING PLATE, ELASTIC TAPE LEFT END ⑦AND RIGHT END ⑧ ARE BUTTED ON TAPE END SETTING PLATE ⑨



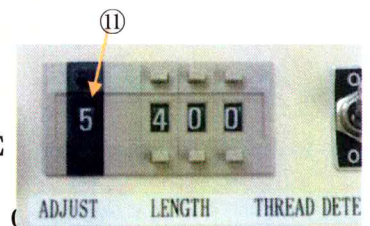
(ADJUSTMENT)

- FACTORY ADJUSTED LEFT END ⑦ POSITION BEFORE SHIPMENT.※1
- IF RIGHT END ⑧ POSITION COULD NOT ALIGN, ADJUST [ADJUST SWITCH ⑪] RATE (STANDARD : 5)※2

WHEN THE SPACKING IS IN THE BUTTED JOINT PART
→INCREASE ⑪ RATE. RIGHT END OVER THE RED LINE
⑩ AND LAPPED ON THE LEFT END ⑦ →DECREASE ⑪ RATE.

注) ※1 : IF READJUSTI TAPE END POSITION, FINE ADJUST ABOVE ROTOR SETTING PLATE ② POSITION.

※2 : INCREASE RATE 1, RIGHT END ⑧ MOVE LEFT ABOUT (MATERIAL BEHAVOIR IS SIMILAR, KEEP THE RATE WHEN CHANGED THE ELASTIC TAPE.



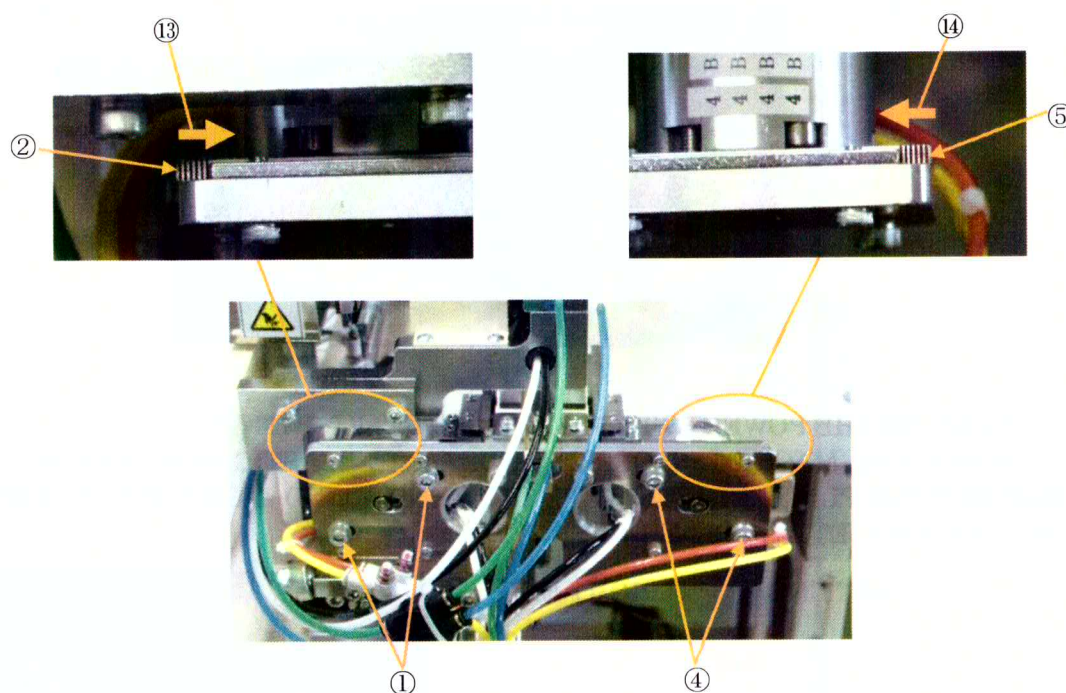
(2) LAPPING SIZE ADJUSTMENT.

1) FROM BUTTED POSITION (FOLLOWING PHOTO STANDARD POSITION) FOR SCRIBING RED LINE, MOVE EACH DIRECTION EQUALLY, LEFT HAND SUPPLYING ROTOR SETTING PLATE ② TO ARROW ⑬, RIGHT HAND SUPPLYING ROTOR SETTING PLATE ⑤ TO ARROW ⑭.

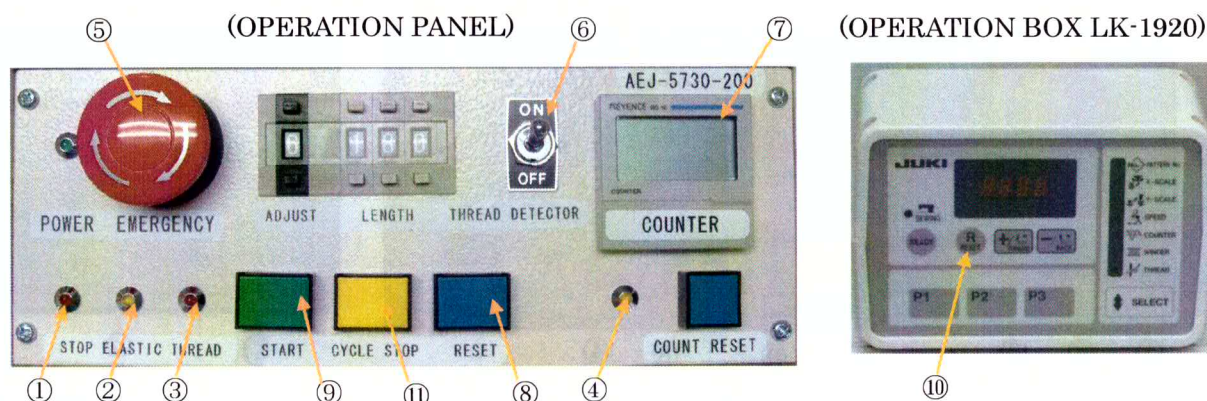
2) FOR ADJUSTING LEFT & RIGHT HAND SUPPLYING ROTOR SETTING PLATE, LOOSEN THE SCREW ① FOR LEFT HAND ②ADJUSTING AND LOOSEN THE SCREW ④ FOR RIGHT HAND ADJUSTING.

※注) IF ADJUST UNEQUALLY, ELASTIC LAPPING CENTER JOLT OUT OF ALIGNMENT.

MOVE LEFT AND RIGHT EACH 1 SCALE MARK, LAPPING SIZE WILL BE CHANGED 2-3MM.



8. INDICATION OF LAMP & CANCELATION



INDICATOR LAMP	CONDITION	EXPLANATION OF INDICATOR	CANCEL RELEASE
STO LAMP ①	LIGHTING-UP	PUSHED DOWN EMERGENCY SWITCH ⑤	A 1
ELASTIC LAMP ②	LIGHTING-UP	1) FINISH UP ELASTIC TAPE 2) DETECTED ELASTIC TAPE JOINT	A 2 A 3
	LIGHTING-UP	1) ELASTIC TAPE IS CATCHING IN THE UPSTREAM OF FEEDING DEVICE. 2) DEFECTS WITHOUT FEEDING PART 1). DROP OUT OF ELASTIC TAPE ETC.	A 4 A 5
THREAD LAMP ③	LIGHTING-UP	UPPER THREAD BREAKAGE (THREAD DETECTOR SWITCH ⑥ IS ON) SEWING MACHINE SUSPEND.	A 6
	FLASHING	THREAD TRIMMING DEFECT (UNCONCERNED THREAD DETECTOR SWITCH⑥)	A 7
COUNT UP LAMP ④	LIGHTING-UP	COUNT UP THE COUNTER ⑦	A 8
STOP LAMP ① AND THREAD LAMP ③	FLASHING AT ONCE	LK-1920 IS IN NONOPERATING SITUATION (AFTER USED LK-1920 OPERATION BOX KEY OR COUNTING UP LOWER THREAD COUNTER ETC)	A 9
STOP LAMP ① AND ELASTIC LAMP ②	FLASHING AT ONCE	LIMIT SWITCH (LS) DEFECTS IN A DEVICE	A 1 0

• SEWING MACHINE ISOLATED OPERATION. REFER INDICATION OF ONE SHOT OPERATION/SEWING MACHINE ISOLATED OPERATION (P17) EXPECT ABOVE LIST.

(CANCEL RELEASE)

A 1 . 1) TURN THE EMERGENCY SWITCH ⑤ TO DIRECTION OF ARROW.

2) PUSH RESET SWITCH⑧→LIGHT OFF STOP LAMP①

3) PUSH START SWITCH ⑨ → RESTART OPERATION. CAN OPERATE CONTINUOUSLY THE MACHINE HAS SUSPENDED.

※ 1 注) CAUTION) IN PROGRESS SITUATION WHEN PUSHED THE EMERGENCY SWITCH⑤, MACHINE WILL BE STOPED FOLLOWING a. Or b. POSITION AFTER WORK FOR A WHILE.

a . STOP SAME POSITION AS SAME AS THE POWER SWITCH. TURN ON.

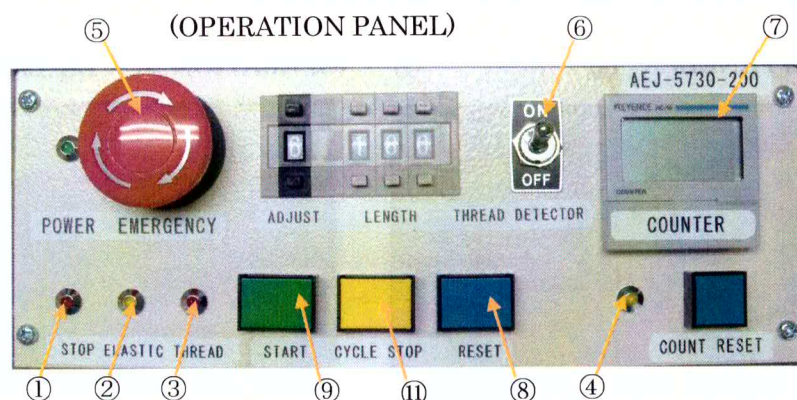
b . SUSPEND AFTER SET ELASTIC RING.

• PUSH EMERGENCY SWITCH ⑤ IN OPERATING A SEWING MACHINE AND SUSPEND SEWING.

OPERATE FOLLOWING 4), 5) METHOD ON LK-1920 OPERATION BOX AFTER HANDLING ABOVE 2)

4) PUSH REST KEY ⑩ → THREAD TRIMMING WORK AT STOP POSITON ON THE WAY OF SEWING.

5) PUSH RESET KEY ⑩ AGAIN. →TAKE THE ELASTIC RING OFF WHICH INTERRUPTED TO SEWING (REJECT PRODUCT). DEVICE IS AS SAME AS ABOVE 3) *1



(LK-1920 OPERATION BOX)



A 2. 1) TAKE REMAINING ELASTIC TAPE OFF BY HAND (DO NOT PUSH RESET SWITCH ⑧FIRST. TOB E HARD TO TAKE OFF THE REJECT.)

2) PUSH RESET SWITCH ⑧ → DEVICE GET BACK TO STANDBY POSITION (ORIGINAL POINT).

3) SET THE NEWLY ELASTIC TAPE (P.7) →ELASTIC LAMP② LIGHT OFF.

4) HOLD DOWN RESET SWITCH FOR OVER SECONDS (P.10)

5) PUSH START SWITCH ⑨→RESTART OPERATION.

A3. 1) CUT OFF AND REJECT JOINT SEAM OF ELASTIC TAPE.

2) PUSH RESET SWITCH ⑧→ELASTIC LAMP ② LIGHT OFF.

3) PUSH START SWITCH ⑨ TO MAKE PRODUCT FORWARD PART OF THE JOINT SEAM. →SUSPEND AFTER SET ELASTIC RING.

4) PUSH START SWITCH⑨AGAIN. RESTART CONTINUOUS OPERATING.

AFTER RESTART, STOP THE MACHINE AUTOMATICALLY AS [ELASTIC TAPE FINISH UP] AFTER MAKE 1-2 PIECES OF PRODUCT.

A4. 1) FIX ELASTIC TAPE HUNG UP

2) PUT OFF THE ELASTIC TAPE AND PUT ON THE FOREFRONT OF TAPE ON FEEDING ROLLER.

3) PUSH RESET SWITCH⑧→DEVICE GET BACK TO STANDBY POSITION (ORIGINAL POINT) ELASTIC LAMP②LGHT OFF

4) HOLD DOWN RESET SWITCH ⑧ FOR OVER SECONDS FOR FOREFRONT POSITIONING (P.10)

5) PUSH START SWITCH ⑨→RESTART OPERATION

A 5. 1) FIX THE TROUBLES, DROP OUT OF ELASTIC TAPE, FEEDING PART ETC.

2) AFTER THIS, AS SAME AS A4-2) AND AFTER

A 6. SEWING MACHINE SUSPEND ON THE WAY OF SEWING OPERATION

1) PUSH RESET SWITCH⑧ THREAD LAMP ③ LIGHT OFF.

• IN CASE OF REJECT ELASTIC TAPE UNDER THE SEWING MACHINE PRESSER

2) PUSH REST KEY ⑩ → THREAD TRIMMING WORK AT STOP POSITON ON THE WAY OF SEWING.

3) PUSH RESET KEY ⑩ AGAIN. →TAKE THE ELASTIC RING OFF WHICH INTERRUPTED TO SEWING (REJECT PRODUCT)※1

※ 1 注) CAUTION) IN PROGRESS SITUATION WHEN STOP THE MACHINE DETECTED UPPER THREAD BREAKAGE AUTOMATICALLY, MACHINE WILL BE STOPED FOLLOWING a. Or b. POSITION AFTER WORK FOR A WHILE.

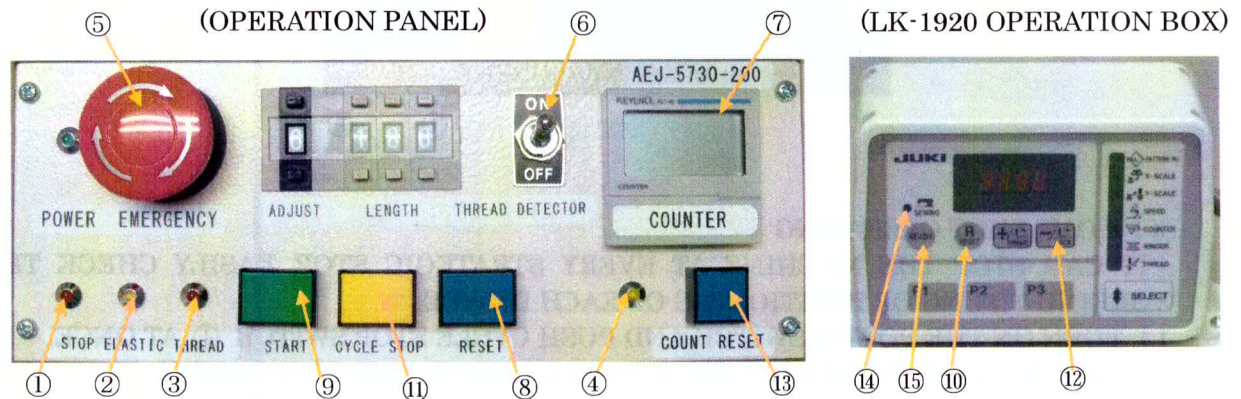
a. STOP SAME POSITION AS SAME AS THE POWER SWITCH. TURN ON.

b. SUSPEND AFTER SET ELASTIC RING.

• OPERATING FOLLOWINGS AFTER THREADING THE UPPER THREAD AT SUSPENDED POSITION (*2 IF SEWING CONTINUOUSLY ABOVE 1)

4) PUSH START SWITCH ⑨ AND CYCLE STOP SWITCH ⑪ AT ONCE. SEWING CONTINUOUSLY. DEVICE OPERATING IS AS SAME AS ABOVE *1 CAUTION)

※ REFER THE THREADING WITH LK-1920 INSTRUCTION MANUAL P22. AFTER WORK BY 2) IT CAN RE-SEWING WITH OPERATING 4) AFTER GET BACK NEEDLE POSITION PUSHED -/BACK KEY ⑫.



A 7. 1) CUT OFF THE THREAD.

2) PUSH RESET SWITCH ⑧ THREAD AMP ③ LIGHT OFF.

A 8. 1) PUSH COUNT RESET SWITCH ⑬ COUNT UP LAMP ④ LIGHT OFF.

2) PUSH START SWITCH ⑨ RESTART OPERATING.

A 9. 1) IN CASE OF SEWING LED ⑭ LIGHT OFF AFTER CHANGED SET UP CONDITION OF LK-1920 OPERATION BOX OR THREADING, PUSH READY KEY ⑮ AND BRING BACK UNDER SEWING CONDITION.

2) IN CASE OF USING LOWER THREAD COUNTER FUNCTION OF LK-1920 OPERATION BOX (LK-1920 INSTRUCTION MANUAL P.44).

3) PUSH RESET KEY ⑧ STOP LAMP AND THREAD LAMP LIGHT OFF.

4) PUSH START SWITCH ⑨ RESTART OPERATING.

A 10. 1) STOP THE AIR.

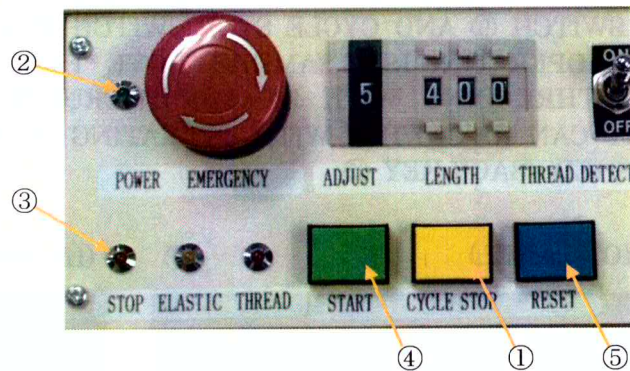
2) TURN OFF THE POWR SWITCH

3) CHECK A LIMIT SWITCH *3

*1 CAUTION) FIXING 4-SPOTS ON THE AIR CYLINDER AND ROTARY ACTUATOR.

WITHOUT BLOWING AIR, TURN ON THE POWER SWITH. MOVE THE DEVICE BY HAND AND CHECK THE INDICATE LAMP LGHTING ON. ADJUST POSITION WHEN SETTING POSITION GAP. IN CASE OF A LAMP IS NOT LIGHTING UP, CHANGE A SWITCH IF NOT POSITION GAP.

9. MAINTENANCE OPERATING MODE



(1) ONE SHOT OPERATING

• IT CAN STOP THE MACHINE AT EVERY STRATEGIC STOP, EASILY CHECK THE WORKING TIMING OR POSITIONING OF EACH DEVICE.

- 1) TURN ON THE POWER SWITCH AND PUSH CYCLE STOP SWITCH ① AT ONCE.
- 2) CHECK LAMPS FLASHING AT ONCE POWER LAMP② AND STOP LAMP③.
- 3) PUSH CYCLE STOP SWITCH ① STOP AT THE FIRST PAUSE POSITION.
- 4) AFTER THIS, PUSH START SWITCH④ AND BRING WORK FORWARD. MACHINE MOVE TILL SUSPEND POSITION AFTER SET ELASTIC RING AS SAME AS NORMAL OPERATING.
- 5) PUSH CYCLE STOP SWITCH① AFTER CHECK SETTING SITUATION. (EFFECTIVE RESET SWITCH⑤. NOT EFFECTIVE START SWITCH, THIS PART).
- 6) PUSH START SWITCH④ AND BRING WORK FORWARD. IF CONTINUOUS WORK AGAIN, DEVICE GET BACK TO STANDBY POSITION AFTER FINISHED SEWING, RUN TO 3)

(2) SEWING MACHINE ISOLATED OPERATION

• SEWING MACHINE ISOLATED OPERATION, WITHOUT DEVICE WORK.

- 1) TURN ON THE POWER SWITCH AND PUSH START SWITCH ④ AT ONCE.
- 2) CHECK POWER LAMP②FLASHING
- 3) BRING TEST MATERIAL TO THE UNDER SEWING MACHINE PRESSER
- 4) PUSH RESET SWITCH⑤ PULL DOWN THE PRESSER (PUSH RESET SWITCH ⑤ AGAIN, PULL UP THE PRESSER).
- 5) PUSH START SWITCH ④, SEWING MACHINE IS STARTING TO WORK.

1 0 . MAINTENANCE AND ADJUSTMENT

(1) FORE- AND AFT POSTION OF PRESSER REAR GUIDE & DEVICE.

1) STOP THE AIR BLOW AND POWER SWITCH, PULL PRESSER REAR GUIDE ① FORWARD (DIRECTION ARROW ②)

2) SPACING BETWEEN PRESSER GUIDE REAR AND NEEDLE HOLE IS 4.5-5MM AT THIS TIME. (ADJUSTMENT) LOOSEN THE SCREW ③ AND ADJUSTING.

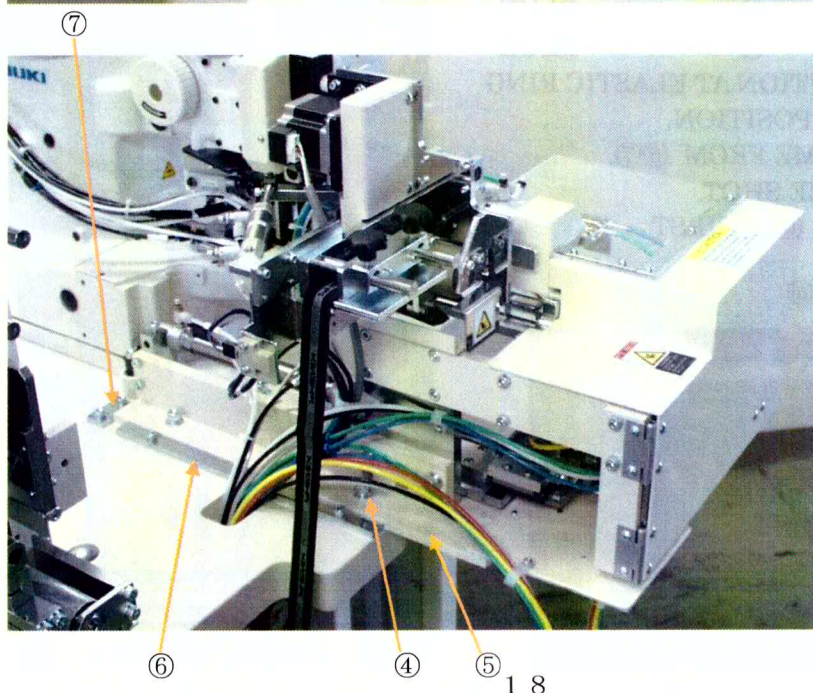
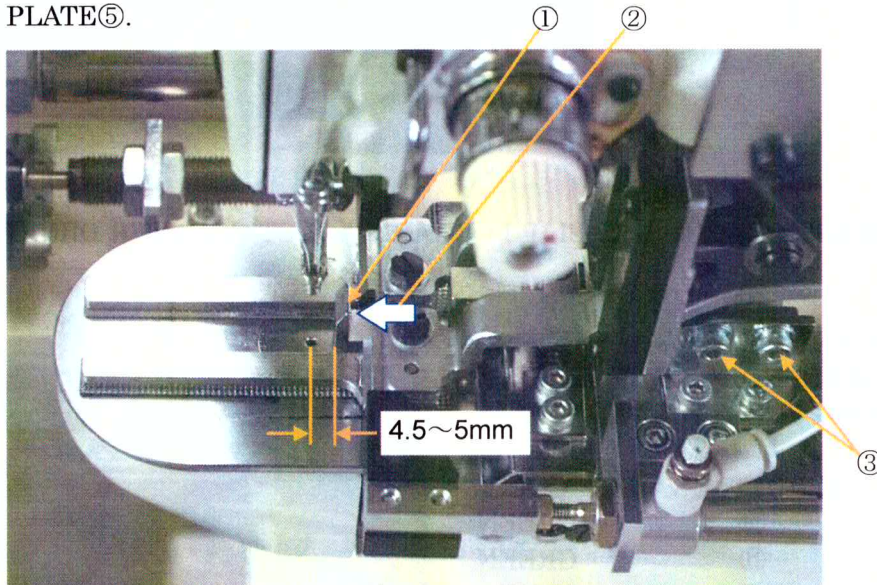
3) WHEN ELASTIC RING BRING TO THE UNDER OF SEWING MACHINE PRESSER, BACK SIDE OF ELASTIC RING JOINT PART CONTACT WITH PRESSER GUIDE REAR①. (CHECKING METHOD) CHECK THE POSITION WHICH ELAXTIC RING BRING TO THE UNDER OF PRESSER AT ONE SHOT OPERATION.

(CAUTION) WHEN ELASTIC RING PUSHING PRESSER GUIDE REAR① SITUATION, IT WILL GAIN ELASTIC RING PUFF UP AND BREAK THREAD OR REJECT. IN CASE OF THIS, ADUST FORE-AFT POSTION OF DEVICE.

• ADUSTING METHOD OF FORE-AFTPOSTION OF DEVICE

LOOSEN THE SCREW ④ (3 SPOTS), MOVE DEVICE BASE PLATE ⑤ FORE-AFT ALONG GUIDE PLATE⑥.

AFTER ADJUSTING, FIX DEVICE FORE-AFT POSITIONING PLATE⑦ CONTACT WITH BASE PLATE⑤.



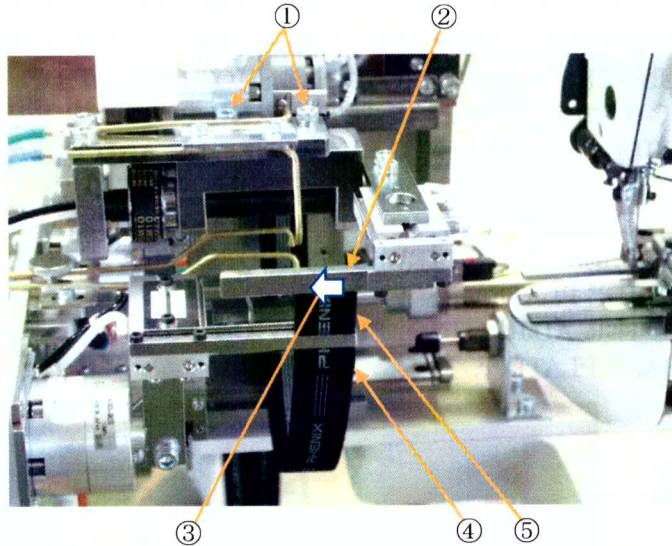
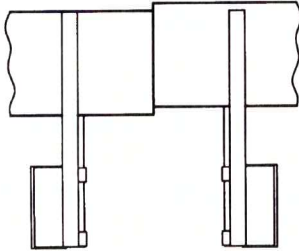
(2) ADJUSTMENT OF TAPE SIDE END SLIP TO CROSS DIRECTION.

• RIGHT END OF ELASTIC RING SLIP TO THE BACK SIDE (LEFT LOWER DRAWING)

1) OPERATING ONE SHOT (P.17) AND BRING WORK FORWARD TO THE PHOTO POSITION.(RIGHT LOWER PHOTO)

2) LOOSEN THE SCREW ① MOVE TAPE PULLER② TO DIRECTION OF ARROW③ (FINE ADJUSTMENT)

CAUTION) AT THE PHOTO POSITION (RIGHT LOWER PHOTO), ADJUST BY VISUALLY CONFIRM ELASTIC SIDE ④⑤ CONNECTING LINE.



• IN CASE OF ELASTIC RIGHT END SLIP FORWARD, ADJUST COUNTER DIRECTION AS ABOVE.

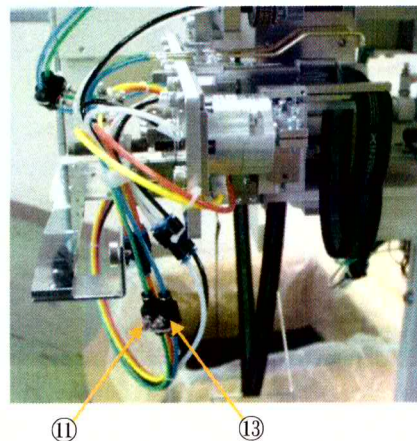
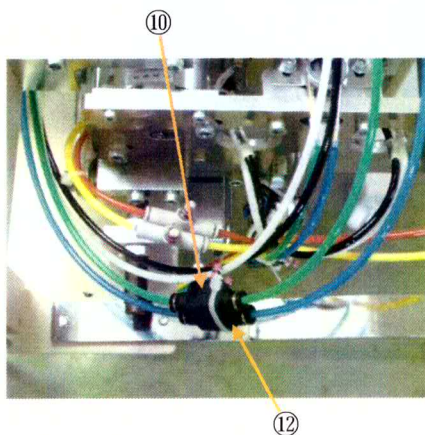
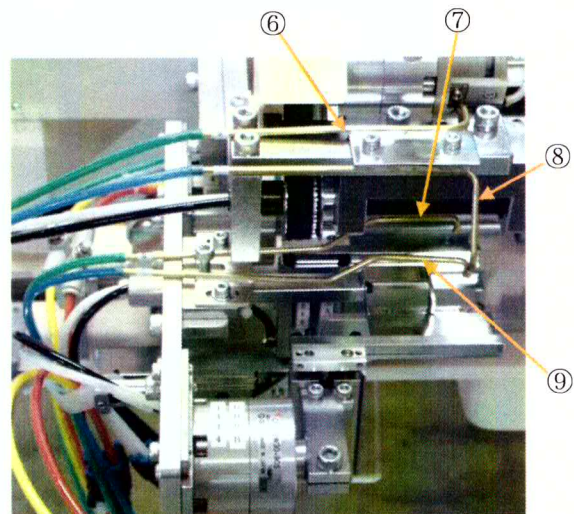
(3) ADJUSTING AIR BLOWING

AIR BLOWING OF AIR NOZZLE⑥-⑨ ADJUST WITH FOLLOWING THROTTLE VALVE ⑩-⑬

AIR NOZZLE	THROTTLE VALVE	COLOR
⑥	⑩	GREEN
⑦	⑪	GREEN
⑧	⑫	BLUE
⑨	⑬	BLUE

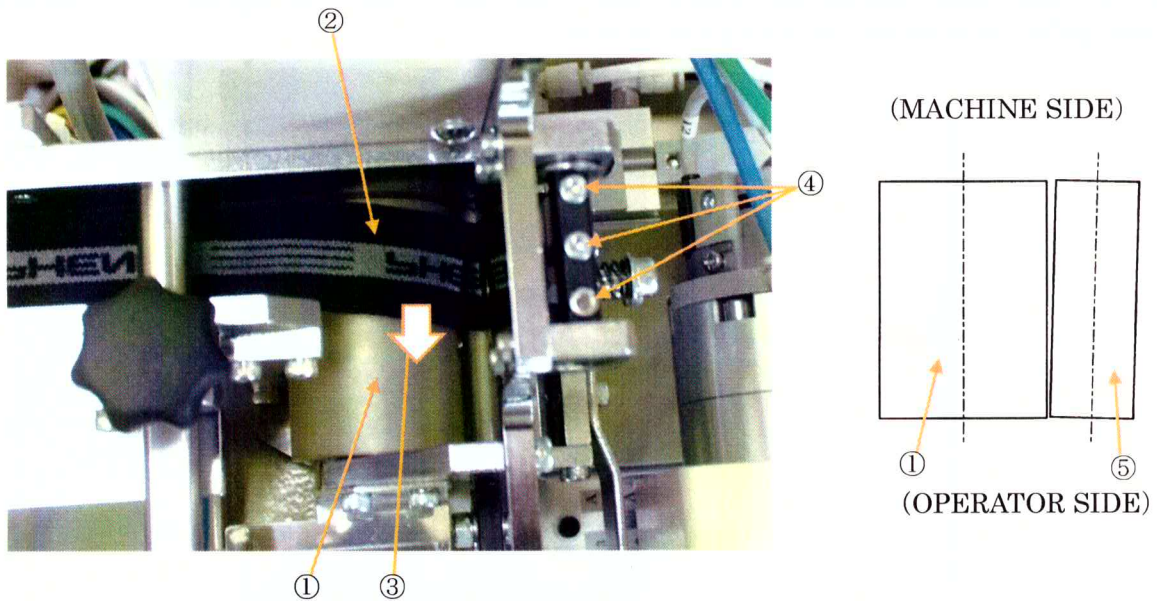
ADJUST THE POSITION AT ELASTIC RING SETTING SUSPEND POSITION.

AIR BLOWING COME FROM ⑥⑦.
WHEN OPERATE ONE SHOT,
ADJUSTABLE ONLY ⑥⑦, FIRST



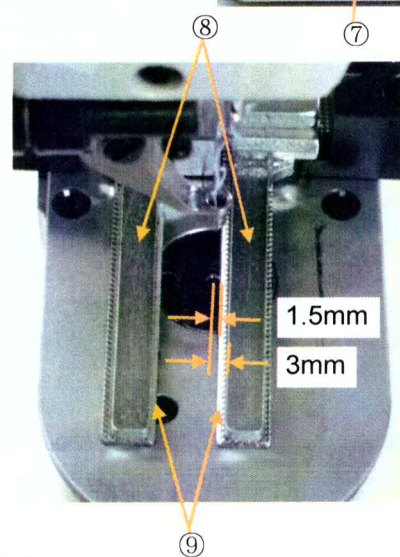
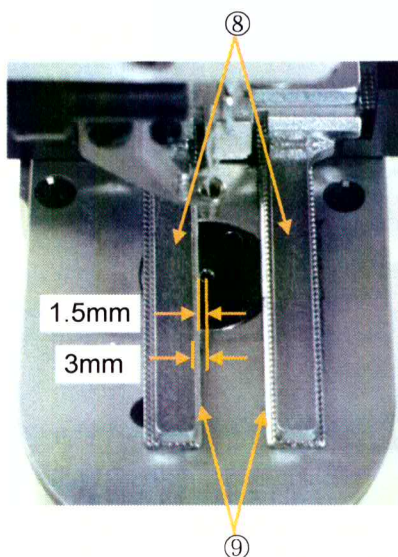
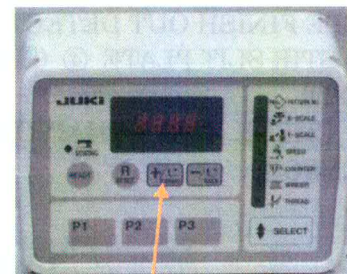
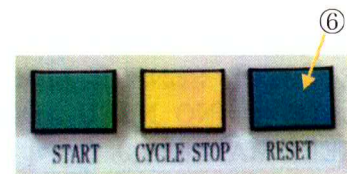
(4) FEEDING ROLLER PART ADJUSTMENT

- IN CASE OF ELASTIC②SLIP TO DIRECTION OF ARROW③ AT FEEDING ROLLER PART
- ① ADJUST FEEDING ROLLER PART.
- 1) LOOSEN THE SCREW.
- 2) TILT PRESSER ROLLER SLIMLY TO DIRECTION OF PHOTO.



(5) BASIS OF ADJUSTMENT OF SEWING MACHINE PRESSER PLATE AND RECEIVING PLATE

- 1) PUT OFF NEEDLE. SWITCH OVER THE MODE TO SEWING MACHINE ISOLATED OPERATION. (P.17)
- 2) SETUP SEWING PATTERN (P8)
- 3) PUSH RESET SWITCH⑥, PULL DOWN PRESSER PLATE.
- 4) PUSH +/FORWARD KEY ⑦ AND MOVE PRESSER PLATE ⑧ AND RECEIVING PATE ⑨
- 5) PRESSER PLATE ⑧ INSIDE POSITION IS MORE OVER 1.5MM THAN RECEIVING PLATE ⑨ INSIDE.
- 6) ADJUSTMENT, LOOSEN THE FIXING SCREW OF RECEIVING PLATE, PRESSER PLATE.



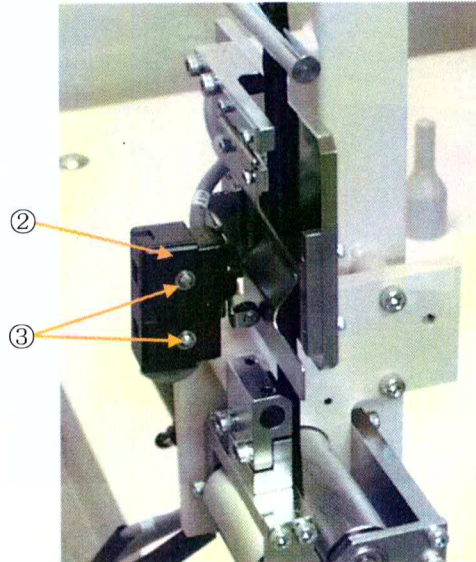
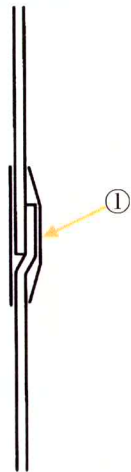
(6) JOINT SEAM AND FINISH OUT OF ELASTIC TAPE DETECTING

• ADJUST THE JOINT SEAM DETECTOR SWITCH② WHEN JOINT PART HUMP ① PASS THROUGH.

(ADJUSTING)

1) LOOSEN SCREW ③

2) AT THE TIME, THE HUMP①PASS THROUGH THE DETECTOR, ADUST ITS POSITION THE DETECTOR START TO ALERT WARNING.



• WHEN USE WHITE COLOR OR SHEER MATERIAL, TRANSPARENT MATERIAL, THE DETECTOR SENSOR LIGHT WILL PASS THROUGH THE MATERIAL. ADUST SLIT PLATE ④ (NO NEED ADJUSTING MORE THE SENSOR AFTER FIXED WITH MOST SHEER MATERIAL).

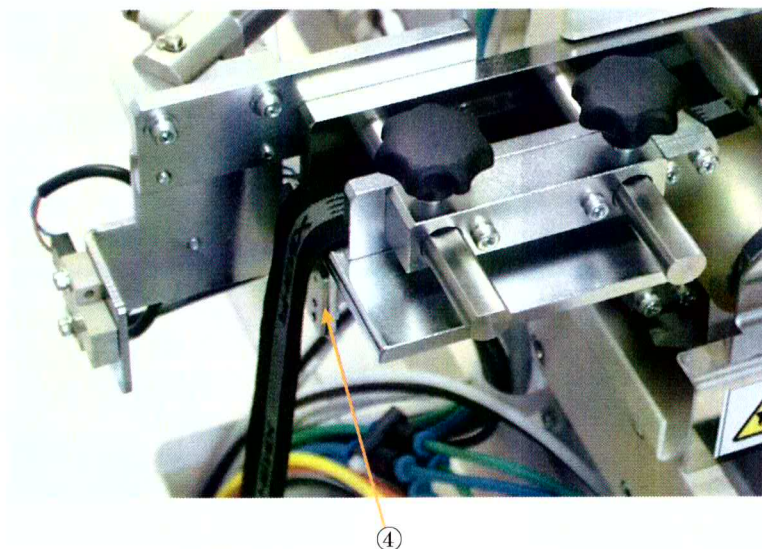
(ADJUSTING)

1) TURN ON THE POWER SWITCH

2) PUT IN THE SHEER MATERIAL WHICH INVITE ERRORS IN SENSOR TO ELASTIC TAPE FINISH OUT DETECTING PART.

3) STIR SLIT PLATE ④ (SPLAY SLIT PLATE ④) AND DECREASE THE SENSITIVITY TO IT.

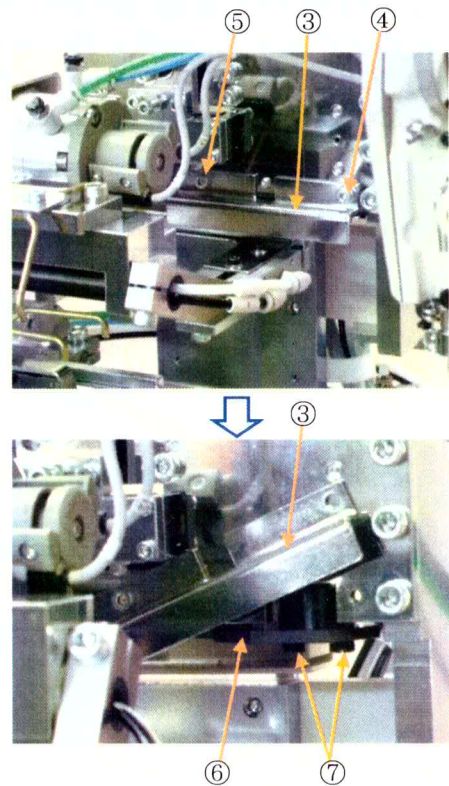
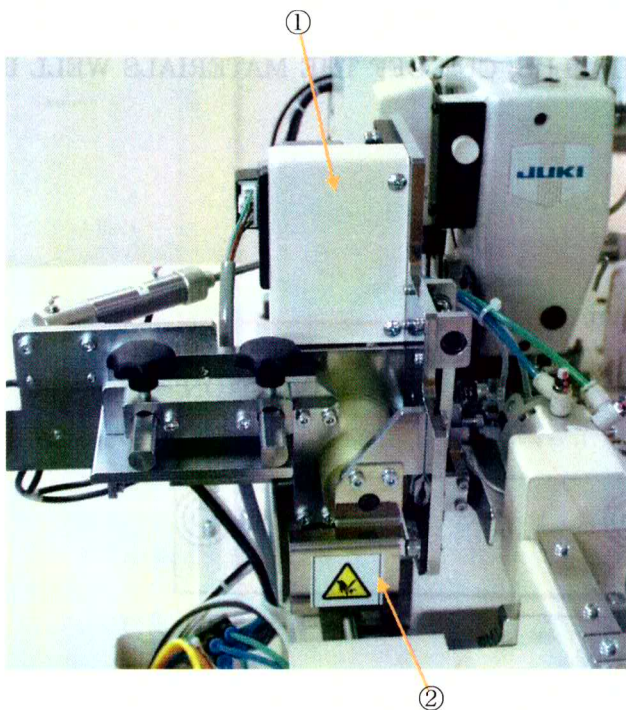
4) CHECK THE BEHAIVOR LAMP WHICH ON THE LIGHT RECEIVING SECTION OF SENSOR.



(7) REPLACING KNIFE AND ADJUSTMENT

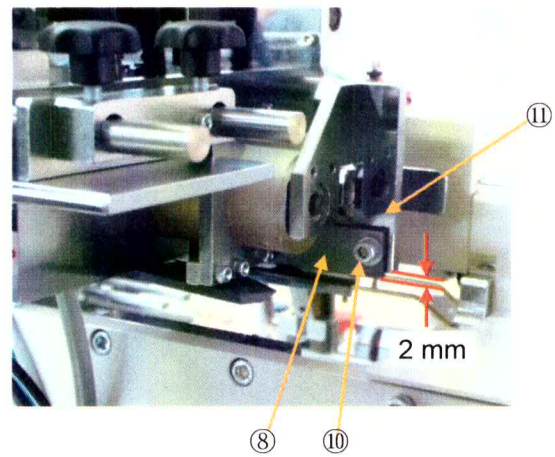
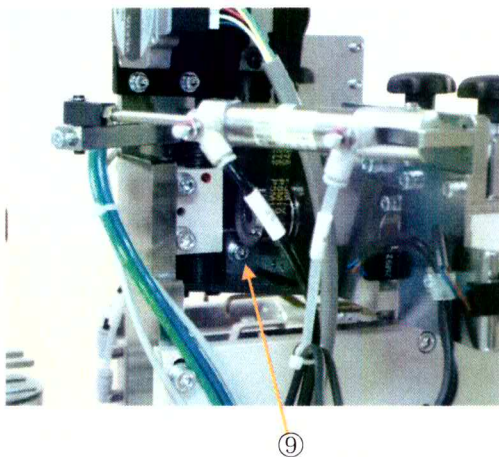
• REPLACING MOVING AND FIXED KNIFE

- 1) TAKE OFF COVER①, ②
- 2) AS COVER③, TAKE OF SCREW④, LOOSEN THE SCREW ⑤ AND TEMPORARY JOINT AS PHOTO RIGHT LOWER.
- 3) REPLACING OF MOVING KNIFE⑥, TAKE OFF SCREW ⑦



- 4) REPLACING OF FIXED KNIFE⑧, TAKE OFF SCREW ⑨⑩

BASIS OF SETUP THE FIXED KNIFE⑧: SETUP BLADE EDGE 2MM LOWER THAN BASE PLATE⑪ LOWER SURFACE.



• BASIS OF KNIFE ADJUSTMENT

1) BASIS 14MM OF SPRING PART ① AS THE DIAGRAM BELOW INDICATES.

(ADJUSTMENT BASIS OF KNIFE LAPPING PRESSURE)

ADJUSTMENT, LOOSEN THE SCREW ②

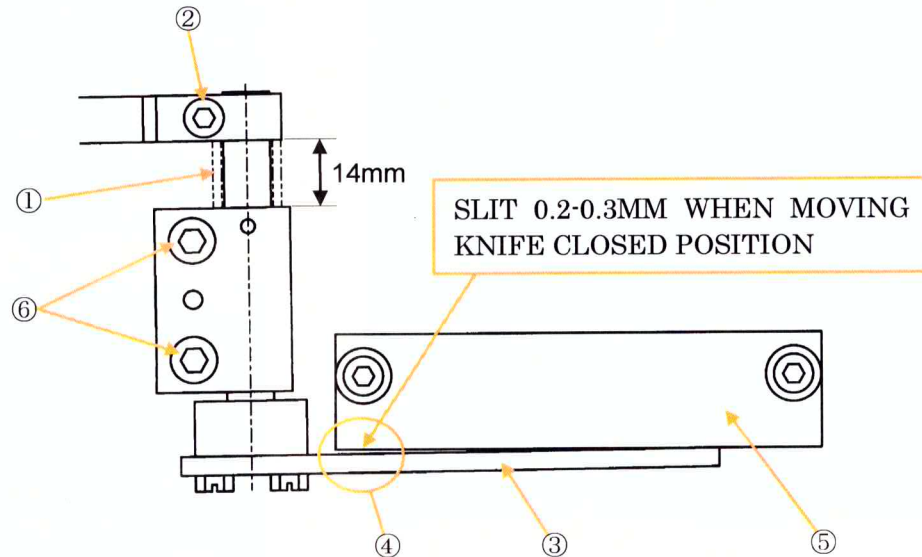
2) WHEN THE MOVING KNIFE ③ HAS CLOSED AT THE POSITION AS ABOVE 1)

ADJUST THE SLIT TO BE 0.2-0.3MM BETWEEN MOVING KNIFE ③ AND FIXED KNIFE

⑤ AS THE DIAGRAM BELOW INDICATES ④)

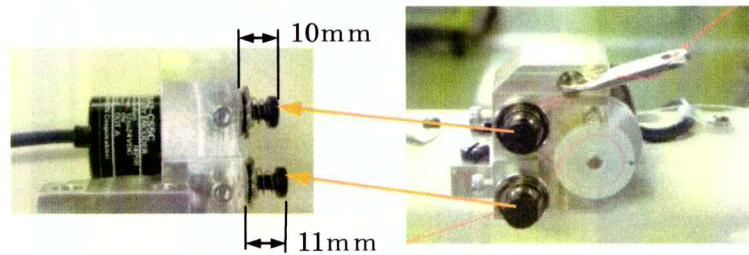
ADJUSTMENT, LOOSEN THE SCREW ⑥

CAUTION) WIDEN PART ④ SLIT IN SURPLUS, CUT OFF THE MATERIALS WELL BUT BECOM WORN AWAY. FASTER



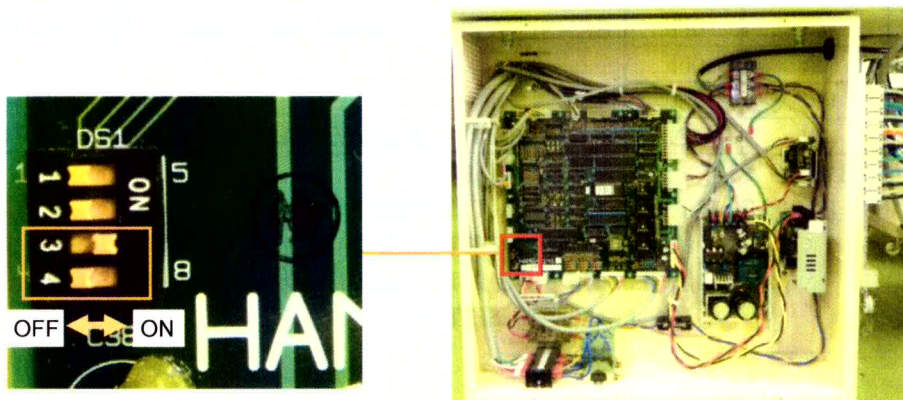
1 1 . ADJUSTMENT OF THREAD-BREAKAGE DETECTOR

(1) STANDARD FOR TENSION ADJUSTMENT OF THREAD-BREAKAGE DETECTOR



(2) SENSITIVITY ADJUSTMENT OF THREAD-BREAKAGE DETECTOR

a . IN THE CASE OF MACHINE USE [HAMS-0141] MAIN BOARD



SETTING	DS1-3	DS1-4	
①	OFF	OFF	<div>SENSITIVITY IS HIGH. MACHINE STOPS OFTEN.</div> <div>↕</div> <div>SENSITIVITY IS LOW. MACHINE NOT STOPS SELDOM</div>
② (NORMAL)	ON	OFF	
③	OFF	ON	
④	ON	ON	

STATE WHEN DELIVERDS IS ②. (NORMAL SETTIING)

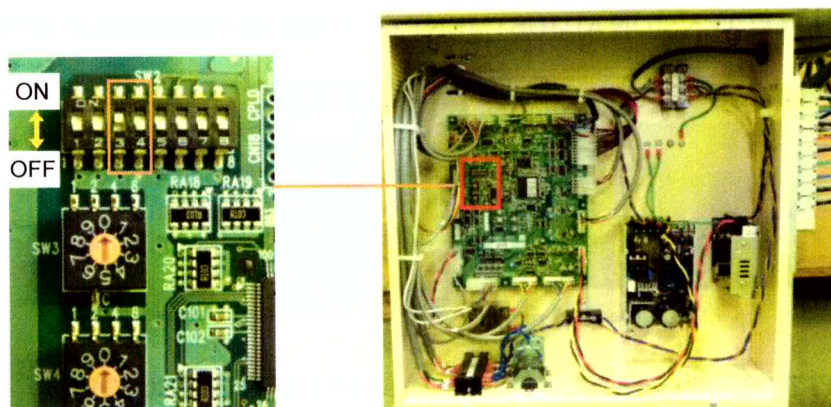
SETTING CHANGE EXAMPLE : WHEN SEWING IS NOT HAPPENED AND MACHINE STOP.

→CHANGE TO SETTING③

WHEN BOBBIN THREAD IS FINISH AND MACHINE NOT STOP

→CHANGE TO SETTING①

b. IN THE CASE OF MACHINE USE [HAMS-1171] MAIN BOARD



SETTING	DS1-3	DS1-4	
①	OFF	OFF	<p>SENSITIVITY IS HIGH. MACHINE STOPS OFTEN.</p> <p>↕</p> <p>SENSITIVITY IS LOW. MACHINE NOT STOPS SELDOM</p>
② (NORMAL)	ON	OFF	
③	OFF	ON	
④	ON	ON	

STATE WHEN DELIVERDS IS ②. (NORMAL SETTING)

SETTING CHANGE EXAMPLE : WHEN SEWING IS NOT HAPPENED AND MACHINE STOP.

→CHANGE TO SETTING③

WHEN BOBBIN THREAD IS FINISH AND MACHINE NOT STOP

→CHANGE TO SETTING①