




Caliber 型號 : **9231K0 (9231/1910)**

Function 功能 : Hour、Minute、Second hands, Sun & Moon 日月星辰

Items 工序	Operations 操作	Tools 工具	Remarks 注意事項
<b>1. Component's Visual checking</b> 成表配件的外觀檢查	1) Check the dial: need to flat, no scratches, no dust, no finger spots, no discoloration. 檢查表面：必須平整，無花痕，無塵，無指紋，無污漬。 2) Check the hands: flat, no scratches, no dust, no finger spots. 檢查表針：平整，無花痕，無塵，無指紋。 3) Check the Case, case back and glass: no scratches, no dust, no finger spots, no discoloration. 檢查表殼、底蓋及玻璃：無花痕，無塵，無指紋，無污漬。 4) Check the hand setting stem: not bent; the crown has to turn round. 檢查把心：無變形，把的可轉動。	 <p><b>TRM03-01</b> 3-head Handfitting tool with movement holder TRT01-32B ( for fitting hour, minute &amp; second hands)</p> <p>3 頭裝針機連 TRT01-32B 機心座 (適用於裝時、分、秒針)</p>	On the casing line, each component has to be checked visually by the collaborator just before assembly.  裝配成表前，必須檢查各成表配件是否合格。
<b>2. Dial fitting</b> 裝表面	1) Align the dial legs to correct position then assemble it. 將表面面腳對准機心面腳孔裝下。 2) Check the centered of dial hole. 檢查表面孔位是否正中。		<p><b>TRT01-32B</b> Movement holder 機心座</p> 
<b>3. Hour、Minute &amp; Second hands Fitting</b> 裝時、分、秒針	1) The crown remains at position 2. Same as time-setting, turn the crown clockwise to change the Sun & Moon disc. As soon as the sun or the moon is point to 12 o'clock, stop immediately. Then, put the movement into the movement holder TRT01-32B of the handfitting tool TRM03-01.  把的保持在位置 2，以調時方法調較日月星辰盆，當太陽或月亮對正 12 時位時即停，然後將機芯放在 TRM03-01 裝針機的 TRT01-32B 機心座內。 2) Set the hour hand, minute hand and second hand one after one. Point them all to 12 o'clock.  逐一將時針、分針、秒針安裝到中央的錶針軸樑，指針須對準指向錶面上顯示的 12 時位置。 3) First check the flatness and the height of all hands. Then turn the crown clockwise check if the Sun & Moon indicator run synchronize with the hour & minute hands:  首先檢查針的高度及平衡度，然後順時針轉動把的檢查日月星辰盆是否與時、分針同步。	<p><b>TRT01-32B</b> Movement holder 機心座</p> 	1) This step must be followed accordingly, if not, the hour hand running will not synchronize with the Sun & Moon disc running.  此步驟必須依足程式進行，否則時針不能與日月星辰盆同步運行。 2) If the sun or the moon of the Sun & moon disc can not point to the 12 o'clock when the hour & minute hands point to 12 o'clock, you have to reassemble the hour hand and minute hands.  如果時、分針指向 12 時位時日月星辰盆的太陽或月亮不能指向 12 時位，則需要重新安裝時針、分針。
<b>4. Stem Removing</b> 拆除把心	1) Use the tweezers tip or other suitable tooling to press down the setting lever slightly then take out the stem.  用鉗尖或其他適當的工具輕輕按下菱角仔拆出把心。		
<b>5. Casing</b> 入殼	1) Put the movement into the case and remove dust and particles. 將機心去塵後裝入表殼。 2) Fit the handsetting. 裝把心。 3) Put and close the case back. 裝上並鎖緊底蓋。		