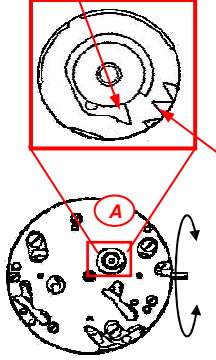# ISASWISS
WATCH MECHANISMS

Casing Guide
裝配須知

Caliber 型號： *9231 / 1890*

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。	Date indicator click 日曆撥頭	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) Pull the crown to position 2. Same as time-setting, turn the crown to position the date indicator click close to the teeth of the date indicator driving wheel, but leaving sufficient space between the two (as shown in the diagram). 將把的拉出至位置2，如正常調較時間一樣轉動把芯，把日曆撥頭調至靠近日曆輪的輪齒，並讓兩者之間保留有足夠的空間（如圖示）。 * The above step is to ensure that the movement is in a state that neither the date nor the day disc is going to jump-turn. This facilitates an easier observation when setting other hands. 上述步驟，是為了確保機芯不處於跳日曆或星期的狀態，在裝配其他指針需要進行日曆慢跳時，可便於觀察。 2) Fit the dial. 裝表面。 3) Check the centered of the dial. 檢查表面孔位是否正中。	 A Teeth of date indicator driving wheel 日曆輪齒	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. Date & Day hands Fitting 裝日曆及星期指針	Place the movement into the movement holder TRT01-32B of the handfitting tool TRM03-01. The crown remains in position 2, and the movement is still in the state that neither the date nor the day is to of jump. Otherwise, the hands set later will be unable to point to the correct positions. 將機芯放在TRM03-01裝針機的TRT01-32B機芯座內，把的應繼續保持在位置2，及機芯仍然不處於跳日曆或星期的狀態，否則稍後在完成安裝指針之後，指針將會偏位。 1) Set the date hand onto the date counter pivot at 3 o'clock, align it to point the centre of any date as printed on the date sub-dial.. 將日曆指針針管對準3時位的日曆錶針軸樺頭位置，日曆指針指向任何一個日期字樣裝下。 2) Set the day hand onto the day counter pivot at 9 o'clock, align it to point to 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 "O". 將星期指針針管對準9時位的星期錶針軸樺位置，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。	 **TRM03-01** 3-head Handfitting tool with movement holder TRT01-32B (for fitting small hands) 3頭裝針機連 TRT01-32B 機心座 (適用於裝小針)	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筒，容易引致小秒針軸曲或斷。 2) Do not set the date hand or day hand if the date or day counter is in the state to jump-turn, otherwise the hands may risk to be misplaced and point to wrong positions. 切勿在跳日曆或星期狀態中裝配日曆指針及星期指針，否則指針將偏位。

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Items 工序	Operations 操作	Tools 工具	Remarks 注意事項
4. Hour、Minute & Second hands Fitting 裝時、分、秒針	1) The crown remains at position 2.　Same as time-setting, turn the crown clockwise to change the date.　As soon the date jumps, 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，以調時方法調較日曆，日曆指針一跳即停，然後將機芯放在 TRM03-01B 裝針機的 TRT01-32B 機芯座內。 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榫，指針須對準指向錶面上顯示的 12 時位置。 3) Check the flatness and the height of all hands. 檢查針的高度及平衡度。		This step must be followed accordingly, if not, the date cannot change at 00:00 midnight. 此步驟必須依足程式進行，否則日曆不能在午夜 12 時轉跳。
5. Test adjusting Functions of date, day 檢查日曆、星期的跳動功能	1) The crown remains at position 2.　Turn it clockwise until the hour hand passes 00:00 midnight.　The date hand will change for one day. 把的保持在位置 2，以順時針方向轉動把芯來調較時間，直至時針轉過午夜 12 時，此時，日曆指針將會變更一天。 2) Continue to turn the crown clockwise, until the hour hand points to anywhere between 00:00 midnight and 04:30 in the morning, the day hand will change for one day. (Note: the day hand will jump two steps in order to complete the change for one day). 繼續以順時針方向轉動把的調較，時針在指向午夜 12 時至凌辰 4：30 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) Quick correction of date 　日曆快調功能： Press A step-by-step to test and observe if the push button functions correctly. 逐下按動按鈕 A，檢驗日曆快調功能。	**TRM03-01** 3-head Handfitting tool with movement holder TRT01-32B (for fitting hour, minute & second hands) 3 頭裝針機連 TRT01-32B 機心座 (適用於裝時、分、秒針) **TRT01-32B** 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。		
8. Watch head Initialization 表頭測試調校	1. Press the push button to test and observe if date function correctly. 按動錶殼上的按鈕，檢查日曆快調功能是否常。		