

USER'S MANUAL SBF-20

Automatic Button Feeder

 FOR AT MOST USE WITH EASINESS, PLEASE CERTAINLY READ THIS MANUAL BEFORE STARTING USE.
 KEEP THIS MANUAL IN SAFE PLACE FOR REFERENCE WHEN THE MACHINE BREAKS DOWN.

MME-090929

SunStar CO., LTD.

USER'S MANUAL

SBF-20 Automatic Button Feeder





- 1. Thank you for purchasing our product. Based on the rich expertise and experience accumulated in industrial sewing machine production, SUNSTAR will manufacture industrial sewing machines, which deliver more diverse functions, high performance, powerful operation, enhanced durability, and more sophisticated design to meet a number of user's needs.
- 2. Please read this user's manual thoroughly before using the machine. Make sure to properly use the machine to enjoy its full performance.
- 3. The specifications of the machine are subject to change, aimed to enhance product performance, without prior notice.
- 4. This product is designed, manufactured, and sold as an industrial sewing machine. It should not be used for other than industrial purpose.



CONTENTS

1.	Machine safety regulations	6	
2.	 M/C structure & specifications 1) Basic parts and option parts 2) Machine structure 3) Machine specifications 4) Control box specifications 5) Control box inner structure 	8 8 9 9 10 11	1(
3.	Installation 1) Table 2) Button sewer & button feeder 3) Button bowl 4) Air wiper 5) Filter regulator 6) Connecting air tube 7) Exchanging button clamp	12 12 13 17 20 21 22 24	1.
4.	Power voltage 1) Power voltage specifications	25 25	12
5.	Changes according to frequency 1) Motor specification change according to frequencies - 2) Installation of vibration connector according to frequencies	26 26 27	14
6.	Connection of control box cables 1) Connections inside the control box 2) Connections outside the control box	28 28 29	15
7.	Program unit panel method of use 1) Names of parts 2) Initial screen 3) Key functions 3-1) Displayer keys 3-2) Transfer time adjusting key 3-3) Main function keys	30 30 31 32 32 33 34	16
8.	Test 1) By air valve 2) By hand	39 39 40	
9.	Button change 1) Changing feeding pin	41 41	

 2) Changing button clamp 3) Chute adjustment 4) Buttons that are not allowed to use 5) Using buttons whose diameter is less than 10mm 6) Button selector 	42 43 44 44 45
10. Operation1) Building the button column	48 48
 11. Maintenance	49 49 50 54 54 55
12. Troubleshooting	56
 13. Other 1) Initializing the machine 2) Parameter setting 3) Parameter setting method 	58 58 59 60
14. Error signs and troubleshooting	62
 15. Machine test function	63 64 65 66 67 68
 16. GUIDE BOOK for installing other compare machine	y's 69 69 73 74 76 78 80

Machine Safety Regulations

The safety signs in this manual are DANGER, WARNING and CAUTION.

If you do not follow these instructions, it may cause physical damage or machine breakdown.

DANGER : This sign should be observed carefully. If the instructions are not followed, it may cause harm during the installation, conveyance and maintenance of the machine.

WARNING : If you follow the instructions under this sign, you will prevent harmful effects.

CAUTION : If you follow the instructions under this sign, you will prevent errors from happening.

1-1) Machine Conveyance	 Only experienced workers fully aware of the safety guide should carry the machine. When carrying the machine, follow the following instructions. (a) At least 2 people should carry the machine. (b) To prevent accidents when carrying the machine, please clean all oil stains found in the machine.
1-2) Machine Installation	 When installing the machine, physical damage such as machine malfunction or breakdown may occur due to the machine's surrounding. Therefore, please satisfy the following conditions. (a) When unpacking the machine, start in order from the top. (b) Because dust and humidity contaminate or cause the machine to erode easily, install a dehumidifier or air cleaner and clean the machine frequently. (c) Keep the machine away from direct sunlight. (d) Leave 50 cm of space between the machine and the wall on the right, left and back of the machine to have sufficient repairing space. (e) Danger of explosion • Do not operate the machine in an environment inducive of explosives. • If the machine operation has no special guarantee, do not operate the machine on hazardous places including those that use aerosol spray cans or places that have oxygen-related products in order to avoid explosions. (f) This machine does not include lighting devices. You must supply and install your own lighting equipment for your work area.
1-3) Machine Reparation	 When the machine needs repair, a trained A/S technician from the company must carry out the repairing job. (a) Before cleaning or repairing the machine, make sure to stop all machine operations and wait 5 minutes until the machine becomes completely discharged. (b) You must not change any of the contents or specifications of the machine without previously consulting with a SunStar company worker. These changes can threaten safe machine operations. (c) When repairing the machine, make sure to use genuine parts from our company. (d) After repair, make sure to put back all the safety covers that were removed during repair.



1-4) Machine Operation	The SBF-20 is a button feeder made for industrial purposes.
WARNING	 Make sure to follow the instructions below when operating the machine. (a) Read this manual thoroughly and understand it exhaustively before operating the machine. (b) Wear appropriate clothes for work safety. (c) Do not put your hand or any part of your body near any machine part that moves (button feeding pin) while the machine is operating. (d) Do not remove any safety plates or any type of cover while the machine is operating. (e) Make sure to connect all ground conductors. (f) Shut off all electric operations and make sure that the power is "OFF" before opening the control box. (g) If possible, install all strong electric wave sources such as high frequency welders, etc. away from the machine. [Warning] Your hand or finger can be cut or injured due to the button feeding pin, so never put your hand or any body part near the machine while the machine is operating.
1-5) Location of Caution Signs	WARNING Image: A state of the state o

2

M/C Structure & Specifications

1) Basic Parts and Option Parts

A. Button Sewer / Button Feeder Set

- 1 Basic Parts and Accessory of Button Sewer
- 2 Feeder and Button Bowl
- 3 Filter Regulator and Accessory
- (4) Table (Ass' y)

B. Basic Parts of Button Feeder

- 1 Feeder and Button Bowl
- ② Button Clamp(Ass' y)
- 3 Filter Regulator and Accessory

C. Option Parts of Button Feeder

① Pedal(Ass' y) : Pedal for exclusive use of Sunstar's button sewer

2 Table

No.	Name	Explanation	Note
1	Table A	For Sunstar's belt-type button sewer (SPS/A-B1202)	
2	Table B	For Sunstar's direct drive motor button sewer (SPS/B-B1202)	
3	Table C	For JUKI's chain-stitch type M/C(MB-373, 372)	
4	Table D	For JUKI's lock-stitch type M/C(LK-1903)	
5	Table E	For Brother's chain-stitch type M/C(CB3-B916, B917)	
6	Table F	For Brother's lock-stitch type M/C(BE-438C)	

3 Feeder Base

No.	Name	Explanation	Note
1	Base A	For JUKI's chain-stitch type M/C (MB-373, 372)	
2	Base B	For JUKI's lock-stitch type M/C (LK-1903)	
3	Base C	For Brother's chain-stitch type M/C (CB3-B916, B917)	
4	Base D	For Brother's lock-stitch type M/C(BE-438C)	

4 Spinning Rubber Guide(S) : Part that ONLY used for the button whose diameter is less than 10mm

No.	Product No.	Product No.	Specifications	Remarks
1	GP-035109-02	Button rotary rubber	8mm	
2	GP-017718-03	Chute button presser bar B	8mm	
3	GP-018212-00	Button chute plate (small)	8mm	
4	GP-038227-00	Main shaft motor head gear	S6DA30B	60Hz
5	GP-038228-00	Main shaft motor head gear	S6DA30B	50Hz



2) Machine Structure



3) Machine Specifications

Feeding and Sorting of Buttons	By Vibrator
Button Feed Mode	Automatic / Semi-Auto / Manual Mode
Button Size Control	Automatic Control Mechanism by a Sample Button
Button Feed Mode	Horizontal Feeding System
Compressed Air	0.49MPa (5.0 kgf/cn²)

4) Control Box Specifications

Item		SBF-20			
Power voltage		Single phase 220V			
Frequency		50Hz , 60Hz			
	Main motor	S8I25GXCE		50Hz	60Hz
Motor Specifica-	Chute motor	SEIDEGYCE	Gear	S8DA9B-K52	S8DA10B-L02
tions	(Button feed motor)	301000,002	Head	50Hz	60Hz
	(Button hold motor)	M41A3G2Y		S6DA15B-K67	TS05-0061
Vibrator		50Hz , 60Hz			
Temperature		5℃ ~ 40℃			
Humidity		20% ~ 80%			
Fuse		250V , 2A			
Time to supply the buttons after sewing		Max: 244[ms] (Out of the factory: 24[ms])			
Time to rotate left and right rubber		Max : 1.93[s] (Out of the factory: 760[ms])			
Time for sewing twice		Max : 1.94[s] (Out of the factory: 380[ms])			
Chute closing time		Max : 464[ms] (Out of t	he fac	tory: 220[ms])	



5) Control Box Inner Structure



3 Installation

1) Table

A. Driven by belt (SPS/A-Series)



B. Direct Drive Type (SPS/B-Series)





2) Button Sewer & Button Feeder

When you install a feeder after an additional procurement together with Sunstar's button sewer, please exchange the button clamp in the button sewer which is provided with the button feeder referring to the corresponding the page 24 of it.

A. Fix the oil tube holder ①, oil holder ②, control box ③, power switch ④, and setting base ⑤ on the table.



B. Attatch the bed cushion rubber to the setting base.





C. Add the hinge metal and hinge rubber to the bed. Then insert the fixing bolt into the hinge metal hole of point ① and fix the table as shown in the [Fig.3].



[Danger]

The machine should be carried by more 2 people for safety.

D. Stand the machine as shown in the [Fig. 4], and then fix the machine on the table after inserting the fixing blots into the hinge metal holes of point ①.



E. Screw the bed fixing bolt on the back of the table as drawing [Fig. 5].



[Fig. 5]

[Danger]

Since the machine is not perfectly installed on the table, extreme care is needed when you make the machine stand up not to have any accident occurred.

- F. Please kindly refer to Page 20 in the manual of the button sewer concerning the connection of the button sewer connector and the installation of other parts.
- G. Temporary fix the 4 fixing bolt ① on the table after you properly put button sewer on the table.



H. Start setting the button sewer and the feeder. Power on the button sewer and adjust the operation box by using the provided basic pattern no. 1 after inserting the button clamp no. 2 and the transfer plate no. 3 in the feeder. And correct the left backward pin among the 4 ones and the center of needle exactly as shown in [Fig. 7] when it stops at the center of the button clamp for a while by operating the feeding pin manually during the power on.(please, refer to Page 40). Fix the feeder on the table tightly by fastening 4 EAs of the fixing screw after the setting.



[Danger]

Please progress on by making sure the changed status of the setting when fastening the fixing screws.





[[]Fig. 12]

15

J. Attach the adjacent ① which monitors whether the button sewing machine is functioning thread trimmer in the inner part of Arm. At that time, fix the sensor (Set ① & ②) by using the screw ③.



[Fig. 13]

Adjust the position of sensor to correct the distance from the end terminal of the sensor ① to the thread loosening pin ④ to be about 1mm.



[Fig. 14]



3) Button Bowl



A. Put in fixing screw after laying the table ring on the table.



[Fig. 16]



[Fig. 17]

B. Temporary fix the nut ${\rm (I)}$ to attach the table ring and table.

C. Temporary fix the fixing nuts ①, ② after assemble vibrator base at the fixing screw.



D. Strongly tighten fixing nut ① of the [Fig.17] after correctly put the vibrator on rubber base. Press once to rubbers go into the hole. (Electric wire has to be toward button supplier)





E. Temporary fix the fixing screw ${\rm \textcircled{O}}$ after put button feeder on vibrator.



[Fig. 20]



F. Loosen fixing nuts ①, ② as in [Fig.18]. Use the setting gauge① to adjust the chute belt (A) in [Fig.21] and the height of feeder entrance (B) to be distant from each other by 1mm, and tighten the fixing nuts. Loosen the fixing screw ① as in [Fig.20] and use the setting gauge ② to make the chute' s right side (C) distant from the button feeder' s right side (D) by 2mm and then tighten the screw. If the distance is incorrect, make the adjustment by using the nuts ①, ② as in [Fig.18].





G. Lock the handle ① in drawing [Fig. 22] after setting vibrator and button bowl. And connect vibrator jack and feeder jack as drawing [Fig. 23].





H. Strongly tighten the bolt in drawing [Fig. 24] after all setting. (It is very important to vibration.)



[Fig. 24]

4) Air Wiper



A. Please fix the wiper bracket A in the button sewer body by using the fixing screw ① as shown in [Fig. 26].



[Fig. 26]

B. Adjust the air wiper ① to prevent that thread out from needle.



[Fig. 27]



5) Filter Regulator



Gauge pressure has to be 0.5MPa(5kgf/cm²). (Caution : Minimum 4kgf/cm²~maximum 6kgf/cm². The machin go wrong under airpressure 4kgf/cm².) Hold up to turn ①. Air pressure will be up if you turn it left. Air pressure will be down of you turn it right. Please press a handel after adjusting airpressure. Loosen ② to remove the water in A after long time works. The cylinder will be wrong if water exist in A.

6) Connecting Air Tube





Air System Circuit Diagram



7) Exchanging Button Clamp

Among the users of 'SPS/A-B1202' and 'SPS/B-B1202', if you want to use 'SBF-20' additionally, you shall exchange the existing button clamp into an exclusive button clamp.

A. Separate the tension adjusting screw (Set) ①.Take out the button clamp holder shaft③ by unfastening the fixing screw (2EA)②.



[Fig. 28]

B. Separate the button clamp (Set) ④ as shown in [Fig. 28].



[Fig. 29]

C. After mounting the exclusive button clamp ①, fix the button clamp ① by using the button clamp holder ② and the fixing screw (1EA) ③. Finally attach the tension adjusting screw (Set) ④.



[Fig. 30]



4 **Power Voltage**

- 1) Power Voltage Specifications
 - A. Exclusive use for single phase 220V
 - B. Changing the power voltage
 - Change the power voltage by using a transformer
 - Transformer model being used: SBF-20-220



If the transformer model being used is incorrect, you may damage the control box. Always use the instructed model.

Changes According to Frequency

You may use both the 50Hz and 60Hz frequencies for the model SBF-20. The specifications for the motor and vibrator change according to these two interchangeable frequencies.

1) Motor Specification Change According to Frequencies

Category	Model	Gear Head		
		50Hz	60Hz	
Main Motor	S8I25GXCE	S8DA9B-K52	S8DA10B-L02	
Chute Motor (Button Feed Motor)	S6IO6GXCE	S6DA15B-K67	TS05-0061	

* The left and right rotating motor (button holding motor) does not use a gear head.



If the gear head specifications according to frequencies do not match, the button feeding operation may not operate smoothly.





2) Installation of Vibration Connector According to Frequencies

Connection of Control Box Cables

1) Connections Inside the Control Box





2) Connections Outside the Control Box



Program Unit Panel Method of Use

1) Names of Parts



- 1 Main motor ON/OFF Key
- 2 Auto / Semi-Auto Mode Key
- ③ Double / Single Mode Key
- ④ Chute Motor ON/OFF Key
- (5) Chute Motor Clockwise / Counterclockwise Rotation Mode Key
- 6 Vibrator ON/OFF Key
- Displayer Screen
- 8 + Key
- 9 Key
- 10 Clear Key
- 1 Displayer Screen of 'Transfer Time' Value
- 12 Up Key
- (13) Down Key
- 14 Parameter Key
- **(15)** Vibrator Adjusting Device
- ◎ Light



2) Initial Screen

■ When you turn the power on, you will see the last programmed work of the button feeder. (Example)



On the figure above, the programmed work of the button feeder before the power was turned on is as follows:

- Button feeding mode : SEL 1
- Work amount : 123
- Chosen value for transfer time : 0
- Main motor was operating
- Auto mode was selected
- Single mode was selected
- Chute motor was operating
- Chute motor was rotating clockwise
- · Vibrator was operating

3) Key Functions

3-1) Displayer Keys



When buttons are fed after sewing work is completed, the number in the displayer will automatically increase by +1.

Screen showing work amount	 If the buttons are fed, the number on the displayer will automatically increase by +1. The numbers "0" to "9999" will appear on the screen. After "9999", the number "0" will appear again.
(+) Key	• Everytime this key is pressed, the number in the displayer will increase by +1. (If you continue to press this key, the number will increase automatically.)
(-) Key	 Everytime this key is pressed, the number on the displayer will decrease by –1. (If you continue to press this key, the number will decrease automatically.)
(CL) Key	Reset the number appearing on the displayer to "0".



3-2) Transfer Time Adjusting Key



This key controls the time the button feeder starts feeding buttons after sewing work is completed.



* Number "0" signifies that the buttons will be fed at the fastest speed while number "9" signifies that the buttons will be fed at the slowest speed.

3-3) Main Function Keys



Main Motor's ON/OFF Key

Everytime these keys are pressed, the main motor will turn on and off repeatedly.

* The displayer key and transfer time adjusting key operate independently from the main motor's on/off key.





Auto/Semi-Auto Mode Key

Everytime you press these buttons, the Auto or Semi-Auto modes are repeated. X You can operate the functions of these keys when the main motor is operating.





Double / Single Mode Key

This key is used for button sewing or when you want to sew buttons twice as fast or faster than the basic sewing time. This key is used only for **Chain Stitch** button sewing machines. XYou can operate the functions of these keys when the main motor is operating.




Chute Motor ON/OFF Key

This key turns ON/OFF the button feeding belt. X You can operate the functions of these keys when the main motor is operating.

Stop O Chute Motor Run	Chute motor is operating.
Stop Chute Motor Run	Chute motor has stopped.

Chute Motor's Clockwise and Counterclockwise Rotation Mode Key

% You can operate the functions of these keys when the main motor is operating.% You can operate this key when the chute motor is operating.

Back O Chute Motor Forw	• The chute motor will rotate clockwise and the buttons can be fed through the button feeding pin.
Back Chute Motor Forw	 The chute motor will rotate counterclockwise and the buttons on the button feeding belt will be sent towards the direction of the vibration.

■ Vibration ON/OFF Key

* You can operate the functions of these keys when the main motor is operating.

* Refer to the page 27 on selection of connectors according to local frequency type.



Adjusting Vibration Intensity



If you turn the vibration adjusting dial to the right, the vibration becomes stronger.

* The user must adjust the intensity of the vibration according to the programmed work.



8 Test

1) By Air Valve



2) By Hand



[Fig. A]

Another method to move feeding pin : Disconnect air jack first, feeder's clutch will be open if you put thin stick into a hole ① screw dirver such as drawing [Fig. A]. If you turn the handle as drawing [Fig. B], the

feeding pin will be moved as drawing [Fig. C].







[Fig. C]



9 Button Change

1) Changing Feeding Pin

		Button	Range fo	Expansion &	Nista
(Button)	No.	No. of hole	Sewing(mm)	Reduction(%)	Note
resion & Reduction) 59 % 74 % 100 % 112 %	4	2	2.5	74%	
	11	4	2.2×2.2	65%	
	2	2	2.9	85%	
	2	4	2.7×2.7	79%	Standard range
	2	2	3.5	103%	$\rightarrow 2 1 (\times 2 1)$
RITTON CITE OUT OF	3	4	3.2×3.2	94%	
BUTTON SIZE CHECK	4	2	4	118%	[100%]
	4	4	3.8×3.8	112%	
• 3 0 3 0 0 2 9 6 *	5	2	4.5	132%	
	5	4	4.5×4.5	132%	
[Fig. 31]					

A. Put a button in button hole size check board which is suitable number of pin as drawing [Fig. 31]. For example, as drawing [Fig. 31] use feeding pin 4 hole No. 3 if the button hole is suit able for 4 hole No. 3.



[Fig. 32]

B. After selecting the feeding pin, press ① part and loosen fixing screw ② to change transfer pin as shown in the [Fig. 32]. For example, as drawing [Fig. 31] use feeding pin 4 hole No. 3 if the button hole is suit able for 4 hole No. 3. (Regarding selection of feeding pin, please refer to the attached sticker in the machine.) Please establish a range of sewing (expansion and reduction) for the button sewing machine dependent on the interval between button holes by referring the above Table. Please establish 94% of the expansion and reduction for the 4 hole No. 3.

2) Changing Button Clamp



- A. Insert the buttons to be used into (A) as in [Fig. 33]. Depending on the colors pointed by the pin as in [Fig. 33], choose the number of the button clamp. For example, when the pin ① points at yellow, choose No. 2 button clamp (as for the choice of button clamps, see the sticker attached to the machine).
- B. Choose a button clamp as in [Fig. 33], and loosen and remove the fixing screw ① as in [Fig.34]. Insert and tighten the button clamp (for the choice of button clamps, see the sticker attached to the machine).



C. Replace the button clamp chosen in [Fig. 33] with reference to [Fig.34]. Then the button holes get automatically aligned with the center of the needles. Therefore do not loosen the fixing screws ①, ② as in [Fig.35] to make adjustment.



[Fig. 35]



3) Chute Adjustment

This machine is suitable for the buttons whose external diameter is 10mm or above. If it is necessary to use buttons whose external diameter is less than 10mm (up to 8mm in external diameter), make additional purchase of optional parts as in page 8 for replacement.



[Fig. 36]

A. Turn 1 in the arrow direction.

- B. Push ② backward and insert buttons. When inserting buttons, make sure that buttons are placed face-down as in [Fig. A]. If the buttons are placed in the opposite way as in [Fig. B], the buttons are not fed to the chute.
- C. Insert buttons into ③ and move ① back to the original position. Then the buttons are sorted by size, thickness and they are aligned along with the center at the same time.



[Fig. 39]

4) Buttons that Are Not Allowed to Use

For the buttons whose shapes are the following, it shall not be allowed to work using 'The specifications taking out of factory for SBF-20'. You shall place a purchase order with our company after a consultation with us when you are going to use the following buttons.

No.	Name	Explanation	Note
1	Paduk Button		
2	Convex Button		
3	Slope Button	-(/////////////////////////////////////	
4	Shell Button	_	Button that made of shell.
5	Symmetry Button	-	Shape of upper part and that of lower part are same.

5) Using Buttons whose Diameter Is Less than 10mm

If the external diameter of a button is less than 10mm, existing parts should be replaced with exclusive parts (see Page 8).

For replacement, please refer to the figure below (However, when replacing the main shaft motor gear head, the tightening screw must be replaced. Also refer to How to replace the chute motor described in Page 48.)





6) SBF-20 Reverse Rotation Function

① The double gear of the chute motor head is used for reverse rotation. This function should be used only for the 8mm button hole sewing.

O The chute motor should be rotated in the backward direction, thereby making the main shaft motor rotating in the backward direction, too.

3 The following instruction shows the way of using the reverse rotation function. Please keep this in your mind for work.

Instruction for using SBF-20 chute motor head reverse rotation function



Forward rotation mode key for chute motor

% The key is operable when the main motor is in motion.

% The key is operable when the chute motor is in motion.



7) Button Selector

A. Put the button in feeder, loosen ① and adjust ② to make button pass one by one. Tighten ①.





B. When you use shaped button, loosen ①, ② and turn ③ to the clockwise direction ④ rises. It move down if turn to opposite direction. If you lift up ④ shaped button will be passed, with be passed, with be fallen.



C. C. shaped button : loosen ① and adjust ②, tighten ① again as shown in the [Fig. 43].

[Note]

In this occasion the gap in drawing left has to be 2mm. (Continue next page drawing [Fig. 44])





D. As drawing [Fig. 44], loosen to adjust to make right side button pass and wrong side button falls down to A part, and then tighten .

E. To select shaped button. After setting as drawing [Fig. 43], loosen ① to adjust ② that right side button pass, wrong side button falls down to A part, and then tighten ①. The sawtooth can select all kind of buttons which has a furrow.

F. As drawing [Fig. 46], loosen ① to adjust ② to make the buttons go into the chute and tighten ① as drawing [Fig. 47].











10 Operation

1) Building the Button Column

Turn A in the right direction as in [Fig. 48] for the button column reeling. Loosen ① to adjust the height of ② and tighten ① again. If the button column reeling is unnecessary, turn A in the left direction as in [Fig. 49].









11 Maintenance

1) Changing Spinning Rubber



Lift up 1 to change spinning rubber as drawing [Fig. 50].

2) Changing Chute Motor



Loosen the fixing screws ① and ②. Loosen all the fixing screws, pull out the chute and change new chute motor. Tighten the fixing screws ①, ② after making horizon K part and chute motor when you reassemble the motor.

3) Replacing Chute Belt & Chute Bearing



A. Disconnect the chute moter jack as drawing [Fig. 52].



B. Loosen the screws as drawing [Fig. 53, 54, 55] in order.



C. Take out the button lifter ② as drawing [Fig. 56] after pushing ①.



D. Loosen the screw ③ to take out button presser ④ as drawing [Fig. 57. 58]. Loosen the screw to take out chute pillar as drawing [Fig. 59].

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E. Loosen the screw to loose motor coupling as drawing [Fig. 60].

F. Loosen the screw as drawing [Fig. 61] and separate chute both side drawing [Fig. 62].



[Fig. 60]







G. Loosen the screw as drawing [Fig. 63] loosen the screws as drawing [Fig. 64, 65, 66], and then replace the belt as drawing [Fig. 67]. Likewise, replace the bearing in drawing [Fig. 64]. After replacing, reassemble in counter order.



[Fig. 63]



4) Control Button Thickness



[Fig. 68]

In the occasion that buttons doubling as drawing B, button will not fed. To select Shaped buttons. Loosen ① of [Fig. 68] to adjust ② to control height of ③ and ④ 0.3mm as drawing A, and then tighten ①.

5) Control Button Clamp Sensor



If closing time of button clamp is not proper, open the supplier clutch and manually turn the right handle the direction of the arrow. Stop the handle when the feeding pin is middle of needle plate and chute. (As above drawing, adjust screw and feeding pin make parallel) Loosen ① to adjust ② and ③ as drawing B and tighten ①.

* Confirm that buton clamp smoothly open and close.



6) Adjusting the Button Revolving Base Return Spring



[Fig. 70]

When shipped out from the factory, it is set for small buttons as default.

In case of using medium-size buttons, increase the compression pressure a bit higher compared with smaller buttons.

A. Loosen the collar screw ①.

B. Tighten the collar screw making sure that the upper side of the collar is distant from the shaft edge by 4mm.

12 Troubleshooting

No.	Trouble	Solution	Note
1	In the occasion that button clamp wrongly hold to button.	ne Special shaped buttons, loosen A and adjust height of B of button sewer depends on button shape when button clamp wrongly hold or buttons fall down. A Image: Comparison of the comparis	 Special button cover to prevent buttons's separation as the No. 4' s picture. (Special order)
	Normality Abnormality	Normality Abnormality	
	In the occasion that buttons fall down between chi and feeding pin.	Assemble the setting device and move feeding pin as drawing [Fig. 1], [Fig. 2]. Correctly set to the pin into the hole when their condition is as drawing 3.	
2	Normality Abnormality	(Fig.1)	
		[Fig.3]	
		[Fig.4]	
		[Fig.5]	



No.	Trouble	Solution	Note
3	Machine's timing is not correct.	Check air pressure is between 4~6Kgf/cm	
4	In case where buttons are not fixed by the button clamp	In case where buttons are not fixed due to inappropriate height of the button clamp lifter Sometimes 2nd sensor timing makes this problem. Refer to 53 page.	Refer to 53 pages
5	Button clamp opening and closing is not smooth.	Put oil to button clamp.	

13 Other

1) Initializing the Machine

- A. To turn the power on, press the "+", "-" and "CL" keys simultaneously.
- B. On the displayer screen window you will see the letter I n I t and soon the number "0" will appear on the displayer.



Program Unit Panel Condition after Initialization



Parameter Condition after Initialization

Туре	A-01	A-02	A-03	A-04
Value	1	2	4	SEL 1



2) Parameter Setting

The button feeder has four types of parameters.

* If the parameter set value is incorrect, the button feeder may not operate properly.

Туре	Contents	
Sewing Time (Double Key) "A-01"	 This is a parameter used for chain stitch sewing machines. The value range is 0 ~ 9. 	
	• You adjust this number from 1~3 according to the button size.	
Chute Clasics Time	Valve 1 2 3	
"A-02"	Button size 8~10mm 11~25mm 25~32mm	
	 The value range is 0 ~ 4. Do not set the number higher than 4. (The buttons can fall to the floor from the feeding belt while the buttons are being fed) 	
Operating Time for the Left and Right Rotating Motor "A-03"	 This parameter is used for the operating time for the left and right rotating motor which enables buttons to attach to the button feeding pin more easily. The value range is 0 ~ 9. Do not set the number higher than 5. 	
Sewing pattern-based button feed mode "A-04"	 This is a parameter of choosing a button feed mode depending on the button sewing pattern in case of SPS/A(B)-1202. The choice can be made between "SEL1" and "SEL2". SEL1 – one trimming SEL2 – two trimmings See the manual of SPS/A(B)-1202 regarding sewing patterns. When using the chain stitch machine, select the SEL1 mode. 	



If the button feed mode is not consistent with the sewing pattern, damage to the machine might occur. Therefore users shall make sure what button feed mode shall be used in accordance with sewing pattern.

3) Parameter Setting Method

In order to set the parameter, the main motor first must be stopped. All parameter setting methods are as shown below.

(Example) Setting the chute closing time

- The chute closing time is set to "2"





E. If you press the "CL" key, you will see the time setting value on the displayer screen. You can choose the value by pressing the "+" key and "-" key.

(All parameter setting value range is $0 \sim 9$)



F. If you need to choose a new value, press the "CL" key and you will return to the parameter setting screen.

G. If you press the "Prog" key, you will hear the buzzer sound for 2 seconds. And you will also see the displayer screen(Prog) and the light blink with the former work amount value.

Error Signs and Troubleshooting

Error Code	Contents	Cause and troubleshooting
E-01	Check the thread trimming cam sensor connector	Check for bad connection to the connector
E-02	Check the cam sensor connector	Check for bad connection to the connector
E-03	Check the reset switch connector	Check for bad connection to the connector
E-04	Check the air pressure	Check for bad connection to the connector



15 Machine Test Function

Test Mode Setting Method



Test Mode Type

Test Mode Type	Contents
t-01	Motor test
t-02	Solenoid test
t-03	Thread trimming cam sensor test
t-04	Cam sensor test
t-05	Reset switch test

1) Motor Test Function (t-01)





2) Solenoid Test Function (t-02)



3) Thread Trimming Cam Sensor Test Function (t-03)



Thread Trimming Cam Sensor





4) Cam Sensor Test Function (t-04)



Cam Sensor



5) Reset Switch Test Function (t-05)



Reset Switch





16

GUIDE BOOK for installing other company's machine



This guidebook is designed to properly install SBF-10 Auto Button Supplier, only including what is different from this company's manual. Accordingly it is recommended that both manuals are referred when installing the supplier.

■ Applied M/C: Juki, Brother Button Sewing Machine

1.Table

1) Applied M/C : JUKI MB-373











3) Applied M/C : Brother CB3-B916, Brother CB3-B917

4) Applied M/C : Brother BE-436C




2. Base

Insert washer and screws on the grooves of ①, ②, and
③ and tighten firmly the table and the base of the supplier using nuts



2)Put the base of the button sewing machine on the supplier's base and tighten it on the grooves of (3), (4), (5), and (6) with washer and screws and then tighten (1) and (2).

3)Hold S shaped loop⑦ on the base of the button sewing machine as the Picture B. On the opposite of the S shaped loop, the chain of the plate is to be held.



3. Supplier

1)Temporarily tighten the screw① on the under plate of the supplier.



2) After lifting properly the button sewing machine to the base, tighten the bolt ① firmly and then start setting the supplier. The sewing scope (the distance among the button's grooves) of the button sewing machine is adjusted to 3.4mm as follows.

Lever② is fixed to 3 according to Picture A and B and then release ③ to fix ④ to 3. Presser foot 2 and the transfer pin 3 are inserted into the supplier and then turn the handle on the right side of the supplier and open the pressure foot according to Picture C. When the transfer pin stops temporarily on the needle plate before turning back, close the pressure foot according to Picture D and move the supplier gradually to fix the centre accurately. After finishing the setting, tighten four pieces of screw ① firmly.







according to Picture C. When the transfer pin stops temporarily on the needle plate and works again, release the screw? and adjust (8) at intervals of around 2߯ between Part(5) and Part(6) and then tighten them. Note that the needle may be broken as the presser foot and the needle are met when (8) is highly lifted.



4. Wiper

1) Adjust the pneumatic type wiper① in order not to release a thread from a needle.



2) Release the screw according to the Picture A and then adjust the wiper support(2) to make tight between the button sewing body and the wiper support(2) according to the Picture B and tighten the screw (1).





- * How to attach a wiper of the sewing machine type
- 1) In the case of LK-1903 (Maker: JUKI), mount a wiper as follows.



2) In the case of BE-438 (Maker: Brother), mount a wiper as follows.



5. Sensor

 When the button sewing machine stops completely, insert a access sensor ① into ② on the thread take-up on the upper part of the button sewing machine and then tighten it using a screw according to the Picture.



2) The access sensor is mounted when the button sewing body stops.

Attach (1) and (2) at distances of 2mm using adhesives.





% How to attach a sensor of the sewing machine type

1) In the case of LK-1903(Maker: JUKI), mount a sensor as follows.

Please make sure that the distance between a sensor and an applicable part (a trimming arm) is set to 1mm.



2) In the case of BE-438(Maker: Brother), mount a sensor as follows.

Please make sure that the distance between a sensor and an applicable part (a presser driving lever) is set to 1mm.



6.Air tube and electric wires connection

