





Caliber 型號: **9232C1 (9232/1940)**

Function 功能: **Date · Second Time Zone / 24-hour 日曆、第二時區 / 24 小時**

Items 工序	Operations 操作	Tools 工具	Remarks 注意事項
1. Component's Visual checking 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。		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。
2. Dial fitting 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。	TRM03-01 3-head Handfitting tool with movement holder TRT01-32D (for fitting small hands) 3 頭裝針機連 TRT01-32D 機心座 (適用於裝小針)	If the dial hole is not centered, will affect the hands running or the hands offset. 如果表面中孔不正中, 會影響機心行針功能, 或指針指不正。
3. Second Time Zone / 24 hour · Hour · Minute & Second hands Fitting 裝第二時區/24 小時及時、分、秒針	1) Pull out the crown to position 3. Same as time-setting, turn the crown to change the date. Stop immediately as soon as the date jumps. Then put the movement into the movement holder TRT01-32D of the handfitting tool TRM03-01. 拉出把的至位置 3, 以調時方法調校日曆, 日曆顯示一跳即停, 然後將機芯放在 TRM03-01 裝針機的 TRT01-32D 機芯座內。 2) Set the Second Time Zone / 24 hour hand onto the counter pivot at 6 o'clock, and make it point to the hour index. 將第二時區 / 24 小時指針安裝到 6 時位的小錶針軸樺, 指針對準整點位置。 3) Set the hour hand, minute hand and second hand in turn. Point it all to 12 o'clock. 逐一將時針、分針、秒針安裝到中央的錶針軸樺, 指針須對準指向表面上顯示的 12 時位置。 4) First check the flatness and the height of all hands, then check the Second Time Zone / 24 hour hand should synchronize with the hour hand. 首先檢查針的高度及平衡度, 然後檢查第二時區 / 24 小時指針是否與時針同步運行。	 TRM03-01 3-head Handfitting tool with movement holder TRT01-32D (for fitting Hour, Minute & Second hands) 3 頭裝針機連 TRT01-32D 機心座 (適用於裝時、分、秒針)	This step must be followed accordingly when setting the hands, otherwise, the Second Time one/24-hour hand will not synchronize with the central hour hand. Meanwhile, the date cannot be changed at 00:00 midnight. You have to reassemble the hour hand and minute hand. 此裝配步驟必須依足程式進行, 否則第二時區 / 24 小時指針可能與時針不能同步運行, 以及日曆不能在午夜 12 時轉跳, 需要重新安裝時、分針。

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4. Stem Removing 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。		
5. Casing 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。	 <p>TRT01-32D Movement holder 機心座</p>	
6. Watch head Initialization 表頭測試調校	1. Pull the crown out to position 2, test the quick date adjusting function, push the crown back to original position. 將把的拉出至位置 2，檢驗日曆快調功能，然後推回把的。 2. Press the button on the case, test the quick adjusting function Second Time Zone / 24 hour in turn. 按動表殼上的按鈕，檢查第二時區 / 24 小時的快調功能。	 <p>TRT01-32D Movement holder 機心座</p>	1) Do not quickly adjust date between 21: 00 and 00: 30. 日曆快調禁區在晚上 9:00 至 00: 30 · 在禁區內，不可進行日曆快調。 2) Do not turn the crown anti-clockwise during quick date adjusting. 日曆快調時，不允許逆時針轉動把芯。 3) If you turn the crown anti-clockwise for time-setting, the hour hand running will not synchronize with the second time zone hand running. Use the quick adjusting of second time zone hand to adjust. 在逆時針轉動把芯調校時間時，第二時區指針將不能與時針同步運行，需要使用第二時區快調功能將指針調到正確時間。