




Caliber 型號 : 9232D0 (9232/1950)

Function 功能 : Hour、Minute & Second hands、Date、Day 日曆、星期

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。	 <p>TRM03-01 3-head Handfitting tool with movement holder TRT01-32D (for fitting small hands)</p> <p>3 頭裝針機連 TRT01-32D 機心座 (適用於裝小針)</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。	
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。			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. Day hand Fitting 裝星期指針	1) Pull the crown out to position 3, same as time-setting, turn it until the date disc is going to jump. Then put the Movement with dial into the Hand Fitting Holder (TRT01-32D) of TRM03-01 Hand Fitting Machine. 將把心拉出至位置 3，以調時的方法調校，使機心處於將跳日曆狀態，然後將機心放入 TRM03-01 裝針機的機心座 (TRT01-32D)內。 2) Set the day hand onto the day counter pivot at 9 o'clock, align it to point the centre of any day as printed on the day sub-dial. For example: "MON", the day hand should point to the centre of the letter "O". 將星期指針針管對準 9 時位的星期錶針軸樁位置，星期指針指正任何一個星期字樣的中間字母裝下。例如："MON"，指針便該指向 "O" 字的中央。			1) Incorrect positioning or excessive strength may result in breakage or bend of the small hand. 裝配時用力過大或未對正針筍，容易引致小秒針軸曲或斷。 2) Do not set the day hand if the day counter is in the state to jump-turn, otherwise the hands may risk to be misplaced and point to wrong positions. 切勿在跳星期狀態中裝配星期指針，否則指針將偏位。

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4. Hour、Minute & Second hands Fitting 裝時、分、秒針	1) Keep the crown at 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. 表冠保持在位置 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 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樞，指針須對準指向表面上顯示的 12 時位置。 1) Check the flatness and the height of all hands. 檢查針的高度及平衡度。	 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 zone / 24 hour hand will not synchronize with the central hour hand. Meanwhile, the date cannot be changed at 00:00 midnight. 以上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。
5. Test the adjusting functions of date, day 檢查日曆、星期的跳動功能	1) Keep the crown at position 3. Turn it clockwise until the hour hand passes 00:00 midnight. The date hand will change for one day. 表冠保持在位置 3，以順時針方向轉動把芯來調校時間，直至時針轉過午夜 12 時，此時，日曆顯示將會變更一天。 2) Continue to turn the crown clockwise, until the hour hand points to anytime between 00:00 midnight and 04:00 in the morning, the day will change for one day (Note: The day hand needs to jump 2 steps to complete the change for one day.) 繼續以順時針方向轉動表冠調校，時針在指向午夜 12 時至凌晨 4 時之間，星期指針會完成變更一天 (星期指針變更一天，需要跳動兩次方才完成)。 3) Push the crown back to position 2, test the quick date adjusting function. 將把的推回至位置 2，檢驗日曆快調功能。	 TRT01-32D Movement holder 機心座	Date advances one step (change for one day) when the hour hand passes 00:00. If not, you have to reassemble the hour hand and minute hand. 時針在經過午夜 12 時左右時，日曆顯示應變更一天完畢，否則便需要重新安裝時針、分針。
6. 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。		
7. 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。		