

INDUSTRIAL SEWING MACHINES

HAND BOOK

JUKI CORPORATION

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1-needle, Lockstitch Machine

DDL-5530N DDL-5550N DDL-5550N-7 (with an automatic thread trimmer)

- The sewing machine has been designed by a computer to achieve the optimal balance and the structure of the sewing machine frame has been strengthened. This reduces vibration and operation noise, allowing the operator to use the machine more comfortably. As a result, the sewing machine greatly improves the working environment.
- The thread take-up mechanism, feed mechanism, thread paths and hook have been further improved to enhance responsiveness to material changes and to ensure consistent stitch quality. (DDL-5550N-7)



DDL-5550N-7-WB/CP-160

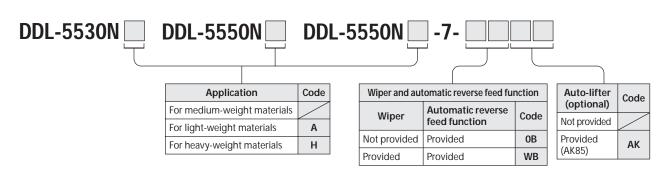
SPECIFICATIONS

Model name	DDL-5530N	DDL-5530NA	DDL-5530NH		
Application	For medium-weight materials For light-weight materials		For heavy-weight materials		
Max. sewing speed	4,500rpm	3,500rpm			
Max. stitch length	5mm	5mm			
Needle bar stroke	30.7mm 29mm		35mm		
Lift of the presser foot	By hand: 5.5mm, By knee: 13mm				
Needle (at the time of delivery)	DB x 1 (#14) DA x 1 (#9) DB x 1 (#21)) For JE: 134 (Nm75) For JE: 134 (Nm65) For JE: 134 (Nm65)				
Hook	Automatic-lubricating full-rotary hook				
Lubrication	Automatic				
Lubricating oil	JUKI New Defrix Oil No.1(equivalent to ISO VG7)				

Model name	DDL-5550N	DDL-5550NA	DDL-5550NH		
Application	For medium-weight materials	For light-weight materials For heavy-weight mate			
Max. sewing speed	5,500rpm	4,000rpm			
Max. stitch length	5mm	4mm	5mm		
Needle bar stroke	30.7mm	29mm 35mm			
Lift of the presser foot	By hand: 5.5mm, By knee: 13mm	m By hand: 4mm, By knee: 9mm By hand: 5.5mm, By knee:			
Needle (at the time of delivery)	DB × 1 (#14) For JE: 134 (Nm75)	DA × 1 (#9) For JE: 134 (Nm65) DB × 1 (#21) For JE: 134 (Nm65)			
Hook	Automatic-lubricating full-rotary hook				
Lubrication	Automatic				
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)				

Model name	DDL-5550N-7	DDL-5550NA-7	DDL-5550NH-7		
Application	For medium-weight materials	For light-weight materials	For heavy-weight materials		
Max. sewing speed	5,000rpm	4,000rpm			
Max. stitch length	4m	าทา	5mm		
Needle bar stroke	30.7mm	29mm	35mm		
Lift of the presser foot	By hand: 5.5mm, By knee: 13mm	By hand: 4mm, By knee: 9mm	By hand: 5.5mm, By knee: 13mm		
Needle (at the time of delivery)	DB × 1 (#14) DA × 1 (#9) For JE: 134 (Nm75) For JE: 134 (Nm65)		DB × 1 (#21) For JE: 134 (Nm130)		
Hook	Automatic-lubricating full-rotary hook				
Lubrication	Automatic				
Lubricating oil	IUL	KI New Defrix Oil No.1 (equivalent to ISO V	G7)		
Automatic reverse feed function	Provided as standard				
Power requirement	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V				
Power consumption	Power rating 400VA				
Total weight		81kg			

WHEN YOU PLACE ORDERS



• PSC box/control panel/motor for SC

SC800- D- A										
	F	SC box		Code	Control box	Code	e	Cont	rol panel	Code
	Single-phase	*	Japanese, English, Chinese	07	Standard	S		CP-60		060
For General	220V	PFL	English, German, French, Spanish, Italy	08	Optional unit A (for the ED-2 and the AE-4) A		CP-16 CP-36	-	160 360
Export	3-phase * 220V PFL	nhaco	Japanese, English, Chinese	11		Pu	lley belt		Code	
		PFL	English, German, French, Spanish, Italy	12		_ockstitch f	or general	fabric	D	
For CE	Single-phase 230V	PFL	English, German, French, Spanish, Italy	34						
** For JUS	Single-phase 120V	PFL *	English, German, French, Spanish, Italy	37						
(LA)	3-phase 220V	PFL	English, German, French, Spanish, Italy	38						

* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

** JUS: North America and Central and South America.

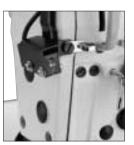
OPTIONS

Model	Part No.	Description	Feature	
AK85		Auto-lifter		
AE-4*	GAE-040000A0	Remaining bobbin thread detector	When the amount of remaining bobbin thread reaches the setting, the buzzer will sound to warn the operator not to press, on the front part of the foot pedal. With this function, the operator doesn't have to look away from the sewing work to check the bobbin thread.	
		When the sensor detects a material edge, it immediately stops the sewing machine and actuates the thread trimmer. This enhances productivity by allowing the operator to conduct sewing work without running to look out for missing stitches.		
	112-43763	Micro-lifter (asm.)	This device can be installed on the back of the face plate. It is very convenient for frequent use.	

* To mount the optional devices onto the machine after the setup, the optional PWB A Part No.: M9701-461-0A0 (separately available) will be required.



Remaining bobbin thread detector (AE-4)



Material edge sensor (ED-2)

DDL-8700 DDL-8700-7 (with an automatic thread trimmer)

• The optimum-balance and highly rigid machine head were created using the latest 3D-CAD design technology. Thanks to its low vibration and low noise feature, the machine head provides the operator with a comfortable work environment. In addition, the distance from the machine arm to the needle on the front of the machine head is sufficiently wide to allow easy handling of the sewing material.

The machine inherits the desirable features, such as high-speed stitching performance, extreme stitching performance, ease of operation, and reliability, from the highly evaluated previous JUKI lockstitch machines.

- The thread take-up, hook, thread path, presser foot and feed mechanisms have been thoroughly investigated and modified to enable low-tension sewing. The machine flexibly responds to various kinds of materials, producing beautiful seams of consistent quality.
- Enhanced maintainability is ensured by the improved machine head, such as incorporation of an eccentric pin that is used to adjust the feed dog. In addition, the machine is provided with a mounting seat for attachment to improve workability while replacing the attachment and increasing the durability of the machine bed surface.

• DDL-8700-7

The machine comes with a thread trimming mechanism that performs speedy and sure thread trimming to achieve highly efficient sewing work.



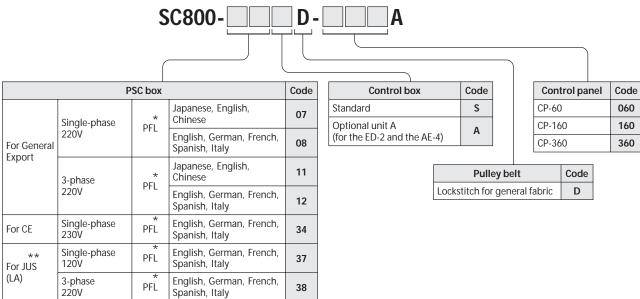
DDL-8700-7-WB/CP-160



SPECIFICATIONS

Model name	DDL-8700	DDL-8700A	DDL-8700H		
Application	For medium-weight materials	For light-weight materials	For heavy-weight materials		
Max. sewing speed	5,500rpm	4,000	Drpm		
Max. stitch length	5mm	4mm	5mm		
Needle bar stroke	30.7	mm	35mm		
Lift of the presser foot	By hand: 5.5mm, By knee: 13mm	By hand: 4mm, By knee: 9mm	By hand: 5.5mm, By knee: 13mm		
Needle (at the time of delivery)	DB × 1 (#14) #9 ~ #18 For JE: 134 (Nm90)	DA × 1 (#9) #9 ~ #11 For JE: 134 (Nm65)	DB × 1 (#21) #19 ~ #23 For JE: 134 (Nm130)		
Feed dog	4-ri	w	3-row		
Hook		Automatic-lubricating full-rotary hook			
Lubrication		Automatic			
Lubricating oil	JUK	New Defrix Oil No.1 (equivalent to ISO V	(G7)		
Weight of the machine heas	Weight of the machine heas 28kg				
Model name	DDL-8700-7	DDL-8700A-7	DDL-8700H-7		
Application	For medium-weight materials	For light-weight materials	For heavy-weight materials		
Max. sewing speed	5,000rpm	4,000rpm			
Max. stitch length	4m	ım	5mm		
Needle bar stroke	30.7	mm	35mm		
Lift of the presser foot	By hand: 5.5mm, By knee: 13mm	By hand: 4mm, By knee: 9mm	By hand: 5.5mm, By knee: 13mm		
Needle (at the time of delivery)	DB × 1 (#14) #9 ~ #18 For JE: 134 (Nm90)	DA x 1 (#9) #9 ~ #11 DB x 1 (#21) #19 ~ #23 For JE: 134 (Nm65) For JE: 134 (Nm130)			
Feed dog	4-r	ow	3-row		
Hook		Automatic-lubricating full-rotary hook			
Lubrication		Automatic			
Lubricating oil	JUK	I New Defrix Oil No.1 (equivalent to ISO V	/G7)		
Automatic reverse feed function	Provided as standard				
Wiper	Provided as standard for DDL-8700-7-WB model.				
Power requirement	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V				
Power consumption	Power rating 400VA				
Total weight		81kg	001 0700 0700 7 (Jupa 2001) 1/2		

Application	Code	Wiper and au	(tomatic reverse feed fu	nction	Auto-lifter	
For medium-weight materials			Automatic reverse		(optional)	Coc
For light-weight materials	A	Wiper	feed function	Code	Not provided	
For heavy-weight materials	н	Not provided	Provided	0B	Provided	A
Tor neavy-weight materials		Provided	Provided	WB	(AK85)	



* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

** JUS: North America and Central and South America.

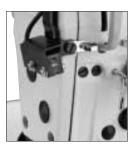
OPTIONS

Model	Part No.	Description	Feature
AK85		Auto-lifter	
AE-4 *	GAE-040000A0	Remaining bobbin thread detector	When the amount of remaining bobbin thread reaches the setting, the buzzer will sound to warn the operator not to press, on the front part of the foot pedal. With this function, the operator doesn't have to look away from the sewing work to check the bobbin thread.
ED-2*		Material edge sensor	When the sensor detects a material edge, it immediately stops the sewing machine and actuates the thread trimmer. This enhances productivity by allowing the operator to conduct sewing work without running to look out for missing stitches.
	112-43763	Micro-lifter (asm.)	This device can be installed on the back of the face plate. It is very convenient for frequent use.

* To mount the optional devices onto the machine after the setup, the optional PWB A Part No.: M9701-461-0A0 (separately available) will be required.



Remaining bobbin thread detector (AE-4)



Material edge sensor (ED-2)

Direct-drive, High-speed, 1-needle, Lockstitch Machine with an Automatic Thread Trimmer

DDL-9000

- With its newly developed large machine head, the DDL-9000 dramatically upgrades seam quality and increases efficiency.
- The DDL-9000 incorporates a direct-drive system (DD system) that offers quick start-up, upgraded stop accuracy, excellent responsiveness, and a stronger needle thrust for faster, better penetration into the material.
- Designed without an oil pan, the machine offers improved maintainability with easy removal of dust and lint.

SPECIFICATIONS



DDL-9000DS-WB/CP-160D

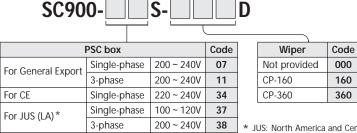
Model name	DDL-9000DS	DDL-9000DF	DDL-9000SS	DDL-9000SH	
model name	Dry hea	ad type	Minute-quantity lubrication type		
Application	For light- to medium-weight materials			For heavy-weight materials	
Max. sewing speed	4,000rpm	3,500rpm	5,000rpm	4,500rpm	
Max. stitch length	5mm	4mm	5n	nm	
Needle bar stroke	30.7	mm	30.7mm	35mm	
Lift of the presser foot		By hand: 5.5mm, By knee:	15mm (max.), Auto: 10mm		
Needle (at the time of delivery)	DB × 1 (#14) #9 ~ #18 For JE: 134 (Nm75) Nm65 ~ Nm110	DB × 1 (#9) #8 ~ #11 For JE: 134 (Nm65) Nm60 ~ Nm75	DB × 1 (#14) #9 ~ #18 For JE: 134 (Nm75) Nm65 ~ Nm110	DB × 1 (#21) #20 ~ #23 For JE: 134 (Nm130) Nm120 ~ Nm160	
Hook		brication hook al-purpose race surface)	Automatic lubrication hook		
Lubrication	No lubi	rication	Minute-quantity lubrication to needle bar and hook		
Lubricating oil			JUKI New Defrix Oil No.1 (equivalent to ISO VG7)		
Distance from needle to machine arm		300	Imm		
Size of bed		517mm :	× 178mm		
Bobbin thread winder		Built-in the n	nachine head		
Micro-lifter screw		Provided a	as standard		
Machine head drive		Compact AC servomot	or (direct-drive system)		
Automatic reverse feed function		Provided as standard	(built-in solenoid type)		
Power requirement		Single-phase 100 ~ 120V, 200	0 ~ 240V, 3-phase 200 ~ 240V		
Power consumption		Power rat	ing 400VA		
Total weight		84.	5kg		

WHEN YOU PLACE ORDERS

		DDL-9000] -]		
Machine head	Code	Application	Code		Wiper and aut	tomatic reverse feed fu	nction	Device and attachment	Code
type	oouo	For light- to medium-weight	c		Wiper	Automatic reverse	Code	Not provided	
Dry head	D	materials	3		wiper	feed function	coue	Auto-lifter (pedal-driven)	AK118
Minute-quantity	S	For heavy-weight materials	Η*		Not provided	Provided	0B		
lubrication	Ű	For extra light-weight materials	F*		Provided	Provided	WB		
		and foundation	Г			1			
		* For the sewing specification "H",	only the	mi	nute-quantity lub	rication type (S type) ma	ichine he	ad is available.	

For the sewing specification "H", only the minute-quantity lubrication type (S type) machine head is availab For the sewing specification "F", only the dry head type (D type) machine head is available.

PSC box/control panel



* JUS: North America and Central and South America.

DDL-9000 (June, 2001) 1/2

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Model	Part No.	Description	Feature
AK118		Auto-lifter	
	236-32656	Optional switch	This switch, mounted on the reverse feed switch, enables handy control of various functions. It is especially effective when operating the machine while standing.
AE-8*	GAE-080000A0	Remaining bobbin thread detector	When the amount of remaining bobbin thread reaches the setting, the buzzer will sound to warn the operator not to press, on the front part of the foot pedal. With this function, the operator doesn't have to look away from the sewing work to check the bobbin thread. (Only supported by the minute-quantity lubricating type machine)
ED-4 *		Material edge sensor	When the sensor detects a material edge, it immediately stops the sewing machine and actuates the thread trimmer. This enhances productivity by allowing the operator to conduct sewing work without running to look out for missing stitches.
	236-11056	Micro-lifter (asm.)	This device can be installed on the back of the face plate. It is very convenient for frequent use.

* To mount the optional devices onto the machine after the setup, the optional PWB A Part No.: M9701-461-0A0 (separately available) will be required.

The SC-900 control box offers further upgraded capabilities.

SC-900

- The motor acceleration can be selected from three setting (standard, slow, rapid) by operator's preferance.
- The function-setting switch is provided with two new capabilities: reverse feed and repeat. In addition, the switch has a reset capability to restore the machine to the default settings.



The control panel can be selected according to the process. **CP-360D**

- With this control panel, two kinds of programs combining as many as 15 steps can be established.
- This control panel has an expanded range of functions such as teaching sewing, a function used to establish the number of stitches during sewing.



CP-160D

• Four different kinds of pattern sewing are possible: automatic back tack, constant-dimension sewing, rectangle-shape sewing, and multi-layer stitching. As many as 19 stitches can be established for automatic back tack (single or double).



* "Without control panel" can also be specified.

CONTROL PANEL SPECIFICATIONS

No.	Function	Pictograph	CP-160D	CP-360D
1	Power indicator lamp (LED)		0	0
2	Max. speed limitation variable resistor		0	0
3	Thread trimming prohibition switch	×	0	0
4	Soft-start			
5	Automatic count back			
6	Material edge sensor ON/OFF switch		**	**
7	Function of detecting the remaining amount of bobbin thread		*	`
8	Automatic thread trimming switch	×	0	0
9	Back tack pattern switch		0	0
10	Overlapped stitching pattern switch		0	0
11	Bobbin thread counter	三	0	0
12	Needle up/down compensating switch		0	0
13	One-shot automatic stitching switch	0	0	0
14	Double back tack switch	M M	0	0
15	Key lock	-	0	0
16	Constant-dimension stitching pattern		0	0
17	Programable seam length	BS ^A A C ^D C ^B B	0	0
18	Production counter	<u>1.2.3.</u>		0
19	Programmed stitching pattern	2		0
20	Combined stitching pattern switch	••		0
21	Re-sewing switch	(j)		0
22	Teaching switch	T		0
23	Presser foot lifting time setting switch	LL		0

△ ● Designated on the control box.

 Operative when the machine is equipped with a remaining bobbin thread detector (AE: optional).

** • Operative when the machine is equipped with a material edge sensor (ED: optional).

1-needle, Lockstitch Machine with a Double-capacity Hook

DDL-5600N DDL-5600N-7 (with an automatic thread trimmer)

- The machine is equipped with a link feeding mechanism which is highly evaluated for its straightness, consistency and durability. Also it enables, the machine to sew well-tensed beautifully finished seams, regardless of the type of heavy-weight materials. The maximum stitch length is as long as 8mm (with the L-type machine for heavy-weight materials with long stitch length), thereby making the machine widely applicable to the sewing of heavy-weight materials, such as bags, requiring a longer stitch length.
- Changing the bobbin is troublesome, especially when using a thick thread. This machine, however, is equipped with a double-capacity hook, thereby reducing the frequency of changing the bobbin. By this feature, greater efficiency is assured.



DDL-5600NJ-7-0B/CP-160

SPECIFICATIONS

Model name	DDL-5600NJ	DDL-5600NL	DDL-5600NR			
Application	For jeans	For heavy-weight materials	For leather shoes			
Max. sewing speed	4,000rpm	3,000	Irpm			
Max. stitch length	5mm (normal/reverse feed)	8mm (normal/	/reverse feed)			
Needle bar stroke	36mm					
Lift of the presser foot		By hand: 5.5mm, By knee: 13mm				
Needle (at the time of delivery)	DB × 1 (#21) #20 ~ #23 For JE: 134 (Nm130)	DB × 1 (#21) #20 ~ #23 For JE: 134 (Nm130)				
Thread		#30 ~ #8, B46 ~ B92, Nm=60/3 ~ 30/3				
Hook		Horizontal-axis double-capacity hook				
Lubrication		Automatic				
Lubricating oil	IUL	KI New Defrix Oil No.1 (equivalent to ISO V	G7)			
Model name	DDL-5600NJ-7	DDL-5600NL-7	DDL-5600NR-7			
Application	For jeans	For heavy-weight materials	For leather shoes			
Max. sewing speed	4,000rpm	3,000	Irpm			
Max. stitch length	5mm (normal/reverse feed)	8mm, 5mm (i	reverse feed)			
Needle bar stroke		36mm				
Lift of the presser foot		By hand: 5.5mm, By knee: 13mm				
Needle (at the time of delivery)	DB × 1 (#21) #20 ~ #23 For JE: 134 (Nm130)	DB × 1 (#21) For JE: 134 (
Thread		#30 ~ #8, B46 ~ B92, Nm=60/3 ~ 30/3				
Hook		Horizontal-axis double-capacity hook				
Lubrication		Automatic				
Lubricating oil	IUL	KI New Defrix Oil No.1 (equivalent to ISO V	G7)			
Automatic reverse feed function		Provided as standard				
Power requirement	Single-p	ohase 100 ~ 120V, 200 ~ 240V, 3-phase 200) ~ 240V			
Power consumption		Power rating 400VA				
Total weight		81kg				

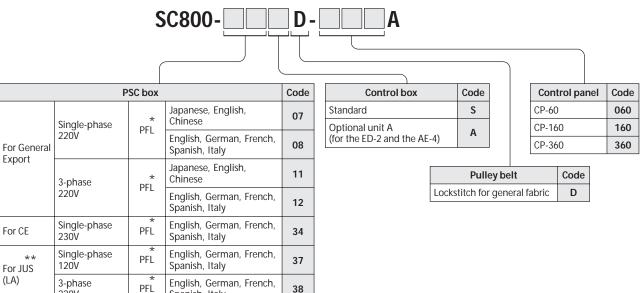
DDL-5600N ____ -7-

Applicat	ion	Code
For jeans		J
For heavy-weight	materials	L
For leather shoes (with roller presse	r foot)	R

Wiper and automatic reverse feed function				
Wiper	Automatic reverse feed function	Code		
Not provided	Provided	0B		
Provided (for DDL-5600NJ-7)	Provided	FB		

Auto-lifter (optional)	Code
Not provided	
Provided (AK85)	AK

PSC box/control panel/motor for SC



Spanish, Italy * If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

** JUS: North America and Central and South America.

220V

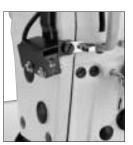
OPTIONS

Model	Part No.	Description	Feature
AK85		Auto-lifter	
AE-5*	GAE-050000A0		When the amount of remaining bobbin thread reaches the setting, the buzzer will sound to warn the operator not to press, on the front part of the foot pedal. With this function, the operator doesn't have to look away from the sewing work to check the bobbin thread.
ED-2*		Material edge sensor	When the sensor detects a material edge, it immediately stops the sewing machine and actuates the thread trimmer. This enhances productivity by allowing the operator to conduct sewing work without running to look out for missing stitches.

* To mount the optional devices onto the machine after the setup, the optional PWB A Part No.: M9701-461-0A0 (separately available) will be required.



Remaining bobbin thread detector (AE-5)



Material edge sensor (ED-2)

1-needle, Needle-feed, Lockstitch Machine

DLN-5410N DLN-5410N-7 (with an automatic thread trimmer)

• The machine head has been redesigned to improve the performance of each component. By the machine's low-tension sewing capability and the adjustment function for the needle-feed amount (±15%), the machine performs stitches without uneven material feeding and puckering, thus enhance the machine's ability to respond to any change in the material to be sewn.

• DLN-5410NJ-7

By increasing the maximum feed amount (stitch length) to 4.5mm and the needle bar stroke to 33mm, penetration into heavy-weight materials and ease of operation have been considerably enhanced. The horizontal-axis double-capacity hook effectively cuts the frequency of troublesome bobbin thread replacement procedures in half.



DLN-5410N-7-WB/CP-160

SPECIFICATIONS

Model name	DLN-5410N	DLN-5410NH	DLN-5410NL			
Application	For light- to medium-weight materials	For heavy-weight materials	For heavy-weight materials (long stitch length type)			
Max. sewing speed	5,000rpm	4,000rpm	3,000rpm			
Max. stitch length	4mm	4.5mm	6mm			
Needle bar stroke		30.7mm				
Lift of the presser foot		By hand: 5.5mm, By knee: 13mm				
Needle (at the time of delivery)	DB × 1 (#14) For JE: 134 (Nm90)	DB × 1 (#21) For JE: 134 (Nm130)	DB × 1 (#21) For JE: 134 (Nm130)			
Hook		Automatic-lubricating full-rotary hook				
Lubrication		Automatic				
Lubricating oil	JUK	I New Defrix Oil No.1 (equivalent to ISO V	G7)			

Model name	DLN-5410N-7	DLN-5410NH-7	DLN-5410NJ-7				
Application	For light- to medium-weight materials	For heavy-weight materials	For jeans				
Max. sewing speed	5,000rpm	4,00	0rpm				
Max. stitch length	4mm	4.5	mm				
Needle bar stroke	30.7	mm	33mm				
Lift of the presser foot		By hand: 5.5mm, By knee: 13mm					
Needle (at the time of delivery)	DB × 1 (#14) For JE: 134 (Nm90)	DB × 1 (#21) For JE: 134 (Nm130)	DB × 1 (#21) For JE: 134 (Nm130)				
Hook	Automatic-lubricati	ating full-rotary hook Automatic-lubricating double-cap. full-rotary hook					
Thread			#30 ~ #8, B46 ~ B92, Nm60/3 ~ 30/3				
Lubrication		Automatic					
Lubricating oil	JUK	I New Defrix Oil No.1 (equivalent to ISO)	/G7)				
Automatic reverse feed function		Provided as standard					
Power requirement	Single-p	e-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V					
Power consumption		Power rating 400VA					
Total weight		83kg					

1

DLN-5410N DLN-5410N -7 Code Auto-lifter Application Code Application Wiper and automatic reverse feed function Code (optional) For light- to For light- to Automatic reverse Code Wiper medium-weight materials feed function Not provided medium-weight materials For heavy-weight materials н For heavy-weight materials Н Not provided Provided **0**B Provided AK (AK85) For heavy-weight materials (long stitch length type) For jeans J Provided Provided WB L

PSC box/control panel/motor for SC

		S	C800-	D -							
	P	SC box		Code	Control box	Co	de		Cont	rol panel	Code
	Single-phase	*	Japanese, English, Chinese	07	Standard	S	;		CP-60		060
For General	220V	PFL	PFL Optional unit A		(for the ED-2 and the AE-4	4) <i>F</i>			CP-160 CP-360		160 360
Export	3-phase	*	Japanese, English, Chinese	11		F	ulley	belt		Code	
	220V	PFL	English, German, French, Spanish, Italy	12	L	Lockstitch	for g	eneral f	abric	D	
For CE	Single-phase 230V	* PFL	English, German, French, Spanish, Italy	34							
** For JUS	Single-phase 120V	* PFL	English, German, French, Spanish, Italy	37							
(LA)	3-phase 220V	PFL *	English, German, French, Spanish, Italy	38							

* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

** JUS: North America and Central and South America.

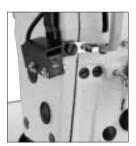
OPTIONS

Model	Part No.	Description	Feature
AK85		Auto-lifter	
AE-4*	GAE-040000A0	Remaining bobbin thread detector	When the amount of remaining bobbin thread reaches the setting, the buzzer will sound to warn the operator not to press, on the front part of the foot pedal. With this function, the operator doesn't have to look away from the sewing work to check the bobbin thread.
AE-5*	GAE-050000A0		For DLN-5410NJ-7, select AE-5
ED-2*		Material edge sensor	When the sensor detects a material edge, it immediately stops the sewing machine and actuates the thread trimmer. This enhances productivity by allowing the operator to conduct sewing work without running to look out for missing stitches.
	112-43763	Micro-lifter (asm.)	This device can be installed on the back of the face plate. It is very convenient for frequent use.

* To mount the optional devices onto the machine after the setup, the optional PWB A Part No.: M9701-461-0A0 (separately available) will be required.



Remaining bobbin thread detector (AE-4)



Material edge sensor (ED-2)

1-needle, Bottom & Variable Top-feed Lockstitch Machine

DLU-5490N DLU-5490N-7 (with an automatic thread trimmer)

- The walking foot provides stable feed at all times, assuring high quality. It also eliminates the need for proficiency.
- The top-feed motion ideally synchronized with the bottom-feed motion to uniformly feed the upper and lower cloths, assuring attractive stitches and uniform gathering stitches. This leads to a higher value of finished products.
- The maximum top-feed amount is 8mm. The top-feed amount has been increased to assure stable gathering stitches.



DLU-5490N-7-WB/CP-160

SPECIFICATIONS

Model name	DLU-5490N	DLU-5490N-7					
Max. sewing speed	4,500rpm						
Max. stitch length	5m	ım					
Max. top-feed amount	8m	ım					
Needle bar stroke	30.7	mm					
Lift of the presser foot	By hand: 5.5mm, By knee: 13mm						
Needle (at the time of delivery)	DB × 1 (#14), For JE: 134 (Nm90) 134 (Nm90)						
Hook	Automatic-lubricat	ing full-rotary hook					
Lubrication	Auto	matic					
Lubricating oil	JUKI New Defrix Oil No.1	(equivalent to ISO VG7)					
Automatic reverse feed function		Provided as standard					
Power requirement	Single-phase 100 ~ 120V, 200 ~ 240V 3-phase 200 ~ 240V						
Power consumption	Power rating 400VA						
Weight	Machine head: 30kg	Total weight: 83kg					

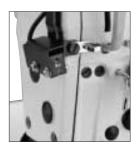
OPTIONS

Model	Part No.	Description	Feature
AK85		Auto-lifter	
AE-4*	GAE-040000A0	Remaining bobbin thread detector	When the amount of remaining bobbin thread reaches the setting, the buzzer will sound to warn the operator not to press, on the front part of the foot pedal. With this function, the operator doesn't have to look away from the sewing work to check the bobbin thread.
ED-2*		Material edge sensor	When the sensor detects a material edge, it immediately stops the sewing machine and actuates the thread trimmer. This enhances productivity by allowing the operator to conduct sewing work without running to look out for missing stitches.
PF-6		Partial shirring device	The partial shirring device permits very easy shirring.
	112-43763	Micro-lifter (asm.)	This device can be installed on the back of the face plate. It is very convenient for frequent use.

* To mount the optional devices onto the machine after the setup, the optional PWB A Part No.: M9701-461-0A0 (separately available) will be required.



Remaining bobbin thread detector (AE-4)



Material edge sensor (ED-2)

DLU-5490N

DLU-5490N

Application Cod		Application	Code
For light-weight materials	BA	For elastic materials	E
For medium-weight materials	BB	For setting zipper (right)	J
For heavy-weight materials	BC	For binding	L*
For edge welt seam	с	For bottom hemming	Μ*
topstitching		For piping	Ν*
To prevent it from catching materials	CG	For zipper attaching (left)	Р
For sewing sharp curves D		For preventing puckering	S
(· · · · · · · · · · · · · · · · · · ·			

	(
Wiper and aut	tomatic reverse feed fu	Auto-lifter		Code	
	Automatic reverse		(optional)		
Wiper	feed function	Code	Not provided	1	
Not provided	Provided	0B	Provided		АК
Provided	Provided	WB	(AK85)		

-7-

* Note • When using the gauges L, M & N, attach them to the binder, etc. Since the prices are separate, please ask us of them.

Various gauges other than those shown are also available.

• PSC box/control panel/motor for SC SC800-D-Α PSC box Code Control box Code **Control panel** Code Japanese, English, Standard S CP-60 060 07 Chinese Single-phase 220V PFL Optional unit A CP-160 160 Α English, German, French, (for the ED-2 and the AE-4) 08 CP-360 360 For General Spanish, Italy Export Japanese, English, 11 **Pulley belt** Code Chinese 3-phase PFL 220V Lockstitch for general fabric D English, German, French, 12 Spanish, Italy Single-phase English, German, French, For CE PFL 34 230V Spanish, Italy Single-phase English, German, French, ** PFL 37 120V Spanish, Italy For JUS (LA) 3-phase English, German, French, PFL 38 220V Spanish, Italy

* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

****** JUS: North America and Central and South America.

1-needle, Bottom & Variable Top-feed, Lockstitch Machine with an Automatic Thread Trimmer and Programmable Shirring Control Device

DLU-5494N-7/CP-560

- The machine enables even inexperienced operators to perform shirring operation smoothly and easily.
- The microcomputer-controlled shirring mechanism allows even inexperienced operators to carry out shirring operations skillfully, producing high-quality products with consistency. While shirring, an operator can enter a program through the use of the teaching function, thereby duplicating a high-quality shirring operation by performed program.



DDL-5494N-7/CP-560

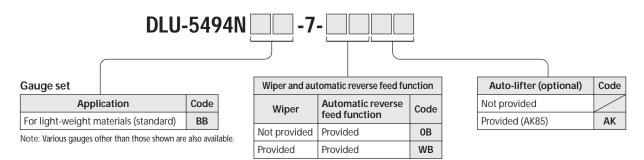
SPECIFICATIONS

Model name	DLU-5494N-7/CP-560	
Max. sewing speed	4,000rpm (normal 3,500rpm)	
Max. stitch length	5mm (normal feed), 3mm (reverse feed)	
Max. top-feed amount	8mm (top-feed amount varies depending on the type of gauge)	
Needle bar stroke	30.7mm	
Lift of the presser foot	By hand: 5.5mm, By knee: 13mm	
Needle(at the time of delivery)	DB × 1 (#14), For JE: 134 (Nm90)	
Hook	Automatic-lubricating full-rotary hook	
Lubrication	Automatic	
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	
Automatic reverse feed function	Provided as standard	
Power requirement Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V		
Power consumption	Power rating 400VA	
Total weight	85kg	

TARGETED INDUSTRIAL APPLICATIONS AND PROCESSES

Targeted industrial applications	Processes
Men's and ladies' suits	1) Runstitching process
Blazer coats	Runstitch front edge, join shoulder, sew center of back, seam side, set sleeve to armhole, etc.
Coats	
Blousons	2) Topstitching process
Slacks	Topstitch front edge, topstitch sleeve cuff, topstitch collar, topstitch waistband, etc.
Skirts	
Men's shirts	3) Gathering process
Blouses	Attach yoke, attach cuff, join top and bottom, etc.
Dresses	
One-piece dresses	4) Sewing process with an attachment used in combination with the machine
Sportswear	Hem bottom, piping, binding, etc.
Sweaters	
Others	5) Others
	Zipper-attachment process, blind-stitching process, sewing processes in which different materials are used in combination, etc.

1



• PSC box/control panel/motor for SC

		S	SC801 A	D-5	60					
	I	PSC box		Code	Control box	Code		Con	trol panel	Code
	Single-phase	*	Japanese, English, Chinese	07	Optional unit A	A		CP-56	0	560
For General	220V	PFL	English, German, French, Spanish, Italy	08			Pulley belt		Code	
Export	3-phase	* PFL	Japanese, English, Chinese	11		Locks	titch for genera		D	
	220V	PFL	English, German, French, Spanish, Italy	12						
For CE	Single-phase 230V	PFL	English, German, French, Spanish, Italy	34						
** For JUS	Single-phase 120V	* PFL	English, German, French, Spanish, Italy	37						
(LA)	3-phase 220V	PFL	English, German, French, Spanish, Italy	38						

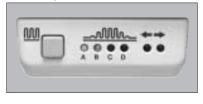
* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

** JUS: North America and Central and South America.

Control panel CP-560



Indication panel



Servomotor/Controller SC-801



OPTIONS

Model	Part No.	Description	Feature
AK85		Auto-lifter	
AE-4	GAE-040000A0	I REITAILIHO DODOIH	When the amount of remaining bobbin thread reaches the setting, the buzzer will sound to warn the operator not to press, on the front part of the foot pedal. With this function, the operator doesn't have to look away from the sewing work to check the bobbin thread.
	112-43763	Micro-lifter (asm.)	This device can be installed on the back of the face plate. It is very convenient for frequent use.

1-needle, Differential-feed, Lockstitch Machine

DLD-5430N DLD-5430N-7 (with an automatic thread trimmer)

- With optional devices such as a partial shirring device (PF-7) and gathering attachment mounted on the machine, beautiful gathers can be sewn with enhanced efficiency. This new, upgraded-quality machine provides not only operating comfort, but also dramatically improved seam quality, further cost reduction, and excellent productivity.
- The thread take-up mechanism, thread path components and differential-feed mechanism have all been improved. By these improvements, partial shirring can be performed with minimum tension applied to the material, thus leading to greater flexibility in response to different types of material.



DLD-5430N-7-WB/CP-160

SPECIFICATIONS

Model name	DLD-5430N	DLD-5430N-7					
Max. sewing speed	4,500rpm						
Max. stitch length	5m	nm					
Max. top-feed amount	Shirring 1:1.5 (Max. 7	1:3), Stretching 1:0.5					
Needle bar stroke	30.7	'mm					
Lift of the presser foot	By hand: 5.5mm,	, By knee: 13mm					
Needle (at the time of delivery)	DB × 1 (#14), For JE: 134 (Nm90)						
Hook	Automatic-lubricating full-rotary hook						
Lubrication	Automatic						
Lubricating oil	JUKI New Defrix Oil No.1	(equivalent to ISO VG7)					
Automatic reverse feed function		Provided as standard					
Power requirement	Single-phase 100 ~ 120V, 200 ~ 240V 3-phase 200 ~ 240V						
Power consumption	Power rating 400VA						
Weight	Machine head: 29kg	Total weight: 82kg					

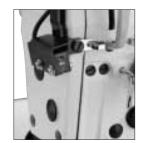
OPTIONS

Model	Part No.	Description	Feature
AK85		Auto-lifter	
AE-4*	GAE-040000A0	Remaining bobbin thread detector	When the amount of remaining bobbin thread reaches the setting, the buzzer will sound to warn the operator not to press, on the front part of the foot pedal. With this function, the operator doesn't have to look away from the sewing work to check the bobbin thread.
ED-2*		Material edge sensor	When the sensor detects a material edge, it immediately stops the sewing machine and actuates the thread trimmer. This enhances productivity by allowing the operator to conduct sewing work without running to look out for missing stitches.
PF-7		Partial shirring device	The partial shirring device permits very easy shirring.
Q036		Gathering attachment	For high-quality gathering, both effectively and consistently.
	112-43763	Micro-lifter (asm.)	This device can be installed on the back of the face plate. It is very convenient for frequent use.

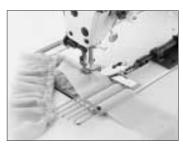
* To mount the optional devices onto the machine after the setup, the optional PWB A Part No.: M9701-461-0A0 (separately available) will be required.



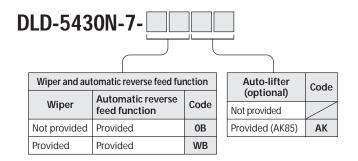
Remaining bobbin thread detector (AE-4)



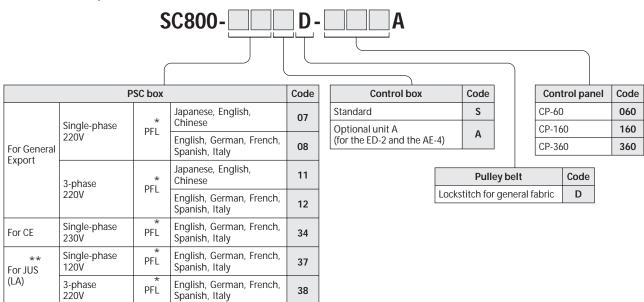
Material edge sensor (ED-2)



Gathering attachment (Q036) DLD-5430N, 5430N-7 (June, 2001) 1/2



PSC box/control panel/motor for SC



* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

** JUS: North America and Central and South America.

1-needle, Lockstitch Machine with Edge Trimmer

DLM-5200N DLM-5210N (exclusive machine for piping)

- The highly efficient lockstitch machine which assures the consistent quality of finished seams comes with a sharp knife capable of cutting various types of material. The DLM-5200N series is composed of high-quality sewing machines provided with these two main features, both of which are designed to significantly upgrade the functions.
- The knife is designed so that the angle can be changed as desired, allowing the knife to be easily applied to any type of material.
- The knife can be attached by simply pressing the presser plate on the machine arm. The knife is removed also by the simple operation of the knob. Thus the type of stitching, such as with or without knife, can be changed with ease.
- The adjustment of the needle and needle gauge can be made by the simple change of the sub-gauges.



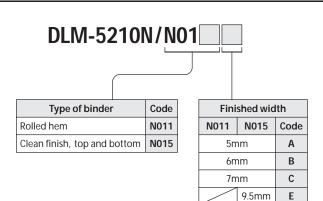
DLM-5200N

SPECIFICATIONS

	DLM-5200N	DLM-5210N		
Model name		Front knife type		
Max. sewing speed	4,500rpm	4,000rpm		
Max. stitch length	5mm (normal/reverse feed)	4mm (normal/reverse feed)		
Needle bar stroke	30.7mm			
Lift of the presser foot	By hand: 4mm, By knee: 10mm			
Needle (at the time of delivery)	DB × 1 (#14), For JE: 134 (Nm90)			
Hook	Automatic-lubricating full-rotary hook			
Max. thickness of the material to be cut	4n	nm		
Lubrication Automatic		matic		
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)			
Weight of the machine head	30kg			

WHEN YOU PLACE ORDERS

DLM-5200N	
Sub-gauge ty	ре
Distance between the needle and the knife	Code
3.2mm (1/8") standard	D
2.4mm (3/32")	С
4.0mm (5/32")	E
4.8mm (3/16")	F
6.4mm (1/4")	н
9.5mm (3/8")	М



DLM-5200N SUB-GAUGE SET LIST

Specifications of the	Gauge width	Throat plate	Throat plate cover (asm.)	Gauge	Throat plate chip guard	Chip guide	Hinging presser (asm.)	Feed dog	Knife
sub-gauge		(·····	÷		the second se	A			ß
С	2.4mm (3/32")	113-46004	B1115-530-0AD	B1190-522-X00	113-46905	113-46400	B1524-522-NB0A	B1613-522-N00A	B4121-522-000
D	3.2mm (1/8")	113-46004	B1115-530-0AD	B1190-522-S00	113-46905	113-46400	B1524-522-NB0A	B1613-522-N00A	B4121-522-000
E	4.0mm (5/32")	113-46004	B1115-530-0AF	B1190-522-Y00	113-46905	113-46400	B1524-522-NB0A	B1613-522-N00A	B4121-522-000
F	4.8mm (3/16")	113-46004	B1115-530-0AF	B1190-522-T00	113-46905	113-46400	B1524-522-NB0A	B1613-522-N00A	B4121-522-000
н	6.4mm (1/4")	113-46004	B1115-530-0AF	B1190-522-U00	113-47101	113-46509	B1524-012-0BA	B1613-522-W00A	B4121-522-000
М	9.5mm (3/8")	113-46103	B1115-530-0AM	B1190-522-V00	113-47309	113-46509	B1524-012-0BA	B1613-522-W00A	B4121-522-000
■ This is r	nade to o	order as an au	xiliary part or	ıly					
CA	2.0mm (5/64")	113-46004	B1115-530-0AD	B1190-522-Y0A	113-46905	113-46400	B1524-522-NB0A	B1613-522-N00A	B4121-522-000
HA	6.4mm (1/4")	113-46004	B1115-530-0AF	B1190-522-U0A	113-47101	113-46509	B1524-012-0BA	B1613-522-A0A	B4121-522-000
к	7.9mm (5/16")	113-46103	B1115-530-0AM	B1190-522-Y0B	113-47101	113-46509	B1524-012-0BA	B1613-522-W00A	B4121-522-000

DLM-5210N/ N011, N015 ATTACHMENTS

• N011

Rolled hem		N011 Semi-fold Binder (cut-before knife, rolled hem) Exclusive sub-gauge					
Finished width	Finished width	Tape width	Part No. of the attachment	Gauge	Presser foot (asm.)	Front knife	
1mm	7mm	24mm	MAN-0110G-0A0	B1190-523-C00	B1524-523-CA0	B4121-523-B00	
	6mm	22mm	MAN-0110F-0A0	B1190-523-B00	B1524-523-BA0	B4121-523-000	
10mm	5mm	20mm	MAT-11801-NA0	B1190-523-000	B1524-523-0A0	B4121-523-000	

• N015

Clean finish, top and bottom	N015 Binder (clean finish, top and bottom) Exclusive sub-gauge					
Finished width	Finished width	Tape width	Part No. of the attachment	Gauge	Presser foot (asm.)	Front knife
	9.5mm	34mm	MAN-0150J-0A0	B1190-523-E00	B1524-523-EA0	B4121-523-B00
1 mm	7mm	26mm	MAN-0150G-0A0	B1190-523-C00	B1524-523-CA0	B4121-523-B00
	6mm	22mm	MAN-0150F-0A0	B1190-523-B00	B1524-523-BA0	B4121-523-000
	5mm	20mm	MAT-11901-NA0	B1190-523-000	B1524-523-0A0	B4121-523-000

1-needle, Bottom-feed Lockstitch Machine with an Edge Trimmer and an Automatic Thread Trimmer

DLM-5400N-7

1-needle, Needle-feed, Lockstitch Machine with an Edge Trimmer and an Automatic Thread Trimmer

DMN-5420N-7

- The knife is capable of cutting any kind of material regardless of its thickness or toughness, including heavy-weight material, elastic material and brushing material.
- Since the knife lever has been placed so as to prevent rust, there is no need to worry about the material becoming soiled with rust.
- The thread trimmer is designed to cut various threads of different thicknesses, so the range of the applicable thread thickness number has been widened. The thread trimmer can therefore cut even a thick thread with ease.
- The cloth trimming knife has been designed so that it can move as much as 5.5mm from the center of the needle.



DLM-5400N-7-WB/CP-160

Model name	DLM-5400N-7	DMN-5420N-7	
Max. sewing speed	4,500rpm	5,000rpm (Max. 4,000rpm with the stitch length set to 4mm or more)	
Feed system	Bottom-feed	Needle-feed	
Max. stitch length	4mm (normal/reverse feed)	5mm (normal feed), 3mm (reverse feed)	
Needle bar stroke	30.7	mm	
Lift of the presser foot	By hand : 5.5mm, By knee : 10mm		
Needle (at the time of delivery)	DB x 1 (#14) #9 ~ #18, For JE: 134 (Nm90)		
Hook	Automatic-lubricating full-rotary hook		
Max. thickness of the material to be cut	4mm		
Lubrication	Auto	matic	
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)		
Automatic reverse feed function	Provided a	s standard	
Power requirement	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V		
Power consumption	Power rating 400VA		
Total weight	83kg	84kg	

SPECIFICATIONS

OPTIONS

Model	Part No.	Description	Feature
AK85		Auto-lifter	
AE-4*	GAE-040000A0		When the amount of remaining bobbin thread reaches the setting, the buzzer will sound to warn the operator not to press, on the front part of the foot pedal. With this function, the operator doesn't have to look away from the sewing work to check the bobbin thread.
ED-2*			When the sensor detects a material edge, it immediately stops the sewing machine and actuates the thread trimmer. This enhances productivity by allowing the operator to conduct sewing work without running to look out for missing stitches.

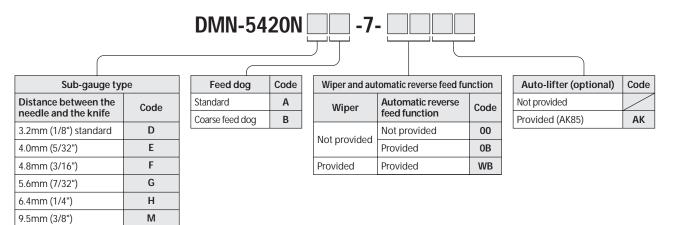
* To mount the optional devices onto the machine after the setup, the optional PWB A Part No.: M9701-461-0A0 (separately available) will be required.

DLM-5400N7-	

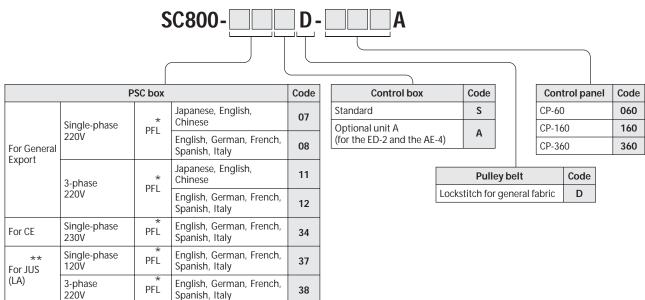
Cub manager					
Sub-gauge type					
Distance between the needle and the knife	Code				
3.2mm (1/8") standard	D				
2.4mm (3/32")	С				
4.0mm (5/32")	E				
4.8mm (3/16")	F				
6.4mm (1/4")	Н				
9.5mm (3/8")	М				

Wiper and automatic reverse feed function					
Wiper	Automatic reverse feed function	Code			
Not provided	Provided	0B			
Provided	Provided	WB			

Auto-lifter (optional)	Code
Not provided	
Provided (AK85)	AK



• PSC box/control panel/motor for SC



* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

** JUS: North America and Central and South America.

DLM-5400N-7 SUB-GAUGE SET LIST

Specifications of the sub-gauge	Gauge width	Throat plate	Throat plate cover (asm.)	Gauge	Throat plate chip guard	Chip guide	Hinging presser (asm.)	Feed dog	Knife
sup-gauge			D			J&			R
** C	2.4mm (3/32")	113-46004	B1115-531-0AD	B1190-522-X00	113-46905	113-46400	B1524-530-DB0	B1613-522-N00A	B4121-522-000
D	3.2mm (1/8")	113-46004	B1115-531-0AD	B1190-522-S00	113-46905	113-46400	B1524-530-DB0	B1613-522-N00A	B4121-522-000
E	4.0mm (5/32")	113-46004	B1115-531-0AD	B1190-522-Y00	113-46905	113-46400	B1524-530-EB0	B1613-522-N00A	B4121-522-000
F	4.8mm (3/16")	113-46004	B1115-530-0AF	B1190-522-T00	113-46905	113-46400	B1524-530-EB0	B1613-522-N00A	B4121-522-000
н	6.4mm (1/4")	113-46004	B1115-530-0AF	B1190-522-U00	113-47101	113-46509	B1524-530-GB0	B1613-522-W00A	B4121-522-000
м	9.5mm (3/8")	113-46004	B1115-530-0AM	B1190-522-V00	113-47309	113-46509	B1524-530-GB0	B1613-522-W00A	B4121-522-000
This is r	nade to orde	r as an auxilia	ary part only.						
** CA	2.0mm (5/64")	113-46004	B1115-531-0AD	B1190-522-Y0A	113-46905	113-46400	B1524-530-CB0	B1613-522-N00A	B4145-530-C00
СВ	2.4mm (3/32")	113-46004	B1115-531-0AD	B1190-522-X0B	113-46905	113-46400	B1524-530-DB0	B1613-522-N0C	B4121-522-000
EA	4.0mm (5/32")	113-46004	B1115-531-0AD	113-62753	113-46905	113-46400	B1524-530-EB0	B1613-522-N00A	B4121-522-000
FA	4.8mm (3/16")	113-46004	B1115-530-0AF	B1190-522-T0A	113-46905	113-46400	B1524-530-EB0	B1613-522-N00A	B4121-522-000
FB	4.8mm (3/16")	113-46004	B1115-530-0AF	B1190-522-Y0C	113-46905	113-46400	B1524-530-EB0	B1613-522-N00A	B4121-522-000
G	5.3mm (27/128")	113-46004	B1115-530-0AF	B1190-522-Y0F	113-47101	113-46400	B1524-530-GB0	B1613-522-N00A	B4121-522-000
HA	6.4mm (1/4")	113-46301	B1115-530-0AF	B1190-522-U0AA	113-47101	113-46509	B1524-530-GB0	B1613-522-A0AA	B4121-522-000
к	7.9mm (5/16")	113-46004	B1115-530-0AF	B1190-522-Y0B	113-47101	113-46509	B1524-530-GB0	B1613-522-W00A	B4121-522-000
MA	9.5mm (3/8")	113-46004	B1115-530-0AM	B1190-522-V0A	113-47309	113-46509	B1524-530-GB0	B1613-522-B00	B4121-522-000
* P	11.1mm (7/16")	113-46004	B1115-530-0AM	B1190-522-Y0M	113-47309	113-46608	B1524-530-GB0	B1613-522-W00A	B4121-522-000

* Knife support replacement B4118-530-00A knife attaching block replacement B4119-530-00A are also available. ** Wiper cannot be attached to the C and CA type of sub-gauges.

DMN-5420N-7 SUB-GAUGE SET LIST

Specifications of the sub-gauge	Gauge width	Throat plate	Throat plate cover (asm.)	Gauge	Throat plate chip guard	Chip guide	Hinging presser (asm.)	Feed dog	Knife
sup-gauge			E)	Ŵ					
** D	3.2mm (1/8")	113-46004	B1115-531-0AD	B1190-530-D00	113-46905	113-46400	B1524-530-DB0	B1609-530-D00 B1609-530-E00	B4121-522-000
E	4.0mm (5/32")	113-46004	B1115-530-0AF	B1190-530-E00	113-46905	113-46400	B1524-530-EB0	B1609-530-D00 B1609-530-E00	B4121-522-000
F	4.8mm (3/16")	113-46004	B1115-530-0AF	B1190-530-F00	113-46905	113-46400	B1524-530-EB0	B1609-530-D00 B1609-530-E00	B4121-522-000
G	5.6mm (7/32")	113-46004	B1115-530-0AF	B1190-530-G00	113-47101	113-46400	B1524-530-GB0	B1609-530-G00 B1609-530-H00	B4121-522-000
н	6.4mm (1/4")	113-46103	B1115-530-0AF	B1190-530-H00	113-47101	113-46509	B1524-530-GB0	B1609-530-G00 B1609-530-H00	B4121-522-000
м	9.5mm (3/8")	113-46103	B1115-530-0AM	B1190-530-M00	113-47309	113-46509	B1524-530-GB0	B1609-530-G00 B1609-530-H00	B4121-522-000
This is r	made to orde	r as an auxilia	ary part only.					Coarse feed d	og
* CA	2.0mm (5/64")	113-46004	B1115-531-0AD	B1190-530-C0A	113-46905	113-46400	B1524-530-CB0	B1609-530-C0A	B4121-530-C00
DA	2.8mm (7/64")	113-46004	B1115-531-0AD	B1190-522-D0A	113-46905	113-46400	B1524-530-DB0	B1609-530-D00 B1609-530-E00	B4121-522-000
** DC	3.2mm (1/8")	113-46004	B1115-531-0AD	B1190-530-D0C	113-46905	113-46400	B1524-530-DB0	B1609-530-D0E	B4121-522-000
DD	3.2mm (1/8")	113-46004	B1115-530-0AD	B1190-530-D0B	113-46905	113-46400	B1524-530-DBA	B1609-530-J00	B4121-522-000
J	7.5mm (9/32")	113-46103	B1115-530-0AF	B1190-530-J00	113-47101	113-46509	B1524-530-GB0	B1609-530-G00 B1609-530-H00	B4121-522-000
JA	7.5mm (19/64")	113-46103	B1115-530-0AF	B1190-530-J0A	113-47101	113-46509	B1524-530-GB0	B1609-530-G00 B1609-530-H00	B4121-522-000
к	7.9mm (5/16")	113-46103	B1115-530-0AM	B1190-530-K00	113-47309	113-46509	B1524-530-GB0	B1609-530-G00 B1609-530-H00	B4121-522-000

* Be sure to use this gauge with the stitch length set to 2mm or less. ** Be sure to use this gauge with the stitch length set to 2.5mm or less. Wiper cannot be attached to the CA and DA type of sub-gauges.



LH-3128-7-WB/CP-160B

2-needle, Needle-feed, Lockstitch Machine

LH-3128 LH-3128-7 (with an automatic thread trimmer)

- The tension applied to the bobbin thread has been reduced and the needle thread path has been thoroughly renovated to achieve highly consistent feed of the needle thread. Puckering, stitch skipping, thread breakage and isolated idling loops can be therefore prevented, enabling the machine to produce beautifully finished seams with consistency.
- After the gauge has been replaced, the machine can be adapted to the newly installed gauge only by adjusting the clearance provided between the blade point of the hook and the needle. In this case, it is not necessary to change the hook timing in accordance with the gauge. As a result, the length of time required to replace the gauge is dramatically reduced.

2-needle, Needle-feed, Lockstitch Machine with Large Hooks LH-3178 LH-3178-7 (with an automatic thread trimmer)

 Our investigation of the thread take-up stroke and other mechanisms results in the reduction of irregular stitches. Even at high speed, the machine performs sewing as consistently as the standard hook machine. The machine can make the most out of the advantageous features of the large hook, upgrading the finished quality of heavy-weight materials and improving efficiency.

2-needle, Bottom-feed, Lockstitch Machine LH-3120 LH-3120-7 (with an automatic thread trimmer)

- The machine has adopted a bottom-feed mechanism. This enables the machine to perform sewing with a low tension applied to the material while preventing puckering and stitch skipping, thereby improving consistency of seam quality.
- The machine is capable of adapting to the sewing of light-weight materials and newly-developed materials. This means that the machine is exceedingly effective to the process to sew top center plaits of shirts and the sewing of foundation.



LH-3188-7-WB/CP-160B

2

2-needle, Needle-feed, Lockstitch Machine with an Organized Split Needle Bar

LH-3168 LH-3168-7 (with an automatic thread trimmer)

• The organized split needle bars which enable either the left or right needle to stop independently of the other can be changed over by simply operating the lever, thereby saving labor in corner stitching.

2-needle, Needle-feed, Lockstitch Machine with an Organized Split Needle Bar and Large Hooks

LH-3188 LH-3188-7 (with an automatic thread trimmer)

- The organized split needle bar mechanism makes it possible to stop or reset the left or right needle by operating a one-touch utility lever.
- The machine produces neatly finished stitches at corner parts of the material.
- Improved thread tension and presser foot dramatically upgrades the seam adjusting ability.
 The range of thread counts that can be used is widened.



LH-3120

SPECIFICATIONS

• Without an automatic thread trimmer

Model name	LH-3120A	LH-3128A	LH-3128S	LH-3128G					
Feed system	Bottom-feed		Needle-feed						
Application	For light-weight materials	For light-weight materials	For medium-weight materials	For jeans and heavy-weight materials					
Max. sewing speed		3,000)rpm						
Max. stitch length	4mm (normal/reverse feed)	Ę	5mm (normal/reverse feed)					
Thread take-up		Slide	type						
Needle bar stroke		33.4	mm						
Lift of the presser foot		By hand: 5.5mm	, By knee: 12mm						
Hook		Vertical-axis	regular hook						
Needle (at the time of delivery)	DP × 5 (#9) #9 ~ #14	DP × 5 (#9) #9 ~ #14	DP × 5 (#14) #11 ~ #18	DP × 5 (#21) #18 ~ #22					
Organized split needle bar mechanism		Not pr	ovided						
Lubrication	Fully a	utomatic lubrication syste	em by means of a plunger	pump					
Lubricating oil		JUKI New Defrix Oil No.1	(equivalent to ISO VG7)						
Distance from needle to machine arm		245	mm						
Bed size		517mm ;	× 178mm						
Weight of the machine head		38	kg						
Model name	LH-3168A	LH-3168S	LH-3168G	LH-3178S	LH-3178G	LH-3188G			
Feed system			Needl	e-feed					
Application	For light-weight materials	For medium-weight materials	For jeans and heavy-weight materials	For medium-weight materials	For jea heavy-weig	ns and ht materials			
Max. sewing speed			3,000)rpm					
Max. stitch length			5mm (normal	/reverse feed)					
Thread take-up			Slide	type					
Needle bar stroke			33.4	mm					
Lift of the presser foot			By hand: 5.5mm	By knee: 12mm					
Hook		Vertical-axis regular hook		Verti	cal-axis double-capacity l	nook			
Needle (at the time of delivery)	DP × 5 (#9) #9 ~ #14	DP × 5 (#14) #11 ~ #18	DP × 5 (#21) #18 ~ #22	DP × 5 (#14) #11 ~ #18	DP × 5 (#21) #18 ~ #22			
Organized split needle bar mechanism		Provided as standard		Not pro	vided	Provided as standard			
Lubrication		Fully a	utomatic lubrication syste	em by means of a plunger	pump				
Lubricating oil			JUKI New Defrix Oil No.1	(equivalent to ISO VG7)					
Distance from needle to machine arm			245	245mm					
Bed size			517mm :	« 178mm					
				kg					

• With an automatic thread trimmer

Model name	LH-3120A-7	LH-3128A-7	LH-3128S-7	LH-3128G-7				
Feed system	Bottom-feed		Needle-feed					
Application	For light- mate	0	For medium-weight materials	For jeans and heavy-weight materials				
Max. sewing speed			Orpm					
Max. stitch length	4mm (normal/reverse feed)		5mm (normal/reverse feed	i)				
Thread take-up		Slide	,					
Needle bar stroke		33.4	lmm					
Lift of the presser foot	By hand	I: 5.5mm, By knee: 12mn	n, By knee lifter with wipe	er: 9mm				
Hook		Vertical-axis	regular hook					
Needle (at the time of delivery)	DP × 5 (#11) #11 ~ #14	DP × 5 (#11) #11 ~ #14	DP × 5 (#14) #11 ~ #18	DP × 5 (#21) #18 ~ #22				
Organized split needle bar mechanism		Not pr	ovided					
Lubrication	Fully a	utomatic lubrication syste	em by means of a plunger	pump				
Lubricating oil	-	JUKI New Defrix Oil No.	I (equivalent to ISO VG7)					
Distance from needle to machine arm		245	mm					
Bed size		517mm :	× 178mm					
Weight of the machine head		43	lkg					
Power requirement	Sing	gle-phase 100 ~ 120V, 20	0 ~ 240V, 3-phase 200 ~ 2	40V				
Model name	LH-3168A-7	LH-3168S-7	LH-3168G-7	LH-3178S-7	LH-3178G-7	LH-3188G-7		
Feed system			Needl	e-feed				
Application	For light-weight materials	For medium-weight materials	For jeans and heavy-weight materials	For medium-weight materials	For jea heavy-weig	ns and ht materials		
Max. sewing speed			3,00	0rpm				
Max. stitch length			5mm (normal	l/reverse feed)				
Thread take-up			Slide	type				
Needle bar stroke			33.4	lmm				
Lift of the presser foot		By han	d: 5.5mm, By knee: 12mn	n, By knee lifter with wipe	r: 9mm			
Hook		Vertical-axis regular hook		Verti	ical-axis double-capacity l	nook		
Needle (at the time of delivery)	DP × 5 (#11) #11 ~ #14	DP x 5 (#14) #11 ~ #18	DP x 5 (#21) #18 ~ #22	DP x 5 (#14) #11 ~ #18	DP × 5 (#21) #18 ~ #22	DP × 5 (#21) #18 ~ #22		
Organized split needle bar mechanism		Provided as standard		Not pr	ovided	Provided as standard		
Lubrication		Fully a	utomatic lubrication syste	em by means of a plunger	pump			
Lubricating oil			JUKI New Defrix Oil No.1	1 (equivalent to ISO VG7)				
Automatic reverse feed function			Provided a	as standard				
Distance from needle to machine arm			245	mm				
Bed size			517mm :	× 178mm				
Weight of the machine head			43	lkg				

LH-3128, 3128-7, 3168, 3168-7, 3178, 3178-7, 3188, 3188-7, 3120, 3120-7 (June, 2001) **2/12** Downloaded from <u>www.Manualslib.com</u> manuals search engine

WHEN YOU PLACE ORDERS

• With an automatic thread trimmer

Туре	C	ode	Application Code Wiper and automatic reverse feed function							on								
n-feed	:	20	For	light-	weigh	t mate	erials		Α		Wip	ber		tomat d fun		erse	Co	de
e-feed	2	28	For	mediı	um-we	eight r	nateria	als	S								00	
e-feed with an orgar	nized	58				ieavy-\	weight	t	G	N	lot pro	vided	-	t provi	aea			
eedle bar			mat	terials									-	vided			0	_
e-feed with large ho		78								P	rovide	d		t provi	ded		W	-
e-feed with an orgar eedle bar and large	hooks	38											Pro	vided			W	В
							_				_	\bigcup				_	Auto	-lifter
						`					((No	t provi	
																	-	tch typ
			LH·						-7-								(89)	
				•														
Code	2	Α	В	С	D	E	F	G	Н	К	W	L	М	N	Р	Q	R	S
			B 3.2	C 4.0				-	H 7.9	К 9.5		_	M 15.9		-			-
Needle g Model	jauge mm	A 2.4 3/32	3.2	C 4.0 5/32	D 4.8 3/16	E 5.6 7/32	6.4	G 7.1 9/32	7.9		W 11.1 7/16	L 12.7 1/2	M 15.9 5/8	N 19.1 3/4	P 22.2 7/8	Q 25.4	R 28.6 1-1/8	31.8
Needle g Model	jauge mm	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8
Needle g Model name Sp	_{pec.} mm	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8
Needle g Model name Sp	jauge mm pec. inch A	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8
Model name LH-3120-7	jauge mm pec. inch A A	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8
Model name LH-3120-7	auge mm pec. inch A A S	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8
Model name LH-3120-7	auge mm pec. inch A A S G	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8
Model name LH-3120-7 LH-3128-7	A A A A A A A A A A A	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8
Needle g Model LH-3120-7 LH-3128-7 LH-3168-7	pauge mm pec. inch A A S G A S	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8
Model name LH-3120-7 LH-3128-7	pec mm pec inch A A S G A S G A S G	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8

* Gauges marked () are standard type. Please contact us for any gauge which is not included in the above table.

• PSC box/control panel/motor for SC

2.20000	control punc							
		(SC800-	H	B			
		PSC box		Code	Control box	Code	Control panel	Code
	Cingle phase	*	Japanese, English, Chinese	07	Standard	S	CP-60	060
For General	Single-phase 220V	PFL	English, German, French, Spanish, Italy	08	Optional unit B (for without a bobbin thread clamp)	В	CP-160 CP-360	160 360
Export	3-phase	* PFL	Japanese, English, Chinese	11		Pulley belt	Code	
	220V	PFL	English, German, French, Spanish, Italy	12		For LH	H	
For CE	Single-phase 230V	* PFL	English, German, French, Spanish, Italy	34				
** For JUS	Single-phase 120V	PFL	English, German, French, Spanish, Italy	37				
(LA)	3-phase 220V	PFL	English, German, French, Spanish, Italy	38				

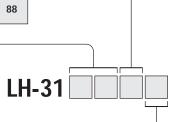
* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

** JUS: North America and Central and South America.

• Without an automatic thread trimmer

Туре	Code
Bottom-feed	20
Needle-feed	28
Needle-feed with an organized split needle bar	68
Needle-feed with large hooks	78
Needle-feed with an organized split needle bar and large hooks	88

Applicatio	n	Code
For light-weight ma	А	
For medium-weight	S	
For jeans and heavy materials	G	



Code		Α	В	С	D	E	F	G	Н	К	W	L	М	Ν	Р	Q	R	S	Т	U	
Needle	gauge	mm	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8	34.9	38.1
Model name	Spec.	inch	3/32	1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4	1-3/8	1-1/2
LH-3120	A	ł																			
	A	ł																			
LH-3128	S	5																			
	G	ò																			
	A	4																			
LH-3168	S	5																			
	G	6																			
LH-3178	S	5																			
	G	6																			
LH-3188	G	ì																			

* Gauges marked () are standard type. Please contact us for any gauge which is not included in the above table.

OPTIONS

Model	Part No.	Description	Feature
AK89		Auto-lifter	
V059	MAV-059000AA	Tension-free feeder (tape feeder)	The amount of tape to be fed can be adjusted in accordance with the sewing speed of the machine. It is adaptable to processes for attaching reinforcement tape, attaching elastic tape or lace to foundation.
AT-36		Tape cutter	The tape cutter is able to cut the tape just behind the presser foot (20mm away from the needle entry point). The cutter pressure is adjustable according to the material thickness.
	226-56854	Automatic reverse feed kit	The automatic reverse feed function device can be mounted on the machine after the setup. (*Synchronizer not included.)
	236-11056	Micro-lifter	This device can be installed on the back of the face plate. It is very convenient for frequent use.

ATTACHMENTS

Name (Code No.)	Application and seam specifications	Applicable machines	Name (Code No.)	Application and seam specifications	Applicable machines
Top center plait hemmer (mousetrap latch type) (L030)	For making top center plait on men's shirts and hemming seats bed covers, etc.	A type S type	Lapping seam folder (reverse) (M171)	For lapping seam in the various joining process including seaming sides of jeans, work uniforms, pantaloons etc.	S type G type
Pocket hammer sewing type (L032)	For hemming side pocket mouth of jeans, work uniforms etc. and hemming bottom of pants	S type G type	Left feed top stitch folder (M024)	For seaming sides	S type G type
Downturn hemmer	Garment For sewing outside pocket mouth of jeans, work uniforms, etc.	S type G type	Right feed top stitch folder (M025)	For seaming sides	S type G type
(L045) Pocket binder (clean finish	To tape attaching process to bind edges of pocket bags of slacks, pants, skirts, etc.		Tape attaching foot with center guide (B006)	For opening seam of brassieres, body suits etc.	LH-3128F A type S type
top and bottom) (N054)	For attaching formal top center plait on	S type	Sewing edge guide (H010)	Edge guide applicable to runstitching process and decorative stitching process	S type G type
Top center plait (folder) (M315)	men's shirts, etc.	A type S type	Sewing roller guide	Edge guide for runstitch process using vinylcoated cloth or man-made leather.	S type
Center plait folder (from neck down) (M037)	For making front facing from the neck side.	A type S type	(H011) Presser foot with guide (B009)	Lapping seam process and counterstitching process for denim, drill, wool, gabardine, etc.	G type S type G type
Right feed piping folder (M137)	To the process for sewing decorative pipings on sports wear, work uniforms,	S type G type	Compensating presser foot (B020)	For making top canter plaits of knit shirts, blouses, etc. and for making belts of ladies' wear	S type G type
Pajama piping folder (M163)	For sewing pipings on the edges of pockets, top-center plaits, bottoms, sleeves, etc. of pajamas.	A type S type	Box pleats folder (small type) (M009)	For sewing box pleats of skirts, box pleats at the back center of ladies' overcoats, sewing box pleats of office uniforms, work uniforms, etc.	LH-3128
Belt folder (turnable mousetrap latch type) (N012)	For making belts including shoulder straps of children's rompers, belts of ladies' overcoats etc.	S type G type	Zipper guide (Q090)	For runstitching left fly of pants and zippers	S type
Lapping seam folder (M170)	For lapping seam in the various joining process including joining sides of jeans, work uniforms, pantalons etc.	S type G type	Zipper folder (S004B)	Attaching zippers on skirts, jumpers, matcovers, etc.	LH-3128S

* The part numbers are designated according to needle gauge and specification. Be sure to confirm the part number of the attachment you need when placing your order with us.

LH-3128											
Need	dle gauge	size	Throat plate		Feed dog			Presser foot asm.			
Code				1.4	1.9	2.2	1.6mm	2.0mm	(tipdivided)		
Α	2.4mm	ı (3/32")	226-25008	226-35007			226-37557				
В	3.2mm	ı (1/8")	226-25107	226-30107			226-37656				
С	4.0mm	ı (5/32")	226-25206	226-35205	226-30206		226-37755	101-52650			
D	4.8mm	ı (3/16")	226-25305	226-35304	226-30404	B1613-512-D0H	226-37854	101-52759	226-40353		
E	5.6mm	ı (7/32")	226-25404	226-35403	226-30503	B1613-512-E0H	226-37953	101-52858	226-40452		
F	6.4mm	ı (1/4")	226-25503	226-35502	226-30602	B1613-512-F0H	226-38050	101-52957	226-40551		
G	7.1mm	ı (9/32")	226-25602	226-35700	226-30800	B1613-512-G0H	226-38258	101-53054	226-40759		
н	7.9mm	ı (5/16")	226-25701	226-35809	226-30909	B1613-512-H0H	226-38357	101-53153	226-40858		
к	9.5mm	ı (3/8")	226-25800	226-35908	226-31006	B1613-512-K0H	226-38456	101-53252	226-40957		
w	11.1mm	ı (7/16")	226-25909	226-36005	226-31105	*	226-38555	101-53351	226-41054		
L	12.7mm	ı (1/2")	226-26006	226-36203	226-31303	B1613-512-L0H	226-38753	101-53450	226-41252		
М	15.9mm	ı (5/8")	226-26105	226-36302	226-31402	B1613-512-M0H	226-38852	101-53559	226-41351		
N	19.1mm	ı (3/4")	226-26204	226-36401	226-31501	B1613-512-N0H	226-38951	101-53658	226-41450		
Р	22.2mm	ı (7/8")	226-26303	226-36609	226-31709	B1613-512-P0H	226-39157	101-53757	226-41658		
Q	25.4mm	ı (1")	226-26402	226-36708	226-31808	B1613-512-Q0H	226-39256	101-53856	226-41757		
R	28.6mm	ı (1-1/8")	226-26501	226-36807	226-31907	B1613-512-R0H	226-39355	101-53955	226-41856		
S	31.8mm	ı (1-1/4")	226-26600	226-36906	226-32004	B1613-512-S0H	226-39454	101-54052	226-41955		
Т	34.9mm	(1-3/8")	226-26709	226-37003	226-32103	B1613-512-T0H	226-39553	101-54151	226-42052		
U	38.1mm	ı (1-1/2")	226-25808	226-37102	226-32202	B1613-512-U0H	226-39652	101-54250	226-42151		
		S									
Stitch	spec.	А	Spec. common								
	G										

IH-3128

LH-3128-7

Need	dle gauge size	Throat plate with thread trimmer	Feed	dog (with thread tri	mmer)	Needle clamp asm.
Code			1.4	2.0	3mm 7	and the state
А	2.4mm (3/32")	226-60104	226-65004			101-47551
В	3.2mm (1/8")	226-60203	226-65103			101-47650
С	4.0mm (5/32")	226-60302	226-65202	102-37907		101-47759
D	4.8mm (3/16")	226-60401	226-65301	102-38004	102-39101	101-47858
E	5.6mm (7/32")	226-60500	226-65440	102-38103	102-39200	101-47957
F	6.4mm (1/4")	226-60609	226-65509	102-38202	102-39309	101-48054
G	7.1mm (9/32")	226-60708	226-65707	102-38301	102-39408	101-48153
Н	7.9mm (5/16")	226-60807	226-65806	102-38400	102-39507	101-48252
К	9.5mm (3/8")	226-60906	226-65905	102-38509	102-39606	101-48351
W	11.1mm (7/16")	226-61003	226-66002	101-68300	101-70801	101-48450
L	12.7mm (1/2")	226-61102	226-66200	102-38707	102-39804	101-48559
М	15.9mm (5/8")	226-61201	226-66309	102-38806	102-39903	101-48658
Ν	19.1mm (3/4")	226-61300	226-66408	102-38905	101-71106	101-48757
Р	22.2mm (7/8")	226-61409	226-66606	102-68706	101-71205	101-48856
Q	25.4mm (1")	226-61508	226-66708	102-39002	101-71304	101-48955
R	28.6mm (1-1/8")	226-61607	226-66804	101-68904	101-71403	101-49052
S	31.8mm (1-1/4")	226-61706	226-66903	101-69001	101-71502	101-49151
т	34.9mm (1-3/8")					101-49250
U	38.1mm (1-1/2")					101-49359
Stitch	S spec. A	Spec. common				Spec. common
	G					

ard spec. andard spec.

l order

LH-3128, 3128-7, 3168, 3168-7, 3178, 3178-7, 3188, 3188-7, 3120, 3120-7 (June, 2001) 6/12 Downloaded from www.Manualslib.com manuals search engine

LH-3128/3128-7

Need	lle gauge size	Bed slide asm. (with thread trimmer)		
Code		Bed Slide asm. (left)	Bed Slide asm. (right)	
A ≀ W	2.4mm (3/32") ≀ 11.4mm (7/16")	226-50857	226-50352	
L ≀ N	12.7mm (1/2") ≀ 19.1mm (3/4")	226-50956	226-50451	
P ≀ Q	22.2mm (7/8") ≀ 28.6mm (1-1/8")	226-51053	226-50550	
S ≀ U	31.8mm (1-1/4") ≀ 38.1mm (1-1/2")	226-51152	226-50659	

Need	lle gauge size	Front metal	Inner metal	
Code		<u>o</u>	and a	
A ≀ P	2.4mm (3/32") ≀ 22.2mm (7/8")	B1802-512-0A0A	B1803-515-0A0	
Q ∼ U	25.4mm (1") ≀ 38.1mm (1-1/2")	B1802-512-0AB	101-12357	

Т

LH-3168

Nee	dle gauge size	Throat plate		Feed dog			Presser foot asm.	
Code		A Contraction	1.4	1.9	2.2	1.6mm	2.0mm	(tipdivided)
В	3.2mm (1/8")	226-25107	226-30107			226-37656		
С	4.0mm (5/32")	226-25206	226-35205	226-30206		226-37755	101-52650	
D	4.8mm (3/16")	226-25305	226-35304	226-30404	B1613-512-D0H	226-37854	101-52759	226-40353
E	5.6mm (7/32")	226-25404	226-35403	226-30503	B1613-512-E0H	226-37953	101-52858	226-40452
F	6.4mm (1/4")	226-25503	226-35502	226-30602	B1613-512-F0H	226-38050	101-52957	226-40551
G	7.1mm (9/32")	226-25602	226-35700	226-30800	B1613-512-G0H	226-38258	101-53054	226-40759
Н	7.9mm (5/16")	226-25701	226-35809	226-30909	B1613-512-H0H	226-38357	101-53153	226-40858
К	9.5mm (3/8")	226-25800	226-35908	226-31006	B1613-512-K0H	226-38456	101-53252	226-40957
L	12.7mm (1/2")	226-26006	226-36203	226-31303	B1613-512-L0H	226-38753	101-53450	226-41252
М	15.9mm (5/8")	226-26105	226-36302	226-31402	B1613-512-M0H	226-38852	101-53559	226-41351
N	19.1mm (3/4")	226-26204	226-36401	226-31501	B1613-512-N0H	226-38951	101-53658	226-41450
Q	25.4mm (1")	226-26402	226-36708	226-31808	B1613-512-Q0H	226-39256	101-53856	226-41757
	S							*
Stitch	spec. A	Spec. common						
	G						*	

LH-3168-7

Needle gauge size		Throat plate with thread trimmer	Feed o	log (with thread tri	mmer)	Needle clamp asm. Left	Needle clamp asm. Right	
Code				1.4 Coching D	2.0	3mm 3mm 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7	0000	
В	3.2mm	n (1/8")	226-60203	226-65103			B1402-528-BA0A	B1402-528-BA0A
С	4.0mm	n (5/32")	226-60302	226-65202	102-37907		B1402-528-CA0A	B1402-528-CA0A
D	4.8mm	n (3/16")	226-60401	226-65301	102-38004	102-39101	B1402-528-DALA	B1402-528-DARA
E	5.6mm	n (7/32")	226-60500	226-65400	102-38103	102-39200	B1402-528-EAL	B1402-528-EAR
F	6.4mm	n (1/4")	226-60609	226-65509	102-38202	102-39309	B1402-528-FAL	B1402-528-FAR
G	7.1mm	n (9/32")	226-60708	226-65707	102-38301	102-39408	B1402-528-GAL	B1402-528-GAR
н	7.9mm	n (5/16")	226-60807	226-65806	102-38400	102-39507	B1402-528-HALA	B1402-528-HARA
к	9.5mm	n (3/8")	226-60906	226-65905	102-38509	102-39606	B1402-528-KALA	B1402-528-KARA
L	12.7mm	n (1/2")	226-61102	226-66200	102-38707	102-39804	B1402-528-LAL	B1402-528-LAR
м	15.9mm	n (5/8")	226-61201	226-66309	102-38806	102-39903	B1402-528-MAL	B1402-528-MAR
N	19.1mm	n (3/4")	226-61300	226-66408	102-38905	101-71106	B1402-528-NAL	B1402-528-NAR
Q	25.4mm	n (1")	226-61508	226-66705	102-39002	101-71304	B1402-528-QAL	B1402-528-QAR
S		S						
Stitch	spec.	A	Spec. common				Spec. co	ommon
		G						

Standard spec. Substandard spec.

* Special order

Need	lle gauge size	Bed slide asm. (with thread trimmer)			
Code		Bed slide asm. (left)	Bed slide asm. (right)		
B ≀ K	3.2mm (1/8") ≀ 9.5mm (3/8")	226-50857	226-50352		
L ≀ N	12.7mm (1/2") ² 19.1mm (3/4")	226-50956	226-50451		
Q	25.4mm (1")	226-51053	226-50550		

Need	dle gauge size	Front metal	Inner metal	
Code				
B ≀ N	1/8" (3.2mm) ≀ 3/4" (19.1mm)	B1802-512-0A0A	B1803-515-0A0	
Q	1" (25.4mm)	B1802-512-0AB	101-12357	

LH-3178

Needle gauge size		Throat plate	Feed	l dog	Presser f	oot asm.	
Code				1.9	2.4 * 2.2	2.0mm	(tipdivided)
Α	2.4mm	n (3/32")					
В	3.2mm	n (1/8")	226-25107	226-30107		226-37657	
С	4.0mm	n (5/32")	226-25206	226-30206		101-52650	
D	4.8mm	n (3/16")	226-25305	226-30404	228-15401	101-52759	228-16557
E	5.6mm	n (7/32")	226-25404	226-30503	228-15500	101-52858	228-16656
F	6.4mm	n (1/4")	226-25503	226-30602	228-15609	101-52957	228-16755
G	7.1mm	n (9/32")	226-25602	226-30800	228-15708	101-53054	228-16854
н	7.9mm	n (5/16")	226-25701	226-30909	228-15807	101-53153	228-16953
к	9.5mm	n (3/8")	226-25800	226-31006	228-15906	101-53252	228-17050
w	11.1mm	n (7/16")	226-25909	226-31105		101-53351	
L	12.7mm	n (1/2")	226-26006	226-31303	228-16003	101-53450	228-17159
м	15.9mm	n (5/8")	226-26105	226-31402		101-53559	
N	19.1mm	n (3/4")	226-26204	226-31501		101-53658	
Р	22.2mm	n (7/8")	226-26303	226-31709		101-53757	
Q	25.4mm	n (1")	226-26402	226-31808	*B1613-512-Q0H	101-53856	226-41757
R	28.6mm	n (1-1/8")	226-26501	226-31907	*B1613-512-R0H	101-53955	226-41856
S	31.8mm	n (1-1/4")	226-26600	226-32004	*B1613-512-S0H	101-54052	226-41955
Т	34.9mm	n (1-3/8")	226-26709	226-32103	*B1613-512-T0H	101-54151	226-42052
U	38.1mm	n (1-1/2")	226-26808	226-32202	*B1613-512-U0H	101-54250	226-42151
Chilada		S	Crea common				
Stitch	spec.	G	Spec. common				

LH-3178-7

Needle gauge size		Throat plate with thread trimmer	Feed dog (with	thread trimmer)	Needle clamp asm.	Presser foot asm.
Code			2.0	2.4	and the state	(tipdivided)
A	2.4mm (3/32")					
В	3.2mm (1/8")	226-60203	226-65103		101-47650	102-22255
С	4.0mm (5/32")	226-60302	102-37907		101-47759	102-22354
D	4.8mm (3/16")	226-60401	102-38004	228-21201	101-47858	226-40353
E	5.6mm (7/32")	226-60500	102-38103	228-21300	101-47957	226-40452
F	6.4mm (1/4")	226-60609	102-38202	228-21409	101-48054	226-40551
G	7.1mm (9/32")	226-60708	102-38301	228-21508	101-48153	226-40759
н	7.9mm (5/16")	226-60807	102-38400	228-21607	101-48252	226-40858
к	9.5mm (3/8")	226-60906	102-38509	228-21706	101-48351	226-40957
w	11.1mm (7/16")	226-61003	101-68300		101-48450	
L	12.7mm (1/2")	226-61102	101-38707	228-21805	101-48559	226-41252
м	15.9mm (5/8")	226-61201	102-38806		101-48658	226-41351
N	19.1mm (3/4")	226-61300	102-38905		101-48757	226-41450
Р	22.2mm (7/8")	226-61409	101-68706		101-48856	
Q	25.4mm (1")	226-61508	102-39002		101-48955	226-41757
R	28.6mm (1-1/8")	226-61607	101-68904		101-49052	
S	31.8mm (1-1/4")	226-61706	101-69001		101-49151	
Т	34.9mm (1-3/8")				101-49250	
U	38.1mm (1-1/2")				101-49359	
	S	Canada and and a			Crace comments	
Stitch	spec. G	Spec. common			Spec. common	

Standard spec.

LH-3178/3178-7

Need	dle gauge size	Bed slide asm. (with thread trimmer)		
Code		Bed slide asm. (left)	Bed slide asm. (right)	
A ≀ W	2.4mm (3/32") ≀ 11.4mm (7/16")	226-50857	226-50352	
L ≀ N	12.7mm (1/2") ≀ 19.1mm (3/4")	226-50956	226-50451	
P ≀ Q	22.2mm (7/8") ≀ 28.6mm (1-1/8")	226-51053	226-50550	
S ≀ U	31.8mm (1-1/4") ≀ 38.1mm (1-1/2")	226-51152	226-50659	

Need	lle gauge size	Front metal	Inner metal
Code			D
A ≀ P	2.4mm (3/32") ≀ 22.2mm (7/8")	B1802-512-0A0A	B1803-515-0A0
Q ≀ U	25.4mm (1") ≀ 38.1mm (1-1/2")	B1802-512-0AB	101-12357

Chain-off thread gauge

Needle gauge size		Throat plate (with- out thread trimmer)		Throat plate (with thread trimmer)	Feed dog (with thread trimmer)	Presser foot asm.	Feed dog screw
Code		E.		C C C C C C C C C C C C C C C C C C C			
D	4.8mm (3/16")	228-35003	228-35557	228-35201	106-91053	B1524-512-DBH	SS6580710TP × 2
F	6.4mm (1/4")	228-35102	228-35656	228-35300	106-98652	B1524-512-FBE	330360/101F X 2

LH-3188

Need	dle gauge	e size	Throat plate	Feed dog	Presser foot asm.		
Code				2.4	(tipdivided)		
В	3.2mn	n (1/8")					
С	4.0mn	n (5/32")					
D	4.8mm (3/16")		226-25305	228-15401	228-16557		
E	5.6mn	n (7/32")	226-25404	228-15500	228-16656		
F	6.4mm (1/4")		6.4mm (1/4")		226-25503	228-15609	228-16755
G	7.1mm (9/32")		226-25602	228-15708	228-16854		
н	7.9mn	n (5/16")	226-25701	228-15807	228-16953		
К	9.5mn	n (3/8")	226-25800	228-15906	228-17050		
L	12.7mn	า (1/2")	226-26006	228-16003	228-17159		
М	15.9mm (5/8")						
N	19.1mm (3/4")						
Q	25.4mn	า (1")					
		S					
Stitch	spec.	А	Spec. common				
		G					

LH-3188-7

Need	lle gauge	e size	Throat plate with thread trimmer	Feed dog (with thread trimmer)	Needle clamp asm. Left	Needle clamp asm. Right
Code					1	1
В	3.2mm	n (1/8")				
С	4.0mm	n (5/32")				
D	4.8mm (3/16")		226-60401	228-21201	B1402-528-DALA	B1402-528-DARA
E	5.6mm (7/32")		226-60500	228-21300	B1402-528-EAL	B1402-528-EAR
F	6.4mm (1/4")		226-60609	228-21409	B1402-528-FALA	B1402-528-FARA
G	7.1mm (9/32")		226-60708	228-21508	B1402-528-GAL	B1402-528-GAR
Н	7.9mm	n (5/16")	226-60807	228-21607	B1402-528-HALA	B1402-528-HARA
К	9.5mm	n (3/8")	226-60906	228-21706	B1402-528-KALA	B1402-528-KARA
L	12.7mm	า (1/2")	226-61102	228-21805	B1402-528-LAL	B1402-528-LAR
М	15.9mm	า (5/8")				
Ν	19.1mm (3/4")					
Q	25.4mm (1")					
Stitch spec. A G		Spec. common		Spec. cc	ommon	

LH-3188/3188-7

Need	dle gauge size	Bed slide asm. (with thread trimmer)			Needle gauge size		
Code		Bed slide asm. (left)	Bed slide asm. (right)		Code		(
B ≀ K	3.2mm (1/8") ≀ 9.5mm (3/8")	226-50857	226-50352		A ≀ P	2.4mm (3/32") ² 22.2mm (7/8")	E
L ≀ N	12.7mm (1/2") ² 19.1mm (3/4")	226-50956	226-50451		Q ~ U	25.4mm (1") ≀ 38.1mm (1-1/2")	
Q	25.4mm (1")	226-51053	226-50550	'			

Need	lle gauge size	Front metal	Inner metal
Code			
A ≀ P	2.4mm (3/32") ≀ 22.2mm (7/8")	B1802-512-0A0A	B1803-515-0A0
Q ≀ U	25.4mm (1") ≀ 38.1mm (1-1/2")	B1802-512-0AB	101-12357

• Chain-off thread gauge

• chain-on thread gauge							
Need	lle gauge size	Throat plate (with- out thread trimmer)	Feed dog (without thread trimmer)	Throat plate (with thread trimmer)	Feed dog (with thread trimmer)	Presser foot asm.	Feed dog screw
Code		EF.		C T			
D	4.8mm (3/16")	228-35003	228-35557	228-35201	106-91053	B1524-512-DBH	SS6580710TP × 2
F	6.4mm (1/4")	228-35102	228-35656	228-35300	106-98652	B1524-512-FBE	33030071011 × 2

LH-3128, 3128-7, 3168, 3168-7, 3178, 3178-7, 3188, 3188-7, 3120, 3120-7 (June, 2001) 11/12

LH-3120

Need	dle gauge size	Throat	t plate	Feed	l dog	Presser foot asm.	Needle clamp asm.
Code		· <u>=:=</u> 0				r:	
Α	2.4mm (3/32")						
В	3.2mm (1/8")	228-45200		228-47206		103-91852	101-47650
С	4.0mm (5/32")						
D	4.8mm (3/16")	228-45408		228-47404		103-92058	101-47858
E	5.6mm (7/32")						
F	6.4mm (1/4")	228-45606		228-47602		103-92256	101-48054
G	7.1mm (9/32")						
Н	7.9mm (5/16")						
К	9.5mm (3/8")						
W	11.1mm (7/16")						
L	12.7mm (1/2")		228-46109		228-48105	103-92751	101-48559
М	15.9mm (5/8")						
N	19.1mm (3/4")		228-46307		228-48303	103-93056	101-48757
Р	22.2mm (7/8")		228-46406		228-48402	228-44450	101-48856
Q	25.4mm (1")		228-46505		228-48501	228-44559	101-48955
R	28.6mm (1-1/8")						
S	31.8mm (1-1/4")						
Т	34.9mm (1-3/8")						
U	38.1mm (1-1/2")						
Stitch	spec. A					Spec. common	Spec. common

LH-3120-7

Need	dle gauge size	Throa	t plate	Feed	l dog	Presser foot asm.	Needle clamp asm.
Code						ţ	
A	2.4mm (3/32")						
В	3.2mm (1/8")	228-53204		228-55209		103-91852	101-47650
С	4.0mm (5/32")						
D	4.8mm (3/16")	228-53402		228-55407		103-92058	101-47858
E	5.6mm (7/32")						
F	6.4mm (1/4")	228-53600		228-55605		103-92256	101-48054
G	7.1mm (9/32")						
Н	7.9mm (5/16")						
К	9.5mm (3/8")						
W	11.1mm (7/16")						
L	12.7mm (1/2")		228-54103		228-56108	103-92751	101-48559
М	15.9mm (5/8")						
N	19.1mm (3/4")		228-54301		228-56306	103-93056	101-48757
Р	22.2mm (7/8")		228-54400		228-56405	228-44450	101-48856
Q	25.4mm (1")		228-54509		228-56504	228-44559	101-48955
R	28.6mm (1-1/8")						
S	31.8mm (1-1/4")						
Т	34.9mm (1-3/8")						
U	38.1mm (1-1/2")						
Stitch	spec. A						

LH-3120/3120-7

Need	dle gauge size	Bed slide asm. (with thread trimmer)		
Code		Bed slide asm. (left)	Bed slide asm. (right)	
A ≀ W	2.4mm (3/32") ≀ 11.4mm (7/16")	226-50857	226-50352	
L ≀ N	12.7mm (1/2") ≀ 19.1mm (3/4")	226-50956	226-50451	
P ≀ Q	22.2mm (7/8") ≀ 28.6mm (1-1/8")	226-51053	226-50550	

Need	dle gauge size	Front metal	Inner metal
Code			
A ≀ P	2.4mm (3/32") 22.2mm (7/8")	B1802-512-0A0A	B1803-515-0A0
Q 2 U	25.4mm (1") ≀ 38.1mm (1-1/2")	B1802-512-0AB	101-12357

2-needle, Needle-feed/Bottom-feed, Lockstitch Machine (for foundation)

LH-3126F

- Operating noise of the machine is dramatically reduced.
- The improved opener reduces the impact against the bobbin. By reducing variations of bobbin thread tension caused by the opener, irregular stitches are eliminated.
- The strokes of the right and left thread take-up are separately adjustable.
- The adjustment range of the needle thread tension is widened.
- The machine is equipped with a hook that uses a non-rotational bobbin.
- Height and inclination of the feed dog can be adjusted.
- Through a simple adjustment of the machine and replacement of the gauge, the feed method can be changed over between the needle-feed and bottom-feed types.

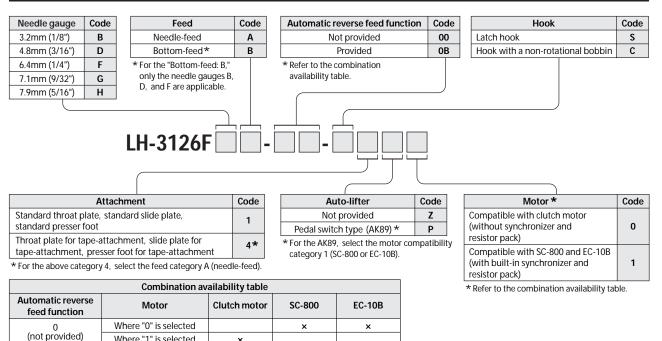


LH-3126F

SPECIFICATIONS

Model name	LH-3126F		
Max. sewing speed	3,000rpm		
Max. stitch length	4mm (normal /reverse feed)		
Thread take-up	Slide type		
Needle bar stroke	33.4mm		
Lift of the presser foot	By hand: 5.5mm, By knee: 12mm		
Hook (selectable)	Vertical-axis hook (regular fold), specific latch hook or specific hook with a non-rotational bobbin		
Needle (at the time of delivery)	DP × 5 (#10) #9 ~ #11		
Feed system	Change-over between needle-feed/bottom-feed		
Lubrication	Fully automatic lubrication system by means of a plunger pump		
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)		
Distance from needle to machine arm	245mm		
Bed size	517mm × 178mm		
Weight of the machine head	43kg		

WHEN YOU PLACE ORDERS



×

×

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×

×

Where "1" is selected

Where "0" is selected

Where "1" is selected

B (provided)

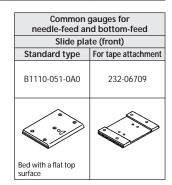
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2

•Gauges installed at the time of delivery

				Needle-fee	ed gauges		
(Gauge size	Needle clamp	Throa	t plate	Press	Feed dog	
Code		Needle clamp	Standard type	For tape attachment	Standard type	For tape attachment	(small pitch)
В	3.2mm (1/8")	101-47650	226-25107	232-06808	226-27152	226-47051	B1613-512-B0B
D	4.8mm (3/16")	101-47858	226-25305	B1109-512-D0B	226-27350	226-47150	B1613-512-D0B
F	6.4mm (1/4")	101-48054	226-25503	B1109-512-F0B	226-27558	226-47358	B1613-512-F0B
G	7.1mm (9/32")	101-48153	226-25602	B1109-512-G0B	226-27657	226-47457	B1613-512-G0B
Н	7.9mm (5/16")	101-48252	226-25701	B1109-512-H0B	226-27756	226-47556	B1613-512-H0B
						With a swivel guide	SELECTION 1.4

		1	Bottom-feed gauges	5
0	Gauge size	Throat plate	Presser foot	Feed dog
			F1633611001	i eeu uog
	3.2mm (1/8")	228-45200	103-91852	232-05107
	4.8mm (3/16")	228-45408	103-92058	232-05305
	6.4mm (1/4")	228-45606	103-92256	232-05503
		1.6	2.0 2.2 Needle slot 2.0 (B gauge) 2.2 (D and F gauges)	



Optional gauges

Code

В

D F

					Needle-feed gauges	6		
(Gauge size	Feed dog		Rectangular feed		For	light-weight mater	ials
Code		(large pitch)	Throat plate	Feed dog (small pitch)	Feed dog (large pitch)	Presser foot	Feed dog (small pitch)	Feed dog (large pitch)
В	3.2mm (1/8")	101-08108	B1109-528-B00	101-86302	101-40804	226-37656	226-35107	226-34000
D	4.8mm (3/16")	101-08207	B1106-528-D00	101-86401	101-40903	226-37854	226-35304	226-34208
F	6.4mm (1/4")					226-38050	226-35502	226-34406
G	7.1mm (9/32")		B1109-528-G00	101-86500		226-38258	226-35700	226-34505
Н	7.9mm (5/16")					226-38357	226-35809	226-34604
		L		Low the second s	Vith behind-the- needle-slot grooves	Ĩ	Vithout behind-the- needle-slot grooves	1.4 Without behind-the- needle-slot grooves
(Gauge size	Throat plate		Slide plate (front)				
Code		For tape attachment		For tape attachment				
В	3.2mm (1/8")	226-28002						
D	4.8mm (3/16")	226-28200						
F	6.4mm (1/4")	226-28408		226-08558				
G	7.1mm (9/32")	226-28507						
Н	7.9mm (5/16")	226-28606						

OPTIONS

With a tape inserting recess

Model	Part No.	Description	Feature
V059	MAV-059000AA	Tension-free feeder (tape feeder)	The amount of tape to be fed can be adjusted in accordance with the sewing speed of the machine. It is adaptable to processes for attaching reinforcement tape, attaching elastic tape or lace to foundation.
AT-36		Tape cutter	The tape cutter is able to cut the tape just behind the presser foot (20mm away from the needle entry point). The cutter pressure is adjustable according to the material thickness.
	226-56854	Automatic reverse feed kit	The automatic reverse feed function device can be mounted on the machine after the setup. This device can be installed on the back of the face plate. It is very convenient for frequent use.
	236-11056	Micro-lifter	This device can be installed on the back of the face plate. It is very convenient for frequent use.

All-thin type

LH-3126F (June, 2001) **2/2** Downloaded from <u>www.Manualslib.com</u> manuals search engine

2-needle, Needle-feed, Lockstitch Machine with an Automatic Organized Split Needle Bar Incorporating Corner Programming Device and an Automatic Thread Trimmer

LH-3162-7 LH-3182-7 (with large hooks)

- The automatic organized split needle bar releasing device automatically counts the number of stitches and releases the needle bar from the stop state. Since the operator only needs to press the switch once at the start of corner stitching, operator can concentrate on the handling of the material being sewn. This upgrades efficiency dramatically.
- To sew several corners of a material continuously, a series of corner stitching processes can be automatically performed by creating a sewing program which combines different types of corner stitching processes.* As many as eight different corner stitching processes and eight different patterns can be combined in a sewing program.
 - * If your machine is equipped with JUKI's unique reverse function (pattern inverting function), as many as 16 different corner stitching processes can be combined.
- The machine is able to sew continuous obtuse-angle corners (gentle corners). Since the machine can perform same pattern sewing in repetition, it allows the operator to continuously sew gentle corners of a skirt (sewing in repetition) only by operating the knee switch.



LH-3182-7/CP-660B

2

SPECIFICATIONS

Model name	LH-3162A-7	LH-3162S-7	LH-3162G-7	LH-3182G-7				
Application	For light-weight materials	For medium-weight materials	For jeans and heav	y-weight materials				
Max. sewing speed		3,000)rpm					
Max. stitch length	5mm (normal/reverse feed)							
Lift of the presser foot	By hand: 5.5mm, By knee: 12mm, By knee lifter with wiper: 9mm							
Hook	Vert	ical-axis regular hook (cap t	ype)	Vertical-axis double- capacity hook (cap type)				
Needle (at the time of delivery)	DP × 5 (#11) #11 ~ #14	DP×5 (#14) #11~#18	DP × 5 (#21) #18 ~ #2	2, For JE: 134 (Nm130)				
Thread take-up		Slide	type					
Needle bar stroke		33.4	mm					
Lubrication	Fully	automatic lubrication syste	m by means of a plunger p	ump				
Lubricating oil		JUKI New Defrix Oil No.1	(equivalent to ISO VG7)					
Organized split needle bar		Provided a	s standard					
Distance from needle to machine arm		245	mm					
Bed size		517mm >	(178mm					
Weight of the machine head		43	Kg					
Power requirement	Si	ngle-phase 100 ~ 120V, 200	0 ~ 240V, 3-phase 200 ~ 240	V				

OPTIONS

Model	Part No.	Description	Feature
AK89		Auto-lifter	
	227-98465	Compensation stitching switch (reverse feed control lever mounting type)	Works effectively when you need to perform sewing while changing the stitch length of the compensation stitch (one stitch).
	227-98052	Compensation stitching switch (foot switch type)	Works effectively when you want to control the compensation stitching (one stitch) by foot.



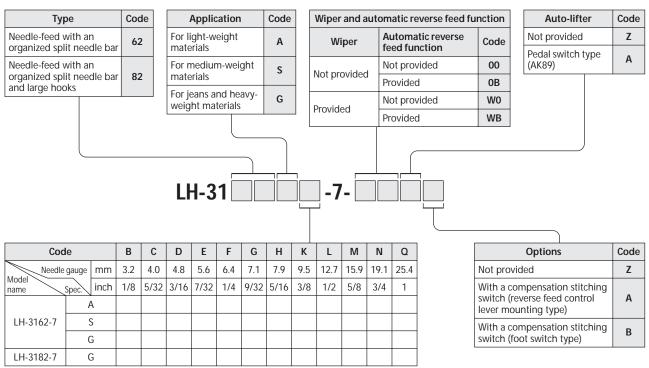
Compensation stitching switch (reverse feed control lever mounting type)



Compensation stitching switch (foot switch type)

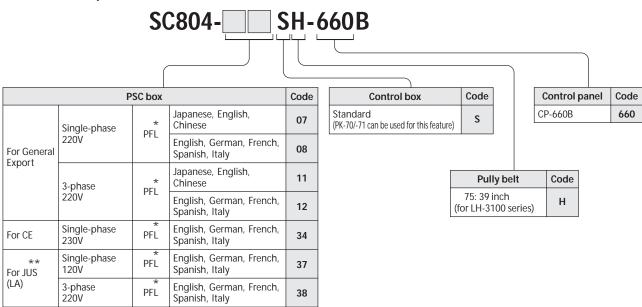
LH-3162-7, 3182-7 (June, 2001) 1/2

WHEN YOU PLACE ORDERS



* Gauges marked () are standard type. Please contact us for any gauge which is not included in the above table.

PSC box/control panel/motor for SC



* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

** JUS: North America and Central and South America.

Corner stitching hand-operated switches

$\begin{array}{c} \bullet & \bullet & \bullet \\ \bullet & \bullet & \bullet$

Control panel CP-660B



Servomotor/Controller SC-804



LH-1152 LH-1152-7 (with an automatic thread trimmer)

- Thanks to the ideal stroke of thread take-up which provides an adequate drawing amount of needle thread and thread tension control mechanism which allows independent adjustment of the right and left threads, the machine ensures consistent formation of stitches even when it runs at a high speed and flexibly adapts to a change of sewing materials.
- An exclusive gauge is respectively prepared for light-weight materials, foundation, medium-weight materials and jeans to allow the machine to adapt to changes of materials.

2-needle, Bottom-feed, Lockstitch Machine

LH-1150

• The machine incorporates a gauge exclusively designed for light-weight materials and reduces the number of revolutions, thereby effectively prevents puckering and material slippage that are likely to occur with light-weight materials.

SPECIFICATIONS

Without an automatic thread trimmer

Model name	LH-1152A	LH-1152S	LH-1152F	LH-1152G	LH-1150A
Application	For light-weight materials	For medium-weight materials	For foundation	For jeans	For light-weight materials
Feed method		Needle	e-feed		Bottom-feed
Max. sewing speed		3,500rpm			
Max. stitch length		4mm			
Lift of the presser foot		Ву	hand: 5.5mm, By knee: 10m	าท	
Hook			Vertical-axis regular hook		
Needle (at the time of delivery)	SG × 1906 (#9) #9 ~ #16 For JE: 134 (Nm65)	DP × 5 (#14) #11 ~ #22 For JE: 134 (Nm90)	SG × 1965 (#9) #9 ~ #11 For JE: 134 (Nm65)	DP × 5 (#21) #18 ~ #22 For JE: 134 (Nm130)	DP × 5 (#11) #9 ~ #16 For JE: 134 (Nm75)
Thread take-up			Link type		
Needle bar stroke			33.4mm		
Lubrication		Fully automatic lub	prication system by means c	of a plunger pump	
Lubricating oil		JUKI New I	Defrix Oil No.1 (equivalent to	o ISO VG7)	
Distance from needle to machine arm			245mm		
Bed size			517mm × 178mm		
Weight of the machine head			38Kg		

• With an automatic thread trimmer

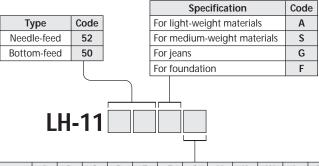
Model name	LH-1152S-7	LH-1152G-7						
Application	For medium-weight materials	For jeans						
Feed method	Needl	e-feed						
Max. sewing speed	4,50	Drpm						
Max. stitch length	4mm	6mm						
Lift of the presser foot	By hand: 5.5mm, By knee: 10mm							
Hook	Vertical-axis regular hook							
Needle (at the time of delivery)	DP x 5 (#14) #11 ~ #22, For JE: 134 (Nm75)	DP × 5 (#21) #18 ~ #22, For JE: 134 (Nm130)						
Thread take-up	Link	type						
Needle bar stroke	33.4	mm						
Lubrication	Fully automatic lubrication syste	m by means of a plunger pump						
Lubricating oil	JUKI New Defrix Oil No.	(equivalent to ISO VG7)						
Distance from needle to machine arm	245	mm						
Bed size	517mm >	(178mm						
Weight of the machine head	43	Kg						
Power requirement	Single-phase 100 ~ 120V, 200	0 ~ 240V, 3-phase 200 ~ 240V						



LH-1152-7-WB/CP-160B

2

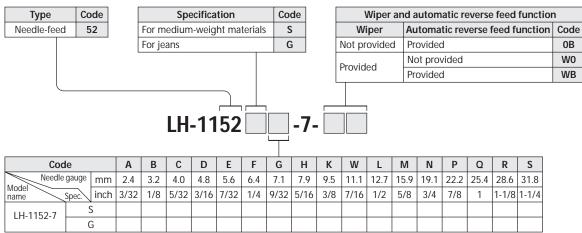
Without an automatic thread trimmer



Cod	е		Α	В	С	D	Ε	F	G	Н	К	W	L	Μ	Ν	Р	Q	R	S	Т	U
Needle	gauge	mm	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8	34.9	38.1
Model name	Spec.	inch	3/32	1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4	1-3/8	1-1/2
	A	ł																			
LH-1152	S	S																			
LII-IIJZ	0	3																			
	F	-																			
LH-1150	A	1																			

* Gauges marked () are standard type. Please contact us for any gauge which is not included in the above table.

With an automatic thread trimmer



* Gauges marked () are standard type. Please contact us for any gauge which is not included in the above table.

PSC box/control panel/motor for SC

• F SC DOM	control parier	motor	01 50						
			SC800-	⊟ H 	B				
		PSC box		Code	Control box	Code		Control panel	Code
	Cingle phase	*	Japanese, English, Chinese	07	Standard	S		CP-60	060
For General	Single-phase 220V	PFL	English, German, French, Spanish, Italy	08	Optional unit A (for use by a standing operator)	А		CP-160 CP-360	160 360
Export	3-phase	* PFL	Japanese, English, Chinese	11		Pulle	ey belt	Code	
	220V	PFL	English, German, French, Spanish, Italy	12			or LH	Н	
For CE	Single-phase 230V	PFL	English, German, French, Spanish, Italy	34		ifter mour	nted on	the machine head	
** For JUS	Single-phase 120V	PFL	English, German, French, Spanish, Italy	37	АК	(109	1		
(LA)	3-phase 220V	* PFL	English, German, French, Spanish, Italy	38				_	
* If an auto	lifter is installed on	the machi	ne the presser foot will be lifted.	/lowered b	by the foot pedal D	evice	Cod	e	

Pedal switch type

109

* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal. ** JUS: North America and Central and South America. High-speed Overlock / Safety Stitch Machine

MO-3300 SERIES

- The presser foot pressure has been reduced and the cloth feeding force has been increased. This enables the machine to smoothly feed soft and delicate materials while preventing the material from fluttering and the presser foot from jumping. This means that the operator can easily handle the material on the machine, leading to a higher efficiency.
- The maximum sewing speed of the MO-3300 series of overlock/ safety stitch machine is 6,500rpm. This is practical use in clothing plants.
- An upper looper of the extra high throw type is provided as standard. This greatly widens responsiveness to material types, from light-weight to heavy-weight materials.

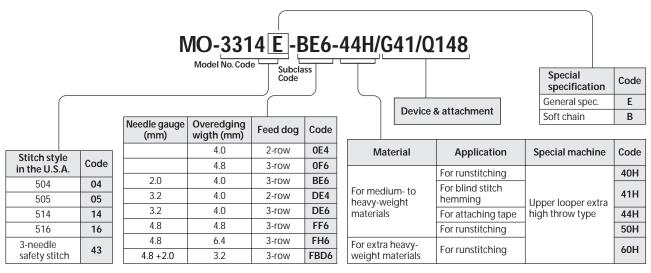


MO-3314

SPECIFICATIONS

Model name	MO-3304	MO-3314	MO-3316					
Stitch type	1-needle overlock	2-needle overlock	Safety stitching					
Stitch style in the U.S.A.	504	514	516					
Max. sewing speed		6,500rpm						
Stitch length		3.6mm						
Needle gauge (mm)		2.0	3.2, 4.8					
Overedging width (mm)	4.0, 4.8 4.0 4.0, 4.8, 6.4							
Differential-feed ratio	For gathering	1:1.9 (max. 1:2.9), For stretching 1:0	0.8 (max. 1: 0.6)					
Needle bar stroke		25.5mm						
Inclination angle of the needle		20°						
Needle		DC × 27						
Max. lift of the presser foot		6.5mm						
Max. presser foot pressure		58.8N (6kg)						
Stitch adjusting method		By push-button						
Differential-feed adjusting method		By lever (with micro-adjustment)						
Needle mechanism	Nee	dle bar method and upper / lower bu	shing					
Upper knife		Carbide flat knife						
Opening/closing of cloth plate	Ву	one-touch type open/close mechan	lism					
Opening/closing of looper cover	Ву	one-touch type open/close mechan	lism					
Looper thread cam position guide mechanism			One-touch type flap mechanism					
Threading marker		Thread path is colored	1					
Needle cooler		Provided as standard						
Weight of the machine head		25kg						
Lubrication		Automatic						
Lubricating oil	JUKI N	New Defrix Oil No.2 (equivalent to ISC) VG32)					

WHEN YOU PLACE ORDERS



SUBCLASS MACHINE LIST

Seams	Model No.	L F H * Materials	Number	S Number of	⊣ ⊢ Needle gauge	Overedging width (mm)	Number of feed dog		Bottom differential-	Presser lifting amount	N Needle system	Max. sewing speed	Remarks
	dle overlock	eral fabric	needles	threads	(mm)		rows	(mm)	L	= Light-w	 ght-weight material /eight materials n-weight materials		 Heavy-weight materials Extra heavy-weight material:
	MO-3304E-0E4-4		1	3	-	4.0	2	3.6	1:0.8 ~ 1:1.9	6.5	DC × 27 #11	6,500	Upper looper
	MO-3304E-0F6-5	0Н М~Н	1	3	-	4.8	3	3.6	1:0.8 ~ 1:1.9	6.5	DC × 27 #14	6,500	extra high throw type
For bac	cklach ★ Z192	: Backlach attach	nment										
Ś	MO-3304B-0E4-4 /Z192	OH L~M	1	3	-	4.0	2	3.6	1:0.8 ~ 1:1.9	6.5	DC × 27 #11	6,500	Upper looper extra high throw type
• For blir	nd stitch hemmir	1g ★ L121 :	Blind sti	tch hemr	ming att	achment							
S	MO-3305E-0E4-4 /L121	1H L~M	1	3	-	4.0	2	3.6	1:0.8 ~ 1:1.9	6.5	DC × 27 #9	6,500	Upper looper extra high throw type
	dle overlock	oral fabria											
	MO-3314E-BE6-4		2	4	2.0	4.0	3	3.6	1:0.8 ~ 1:1.9	6.5	DC × 27 #11	6,500	Upper looper extra high throw type
For tar	be attaching	★G41 : Tape at	l taching i	oresser fr	not 🛨) 148 · Tape	auide	1		1		1	
<u> </u>	MO-3314E-BE6-4 /G41/Q148		2	4	2.0	4.0	3	3.6	1:0.8 ~ 1:1.9	6.5	DC × 27 #14	6,500	Upper looper extra high throw type
Safet	y stitching				•	•	•			•		•	•
For run	nstitching in gene			1	1	1	1	1	1			1	
	MO-3316E-DE4-4		2	5	3.2	4.0	2	3.6	1:0.8 ~ 1:1.9	6.5	DC × 27 #11	6,500	-
	MO-3316E-DE6-4	-	2	5	3.2	4.0	3	3.6	1:0.8 ~ 1:1.9	6.5	DC × 27 #11	6,500	-
	MO-3316E-FF6-4		2	5	4.8	4.8	3	3.6	1:0.8 ~ 1:1.9	6.5	DC × 27 #11	6,500	Upper looper
- THE	MO-3316E-FF6-5	-	2	5	4.8	4.8	3	3.6	1:0.8 ~ 1:1.9	6	DC × 27 #16	6,500	extra high throw type
•	MO-3316E-FH6-5		2	5	4.8	6.4	3	3.6	1:0.8 ~ 1:1.9	6	DC × 27 #16	6,500	-
	MO-3316E-FF6-6	OH H~EH	2	5	4.8	4.8	3	3.6	1:0.8 ~ 1:1.9	6	DC × 27 #21	6,500	-
	MO-3316E-FH6-6	OH H~EH	2	5	4.8	6.4	3	3.6	1:0.8 ~ 1:1.9	6	DC × 27 #21	6,500	
For mu	Iti-purpose runs MO-3343E-FBD6-		2		4.8	3.2	3	4	1:0.7 ~ 1:2	6.5	DC × 27 #11	6,500	Upper looper
			3	6	+2.0	5.2	5		1.0.7 1.2	0.0	00 27 #11	0,500	extra high throw type
	ICES AND A		ENTS		+2.0	3.2	5		1.0.7 1.2			0,500	extra high throw type
Model	ICES AND A	ATTACHM	ENTS		+2.0	5.2	5		1.0.7 1.2		Feature	0,300	extra high throw type
Model Chain-e	ICES AND A Part No.	ATTACHM ing device	ENTS Desc		+2.0	0.2			1.0.7 1.2			0,500	extra high throw type
Model Chain- T041	Part No. Part No. off thread trimm MAT-041000AC	ATTACHM	ENTS Desc cutter		+2.0							0,000	extra high throw type
Model Chain-0 T041 T045	ICES AND A Part No.	ATTACHM ing device	ENTS Desc cutter e cutter	cription	I 				100, 12 100, 240V			0,500	extra high throw type
Model Chain- T041	Part No. Part No. off thread trimm MAT-041000AC MAT-045000AA	Ing device Pneumatic flat Pneumatic side	ENTS Desc cutter e cutter e tape cu	cription		ff thread	For 100), 115, 2					extra high throw type
Model Chain-0 T041 T045 T052 Chain-0	Part No. Part No. off thread trimm MAT-041000AC MAT-045000AA MAT-052001A0	ATTACHM	ENTS Desc cutter e cutter e tape cu ce (electr	cription	l chain-c	ff thread	For 100), 115, 2	200, 240V				extra high throw type
Model Chain-o T041 T045 T052 Chain-o MC-4 Air reg • Air reg • Air reg	Part No. off thread trimm MAT-041000AC MAT-041000AC MAT-052001A0 MAT-052002A0 off thread suctio ulator (cption) ulator (F.R. unit asm. onnector (male) Par	ATTACHM	ENTS Desc cutter e cutter e tape cu e (electr n-off three 52010-B	ription utter and omagne ead suction	I chain-c tic type; on devic	ff thread) e w for F.R. ui	For 100 For 220 hit asm.), 115, 2), 380, 4 Part No	200, 240V 115, 440V	× 2	Feature		
Model Chain-o T041 T045 T052 Chain-o MC-4 Air reg Air reg Tube c	ICES AND A Part No. off thread trimm MAT-041000AC MAT-045000AA MAT-052001A0 MAT-052002A0 off thread suctio off thread suctio ulator (cR. unit asm onnector (male) Par ing device	ATTACHM ing device Pneumatic flat Pneumatic side One-touch typ trimming device Pneumatic chai .) Part No.: PF-05 t No.: F1021-003 Swing-type gai	ENTS Desc cutter e cutter e tape cu ce (electr n-off three 52010-B -000	ead suction on Fixion device	I chain-c tic type; on devic ing scre e-touch	e w for F.R. ur connector	For 100 For 220 hit asm. Part No.), 115, 2), 380, 4 Part No : GAS-12	200, 240V 115, 440V 0.: GMD-0108000 : 0063000 (* Selec:	× 2 tion part	Feature S instead of the	tube conr	nector.)
Model Chain-o T041 T045 T052 Chain-o MC-4 Air reg • Air reg • Tube c	Part No. off thread trimm MAT-041000AC MAT-041000AC MAT-052001A0 MAT-052002A0 off thread suctio ulator (cption) ulator (F.R. unit asm. onnector (male) Par	ATTACHMI ing device Pneumatic flat Pneumatic side One-touch typ trimming device Pneumatic chai .) Part No.: PF-05 t No.: F1021-003 Swing-type gai (interlocked wi Swing-type gai	ENTS Desc cutter e cutter e tape cut e (electr n-off three 52010-B -000 chering c the the point the point chering c	utter and omagne ead suction 0 • Fixi • On device edal for s device	I chain-c tic type) on devic ing scre e-touch safety sti	e w for F.R. ur connector tch)	For 100 For 220 hit asm. Part No. The sep materia), 115, 2), 380, 4 Part No : GAS-12	00, 240V 15, 440V 0: GMD-0108000 : 063000 (* Select plate opens inter machine. The m	× 2 tion part	Feature S instead of the statement of th	tube conr	nector.)
Model Chain- T041 T045 T052 Chain- MC-4 Air reg · Air reg · Air reg · Sl69 Sl70	ICES AND A Part No. off thread trimm MAT-041000AC MAT-045000AA MAT-052001A0 MAT-052002A0 off thread suctio ulator (cPR. unit asm onnector (male) Par ing device MAS-169000A0 MAS-170000A0	ATTACHM ing device Pneumatic flat Pneumatic side One-touch typ trimming device Pneumatic chai) Part No.: PF-05 t No.: F1021-003 Swing-type gai (interlocked wi	ENTS Desc cutter e cutter e tape cut e (electr n-off three 52010-B -000 chering c the the point the point chering c	utter and omagne ead suction 0 • Fixi • On device edal for s device	I chain-c tic type) on devic ing scre e-touch safety sti	e w for F.R. ur connector tch)	For 100 For 220 hit asm. Part No. The sep materia), 115, 2), 115, 2), 380, 4 Part No : GAS-12 Darating al on the	00, 240V 15, 440V 0: GMD-0108000 : 063000 (* Select plate opens inter machine. The m	× 2 tion part	Feature S instead of the statement of th	tube conr	nector.)
Model Chain-o T041 T045 T052 Chain-o MC-4 Air reg Air reg Air reg S169 S170 Guide,	ICES AND A Part No. off thread trimm MAT-041000AC MAT-041000AC MAT-052001A0 MAT-052002A0 off thread suctio ulator (cR. unit asm onnector (male) Par ing device MAS-169000A0 MAS-170000A0 Ruler	ATTACHMI ing device Pneumatic flat Pneumatic side One-touch typ trimming device Pneumatic chai) Part No.: PF-05 t No.: F1021-003 Swing-type gai (interlocked wi Swing-type gai	ENTS Desc cutter e cutter e tape cc ce (electr n-off three 52010-B 52010-B cooo	ead suction ead suction 0 • Fixion • On fevice edal for s device edal for s	I chain-co tic type) on device ing scree e-touch safety sti	e w for F.R. ur connector tch)	For 100 For 220 hit asm. Part No. The sep materia), 115, 2), 115, 2), 380, 4 Part No : GAS-12 Darating al on the	00, 240V 15, 440V 0: GMD-0108000 : 063000 (* Select plate opens inter machine. The m	× 2 tion part	Feature S instead of the statement of th	tube conr	nector.)
Model Chain-G T041 T045 T052 Chain-G MC-4 Air reg • Air reg • Air reg • Tube c Gather \$169 \$170 Guide, H153	ICES AND A Part No. off thread trimm MAT-041000AC MAT-045000AA MAT-052001A0 MAT-052002A0 off thread suctio ulator (coption) ulator (F.R. unit asm onnector (male) Par ing device MAS-169000A0 MAS-170000A0 Ruler MAH-153000A0	ATTACHM ing device Pneumatic flat Pneumatic side One-touch typ trimming device n device Pneumatic chai) Part No.: PF-05 t No.: F1021-003 Swing-type gai (interlocked wi Swing-type gai (interlocked wi	ENTS Desc cutter e cutter e tape cu- e (electr n-off three 52010-Bi -000 thering c thering c thering c thering c	ead suction ead suction omagne ead suction on fixion edal for s levice edal for s levice edal for c (for over	I chain-o tic type) on device ing scree e-touch safety sti overlock	ff thread e w for F.R. ur connector tch))	For 100 For 220 hit asm. Part No. The sep materia the atta), 115, 2), 380, 4 Part No : GAS-12 Darating al on the achment	00, 240V 15, 440V 0: GMD-0108000 : 063000 (* Select plate opens inter machine. The m	× 2 tion part	Feature S instead of the statement of th	tube conr	nector.)
Model Chain- T041 T045 T052 Chain- MC-4 Air reg Air reg Air reg Air reg S169 S170 Gather S169 S170 Guide, H153 H154	ICES AND A Part No. off thread trimm MAT-041000AC MAT-045000AA MAT-052001A0 MAT-052002A0 off thread suctio ulator (option) ulator (F.R. unit asm onnector (male) Par ing device MAS-169000A0 MAS-170000A0 Ruler MAH-153000A0 MAH-154000A0	ATTACHM ing device Pneumatic flat Pneumatic side One-touch typ trimming device n device Pneumatic chai) Part No.: PF-05 t No.: F1021-003 Swing-type gai (interlocked wi Swing-type gai (interlocked wi Cloth edge gui	ENTS Desc cutter e cutter e tape cu- e (electr n-off three 52010-B -000 thering c thering c thering c thering c thering c thering c	itter and omagne ead suction 0 • Fixi • On levice edal for s levice edal for c (for over (for safet	I chain-c tic type, on devic ing screte-touch safety sti overlock lock) ty stitch)	ff thread e w for F.R. ur connector tch))	For 100 For 220 hit asm. Part No. The seg materia the atta), 115, 2), 380, 4 Part No : GAS-12 Darating al on the achment	00, 240V 15, 440V 0: GMD-0108000 063000 (* Select plate opens interi machine. The m t.	× 2 tion part	Feature Feature s instead of the s ith the foot peda ver is also mount	tube conr	nector.)
Model Chain-o T041 T045 T052 Chain-o MC-4 Air reg Air reg Tube c Gather S169 S170 Guide, H153	ICES AND A Part No. off thread trimm MAT-041000AC MAT-045000AA MAT-052001A0 MAT-052002A0 off thread suctio ulator (coption) ulator (F.R. unit asm onnector (male) Par ing device MAS-169000A0 MAS-170000A0 Ruler MAH-153000A0	ATTACHM ing device Pneumatic flat Pneumatic side One-touch typ trimming device n device Pneumatic chai) Part No.: PF-05 t No.: F1021-003 Swing-type gai (interlocked wi Swing-type gai (interlocked wi	ENTS Desc cutter e cutter e tape cu- e (electr n-off three 52010-B -000 thering c thering c thering c thering c thering c thering c	itter and omagne ead suction 0 • Fixi • On levice edal for s levice edal for c (for over (for safet	I chain-c tic type, on devic ing screte-touch safety sti overlock lock) ty stitch)	ff thread e w for F.R. ur connector tch))	For 100 For 220 Part No. The sep materia the atta A swing Blind st To be p	p, 115, 2 p, 115, 2 p, 380, 4 Part No carating al on the achment g type cl iitch her blaced or	200, 240V 15, 440V 20: GMD-0108000 : 20: 063000 (* Select plate opens interf machine. The m t. oth edge guide mming for knitted n the eye guard of	× 2 tion part locked w anual le	Feature Feature s instead of the the foot peda ver is also mount and knits	tube conr	nector.)
Model Chain-r T041 T045 T052 Chain-r MC-4 Air reg · Tube c Gather S169 S170 Guide, H153 H154 L121	ICES AND A Part No. off thread trimm MAT-041000AC MAT-045000AA MAT-052001A0 MAT-052002A0 off thread suctio ulator (option) ulator (F.R. unit asm. onnector (male) Par ing device MAS-169000A0 MAS-170000A0 Ruler MAH-153000A0 MAH-154000A0 MAL-121000A0 MAQ-148010A0	ATTACHIMI ing device Pneumatic flat Pneumatic side One-touch typ trimming device Pneumatic chai One-touch typ trimming device Pneumatic chai One-touch typ trimming device Pneumatic chai Swing-type gai (interlocked wi Swing-type gai (interlocked wi Cloth edge gui Blind stitch her	ENTS Desc cutter e cutter e tape cu- e (electr n-off three 52010-B -000 thering c thering c thering c thering c thering c thering c	itter and omagne ead suction 0 • Fixi • On levice edal for s levice edal for c (for over (for safet	I chain-c tic type, on devic ing screte-touch safety sti overlock lock) ty stitch)	ff thread e w for F.R. ur connector tch))	For 100 For 220 Part No. The sep materia the atta A swing Blind st To be p), 115, 2), 380, 4 Part No : GAS-12 Darating al on the achment	200, 240V 15, 440V 20: GMD-0108000 : 20: 063000 (* Select plate opens interf machine. The m t. oth edge guide mming for knitted n the eye guard of	× 2 tion part locked w anual le	Feature Feature s instead of the the foot peda ver is also mount and knits	tube conr	nector.) ble easy placement of a sy opening/closing of
Model Chain- T041 T045 T052 Chain- MC-4 Air reg • Tube c Gather S169 S170 Guide, H153 H154 L121 Q148	ICES AND A Part No. off thread trimm MAT-041000AC MAT-045000AA MAT-052001A0 MAT-052002A0 off thread suctio ulator (option) ulator (F.R. unit asm. onnector (male) Par ing device MAS-169000A0 MAS-170000A0 Ruler MAH-153000A0 MAH-154000A0 MAL-121000A0 MAQ-148010A0	ATTACHIMI ing device Pneumatic flat Pneumatic side One-touch typ trimming device Pneumatic chai One-touch typ trimming device Pneumatic chai One-touch typ trimming device Pneumatic chai Swing-type gai (interlocked wi Swing-type gai (interlocked wi Cloth edge gui Blind stitch her	ENTS Desc cutter e cutter e tape cuter e tape cuter e tape cuter cuter e tape cuter s22010-B 522010-B 522010-B 522010-B cuter the the policity cuter the policity cut	ead suction atter and comagne ead suction atter	I chain-c tic type, on devic ing screte-touch safety sti overlock lock) ty stitch)	ff thread e w for F.R. ur connector tch))	For 100 For 220 hit asm. Part No. The sep materia the atta A swing Blind st To be p width 7), 115, 2), 115, 2), 380, 4 Part No : GAS-12 Darating al on the achment g type cl itch her placed or 'mm or l	200, 240V 15, 440V 20: GMD-0108000 : 20: 063000 (* Select plate opens interf machine. The m t. oth edge guide mming for knitted n the eye guard of	× 2 tion part locked w hanual le	Feature Feature s instead of the the foot peda ver is also mount ad knits plate. It is desi	tube conr	nector.)
Model Chain- T041 T045 T052 Chain- MC-4 Air reg · Tube c Gather S169 S170 Guide, H153 H154 L121 Q148 Presset	ICES AND A Part No. off thread trimm MAT-041000AC MAT-041000AC MAT-052001A0 MAT-052002A0 off thread suctio ulator (option) ulator (coption) ulator (F.R. unit asm onnector (male) Par ing device MAS-169000A0 MAS-170000A0 Ruler MAH-153000A0 MAL-121000A0 MAQ-148010A0 rtot 124-66850	ATTACHIMI	ENTS Desc cutter e cutter e tape cuter e tape cuter e tape cuter cuter e tape cuter s22010-B 522010-B 522010-B 522010-B cuter the the policity cuter the policity cut	ead suction atter and comagne ead suction atter	I chain-c tic type, on devic ing screte-touch safety sti overlock lock) ty stitch)	ff thread e w for F.R. ur connector tch))	For 100 For 220 hit asm. Part No. The sep materia the atta A swing Blind st To be p width 7), 115, 2), 115, 2), 380, 4 Part No : GAS-12 Darating al on the achment g type cl itch her placed or 'mm or l	200, 240V 115, 440V 20.: GMD-0108000 : 2063000 (* Selec: plate opens interly machine. The m the opens interly oth edge guide nming for knitted n the eye guard of ess.	× 2 tion part locked w hanual le	Feature Feature s instead of the the foot peda ver is also mount ad knits plate. It is desi	tube conr	nector.)

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High-speed Overlock/Safety Stitch Machine

MO-3600 SERIES

- The maximum sewing speed of the MO-3600 series is 6,000rpm. It sufficiently responds to the need of apparel plants for high-speed sewing in terms of practical production.
- Extra high throw type of the upper looper has been adopted as standard. This greatly widens applicability of the machine ranging from light- to heavy-weight materials. The presser foot goes up as high as 7mm. The multi-layer portion of material can be smoothly fed under the presser foot and the material can be easily placed under it.



MO-3616

3

SPECIFICATIONS

Model name	MO-3604	MO-3614	MO-3616
Stitch type	1-needle overlock	2-needle overlock	Safety stitching
Stitch style in the U.S.A.	504	514	516
Max. sewing speed		6,000rpm	
Stitch length	0.8 ~ 4	łmm	1.5 ~ 4mm
Needle gauge (mm)		2, 2.4	2, 3.2, 4.8
Overedging width (mm)	1.6, 3.2, 4, 4.8, 5.6, 6.4	3.2, 4	3.2, 4, 4.8, 6.4
Differential-feed ratio		For gathering 1:2, For stretching 1:0.7	
Needle bar stroke		24.5mm	
Inclination angle of the needle		20°	
Needle		DC × 27, For JE: B-27	
Max. lift of the presser foot		7mm	
Max. presser foot pressure		58.8N (6kg)	
Stitch length adjusting method		By push-button	
Differential-feed adjusting method		By lever	
Weight of the machine head		24kg	
Lubrication		Automatic	
Lubricating oil	JUKI I	New Defrix Oil No.2 (equivalent to ISO V	G32)
Needle cooler	Optional	By silicon oil lubricating unit for the ne	edle tip
Needle thread heat remover	Optional: B	y silicon oil lubricating unit for the need	lle thread

SU	BCLASS MACH	NE LI	ST							L = Light	light-weight materi weight materials um-weight material	EH =	E Heavy-weight materials Extra heavy-weight materials
Seams	Model No.	Katerials	Number of needles	Sumber of threads	⊢ Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	Max. stitch length (mm)	Bottom differential- feed ratio	Presser lifting amount (mm)	Needle system	Max. sewing speed (rpm)	Remarks
	edle overlock unstitching in general	fabric				For the machine (), the numb width is two or	er of kind		dging { B – 2.0m		2mm G – 5.6mm 0mm H – 6.4mm 8mm		tal overedging wigth: e gauge + Overedging width
	MO-3604E-0F6-300	L~M	1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	
	MO-3604E-0G4-300	L~M	1	3	-	5.6	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	
	MO-3604E-0E6-40H	L~H	1	3	-	4.0	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	Upper looper
\square	MO-3604E-0E4-40K/F	L~H	1	3	-	4.0	2	4	1:0.7 ~ 1:2	5.5	DC × 27 #11	6,000	extra high throw type
	MO-3604B-0E4-40H/F	L~H	1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	Upper looper extra high throw type/ For soft-chains
	MO-3604E-0 4-40H/F	L~H	1	3	-	4.0, 4.8, 6.4	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	Upper looper
	MO-3604E-0 6-50H/F	М~Н	1	3	-	4.8, 6.4	3	4	1:0.7 ~ 1:2	7	DC × 27 #14	6,000	extra high throw type
• For b	lind hemming L121	: Blind stit	tch hemr	ning atta	achment								
	MO-3605E-0E4-41H/F /L121	L~M	1	3	-	4.0	2	4	1:0.7 ~ 1:2	5.5	DC × 27 #9	6,000	Upper looper
	MO-3605E-0E4-210 /L121	L~M	1	3	-	4.0	2	4	1:0.7 ~ 1:2	5.5	DC × 27 #9	6,000	extra high throw type
• For ro	olled hemming (folded	l downw	ard)										
	MO-3604E-0A4-150	51 1	1	3	-	1.6	2	4	1:0.7 ~ 1:2	5	DC × 1 #8	6,000	
$ \mathfrak{S} $	MO-3604E-0A5-150/F	EL~L	1	3	-	1.6	1	4	1:0.7 ~ 1:2	5	DC × 1 #8	6,000	
• For b	acklach Z173: Backla	ch device											
Ŝ	MO-3604B-0E4-40H/F /Z173	L~H	1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	Upper looper extra high throw type/ For soft-chains

\mathbf{i}				ļ	الله الله		IM-	******	, Ţ	õõ	1			Remarks
	edle overloc unstitching in g		abric											
6	MO-3612E-CE4-4	40H	L~H	2	4	2.4	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	
S	MO-3612E-0 6	-40H	L~H	2	4	2.4	3.2, 4.0	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	-
	MO-3614E-B 6	-20H	L~M	2	4	2.0	4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	
	MO-3614E-BE4-4	40H/F	L~M	2	4	2.0	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	Upper looper extra high throw type
Ø	MO-3614E-DE4-2	20H	L~H	2	4	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	-
	MO-3614E-BE6-4	40H/F	L~H	2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	-
For ta	ape attaching	G39: T	ape attac	hing pre	esser foo	t Q1	41: Tape guid	le			1	1	1	1
\mathbf{i}	MO-3614E-BE6-4 /G39/Q141	44H	M ~ H	2	4	2.0	4.0	3	3.2	1:0.7 ~ 1:2	7	DC × 27 #14	6,000	Upper looper extra high throw type
	ety stitching unstitching in g	eneral f	abric											
	MO-3616E-BE4-4	0H/F	L~H	2	5	2.0	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	
	MO-3616E-D 4-	40H/F	L~H	2	5	3.2	4.0, 4.8	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	-
	MO-3616E-D 6-	40H/F	L~H	2	5	3.2	4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	Upper looper extra high throw type
S	MO-3616E-FF6-4	0H/F	L~H	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	
~~~	MO-3616E-F 6-	50H/F	M~H	2	5	4.8	4.8, 6.4	3	4	1:0.7 ~ 1:2	7	DC × 27 #16	6,000	
	MO-3616E-FF6-5 /G32	0H/F	M~H	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #16	6,000	Upper looper extra high thro type (with tractor presser for
	MO-3616E-F 6-0	50H/F	H~EH	2	5	4.8	4.8, 6.4	3	4	1:0.7 ~ 1:2	6	DC × 27 #21	6,000	Upper looper extra high throw type (for jeans)
	eedle safety s nulti-purpose ru MO-3643E-FBD6 /F	nstitch	-	3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	Upper looper extra high throw type
(Note	HEN YOU P e) Some combinati				1									
Needle (mi	gauge n) Code	Overedo	ging mm) Co		For ovtr	light t	Material	t matoria	lc	Code		oplication stitching	Code 0	Special machine Cod Standard 0
1-nee	edle 0	1.6	A		For light	- to	b light-weigh Training w			2		id hemming	1	Upper looper
1. 2.		2.0	B		medium material		Standard (for dress	skirts to s	sport we	ar) 3	For gat For pip		23	extra high H throw type
2. 3.		3.2 4.0	E		For med heavy-w		Knit sweat Standard	er, bulky	/ etc.	4		aching tape	4	
3 4.i		4.0	F		material	s	(general fa	abrics, je	ans etc.)	5	For bin For bin	ding ding tape	5	
4.		5.6 6.4	G	,	For extra weight r		Jeans etc.			6		ing & gathering	B	
2.0 +		0.4	Ţ	•								J		
3.2 +														
					oclass Co			Ĺ						
		N	10-2	361	4 E	-BE	E <u>6</u> -44	H/[F	- /G	39/Q1	41/	T039		
	_	Mod	del No. Co	ode 🗌	 	-			T		Ţ			
<u></u>			•											
Stitch	type in the U.S.A. 503	Code 03		ificatio			ed dog Coo 1-row 5		Classifica		uges Parts	Sym		Device & attachment
	504	04	Gene Soft o	eral spec chain	E B		2-row 4		Jpper kn			K		
	505 512	05					3-row 6			Flat kni		are knife W	_	

gauge Feed dog Presser foot Looper * No code is to be given to the standard square knife. Specify the knife code, "F" or "W" only when a knife other than the standard one is required.

Replacement

Corrugated square knife

Throat plate

W

E01~

F01~

G01~

H01~

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512

514

515

516

3-needle safety stitch

2-needle double chain stitch

High-speed Overlock / Safety Stitch Machine

# **MO-3700 SERIES**

- The machine has improved the feed efficiency, with the ability to feed the material straight and securely. The machine allows the operator to handle the material easily and ensures a consistent thread tension even when running at the max. sewing speed of 7,000rpm. This means that the machine has a higher degree of productivity.
- The machine head has been designed so that the simple shape and mechanism provide an expanded and brighter space around the needle entry point. Furthermore, the machine uses high-precision parts, while the machine weight is reduced and the pressure of the presser foot is decreased. As a result, the machine can smoothly feed a soft and delicate material, prevents the material from flapping, and stops the presser foot from jumping.



MO-3716

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## SPECIFICATIONS

Model name	MO-3704	MO-3714	MO-3716									
Stitch type	1-needle overlock	2-needle overlock	Safety stitching									
Stitch style in the U.S.A.	504	514	516									
Max. sewing speed		7,000rpm										
Stitch length	0.8 ~ (for special type machine, stitch le		1.5 ~ 4 (5)mm									
Needle gauge (mm)		2, 2.4, 3.2	3.2, 4.8									
Overedging width (mm)	1.6, 2, 3.2, 4, 4.8, 5.6, 6.4	3.2, 4, 4.8	3.2, 4, 4.8, 5.6, 6.4									
Differential-feed ratio	For gatheri	ng 1: 2 (max. 1: 4), For stretching 1: 0.7 (	max. 1: 0.6)									
Needle bar stroke		24.5mm										
Inclination angle of the needle		24.31111 20°										
Needle		DC × 27, For JE: B-27										
Max. lift of the presser foot		7mm										
Max. presser foot pressure		58.8N (6kg)										
Stitch length adjusting method		By push-button										
Differential-feed adjusting method		By lever										
Weight of the machine head		26kg										
Lubrication		Automatic										
Lubricating oil	JUKI	New Defrix Oil No.2 (equivalent to ISO V	G32)									
Needle cooler	Optional: By silicon oil lubricating unit for the needle tip											
Needle thread heat remover	Optional: E	By silicon oil lubricating unit for the need	dle thread									

SU	BCLASS MACH	NE LI	ST						*	L = Light	light-weight materi weight materials um-weight material	EH =	Heavy-weight materials Extra heavy-weight materials
Seams	Model No.	Katerials	of	S Number of threads	H ⊢ Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	(mm)	Bottom differential- feed ratio	Presser lifting amount (mm)	V Needle system	Max. sewing speed (rpm)	Remarks
	edle overlock unstitching in general	fabric			•	For the machin (), the numb width is two or	per of kind		edging ∤ B – 2.0		8.2mm G – 5.6mm .0mm H – 6.4mm .8mm		otal overedging wigth: lle gauge + Overedging width
	MO-3703E-0E4-300		1	2	-	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	For serging
	MO-3704E-0D4-306	L~M	1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3704E-0 4-300		1	3	-	3.2, 4.0, 4.8, 5.6	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3704E-0 6-300		1	3	-	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3704E-0 6-500	м~н	1	3	-	4.8, 5.6, 6.4	3	4	1:0.7 ~ 1:2	7	DC × 27 #14	7,000	
	MO-3704E-0F6-50H	м~н	1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #14	7,000	Upper looper extra high throw type
	MO-3704B-0 4-300		1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3704B-0D6-300	L~M	1	3	-	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	For soft-chains
	MO-3704B-0D4-306		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3704E-0E4-40K/F	]	1	3	-	4.0	2	4	1:0.7 ~ 1:2	5.5	DC × 27 #11	7,000	Upper looper extra high throw type (For JHK)

S		L > H		Ľ		IЩ ⁻	******	_][_	io.	Ţ	,V	0	Remarks
For b		1: Blind stit	ch hem	ming att	achmen	t L122: Blir	nd stitch	hemmin	g attachment (	with aut	omatic folder ed	ge contro	lled hemming device)
Ð	MO-3705E-0 4-210 /L121, L122	L ~ M	1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	5.5	DC × 27 #9	7,000	
For ro	olled hemming (folded	d downw	ard)		-								
	MO-3704E-0 5-150		1	3	-	1.6, 2.0	1	4	1:0.7 ~ 1:2	5	DC × 27 #8	7,000	
S	MO-3704E-0 4-150	EL~L	1	3	-	1.6, 2.0	2	4	1:0.7 ~ 1:2	5	DC × 27 #8	7,000	
	MO-3704E-0 5-156		1	3	-	1.6	1	4	1:0.7 ~ 1:2	5	DC × 27 #8	7,000	
For B	acklach Z173: Backla	ich attachr	ment				-			-			
	MO-3704B-0E4-300 /Z173		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
S	MO-3704B-0E4-40H /Z173	L~M	1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	For soft-chains
	MO-3704S-0D4-300 /Z173		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
For g	athering S160: Swin	g-type gat	hering c	device (ir	nterlocke	ed with pedal)	S16	2: Swing	-type gathering	g device	(manual-lever o	perated)	
S	MO-3704E-0F6-320 /S160, S162	L ~ M	1	3	-	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	
For p	· · ·								-made piping for made to order		L	I	l
S	MO-3704E-0F6-330 /M075, M076	L~M	1	3	-	4.8	3	4	1:0.7 ~ 1:2	5	DC × 27 #11	7,000	
For ta		Tape attac	hing pre	esser foo	t 01	I 41: Tape guic	le.			I	I		
Ś	MO-3704E-0F6-340	L~M	1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
4	/G40/Q141												
	edle overlock unstitching in general	fabric											
	MO-3714E-B 4-307		2	4	2.0	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3714E-B 6-307	L~M	2	4	2.0	3.2, 4.0	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3714E-BF6-20H		2	4	2.0	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
S	MO-3714E-B 6-40H		2	4	2.0	4, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	-
	MO-3714E-C 6-40H	м~н	2	4	2.4	4, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	-
	MO-3712E-CD6-40H		2	4	2.4	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3712E-DF6-507		2	4	3.2	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #14	7,000	Upper looper extra high throw type
For g	athering S160: Swin	g-type gat	hering o	device (ir	nterlocke	ed with pedal)	S16	2: Swing	-type gathering	g device	(manual-lever oj	perated)	
Ś	MO-3714E-B 6-327 /S160, S162	L~M	2	4	2.0	4.0, 4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	
For p Diame	iping M075: Piping for ter of gimp: To use a gimp							,	-made piping for made to order				
Ś	MO-3714E-BE6-337 /M075, M076	L ~ M	2	4	2.0	4.0	3	3.2	1:0.7 ~ 1:2	5	DC × 27 #11	7,000	
For ta		G02, G20:	Tape at	taching	Dresser f	foot 014	1: Tape g	uide		•		•	•
	MO-3714E-B 6-347 /G39/Q141	L~M	2	4	2.0	3.2, 4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #11	7,000	
	MO-3714E-BE6-44H/F /G39/Q141		2	4	2.0	4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #14	7,000	
	MO-3714E-BE7-44H/F /G02/Q141	М~Н	2	4	2.0	4.0	4	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #14	7,000	Upper looper extra high throw type
	MO-3714E-CE7-44H /G39/Q141		2	4	2.4	4.0	4	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #14	7,000	
	MO-3714E-BE6-40K/F /G20/Q141	- L~H	2	4	2.0	4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #11	7,000	Upper looper extra hig
	MO-3714E-BE6-40K/F	<b>-</b>	2	4	2.0	4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #11	7,000	throw type (For JHK)

	_ <b>(</b> ) Remarks
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Safety stitching
 For runstitching in general fabric

	institching in general	Tablic				_				_		_	-
	MO-3715E-DE4-300		2	4	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3716E-BD4-300		2	4	2	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3716E-D 4-300	1	2	5	3.2	3.2, 4.0, 4.8	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3716E-D 6-300	L~M	2	5	3.2	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3716E-F 4-300		2	5	4.8	4.8, 5.6	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3716E-FF6-300		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3716E-D 6-500		2	5	3.2	3.2, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #16	7,000	
	MO-3716E-FF6-500	1	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #16	7,000	
	MO-3716E-FF6-50H	м∼н	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #16	7,000	Upper looper
	MO-3716E-RH6-50H		2	5	6.8	6.4	3	4	1:0.7 ~ 1:2	7	DC × 27 #16	7,000	extra high throw type
	MO-3716B-D 4-300		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	For soft-chains
	MO-3716E-DE4-40K/F	L~M	2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	Upper looper extra high
	MO-3716E-FF6-50K/F /F26/G09	М~Н	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	6	DC × 27 #16	7,000	throw type (For JHK)
• For n	ewly-developed synth	etic fabr	ic										
	MO-3716E-D 4-30N	L~M	2	5	3.2	3.2, 4.0, 4.6	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
• For je	eans												
	MO-3716E-FF6-50H /F26/G32		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	5	DC × 27 #16	7,000	Upper looper
	MO-3716E-FH6-60H	н∼ен	2	5	4.8	6.4	3	4	1:0.7 ~ 1:2	5	DC × 27 #21	6,500	extra high throw type
	MO-3716E-FH6-60K/F		2	5	4.8	6.4	3	4.5	1:0.6 ~ 1:1.7	5	DC × 27 #21	6,500	Upper looper extra high throw type (For JHK)
• For g	athering S159: Swin	g-type gat	hering d	levice (ir	iterlocke	d with pedal)	S16	1: Swing	-type gathering	g device	(manual-lever o	perated)	
	MO-3716E-DE4-320 /S159, S161		2	5	3.2	4.0	2	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	
	MO-3716E-DF6-320 /S159, S161		2	5	3.2	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	
	MO-3716E-FF6-320 /S159, S161	L~M	2	5	4.8	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	
	MO-3716E-FF6-42H /S159, S161		2	5	4.8	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #14	7,000	Upper looper extra high throw type
• For p		older (to be	ecommo	only used	d with kr	nit materials)	M07	6: Ready	-made piping fo	older		1	1
Diame	ter of gimp: To use a gimp MO-3716E-DE4-330	whose dia		ľ –				I					
	/M075, M076 M0-3716E-FF6-330	L~M	2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	5	DC × 27 #11	7,000	
Ľ	/M075, M076		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	5	DC × 27 #14	7,000	
• For p	1 3 3 3	M077: Pipi	ng folde	r for gatl	hering							1	
	MO-3716E-DD4-3B0 /S159/M077	L ~ M	2	5	3.2	3.2	2	3.2	1:0.9 ~ 1:2.6	5	DC × 27 #11	7,000	
• For r	<u> </u>	Binder for	attachi	ng reinfo	orcemen	t tape		1					I
	MO-3716E-DD4-360 /N067	L~M	2	5	3.2	3.2	2	4	1:0.7 ~ 1:2	6.5	DC × 27 #11	7,000	
	MO-3745E-DD4-360 /N077		2	5	3.2	3.2	2	4	1:0.7 ~ 1:1	5	DC × 27 #11	7,000	For binding periphery
	edle safety stitch			-									
For re	Institching in general MO-3743E-DBD6-307	Tabric	Q141: 3	Tape gu	3.2	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3743E-EBD6-307	L~M	3	6	+2.0 4.8	3.2	3	4	1:0.7~1:2	7	DC × 27 #11	7,000	
	MO-3743E-FBD6-307 MO-3743E-FBD6-347		3		+2.0 4.8		3			7		7,000	
	/G07/Q141		3	6	+2.0	3.2	3	4	1:0.7 ~ 1:2	/	DC × 27 #11	7,000	

+2.0 4.8 +2.0

3.2

3

4

1:0.7 ~ 1:2

7

DC × 27 #16

7,000

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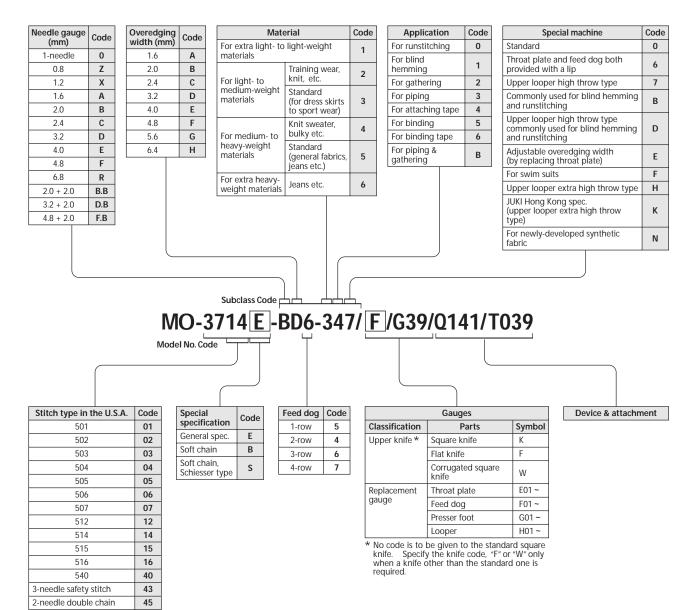
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MO-3743E-FBD6-50H

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## WHEN YOU PLACE ORDERS

(Note) Some combinations are not available.



Super-high-speed Overlock / Safety Stitch Machine

# MO-3900 SERIES

- The maximum sewing speed of the MO-3900 series is 9,000rpm. The machine can run continuously at a maximum sewing speed of 8,000rpm when serging. Naturally, the machine always finishes uniform seams when sewing a light-weight material at high speed, thereby leading to higher productivity.
- The MO-3900 series are equipped with a light presser foot mechanism and an improved feed mechanism so as to prevent the presser foot from jumping and to reduce the pressure of the presser foot. Thereby the material can not become damaged by the presser foot and feed dog during a sewing operation. These mechanisms, together with the block-type feed cam and the throat plate support which reduces the vibration of the throat plate, enable the machine to feed the material smoothly and consistently free from material flapping even at high speed.

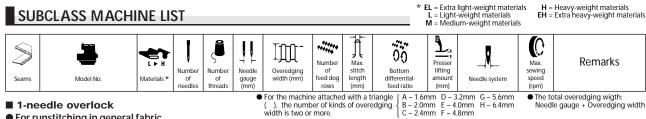


MO-3916

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## **SPECIFICATIONS**

Model name	MO-3904	MO-3914	MO-3916
Stitch type	1-needle overlock	2-needle overlock	Safety stitching
Stitch style in the U.S.A.	504	514	516
Max. sewing speed	9,000	)rpm	8,000rpm
Stitch length	0.8 ~ 4 (for special type machine, stitch le		1.5 ~ 4 (5)mm
Needle gauge (mm)		1.2, 1.6, 2, 2.4, 3.2	1.6, 2, 2.4, 3.2, 4.8, 6.8
Overedging width (mm)	1.6, 2, 3.2, 4, 4.8, 5.6, 6.4, 8	2, 3.2, 4, 4.8	3.2, 4, 4.8, 5.6, 6.4
Differential-feed ratio	For gatheri	ng 1: 2 (max. 1: 4), For stretching 1: 0.7 (	(max. 1: 0.6)
Needle bar stroke		24.5mm	
Inclination angle of the needle		20°	
Needle		DC × 27, For JE: B-27	
Max. lift of the presser foot		7mm	
Max. presser foot pressure		58.8N (6kg)	
Stitch length adjusting method		By push-button	
Differential-feed adjusting method		By lever (with micro-adjustment)	
Weight of the machine head		28kg	
Lubrication		Automatic	
Lubricating oil	JUKI	New Defrix Oil No.2 (equivalent to ISO V	/G32)
Needle cooler	Provided as sta	ndard: By silicon oil lubricating unit for	the needle tip
Needle thread heat remover	Provided as stand	dard: By silicon oil lubricating unit for th	ne needle thread



For runstitching in general fabric

FORT														
	MO-3903E-0E4-300		1	2	-	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,500	For serging	
	MO-3904E-0D4-306		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	9,000		
	MO-3904E-0 4-300	L~M	1	3	-	3.2, 4.0, 4.8, 5.6	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	9,000		
	MO-3904E-0 6-300		1	3	-	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	9,000		
	MO-3904E-0 6-500	M~H	1	3	-	4.8, 5.6, 6.4	3	4	1:0.7 ~ 1:2	7	DC × 27 #14	8,000		
	MO-3904E-0H6-50H	L~M	1	3	-	6.4	3	5	1:0.6 ~ 1:1.6	5	DC × 27 #14	7,500	Upper looper	
- STATE	MO-3904E-0K6-50H	M~H	1	3	-	8.0	3	5	1:0.6 ~ 1:1.6	5	DC × 27 #16	7,500	extra high throw type	
	MO-3904B-0 4-300		1	3	-	3.2, 4.0, 4.8	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	9,000		
	MO-3904B-0 6-300		1	3	-	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	9,000	For soft-chains	
	MO-3904B-0D4-306	L~M	1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	9,000		
	MO-3904S-0D4-300		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	9,000		
	MO-3904E-0 4-40K/F		1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	5.5	DC × 27 #11	7,500	Upper looper extra high throw type	

S	4		ļ	ر <b>آ</b>		IIII-	******	Ĵ	00	Ţ			Remarks
	lind hemming L121 pring-type folded-edge co	: Blind stit		5		t L122: Blir	nd stitch	hemmir	ng attachment (	with aut	omatic folder ed	lge contro	olled hemming device)
X	MO-3903E-0 4-210 /L121, L122, L123		1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	5.5	DC × 27 #9	8,500	
S	MO3905E-0 4-210 /L121, L122, L123	L~M	1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #9	9,000	
• For ro	olled hemming (folded	l downw	ard)										
	MO-3904E-0 5-150		1	3	-	1.6, 2.0	1	4	1:0.7 ~ 1:2	5	DC × 27 #8	9,000	
$\mathbf{S}$	MO-3904E-0 4-150	EL ~ L	1	3	-	1.6, 2.0	2	4	1:0.7 ~ 1:2	5	DC × 27 #8	9,000	
	MO-3904E-0 5-156		1	3	-	1.6	1	4	1:0.7 ~ 1:2	5	DC × 27 #8	9,000	
• For Ba	acklach Z173: Backla	ch attachr	nent										
	MO-3904B-0 4-300 /Z173		1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	9,000	For off chains
	MO-3904B-0 6-300 /Z173	L~M	1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	9,000	For soft-chains
-	MO-3904S-0D4-300 /Z173		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	9,000	
• For ga	athering S160: Swing	g-type gat	hering d	levice (ir	nterlocke	d with pedal)	S16	2: Swing	-type gathering	device	(manual-lever op	erated)	
$\bigcirc$	MO-3904E-0 6-320 /S160, S162	L~M	1	3	-	4.0, 4.8	3	4	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	
• For pi Diamet	iping M075: Piping fo ter of gimp: To use a gimp	•		,		,		,	-made piping fo made to order				
$\mathbf{i}$	MO-3904E-0F6-330 /M075, M076	L~M	1	3	-	4.8	3	4	1:0.7 ~ 1:2	5	DC × 27 #11	7,000	
• For ga	athering and piping	M077: F	Piping fo	lder for	gatherin	g							
S	MO-3904E-0F6-3B0 /S160, S162/M077	L~M	1	3	-	4.8	3	3.2	1:0.9 ~ 1:2.6	5	DC × 27 #11	7,000	
• For ta	pe attaching G40:	Tape attac	hing pre	esser foo	t Q1	41: Tape guid	le					_	
	MO-3904E-0F6-340 /G40/Q141	L ~ M	1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-3904E-0F6-44H /G40/Q141	М~Н	1	3	-	4.8	3	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #14	7,000	For knits extra high throw type
• For u	pturn felling K006:	Upturn fell	ler										
	MO-3905E-0F5-3C0 /K006	L~M	1	3	-	4.8	1	4	1:0.7 ~ 1:2	6	DC × 27 #14	7,000	
	edle overlock Institching in general	fabric											
	MO-3914E-XB5-100	EL~L	2	4	1.2	2.0	1	4	1:0.7 ~ 1:2	5	DC × C47 #9	9,000	For sewing tip and crotch of panty hoses
	MO-3914E-AD4-307		2	4	1.6	3.2	2	4	1:0.7 ~ 1:2	6	DC × 3 #11	8,000	
	MO-3914E-B 4-307	L~M	2	4	2.0	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	Upper looper high throw type
	MO-3914E-B 6-307		2	4	2.0	3.2, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-3914E-B 6-40H		2	4	2.0	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #14	7,500	Upper looper
	MO-3914E-C 6-40H	NA	2	4	2.4	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #14	7,500	extra high throw type
	MO-3914E-DF6-50G	М∼Н	2	4	3.2	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #14	7,500	
	MO-3912E-D 6-507	]	2	4	3.2	3.2, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #14	7,500	For imitation safety-stitching
• For ga	athering S160: Swing	g-type gat	hering d	levice (ir	nterlocke	d with pedal)	S16	2: Swing	-type gathering	g device	(manual-lever op	perated)	
	MO-3914E-B 6-327 /S160, S162		2	4	2.0	3.2, 4.0, 4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	Upper looper
	MO-3912E-DF6-327 /S160, S162	L~M	2	4	3.2	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	high throw type
• For pi Diamet		-							-made piping for made to order				
<b>~</b>	MO-3914E-B 4-337 /M075, M076		2	4	2.0	3.2, 4.0	2	4	1:0.7 ~ 1:2	5	DC × 27 #11	7,000	Lipper loopor
	MO75, M078 MO-3914E-B 6-337 /M075, M076	L~M	2	4	2.0	3.2, 4.0	3	4	1:0.7 ~ 1:2	5	DC × 27 #11	7,000	Upper looper high throw type
•	athering and piping		Piping fo	lder for	gatherin	g.							

3

3.2

1:0.9 ~ 1:2.6

5

DC × 27 #11

Upper looper high throw type

7,000

MO-3900 SERIES (June, 2001) 2/6 Downloaded from <u>www.Manualslib.com</u> manuals search engine

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6

MO-3914E-BD6-3B7 /S160, S162/M077

L~M

2

4

2.0

3.2

			<b>I</b>	<u>_</u>			******	<u></u>	ŐŐ	Ţ	V	0	Remarks
For ta	ape attaching G39, MO-3914E-BD6-347	G02, G20:					I: Tape g						
	/G20/Q141	L~M	2	4	2.0	3.2	3	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #11	7,000	Upper looper high throw type
	MO-3914E-B 6-347 /G39/Q141		2	4	2.0	3.2, 4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #11	7,000	nigh throw type
	MO-3914E-B 6-44H /G39/Q141		2	4	2.0	3.2, 4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #14	7,000	
	MO-3914E-B 7-44H /G02/Q141	M~H	2	4	2.0	3.2, 4.0	4	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #14	7,000	
- Carlos	MO-3914E-CE7-44H /G02/Q141		2	4	2.4	4.0	4	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #14	7,000	Upper looper
	MO-3914E-B 6-40K/F /G20/Q141		2	4	2.0	3.2, 4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #14	7,500	extra high throw type
	MO-3914E-B 6-40K/F /G39/Q141	L~H	2	4	2.0	3.2, 4.0, 4.8	3	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #14	7,500	
	MO-3914E-BD6-44H /G20/Q141		2	4	2.0	3.2	3	3.2	1:0.9 ~ 1:2.6	7	DC × 27 #14	7,000	
	ety stitching unstitching in general	fabria											
FOLI	MO-3915E-DE4-300		2	4	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-3915E-FF6-300		2	4	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	8.000	
	MO-3916E-AE4-300		2	5	1.6	4.0	2	4	1:0.7 ~ 1:2	, 7	DC × 27 #11	8,000	
	MO-3916E-B 4-300		2	5	2.0	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-3916E-CE4-300		2	5	2.4	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-3916E-D 4-300	L~M	2	5	3.2	3.2, 4.0, 4.8	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-3916E-F 4-300		2	5	4.8	4.8, 5.6	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-3916E-D 6-300		2	5	3.2	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-3916E-FF6-300		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-3916E-R 6-30H		2	5	6.8	4.8, 6.4	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,500	Upper looper extra high throw type
	MO-3916E-D 6-500		2	5	3.2	3.2, 4.8, 6.4	3	4	1:0.7 ~ 1:2	7	DC × 27 #16	8,000	
$\sim$	MO-3916E-F 6-500		2	5	4.8	4.8, 6.4	3	4	1:0.7 ~ 1:2	7	DC × 27 #16	8,000	
THE REAL PROPERTY IN	MO-3916E-DF6-50H	м~н	2	5	3.2	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #16	7,500	
Ŧ	MO-3916E-FF6-50H		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #16	7,500	Upper looper extra high throw type
	MO-3916E-RH6-50H		2	5	6.8	6.4	3	4	1:0.7 ~ 1:2	7	DC × 27 #16	7,500	
	MO-3916E-FF6-50H /F26/G32	M~H	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	6	DC × 27 #16	7,500	For jeans
	MO-3916B-D 4-300		2	5	3.2	3.2, 4.0, 4.8	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-3916B-D 6-300		2	5	3.2	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	For soft-chains
	MO-3916B-FF6-300		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-3916E-D 4-300 /G12	L~M	2	5	3.2	3.2. 4.0	2	4	1:0.7 ~ 1:2	6	DC × 27 #11	8,000	For sewing sharp cur
	MO-3916E-FF6-300 /G13		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	6	DC × 27 #11	8,000	For sewing snarp cur
	MO-3916E-D 4-40K/F		2	5	3.2	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,500	Upper looper
	MO-3916E-FF6-50K/F /F26/G09	М~Н	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	6	DC × 27 #16	7,500	extra high throw type
	MO-3916E-F 6-60K/F	H ~ EH	2	5	4.8	4.8, 6.4	3	4.5	1:0.6 ~ 1:1.7	5	DC × 27 #21	7,000	Extra high throw type For jeans
For g	athering S159: Swin	g-type gatl	hering c	levice (ir	iterlocke	d with pedal)	S16	1: Swing	g-type gathering	g device	(manual-lever op	perated)	
	MO-3916E-D 4-320 /S159, S161		2	5	3.2	3.2, 4.0	2	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	
~	MO-3916E-DF6-320 /S159, S161		2	5	3.2	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	
M	MO-3916E-FF6-320 /S159, S161	L~M	2	5	4.8	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	
	MO-3916E-FF6-42H /S159, S161		2	5	4.8	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #14	7,000	Upper looper
	MO-3916E-RH6-42H /S159, S161		2	5	6.8	6.4	3	3.2	1:0.9 ~ 1:2.6	5	DC × 27 #14	7,000	extra high throw type

3

For piping M075: Piping folder (to be commonly used with knit materials) M076: Ready-made piping folder

Diame	ter of gimp: To use a gimp	whose dia	meter is	greater	than 2	to 2.5mm the	emachin	ie.					
	MO-3916E-D 4-330 /M075, M076	L~M	2	5	3.2	3.2, 4.0	2	4	1:0.7 ~ 1:2	5	DC × 27 #11	7,000	
STREET, ST	MO-3916E-FF6-330 /M075, M076		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	5	DC × 27 #11	7,000	
For gathering and piping M077: Piping folder for gathering.													
	MO-3916E-DD4-3B0 /S159, S161/M077	L~M	2	5	3.2	3.2	2	3.2	1:0.9 ~ 1:2.6	5	DC × 27 #11	7,000	
- Standard	MO-3916E-FF6-3B0 /S159, S161/M077		2	5	4.8	4.8	3	3.2	1:0.9 ~ 1:2.6	5	DC × 27 #11	7,000	
• For rolling-in tape N067D: Binder for attaching reinforcement tape													
	MO-3916E-DD4-360 /N067		2	5	3.2	3.2	2	4	1:0.7 ~ 1:2	6.5	DC × 27 #11	7,000	For rolling in
5	MO-3916E-FF6-360	]		-		1.0			107.10		D.0. 07. #44	7 000	reinforcement tapes

	MO-3916E-FF6-360 /N067D	L~M	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	6.5	DC × 27 #11	7,000	reinforcement tapes
- Same	MO-3945E-DD4-360 /N077	L~1V1	2	5	3.2	3.2	2	4	1:0.7 ~ 1:1	5	DC × 27 #11	7,000	2-needle type for double-
	MO-3945E-ED4-360 /N077		2	5	4.0	3.2	2	4	1:0.7 ~ 1:1	5	DC × 27 #11	7,000	chainstitch on pocket bags

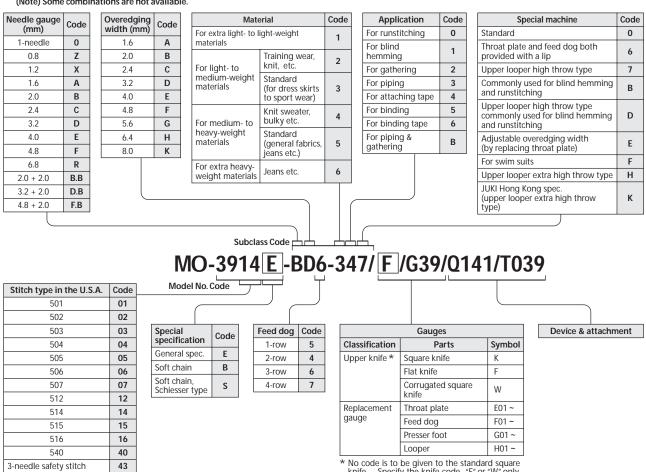
■ 3-needle safety stitching

• For runstitching in general fabric Q141: Tape guide

MO-3943E-DBD6-307		3	6	3.2 +2.0	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,500	Upper looper
MO-3943E-FBD6-307		3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,500	high throw type
MO-3943E-DBD6-347 /G06/Q141	L~M	3	6	3.2 +2.0	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,500	
MO-3943E-FBD6-347 /G07/Q141	L~IVI	3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,500	Combined use for attaching tapes
MO-3943E-DBD6-347 /G33/Q141		3	6	3.2 +2.0	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,500	
MO-3943-FBD6-327 /S159, S161		3	6	4.8 +2.0	3.2	3	3.2	1:0.9 ~ 1:2.6	6	DC × 27 #11	7,000	3-needle type for various applications

## WHEN YOU PLACE ORDERS

(Note) Some combinations are not available.



* No code is to be given to the standard square knife. Specify the knife code, "F" or "W" only when a knife other than the standard one is required.

45

2-needle double chain

stitch

## MO-3600, MO-3700 and MO-3900 SERIES

							Ap	plicati	on
Model	Part No.		Description			Feature	MO- 3600	MO- 3700	
Chain-	off thread trimmin	g device	,						
Taga	MAT-039001A0	One-to	uch type tape cutter and chain-off thread	For 11	0, 115,	220, 240V			
T039	MAT-039002A0	trimmir	ng device (electromagnetic type)	For 22	0, 380,	415, 440V			
	MAT-040001A0			For se	mi-	For 110, 115, 220, 240V			
	MAT-040002A0		atic tape cutter and chain-off thread trimming	sunke	n type	For 220, 380, 415, 440V			
T040	MAT-040001AA	device	er-off-stitch control and electromagnetic type)	For ful	lv-	For 110, 115, 220, 240V	-		
	MAT-040002AA			sunke	5	For 220, 380, 415, 440V	-		
T041	MAT-041000A0A	Pneum	atic flat cutter			1			
T042	MAT-042000A0	Pneum	atic side cutter						
T047	MAT-047000A0	-	atic flat cutter				-		
Blower	-type chain-off thr	1		1				1	
MC-7A			off thread and cloth chips)						
-		1.							
Chain-	off thread suction	device							
MC-4		Pneum	atic chain-off thread suction device (pedal type)						
MC-5		Pneum	atic chain-off thread suction device						
MC-8			atic chain-off thread suction device						
			off thread and cloth chips)				_		
MC-9		-	d with the function of MC-8 and an auto-lifter	-			_		
MC-24			atic chain-off thread suction device off thread and cloth chips)						
* The afore	ementioned devices ar	e not equ	ipped with an air regulator. Please purchase the	followin	g compo	pnents when you need to regulate air press	sure.		
	PF-0552010-B0	Air regu	ulator (F.R. unit asm.)						
	GMD-01080000 × 2	-	crew for F.R. unit asm.				-		
	F1021-003-000	-	onnector (male)						
	GAS-12063000 *		uch connector	* Sele	ection pa	arts instead of the tube connector	+		
Auto-li									
				1			_		
AK25	GAK-250000A0	-	magnetic type						
AK32	GAK-320000A0		atic type						
AK49	GAK-490000A0	-	atic type (operated by pedal)				_		
AK52	GAK-520000A0	-	atic type (with chain-off thread suction device)						
AK65	GAK-650000A0		magnetic type				_		
AK101	GAK-A01000A0	Pneum	atic type (for servomotor)						
[Refere	nce] Combination ta	able of "c	hain-off thread suction device" and "auto-lif	ter" wh	ich cor	respond to "chain-off thread trimming	g device	<i>"</i>	
	ff thread trimming	]	Chain-off thread suction device to which the cha	ain-off	Autolifte	r which can be attached to the chain-off th	nread su	ction de	evice
device			thread trimming device			ith an algoritania stan mater or AC sorrow	ator)		
	T039	1 '	MC-7A • MC-8			ith an electronic-stop motor or AC servom	otor)		
			MC-9		(IVIC-S	is equipped with an auto-lifter)			
		٦			AK22 (ar	ny motor (1) do)			
			MC-7A			ny motor will do)	atar		
	T040	+			-	ith an electronic-stop motor or AC servom	otor)		
		'	MC-5			ny motor will do)			
			MC-24	1	AK32 (ar	ny motor will do)			
		7							
	T041		*			ny motor will do)			
	or	+	MC-4			ith an electronic-stop motor or AC servom			
	T042	1	MC-7A • MC-8			ith an electronic-stop motor or AC servome	otor)		
	MC-9 * AK52 is equipped with a chain-off thread					is equipped with an auto-lifter)			
Garthe	* AK52 is equipped with a chain-off thread su Garthering device			JI DEVICE	<del>.</del>				
		Swing	type gathering device	Tho of	tachma	at anone with the process fact podel.			
S159	MAS-159000A0	Swing-type gathering device (interlocked with pedal/S159 is used with a safety				nt opens with the presser foot pedal. This erial setting on the machine. Furthermore			
		(interlocked with pedal/S159 is used with a safety s machine)				type differential-feed adjusting device is	-' L		
0	Swing-type gathering device					achment. It controls a differential-feed			
S160	MAS-160000A0	(interlo machin	cked with pedal/S160 is used with an overlock		is desire iful gath	d, thereby enabling the operator to make ers.			

The attachment is used to perform two different

using the lever (manually operated).

processes, joining fabric process and gathering process,

The differential-feed ratio is controlled with the knee lever

at a time. The attachment can be opened/closed by

MAS-161000A0

MAS-162000A0

S161

S162

machine)

Swing-type gathering device

Swing-type gathering device

(lever-operated/S161 is used with a safety stitch machine)

(lever-operated/S162 is used with an overlock machine)

3

					Ap	plicati	ion
Model	Part No.	Description		MO- 3600	MO- 3700		
Blind h	emming device						
L121	MAL-121000A0	Blind stitch hemming attachment	A ruler used fo	r blind hemming in knits			
	MAL-122001A0	Automatic folded-edge controlled blind hemming device	Flat upper	For 110, 115, 220, 240V			
L122	MAL-122002A0	(The attachment automatically detects the overlapped	knife	For 220, 380, 415, 440V			
	MAL-122001AA	section of a material. Then, it makes the needle enter the	Square upper	For 110, 115, 220, 240V			
	MAL-122002AA	material deeper to prevent stitch deviation.)	knife	For 220, 380, 415, 440V			
L123	MAL-123000A0	Spring-type folded-edge controlled bottom hemming device		lapped section of a material is reached, ming guide will move sufficiently to deviation.			

#### • Piping folder

•					
M056	MAM-0560J0A0	Piping folder	This piping folder makes a piping first, then turns up the tape.		
M075	MAM-0750J0A0	Piping folder (to be used with knit tape)	This attachment can be used for both "cotton bias tape with gimp" and "knit tape". The operation mode can be changed over with a fingertip control.		
M076	MAM-0760N0A0	Ready-made piping folder	The dimension of ready-made tapes can be adjusted within the range of 8 to 13mm.		
M077	MAM-0770M0A0	Piping folder for shirring	The attachment makes gathers on the lower fabric while making decorative piping.		

#### • Guide, Ruller

H153	MAH-153000A0	Cloth edge guide ruler (for overlock machine)	A swing type edge guide		
H154	MAH-154000A0	Cloth edge guide ruler (for safety stitch machine)	A swing type eage guide		
Q141	MAQ-141000B0	Tape guide	This attachment is used attached on the machine head (face plate). It is used for tapes with the width of 7mm or less		
S084D	MAS-084000AD	Pattern guide	This attachment is used for overedging a sleeve bottom placket with a sharp curve. It enables the machine to smoothly sew the curved section of a sleeve bottom placket along with the guide pin of the presser foot.		

#### • Feller, Binder

K006	MAK-00601000	Upturn feller	This feller is exclusively used with the 3C0 throat plate. It is attached on the throat plate.		
N067	MAN-0670D0A0	Reinforcement tape attachment binder	This binder binds the edge of a pocket bag while cutting round its periphery.		
N077	MAN-077000A0	Clean finish top and bottom	This binder runstitches a pocket bag and binding its periphery with tape simultaneously.		

#### Miscellaneous

Z173	MAZ-173000A0	MAZ-173000A0 Backlach device (for 1-needle overlock machine )		It sews chain-off thread at the start of sewing inside overedged seam. With this device, the operator is no longer required to neatly arrange the chain-off thread. Rolled-in chain-off thread also works as a simplified bartack.		
Z175	MAZ-175000A0	Needle thread tension relea (for 1-needle overlock mach releasing device)		When making chain-off thread, the attachment reduces the needle thread tension to make soft-chains. It is used in combination with the Z173.		
	118-55954	54 Needle cooler (for overlock machine				
	118-56051	Needle cooler (for safety stit	ch machine)			
	121-47203	Cloth waste cover (for overla	ock machine)			
	121-47302	Cloth waste cover (for overlock machine, overe	dging width 8mm over)	Needle cooler		s
	121-03305	SS-7091410SP	121-02950	By silicon oil lubricating unit for the needle tip.		
	121-03511	SS-6111440SP 121-03107				
	118-02402	NS-6110420SP	118-02006			
	SS-7110710SP × 2	121-02810				
	121-38400	121-38301	SM-4040855SP	Nedle thread heat remover		S
	121-38152	TA-0950806R0		By silicon oil lubricating unit for the needle thread.		5

S: Provided as standard

Cloth p	ouller		S: 1	Provide	d as sta	andard
V058A			For table top type			
V058B		Electromagnetic cloth puller (top and bottom roller type)	For semi-sunken type			
V058C			For fully-sunken type			
V068A		Pneumatic cloth puller (top and bottom roller type)	For table top type			
V068C			For fully-sunken type			

High-speed, Variable Top-feed, Overlock/Safety Stitch Machine

# **MOR-3900 SERIES**

- Many different kinds of subclass models have been prepared for materials with different thickness each of which has the presser foot pressure and the height and vertical stroke of the top-feed dog optimally set in accordance with the intended material thickness. The machine also adopts a newly developed feed mechanism that provides a larger area where the locus of movement of the top-feed dog horizontally synchronizes the bottom-feed dog, thus achieving the secure feed of the material without damaging it. The feed mechanism softly holds light-weight materials and securely catches heavy-weight materials for smooth feeding.
- By setting the fulcrum position of the locus of the top-feed near you, the rake-in always starts at a constant position and the force to catch the material is increased. This feed mechanism demonstrates its performance when feeding heavy-weight materials such as jeans. The machine for ruffling is capable of making beautiful and uniform ruffles.

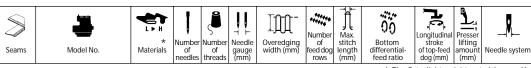


MOR-3914

## SPECIFICATIONS

Model name	MOR-3904	MOR-3914	MOR-3916
Stitch type	1-needle, 3-thread variable top-feed overlock	2-needle, 4-thread variable top-feed overlock	2-needle, 5-thread variable top-feed safety stitch
Stitch style in the U.S.A.	504	516	
Feed system		Variable top-feed (rake-in type)	
Max assistanced	Longitud	inal stroke of top-feed is 6mm or less:	7,000rpm
Max. sewing speed	Longitudin	al stroke of top-feed is 6mm to 8.5mm	n: 6,000rpm
Stitch length	0.8 ~ / (for special type machine, stitch le	4mm ength as long as 5mm is available)	1.5 ~ 4 (5)mm
Needle gauge (mm)		2, 2.4	2, 3.2, 4.8, 6.8
Overedging width (mm)	3.2, 4, 4.8, 5.6, 6.4	3.2, 4, 4.8	3.2, 4, 4.8, 6.4
Bottom differential-feed ratio	For gatheri	ng 1:2 (max. 1:4), For stretching 1:0.7	(max. 1: 0.6)
Needle bar stroke		24.5mm	
Inclination angle of the needle		20°	
Needle		DC × 27, For JE: B-27	
Vertical stroke of top-feed dog		3.5 ~ 8.5mm	
Longitudinal stroke of top-feed dog		1 ~ 8.5mm	
Max. lift of the presser foot	7mm	6.5mm	7mm
Max. presser foot pressure		58.8N (6kg)	
Stitch length adjusting method		By push-button	
Differential-feed adjusting method		By lever (with micro-adjustment)	
Weight of the machine head		30kg	
Lubrication		Automatic	
Lubricating oil	JUKI M	New Defrix Oil No.2 (equivalent to ISO	VG32)
Needle cooler	Provided as sta	ndard: By silicon oil lubricating unit fo	or the needle tip
Needle thread heat remover	Provided as stand	lard: By silicon oil lubricating unit for t	the needle thread

3



Max. sewing speed (rpm)

* EL = Extra light-weight materials L = Light-weight materials M = Medium-weight materials

H = Heavy-weight materials EH = Extra heavy-weight materials

Remarks

#### ■ 1-needle overlock • For runstitching in general fabric

institching in gener													
MOR-3904E-0D4-300		1	3	-	3.2	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	
MOR-3904E-0E4-300		1	3	-	4.0	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	
MOR-3904E-0F4-300		1	3	-	4.8	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	
MOR-3904B-0D4-306	L~M	1	3	_	3.2	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	For soft-chains
MOR-3904E-0D6-300		1	3	_	3.2	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	
MOR-3904E-0E6-300		1	3	-	4.0	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	
MOR-3904E-0F6-300		1	3	-	4.8	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #11	7,000	
MOR-3904E-0F6-500		1	3	-	4.8	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #14	7,000	
MOR-3904E-0G6-500	M∼H	1	3	-	5.6	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #14	7,000	
MOR-3904E-0H6-500	IVI ~ <b>N</b>	1	3	-	6.4	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #14	7,000	
MOR-3904E-0H4-50M		1	3	-	6.4	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #14	7,000	For zipper attaching

#### For blind hemming

*L121: Blind stitch hemming attachment *L122: Blind stitch hemming attachment (with automatic preventer of stitch deviation)

MOR-3905E-0D4-210 /L121		1	3	_	3.2	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #9	7,000
MOR-3905E-0E4-210 /L121	L~M	1	3	-	4.0	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #9	7,000
MOR-3905E-0D4-210 /L122	L ~ IVI	1	3	-	3.2	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #9	7,000
MOR-3905E-0E4-210 /L122		1	3	-	4.0	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #9	7,000

#### • For upper-cloth gathering

★S167: Swing-type upper-cloth gathering device (knee-operated)

MOR-3904E-0E6-320 /S167	L~M	1	3	_	4.0	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	6,000	
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#### 2-needle overlock

• For runstitching in general fabric

MOR-3914E-BD4-307		2	4	2.0	3.2	2	4	1:0.7 ~ 1:2	1~7.5	6.5	DC × 27 #11	7,000	
MOR-3914E-BE4-307		2	4	2.0	4.0	2	4	1:0.7 ~ 1:2	1~7.5	6.5	DC × 27 #11	7,000	
MOR-3914E-BD6-307	L~M	2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC × 27 #11	7,000	
MOR-3914E-BE6-307		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC × 27 #11	7,000	
MOR-3914E-BD6-40H		2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC × 27 #11	7,000	
MOR-3914E-BE6-40H	М~Н	2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC × 27 #11	7,000	Upper looper extra high
MOR-3914E-BF6-40H	IVI ~ <b>H</b>	2	4	2.0	4.8	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC × 27 #11	7,000	throw type
MOR-3914E-CE6-40H		2	4	2.4	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC × 27 #11	7,000	

#### • For upper-cloth gathering

★S167: Swing-type upper-cloth gathering device (knee-operated)

	MOR-3914E-BD6-327 /S167	L~M	2	4	2.0	3.2	3	3.2	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC × 27 #11	6,000	
<b>TRADUCTOR</b>	MOR-3914E-BE6-327 /S167		2	4	2.0	4.0	3	3.2	1:0.7 ~ 1:2	1~7.5	6.5	DC × 27 #11	6,000	

#### • For piping

★M075: Piping folder (to be commonly used with knit materials)

MOR-3914E-BD6-337 /M075	L~M	2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	1~7.5	6.5	DC × 27 #11	7,000	
MOR-3914E-BE6-337 /M075		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC × 27 #11	7,000	

● For tape attaching ★L01, L07: Tape attaching presser foot ★Q141: Tape guide

MOR-3914E-BD6-347 /L01/Q141	L~M	2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	1~7.5	6.5	DC × 27 #11	7,000	
MOR-3914E-BE6-347 /L01/Q141	L ~ IVI	2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	1~7.5	6.5	DC × 27 #11	7,000	
MOR-3914E-BE6-44H /L01/Q141		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	1~7.5	6.5	DC × 27 #14	7,000	
MOR-3914E-BF6-44H /L01/Q141		2	4	2.0	4.8	3	4	1:0.7 ~ 1:2	1~7.5	6.5	DC × 27 #14	7,000	
MOR-3914E-BD7-44H /L07/Q141	M ~ H	2	4	2.0	3.2	4	4	1:0.7 ~ 1:2	1~7.5	6.5	DC × 27 #14	7,000	Upper looper extra high throw type
MOR-3914E-BE7-44H /L07/Q141		2	4	2.0	4.0	4	4	1:0.7 ~ 1:2	1~7.5	6.5	DC × 27 #14	7,000	
MOR-3914E-CE7-44H /L07/Q141		2	4	2.4	4.0	4	4	1:0.7 ~ 1:2	1~7.5	6.5	DC × 27 #14	7,000	

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## Safety stitching

• For runstitching in general fabric

	5 5													
	MOR-3916E-BE4-300		2	5	2.0	4.0	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	
	MOR-3916E-DD4-300		2	5	3.2	3.2	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #11	7,000	
	MOR-3916E-DE4-300		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	
	MOR-3916E-DF4-300		2	5	3.2	4.8	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	
	MOR-3916E-DD6-300	L~M	2	5	3.2	3.2	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	
	MOR-3916E-DE6-300		2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	
	MOR-3916E-DF6-300		2	5	3.2	4.8	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #11	7,000	
- Sect	MOR-3916E-FF6-300		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	
	MOR-3916E-RH6-30H		2	5	6.8	6.4	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000	Upper looper
	MOR-3916E-FF6-50H	M~H	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	1~7	6	DC × 27 #16	7,000	extra high throw type
	MOR-3916E-FH6-50H		2	5	4.8	6.4	3	4	1:0.7 ~ 1:2	1~7	6	DC × 27 #16	7,000	
	MOR-3916E-FF6-60H	H~EH	2	5	4.8	4.8	3	4.5	1:0.6 ~ 1:1.7	1~7	6	DC × 27 #21	7,000	Upper looper extra high
	MOR-3916E-FH6-60H		2	5	4.8	6.4	3	4.5	1:0.6 ~ 1:1.7	1~7	6	DC × 27 #21	7,000	throw type For jeans

• For upper-cloth gathering ★S167: Swing-type upper-cloth gathering device (knee-operated)

MOR-3916E-DD4-320 /S167		2	5	3.2	3.2	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	6,000
MOR-3916E-DE4-320 /S167		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #11	6,000
MOR-3916E-DE6-320 /S167	L~M	2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #11	6,000
MOR-3916E-DF6-320 /S167		2	5	3.2	4.8	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #11	6,000
MOR-3916E-FF6-320 /S167		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	6,000

For piping	★M075: Piping folder (to be commonly used with knit materials)
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MOR-3916E-DD4-330 /M075		2	5	3.2	3.2	2	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000
MOR-3916E-DE4-330 /M075		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #11	7,000
MOR-3916E-DE6-330 /M075	L~M	2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #11	7,000
MOR-3916E-DF6-330 /M075		2	5	3.2	4.8	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000
MOR-3916E-FF6-330 /M075		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000

## ■ 3-needle safety stitching

Multi-purpose runstitching

	MOR-3943E-DBD6-307		3	6	3.2 +2.0	3.2	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000
	MOR-3943E-FBD6-307	-	3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000
	MOR-3943E-BBD6-30H		3	6	2.0 +2.0	3.2	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #11	7,000
	MOR-3943E-DBD6-30H		3	6	3.2 +2.0	3.2	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC × 27 #11	7,000
	MOR-3943E-FBD6-30H		3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	1~7.5	7	DC × 27 #11	7,000

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## **DEVICES AND ATTACHMENTS**

Model	Part No.	Description	Feature									
Chain	Chain-off thread trimming device											
T039	MAT-039003A0	One-touch type tape cutter and chain-off thread	For 110, 115, 220, 240V									
1037	MAT-039004A0	trimming device (electromagnetic type)	For 220, 380, 415, 440V									
	MAT-040005A0		For semi-	For 110, 115, 220, 240V								
T040	MAT-040006A0	Automatic tape cutter and chain-off thread trimming device	sunken type	For 220, 380, 415, 440V								
1040	MAT-040005AA	(number-off-stitch control electromagnetic type)	For fully-	For 110, 115, 220, 240V								
	MAT-040006AA		sunken type	For 220, 380, 415, 440V								
T041	MAT-041000AB	Pneumatic flat cutter										
T045	MAT-045000A0	Pneumatic side cutter										

#### Blower-type chain-off thread suction device

MC-7A	(chain-off	thread and cloth chips)	
• Chain-	off thread suction device		
MC-4	Pneumati	c chain-off thread suction device (pedal type)	
MC-5	Pneumati	c chain-off thread suction device	
MC-8		c chain-off thread suction device thread and cloth chips)	
MC-9	Provided	with the function of MC-8 and an auto-lifter	
MC-24		c chain-off thread suction device thread and cloth chips)	

* The aforementioned devices are not equipped with an air regulator. Please purchase the following components when you need to regulate air pressure.

PF-05520	010-B0 Air	regulator (F.R. unit asm.)	
GMD-010	080000 × 2 Fixi	ring screw for F.R. unit asm.	
F1021-00	)3-000 Tub	be connector (male)	
GAS-120	63000 * One	ne-touch connector	* Selection parts instead of the tube connector

#### • Auto-lifter

AK32	GAK-320000A0	Pneumatic type	
AK49	GAK-490000A0	Pneumatic type (pedal type)	
AK52	GAK-520000A0	Pneumatic type (with chain-off thread suction device)	
AK101	GAK-A01000A0	Pneumatic type (for servomotor)	

#### ■ [Reference] Combination table of "chain-off thread suction device" and "auto-lifter" which correspond to "chain-off thread trimming device"

			· · · ·						
Chain-off thread trimming device		Chain-off thread suction device to which the chain-off thread trimming device	Auto-lifter which can be attached to the chain-off thread suction device						
T039	+	MC-7A • MC-8	AK65 (with an electronic-stop motor or AC servomotor) AK101 (for JUKI AC servomotor)						
		MC-9	(MC-9 is equipped with an auto-lifter)						
		MC-7A	AK32 (any motor will do)						
T040	+	NIC-7A	AK65 (with an electronic-stop motor or AC servomotor)						
1040		MC-5	AK32 (any motor will do)						
		MC-24	AK32 (any motor will do)						
70.11		*	AK52 (any motor will do)						
T041	1	MC-4	AK65 (with an electronic-stop motor or AC servomotor)						
or	+	MC-7A • MC-8	AK65 (with an electronic-stop motor or AC servomotor)						
T045		MC-9	(MC-9 is equipped with an auto-lifter)						
	_	* AK52 is equipped with a chain-off thread	d suction device.						

#### • Gathering device

S167		Swing-type upper-cloth gathering device (interlocked with pedal)	The attachment opens interlocking with the presser foot pedal. This facilitates material setting on the machine. Furthermore, a knee- control type differential-feed adjusting device which is used to control a differential-feed ratio as desired, is built in the attachment, thereby enabling the operator to make beautiful gathers.
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#### Blind hemming device

	-						
L121	MAL-121000A0	Blind stitch hemming attachment	A ruler used for	A ruler used for blind hemming in knits			
	MAL-122001A0	Automatic folded-edge controlled blind hemming	Flat	For 110, 115, 220, 240V			
L122	MAL-122002A0	device (The attachment automatically detects the	upper knife	For 220, 380, 415, 440V			
	MAL-122001AA	overlapped section of a material. Then, it makes the needle enter the material deeper to prevent stitch	square	For 110, 115, 220, 240V			
	MAL-122002AA	deviation.)	upper knife	For 220, 380, 415, 440V			
L123	MAL-123000A0	Spring-type folded-edge controlled bottom hemming device	When the overlapped section of a material is reached, the blind hemming guide will move sufficiently to prevent stitch deviation.				

Model	Part No.	Description	Feature						
Piping	g								
M056	MAM-0560J0A0	Piping folder	This is a piping folder which makes a piping first, then turns up the tape.						
M075	MAM-0750J0A0	Piping folder (to be used with knit tape)	This attachment can be used for both "cotton bias tape with gimp" and "knit tape". The operation mode can be changed over with a fingertip control.						
M076	MAM-0760N0A0	Ready-made piping folder	The dimension of ready-made tapes can be adjusted within the range of 8 to 13mm.						
M077	MAM-0770M0A0	Piping folder for shirring	The attachment makes gathers on the lower fabric while making decorative piping.						
M222	MAM-2220M0B0	Piping folder upper-cloth gathering (finished width 12mm. tape width 26mm)							
IVIZZZ	MAM-2220J0B0	Piping folder upper-cloth gathering (finished width 9mm. tape width 20mm)	This folder is to be used together with upper-cloth gathering device \$167.						
M224	MAM-2240N0A0	Ready-made piping folder for upper-cloth gathering							
• Guide	e, Ruler								
H153	H153 MAH-153000A0 Cloth edge guide ruler (for overlock)		A swing type edge guide						
H154	MAH-154000A0	Cloth edge guide ruler (for safety stitch)							
Q141	MAQ-141000B0	Tape guide	This attachment is used for attached on the machine head (face plate). It is used for tapes of which width is 7mm or less						
Cloth	puller								
V058A			For table top type						
V058B		Electromagnetic cloth puller (top and bottom roller type)	For semi-sunken type						
V058C			For fully-sunken type						
V068A		Pneumatic cloth puller	For table top type						
V068C		(top and bottom roller type)	For fully-sunken type						
• Tape I	reel								
V059	MAV-059000AA	Tension-free feeder							
R001	MAR-001000A0								
R002	MAR-002010A0	1							
R006	MAR-006010A0								
R007	MAR-007000A0	Tape reel							
	1								

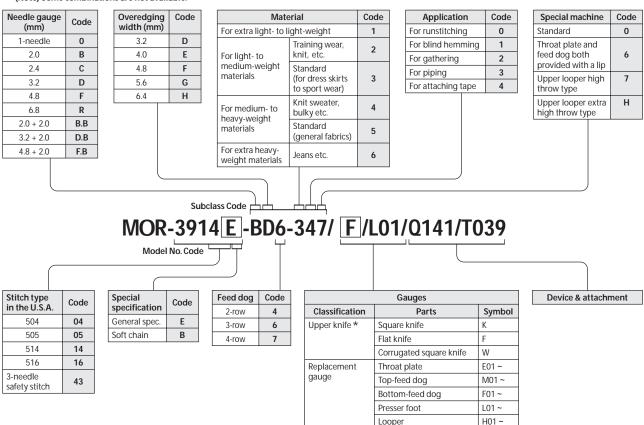
## WHEN YOU PLACE ORDERS

#### (Note) Some combinations are not available.

MAR-008000A0 MAR-013000A0

R008

R013



* No code is to be given to the standard square knife. Specify the knife code, "F" or "W" only when a knife other than the standard one is required. Super-high-speed, Cylinder-bed, Overlock Machine

# **MOC-3900 SERIES**

- A small-diameter cyilinder bed has been introduced. As a result, the operator can easily handle the sleeve cuffs of children's wear, the diameters of which are very small. The cylinder-bed allows the operator to help feed a tubular material being sewn along the bed. This helps reduce the operator's fatique.
- The machines in the MOC-3900 series in corporate high-precision components, are light in weight, and can sew pieces of material without applying heavy pressure on them. These features enable the machines to smoothly feed soft and delicate materials as well as perform consistent sewing, while preventing the material from flopping and the presser foot from jumping even when running at high speed.

# High-speed, Cylinder-bed, Variable Top-feed Overlock Machine MOF-3900 SERIES

- The machine comes with the top-feed dog that moves along an ideal locus. The feed dog securely catches the material and allows the multi-layer portion of a material to be fed under it with consistency. In addition, it helps finish uniform seams while preventing the presser foot from jumping and smoothly feeds the material without fail. Compact-shape of the cylinder effectively prevents the material from being fed unevenly and from twisting in various kinds of sewing of tubular materials, e.g., joining sleeve cuffs of which diameter is small and blind hemming long materials.
- The machine achieves the highest sewing speed among cylinder-bed, variable top-feed overlock machines. It demonstrates its sewing capabilities especially when blind hemming long materials.
   In addition, it is not necessary to reduce the sewing speed even if the material thickness changes at joints or the like.



MOC-3914

3



MOF-3914

## SPECIFICATIONS

			1							
Model name	MOC-3904	MOC-3914	MOF-3904	MOF-3914						
Stitch type	1-needle overlock	2-needle overlock	1-needle, variable top-feed overlock	2-needle, variable top-feed overlock						
Stitch style in the U.S.A.	504	514	504	514						
Max. sewing speed	8,500rpm	8,000rpm	Longitudinal stroke of top-feed is 6mm or less: 7,000rpm Longitudinal stroke of top-feed is 6mm to 8.5mm: 6,000rp							
Stitch length		0.8 ~ 3	3.5mm							
Needle gauge (mm)		2, 2.4	2, 2.4							
Overedging width (mm)	3.2, 4, 4.8	2, 3.2, 4, 4.8	3.2, 4	4, 4.8						
Bottom differential-feed ratio	For gathering 1:2.3 (max. 1:4.5), For stretching 1:0.8									
Needle bar stroke	24.5mm									
Inclination angle of the needle	20°									
Needle	DC × 27, For JE: B-27									
Vertical stroke of top-feed dog	3.5 ~ 8.5mm									
Longitudinal stroke of top-feed dog			1 ~ 8.	5mm						
Max. lift of the presser foot	7m	ım	7mm	6.5mm						
Max. presser foot pressure		58.8N	l (6kg)							
Stitch length adjusting method		By push	n-button							
Differential-feed adjusting method		By I	ever							
Weight of the machine head		28	lkg							
Lubrication		Auto	matic							
Lubricating oil		JUKI New Defrix Oil No.2	(equivalent to ISO VG32)							
Needle cooler		By silicon oil lubricating	g unit for the needle tip							
Needle thread heat remover		By silicon oil lubricating	unit for the needle thread							

MOC-3900, MOF-3900 SERIES (June, 2001) 1/4

## SUBCLASS MACHINE LIST

			•.										
Seams	Model No.	Katerials	of	S Number of threads	→ ⊢ Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	Max. stitch length (mm)	Bottom differential- feed ratio	Presser lifting amount (mm)	N Needle system	Max. sewing speed (rpm)	Remarks
	edle overlock unstitching		( ), th	machine a e number two or m	of kinds of	vith a triangle of overedging 〈	B – 2.0m E – 4.0m		ZIIIIII Nee	total ove edle gaug	redging wigth: e + Overedging wi	dth 🛛	L = Light-weight materi M = Medium-weight ma H = Heavy-weight mater
	MOC-3904E-0 4-300		1	3	-	3.2, 4.0	2	3.5	1: 0.8 ~ 1: 2.3	6.5	DC × 27 #11	8,500	
	MOC-3904E-0F4-307	L~M	1	3	-	4.8	2	3.5	1: 0.8 ~ 1: 2.3	7	DC × 27 #11	8,000	Upper looper
	MOC-3904E-0 6-307		1	3	-	3.2, 4.0	3	3.5	1: 0.8 ~ 1: 2.3	7	DC × 27 #11	8,000	high throw type
	MOC-3904E-0F6-40H	M~H	1	3	-	4.8	3	3.5	1: 0.8 ~ 1: 2.3	7	DC × 27 #11	7,500	Upper looper extra high throw type
For b	lind hemming L124	: Blind he	mming a	ttachme	ent L1	125: Blind hen	nming at	tachmei	nt (with automa	atic folde	d-edge control I	nemming	device)
	MOC-3903E-0 4-210		1	2	-	3.2, 4.0	2	3.5	1: 0.8 ~ 1: 2.3	5.5	DC × 27 #9	8,500	
	MOC-3903E-0 4-210 /L125		1	2	-	3.2, 4.0	2	3.5	1: 0.8 ~ 1: 2.3	5.5	DC × 27 #9	8,500	
	MOC-3905E-0 4-210 /L124	L~M	1	3	-	3.2, 4.0	2	3.5	1: 0.8 ~ 1: 2.3	5.5	DC × 27 #9	8,500	
	MOC-3905E-0 4-210 /L125		1	3	-	3.2, 4.0	2	3.5	1: 0.8 ~ 1: 2.3	5.5	DC × 27 #9	8,500	
	eedle overlock unstitching											•	
	MOC-3914E-B 4-307		2	4	2.0	2.0, 3.2, 4.0	2	3.5	1: 0.8 ~ 1: 2.3	7	DC × 27 #11	8,000	
	MOC-3914E-B 6-307	1	2	4	2.0	3.2, 4.0, 4.8	3	3.5	1: 0.8 ~ 1: 2.3	7	DC × 27 #11	8,000	Upper looper
	MOC-3914E-CE4-307	L∼M	2	4	2.4	4.0	2	3.5	1: 0.8 ~ 1: 2.3	7	DC × 27 #11	8,000	high throw type
	MOC-3914E-CE6-307	1	2	4	2.4	4.0	3	3.5	1: 0.8 ~ 1: 2.3	7	DC × 27 #11	8,000	
	MOC-3914E-B 6-40H		2	4	2.0	3.2, 4.0, 4.8	3	3.5	1: 0.8 ~ 1: 2.3	7	DC × 27 #11	7,500	Upper looper

3

3.5

1:0.8 ~ 1:2.3

7

DC × 27 #11

4.0, 4.8

Upper looper

7,500

extra high throw type

## WHEN YOU PLACE ORDERS

MOC-3914E-C 6-40H

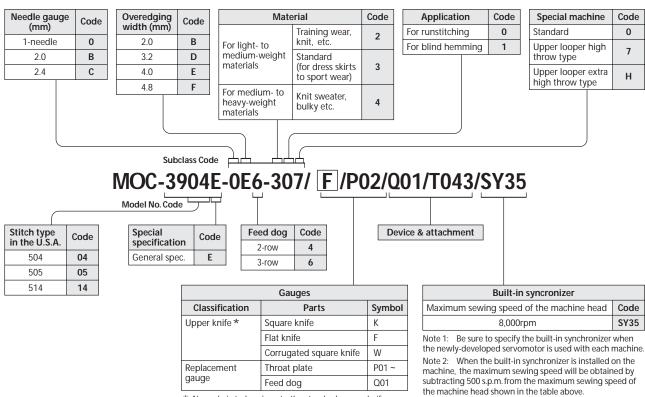
M~H

2

4

2.4

#### (Note) Some combinations are not available.



* No code is to be given to the standard square knife. Specify the knife code, "F" or "W" only when a knife other than the standard one is required.

MOC-3900, MOF-3900 SERIES (June, 2001) 2/4 Downloaded from www.Manualslib.com manuals search engine

## SUBCLASS MACHINE LIST

		Seams	Model No.	K Materials	Number of needles	Number of threads	→ ⊢ Needle gauge (mm)	⊥ <u>µ</u> µ Overedging	Number of feed dog rows	Max. stitch	Bottom differential- feed ratio	Longitudinal stroke of top-feed dog (mm)	lifting	Needle system	Max. sewing speed (rpm)	Remarks
--	--	-------	-----------	----------------	-------------------------	-------------------------	--------------------------------	----------------------------	----------------------------------	----------------	---------------------------------------	---------------------------------------------------	---------	---------------	----------------------------------	---------

1-needle overlock

Needle gauge + Overedging width

terials

3

For runstitching

• • • • • •	anstroning													
	MOF-3904E-0E4-300		1	3	-	4.0	2	3.5	1: 0.8 ~ 1: 2.3	1 ~ 7.5	7	DC × 27 #11	7,000	
	MOF-3904E-0F4-307		1	3	-	4.8	2	3.5	1: 0.8 ~ 1: 2.3	1 ~ 7.5	7	DC × 27 #11	7,000	
	MOF-3904E-0D6-307	L~H	1	3	-	3.2	3	3.5	1: 0.8 ~ 1: 2.3	1~7.5	7	DC × 27 #11	7,000	Upper looper high throw type
	MOF-3904E-0E6-307		1	3	-	4.0	3	3.5	1: 0.8 ~ 1: 2.3	1 ~ 7.5	7	DC × 27 #11	7,000	
	MOF-3904E-0F6-40H	M~H	1	3	-	4.8	3	3.5	1: 0.8 ~ 1: 2.3	1 ~ 7.5	7	DC × 27 #11	7,000	Upper looper extra high throw type

For blind hemming L124: Blind hemming attachment L125: Blind hemming attachment (with automatic folded-edge control hemming device)

	MOF-3905E-0D4-210 /L124		1	3	-	3.2	2	3.5	1: 0.8 ~ 1: 2.3	1~7.5	7	DC × 27 #9	7,000	
	MOF-3905E-0D4-210 /L125	L~M	1	3	-	3.2	2	3.5	1: 0.8 ~ 1: 2.3	1~7.5	7	DC × 27 #9	7,000	
$\square$	MOF-3905E-0E4-210 /L124	L~W	1	3	-	4.0	2	3.5	1: 0.8 ~ 1: 2.3	1~7.5	7	DC × 27 #9	7,000	
~~	MOF-3905E-0E4-210 /L125		1	3	-	4.0	2	3.5	1: 0.8 ~ 1: 2.3	1~7.5	7	DC × 27 #9	7,000	

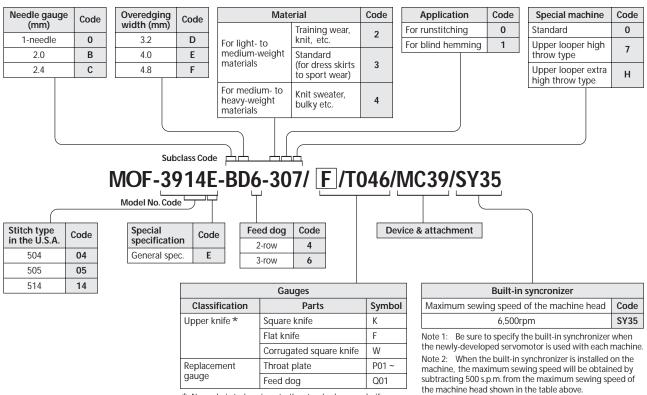
#### 2-needle overlock

For runstitching

	MOF-3914E-BD6-307	L~H	2	4	2.0	3.2	3	3.5	1: 0.8 ~ 1: 2.3	1 ~ 7.5	6.5	DC × 27 #11	7,000	Upper looper
	MOF-3914E-BE6-307	L~H	2	4	2.0	4.0	3	3.5	1: 0.8 ~ 1: 2.3	1 ~ 7.5	6.5	DC × 27 #11	7,000	high throw type
6	MOF-3914E-BD6-40H		2	4	2.0	3.2	3	3.5	1: 0.8 ~ 1: 2.3	1 ~ 7.5	6.5	DC × 27 #11	7,000	
	MOF-3914E-BE6-40H		2	4	2.0	4.0	3	3.5	1: 0.8 ~ 1: 2.3	1 ~ 7.5	6.5	DC × 27 #11	7,000	
	MOF-3914E-BF6-40H	M~H	2	4	2.0	4.8	3	3.5	1: 0.8 ~ 1: 2.3	1 ~ 7.5	6.5	DC × 27 #11	7,000	Upper looper extra high throw type
	MOF-3914E-CE6-40H		2	4	2.4	4.0	3	3.5	1: 0.8 ~ 1: 2.3	1 ~ 7.5	6.5	DC × 27 #11	7,000	
	MOF-3914E-CF6-40H		2	4	2.4	4.8	3	3.5	1: 0.8 ~ 1: 2.3	1 ~ 7.5	6.5	DC × 27 #11	7,000	

## WHEN YOU PLACE ORDERS

(Note) Some combinations are not available.



No code is to be given to the standard square knife. Specify the knife code, "F" or "W" only when a knife other than the standard one is required.

## MOC-3900, MOF-3900 SERIES

				Applicatio		
Model	Part No.	Description	Feature	MOC- 3900		
				0,00	0,00	

#### Chain-off thread trimming device

T043	MAT-043000A0	Pneumatic side cutter		
T046	MAT-046000A0	Pneumatic side cutter		

#### • Blower-type chain-off thread suction device

MC-7B		(chain-off thread and cloth chips)			
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#### Chain-off thread suction device

MC-4	Pneumatic chain-off thread suction device		
MC-38	Pneumatic chain-off thread suction device (chain-off thread and cloth chips)		
MC-39	Provided with the function of MC-38 and an auto-lifter		

* The aforementioned devices are not equipped with an air regulator. Please purchase the following components when you need to regulate air pressure.

PF-0552010-B0	Air regulator (F.R. unit asm.)		
GMD-01080000 × 2	Fixing screw for F.R. unit asm.		
F1021-003-000	Tube connector (male)		
GAS-12063000 *	One-touch connector	* Selection parts instead of the tube connector	

#### • Auto-lifter

AK93	GAK-930000A0	Pneumatic type		
AK94	GAK-940000A0	Pneumatic type (with chain-off thread suction device)		
AK102	GAK-A02000A0	Pneumatic type (for servomotor)		

#### Blind hemming device

L124	MAL-124000A0	Blind stitch hemming device			
	MAL-125001A0	Automatic folded-edge controlled blind	Flate	For 110, 115, 220, 240V	
L125	MAL-125002A0	hemming device (The attachment automatically detects the	upper knife	For 220, 380, 415, 440V	
LIZO	MAL-125001AA	overlapped section of a material. Then, it makes the needle enter the material deeper	Square	For 110, 115, 220, 240V	
		to prevent stitch deviation.)	upper knife	For 220, 380, 415, 440V	

#### • Guide, Ruler

H153	MAH-153000A0	Cloth edge guide ruler (for overlock)	A swing type edge guide		
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### Cloth tensioner

TR01	Small-diameter roller for rib attaching		
TR02	Large-diameter cloth tensioner		

#### Cloth puller

V058A		For table top type	
V058B	ectromagnetic cloth puller pp and bottom roller type)	For semi-sunken type	
V058C		For fully-sunken type	
V068A	Pneumatic cloth puller	For table top type	
V068C	(top and bottom roller type)	For fully-sunken type	

#### • Tape reel

V059	MAV-059000AA	Tension-free feeder		
R001	MAR-001000A0			
R002	MAR-002010A0			
R006	MAR-006010A0	ape reel		
R007	MAR-007000A0			
R008	MAR-008000A0			
R013	MAR-013000A0			

Bottom-feed, Overlock / Safety Stitch Machine for Extra Heavy-weight Materials

# **MOG-3700 SERIES**

- The machines are equipped with a full range of newly developed functions that are ideal for the sewing extra heavy-weight materials including, an extra high-throw upper looper (equipped as standard), tractor foot, and exclusive feed dog. The machines demonstrate outstanding capabilities in the sewing of various kinds of extra heavy-weight materials, including raised materials, mats and carpets.
- The machines are equipped with a newly developed mechanism that prevents needle vibration and backlash in the needle bar. This not only prevents the needle tip from becoming blunt and wearing out, but also dramatically improves the efficiency of feed on multi-layered portions of fabric. The machines promise easy-response to materials as heavy as 12-ply 14 oz. denim jeans.



MOG-3716

## SPECIFICATIONS

		T	T			
Model name	MOG-3704	MOG-3714	MOG-3716			
Stitch type	1-needle, 3-thread bottom-feed overlock	2-needle, 4-thread bottom-feed overlock	2-needle, 5-thread bottom-feed safety stitch			
Stitch style in the U.S.A.	504	514	516			
Feed system		Bottom-feed				
Max. sewing speed		6,000rpm				
Stitch length	2.5 ~ 5mm	2.5 ~ 4mm	2.5 ~ 5mm			
Needle gauge (mm)		2.6	4.8			
Overedging width (mm)	4.8, 10	6.4	4.8, 6.4			
Bottom differential-feed ratio	For gathering 1: 1.8 (max. 1: 3.8) For stretching 1: 0.6	For gathering 1:2 (max. 1: 3.8) For stretching 1:0.7 (max. 1: 0.6)	For gathering 1: 1.8 (max. 1: 3.8) For stretching 1: 0.6			
Needle bar stroke	28.8mm					
Inclination angle of the needle		20°				
Needle	GROZ-BECKERT 142 × 5	GROZ-BECKERT 142 × 5	GROZ-BECKERT 142 × 5			
Max. lift of the presser foot		8mm				
Max. presser foot pressure		58.8N (6kg)				
Stitch length adjusting method		By push-button				
Differential-feed ratio adjusting method		By lever (with micro-adjustment)				
Upper knife		Cemented square knife				
Weight of the machine head		28kg				
Lubrication		Automatic				
Lubricating oil	JUKI	New Defrix Oil No.2 (equivalent to ISO \	/G32)			
Needle cooler	Optiona	I: By silicon oil lubricating unit for the n	eedle tip			
Needle thread heat remover	Optional:	By silicon oil lubricating unit for the nee	dle thread			

## SUBCLASS MACHINE LIST

Seams	Model No.	Number of needles	S Number of threads	→ ⊢ Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	Max. stitch length (mm)	Bottom differential- feed ratio	Presser lifting amount (mm)	Needle system	Max. sewing speed (rpm)	Remarks
	MOG-3703E-0N6-3D1	1	2	_	20	3	5	1:3.8 ~ 1:0.6	5	Groz 142 × 5 #100	5,500	For splicing fabrics
	MOG-3704E-0F6-600	1	3	-	4.8	3	5	1:3.8 ~ 1:0.6	8	Groz 142 × 5 #130	6,000	For runstitching extra heavy-weight materials such as denim and drill.
$\square$	MOG-3704E-0M6-600	1	3	-	10	3	5	1:3.8 ~ 1:0.6	8	Groz 142 × 5 #130	5,500	For serging extra heavy- weight materials such as denim and drill.
	MOG-3705E-0M6-700	1	3	-	10	3	5	1:3.8 ~ 1:0.6	7	Organ DC × 1 #24	4,500	For overedging carpets, mats for entrance halls, etc.
	MOG-3705E-0M6-7E0	1	3	-	10	3	5	1:3.8 ~ 1:0.6	7	Organ DC × 1 #24	4,500	For overedging car mats.
S	MOG-3714E-CH6-600	2	4	2.6	6.4	3	4	1:3.8 ~ 1:0.6	8	Groz 142 × 5 #130	6,000	For overedging jersey, etc.
	MOG-3716E-FF6-700	2	5	4.8	4.8	3	5	1:3.8 ~ 1:0.6	8	Groz 142 × 5 #130	6,000	
	MOG-3716E-FH6-700	2	5	4.8	6.4	3	5	1:3.8 ~ 1:0.6	8	Groz 142 × 5 #130	6,000	For safety stitching extra heavy-weight materials such as denim and drill.
	MOG-3716E-FM6-700	2	5	4.8	10	3	5	1:3.8 ~ 1:0.6	8	Groz 142 × 5 #130	4,500	

MOG-3700 SERIES (June, 2001) 1/1

Bottom-feed, Overlock / Safety Stitch Machine for Extra Heavy-weight Materials

# **MOJ-3900 SERIES**

- The MOJ-3900 series incorporates a newly developed feed mechanism that permits independent motion of the top and bottom-feed dogs. With its upgraded efficiency of feed and stronger clamping force, the feed mechanism eliminates irregular feed of extra heavy-weight materials, thereby helping improve the quality of finished products and enhance efficiency in sewing.
- The machines are equipped with a full range of newly developed functions that are ideal for the sewing extra heavy-weight materials including, an extra high-throw upper looper (equipped as standard), tractor foot, and exclusive feed dog. The machines demonstrate outstanding capabilities in the sewing of various kinds of extra heavy-weight materials, including raised materials, mats and carpets.



MOJ-3904

## SPECIFICATIONS

Model name	MOJ-3904	MOJ-3914	MOJ-3916			
Stitch type	1-needle, 3-thread variable top-feed overlock	2-needle, 4-thread variable top-feed overlock	2-needle, 5-thread variable top-feed safety stitch			
Stitch style in the U.S.A.	504	514	516			
Feed system		Variable top-feed (rake-in type)				
Max. sewing speed	Longitudir	nal stroke of top-feed is 6mm or less : 6,0	000rpm			
Max. sewing speed	Longitudinal stroke of top-feed is 6mm to 8.5mm : 5,500rpm					
Stitch length	2.5 ~ 5mm	2.5 ~ 4mm	2.5 ~ 5mm			
Needle gauge (mm)		2.6	4.8			
Overedging width (mm)	4.8	6.4	4.8, 6.4			
Bottom differential-feed ratio	For gathering 1: 1.8 (max. 1: 3.8) For stretching 1: 0.6	For gathering 1: 2.0 (max. 1: 3.8) For stretching 1: 0.7 (max. 1: 0.6)	For gathering 1: 1.8 (max. 1: 3.8) For stretching 1: 0.6			
Needle bar stroke		28.8mm				
Inclination angle of the needle		20°				
Needle (at the time of delivery)	GROZ-BECKERT 142 × 5 (#130)	GROZ-BECKERT 142 × 5 (#110)	GROZ-BECKERT 142 × 5 (#130)			
Vertical stroke of top-feed dog		8.5mm				
Longitudinal stroke of top-feed dog		1 ~ 8.5mm				
Max. lift of the presser foot		8mm				
Max. presser foot pressure		58.8N (6kg)				
Stitch length adjusting method		By push-button				
Differential-feed adjusting method		By lever (with micro-adjustment)				
Upper knife		Cemented square knife				
Weight of the machine head		30kg				
Lubrication		Automatic				
Lubricating oil	JUKI	New Defrix Oil No.2 (equivalent to ISO V	/G32)			
Needle cooler	Ву	silicon oil lubricating unit for the needle	e tip			
Needle thread heat remover	By sil	icon oil lubricating unit for the needle the	hread			

## SUBCLASS MACHINE LIST

Seams	Model No.	Number of needles	S Number of threads	→ ⊢ Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	Max. stitch length (mm)	Bottom differential- feed ratio	Longitudinal stroke of top-feed dog (mm)	Presser lifting amount (mm)	NNeedle system	Max. sewing speed (rpm)	Remarks
	MOJ-3904E-0A6-600	1	3	-	4.8, 6.4	3	5	1: 3.8 ~ 1: 0.6	8	1~8.5	Groz 142 × 5 #130	6,000	For runstitching extra heavy-weight materials such as denim and drill.
$\bigcirc$	MOJ-3914E-CH6-600	2	4	2.6	6.4	3	4	1: 3.8 ~ 1: 0.6	8	1~8.5	Groz 142 × 5 #110	6,000	For overedging jersey, etc.
-	MOJ-3916E-FF6-700	2	5	4.8	4.8	3	5	1: 3.8 ~ 1: 0.6	8	1~8.5	Groz 142 × 5 #130	6,000	
SILING	MOJ-3916E-FH6-700	2	5	4.8	6.4	3	5	1: 3.8 ~ 1: 0.6	8	1~8.5	Groz 142 × 5 #130	6,000	For safety stitching extra heavy-weight materials such as denim and drill.
	MOJ-3943E-FDE6-600	3	6	4.8 + 3.2	4.0	3	5	1: 3.8 ~ 1: 0.6	8	1~8.5	Groz 142 × 5 #130	6,000	denim and dim.

## MOG-3700 SERIES, MOJ-3900 SERIES

			Application MOG- MOJ- 3700 3900		
Model	Part No.	Description	MOG-	MOJ-	
			3700	3900	

#### • Chain-off thread trimming device

	MAT-039001A0	One-touch type tape cutter and chain-off threa	d trimming	For 110, 115, 220, 240V		
T039	MAT-039002A0	device (electromagnetic type)	a a mining	For 220, 380, 415, 440V	-	
	MAT-040001A0			For 110, 115, 220, 240V		
T0 40	MAT-040002A0	Automatic tape cutter and chain-off thread trimming device (number-off-stitch control and electromagnetic type)		For 220, 380, 415, 440V		
T040	MAT-040001AA		For fully- sunken type	For 110, 115, 220, 240V		
	MAT-040002AA			For 220, 380, 415, 440V		
T048	MAT-048010A0	Pneumatic flat cutter (for overlock stitch machi	no)	•		
1046	MAT-040010B0					
T050	MAT-050010A0	Pneumatic flat cutter (for safety stitch machine)				
1050	MAT-050010B0					

#### • Blower-type chain-off thread suction device

MC-7A		(chain-off thread and cloth chips)		
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#### Chain-off thread suction device

MC-4	Pneumatic chain-off thread suction device	
MC-5	Pneumatic chain-off thread suction device	
MC-8	Pneumatic chain-off thread suction device (chain-off thread and cloth chips)	
MC-9	Provided with the function of MC-8 and an auto-lifter	
MC-24	Pneumatic chain-off thread suction device (chain-off thread and cloth chips)	

* The aforementioned devices are not equipped with an air regulator. Please purchase the following components when you need to regulate air pressure.

PF-0552010-B0	Air regulator (F.R. unit asm.)		
GMD-01080000 × 2	Fixing screw for F.R. unit asm.		
F1021-003-000	Tube connector (male)		
GAS-12063000 *	One-touch connector	* Selection parts instead of the tube connector	

#### Auto-lifter

AK25	GAK-250000A0	Electromagnetic type	
AK32	GAK-320000A0	Pneumatic type	
AK49	GAK-490000A0	Pneumatic type	
AK52	GAK-520000A0	Pneumatic type (with chain-off thread suction device)	

#### ■ [Reference] Combination table of "chain-off thread suction device" and "auto-lifter" which correspond to "chain-off thread trimming device"

Chain-off thread trimming device		Chain-off thread suction device to which the chain-off thread trimming device	Autolifter which can be attached to the chain-off thread suction device		
T039	1+	MC-7A • MC-8	AK25		
1039		MC-9			
	_				
T040	] +	MC-5 • MC-24	AK32		
	_				
T048		MC-4	AK52		
or	+	MC-7A • MC-8	AK25		
T050		MC-9			

Overlock Machine with a Semi-automatic Backlatch Device

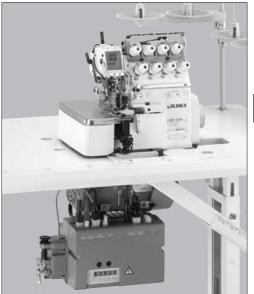
(1-Needle)

MO-3 04E-0E6-300/LB-1 ^(2-Needle) MO-3 14E-BE4-307/LB-2

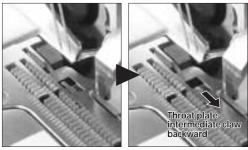
Variable Top-feed Overlock Machine with a Semi-automatic Backlatch Device (1-Needle)

MOR-3904E-0E6-300/LB-1 (2-Needle) MOR-3914E-BE4-307/LB-2

- Aided by the precise control of the stitch number provided by the material-edge sensor and SC-380 motor/controller, the tension-release mechanism is activated during production of chain-off thread at both the start and end of sewing so that thin chain-off thread can be produced. The chain-off thread is completely tucked into the finished seam on the material to achieve a beautifully finished sewing product.
- For the 2-needle overlock machine, the throat plate intermediate claw automatically moves backward at the end of sewing so that the chain-off thread can be guided to the needle thread retainer without getting caught by the claw. At the start of the next sewing, the chain-off thread is rolled into the stitches to the material edge, giving the seam a beautiful finish.
- For both 1-needle and 2-needle overlock machines, the tension-release function can be disabled by setting the material edge sensor in the OFF state. In addition, for 2-needle machines, the intermediate claw of the throat plate can be fixed with projected. This means that the machine can be used as a standard machine with standard specifications for processes not requiring the backlatching capability such as continuous stitching and runstitching, thereby saving on new equipment.



MO-3914E-BE4-307/LB-2



Throat plate intermediate claw forward/backward mechanism (for 2-needle machines)

## **SPECIFICATIONS**

Auto-lifter	Provided as standard
Compressed air	0.5 MPa (5kgf/cm ² )

* For specifications not listed above, refer to the respective model catalogs.

## WHEN YOU PLACE ORDERS

• Overlock (1-NEEDLE)		)4E-C	E6-300/LB-1
	Model	Code	
	MO-3604E	6	
	MO-3704E	7	
	MO-3904E	9	
(2-NEEDLE)	MO-3_1	4E-E	BE4-307/LB-2
	Model	Code	
	MO-3614E	6	
	MO-3714E	7	
	MO-3914E	9	

• Variable Top-feed Overlock Machine (1-NEEDLE) MOR-3904E-0E6-300/LB-1

^(2-NEEDLE) MOR-3914E-BE4-307/LB-2



	PSC box		Code
For Conoral Export	Single-phase	Single-phase 220 ~ 240V	
For General Export	3-phase	200 ~ 220V	11
For JUS (LA) *	Single-phase	110 ~ 120V	37
FOI JUS (LA) "	3-phase	220 ~ 240V	38
For CE	Single-phase 220 ~ 240		34

Motor for SC

	Motor		Code	
For General Export	Single-phase	220 ~ 240V	60	
	3-phase	220 ~ 240 V	80	
For JUS (LA) *	Single-phase	100 ~ 120V	61	
F0I JUS (LA) *	3-phase	200 ~ 240V	62	
For CE	Single-phase	200 ~ 240V	63	

M

* JUS: North America and Central and South America.

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3

Computer-controlled, Direct-drive, High-speed, 1-needle, Lockstitch, Zigzag Stitching Machine

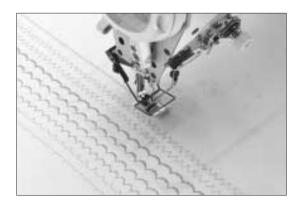
## LZ-2290SS LZ-2290SS-7 (with an automatic thread trimmer) LZ-2290SU-7 (with an anti-material-slip capability and an automatic thread trimmer)

- A single unit is extremely versatile and can perform straight stitching, standard zigzag stitching, 2-step zigzag stitching, 3-step zigzag stitching, scallop stitching, and blind stitching. As a result, the system is available for a far wider range of applications.
- You can quickly create an original stitching pattern on the operation panel and then try to sew it on a trial basis. The machine requires neither a programming device nor ROM writer.
- The machine adopts a direct-drive system featuring a compact AC servomotor directly coupled with the main shaft. This system offers excellent responsiveness and allows the machine to start up more quickly and stop with better accuracy.
- Newly developed long-arm machine head one size bigger than the conventional machine head.
- The machine is structured without an oil pan. Only clean oil is supplied from the oil tank installed on the machine to the hook and needle bar. The machine supports high-speed sewing in a clean working environment.



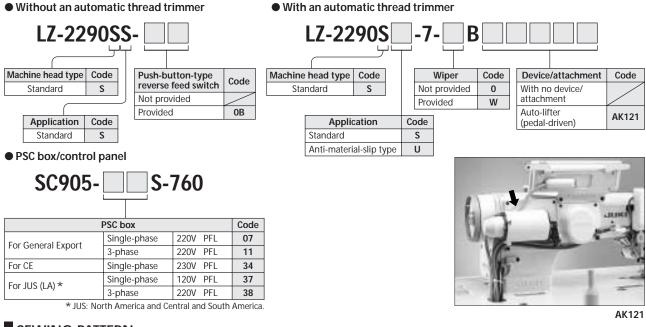
LZ-2290SS-7-WB

4



## SPECIFICATIONS

	1200000	17 000000 00	17 000000 7	17 0000011 7		
Model name	LZ-2290SS	LZ-2290SS-0B	LZ-2290SS-7	LZ-2290SU-7		
model name		With an anti-material-slip capability				
Max. sewing speed		4,500rpm				
wax. sewing speed	(for stand	lard zigzag stitching, the zig:	zag width has to be set to 4m	m or less)		
Max. zigzag width	Standard	zigzag: 8mm/2-step, 3-step	zigzag: 10mm (in increments o	of 0.1mm)		
Needle throw mechanism		Computer	-controlled			
Max. feeding amount		5.0mm (stepless fine adjustment)		2.5mm (stepless fine adjustment)		
Lift of the presser foot		By hand: 5.5mm	, By knee: 10mm			
Hook		DP hook (with a titani	um-treated inner hook)			
Thread take-up		Rotar	y type			
Needle (at the time of delivery)		SCHMETZ 438 (Nm75	), ORGAN DP × 5 (#10)			
Number of patterns for standard stitching	8 types/14 patterns					
Input function of the main unit	Provided as standard (operation panel)					
Bobbin thread winder	Built-in the machine head					
Push-button-type reverse feed switch	Option Provided as standard					
Machine head drive	Compact AC servomotor (direct-drive system)					
Lubrication		Minute-quantity lubrication	on to needle bar and hook			
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)					
Distance from needle to machine arm	300mm					
Bed size	517mm × 178mm					
Power requirement and power consumption	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V/Power rating 600VA					
Total weight	98	kg	100	Okg		



## **SEWING PATTERN**

The machine is provided as standard with fourteen different basic zigzag stitching patterns grouped into eight different types. You can choose the zigzag stitching pattern you want directly on the operation panel of the machine body. The zigzag width, needle throw position and number of blind stitches can also be easily adjusted on the operation panel.



Operation panel CP-760

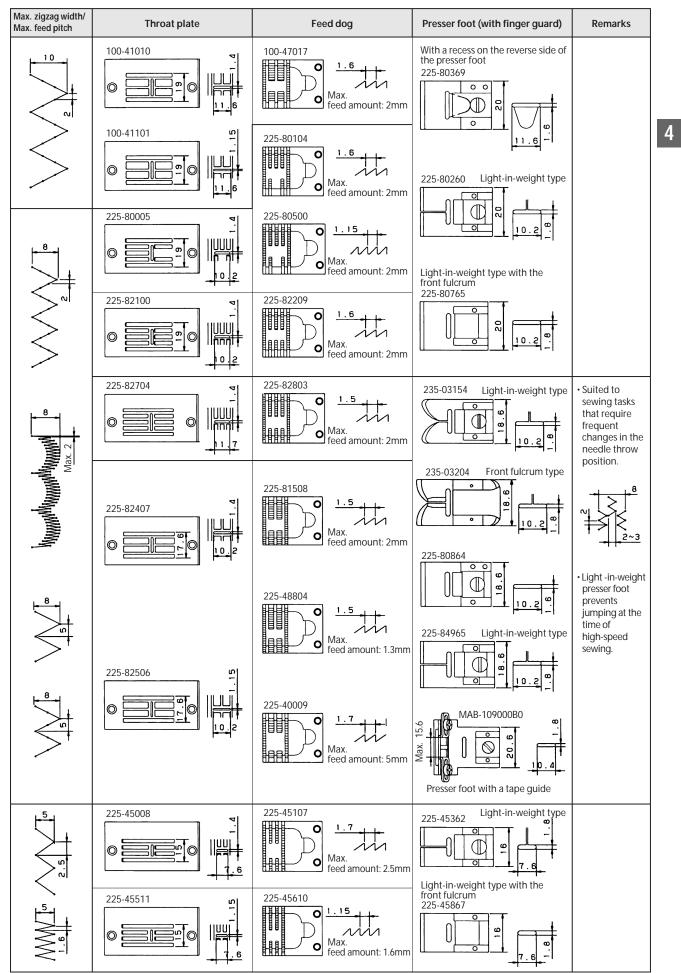
News	Charlinkt	Charal and	Chanaland	Chara danal						2		Scallo	p (left)			Scallop	(right)		Blind	Blind	0
Name of pattern	Straight stitch	Standard zigzag	2-step zigzag	3-step zigzag	Standard	Crescent	Equal- width	Equal- width	Standard	Crescent	Equal- width	Equal- width	stitch (left)	stitch (right)	Custom pattern						
Stitch pattern		$\sim$	$\sim$	$\sim$	hhhhh	MMMMM	NWWW	hun	hummmer -	MMMMM	MAMMAN	1 MM	$A_{A}A_{A}A$	$\sum_{i=1}^{n}$							
Number of stitches		2	4	6	24		12		24		12	2 +	- α	Max. 64							
Pattern selection key	0	2	2	$\sim$							٩										

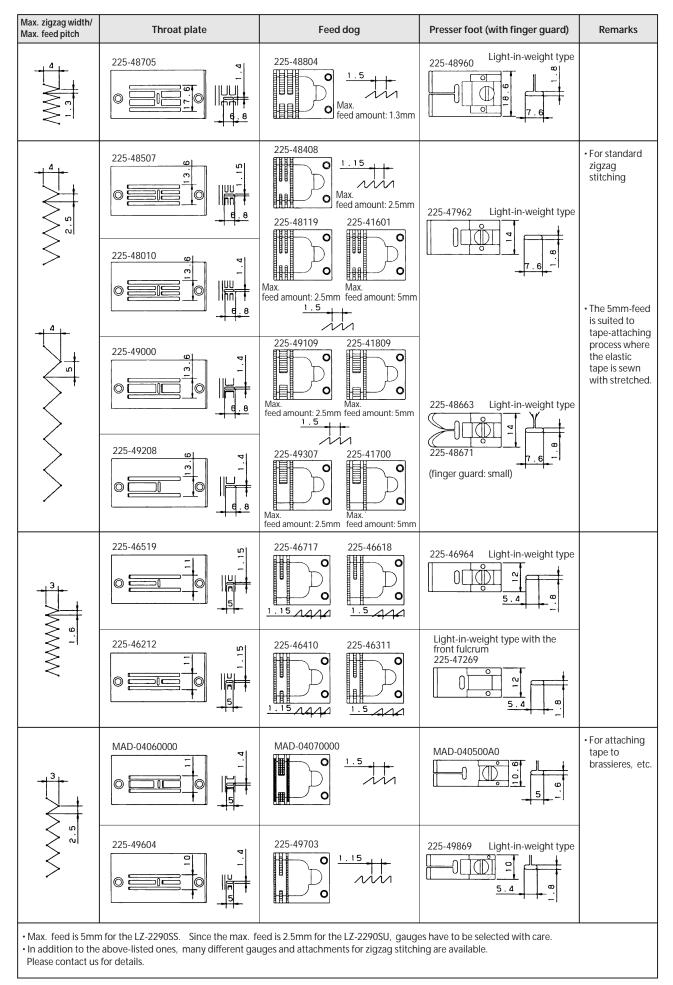
## OPTIONS

Model	Part No.	Desc	ription	Feature					
	235-46658	Automatic reverse feed kit		When this device is installed, the LZ-2290SS (without a thread trimmer) can perform reverse feed operation. (The mirroring switch for scallop stitching is used as the push-button-type reverse feed switch.)					
	D1501-583-H00	Presser bar							
	D1502-583-H00	Presser connecting rod	Presser foot connecting components	The aforementioned parts are used when a lockstitching type presser foot is installed on the machine.					
	SS-7091110-SP	Screw	components						
	225-26669	Non-lubricated hook (plastic hook with special race surface)		The hook effectively prevents oil stains. * When the hook is used, setscrews are required for the front of the hook-driving shaft (Part No.: 110-79506).					
	225-26560	Hard-point hook		The blade point of this hook prevents abrasion.					
	235-23152	Hook		The hook with a non-rotational bobbin eliminates sewing troubles resulting from bobbin idling. It provides a uniform bobbin thread tension at all times, thereby guaranteeing a					
	235-22550	Bobbin case asm.	Hook with a non- rotational bobbin						
	235-23004	Bobbin		consistent stitch formation.					
V059	MAV-059000AA	Tension-free feede (tape feeder)	ır	The amount of tape to be fed can be adjusted in accordance with the sewing speed of the machine. It is adaptable to processes for attaching reinforcement tape, attaching elastic tape or lace to foundation.					
S189A	MAS-189000AA	Elastic tape tensing device		Applies tension to desired portions of the tape fed from a tension-free tape puller. The device is started/stopped by operating the knee switch. This increases operator					
S189B	MAS-189000AB		9 401.00	productivity without interrupting the sewing work.					

LZ-2290SS, 2290SS-7, 2290SU-7 (June, 2001), 2/4 Downloaded from www.Manualslib.com manuals search engine

## LIST OF THE MAJOR GAUGES





LZ-2290SS, 2290SS-7, 2290SU-7 (June, 2001), 4/4 Downloaded from www.Manualslib.com manuals search engine

Computer-controlled, Direct-drive, High-speed, 1-needle, Lockstitch, Zigzag Stitching Machine [Dry-head type]

### LZ-2290DS LZ-2290DS-7 (with an automatic thread trimmer) LZ-2290DU-7 (with an anti-material-slip capability and an automatic thread trimmer)

- The non-lubricated head will never scatter oil, promising cleanly finished sewing products free from oil stains.
   Further, there will be no oil stains in the room around the machine, promising a cleaner working environment.
- The newly developed special-race plastic hook offers increased durability and upgraded sewing capabilities. It responds beautifully to various types of thread. The hook helps the machine produce consistent high-quality, seams by eliminating changes in the thread tension caused by fluctuating oil levels.
- The machine runs at a top sewing speed of 4,000rpm.
- The machine requires neither periodical oiling or adjustment of the oil level.



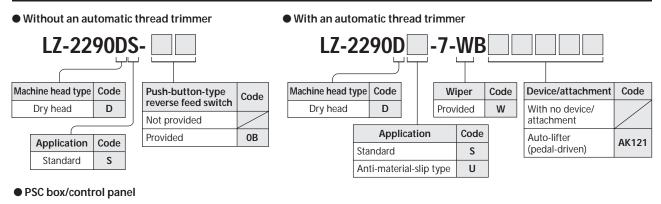
LZ-2290DS-7-WB

4



### SPECIFICATIONS

	LZ-2290DS	LZ-2290DS-0B	LZ-2290DS-7	LZ-2290DU-7				
Model name		Standard						
Max sources and		4,00	Orpm					
Max. sewing speed	(for stand	lard zigzag stitching, the zigz	ag width has to be set to 5m	o 5mm or less)				
Max. zigzag width	Standard	zigzag: 8mm/2-step, 3-step z	zigzag: 10mm (in increments o	of 0.1mm)				
Needle throw mechanism		Computer	-controlled					
Max. feeding amount		5.0mm (stepless fine adjustment)		2.5mm (stepless fine adjustment)				
Lift of the presser foot		By hand: 5.5mm	, By knee: 10mm					
Hook	Exclusive	Exclusive no-lubrication hook (plastic hook with special-purpose race surface)						
Thread take-up	Rotary type							
Needle (at the time of delivery)	SCHMETZ 438 (Nm75), ORGAN DP × 5 (#10)							
Number of patterns for standard stitching		8 types/14 patterns						
Input function of the main unit		Provided as standa	rd (operation panel)					
Bobbin thread winder		Built-in the n	nachine head					
Push-button-type reverse feed switch	Option		Provided as standard					
Machine head drive		Compact AC servomot	or (direct-drive system)					
Lubrication		No lubi	rication					
Distance from needle to machine arm		300	mm					
Bed size		517mm :	× 178mm					
Power requirement and power consumption	Single-pha	ase 100 ~ 120V, 200 ~ 240V, 3	3-phase 200 ~ 240V/Power rat	ing 600VA				
Total weight	98	kg	100	Okg				



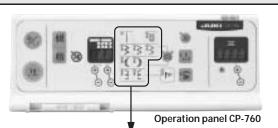
PSC box								
For General Export	Single-phase	220V PFL	07					
	3-phase	220V PFL	11					
For CE	Single-phase	230V PFL	34					
For JUS (LA) *	Single-phase	120V PFL	37					
	3-phase	220V PFL	38					

SC905- S-760

* JUS: North America and Central and South America.

### SEWING PATTERN

The machine is provided as standard with fourteen different basic zigzag stitching patterns grouped into eight different types. You can choose the zigzag stitching pattern you want directly on the operation panel of the machine body. The zigzag width, needle throw position and number of blind stitches can also be easily adjusted on the operation panel.



										1					
Name	Straight	Standard	2-step	3-step		Scallo	p (left)			Scallop	(right)		Blind	Blind	Custom
of pattern	stitch	zigzag	zigzag		Standard	Crescent	Equal- width	Equal- width	Standard	Crescent	Equal- width	Equal- width	stitch (left)	stitch (right)	pattern
Stitch pattern		$\mathcal{M}$	$\sim$	$\sim$	hhhhhh	MMMMM	MMMMMM	hun	hywwww	MMMMM	WHHMMW	MM		$\mathcal{M}$	
Number of stitches		2	4	6		24		12		24		12	2 +	- α	Max. 64
Pattern selection key	0	∑∎ Q	° ₽			P				Q-			۲	٩	

## OPTIONS

Model	Part No.	Descrip	otion	Feature				
	235-46658	Automatic reverse feed kit f		When this device is installed, the LZ-2290SS (without a thread trimmer) can perform reverse feed operation. (The mirroring switch for scallop stitching is used as the push-button-type reverse feed switch.)				
	D1501-583-H00	Presser bar						
	D1502-583-H00	Presser connecting rod	Presser foot connecting components	The aforementioned parts are used when a lockstitching type presser foot is installed on machine.				
	SS-7091110-SP	Screw	components					
V059	MAV-059000AA	Tension-free feeder (tape feeder)		The amount of tape to be fed can be adjusted in accordance with the sewing speed of the machine. It is adaptable to processes for attaching reinforcement tape, attaching elastic tape or lace to foundation.				
S189A	MAS-189000AA	Flastic tang tons	ing device	Applies tension to desired portions of the tape fed from a tension-free tape puller. The device is started/stopped by operating the knee switch. This increases operator				
S189B	MAS-189000AB	Elastic tape tensing device		productivity without interrupting the sewing work.				

LZ-2290DS, 2290DS-7, 2290DU-7 (June, 2001) 2/2 Downloaded from www.Manualslib.com manuals search engine High-speed, 1-needle, Lockstitch, Zigzag Stitching Machine

## LZ-2280N SERIES

- The hook driving shaft offset mechanism assures trouble-free and consistent zigzag stitching.
- The market-proven hook and thread take-up lever enables sewing with upgraded consistency with a lower tension applied to the thread.
- Greater durability is secured by preventing the hook from heating up when the machine is running at high speeds.
- The highly reliable machine head is structured to reduce operating noise and prevent oil leakage.
- The machine ensures easy adjustment of zigzag width and feed pitch.
- The adjustable range of the feed mechanisms has been widened, thereby upgrading the machine's responsiveness to materials.



LZ-2284N-7-WB/CP-160B

4

## LZ-2280N (standard zigzag)

• The standard zigzag stitching machine creates softly finished seams. The needle rocking mechanism is provided with a triangular cam which helps produce beautiful seams with consistency.

## LZ-2282N (standard zigzag/with a lower knife) LZ-2282N-7 (standard zigzag/with a lower knife and an automatic thread trimmer)

• The machine incorporates a built-in lower knife that trims only the lower material. This allows the machine to simultaneously attach lace to the body of the foundation and trim only the body during processes to attach lace to the bottoms or tops of slips or to the joint seam lines of shorts.

## LZ-2286N (3-step zigzag)

The maximum needle throw is 10mm. The needle rocking mechanism means a higher degree of accuracy, thereby leading to a very high performance.

## LZ-2288N (with changeable pattern cams)

• The machine is able to perform eleven different kinds of zigzag stitching only by a quick procedure to replace the cams.

## LZ-2285N (fagoting)

• The pressure of the fagoting holder can be separately adjusted by the left- and right-hand sections in order to prevent an uneven material feed

## LZ-2281N (standard wider zigzag)

• Two kinds of gauges can be selected in accordance with the application of the machine: an A-type gauge with a zigzag width of 5mm, and a B-type gauge with a zigzag width of 8mm. The needle rocking cam is provided with a triangular cam which helps produce beautiful seams with consistency.

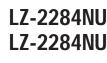
## LZ-2284N (with a standard/3-step zigzag stitching pattern changeover function) LZ-2284N-7 (with a standard/3-step zigzag stitching pattern changeover https://www.communication.com/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/communication/commu

• The operator can easily switch the needle-throwing pattern between the standard and 3-step zigzag stitching patterns using the lever located in the free space under the arm.

(Time required: Approx. 15 sec)

When changing the sewing product or design, there's no need to adjust the sewing machine head or machine layout.

## LZ-2280NU (standard zigzag/ with an anti-material-slip capability)



LZ-2284NU (with a standard/3-step zigzag stitching pattern changeover function and an anti-material-slip capability) LZ-2284NU-7 (with a standard/3-step zigzag stitching pattern changeover function, an anti-material-slip capability and an automatic thread trimmer)

- With its newly developed feed mechanism, the machine prevents "uneven feed of the upper and lower cloths" when sewing girdles and body suits made of slippery, elastic materials.
- Drop-feed sewing machines have been widely said to feed in the lower cloth more quickly than the upper cloth. However, this machine prevents uneven feed between the upper and lower cloths in spite of its a drop-feed mechanism.

In appearances, the gauge parts are identical to those of a conventional zigzag stitching machine, and operability is in no way affected by the newly developed feed mechanism.

LZ-2280N, 2281N, 2282N, 2282N-7, 2284N, 2284N-7, 2286N, 2288N, 2285N, 2280NU, 2284NU, 2284NU-7 (June, 2001) 1/6 Downloaded from www.Manualslib.com manuals search engine

### SPECIFICATIONS

Model	Without an automatic thread trimmer	LZ-2280N	LZ-2281N	LZ-2282N	LZ-2284N	LZ-2286N	LZ-2288N	LZ-2285N	
name	With an automatic thread trimmer			LZ-2282N-7	LZ-2284N-7				
Stitch s	ystem	Standard zigzag	Standard wider zigzag	Standard zigzag (with a lower knife)	Standard/ 3-step zigzag	3-step zigzag	With changeable pattern cams	Fagoting	
Stitch pattern		$\sim$	$\sum$		~~ <del>~</del> ~~~	$\sim$	Refer to the specifications for pattern cam	$\checkmark$	
Max. sewing speed		5,500rpm			5,000rpm			4,000rpm	
Max. zi (mm)	gzag width	5.0	5.0 (A type) 8.0 (B type)	4.5	5.0 (standard) 10.0 (3-step)	10.0	8.0 (standard:6.0)	8.0	
Max. fe (mm)	eding amount	2.5	2.5 (A type) 5.0 (B type)	2.5	2.5 (standard) 2.0 (3-step)	2.0	2.5	2.2	
	tting allowance r knife (mm)			3.0					
Lower k method	nife driving			AC motor					
Lift of t (mm)	he presser foot	By hand: 5.5, By knee: 10.0         By hand: 4.0 By knee: 8.5         By hand: 5.5, By knee: 10.0							
Hook				DP hook (with	n a titanium-treate	ed inner hook)			
Thread	take-up				Rotary type				
Lubrica	tion				Fully automatic				
Lubrica	ting oil			JUKI New Defri	x Oil No.1 (equival	ent to ISO VG7)			
Needle (at the t	time of delivery)		SCH	IMETZ 438 (Nm75)	, ORGAN DP × 5 (	#10)		SCHMETZ 438SUK (#80)	
Needle changir	position 1g mechanism			Provided a	s standard				
	Reverse feed stitching nechanism Provided as standard								
	throw direction -over mechanism						Provided as standard		
Needle cam	throw pattern		Triangular cam			Groov	ed cam		
Number specifie	r of pattern cams d						11 *		

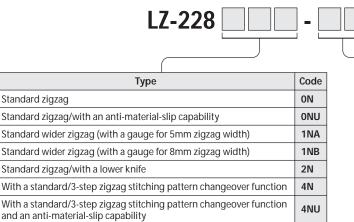
* LZ-2288N: Selectable form five different cams; Standard zigzag stitching cam, 3-step zigzag stitching cam, 2-step zigzag stitching cam, standard scalloping cam, crescent scalloping cam. Other cams are optionally available.

#### Anti-material-slip type

Model	Without an automatic thread trimmer	LZ-2280NU	LZ-2284NU			
name	With an automatic thread trimmer		LZ-2284NU-7			
Stitch s	ystem	$\sim$	$ \land \bullet \land \land \land $			
Max. se	ewing speed	4,500rpm				

### WHEN YOU PLACE ORDERS

#### LZ-2280N series (without an automatic thread trimmer)



Code
0B

LZ-2284NT, -2286NT and -2285N are not classified by the automatic reverse feed function.

• LZ-2280N-7 series (with an automatic thread trimmer)

With a standard/3-step zigzag stitching pattern changeover function

and with a tape attaching foot capability

3-step zigzag/with a tape attaching foot

With changeable pattern cams/Standard zigzag

With changeable pattern cams/3-step zigzag

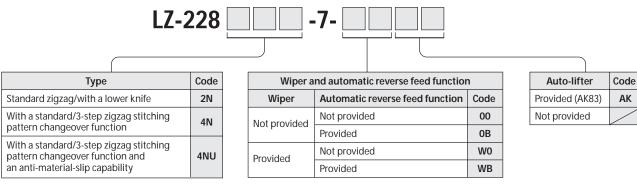
With changeable pattern cams/2-step zigzag

With changeable pattern cams/Standard scalloping

With changeable pattern cams/Crescent scalloping

3-step zigzag

Fagoting



4NT

6N

6NT

8NA

8NB

8NC

8ND

8NE

5N

#### PSC box/control panel/motor for SC



	Р	SC box		Code
For General Export	Single-phase	* PFL	Japanese, English, Chinese	07
	220V	PTL	English, German, French, Spanish, Italy	08
	3-phase	* PFL	Japanese, English, Chinese	11
	220V	PFL	English, German, French, Spanish, Italy	12
For CE	Single-phase 230V	* PFL	English, German, French, Spanish, Italy	34
** For JUS	Single-phase 120V	* PFL	English, German, French, Spanish, Italy	37
(LA)	3-phase 220V	* PFL	English, German, French, Spanish, Italy	38

For zigzag stitching machine	Z

Control panel	Code
CP-60	060
CP-160	160

AK

#### * If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

** JUS: North America and Central and South America.

## OPTIONS

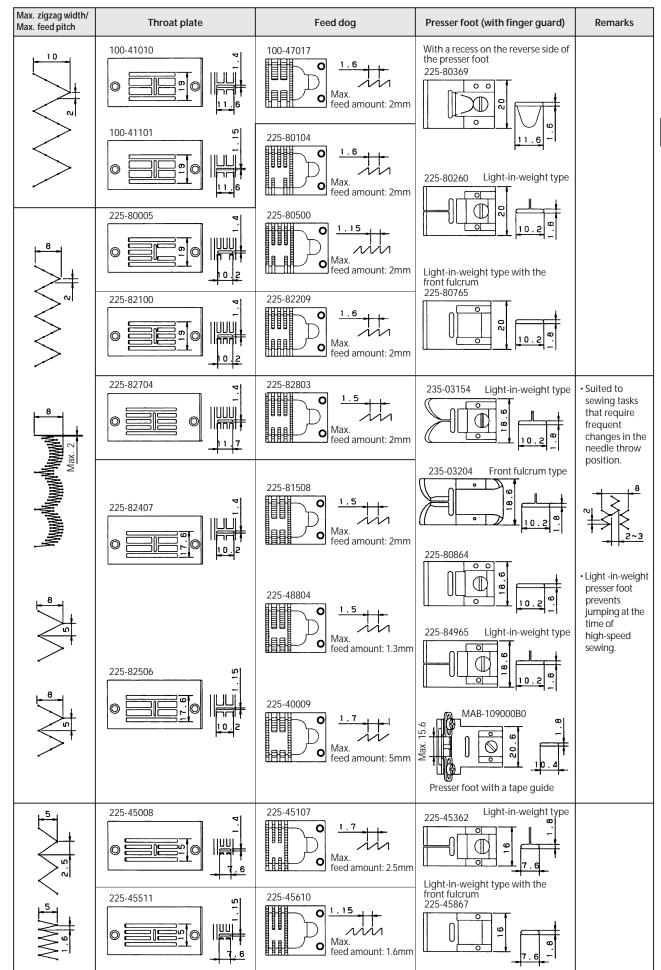
Model	Part No.	Desc	ription	Feature					
	225-61559	Automatic reverse	feed kit	This device allows a machine without a thread trimmer to perform automatic reverse feed function.					
	D1501-583-H00	Presser bar							
	D1502-583-H00	Presser connecting rod	Presser foot connecting components	The aforementioned parts are used when a lockstitching type presser foot is installed on the machine.					
	SS-7091110-SP	Screw	components						
	225-26669	Non-lubricated how (plastic hook with s	ok special race surface)	The hook effectively prevents oil stains. * When the hook is used, setscrews are required for the front of the hook-driving shaft (Part No.: 110-79506).					
	225-26560	Hard-point hook		The blade point of this hook prevents abrasion.					
	235-23152	Hook		The hook with a non-rotational bobbin eliminates sewing troubles resulting					
	235-22550	Bobbin case asm.	Hook with a non- rotational bobbin	from bobbin idling. It provides a uniform bobbin thread tension at all times,					
	235-23004	Bobbin		thereby guaranteeing a consistent stitch formation.					
V059	MAV-059000AA	Tension-free feede (tape feeder)	r	The amount of tape to be fed can be adjusted in accordance with the sewing speed of the machine. It is adaptable to processes for attaching reinforcement tape, attaching elastic tape or lace to foundation.					
S189A	MAS-189000AA	Elastic tano tonsing	n dovico	Applies tension to desired portions of the tape fed from a tension-free tape puller.					
S189B	MAS-189000AB	Elastic tape tensing device		The device is started/stopped by operating the knee switch. This increases operator productivity without interrupting the sewing work.					
RF-1		Pedal-operated rev device	verse feed stitching	The device enables the operator to perform reverse feed stitching using the pedal without using the right hand. (excluding the LZ-2285N)					

## LZ-2288N SPECIFICATIONS OF PATTERN CAM

Name of pattern	Standard zigzag	3-step zigzag	2-step zigzag	Standard scallop	Crescent scallop	Equal-width scallop	Equal-width scallop	Blind stitch	Blind stitch	Blind stitch	Blind stitch
Part No.	225-68851	225-68950	225-69057	225-69156	225-69255	225-69354	225-69453	225-69552	225-69651	225-69750	225-69859
Part name	Pattern cam A	Pattern cam B	Pattern cam C	Pattern cam D	Pattern cam E	Pattern cam F	Pattern cam G	Pattern cam H	Pattern cam J	Pattern cam K	Pattern cam L
Max. zigzag width (mm)	* 6.0	8.0	8.0	8.0	8.0	8.0	8.0	6.0	6.0	6.0	6.0
Max. pattern width (mm)				2.4	3.6	3.4	2.4				
Number of stitches	2	6	4	24	24	24	12	4	6	8	12
Stitch pattern	MMM	Ŵ	MMM	Right Annound Annound	Right Number of the second sec	Right Hummunt (77544444444444444444444444444444444444	Right	Right WWWWW Left	Right VVVV Left	Right	Right VVV Left

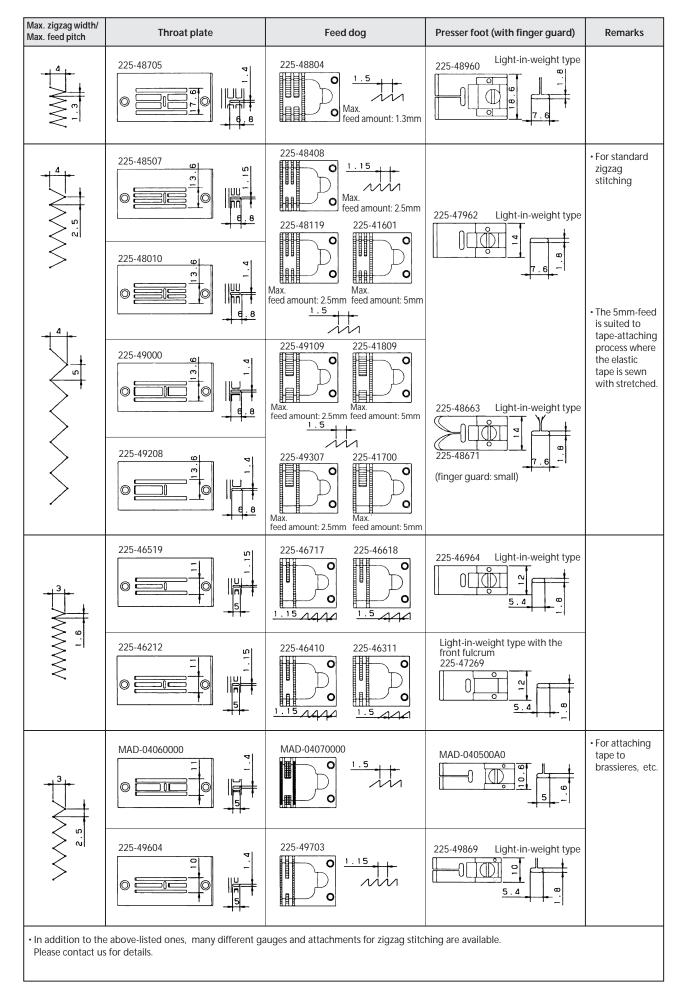
* For standard zigzag stitching and blind stitching, set the zigzag width to 5mm or less when the machine runs at a sewing speed of 4,200rpm or more.

## LIST OF THE MAJOR GAUGES



4

Downloaded from www.Manualslib.com manuals search engine LZ-2280N, 2281N, 2282N, 2282N-7, 2284N, 2284N-7, 2286N, 2288N, 2285N, 2280NU, 2284NU, 2284NU-7 (June, 2001) 5/6



LZ-2280N 2281N 2282N, 2282N-7, 2284N, 2284N-7, 2284N-7, 2286N, 2288N, 2285N, 2280NU, 2284NU, 2284NU-7 (June, 2001) 6/6 Downloaded from www.Manualshb.com manuals search engine

#### 1-needle, Embroidering Sewing Machine

## LZ-271

- This machine can be used for extra light-weight materials including lawn and organdy, medium-weight materials including those used for blouses and handkerchieves, and heavy-weight materials on which names and labels are to be embroidered.
   Beautifully finished seams free from needle swaying or material breakage are assured every time.
- The zigzag width is regulated up to 12mm using the knee lifter. This knee lifter has been designed to fit the jut-type knee lifter widely used by zigzag stitch machines.



LZ-271

4

## 1-needle, Lockstitch, Zigzag and Embroidering Sewing Machine

## LZ-391N

• When this machine is used as an embroidering machine, the zigzag width is as large as 12mm and the sewing speed is as high as 1,700rpm. When used as a zigzag stitch machine, the zigzag width is as large as 10mm and the sewing speed is as high as 2,000rpm.

Furthermore, the JUKI LZ-391N can be used as a straight stitching machine capable of running at a speed of 2,000rpm by simply setting the zigzag width to 0.

• To change from embroidering to zigzag stitching or vice versa, all you need to do is install the throat plate exclusive for either function, and install/remove the presser bar and feed dog. This procedure can be carried out very easily.

# High-speed, 1-needle, Lockstitch, Zigzag Stitching Machine

- While the needle is piercing the cloth, the needle bar does not throw. So, with this feature, tearing the sewing cloth and curving or breaking of the needle is prevented to produce beautifully sewn seams.
- In order to facilitate smooth passing of the thread around the bobbin case, a thread opener is equipped on these models.
   Thus, beautiful stitches without flaws can be produced constantly.
- As the machines are equipped with completely automatic lubrication system by which all essential parts are automatically lubricated by means of plunger pump, there is no worry of scorching of parts to ensure durability and also eliminates troublesome hand oiling.

#### Applications

Light-, medium-, heavy-weight materials: Attaching laces to undergarments, table cloth, etc. gathering of negligees, etc. Heavy weight materials: Attaching sweat bands to hats; closing stitches on heels; hemming of rubber corded materials; stitching of all leather goods



LZ-391N



LZ-586

## SPECIFICATIONS

Model name	LZ-271
Application	Embroidering on light-, medium-, and heavy-weight materials
Max. sewing speed	2,000rpm (with a zigzag width set to 10mm) 1,700rpm (with a zigzag width set to 12mm)
Thread take-up	Link type
Needle bar stroke	33.4mm
Needle (at the time of delivery)	DB × 1 (#11) #9 ~ #18
Zigzag width	0 ~ 12mm
Zigzag width regulating method	Using the jut-type knee lifter with the zigzag width pointer released.
Hook	DB-type hook for embroidering
Distance from needle to machine arm	270mm (from the needle entry bottom of the arm)
Lubrication	By an oiler
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)

Model name	LZ-391N
Application	Embroidering and zigzag stitching light-, medium-, and heavy -weight materials
Max. sewing speed	2,000rpm (with a zigzag width set to 10mm) 1,700rpm (with a zigzag width set to 12mm)
Thread take-up	Link type
Needle bar stroke	33.4mm
Max. stitch length	5mm
Stitch length adjustment method	Moving the knob up/down
Needle (at the time of delivery)	DB × 1 (#14) #9 ~ #16
Zigzag width	0 ~ 12mm
Zigzag width regulating method	Using the knee lifter with the zigzag width pointer released. If you sew the product with the zigzag width fixed to a certain value, the pointer should be fixed to that value.
Hook	DB-type hook for embroidering (capable of using a thick thread)
Distance from needle to machine arm	270mm (from the needle entry bottom of the arm)
Lubrication	By an oiler
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)

Model name	LZ-586
Max. sewing speed	3,500rpm
Thread take-up	Link type
Needle bar stroke	30.7mm
Max. stitch length	4mm
Stitch length adjustment method	Dial system
Lift of the presser foot	By hand: 6mm, By knee: 10mm
Reverse feed stitching	Lever system
Needle (at the time of delivery)	DP × 58 or DP × 5 (#14) #11 ~ #18
Zigzag width	0 ~ 6mm
Hook	DB-type fully rotating hook
Lubrication	Automatic
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)

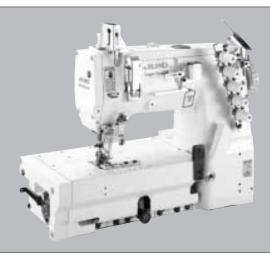
## ATTACHMENTS

Part No.	Description	Apprication
B3352-271-0A0	Compass (asm.)	
B1502-391-BA0	Presser bar joint rod B (asm.)	LZ-271, LZ-391N
B5001-271-0A0	Scallop (asm.)	

Flat-bed, Bottom/Top & Bottom Covering Stitch Machine

## **MF-7000 SERIES**

- The MF series a new line of multi-purpose subclass models (with universal gauges) that respond to the diversified sewing processes and stitch specifications demanded by customers in various markets.
- The max sewing speed is 6,500rpm for both bottom covering stitching and top-and-bottom covering stitching. With its excellent performance, the machine promises higher reliability and demonstrates high-quality, consistently finished seams that ideally suit the materials and processes used.
- Adjustment is seldom necessary when changing the type or color of the thread, and if it is, it is kept to a minimum.
- The low-vibration and low-noise design of the machine enables the operator to concentrate on sewing works in a more comfortable environment.



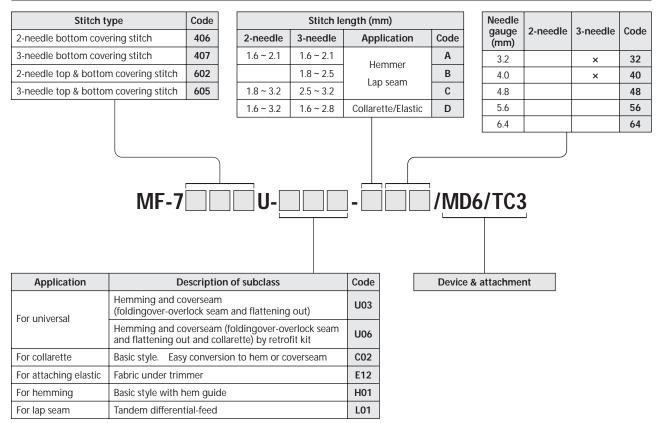
MF-7605U-U03-B56

5

### SPECIFICATIONS

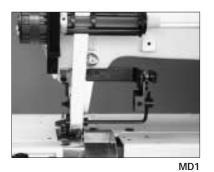
Model name	MF-7406	MF-7407	MF-7602	MF-7605						
Stitch type	2-needle bottom covering stitch	3-needle bottom covering stitch	2-needle top & bottom covering stitch	3-needle top & bottom covering stitch						
Max. sewing speed	6,500rpm									
Stitch length	1.6 ~ 3.2mm									
Differential-feed ratio	Gathering stitch 1:1.5, Stretching stitch 1:0.6									
Needle gauge (mm)	3.2, 4.0	4.8, 5.6, 6.4	3.2, 4.0	4.8, 5.6, 6.4						
Needle (at the time of the delivery)		UY128GAS (#70/027) #65/025 ~ #90/036								
Lift of the presser foot		8 mm								
Lubrication		Auto	matic							
Lubricating oil		JUKI New Defrix Oil No.2	(equivalent to ISO VG32)							

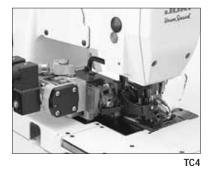
## WHEN YOU PLACE ORDERS

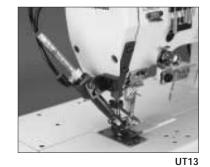


### **DEVICES AND ATTACHMENTS**

Model	Description		Applicab	le models	Application	
woder	Description	7406	7407	7602	7605	- Application
Elasti	c tape metering device					
MD1	Single stage function top tape metering device Pulse motor type					
MD2	Two stage function top tape metering device Pulse motor type					For E12
MD6	Single stage function top tape metering device Mechanical type					
Elasti	c tape cutter		-			
TC2	Pneumatic type					
TC3	Electromagnetic type					Collarette/Elastic
TC4	Pneumatic type (fast-action type)					
Chain	cutter					
CC1	Pneumatic type chain-off thread cutter (mounted horizontal venturi suction)					
Threa	d trimming device					
UT12	Pneumatic type (mechanical wiper + auto-lifter)					
UT13	Pneumatic type (top and bottom thread trimmer + auto-lifter)					
Cloth	puller					
PL5						







## EXAMPLE OF APPLICATION: MULTIPURPOSE UNIVERSAL STYLE (UNIVERSAL GAUGES)

#### (U03

This model responds to a host of different processes, including bottom-covering for T-shirts and polo-shirts, folding-over for overlocked sleeves and garment bodies, and flattening-out of overlocked fleece. Recommended model: MF-7605U-U03-B56

#### (U06

This model is designed to handle hemming and coverseams for T-shirts and trainers. It is also used for collarette for knitwear and underwear by replacing the gauge components. Recommended model: MF-7605U-U06-B56 **C02** 

This model is intended for collarette for underwear, briefs, and ladies' knitwear. Recommended model: MF-7605U-C02-B56/TC3

### U06 C02 EASY TO CHANGE BY REPLACING PARTS

Parts No.

6.4mm

50326BW

50305CB

50324DF64

#### $C02 \Rightarrow U06$

Sewing parts
Parts name

Kit No.: 29480FC02U06J + Kit No.: 29480FU06C02J

 $U06 \Rightarrow C02$ 

+

Sewing parts									
Parts I	name	Parts No.							
	Needle gauge	4.0 mm	4.8 mm	5.6 mm	6.4 mm				
Needle clamp		50318AM40	50318AM48	50318AM56	50318AM64				
Presse	er foot	50320CB40	50320CB48	50320CB56					
Differe	ential-feed dog	5032	26BV	50326BT					
Main f	eed dog	5030	)5BZ	50305BX					
Throat plate		50324AU40	50324AU48	50324AU56	50324AU64				

MF-7000 SERIES (June, 2001) 2/8 Downloaded from <u>www.Manualslib.com</u> manuals search engine

Needle gauge

Differential-feed dog

Main feed dog

Throat plate

Needle clamp	50318AM56	50318AM64
Presser foot	50320	CD56

5.6mm

50326BP

50305BW

50324DF56

### SUBCLASS MACHINE LIST

Seams	Model No.	Number of needles	Number of threads	H ⊢ Needle gauge (mm)	Max. stitch length (mm)	Bottom differential feed ratio	Presser lifting amount (mm)	Max. sewing speed (rpm)	Devices
For unive	rsal (hemming, coversear	n: foldin	gover-ov	erlock se	am, coverse	eam: flatteni	ng out)		
	MF-7605U-U03-B56		_	5.6	4.0.05			( 500	UT13, CC1
*1	MF-7605U-U03-B64	3	5	6.4	1.8 ~ 2.5	1:0.4 ~ 1:2.8	8	6,500	PL5
For unive	rsal (hemming, coversear	n: foldin	gover-ov	erlock se	am, coverse	eam: flatteni	ng out, co	ollarette) b	y retrofit kit
	MF-7605U-U06-B56		_	5.6	4.0.05		_	( 500	UT13
*2	MF-7605U-U06-B64	3	5	6.4	1.8 ~ 2.5	1:0.4 ~ 1:2.8	8	6,500	PL5
For collar	ette		1	II					I
	MF-7602U-C02-B40	2	4	4.0					
	MF-7605U-C02-B48			4.8	- 1.8 ~ 2.5	1:0.3 ~ 1:3.6	8	6,500	TC2/3/4
- ALARSAN	MF-7605U-C02-B56	3	5	5.6					
""	MF-7605U-C02-B64			6.4					
For attach	ning elastic	1	1	II			I		
	MF-7602U-E12-B40/MD1								
	MF-7602U-E12-B40/MD2	2	4	4.0					
	MF-7602U-E12-B40/MD6								
	MF-7605U-E12-B48/MD1								
	MF-7605U-E12-B48/MD2			4.8					
and the second s	MF-7605U-E12-B48/MD6						_		
Caller Street	MF-7605U-E12-B56/MD1				1.6 ~ 2.8	1:0.3 ~ 1:3.0	7	5,500	TC2/3/4
''t	MF-7605U-E12-B56/MD2	3	5	5.6					
	MF-7605U-E12-B56/MD6								
	MF-7605U-E12-B64/MD1								
	MF-7605U-E12-B64/MD2			6.4					
	MF-7605U-E12-B64/MD6								
For hemm	ning	1	1	<u> </u>		1	1	1	1
	MF-7602U-H01-A40	2	4	4.0		1:0.3 ~ 1:3.6			
				4.0					UT12 001

	MF-7602U-H01-A40	2	4	4.0		1:0.3 ~ 1:3.6			
	MF-7605U-H01-A48			4.8	1.6 ~ 2.1		8	6,500	UT13, CC1
A States	MF-7605U-H01-A56	3	5	5.6	1.0 ~ 2.1	1:0.4 ~ 1:2.8	-	0,000	PL5
	MF-7605U-H01-A64			6.4					

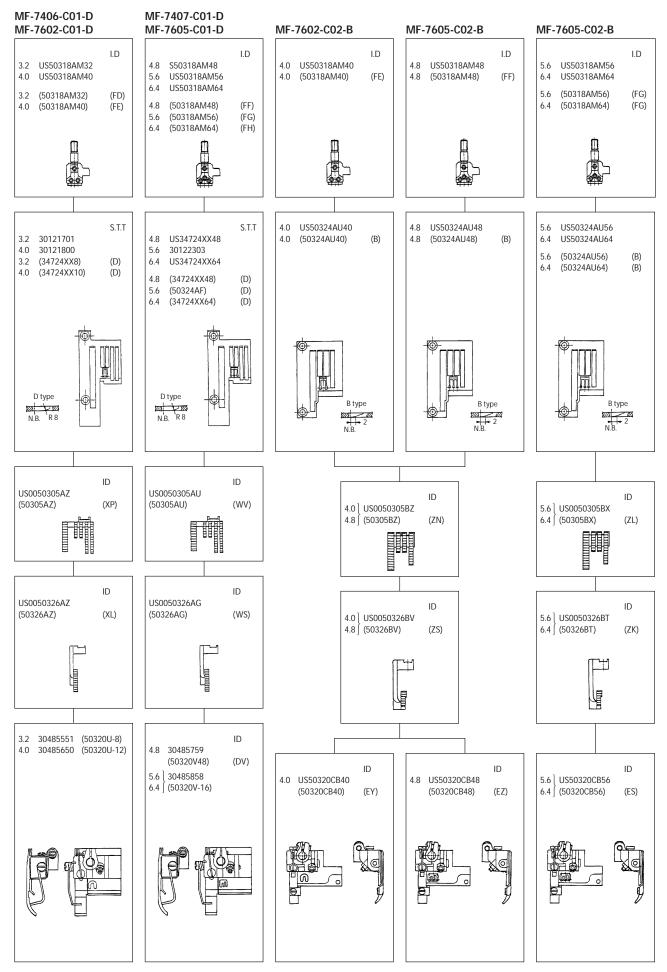
• For lap seam

	MF-7605U-L01-B48			4.8					UT12_001
	MF-7605U-L01-B56	3	5	5.6	1.8 ~ 2.5	1:0.4 ~ 1:2.4	8	6,500	UT13, CC1
A State of the second s	MF-7605U-L01-B64			6.4					PL5

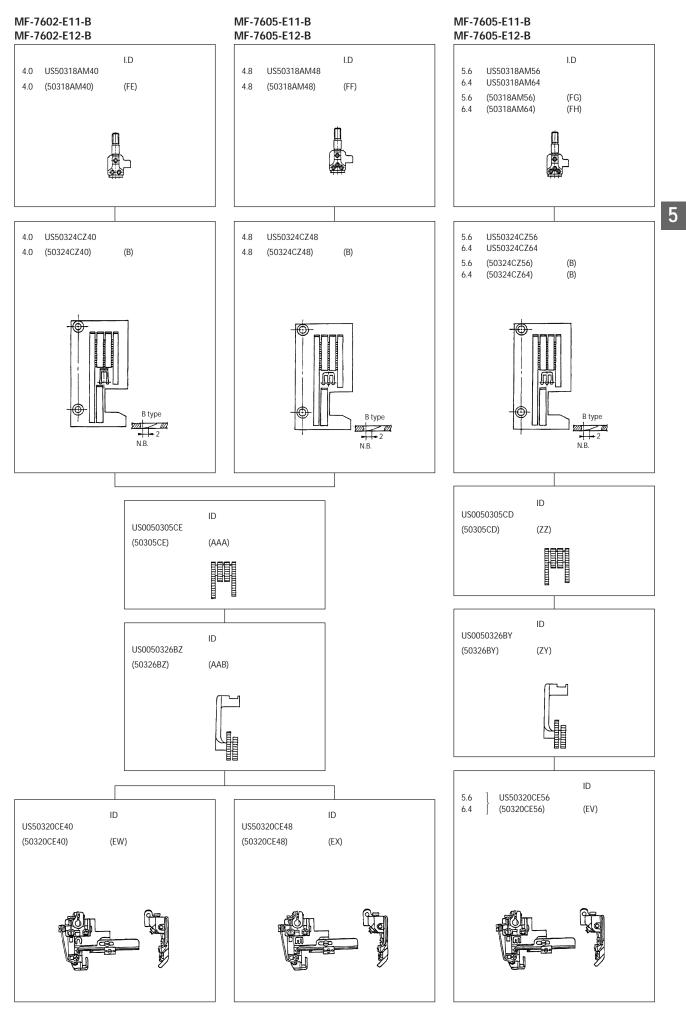


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### GAUGE PARTS CONSTRUCTION CHART OF MF-7000 SERIES

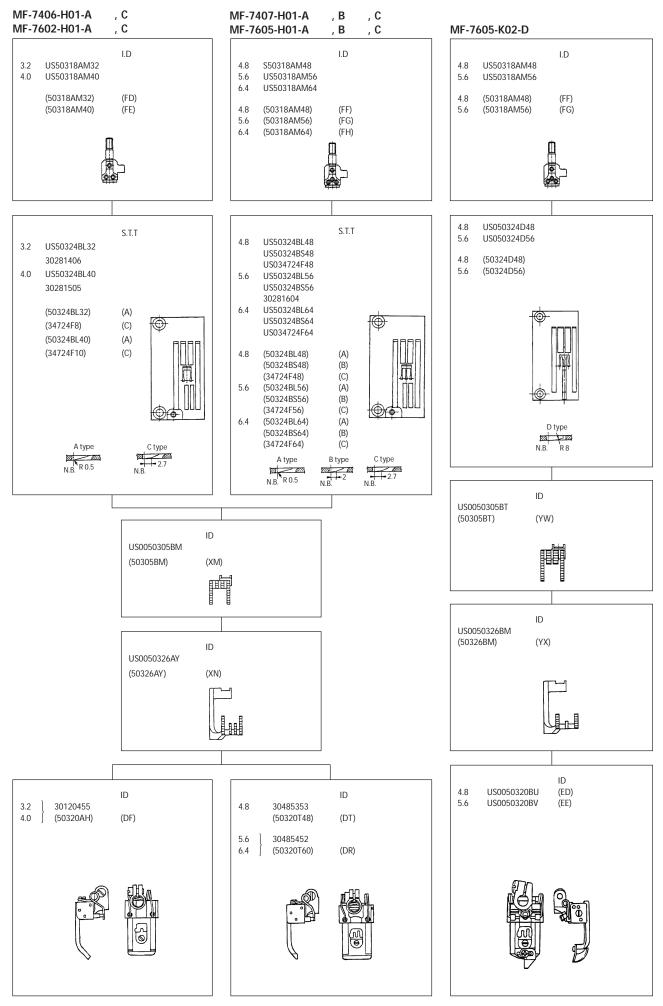


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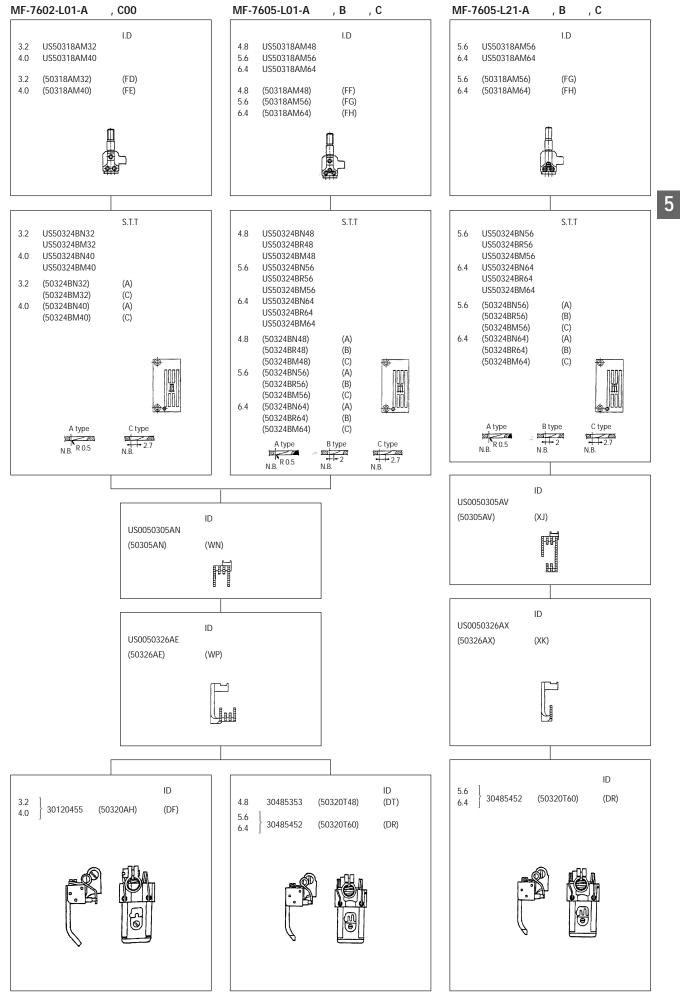


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MF-7000 SERIES (June, 2001) 5/8

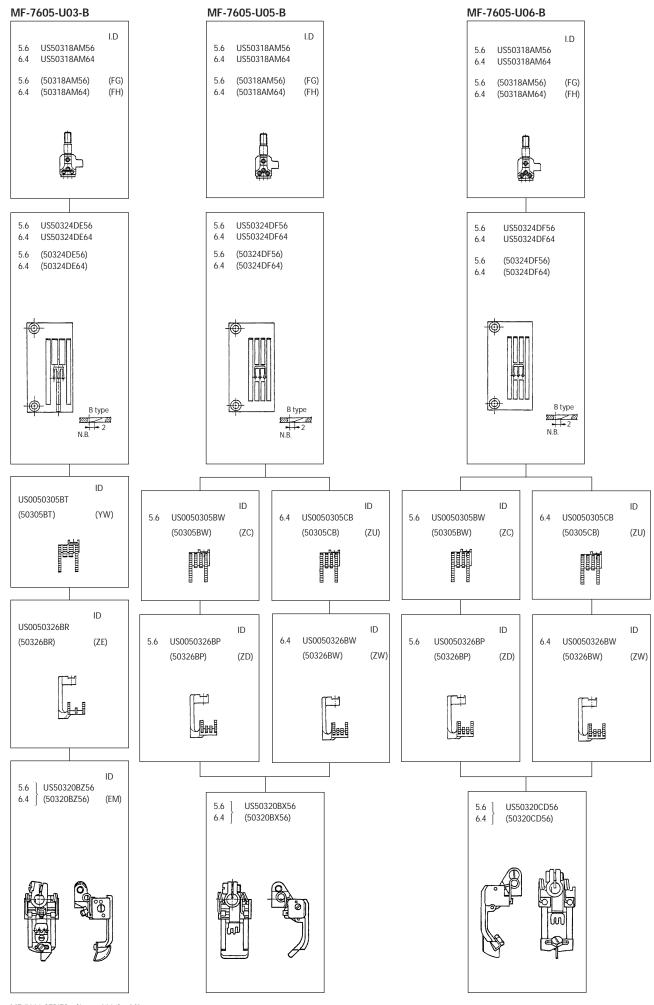


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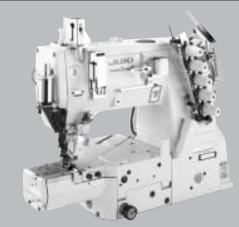
MF-7000 SERIES (June, 2001) 7/8



MF-7000 SERIES (June, 2001) 8/8 Downloaded from <u>www.Manualslib.com</u> manuals search engine Cylinder-bed, Bottom/Top & Bottom Covering Stitch Machine

## **MFC-7000 SERIES**

- The MFC series a new line of multi-purpose subclass models (with universal gauges) that respond to the diversified sewing processes and stitch specifications demanded by customers in various markets.
- The machine smoothly and consistently produces well-tensed seams with a low tension applied to the thread, finishing materials without thread breakage or thread flapping even when elastic woolly thread is used.
- With this mechanism, the needle thread and looper thread can be tucked with greater consistency, thereby reducing the occurrence of sewing troubles such as stitch skipping. This added advantage enhances the machine's ability to produce high-quality seams on all kinds of heavy-to light-weight materials.

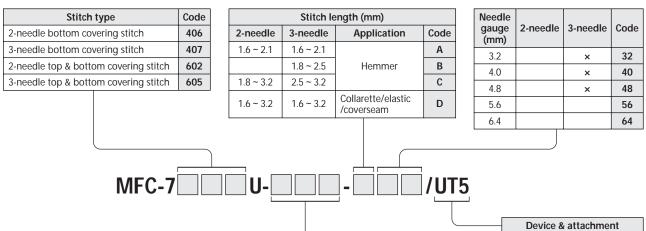


MFC-7605U-U03-B56/UT2

### SPECIFICATIONS

Model name	MFC-7406	MFC-7407	MFC-7602	MFC-7605						
Stitch type	2-needle bottom covering stitch	3-needle bottom covering stitch	2-needle top & bottom covering stitch	3-needle top & bottom covering stitch						
Max. sewing speed	6,500rpm									
Stitch length	1.6 ~ 3.2mm									
Differential-feed ratio	Gathering stitch 1:1.3, Stretching stitch 1:0.5									
Needle gauge (mm)	3.2, 4.0, 4.8	5.6, 6.4	3.2, 4.0, 4.8	5.6, 6.4						
Needle (at the time of the delivery)		UY128GAS (#70/027) #65/025 ~ #90/036								
Lift of the presser foot	7 mm									
Lubrication	Automatic									
Lubricating oil		JUKI New Defrix Oil No.2	(equivalent to ISO VG32)							

## WHEN YOU PLACE ORDERS

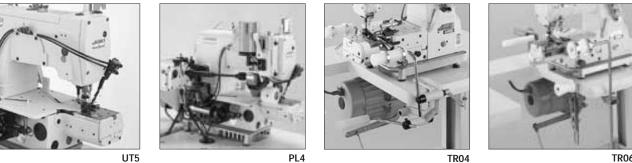


		1					
Application	Description of subclass						
	Hemming and coverseam (foldingover-overlock seam and flattening out)	U03					
For universal	Hemming and coverseam (foldingover-overlock seam and flattening out and collarette) by retrofit kit	U06					
	Hemming and coverseam (foldingover-overlock seam and flattening out) including conversion parts	U02					
For collarette	Basic style. Easy conversion to hem or coverseam	C02					
	Left hand fabric trimmer						
For hemming	For hemming with left hand fabric trimmer & rear puller						
	With puller. On pre-closed waists and neck, arm, and leg openings with pre-attched elastic.	H11					
	Preclosed elastic tape attaching & fabric under trimmer for waistband to brief	E11					
For attaching elastic	Preclosed elastic tape attaching & fabric under trimmer for waistband to brief (with rear puller)						
For hemming	Basic style with hem guide	H01					
For coverseam	Standard fixed seam guide for light-weight materials						
	Adjustable seam guide for medium-to heavy-weight materials						

5

### **DEVICES AND ATTACHMENTS**

Model	Description		Applicable models					
woder	Description	7406	7407	7602	7605	Application		
There	ad trimming device							
UT1	Electromagnetic type (mechanical wiper + auto-lifter)							
UT2	Electromagnetic type (top & bottom thread trimmer + auto-lifter)							
UT3	Pneumatic type (mechanical wiper + auto-lifter)							
UT4	Pneumatic type (air blow type wiper + auto-liter)							
UT5	Pneumatic type (top & bottom thread trimmer + auto-lifter)							
Cloth	puller							
PL1	(not apply with UT1, UT2)					For H11, E61		
PL4	(It can be attached after the setup.)							
Smoo	th cloth puller					1		
PL1S	Rubber type							
Roller	tensioner		1			-		
TR04	Fixed roller tensioner							
TR05	Pneumatic roller tensioner							
TR06	Fixed roller tensioner							
Cloth	chip suction device	-1	1	1		1		
MC-34	Monolithic type							
Pneur	natic hem binder		<u>I</u>	I	1	1		
AH3	Pneumatic hem binder					For U02/U03/U00 H01, H21		



TR06

### **EXAMPLE OF APPLICATION: MULTIPURPOSE UNIVERSAL STYLE (UNIVERSAL GAUGES)**

#### (U03

This model is used for hemming for T-shirts and polo shirts, and coverseams for T-shirts, polo-shirts, and fleece. Recommended model: MFC-7605U-U03-B56/UT2

#### (U06

This model is used for hemming and coverseams for trainers and T-shirts. It is also used for collarette for knitwear and underwear with optional parts. Recommended model: MFC-7605U-U06-B56

 $U06 \Rightarrow C02$ 

Kit No.: 29480CU06C02J

+

### C02

This model is designed to handle collarette for underwear, briefs, and ladies' knitwear. Recommended model: MFC-7605U-C02-B56

### U06 C02 EASY TO CHANGE BY REPLACING PARTS

#### $C02 \Rightarrow U06$

Kit No.: 29480CC02U06J +

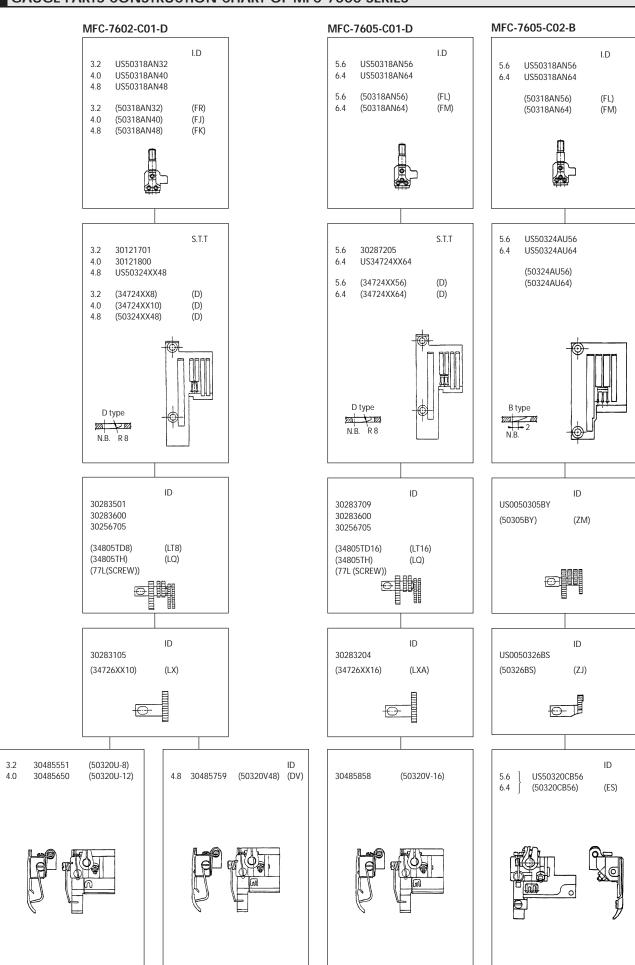
Sewing parts								
Parts name		Parts No.						
	Needle gauge	5.6mm	6.4mm					
Needl	e clamp	amp 50318AN56 50318AN64						
Presse	er foot	50320	CD56					
Differential-feed dog		50326BN	50326BX					
Main feed dog		50305BV	50305CC					
Throat plate		50324DF56	50324DF64					

Sewing parts								
Parts No.								
Needle gauge 5.6 mm 6.								
50318AN56 50318AN64								
50320	)CB56							
5032	26BS							
5030	05BY							
50324AU56	50324AU64							
	5.6 mm 50318AN56 5032( 503) 503(							

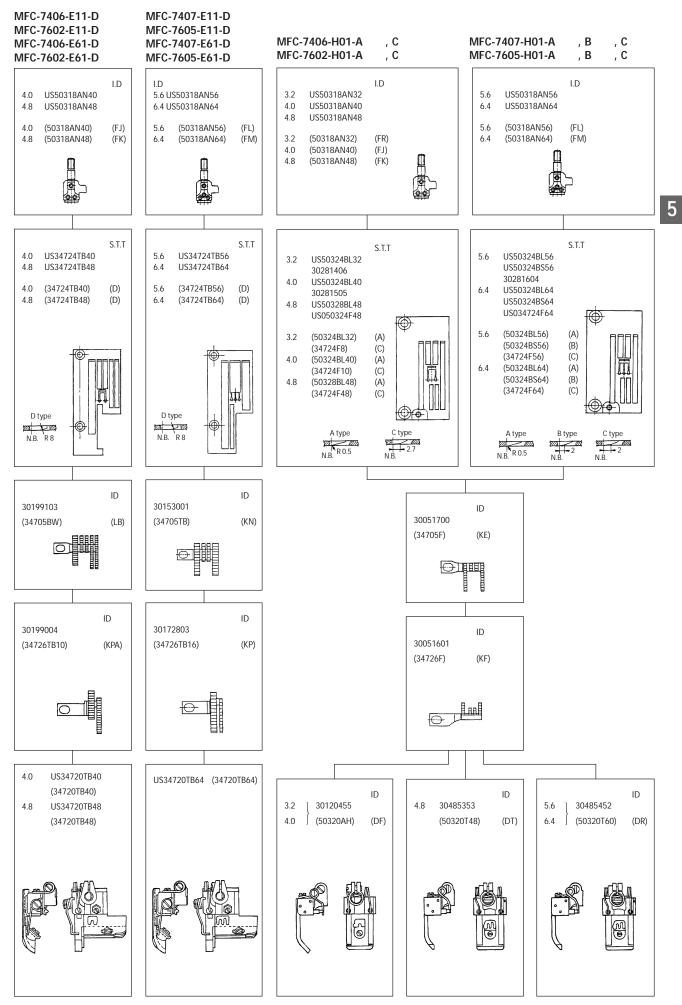
		I	گ			öõ	<b>L</b> .	0	- ·
Seams	Model No.	Number of needles	ס Number of threads	H ⊢ Needle gauge (mm)	Max. stitch length (mm)	Bottom differential feed ratio	Presser lifting amount (mm)	Max. sewing speed (rpm)	Devices
or unive	rsal (hemming, coversean	n: foldin	gover-ov	erlock se	am, coverse	eam: flatteni	ng out)		
	MFC-7407U-U03-B56			5.6					UT1/3/4
+ 4	MFC-7407U-U03-B64	2	4	6.4	10 05	100 107	7	( 500	PL4, AH3
*1	MFC-7605U-U03-B56	3	г	5.6	1.8 ~ 2.5	1:0.3 ~ 1:2.7	7	6,500	UT2/5
	MFC-7605U-U03-B64		5	6.4					PL4, AH3
or unive	rsal (hemming, coversean	n: foldin	gover-ov	erlock se	am, coverse	eam: flatteni	ng out, co	llarette) b	oy retrofit kit
	MFC-7605U-U06-B56		_	5.6	10.05		_	( 500	UT2/5
* 2	MFC-7605U-U06-B64	3	5	6.4	1.8 ~ 2.5	1:0.3 ~ 1:2.7	7	6,500	PL4, AH3
or unive	rsal (hemming, coversean	n: foldin	g over-o	verlock s	eam, covers	eam: flatten	ing out) in	cluding co	onversion parts
	MFC-7602U-U02-B48	2	4	4.8					UT2/5, PL4, AH3
*1	MFC-7605U-U02-B56	3	5	5.6	1.8 ~ 2.5	1:0.3 ~ 1:2.7	7	6,500	TR04/TR05/TR06
or collar	ette								
	MFC-7605U-C02-B56			5.6					
Serence A	MFC-7605U-C02-B64	3	5	6.4	1.8 ~ 2.5	1:0.3 ~ 1:3.0	6	6,500	
or hemn	ning with left hand fabric	trimmer							
	MFC-7605U-H21-B56			5.6					
Summer	MFC-7605U-H21-B64	3	5	6.4	1.6 ~ 3.2	1:0.3 ~ 1:2.7	7	5,500	UT2/5, AH3
or home	ning with left hand fabric	trimmor	& roar p						
or nemin	MFC-7605U-H31-B56/PL1								
	MFC-7605U-H31-B56/PL1S	3	5	5.6					
	MFC-7605U-H31-B64/PL1			1.6 ~ 3.2	1:0.3 ~ 1:2.7	7	5,500	UT5	
*				6.4					
	MFC-7605U-H31-B64/PL1S								
or hemn	ning with close-coupled ro	ller pull	er for pre	e-attache	d elastic on	the edge			
	MFC-7605U-H11-B56/PL1	3	5	5.6	1.8 ~ 2.5	1:0.3 ~ 1:2.7	7	6,000	UT5
<u> </u>	MFC-7605U-H11-B56/PL1S								
or attack	hing pre-closed elastic wai	istband 1	o under		th right fabr	ic trimmer)			1170/5
	MFC-7605U-E11-D56	3	5	5.6	1.6 ~ 3.0	1:0.3 ~ 1:2.4	6	5,500	UT2/5
TR	MFC-7605U-E11-D64			6.4					PL4, TR04/TR05/T
or attacl	hing pre-closed elastic wai	istband t	o under	wear (wit	th right fabr	ic trimmer &	rear pulle	r)	
	MFC-7605U-E61-D56/PL1			5.6					
	MFC-7605U-E61-D56/PL1S	3	5		1.6 ~ 3.2	1:0.3 ~ 1:2.7	6	5,500	UT5
	MFC-7605U-E61-D64/PL1			6.4					TR04/TR05/TR06
	MFC-7605U-E61-D64/PL1S								
or hemn						1			1
	MFC-7602U-H01-A40	2	4	4.0					
$\sim$	MFC-7602U-H01-A48			4.8	1.6 ~ 2.1	1:0.3 ~ 1:2.7	7	6,500	UT2/5, AH3
A Therease	MFC-7605U-H01-B56	3	5	5.6	1.0 2.1	1.0.0 1.2.7	,	0,000	012/3, 7113
	MFC-7605U-H01-B64	5	5	6.4					
or cover	seam (with adjustable sea	m guide	medium	to heav	y fabrics)				
	MFC-7602U-K02-D56			5.6					
	MFC-7602U-K02-D64	2	4	6.4					UT2/5
	MFC-7406U-K02-D56		3	5.6	1.6 ~ 3.2	1:0.3 ~ 1:2.4	7	6,500	UT4
R	MFC-7605U-K02-D56			5.6					
	MFC-7605U-K02-D64	3	5	6.4					UT2/5
								- ~	

5

### GAUGE PARTS CONSTRUCTION CHART OF MFC-7000 SERIES

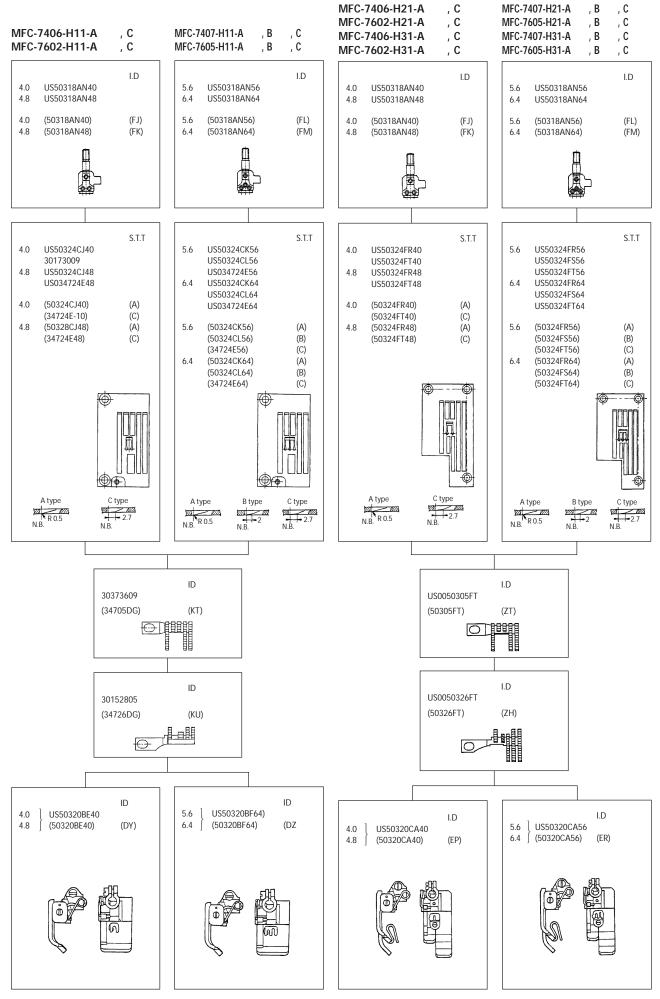


MFC-7000 SERIES (June, 2001) 4/8 Downloaded from <u>www.Manualslib.com</u> manuals search engine

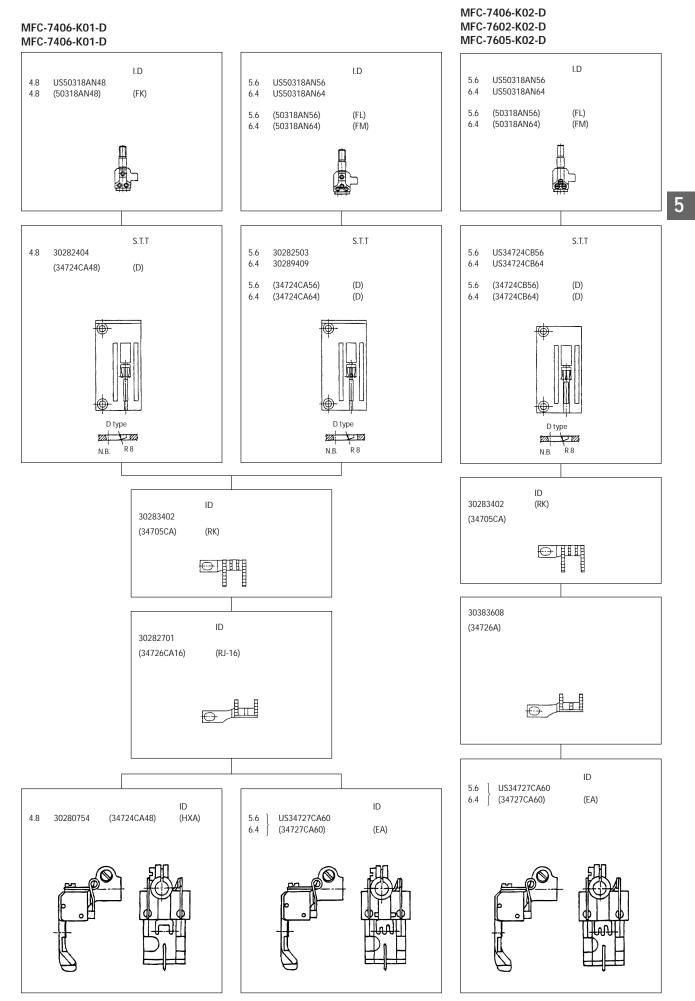


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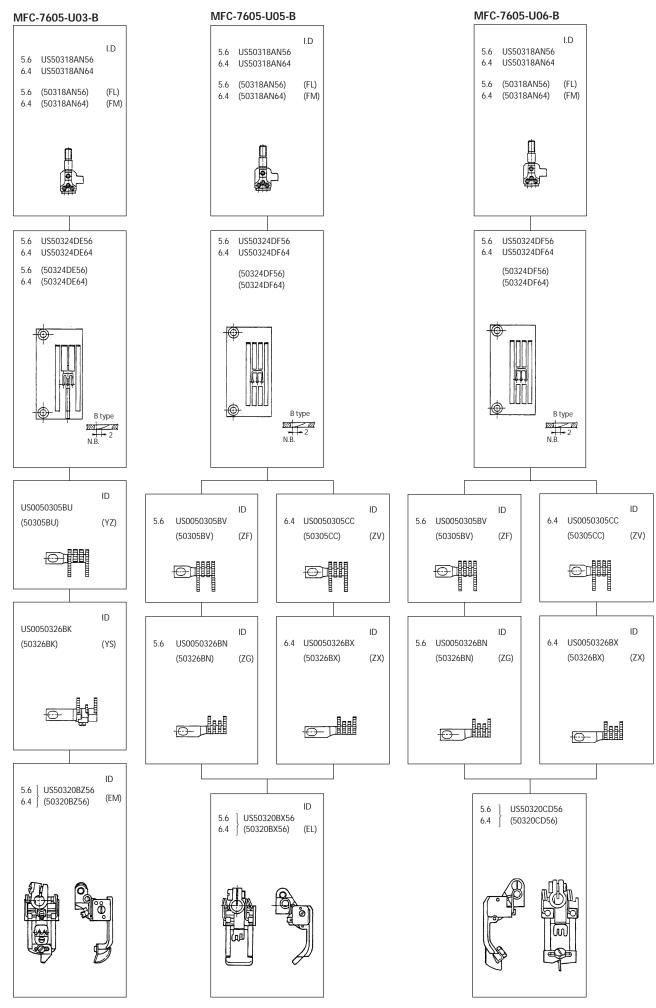
MFC-7000 SERIES (June, 2001) 5/8



MFC-7000 SERIES (June, 2001) 6/8 Downloaded from <u>www.Manualslib.com</u> manuals search engine



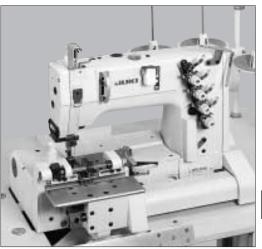
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MFC-7000 SERIES (June, 2001) **8/8** Downloaded from <u>www.Manualslib.com</u> manuals search engine High-speed, 2-needle, 3-thread, Bottom Covering Stitch, Belt-loop Making Machine

## MFB-2600

- The sewig speed is very fast, the normal rotational speed of the machine is as high as 5,000rpm. This leads to highly efficient belt-loop making.
- The side cutter is equipped with a newly developed mechanism to drive the knife using the timing belt from the pulley side. This reduces the vibration of the machine during a high-speed operation, thereby leading to a consistent performance.
- The newly developed binder unique to JUKI is longer than conventional binders. It is therefore capable of rolling up the material smoothly, making beautifully and uniformly finished belt-loops without any twisted or irregularly rolled section.



MFB-2600

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### SPECIFICATIONS

Model name	MFB-2600
Stitch type	2-needle, 3-thread, bottom covering stitch
Max. sewing speed	5,500rpm (normal 5,000rpm)
Stitch length	1.2 ~ 3.2mm
Needle bar stroke	30.4mm
Feed adjustment method	By adjusting the amount of eccentricity
Needle gauge (mm)	4.8, 5.6, 6.4
Finished width	8 ~ 20mm
Differential-feed ratio	1:0.5 ~ 1:3.2
Needle (at the time of delivery)	DV × 1 (#11) #11 ~ #14 or UY128GAS (#75) #75 ~ #90
Lubrication	Automatic
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)

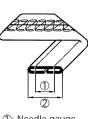
## WHEN YOU PLACE ORDERS



Needle gauge	Code
4.8mm	F
5.6mm	G
6.4mm	Н

Application	Code
For light-wight materials	Α
For medinum-weight materials	В
For heavy-weight materials	Н

Finished width (mm)	Code	Finished width (mm)	Code
8	Н	15	Q
9	J	16	R
10	К	17	S
11	L	18	Т
12	М	19	U
13	N	20	V
14	Р		



①: Needle gauge②: Finished width

## NEEDLE GAUGE: FINISHED WIDTH

	Finished width			Н	J	К	L	М	Ν	Р	Q	R	S	Т	U	V
Appli	Application Needle gauge			8mm	9mm	10mm	11mm	12mm	13mm	14mm	15mm	16mm	17mm	18mm	19mm	20mm
		F	4.8mm													
A (	(light-weight materials)	G	5.6mm													
	•	Н	6.4mm													
		F	4.8mm													
	(medium-weight materials)	G	5.6mm													
		Н	6.4mm													
Н (	(heavy-weight materials)	G	5.6mm													
r		н	6.4mm													

#### High-speed, Flat-bed, 2-needle Double Chainstitch Machine

## MH-380 (parallel 2-needle) MH-382 (tandem 2-needle)

- It comes with JUKI's unique inclined crank type looper mechanism. This gives the machine outstanding durability. You can use the sewing machine for a long time without ever worrying about looper failure.
- You can easily set the machine to perform condensation stitching by operating the lever.

Condensation stitches that prevent the thread from fraying can be consistently sewn.

• Attachments (optional) have been prepared for many different applications, including sewing sides of jeans, slacks and skirts, hemming pockets, making decorative stitches on tape for sportswear.



6

## SPECIFICATIONS

	MH-380	MH-382			
Model name	Parallel 2-needle	Tandem 2-needle			
Max. sewing speed	6,000	)rpm			
Stitch length	4m	ım			
Lift of the presser foot	By hand: 5.5mm,	By knee: 10mm			
Needle bar stroke	30r	nm			
Needle (at the time of delivery)	TV × 7 (#14	) #9~#21			
Thread take-up	Needle bar thread take-up				
Stitch length adjustment	By stitch dia	I (lockstitch)			
Condensation stitches	By lever for conde	ensation stitching			
Looper system	Rocking ty	pe looper			
Looper stroke	22.6	mm			
Elliptical motion	2.4 ~ 3	.7mm			
Lubrication	Automatic				
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)				
Needle cooler	Opti	onal			

### WHEN YOU PLACE ORDERS

MH-380 U										
	Code	В	С	D	E	F	н	К	L	
Needle gauge	mm	3.2	4.0	4.8	5.6	6.4	7.9	9.5	12.7	
guugo	inch	1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	

### APPLICATIONS

Model	Application
MH-380 (parallel 2-needle)	<ul> <li>Sewing sides of slacks</li> <li>Hemming or welting garment parts</li> <li>Attaching lining tape</li> </ul>
MH-382 (tandem 2-needle)	Joining seat of slacks

MH-382U

### **DEVICES AND ATTACHMENTS**

AT-8	Applicable machines: MH-380, MH-382 Class of work: Jeans, Working wear Applications: Cut a chaining thread bridging two workpieces continuously sewn by chainstitch in the way that a knife blade of the cutter is dropped. Best suited to continuous sewing on pocket openings of jeans or working wear.			dging two stitch in the way ed. Best suited for	•Lap seam folder (Reverse) M052	Applications: Sew	ns, Working pa side seams heavy-weight	nts, Pants, Overalls materials and heavy- Irill, etc.
						Finished width (mm)	Needle gauge mm (in)	Part No.
, Ny#	Guide wi	dth mm (in)		Part No.		17	12.7 (1/2)	MAM-0520S0A0
		n 2-needle		-080000AC		14	9.5 (3/8)	MAM-052090A0
THE .		(5/32)	-	-08000CAC	-	12	7.9 (5/16)	MAM-0520M0A0
	-	(3/16)		-08000DAC	В	10	6.4 (1/4)	MAM-0520K0A0
		(1/4)		-08000FAC	A: Needle gauge	10	5.6 (7/32)	MAM-0520K0A0
		(5/16)	-	-08000HAC	B: Finished width	9	4.8 (3/16)	MAM-0520J0A0
		, ,					, ,	11.1.1.1.1.002000110
<ul> <li>Down turn hemmer</li> <li>L050</li> </ul>	Class of work	nachines: MH-3 k: Jeans, Worki : Hem jeans hij ons where high	ing pants o pocket mo	outh, especially ight stitch is	<ul> <li>Left feed top stitch folder</li> <li>M054</li> </ul>	Applicable machin Class of work: Jea Applications: Sew Attach flat faces of	ns, Working pa side seams.	nts, Jackets, Skirts
						Finished width (mm)	Needle gaug mm (in)	e Part No.
						17	12.7 (1/2)	MAM-0540S0A0
						14	9.5 (3/8)	MAM-0540P0A0
<u></u> //	Finished	width (mm)		Part No.		12	7.9 (5/16)	MAM-0540M0A0
A		14		-0500P0A0		10	6.4 (1/4)	MAM-0540K0A0
B		12	-	-0500M0A0	В	10	5.6 (7/32)	MAM-0540K0A0
A: Needle gauge		11	-	-0500L0A0	A: Needle gauge	9	4.8 (3/16)	MAM-0540J0A0
B: Finished width		10		-0500K0A0	B: Finished width	8	4.0 (5/32)	MAM-0540H0A0
Decorative		nachines: MH-3		03001070			. ,	101/101 0340110/10
tape attaching foot B050	Class of work Uniforms, Bo Applications	<ul> <li>k: Sportswear, ixer pants, Rom</li> <li>: Stitch accent</li> <li>otton bias tape,</li> </ul>	Training we npers line attach t	tapes	Right feed top stitch folder     M055		ns, Working pa side seams.	nts, Jackets, Skirts
	Finished	Needle gauge	Tapo width			Finished width (mm)	Needle gaug mm (in)	e Part No.
	width (mm)			Part No.				
Thirty			i (mm)			17	127(1/2)	MAM-0550S0A0
This ??		mm (in) 12.7 (1/2)	(mm) 34	MAB-0500SLA0		17	12.7 (1/2) 9.5 (3/8)	MAM-0550S0A0 MAM-0550P0A0
	17	12.7 (1/2)	34	MAB-0500SLA0 MAB-0500OKA0	A	14	9.5 (3/8)	MAM-0550P0A0
A	17 15	12.7 (1/2) 9.5 (3/8)	34 30	MAB-0500QKA0		14 12	9.5 (3/8) 7.9 (5/16)	MAM-0550P0A0 MAM-0550M0A0
A B	17 15 12	12.7 (1/2) 9.5 (3/8) 7.9 (5/16)	34 30 24	MAB-0500QKA0 MAB-0500MHA0		14 12 10	9.5 (3/8) 7.9 (5/16) 6.4 (1/4)	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0
A: Needle gauge	17 15 12 10	12.7 (1/2) 9.5 (3/8) 7.9 (5/16) 6.4 (1/4)	34 30 24 20	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0	A: Needle gauge	14 12 10 10	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32)	MAM-0550P0A0           MAM-0550M0A0           MAM-0550K0A0           MAM-0550K0A0
	17 15 12 10 8	12.7 (1/2) 9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 4.8 (3/16)	34 30 24 20 16	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0	A: Needle gauge B: Finished width	14 12 10 10 9	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16)	MAM-0550P0A0           MAM-0550M0A0           MAM-0550K0A0           MAM-0550K0A0           MAM-0550J0A0
	17 15 12 10	12.7 (1/2) 9.5 (3/8) 7.9 (5/16) 6.4 (1/4)	34 30 24 20	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0		14 12 10 10	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32)	MAM-0550P0A0           MAM-0550M0A0           MAM-0550K0A0           MAM-0550K0A0
A: Needle gauge B: Finished width • Decorative tape attaching foot	17 15 12 10 8 6 Applicable n Class of worl Uniforms Applications	12.7 (1/2) 9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 4.8 (3/16) 4.0 (5/32) hachines: MH-3 k: Ladies' wear,	34 30 24 20 16 14 380 Children' w	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0		14 12 10 9 8 Applicable machin Applications: Used	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) mes: MH-382 4 with lockstitch de seam, and si	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining
B: Finished width Decorative tape attaching foot	17 15 12 10 8 6 Applicable n Class of worl Uniforms Applications tapes	12.7 (1/2) 9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 4.8 (3/16) 4.0 (5/32) nachines: MH-3 k: Ladies' wear, : Attach decora	34 30 24 20 16 14 380 Children' w	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 vear, Sportswear, and reinforcement	B: Finished width	14       12       10       9       8   Applications: Used machines to sew si	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) mes: MH-382 4 with lockstitch de seam, and si	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550J0A0 MAM-0550H0A0
<ul> <li>B: Finished width</li> <li>Decorative tape attaching</li> </ul>	17 15 12 10 8 6 Applicable n Class of worl Uniforms Applications tapes Materials: Ta	12.7 (1/2) 9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 4.8 (3/16) 4.0 (5/32) machines: MH-3 k: Ladies' wear, : Attach decora	34 30 24 20 16 14 880 Children' w tive tapes a uede cloth t	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 rear, Sportswear,	B: Finished width	14 12 10 10 9 8 Applicable machin Applications: Used machines to sew si edge of garments w	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) mes: MH-382 d with lockstitch de seam, and si with different cu	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines
B: Finished width Decorative tape attaching foot	17 15 12 10 8 6 Applicable n Class of worl Uniforms Applications tapes Materials: Ta	12.7 (1/2) 9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 4.8 (3/16) 4.0 (5/32) machines: MH-3 k: Ladies' wear, : Attach decora	34 30 24 20 16 14 880 Children' w tive tapes a uede cloth t	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 //ear, Sportswear, and reinforcement rape, decorative	B: Finished width	14 12 10 10 9 8 Applicable machin Applications: Used machines to sew si edge of garments w Type	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) mes: MH-382 d with lockstitch de seam, and si with different cu	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No.
B: Finished width Decorative tape attaching foot	17 15 12 10 8 6 Applicable m Class of work Uniforms Applications tapes Materials: Ta tape, plain w	12.7 (1/2) 9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 4.8 (3/16) 4.0 (5/32) machines: MH-3 k: Ladies' wear, : Attach decora	34 30 24 20 16 14 880 Children' w tive tapes a uede cloth t	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 //ear, Sportswear, and reinforcement rape, decorative	B: Finished width  Superpose joining guide  Edge allowance:	14         12         10         9         8         Applications: Used machines to sew si edge of garments with the second seco	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) hes: MH-382 d with lockstitch de seam, and si with different cu terial material	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA
B: Finished width Decorative tape attaching foot	17 15 12 10 8 6 Applicable m Class of work Uniforms Applications tapes Materials: Ta tape, plain w	12.7 (1/2) 9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 4.8 (3/16) 4.0 (5/32) machines: MH-3 k: Ladies' wear, : Attach decora	34 30 24 20 16 14 880 Children' w tive tapes a uede cloth t	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 //ear, Sportswear, and reinforcement rape, decorative	B: Finished width  • Superpose joining guide	14         12         10         9         8         Applicable machine         Applications: Used machines to sew si edge of garments with the set of garments with the set of garment with the set of gar	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) hes: MH-382 d with lockstitch de seam, and si with different cu terial material	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines <b>Part No.</b> MAH-027000AA MAH-027000AB MAH-027000AH
B: Finished width Decorative tape attaching foot	17 15 12 10 8 6 Applicable n Class of worl Uniforms Applications tapes Materials: Ta tape, plain w tapes. Finished with	12.7 (1/2)       9.5 (3/8)       7.9 (5/16)       6.4 (1/4)       4.8 (3/16)       4.0 (5/32)       machines: MH-3       k: Ladies' wear,       : Attach decora       : Attach decora       : oven tape. Co       idth     Needle	34 30 24 20 16 14 380 Children' w tilve tapes a uede cloth t ntact us for	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 //ear, Sportswear, and reinforcement rape, decorative	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm	14         12         10         9         8         Applications: Used machines to sew si edge of garments widge of garments widge of garments widge of garments widge.         Type         Light-weight ma         Medium-weight ma         Spacer (assy.)	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) nes: MH-382 d with lockstitch de seam, and si with different cu terial material aterial	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AB
B: Finished width Decorative tape attaching foot	17 15 12 10 8 6 Applicable n Class of worl Uniforms Applications tapes Materials: Ta tape, plain w tapes. Finished wi (mm)	12.7 (1/2)           9.5 (3/8)           7.9 (5/16)           6.4 (1/4)           4.8 (3/16)           4.0 (5/32)           machines: MH-3           k: Ladies' wear,           : Attach decora           pe: Synthetic si voven tape. Co           idth         Needle mm	34 30 24 20 16 14 380 Children' w tilve tapes a uede cloth t ntact us for	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 vear, Sportswear, and reinforcement ape, decorative special type of Part No.	B: Finished width  Superpose joining guide  Edge allowance:	14         12         10         9         8         Applications: Used machines to sew si edge of garments with edge of garments with theavy-weight ma Medium-weight ma Spacer (assy.)         Applicable maching	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) nes: MH-382 d with lockstitch de seam, and si with different cu terial material aterial aterial	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AB MAH-027000AH MAH-025020A0
B: Finished width Decorative tape attaching foot	17 15 12 10 8 6 Applicable n Class of wort Uniforms Applications tapes Materials: Ta tape, plain w tapes. Finished wi (mm) 17	12.7 (1/2)           9.5 (3/8)           7.9 (5/16)           6.4 (1/4)           4.8 (3/16)           4.0 (5/32)           machines: MH-3           k: Ladies' wear,           : Attach decora           : Attach decora           pe: Synthetic si           voven tape. Co           idth         Needle           mm         12.7 (1/2)	34 30 24 20 16 14 380 Children' w tilve tapes a uede cloth t ntact us for gauge (in) (1/2)	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 vear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm	14         12         10         9         8         Applications: Used machines to sew si edge of garmentsv         Edge of garmentsv         Light-weight ma         Medium-weight Heavy-weight m         Spacer (assy.)         Applicable machin         Class of work: Jea	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) mes: MH-382 d with lockstitch de seam, and si with different cu terial material aterial aterial mes: MH-380 ns, Working pa	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AB MAH-027000AH MAH-025020A0
B: Finished width Decorative tape attaching foot	17 15 12 10 8 6 Applicable n Class of worl Uniforms Applications tapes Materials: Ta tape, plain w tapes. Finished wi (mm) 17 15	12.7 (1/2)           9.5 (3/8)           7.9 (5/16)           6.4 (1/4)           4.8 (3/16)           4.0 (5/32)           machines: MH-3           k: Ladies' wear,           : Attach decora           pe: Synthetic si voven tape. Cor           idth         Needle mm           12.7 ( 9.5 (	34           30           24           20           16           14           380           Children' w           titve tapes a           uede cloth t           ntact us for           gauge           (in)           (1/2)           (3/8)	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 vear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0 MAB-0510QKA0	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm	14 12 10 10 9 8 Applicable machin Applications: User machines to sew si edge of garments w Type Light-weight ma Medium-weight Heavy-weight m Spacer (assy.) Applicable machin Class of work: Jea Applications: Sew	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) mes: MH-382 d with lockstitch de seam, and si with different cu terial material aterial aterial aterial mes: MH-380 ns, Working pa zippers on left	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AB MAH-027000AB MAH-025020A0
B: Finished width Decorative tape attaching foot	17 15 12 10 8 6 Applicable n Class of worl Uniforms Applications tapes Materials: Ta tape, plain w tapes. Finished wi (mm) 17 15 12	12.7 (1/2)           9.5 (3/8)           7.9 (5/16)           6.4 (1/4)           4.8 (3/16)           4.0 (5/32)           machines: MH-3           k: Ladies' wear,           : Attach decora           pe: Synthetic si voven tape. Con           idth         Needle mm           12.7 ( 9.5 ( 7.9 (	34           30           24           20           16           14           380           Children' w           titve tapes a           uede cloth t           ntact us for           gauge           (in)           (1/2)           (3/8)           (5/16)	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 vear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0 MAB-0510QKA0 MAB-0510MHA0	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm	14 12 10 10 9 8 Applicable machin Applications: User machines to sew si edge of garments w Type Light-weight ma Medium-weight Heavy-weight m Spacer (assy.) Applicable machin Class of work: Jea Applications: Sew	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) mes: MH-382 d with lockstitch de seam, and si with different cu terial material aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AB MAH-027000AH MAH-025020A0
B: Finished width  Decorative tape attaching foot  B051  A B B B B B B B B B B B B B B B B B B	17         15         12         10         8         6         Applicable n         Class of worl         Uniforms         Applications         tapes         Materials: Ta         tape, plain w         tapes.         Finished wi         (mm)         17         15         12         10	12.7 (1/2)         9.5 (3/8)         7.9 (5/16)         6.4 (1/4)         4.8 (3/16)         4.0 (5/32)         machines: MH-3         k: Ladies' wear,         : Attach decora         pe: Synthetic si         yoven tape. Con         idth       Needle         mm         12.7 (1/2)         9.5 (1/2)         7.9 (1/2)         9.5 (1/2)         7.9 (1/2)         9.5 (1/2)         7.9 (1/2)         0.4 (1/2)	34         30         24         20         16         14         380         Children' w         titve tapes a         uede cloth t         ntact us for         gauge (in)         (1/2)         (3/8)         (5/16)         (1/4)	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 wear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0 MAB-0510SLA0 MAB-0510MHA0 MAB-0510KFA0	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm	14         12         10         9         8         Applicable machine         Applications: Used         machines to sew si         edge of garments w         Ight-weight ma         Medium-weight         Heavy-weight ma         Spacer (assy.)         Applications: Sew         Applications: Sew         Materials: Medium	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) nes: MH-382 d with lockstitch de seam, and si with different cu terial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AB MAH-027000AB MAH-025020A0
B: Finished width Decorative tape attaching foot	17         15         12         10         8         6         Applicable n         Class of wort         Uniforms         Applications         tapes         Materials: Ta         tape, plain w         tapes.         Finished wi         (mm)         17         15         12         10         9	12.7 (1/2)         9.5 (3/8)         7.9 (5/16)         6.4 (1/4)         4.8 (3/16)         4.0 (5/32)         machines: MH-3         k: Ladies' wear,         : Attach decora         ipe: Synthetic si voven tape. Cor         idth       Needle mm         12.7 ( 9.5 ( 7.9 ( 6.4 ( 5.6 (	34         30         24         20         16         14         380         Children' w         titve tapes a         uede cloth t         ntact us for         gauge (in)         (1/2)         (3/8)         (5/16)         (1/4)         (7/32)	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 wear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0 MAB-0510SLA0 MAB-0510MHA0 MAB-0510KFA0 MAB-0510JEA0	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm  Zipper guide	14         12         10         9         8         Applicable machine         Applications: Used         machines to sew si         edge of garments w         Ight-weight ma         Medium-weight         Heavy-weight ma         Spacer (assy.)         Applications: Sew         Applications: Sew         Materials: Medium	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) nes: MH-382 d with lockstitch de seam, and si with different cu terial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial ateria aterial aterial aterial aterial	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AB MAH-027000AH MAH-025020A0 nts files als such as jeans denim
B: Finished width Decorative tape attaching foot B051 A: Needle gauge	17         15         12         10         8         6         Applicable n         Class of worl         Uniforms         Applications         tapes         Materials: Ta         tape, plain w         tapes.         Finished wi         (mm)         17         15         12         10	12.7 (1/2)         9.5 (3/8)         7.9 (5/16)         6.4 (1/4)         4.8 (3/16)         4.0 (5/32)         machines: MH-3         k: Ladies' wear,         : Attach decora         ipe: Synthetic si voven tape. Cor         idth       Needle mm         12.7 ( 9.5 ( 7.9 ( 6.4 ( 5.6 (	34         30         24         20         16         14         380         Children' w         titve tapes a         uede cloth t         ntact us for         gauge (in)         (1/2)         (3/8)         (5/16)         (1/4)         (7/32)	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 wear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0 MAB-0510SLA0 MAB-0510MHA0 MAB-0510KFA0	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm  Zipper guide  Jamm	14         12         10         9         8         Applicable machine         Applications: Used         machines to sew si         edge of garments w         Ight-weight ma         Medium-weight         Heavy-weight ma         Spacer (assy.)         Applications: Sew         Applications: Sew         Materials: Medium	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) nes: MH-382 d with lockstitch de seam, and si with different cu terial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial aterial	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AB MAH-027000AH MAH-025020A0 nts files als such as jeans denim
B: Finished width  Decorative tape attaching foot  B051  A: Needle gauge B: Finished width	17         15         12         10         8         6         Applicable n         Class of wort         Uniforms         Applications         tapes         Materials: Ta         tape, plain w         tapes.         Finished wi         (mm)         17         15         12         10         9	12.7 (1/2)           9.5 (3/8)           7.9 (5/16)           6.4 (1/4)           4.8 (3/16)           4.0 (5/32)           nachines: MH-3           k: Ladies' wear,           : Attach decora           ipe: Synthetic si           yoven tape. Cor           12.7 (           9.5 (           7.9 (           6.4 (           5.6 (           4.8 (	34         30         24         20         16         14         380         Children' w         titve tapes a         uede cloth t         ntact us for         gauge (in)         (1/2)         (3/8)         (5/16)         (1/4)         (7/32)	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 wear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0 MAB-0510SLA0 MAB-0510MHA0 MAB-0510KFA0 MAB-0510JEA0	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm  Zipper guide  Jamm 50-60mm	14         12         10         9         8         Applicable machine         Applications: Used         machines to sew si         edge of garments w         Ight-weight ma         Medium-weight         Heavy-weight ma         Spacer (assy.)         Applications: Sew         Applications: Sew         Materials: Medium	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) mes: MH-382 d with lockstitch de seam, and si with different cu terial material aterial aterial aterial aterial aterial material aterial aterial material aterial material aterial pes: MH-380 ns, Working pa zippers on left 1-weight materia drill etc. Part No. MAQ-020000	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AB MAH-027000AH MAH-025020A0 nts files als such as jeans denim
B: Finished width Decorative tape attaching foot B051 A: Needle gauge	17         15         12         10         8         6         Applicable n         Class of wort         Uniforms         Applications         tapes         Materials: Ta         tape, plain w         tapes.         Finished wit         (mm)         17         15         12         10         9         8         SPECIFICA	12.7 (1/2)         9.5 (3/8)         7.9 (5/16)         6.4 (1/4)         4.8 (3/16)         4.0 (5/32)         nachines: MH-3         k: Ladies' wear,         : Attach decora         pe: Synthetic si         yoven tape. Co         idth         Needle         mm         12.7 (         9.5 (         7.9 (         6.4 (         5.6 (         4.8 (         TIONS	34         30         24         20         16         14         380         Children' w         titve tapes a         uede cloth t         ntact us for         gauge (in)         (1/2)         (3/8)         (5/16)         (1/4)         (7/32)         (3/16)	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 wear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0 MAB-0510SLA0 MAB-0510MHA0 MAB-0510KFA0 MAB-0510JEA0	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm  Zipper guide  Ja4mm 50-60mm  W	14         12         10         9         8         Applications: Used machines to sew si edge of garments with the set of garments wi	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) mes: MH-382 d with lockstitch de seam, and si with different cu terial material aterial aterial aterial aterial aterial material aterial aterial material aterial material aterial pes: MH-380 ns, Working pa zippers on left 1-weight materia drill etc. Part No. MAQ-020000	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AB MAH-027000AH MAH-025020A0 nts files als such as jeans denim
B: Finished width  Decorative tape attaching foot  B051  A: Needle gauge B: Finished width  Tape cutter	17         15         12         10         8         6         Applicable m         Class of wort         Uniforms         Applications         tapes         Materials: Ta         tape, plain w         tapes.         Finished wit         (mm)         17         15         12         10         9         8         SPECIFICA         Applicable m	12.7 (1/2)         9.5 (3/8)         7.9 (5/16)         6.4 (1/4)         4.8 (3/16)         4.0 (5/32)         nachines: MH-3         k: Ladies' wear,         : Attach decora         pe: Synthetic si         yoven tape. Co         idth         Needle         mm         12.7 (         9.5 (         7.9 (         6.4 (         5.6 (         4.8 (         TIONS	34         30         24         20         16         14         380         Children' w         witive tapes a         uede cloth t         ntact us for         gauge (in)         (1/2)         (3/8)         (5/16)         (1/4)         (7/32)         (3/16)         D (Cannot b)         r type.)	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 vear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0 MAB-0510SLA0 MAB-0510MHA0 MAB-0510MHA0 MAB-0510JEA0 MAB-0510HDA0 e use with the threat	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm  Zipper guide  Ja4mm 50-60mm  W	14         12         10         9         8         Applications: Used machines to sew si edge of garments with the set of garments wi	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) hes: MH-382 d with lockstitch de seam, and si with different cu terial material aterial aterial aterial aterial material aterial pes: MH-380 ns, Working pa zippers on left hweight material drill etc. Part No. MAQ-020000 RDERS	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550H0A0 MAM-0550H0A0 machines or chainstitcf milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AH MAH-027000AH MAH-025020A0 nts files als such as jeans denim
B: Finished width  Decorative tape attaching foot  B051  A: Needle gauge B: Finished width	17         15         12         10         8         6         Applicable m         Class of wort         Uniforms         Applications         tapes         Materials: Ta         tape, plain w         tapes.         Finished wit         (mm)         17         15         12         10         9         8         SPECIFICA         Applicable m	12.7 (1/2)         9.5 (3/8)         7.9 (5/16)         6.4 (1/4)         4.8 (3/16)         4.0 (5/32)         machines: MH-3         k: Ladies' wear,         : Attach decora         pe: Synthetic si         yoven tape. Cord         idth       Needle         mm         12.7 (1/2)         9.5 (1/2)         7.9 (1/2)         9.5 (1/2)         7.9 (1/2)         6.4 (1/2)         5.6 (1/2)         4.8 (1/2)         THONS         model : MH-38(1)         httmme         ethod : Air drive	34         30         24         20         16         14         380         Children' w         titve tapes a         uede cloth t         ntact us for         (in)         (1/2)         (3/8)         (5/16)         (1/4)         (7/32)         (3/16)         D (Cannot border type.)         re by an air	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 vear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0 MAB-0510SLA0 MAB-0510MHA0 MAB-0510MHA0 MAB-0510JEA0 MAB-0510HDA0 e use with the threat	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm  Zipper guide  June So-60mm  Wad	14         12         10         9         8         Applications: Used machines to sew si edge of garments widge of garments widge Light-weight ma Medium-weight Heavy-weight m Spacer (assy.)         Applications: Sew Materials: Medium cotton gabardine,         HEN YOU PLACE OF	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) hes: MH-382 d with lockstitch de seam, and si with different cu terial material aterial aterial aterial aterial material aterial pes: MH-380 ns, Working pa zippers on left hweight material drill etc. Part No. MAQ-020000 RDERS	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AB MAH-027000AH MAH-025020A0 nts files als such as jeans denim
B: Finished width  Decorative tape attaching foot  B051  A: Needle gauge B: Finished width  Tape cutter	17         15         12         10         8         6         Applicable m         Class of word         Uniforms         Applications         tapes         Materials: Ta         tape, plain w         tapes.         Finished wid         (mm)         17         15         12         10         9         8         SPECIFICA         Applicable m         Operating m         Applications	12.7 (1/2)         9.5 (3/8)         7.9 (5/16)         6.4 (1/4)         4.8 (3/16)         4.0 (5/32)         nachines: MH-3         k: Ladies' wear,         : Attach decora         ipe: Synthetic size         ipe: Synthetic size </td <td>34         30         24         20         16         14         380         Children' w         tive tapes a         uede cloth t         ntact us for         gauge (in)         (1/2)         (3/8)         (5/16)         (1/4)         (7/32)         (3/16)         D (Cannot b)         r type.)         re by an air         y various tap         cement tape</td> <td>MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 vear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0 MAB-0510QKA0 MAB-0510MHA0 MAB-0510MHA0 MAB-0510HDA0 MAB-0510HDA0 e use with the threa switch pes related to attach and decorative tap</td> <td>B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm  Zipper guide  Jamm 50-60mm  Wad</td> <td>14         12         10         9         8         Applications: Used machines to sew si edge of garments widge of garments widge Light-weight ma Medium-weight Heavy-weight m Spacer (assy.)         Applications: Sew Materials: Medium cotton gabardine,         HEN YOU PLACE OF</td> <td>9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) mes: MH-382 d with lockstitch de seam, and si with different cu terial material aterial aterial aterial aterial mes: MH-380 ns, Working pa zippers on left n-weight materia drill etc. MAQ-020000 RDERS T28 Needli Needli Needli Needli Needli</td> <td>MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch &amp; joining rve lines Part No. MAH-027000AA MAH-027000AH MAH-027000AH MAH-025020A0 nts files als such as jeans denim A0</td>	34         30         24         20         16         14         380         Children' w         tive tapes a         uede cloth t         ntact us for         gauge (in)         (1/2)         (3/8)         (5/16)         (1/4)         (7/32)         (3/16)         D (Cannot b)         r type.)         re by an air         y various tap         cement tape	MAB-0500QKA0 MAB-0500MHA0 MAB-0500KFA0 MAB-0500HDA0 MAB-0500GCA0 vear, Sportswear, and reinforcement ape, decorative special type of Part No. MAB-0510SLA0 MAB-0510QKA0 MAB-0510MHA0 MAB-0510MHA0 MAB-0510HDA0 MAB-0510HDA0 e use with the threa switch pes related to attach and decorative tap	B: Finished width  Superpose joining guide  Edge allowance: Max. 20mm  Zipper guide  Jamm 50-60mm  Wad	14         12         10         9         8         Applications: Used machines to sew si edge of garments widge of garments widge Light-weight ma Medium-weight Heavy-weight m Spacer (assy.)         Applications: Sew Materials: Medium cotton gabardine,         HEN YOU PLACE OF	9.5 (3/8) 7.9 (5/16) 6.4 (1/4) 5.6 (7/32) 4.8 (3/16) 4.0 (5/32) mes: MH-382 d with lockstitch de seam, and si with different cu terial material aterial aterial aterial aterial mes: MH-380 ns, Working pa zippers on left n-weight materia drill etc. MAQ-020000 RDERS T28 Needli Needli Needli Needli Needli	MAM-0550P0A0 MAM-0550M0A0 MAM-0550K0A0 MAM-0550K0A0 MAM-0550J0A0 MAM-0550H0A0 machines or chainstitch milar runstitch & joining rve lines Part No. MAH-027000AA MAH-027000AH MAH-027000AH MAH-025020A0 nts files als such as jeans denim A0

## TABLE OF EXCHANGING GAUGE SETS

#### MH-380

Description	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog	Rear moving needle guard	Right fix needle guard	Left needle guard	
Gauge components		000		E B B B B B B B B B B B B B B B B B B B				
3.2mm (1/8")	B1103-380-B00	B1406-019-BA0	B1509-038-BB0	B1613-380-B00				
4.0mm (5/32")	B1103-380-C00	B1406-019-CA0	B1509-038-CB0	51013 300 500	B2311-380-B00			
4.8mm (3/16")	B1103-380-D00	B1406-019-DA0	B1509-038-DB0	B1613-380-D00				
5.6mm (7/32")	B1103-380-E00	B1406-019-EA0	B1509-038-EB0	B1613-380-F00	B1613-380-F00 B2311-380-E00	B2315-380-000	B2312-380-000	
6.4mm (1/4")	B1103-380-F00	B1406-019-FA0	B1509-038-FB0	D1013-300-F00	B2311-300-E00		B2315-360-000	B2312-360-000
7.9mm (5/16")	B1103-380-H00	B1406-038-HA0	B1509-038-HB0	B1613-380-H00	B2311-380-H00			
9.5mm (3/8")	B1103-380-K00	B1406-038-KA0	B1509-038-KB0	B1613-380-K00	B2311-380-H00			
12.7mm (1/2")	B1103-380-L00	B1406-038-LA0	B1509-038-LBB	B1613-380-L00	B2311-380-L00			
MH-382	MH-382							
	B1103-382-000	B1406-038-BA0	B1524-382-0B0	B1613-382-000	B2311-382-000	B2312-	382-000	

#### MH-380

Description	Diskt lass an	1.64.1	De delide com	Ded alida asso		Folder	
$\backslash$	Right looper	Left looper	Bed slide asm.	Bed slide asm.	М	MH	н
Gauge components			Si.		Ć	30°	
3.2mm (1/8")					B9126-038-BAA	B9126-038-BAB	B9126-038-BAC
4.0mm (5/32")					B9126-038-CAA	B9126-038-CAB	B9126-038-CAC
4.8mm (3/16")		B2031-380-000	B1104-380-AA0	B1108-380-BA0	B9126-038-DAA	B9126-038-DAB	B9126-038-DAC
5.6mm (7/32")	B2030-380-000				B9126-038-EAA	B9126-038-EAB	B9126-038-EAC
6.4mm (1/4")	B2030-300-000				B9126-038-FAA	B9126-038-FAB	B9126-038-FAC
7.9mm (5/16")				B1108-380-HA0	B9126-038-HAA	B9126-038-HAB	B9126-038-HAC
9.5mm (3/8")				БТТ08-380-HAU			
12.7mm (1/2")			B1104-380-LA0	B1108-380-LA0			
MH-382							
	B2030-380-000	B2031-380-000	B1104-380-A00	B1108-380-B00			

#### 1) Size code

3.2mm (1/8") = B
4.0mm (5/32") = C
4.8mm (3/16") = D
5.6mm (7/32") = E
6.4mm (1/4") = F
7.9mm (5/16") = H
9.5mm (3/8") = K
12.7mm (1/2" ) = L

#### 2) Folder code

Μ	(for light weight materials) = A
MH	l (for medium heavy weight materials) = B
Н	(for heavy weight materials) = C

#### 1-needle, Double Chainstitch Machine

## MH-481 MH-481-5(4) (with an automatic thread trimmer)

- The machine comes with a thread spreading mechanism and an adjustable needle guard to prevent stitch skipping. The thread clamp mechanism, tension release mechanism and needle thread draw-out mechanism enable the machine to leave thread of a uniform length after thread trimming, and prevent slip-off of the needle thread. All of these mechanisms contribute to upgraded sewing.
- Safety stitching (condensation stitching) the perfect method of preventing loose stitches, or reverse feed stitching (back-tacking) can be alternated through the simple adjustment of the stopper of the reverse feed lever. Either sewing method can be used.

#### 1-needle, Double Chainstitch Differential-feed Machine

## MH-484 MH-484-5(4) (with an automatic thread trimmer)

- The differential-feed is the best-suited feeding device when sewing elastic materials including double-jersey or light-weight materials such as satin or georgette.
   Beautiful, elastic seams are created, while puckering, thread breakage and thread fraying are all prevented.
- The sewing method can be alternated between stretch stitching and shirr stitching with the simple operation of a lever. This lever is also used to adjust the differential-feed ratio.



MH-481-5

6

1-needle, Double Chainstitch, Bottom & Variable Top-feed Machine with an Automatic Thread Trimmer

## MH-486-5(4)

- The machine comes with many different functions to prevent uneven material feed and puckering for higher-quality seams. The machine is adaptable to a wider variety of light-to heavyweight materials and takes full advantage of top-feed mechanism. This enables unskilled operators to finish seams of consistent quality.
- The machine comes with a forced lifting mechanism for the top-feed dog. This enables the operator to place the material to be sewn on the top-feed dog more smoothly. The machine incorporates its exclusive chain-off thread presser pedal foot, which improves seam quality and ease of operation.

### SPECIFICATIONS

Model name	MH-481	MH-481-5(4)	MH-484	MH-484-5(4)	MH-486-5(4)
Feed system	Botton	n-feed	Differer	ntial-feed	Bottom & variable top-feed
Max. sewing speed		5,500rpm			4,500rpm
Stitch length	1~4	lmm		d: 1 ~ 4mm ed: 1 ~ 5.6mm	1 ~ 5mm
Top-feed amount					0 ~ 7mm
Differential-feed ratio			Max. gathering (standa Max. stretch st	stitching 1: 3.0 rd 1: 1.5) itching 1: 0.5	
Lift of the presser foot		By hand: 5mm,	By knee: 10mm		By hand: 5mm, By knee: 7mm
Needle bar stroke		301	mm		33mm
Needle (at the time of the delivery)		TV × 7 (#1	1) #9 ~ #18		TV × 7 (#11) #9 ~ #21
Stitch length adjustment			Ву	dial	
Safety stitch		Cond	lensation stitch/reve	rse stitching (by feed	lever)
Looper system			Incline	ed crank	
Looper stroke			21.	ōmm	
Looper stroke of the front and rear		2.1 ~ 3	3.3mm		3.2mm
Speed control		* (1)		* (1)	* (1)
Lubrication			Auto	matic	
Lubricating oil		JUł	(I New Defrix Oil No.	1 (equivalent to ISO V	G7)
Power consumption		* (2)		* (2)	* (2)

* (1) From 500rpm to the Max. sewing speed determined by the pulley used (externally adjustable)
 * (2) Single-phase, 3-phase (400W)

## APPLICATION FOR MH-481/MH-484/MH-486 SERIES

Men's shirts	Attaching yokes on the back
Slacks, pantaloons, ski pants	Attaching waist belts, joining sides, seam insides, or hip seams.
Coats, blazers	Sewing the center of the back, joining sides, sewing sleeves, belts, collars, and sewing the facing on to the front.
Skirts	Sewing the center and joining sides
One-piece suits, blouses, negligees	Making pleats or gathers
Uniforms, jumpers	Sew side and sew interlining on the wrong side of the material
Interior decorations	Making pleats or gathers

### SPECIFICATION CONFIRMATION TABLE WITH TYPES OF MACHINES

Model name	MH-481	MH-481-5(4)	MH-484	MH-484-5(4)	MH-486-5(4)	Remarks
Condensation stitch						Use the reverse stitiching lever
Revers stitch						Adjust the stopper
Thread clamp device						
Needle thread releasing device						
Needle thread drow-out mechanism						
Thread spreader						
Movable needle guard						
Sliding presser						
Chain-off thread presser			Option	Option		Chain-off thread presser foot for the MH-480 series
Silicon oil lubricating unit						Provided as standard (packed together with accessories)

## OPTIONS

Model	Part No.	Description	Application Application					
woder	Part No.	Description	Remarks	MH-481	MH-481-5(4)	MH-484	MH-484-5(4)	MH-486-5(4)
AK4		Auto-lifter						
PF-3		Partial shirring device	Upper shirring					
PF-5		Partial shirring device	Lower shirring			×		
S060	MAS-06000A0	Attachment for gathering (manual type)	Specialized presser foot, main feed dog,			×		
S061	MAS-061000A0	Attachment for intermittent gathering (foot pedal type)	differential-feed dog			×		

## REPLACEABLE GAUGE TABLE

#### • MH-481, MH-481-5(4)

#### • MH-484, MH-484-5(4)

Usage	Throat plate	Feed dog	Presser foot			
Light-weight materials	B1103-481-A00	B1613-481-A00	B1524-481-CC0			
Medium-weight materials	B1103-481-F00	B1613-481-F00	B1524-481-CC0			
Heavy-weight materials	B1103-481-H00	B1613-481-H00	B1524-481-H00			
In addition, a urethane feed dog and coarse feed dog are also available.						

Usage	Throat plate	Main feed dog	Differential- feed dog	Presser foot
Light-weight materials	B1103-484-B00			
Medium-weight material (standard)	B1103-484-F00	B1613-484-F00	B1653-484-F00	B1524-481-CC0
Urethan pad		B1613-484-G00	B1653-484-G00	
Reverse feed dog			B1653-484-C00	
Gathering one piece of material				B1524-481-DA0
S060 and S061 a     and differential	are optionally av feed dog exclusi			ain feed dog

#### • MH-486-5(4)

	● MH-4865(4)						
Code	Usage	Throat plate	Feed dag	Walking foot	Presser foot		
	Standard type for general runstitch (rake-in type)		B1613-481-F00	B3026-487-000	B1524-486-0A0		
В	For medium turning stitch, gathering stitch (rake-in type: for preventing uneven mateial feed)			B3026-487-000	B1524-486-BA0		
D	For sharp turning stitch (pull-in type: for Preventing Puckering)	B1103-481-F00		B3026-487-D00	B1524-486-DA0		
м	For seaming side of slacks (right-compensaling foot for side pockets)			B3026-487-M00	B1524-486-MAA		
s	For sharp turning stich (rake-in type: for Preventing puckering)			B3026-487-S00	B1524-486-SA0		

High-speed, Cylinder-bed, Needle-feed, Double Chainstitch Machine

## MH-1410

- With its head mechanism to ensure optimum balance and high rigidity, the machine achieves high-speed performance of 5,000rpm with reduced operating noise and vibration.
- And now that an automatic lubricating system and strong needlefeed mechanism are newly adopted, the machine guarantees improved reliability and durability.
- The MH-1410 is a needle-feed machine noted for an outstanding feed efficiency that ensures smooth stitching at the beginning of sewing and consistent stitch pitches when sewing multi-layered sections.
- The machine uses a right-and-left split type needle thread take-up guide. Even when the right and left needles sew materials of different thicknesses, separate stroke can be set for the right and left thread take-up guide to ensure consistently excellent seam quality.
- The differential between the needle-feed amount and bottom-feed amount can be adjusted within the range of -5 % to +25 % of the latter. Waving or twisting of the material can be prevented by adjusting the differential-feed amount to suit the material thickness, the type of folder to be used, and other sewing conditions.
- The cloth puller is driven by a top roller, ensuring excellent feed efficiency and uniform stitch pitches at multi-layered parts of the material.
- The machine comes with a light-in-weight roller that offers good adhesion on the material to ensure consistent stitch pitches regardless of the sewing speed, i.e., both at a low high speeds.



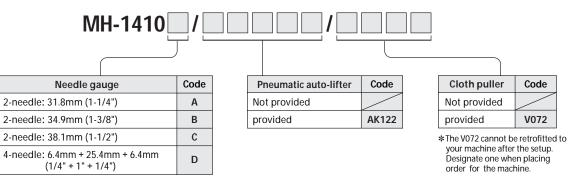
MH-1410D/AK122/V072



#### **SPECIFICATIONS**

Model name	MH-1410A	MH-1410B	MH-1410C	MH-1410D		
Needle gauge	31.8mm (1-1/4")	34.9mm (1-3/8")	38.1mm (1-1/2")	6.4mm + 25.4mm + 6.4mm (1/4" + 1" + 1/4")		
Number of needle	2-needle			4-needle		
Feed system	Needle-feed					
	Needle-feed + Cloth puller (optional)					
Stitch system	Double chainstitch					
Max. sewing speed	5,000rpm (when stitch length is 4.5mm or less) 4,000rpm (when stitch length is 4.5 ~ 6.4mm) (4,000rpm for the machine equipped with a cloth puller)					
Stitch length	2.1 ~ 6.4mm					
Stitch adjusting method	By push-button (needle-feed/bottom-feed synchronized)					
Lift of the presser foot	9mm					
Needle bar stroke	32mm					
Needle $DV \times 57 (#21) #18 \sim #25^{*}$						
Looper motion	Longitudinal motion method (longitudinal swing method) : Looper can be tilted for threading					
Fine adjustment function for the needle-feed amount	Provided as standard ( $-5\% \sim +25\%$ )					
Peripheral dimension of the cylinder section	395mm (for the machine that is not equipped with a cloth puller)					
Lubrication	Trochoidal pump type automatic lubrication					
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)					
Weight of the machine head		46kg		50kg		

* For needle size #23 to #25, a special-order gauge is required.



* The needle gauge that falls within the range from 4.8mm to 50.8mm is available. Gauges other than those shown in the above table are available on a special order.

### OPTIONS

Model	Part No.	Description		
AK122	GAK-A22010B0	Pneumatic auto-lifter (* JUKI: The SC-380 or a commercially available needle positioning motor is required.)		
	311-42565	Needle cooler (pneumatic type): For MH-1410A		
	311-43068	Needle cooler (pneumatic type): For MH-1410B, MH-1410C		
	311-43167	Needle cooler (pneumatic type): For MH-1410D		
	311-41658	Brakedown folder bracket (asm.)		
	MAV-07236000	Top roller (made of iron)		
	MAV-07237000	Top roller (made of urethane)		
	MAV-07240000	Top roller cover (for urethan roller)		

Feed-off-the-arm, 2-needle Double Chainstitch Machine

## MS-1190

- Both needle thread tension and bobbin thread tension have been decreased after reinvestigation of the double chainstitching mechanism. Furthermore, the stitch dial, gauges and looper have been dramatically improved, thereby forming beautifully finished seams and preventing puckering.
- Relation between the needle and the looper, and the relation between the needle and the feed have been changed. This enables the machine to consistently form seams of uniform quality. The machine prevents stitch skipping when it runs at high speed, thereby producing higher-grade products.
- Newly developed folders are equipped as standard for the machine. The folders are designed to match the presser foot and allow overlapping material to be fed smoothly under them. They are easy to use and improve consistency in sewing. Many different kinds of folders are prepared in accordance with the materials, ranging from extra heavy-weight materials to medium-weight materials.

#### Feed-off-the-arm, 2-needle/3-needle Double Chainstitch Machine

## MS-1260 (2-needle) MS-1261 (3-needle)

- The placement of the feed mechanism has been charged to decrease the feed amount when the needle enters the material, thus preventing the needle from bending. The bobbin thread is clamped without fail, thereby producing consistent thread loops. The looper tucks the needle thread without fail, thereby finishing uniform seams.
- The number of teeth of the feed dog has been increased so that it can easily catche overlapping material. The shape of the presser foot has been modified to prevent single-sided contact with the overlapped part. The movable needle guard (rear) is provided with a vertical adjusting mechanism. These features contribute to smoother feed of heavy-weight materials, thereby preventing stitch skipping.
- Thanks to the tread guide located between the needle bar thread take-up and the intermediate tension release lever, the timing to tense the needle thread can be changed and the bobbin thread tension can be decreased. As a result, the machine is capable of beautiful finished stitches with a soft appearance even when heavy-weight material is used.





6

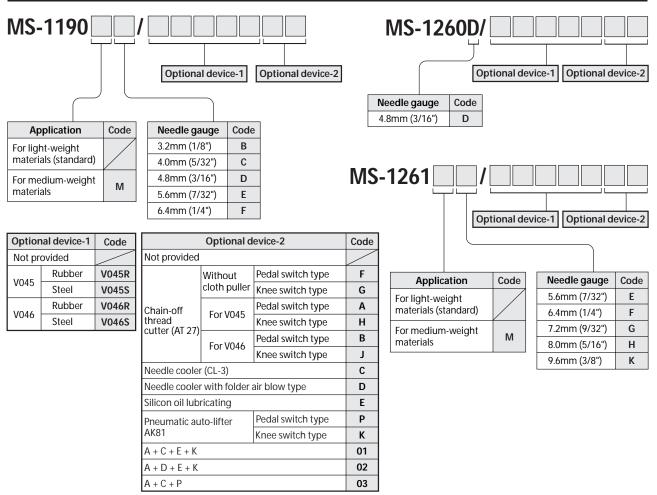


MS-1261/V045

## SPECIFICATIONS

Model name	MS-1190 MS-1190/V046	MS-1190M MS-1190M/V045	MS1260/V045 MS-1260	MS-1261M/V045 MS-1261M	MS-1261/V045 MS-1261	
Application	For light-weight materials	For medium-weight materials	For medium-to heavy-weight materials		For extra heavy-weight materials for jeans	
No. of needle		2	3		3	
Max. sewing speed	4,000rpm (normal 3,500rpm)		3,600rpm (normal 3,000rpm)			
Needle bar stroke	28.0mm		33.2mm			
Needle (at the time of delivery)	SCHMETZ B-64 (Nm80) Nm60 ~ Nm90 ORGAN TV x 64-NY (#12) #8 ~ #14	SCHMETZ B-64 (Nm100) Nm80 ~ Nm120 ORGAN TV x 64-NY (#16) #12 ~ #19	SCHMETZ UY128GAS (Nm120) Nm100 - Nm140 ORGAN UY x 128GAS-NY (#19) #16 ~ #22		SCHMETZ UY128GAS (Nm130) Nm100 ~ Nm140 ORGAN UY x 128GAS-NY (#21) #16 ~ #22	
Needle gauge         3.2mm (1/8"), 4.0mm (5/32"), 4.8mm (3/16"), 5.6mm (7/32"), 6.4mm (1/4")         4.8mm (3/16"), 4.8mm		4.8mm (3/16") 5.6mm (7/32"), 6.4mm (1/4"), 7.2mm (9/32"), 8.0mm (5/16"), 9.6mm (3/8")				
Stitch length	1.2 ~ 3.2mm		1.4 ~ 4.2mm			
Lift of the presser foot	e presser 10mm					
Thread take-up lever	Thread pulling cam type thread take-up lever	Needle bar thread take-up lever				
Circumference of tube at the needle entry 171mm		190mm				
Needle guard	Longitudinally-fixe	ed needle guard	Backward travelling needle guard			
Stitch adjusting system	By a push-button (with a locking mechanism)					
Lubrication	Semi-automatic lubrication					
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)					

### WHEN YOU PLACE ORDERS



## **OPTIONS**

Model	Part No.	Descrip	otion	Feature		
Cloth	puller					
10.15	MAV-04500AA0	Made of rubber	<b>.</b>	The cloth puller is an auxiliary tool for smooth feed of the material. The top roller		
V045	MAV-045000A0	Made of steel	Top roller type	type cloth puller (V045) can be used for medium- to extra heavy-weight materials for		
	MAV-04600AA0	Made of rubber	Top and bottom	jeans. The top and bottom roller type cloth puller (V046) can be used for light- to medium-weight materials. Furthermore, you can choose either a rubber cloth puller		
V046	MAV-046000A0	Made of steel	roller type	that is soft on material, or steel cloth puller that securely clamps the materials.		
Chain	off thread cutter	•				
	GAT-270000A0 Pedal switch typ		Without			
	GAT-27000CA0	Knee switch type	cloth puller			
AT07	GAT-27000AA0	Pedal switch type	For V045	The chain-off thread cutter is operated by the knee switch or the pedal switch. The chain-off thread cutter comes in three different types in accordance with the		
AT27	GAT-27000DA0	Knee switch type	FUI V045	types of cloth pullers and whether or not the machine is equipped with a cloth puller.		
	GAT-27000BA0	Pedal switch type	For V046			
	GAT-27000EA0	Knee switch type	FUI VU46			
Needl	e cooler					
01.0	GCL-030000A0	Standard		The needle cooler is a device to prevent thread breakage caused by a hot needle. The needle cooler equipped with an auxiliary blower (for light-weight materials)		
CL-3	GCL-03000AA0	With an auxiliary b light-weight mate		available, and this allows the material to be easily rolled in at the sewing start.		
Silicor	n oil lubricating u	nit for the needle	thread			
	129-45168	For MS-1190 series	5	Silicon oil lubricating unit is an auxiliary device to reduce the frequency of thread		
	129-76254	6254 For MS-1260 series		breakage caused by a hot needle.		
Pneun	natic auto-lifter					
AI/01	GAK-810000A0 Pedal switch type		The pneumatic auto-lifter helps reduce the operator's fatigue and enables the			
AK81	GAK-81000AA0	Knee switch type		operator to operate the sewing machine rhythmically.		

### TABLE OF EXCHANGING GAUGE PARTS

### MS-1190

		1	2	3	4	5	6	7
D	escription	Gauge set (with finger guard)	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog	Looper asm. (L)	Looper asm. (R)
Need	le gauge size				A		A	
Code	<u> </u>							
	Size			G		¥	¥⁄	<b>V</b>
В	3.2mm (1/8")	129-23561	129-23504	129-26051	129-27869	129-32307	129-41555	129-40656
С	4.0mm (5/32")	129-23660	129-23603	129-26150	129-27968	129-32307	129-41654	129-40755
D	4.8mm (3/16")	129-23462	129-23405	129-25954	129-27760	129-32307	129-41456	129-40557
E	5.6mm (7/32")	129-23769	129-23702	129-26259	129-28065	129-32307	129-41753	129-40854
F	6.4mm (1/4")	129-23868	129-23801	129-26358	129-28164	129-32406	129-41852	129-40953
н	7.9mm (5/16")		129-24007	129-26457	129-28354	129-32802	129-41951	129-41050

		8	9	10	11	12	13	14
	escription		Lap seam folder asm		Feed dog asm. (with removing needle holder)	Looper needle guide (for removing	Throat plate (for chain-off	Feed (for chain-off
	escription	M295	M296	M297		needle holder)	thread)	thread)
Need	lle gauge size							
Code			VD			2		
Code	Size		$\sim$			(°		
В	3.2mm (1/8")	MAM-2950AAAA	MAM-2960AAAA	MAM-2970AAAA	129-32653	129-43007	129-23306	129-32208
С	4.0mm (5/32")	MAM-2950BBAA	MAM-2960BBAA	MAM-2970BBAA	129-32653	129-43007		
D	4.8mm (3/16")	MAM-2950CCAA	MAM-2960CCAA	MAM-2970CCAA	129-32653	129-43007		
E	5.6mm (7/32")	MAM-2950DDAA	MAM-2960DDAA	MAM-2970DDAA	129-32653	129-43007		
F	6.4mm (1/4")	MAM-2950EEAA	MAM-2960EEAA	MAM-2970EEAA	129-32752	129-43007		
н	7.9mm (5/16")			MAM-2970GGAA				

Folder mark: M295- Extra light-weight materials, M296 - Light-weight materials (MS-1190 standard equipment), M297 - Medium-weight materials (MS-1190M standard equipment) The folder is not included in gauge set. For code H, throat plate, presser foot and feed dog for MS-1190 are used. Also, exclusive needle guards (12943957) are necessary.

#### MS-1190M

		1	2	3	4	5	6	7
D	escription	Gauge set (with finger guard)	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog	Looper asm. (L)	Looper asm. (R)
Need Code	lle gauge size							
В	3.2mm (1/8")	129-80561	129-80504	129-26051	129-82666	129-83508	129-41555	129-40656
С	4.0mm (5/32")	129-80660	129-80603	129-26150	129-82765	129-83508	129-41654	129-40755
D	4.8mm (3/16")	129-80462	129-80405	129-25954	129-82567	129-83508	129-41456	129-40557
E	5.6mm (7/32")	129-80769	129-80702	129-26259	129-82864	129-83508	129-41753	129-40854
F	6.4mm (1/4")	129-80868	129-80801	129-26358	129-82963	129-83607	129-41852	129-40953

		8	9	10	11	
		Lap seam f	folder asm.	Throat plate (for chain-off	Feed	
D	escription	M296	M297	thread)	(for chain-off thread)	
Needle gauge size			2			
Code		$\sim$	Se .			
coue	Size		$\searrow$			
В	3.2mm (1/8")	MAM-2960AAAA	MAM-2970AAAA	129-80900	129-83706	
С	4.0mm (5/32")	MAM-2960BBAA	MAM-2970BBAA			
D	4.8mm (3/16")	MAM-2960CCAA	MAM-2970CCAA			
Е	5.6mm (7/32")	MAM-2960DDAA	MAM-2970DDAA			
F	6.4mm (1/4")	MAM-2960EEAA	MAM-2970EEAA			

### MS-1261/V045 (for extra heavy-weight materials)

		1	2	3	4	5
D	escription	Gauge set (with finger guard)	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog asm.
Needle gauge size						
Code				200		
	Size		×	P.		· •
Е	5.6mm (7/32")	129-53360	129-53303	129-56355	129-60167	129-63450
F	6.4mm (1/4")	129-53261	129-53204	129-56256	129-60068	129-63351
G	7.2mm (9/32")	129-53469	129-53402	129-56454	129-60266	129-63559
н	8.0mm (5/16")	129-53568	129-53501	129-56553	129-60365	129-63658
К	9.5mm (3/8")	129-53667	129-53600	129-56652	129-60464	129-63757

### MS-1261/V045 (for heavy-weight materials)---Option

		6		7		8				1	2	3
D	escription	Looper (L)				Looper (C)			Gauge set	Throat plate	Feed dog asm.	
Need	lle gauge size		Mark		<u>Mark</u>		<u>Mark</u>	Need	lle gauge size			
Code	Size	Ì	Mark No.	Ì	Mark No.	Ì	Mark No.	Code	Size		- Star	
Е	5.6mm (7/32")	129-68558	1	129-68855	1	129-69150	1	Ε	5.6mm (7/32")	129-72253	129-72204	129-74259
F	6.4mm (1/4")	Ť	1	Ť	1	Ť	1	F	6.4mm (1/4")	129-72154	129-72105	129-74150
G	7.2mm (9/32")	Ť	1	Ť	1	Ť	1	G	7.2mm (9/32")	129-72352	129-72303	129-74358
н	8.0mm (5/16")	129-68657	2	129-68954	2	Ť	1	Н	8.0mm (5/16")	129-72451	129-72402	129-74457
К	9.5mm (3/8")	Ť	2	Ť	2	Ť	1	К	9.5mm (3/8")	129-72550	129-72501	129-74556

### MS-1260 · 1261M/V045 (for medium-weight materials)-Option

		1		2 3		4	5	6		7	
	Description Needle gauge size		Gauge set (with finger guard)	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog asm.	Looper (L)		Loope (R)	r
Model				6		S.		Mark		Mark	
	Code				Con I				Mark		Mark
		Size		<b>*</b>			Ŷ	SP -	No.	X)	No.
MS-1260 /V045	D	4.8mm (3/16")	129-77963	129-77906	129-25954	129-78268	129-78755	129-79258	3	129-79357	2
	Е	5.6mm (7/32")		129-72907			129-75058				
	F	6.4mm (1/4")		129-72808			129-74952				
MS-1261 /V045	G	7.2mm (9/32")		129-73004			129-75157				
	Н	8.0mm (5/16")		129-73103			129-75256				
	к	9.5mm (3/8")		129-73202			129-75355				

			8	9	
	D	escription	Looper (C)	Thread guide	
Model	Need	lle gauge size			
	Code		<u> </u>	Q	
		Size	SP -	$\smile$	
MS-1260 /V045	D	4.8mm (3/16")		B1130-051-000	
	E	5.6mm (7/32")		t	
	F	6.4mm (1/4")		†	
MS-1261 /V045	G	7.2mm (9/32")		†	
	н	8.0mm (5/16")		t	
	к	9.5mm (3/8")		†	

1

		10. Spacer for press	ser	Screw for spacer			
No.	Thickness	Part No.	Description	Part No.	Qty		
1	0.3	129-72509	Adjusting plate B	SS-5060310SP	2		
2	0.5	129-73608	Adjusting plate C	Ť	2		
3	0.8	129-73707	Adjusting plate D	SS-5060410SP	2		
4	1.0	129-62106	Adjusting plate A	Ť	2		
5	1.2	129-73806	Adjusting plate E	t	2		
Tho	spacer and	installing scrows are	not included in agua	s sat			

The spacer and installing screws are not included in gauge set.

	11. Spacer for presser									
No.	Thickness	Part No.	Description							
1	0.3	129-75702	Adjusting plate B							
2	0.5	129-64102	Adjusting plate A							
3	0.8	129-75801	Adjusting plate C							
4	1.0	129-75900	Adjusting plate D							

The spacer is not included in gauge set.

### MS-1261M/V045 (for medium-weight materials)

		1	2	3	4	5
Description		Gauge set (with finger guard)	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog asm.
Needle gauge size					S.	
Code	Size			no see		
E	5.6mm (7/32")	129-72972	129-72907	129-56355	129-60183	129-75058
F	6.4mm (1/4")	129-72873	129-72808	129-56256	129-60084	129-74952
G	7.2mm (9/32")	129-73079	129-73004	129-56454	129-60282	129-75157
Н	8.0mm (5/16")	129-73178	129-73103	129-56553	129-60381	129-75256
К	9.5mm (3/8")	129-73277	129-73202	129-56652	129-60480	129-75355

		6		7		8	
D	escription	Looper (L)		Looper (R)		Looper (C)	
Need	lle gauge size	age size Mark Mark		ark	Mark		
Code	Size	Ð	Mark No.	Ì	Mark No.	Ì	Mark No.
E	5.6mm (7/32")	129-68558	1	129-68855	1	129-69150	1
F	6.4mm (1/4")	†	1	1	1	Ť	1
G	7.2mm (9/32")	t	1	t	1	Ť	1
Н	8.0mm (5/16")	129-68657	2	129-68954	2	Ť	1
к	9.5mm (3/8")	Ť	2	1	2	Ť	1

		1	2	3
Description Folder asm.				
Need	lle gauge size	M297	M298	M299
	Mark	MH	Н	ХН
Code				<u>lark</u>
	Size			
D	4.8mm (3/16")	MAM-2970CCBA		
E	5.6mm (7/32")	MAM-2970DDBA	MAM-2980AABA	MAM-2990AABA
F	6.4mm (1/4")	MAM-2970EEBA	MAM-2980BBBA	MAM-2990BBBA
G	7.2mm (9/32")	MAM-2970FFBA	MAM-2980CCBA	MAM-2990CCBA
н	8.0mm (5/16")	MAM-2970GGBA	MAM-2980DDBA	MAM-2990DDBA
к	9.5mm (3/8")	MAM-2970HHBA	MAM-2980EEBA	MAM-2990EEBA

Т

The folder is not included in gauge set. Folder mark

M297 — Medium-weight materials (MS-1261M/1260/V045 standard equipment) M298 — Heavy-weight materials

M299 - Extra heavy-weight materials (MS-1261/V045 standard equipment)

		1	2	
De	escription	Roller asm.		
Need	le gauge size	Steel roller	Urethane roller	
Code		6		
	Size	L'as		
D	4.8mm (3/16")	MAV-045450A0	MAV-045500B0	
Е	5.6mm (7/32")	Ť	Ť	
F	6.4mm (1/4")	Ť	Ť	
G	7.2mm (9/32")	Ť	Ť	
н	8.0mm (5/16")	Ť	<b>↑</b>	
к	9.5mm (3/8")	Ť	†	

 $\overline{}$ 

The cloth roller is not included in gauge set.

The kind of roller Steel roller —— Heavy & extra heavy-weight materials (MS-1261/V045 standard equipment) Urethane roller - Medium-weight materials

Computer-controlled, Dry-head, High-speed, Single-thread, Chainstitch Button Sewing Machine

## MB-1800B (with a wiper unit)

- The machine has 55 different stitching patterns as standard. In addition to the sewing shapes, the buttonhole intervals and number of stitches can also be changed on the operation panel. The machine completely supports many different button specifications to increase its range of applicability, reduce costs associated with changes in specifications, and save the operator from having to adapt the machine to different specifications.
- The machine performs thread trimming at the optimal position by correcting the button position with respect to the needle entry of the last stitch. This shortens the thread remaining on the material after thread trimming to approx. 3.5mm.
- The machine comes as standard with the solenoid-operated, thread-tensionchangeover "thread-fray-prevention function." Since the machine is designed to use a long needle (TQ × 7), the "thread-fray-prevention function" can be used for sewing shank buttons.
- The machine head is a non-lubricating type. With this type, the operator never has to add oil, and staining of the sewing product with oil is an impossibility.

## MB-1800A/BR10 (with a button feeder)

- The three different operation modes available are the automatic button feeding mode in which the machine continuously feeds the buttons in the feeder bowl, the non-feed mode in which the operator manually places the buttons in the sewing position one by one, and the small-lot sewing mode in which the operator sets the buttons in place for one garment (five or six buttons) in advance, upon which the buttons are automatically and continuously fed to the sewing position. As a result the machine can employed by a small-lot production system by selecting the appropriate operation mode.
- The machine is provided with a wider sewing area to facilitate garment setting, and allows the operator to check the remaining quantity of buttons while remaining seated, thereby enhancing ease of operation. Furthermore, the machine allows the operator to continuously sew buttons with pedal depressed, thereby helping reduce the operator's fatigue.



MB-1800A/BR10

## SPECIFICATIONS

Model name	MB-1800S	MB-1800B	MB-1800A/BR10		
Max. sewing speed		1,800	Orpm		
Amount of feed	Crosswise feed 0 ~ 10mm/Le	ngthwise feed 0 ~ 6.5mm	Crosswise feed 0 ~ 4.0mm/Lengthwise feed 0 ~ 4.0mm		
Applicable button	Type: Round-shaped flat button Size: 10 ~ 28mm Attachment: • For small button ( 10 ~ 12mm) • For medium button ( 12 ~ 20mm) • For large button ( 20mm or more) Thickness: 1.8 ~ 5.0mm • The button clamp jaw lever for thick button has to be used for buttons with thicknesses of 3.5mm or more.		<ul> <li>Type: Round-shaped flat button</li> <li>Size: 9 ~ 26mm</li> <li>Machines can be custom ordered for the sewing of button diameters outside the standard range less than 10mm and less, 19mm and over.</li> <li>For button of which diameter is 16mm or more, a button clamp jaw lever for large buttons has to be used.</li> <li>Thickness: 1.8 ~ 3.5mm</li> </ul>		
	Type: Shank button, wrapped-around button, snap, metal button, stay button, label (exclusive attachments have to be used.)				
Stitching shape	$ \begin{array}{c} \square, \square, \square, X, X, Z, \Gamma \\ \hline \triangle, \nabla, \forall, Q, D \end{array} $	ר, ו, −−, ו	$\Box, \Box, X, X, Z, \Box, \Box, \Box, -, \Box$		
Wiper unit	Options Provided as standard				
Lift of the button clamp	Max. 14mm				
Needle bar stroke		48.6	omm		
Needle (at the time of delivery)		TQ × 7 (#16	b) #14 ~ #20		
Feed system		By steppi	ng motor		
Knot-tying mechanism		Provided a	is standard		
Lubrication		No lubi	rication		
Discrimination of button to be feed			Vibration system		
Button feed			By the horizontal, forced feed mechanism		
Button feed mode		Automatic feed mode, non-feed and small-lot sewing mod			
Power requirement		e 220 ~ 240V, 100 ~ 120V g over the PWB connector) Single-phase 100V, 115V, 200V, 220V, 240V			
Power consumption	15	50W	250W		
Weight	Machine head, o	circuit board 25kg	Machine head, circuit board + control box for BR + device + table 56.5kg		

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MB-1800B, 1800A/BR10 (June, 2001) 1/4



## MB-1800S, MB-1800B (with a wiper unit) ____

## WHEN YOU PLACE ORDERS

### Machine head, Circuit board

MB-18	300		
Specification	Code	Attachment	Code
Without a wiper unit	s	For flat button (small)	
With a wiper unit	В	For flat button (medium)	М

## **OPTIONS**

Model	Part No.	Description	Feature
wouch	Tarrito.	Description	
	M8512-630-0A0	Wiper device (for MB-1800S)	A wiper device and thread pulling wire used in unison to sew buttons without cross-over stitches.
	M8513-630-0A0	2-step pedal unit	A foot pedal unit and accompanying pitman rod. The pedal is operated in two steps, i.e., for lowering the button clamp and starting the sewing machine to facilitate positioning of the button and sewing product.
PK-51	GPK-510010B0	2-pedal unit for standing work	* For PK-51 or PK-57, pedal switch conversion cable asm.
PK-57	GPK-570010B0	2-step pedal unit for standing work	(Part No.: M9013-590-0A0)

## PATTERN DATA TABLE

Pattern	Shape		Number of stitches	Stitch pitch	
No.	Application	Stitch diagram	Data setting range	Data setting range	
1~3	4-holed		15, 19, 23, 27		
4 ~ 6	4-holed		16, 20, 24, 28		
7~9	4-holed	×	15, 19, 23, 27		
10~12	4-holed	X	16, 20, 24, 28	2.0 ~ 6.5mm (in increments	
13~15	4-holed		15, 19, 23, 27	of 0.2 mm)	
16~18	2-holed	I	8, 10, 12, 14		
19~21	2-holed		0, 10, 12, 14		
22~24	4-holed		15, 19, 23, 27		
25 ~ 27	4-holed		16, 20, 24, 28		
28 ~ 30	3-holed				
31 ~ 33	3-holed		17 00	2.6, 2.8, 3.0mm	
34 ~ 36	3-holed		17, 23	2.0, 2.0, 3.011111	
37 ~ 39	3-holed				
40 ~ 42	Label attachment		5, 7	6.0, 8.0, 10.0mm	
43 ~ 45	Button neck wrapping, 2nd process Zigzag width: 4 mm			Duttor	
46~48	Button neck wrapping, 2nd process Zigzag width: 5 mm	WWW.	6, 10, 16	Button neck height 0 ~ 6.5mm (in increments	
49~51	Button neck wrapping, 2nd process Zigzag width: 6 mm			of 0.2 mm)	

* For all stitch shapes, three different pieces of data can be established by selecting the number of stitches and stitch pitch within the respective data setting ranges.

## DIFFERENCE IN KNOT-TYING METHOD Should the last stitch undo -Conventional machine State of the finished seam With a thread-frayprevention function. MB-1800, MB-377 In the event that the last stitch comes united, the thread will not easily come off. Since the thread knot is securely tied, the last stitch is unlikely to loosen. • Attaching flat button (small)



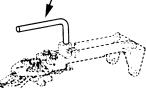
• Space pin (accessory)

### ATTACHMENT TABLE

Ар	plication			Sketch	For MB-1800	For MB-373	For MB-377
	Small- to large-button	Left		Button size A: 0 ~ 6.5mm	D2556-372-CAA	Common	Common
	thickness 5.0mm	Right		B: 0 ~ 6.5mm C: 10 ~ 28mm	D2558-372-CAA	$\leftarrow$	$\leftarrow$
For	Large-buttor thickness 3.5			Button size A: 0 ~ 6.5mm B: 0 ~ 6.5mm C: 20 ~ 28mm	146-17559	MAZ-031000AA *	MAZ-201010A0 *
flat button	Medium-but thickness 3.5			Button size A: 0 ~ 4.5mm B: 0 ~ 4.5mm C: 12 ~ 20mm	D2529-373-B00A	<i>←</i>	<i>←</i>
	Small-buttor thickness 3.5			Button size A: 0 ~ 3.5mm B: 0 ~ 3.5mm C: 10 ~ 12mm	B2529-373-000	<i>←</i>	<i>~</i>
				Button diameter: 16mm or less Shank size A: 5 ~ 6mm B: 2.5 ~ 3mm	146-17658	B2401-373-0BA *	Not prepared
For shank bu	tton		<u>J</u>	Button diameter: 16mm or less Responds to slight variations in the button shank.	146-17757	MAZ-040000AA *	
				Buttons with round shank A: 5mm Cloth-to-button distance is small.	146-17856	MAZ-04000BAA *	
				Button-to-material distance A: 5.5mm	B2447-372-0A0	$\leftarrow$	
For wrapped-aro button	1st proc	cess		Button-to-material distance is adjustable. The machine is capable of sewing flat button without neck wrap. A: 3mm or more B: 12mm or less	141-34050	←	
button	2				B2440-373-0A0	<i>←</i>	
	2nd pro	ocess		The machine wrap the button neck while moving the attachment back and forth.	MAZ-046010A0	~	
For flat button and wrapped-around button (first process of button neck wrapping)			Button-to-material distance A: 5.5mm Flat button sewing process or the first process of button-neck wrapping is enabled by sliding the neck wrapping foot away from the sewing position.	MAZ-172000A0	~		
For snap			Size A: 8mm	146-17955	B2552-373-BAA *		
For metal button				146-18052	B2420-373-0AA *		
For stay butte	on			To be used in combination with the B2447-372-0A0 or 141-34050. For the 141-34050 A: 3.5mm or more	MAZ-039010A0	<i>←</i>	
For label atta	ching			Zigzag width: Max. 10mm	146-18151	MAT-64401ZBA *	

* Applicable by replacing the lifting hook of the button clamp mechanism with that for the MB-1800.

• Button clamp mechanism, lifting hook (Part No.: 146-02502)



Attachments for sewing flat button, shank button, wrapped-around button, snap and bartacking label are prepared. Note that the attachments for the button clamp jaw lever of your MB-373 or -377 can be used with the MB-1800 only by replacing the lifting hook of the button clamp mechanism with the lifting hook exclusive to the MB-1800 (Part No.: 146-02502).

## WHEN YOU PLACE ORDERS

### Machine head, Circuit board: with a button feeder

MB-1800A / BR10						
Attachment	Code		Power	supply	у	Code
For flat button (small)			For General Export	100 ~ 240V		А
For flat button (medium)	м		For CE	220 ~	~ 240V	С
				ſ		
			Feed	plate		Code

Feed plate	Cod
Standard 16 (For small-button)	
22 (For medium-button)	м

## OPTIONS

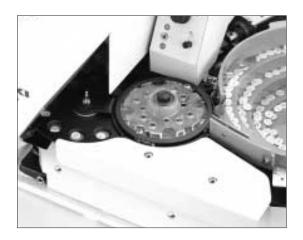
Description	Part No. (asm.)
Button clamp jaw lever (left) for large-sized button	MAZ-088220-BAA
Button clamp jaw lever (right) for large-sized button	MAZ-088230-BAA

## SHAPE OF BUTTON

	Applicable button	Inapplicable carrier
Shape of button	← 1.2mm or more	Button without indented part (concavo-convex shape button)
Remarks	Thickness of button should be 1.8mm to 3.5mm	Button with thin edge may not be fed by the button feeder.

## **BUTTON CARRIER**

	Configuration of button carrier							
For 4-holed button				For 2-holed button				
Distance A (mm): Distance between holes in button	Distance B (mm): Diameter of set pin	Part No.	Code	Distance A (mm): Distance between holes in button	Distance B (mm): Diameter of set pin	Part No.	Code	
			Stan	dard				
2.6	1.0	165-57902	Α	3.2	1.2	165-58009	В	
			Opti	onal				
2.0	1.0	165-90507	Q	2.0	1.0	165-87305	E	
2.2	1.0	165-90606	R	2.2	1.0	165-87404	F	
2.4	1.0	165-88501	S	2.4	1.0	165-87503	G	
2.4	1.2	165-88600	Т	2.4	1.2	165-87909	L	
2.6	1.2	165-88709	U	2.6	1.0	165-87602	н	
2.8	1.2	165-88808	V	2.6	1.2	165-88006	М	
3.0	1.2	165-88907	W	2.8	1.0	165-87701	J	
3.0	1.5	165-89806	F1	2.8	1.2	165-88105	N	
3.1	1.0	165-87206	D	3.0	1.0	165-87800	к	
3.1	1.2	165-89004	Х	3.0	1.2	165-88204	Р	
3.1	1.4	165-89202	Z	3.8	1.2	165-87107	С	
3.2	Taper	165-89905	G1					
3.6	1.2	165-90705	H1	2.8*	1.0	182-13603	J1	
4.0	1.2	165-89707	E1					
					* For \	vertical 2-hole	button	



High-speed, Single-thread, Chainstitch, Button Sewing Machine

## MB-372 SERIES MB-373 SERIES

- Various kinds of attachments, which can do everything from sewing flat buttons to attaching labels, are available. They can be used, in combination with different subclass models, in a wide range of applications.
- The machine ensures consistent sewing performance even when it runs at 1,500rpm. The unique speed-decreasing device reduces vibration when the sewing machine stops, thereby enabling the sewing machine to beautifully finish button with accuracy.
- The MB-373 comes with a compact-in-size thread trimming mechanism which interlocks with the button clamp lifting lever. The thread trimmer allows the machine to beautifully finish button with no remaining thread after thread trimming. Furthermore, the machine can sew large button which need thick thread.



MB-373

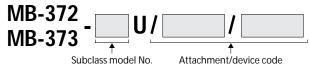
## SPECIFICATIONS

Mod	lel name	MB·	-372	MB	-373		
Thread trimming mechanism		The ordinary mechanism that shock of button clamp lift.	The ordinary mechanism that the tread is cut out by the shock of button clamp lift. The trimming mechanism that the tread is trimmoving knife and the fixed knife under the three shocks of button clamp lift.				
Max. sewing	speed		1,50	0rpm			
Number of st	itches		8, 16, 32* or 6, 12, 24* (	according to each subclass)			
Feed length		N.B. Feed length mus		n, Crosswise 2.5 ~ 6.5mm ch attachment which is suitabl	e to each button size		
Stitching sha	ipe		$\Box$ , $Z$ , $\Box$	$, \Join, \vdash, \bigtriangleup$			
Kinds of buttons which these machines can sew			2- and 4-hole flat button, wrapped-around button, wrapped-around button with stay button, shank button, snap, metal button, metal button with stay button, label.				
Button size		10 ~ 28mm					
Needle bar st	troke	48.6mm					
	ORGAN	TQ × 7 (#16) Nm14 ~ Nm18	TQ × 1 (#16) Nm14 ~ Nm18	TQ × 7 (#16) Nm14 ~ Nm20	TQ × 1 (#16) Nm14 ~ Nm20		
Needle	SCHMETZ	1661EL 1987 2091	1661M 1985 }Nm90 ~ Nm115	1661EL 1987 2091 Nm90 ~ Nm125	1661M 1985 }Nm90 ~ Nm125		
	SINGER	175 × 7 #036 ~ #044	175 ×1 #036 ~ #044	175 × 7 #036 ~ #048	175 × 1 #036 ~ #048		
Button clamp	o lifting system	Automatic system (pedal type possible)					
Sewing syste	m	Single thread chainstitch					
Stop-motion	mechanism	Automatic stop-motion mechanism (equipped with the speed-decreasing device and the reverse rotation preventing device)					
Lubrication			By ar	n oiler			
Lubricating of	bil		JUKI New Defrix Oil No.1	1 (equivalent to ISO VG7)			
Motor			200W (1/4HP) single or 3-phase induction motor				
		* To set the number of stitches to	24 or 32 ontional parts (separat	elv available) stated below are req	uire		

* To set the number of stitches to 24 or 32, optional parts (separately available) stated below are require

## WHEN YOU PLACE ORDERS

MB-372U MB-373U For the Subclass models, devices and attachments



- The number of stitches can be quickly set to one of the six different values, 6, 12, 24, 8, 16, and 32,
  - responding to the changing sewing specifications.

* To set the number of stitches to 24 or 32, optional

parts (separately available) stated below are required.

Discription	Part No.		
Stitch selecting lever	B2642-372-000		
Hinge screw	SD-0600361-SP		

• Device for sewing buttons without cross-over stitches Z025/A014. The machine automatically starts twice continuously by only depressing the pedal once. This means that the machine can sew buttons without the cross-over stitches required for hand sewn buttons.

[•] For the standard machine heads

## TABLE OF MB-372 & 373 SERIES

	Number of stitches	Type of stitching	Description	Remarks
MB-372 MB-373	8,16 or 32			
MB-372-4 MB-373-4	6,12 or 24		<ul> <li>a. Adjustment for 2-hole flat button can be speedily done.</li> <li>b. According to attachments, these models can sew kinds of buttons such as wrapped-around button, wrapped-around</li> </ul>	By means of setting the electro- magnetic wiper (Z025) and starting magnet (AO14), each crossover
MB-372-5 MB-373-5	6,12 or 24		<ul><li>button with stay button, shank button, snap, metal button, metal button with stay button and label.</li><li>c. Without attachments, these models are of use only to small flat button.</li></ul>	stitch of buttons can be taken off!!
MB-372-10 MB-373-10	8,16 or 32		(In case of sewing other size or other type buttons, it is necessary to set the suitable attachmentscf. the right page)	
MB-372-11 MB-373-11	8,16 or 32			
MB-372-6 MB-373-6	6,12 or 24		<ul><li>a. These two models are exclusively used for 4-hole flat button.</li><li>b. Without attachments, these models are of use only to small flat button.</li></ul>	
MB-372-12 MB-373-12	8,16 or 32		(In case of sewing other size flat buttons, it is necessary to set the suitable attachmentscf. the right page)	
MB-372-16 MB-373-16	8,16 or 32		This model is exclusively used for extremely small 2 and 4-hole flat button for button-downcf. the right page.	
MB-372-14 MB-373-14	8,16 or 32		Exclusively for attaching 2-holed flat button with holes aligned vertically.	
MB-372-15 MB-373-15	8,16 or 32	Max. 6mm Max. 5mm	<ul><li>a. This model is exclusively used for second process of wrapped-around button.</li><li>b. The wrapped-around action is performed by front and back moving, and consequently the wrapped-around part is liable to be rigid.</li></ul>	
* MB-372-17 MB-373-17	18 or 36		Exclusively for attaching 3-holed flat button	

* The machine for attaching 3-holed flat buttons is made to order.

## TABLE OF BUTTON SIZES & ATTACHMENTS

### Flat button

	in common wit	tton size th the attachments of es & MB-373 series	Attachmer for MB-372 s		Attachments for MB-373 series		
Large flat button	2.5~6.5mm 0~6.5mn 20~28mm	ⁿ Thickness: under 3.1mm	<b>Z001 (MAZ-00100-00A)</b> Attachment for sewing large button	Clamp	<b>Z031 (MAZ-03100-0AA)</b> Attachment for sewing large button	Clamp	
Medium size flat button	2.5 ~ 6.5mm 0 ~ 6.5mm 12 ~ 20mm	n Thickness: under 2.8mm	<b>Z002 (D2529-372-B00)</b> Attachment for sewing medium size button	Clamp	2032 (D2529-373-B00) Attachment for sewing medium size button	Clamp	
Small flat button	2.5 ~ 5mm 0 ~ 5mm 10 ~ 12mm	This size buttons are sewn without attachments. Thickness: under 2.8mm	Standard cla	amp	Standard cl	amp	
Extremely small flat button	1.5 ~ 4mm 1.5 ~ 4mm 0 ~ 4mm 7 ~ 10mm	This size buttons can be sewn only by MB-372-16 without attachments. [Exclusive machines for this button size]					

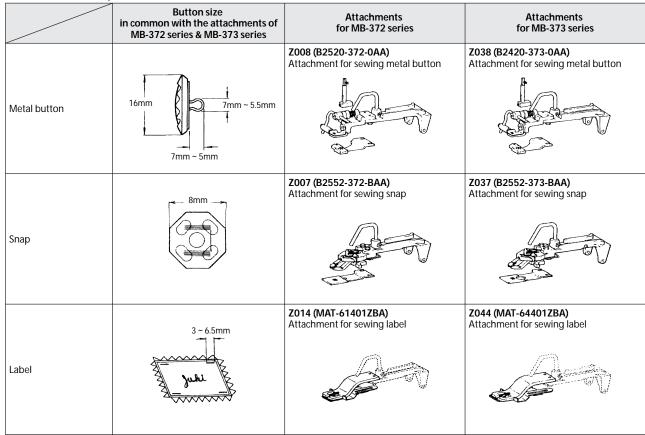
#### Wrapped-around button

	Button size in common with the attachments of MB-372 series & MB-373 series	Attachments for MB-372 series	Attachments for MB-373 series
Wrapped-around button (first process) (Note) Distance between the cloth and button is not adjustable	Max. 28mm	2004 (B2447-372-0A0) Attachment for sewing wrapped-around button (first process)	Z004 (B2447-372-0A0) Attachment for sewing wrapped-around button (first process)
Wrapped-around button (first process) (Note) Distance between the cloth and button is adjustable	pin A mm A	Z011 (MAT-61100ZA0) Attachment for sewing wrapped-around button (first process) Z099 (131-34050) Attachment for sewing wrappe	<b>Z041 (MAZ-041010A0)</b> Attachment for sewing wrapped-around button (first process)
Wrapped-around button with stay button (first process)		Z009 (MAT-60901ZAO) Clamp Use this attachment in combination with Z004, Z011 or Z041.	Z039 (MAZ-0390100A0) Use this attachment in combination with Z004 or Z041.
Wrapped-around button with or without stay button (second process)	* 25mm in case of (A) 23mm in case of (B) Cross section of button (A)	<b>Z005 (B2440-372-0A0)</b> Attachment for sewing wrapped-around button (second process)	Z035 (B2440-373-0A0) Attachment for sewing wrapped-around button (second process)
Wrapped-around button (second process)	Max. 6mm Max. 5mm	<b>Z016 (MAT-61601ZA0)</b> Attachment for sewing wrapped-around button (second process)	<b>Z046 (MAZ-046010A0)</b> Attachment for sewing wrapped-around button (second process)
Button sewing height A: 5.5mm Flat button sewing process and the first process of neck wrapping can be performed by sliding the neck wrapping foot.	Max. 28mm	Z172 (MAZ-172000 For flat button and b (first process)	A0) utton with neck wrap

#### Shank button

	Button size in common with the attachments of MB-372 series & MB-373 series	Attachments for MB-372 series	Attachments for MB-373 series
Shank button with the size indicated in the right figures	Possible sewing sizes of A : B A=6mm, B=3mm or A-5mm, B-2.5mm	2003 (B2401-372-0BA) Attachment for sewing shank button	Z033 (B2401-373-0BA) Attachment for sewing shank button
Shank button (A little different type of Z003 or Z033) Even if the shank shape is a little different from Z003 or Z033, button sewing can be performed.		Z010 (MAZ-010000AA) Attachment for sewing shank button	Z040 (MAZ-040000AA) Attachment for sewing shank button
Button with a shank A: 5mm A clearance provided between the material and button is small.	5mm	Z010B (MAZ-01000IAA) Attachment for sewing shank button	Z040B (MAZ-04000BAA) Attachment for sewing shank button

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Note: When shank button, metal button and second process of wrapped-around button are sewn with thick thread by MB-373 series, the remaining thread on the back of cloth is about 8mm, so it is necessary to cut it off by handwork.

### COMBINATION TABLE OF MB-372/373 SERIES

#### Flat button

	MB-372	MB-373	Number of stitches	Stitch shape	Remarks
	MB-372	MB-373	8,16 or 32	3	
	MB-372-4	MB-373-4	6,12 or 24	$(\mathbf{I})$	
	MB-372-5	MB-373-5	6,12 or 24	Z	
	MB-372-6	MB-373-6	6,12 or 24		
	MB-372-10	MB-373-10	8,16 or 32	I	
Small button	MB-372-11	MB-373-11	8,16 or 32	X	
Sman button	MB-372-12	MB-373-12	8,16 or 32		
$(\circ \circ)$	MB-372-14	MB-373-14	8,16 or 32		
	MB-372-17	MB-373-17	18, or 36	٨	
	MB-372/Z025/AO14	MB-373/Z025/AO14	8,16 or 32		
	MB-372-10/Z025/AO14	MB-373-10/Z025/AO14	0,100132	3	
	MB-372-4/Z025/AO14	MB-373-4/Z025/AO14	6,12 or 24		
	MB-372-5/Z025/AO14	MB-373-5/Z025/AO14	0,12 01 24	I	
	MB-372-6/Z025/AO14	MB-373-6/Z025/AO14	6,12 or 24		
	MB-372-12/Z025/AO14	MB-373-12/Z025/AO14	8,16 or 32		
	MB-372-11/Z025/AO14	MB-373-11/Z025/AO14	8,16 or 32	X	

#### Flat button

	MB-372	MB-373	Number of stitches	Stitch shape	Remarks
-	MB-372/Z002	MB-373/Z032	8,16 or 32	3	
	MB-372-4/Z002	MB-373-4/Z032	6,12 or 24	3	
	MB-372-5/Z002	MB-373-5/Z032	6,12 or 24		
	MB-372-6/Z002	MB-373-6/Z032	6,12 or 24		
	MB-372-10/Z002	MB-373-10/Z032	8,16 or 32	Z	
	MB-372-11/Z002	MB-373-11/Z032	8,16 or 32	*	
Medium size button	MB-372-12/Z002	MB-373-12/Z032	8,16 or 32		
	MB-372-14/Z002	MB-373-14/Z032	8,16 or 32	1	
$(\circ \circ)$	MB-372-17/Z002	MB-373-17/Z032	18 or 36		
	MB-372/Z002/Z025/AO14	MB-373/Z032/Z025/AO14	0.1/ -= 22		
$\bigcirc$	MB-372-10/Z002/Z025/AO14	MB-373-10/Z032/Z025/AO14	8,16 or 32		
	MB-372-4/Z002/Z025/AO14	MB-373-4/Z032/Z025/AO14	( 10 01		
	MB-372-5/Z002/Z025/AO14	MB-373-5/Z032/Z025/AO14	6,12 or 24		
	MB-372-6/Z002/Z025/AO14	MB-373-6/Z032/Z025/AO14	6,12 or 24		
	MB-372-12/Z002/Z025/AO14	MB-373-12/Z032/Z025/AO14	8,16 or 32		
	MB-372-11/Z002/Z025/AO14	MB-373-11/Z032/Z025/AO14	8,16 or 32	X	
	MB-372/Z001	MB-373/Z031	8,16 or 32	3	
	MB-372-4/Z001	MB-373-4/Z031	6,12 or 24	3	
	MB-372-5/Z001	MB-373-5/Z031	6,12 or 24	Z	
	MB-372-6/Z001	MB-373-6/Z031	6,12 or 24		
	MB-372-10/Z001	MB-373-10/Z031	8,16 or 32	Z	
Large button	MB-372-11/Z001	MB-373-11/Z031	8,16 or 32	*	
	MB-372-12/Z001	MB-373-12/Z031	8,16 or 32		
	MB-372-14/Z001	MB-373-14/Z031	8,16 or 32		
	MB-372-17/Z001	MB-373-17/Z031	18 or 36		
	MB-372/Z001/Z025/AO14	MB-373/Z031/Z025/AO14	0.1/ -= 22		
	MB-372-10/Z001/Z025/AO14	MB-373-10/Z031/Z025/AO14	8,16 or 32		
	MB-372-4/Z001/Z025/AO14	MB-373-4/Z031/Z025/AO14	( 12 -= 24		
	MB-372-5/Z001/Z025/AO14	MB-373-5/Z031/Z025/AO14	- 6,12 or 24		
	MB-372-6/Z001/Z025/AO14	MB-373-6/Z031/Z025/AO14	6,12 or 24		
	MB-372-12/Z001/Z025/AO14	MB-373-12/Z031/Z025/AO14	8,16 or 32		
	MB-372-11/Z001/Z025/AO1	MB-373-11/Z031/Z025/AO14	8,16 or 32	X	

### Extremely small flat button

Extremely small flat button $\bigcirc \bigcirc \bigcirc \bigcirc \bigcirc \bigcirc \bigcirc \bigcirc$	MB-372-16	MB-373-16	8,16 or 32	3		
	MB-372-16/Z025/AO14	MB-373-16/Z025/AO14	8,16 or 32	Î		
	MB-372-16/Z004	MB-373-16/Z004	8,16 or 32		Distance between the cloth and button	
Wrapped-around button	MB-372-16/Z172	MB-373-16/Z172	8,16 or 32		is not adjustable	
(first process)	MB-372-16/Z004/Z025/AO14	MB-373-16/Z004/Z025/AO14	8,16 or 32	(I)	Distance between the cloth and button is adjustable	
	MB-372-16/Z172/Z025/AO14	MB-373-16/Z172/Z025/AO14	8,16 or 32	-		
Wrapped-around button (second process)	MB-372-16/Z005	MB-373-16/Z035	8,16 or 32	3		

### ■ Wrapped-around button

#### • Medium size

	MB-372	MB-373	Number of stitches	Stitch shape	Remarks	
	MB-372/Z002/Z004	MB-373/Z032/Z004	8,16 or 32	3		
	MB-372-4/Z002/Z004	MB-373-4/Z032/Z004	6,12 or 24	3		
	MB-372-5/Z002/Z004	MB-373-5/Z032/Z004	6,12 or 24	Z		
	MB-372-6/Z002/Z004	MB-373-6/Z032/Z004	6,12 or 24		Distance hadrones	
	MB-372-10/Z002/Z004	MB-373-10/Z032/Z004	8,16 or 32	Z	Distance between the cloth and button is not adjustable.	
Maaliumaaina	MB-372-11/Z002/Z004	MB-373-11/Z032/Z004	8,16 or 32	X		
Medium size wrapped- around button	MB-372-12/Z002/Z004	MB-373-12/Z032/Z004	8,16 or 32			
(first process)	MB-372-14/Z002/Z004	MB-373-14/Z032/Z004	8,16 or 32			
	MB-372-17/Z002/Z004	MB-373-17/Z032/Z004	18 or 36			
	MB-372-5/Z002/Z011, Z041	MB-373-5/Z032/Z011,Z041	6,12 or 24	Z		
¥	MB-372-10/Z002/Z011, Z041	MB-373-10/Z032/Z011, Z041	8,16 or 32	Z		
	MB-372/Z002/Z011,Z041/Z025/AO14	MB-373/Z032/Z011, Z041/Z025/AO14			Distance between the cloth and button is adjustable.	
	MB-372-10/Z002/Z011, Z041/Z025/AO14	MB-373-10/Z032/Z011,Z041/Z025/AO14	8,16 or 32			
	MB-372-4/Z002/Z011,Z041/Z025/AO14	MB-373-4/Z032/Z011,Z041/Z025/AO14	Z011, Z041/Z025/AO14 6,12 or 24		·····	
	MB-372-5/Z002/Z011,Z041/Z025/AO14	MB-373-5/Z032/Z011,Z041/Z025/AO14	0,12 01 24			
	MB-372-11/Z002/Z011, Z041/Z025/AO14	MB-373-11/Z032/Z011,Z041/Z025/AO14	8,16 or 32	X		
	MB-372/Z004/Z009	MB-373/Z004/Z039	8,16 or 32	3		
	MB-372-4/Z004/Z009	MB-373-4/Z004/Z039	6,12 or 24	3	-	
	MB-372-5/Z004/Z009	MB-373-5/Z004/Z039	6,12 or 24			
	MB-372-6/Z004/Z009	MB-373-6/Z004/Z039	6,12 or 24			
	MB-372-10/Z004/Z009	MB-373-10/Z004/Z039	8,16 or 32		Distance between the cloth and button is not adjustable.	
Medium size	MB-372-11/Z004/Z009	MB-373-11/Z004/Z039	8,16 or 32	*	io not adjustable.	
wrapped- around button	MB-372-12/Z004/Z009	MB-373-12/Z004/Z039	8,16 or 32			
with stay button (first process)	MB-372-14/Z004/Z009	MB-373-14/Z004/Z039	8,16 or 32			
	MB-372-17/Z004/Z009	MB-373-17/Z004/Z039	18 or 36			
	MB-372-5/Z009/Z011, Z041	MB-373-5/Z039/Z011,Z041	6,12 or 24			
	MB-372-10/Z009/Z011, Z041	MB-373-10/Z039/Z011, Z041	8,16 or 32			
	MB-372/Z009/Z011, Z041/Z025/AO14	MB-373/Z039/Z011, Z041/Z025/AO14	0.16 -= 22			
	MB-372-10/Z009/Z011, Z041/Z025/AO14	,Z041/Z025/AO14 MB-373-10/Z039/Z011,Z041/Z025/AO14 8,16 or 32		I	Distance between the cloth and button	
	MB-372-4/Z009/Z011, Z041/Z025/AO14	MB-373-4/Z039/Z011,Z041/Z025/AO14	6 12 24		– is adjustable.	
	MB-372-5/Z009/Z011, Z041/Z025/AO14	MB-373-5/Z039/Z011,Z041/Z025/AO14	6,12 or 24			
	MB-372-11/Z009/Z011, Z041/Z025/AO14	MB-373-11/Z039/Z011, Z041/Z025/AO14	8,16 or 32	*		
		•				

#### • Large size

	MB-372	MB-373	Number of stitches	Stitch shape	Remarks	
	MB-372/Z001/Z004	MB-373/Z031/Z004	8,16 or 32	n		
	MB-372-4/Z001/Z004	MB-373-4/Z031/Z004	6,12 or 24	n		
	MB-372-5/Z001/Z004	MB-373-5/Z031/Z004	6,12 or 24		Distance between the cloth and button is not adjustable.	
	MB-372-6/Z001/Z004	MB-373-6/Z031/Z004	6,12 or 24			
	MB-372-10/Z001/Z004	MB-373-10/Z031/Z004	8,16 or 32	X		
Large size	MB-372-11/Z001/Z004	MB-373-11/Z031/Z004	8,16 or 32	X	is not adjustadie.	
wrapped- around button	MB-372-12/Z001/Z004	MB-373-12/Z031/Z004	8,16 or 32			
(first process)	MB-372-14/Z001/Z004	MB-373-14/Z031/Z004				
	MB-37217/Z001/Z004	MB-373-17/Z031/Z004				
	MB-372-5/Z001/Z011,Z041	MB-373-5/Z031/Z011,Z041	6,12 or 24	I		
- v	MB-372-10/Z001/Z011, Z041	MB-373-10/Z031/Z011, Z041	8,16 or 32	X		
	MB-372/Z001/Z011, Z041/Z025/AO14	MB-373/Z031/Z011,Z041/Z025/AO14	0.1/ -= 22	()	Distance between	
	MB-372-10/Z001/Z011, Z041/Z025/AO14	8,16 or 32 8,16 or 32 8,16 or 32			Distance between the cloth and button is adjustable.	
	MB-372-4/Z001/Z011,Z041/Z025/AO14	MB-373-4/Z031/Z011,Z041/Z025/AO14	( 10 -= 04	I		
	MB-372-5/Z001/Z011,Z041/Z025/AO14	MB-373-5/Z031/Z011,Z041/Z025/AO14	6,12 or 24			
	MB-372-11/Z001/Z011, Z041/Z025/AO14	MB-373-11/Z031/Z011,Z041/Z025/AO14	8,16 or 32	X		
	MB-372/Z001/Z004/Z009	MB-373/Z031/Z004/Z039	8,16 or 32	n	_	
	MB-372-4/Z001/Z004/Z009	MB-373-4/Z031/Z004/Z039	6,12 or 24	n		
	MB-372-5/Z001/Z004/Z009	MB-373-5/Z031/Z004/Z039	6,12 or 24	X		
	MB-372-6/Z001/Z004/Z009	MB-373-6/Z031/Z004/Z039	6,12 or 24		)	
Large size wrapped-	MB-372-10/Z001/Z004/Z009	MB-373-10/Z031/Z004/Z039	8,16 or 32		Distance between the cloth and button	
around button with stay	MB-372-11/Z001/Z004/Z009	MB-373-11/Z031/Z004/Z039	8,16 or 32	X	is not adjustable.	
button (first process)	MB-372-12/Z001/Z004/Z009	MB-373-12/Z031/Z004/Z039	8,16 or 32			
(	MB-372-14/Z004/Z009	MB-373-14/Z004/Z039	8,16 or 32			
	MB-372-17/Z004/Z009	MB-373-17/Z004/Z039	18 or 36			
	MB-372-5/Z001/Z009/Z011,Z041	MB-373-5/Z031/Z039/Z011,Z041	6,12 or 24	R		
	MB-372-10/Z001/Z009/Z011, Z041	MB-373-10/Z031/Z039/Z011,Z041	8,16 or 32	X		
	MB-372/Z001/Z009/Z011,Z041/Z025/AO14	MB-373/Z031/Z039/Z011, Z041/Z025/AO14	0.1/ 07.22	(j		
	MB-372-10/Z001/Z009/Z011, Z041/Z025/AO14	MB-373-10/Z031/Z039/Z011,Z041/Z025/AO14	8,16 or 32	I	Distance between the cloth and button	
	MB-372-4/Z001/Z009/Z011,Z041/Z025/AO14	MB-373-4/Z031/Z039/Z011, Z041/Z025/AO14	6 10 0 - 04		is adjustable.	
	MB-372-5/Z001/Z009/Z011,Z041/Z025/AO14	MB-373-5/Z031/Z039/Z011,Z041/Z025/AO14	6,12 or 24			
	MB-372-11/Z001/Z009/Z011, Z041/Z025/AO14	MB-373-11/Z031/Z039/Z011,Z041/Z025/AO14	8,16 or 32	X		

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# Flat button and wrapped-around button (first process) Medium size

	MB-372	MB-373	Number of stitches	Stitch shape	Remarks
	MB-372/Z002/Z172	MB-373/Z032/Z172	8,16 or 32	3	
	MB-372-4/Z002/Z172	MB-373-4/Z032/Z172	6,12 or 24	3	
Medium	MB-372-5/Z002/Z172	MB-373-5/Z032/Z172	6,12 or 24		
size wrapped- around button	MB-372-6/Z002/Z172	MB-373-6/Z032/Z172	6,12 or 24		
(first process)	MB-372-10/Z002/Z172	MB-373-10/Z032/Z172	8,16 or 32		Distance between the cloth and button is not adjustable.
	MB-372-11/Z002/Z172	MB-373-11/Z032/Z172	8,16 or 32	X	is not adjustable.
	MB-372-12/Z002/Z172	MB-373-12/Z032/Z172	8,16 or 32		
	MB-372-14/Z002/Z172	MB-373-14/Z032/Z172	8,16 or 32		
	MB-372-17/Z002/Z172	MB-373-17/Z032/Z172			
	MB-372/Z009/Z172	MB-373/Z039/Z172	8,16 or 32	3	
	MB-372-4/Z009/Z172	MB-373-4/Z039/Z172	6,12 or 24	3	
Medium size wrapped-	MB-372-5/Z009/Z172	MB-373-5/Z039/Z172	6,12 or 24		
around button with stay button	MB-372-6/Z009/Z172	MB-373-6/Z039/Z172	6,12 or 24	(1)	
(first process)	MB-372-10/Z009/Z172	MB-373-10/Z039/Z172	8,16 or 32		Distance between the cloth and button
	MB-372-11/Z009/Z172	MB-373-11/Z039/Z172	8,16 or 32	X	is not adjustable.
ECCEPTION OF THE PROPERTY OF T	MB-372-12/Z009/Z172	MB-373-12/Z039/Z172	8,16 or 32		
	MB-372-14/Z009/Z172	MB-373-14/Z039/Z172	8,16 or 32		
	MB-372-17/Z009/Z172	MB-373-17/Z039/Z172	18 or 36		

#### • Large size

0						
	MB-372/Z001/Z172	MB-373/Z031/Z172	8,16 or 32	I		
	MB-372-4/Z001/Z172	MB-373-4/Z031/Z172	6,12 or 24	$(\mathbf{I})$		
Large size	MB-372-5/Z001/Z172	MB-373-5/Z031/Z172	6,12 or 24	Z		
wrapped- around button (first process)	MB-372-6/Z001/Z172	MB-373-6/Z031/Z172	6,12 or 24			
	MB-372-10/Z001/Z172	MB-373-10/Z031/Z172	8,16 or 32		Distance between the cloth and button is not adjustable.	
	MB-372-11/Z001/Z172	MB-373-11/Z031/Z172	8,16 or 32	X	is not adjustable.	
Hand Gumme	MB-372-12/Z001/Z172	MB-373-12/Z031/Z172	8,16 or 32			
	MB-372-14/Z001/Z172	MB-373-14/Z031/Z172	8,16 or 32			
	MB-372-17/Z001/Z172	MB-373-17/Z031/Z172	18 or 36			
	MB-372/Z001/Z172/Z009	MB-373/Z031/Z172/Z039	8,16 or 32	$(\mathbf{n})$		
5	MB-372-4/Z001/Z172/Z009	MB-373-4/Z031/Z172/Z039	6,12 or 24	$(\mathbf{n})$		
Large size wrapped-	MB-372-5/Z001/Z172/Z009	MB-373-5/Z031/Z172/Z039	6,12 or 24	Z		
around button with stay button	MB-372-6/Z001/Z172/Z009	MB-373-6/Z031/Z172/Z039	6,12 or 24			
(first process)	MB-372-10/Z001/Z172/Z009	MB-373-10/Z031/Z172/Z039	8,16 or 32		Distance between the cloth and button is not adjustable.	
	MB-372-11/Z001/Z172/Z009	MB-373-11/Z031/Z172/Z039	8,16 or 32	X	is not adjustable.	
Rudelkum	MB-372-12/Z001/Z172/Z009	MB-373-12/Z031/Z172/Z039	8,16 or 32			
	MB-372-14/Z001/Z172/Z009	MB-373-14/Z031/Z172/Z039	8,16 or 32			
	MB-372-17/Z001/Z172/Z009	MB-373-17/Z031/Z172/Z039	18 or 36			

#### ■ Wrapped-Around button (second process)

	MB-372	MB-373	Number of stitches	Stitch shape	Remarks
	MB-372/Z005	MB-373/Z035	8,16 or 32		
Medium and large size	MB-372-4/Z005	MB-373-4/Z035	6,12 or 24		
wrapped- around button	MB-372-5/Z005	MB-373-5/Z035	6,12 or 24		
(second process)	MB-372-10/Z005	MB-373-10/Z035	8,16 or 32		
	MB-372-11/Z005	MB-373-11/Z035	8,16 or 32		
KIIII EKIIII	MB-372-15/Z005	MB-373-15/Z005	16 or 32		
	MB-372-15/Z016	MB-373-15/Z046	16 or 32		

#### Snap

■ Shap					
	MB-372/Z007	MB-373/Z037	8,16 or 32	$\square$	
	MB-372-4/Z007	MB-373-4/Z037	6,12 or 24	3	
	MB-372-6/Z007	MB-373-6/Z037	6,12 or 24		
	MB-372-12/Z007	MB-373-12/Z037	8,16 or 32		
Snap	MB-372-16/Z007	MB-373-16/Z037	8,16 or 32		
00	MB-372/Z007/Z025/AO14	MB-373/Z037/Z025/AO14	8,16 or 32		
00	MB-372-4/Z007/Z025/AO14	MB-373-4/Z037/Z025/AO14	6,12 or 24	Î	
	MB-372-5/Z007/Z025/AO14	MB-373-5/Z037/Z025/AO14	6,12 or 24		
	MB-372-6/Z007/Z025/AO14	MB-373-6/Z037/Z025/AO14	6,12 or 24		
	MB-372-10/Z007/Z025/AO14	MB-373-10/Z037/Z025/AO14	8,16 or 32	(B)	
	MB-372-12/Z007/Z025/AO14	MB-373-12/Z037/Z025/AO14	8,16 or 32		
	MB-372-6/Z007/Z025/AO14 MB-372-10/Z007/Z025/AO14	MB-373-6/Z037/Z025/AO14 MB-373-10/Z037/Z025/AO14	6,12 or 24 8,16 or 32		

#### Label

	MB-372/Z014	MB-373/Z044	8,16 or 32	
	MB-372-4/Z014	MB-373-4/Z044	6,12 or 24	
Label	MB-372-5/Z014	MB-373-5/Z044	6,12 or 24	
Juki	MB-372-10/Z014	MB-373-10/Z044	8,16 or 32	
A.	MB-372-11/Z014	MB-373-11/Z044	8,16 or 32	
	MB-372-14/Z014	MB-373-14/Z044	8,16 or 32	
	MB-372-16/Z014	MB-373-16/Z044	8,16 or 32	

#### Shank button

	MB-372	MB-373	Number of stitches	Stitch shape	Remarks
	MB-372/Z003	MB-373/Z033	8,16 or 32		
	MB-372-4/Z003	MB-373-4/Z033	6,12 or 24		
	MB-372-5/Z003	MB-373-5/Z033	6,12 or 24		Standardized
	MB-372-10/Z003	MB-373-10/Z033	8,16 or 32		button size
	MB-372-11/Z003	MB-373-11/Z033	8,16 or 32		
	MB-372-16/Z003	MB-373-16/Z033	8,16 or 32		
Shank	MB-372/Z010	MB-373/Z040	8,16 or 32		
button	MB-372-4/Z010	MB-373-4/Z040	6,12 or 24		
$\langle \rangle$	MB-372-5/Z010	MB-373-5/Z040	6,12 or 24		A little different button size
	MB-372-10/Z010	MB-373-10/Z040	8,16 or 32		from the standardized size
	MB-372-11/Z010	MB-373-11/Z040	8,16 or 32		
	MB-372-16/Z010	MB-373-16/Z040	8,16 or 32		
	MB-372/Z010B	MB-373/Z040B	8,16 or 32		
	MB-372-4/Z010B	MB-373-4/Z040B	6,12 or 24		
	MB-372-5/Z010B	MB-373-5/Z040B	6,12 or 24		
	MB-372-10/Z010B	MB-373-10/Z040B	8,16 or 32		
	MB-372-11/Z010B	MB-373-11/Z040B	8,16 or 32		
	MB-372-16/Z010B	MB-373-16/Z040B	8,16 or 32		

	MB-372/Z008	MB-373/Z038	8,16 or 32	
	MB-372-4/Z008	MB-373-4/Z038	6,12 or 24	
Metal button	MB-372-5/Z008	MB-373-5/Z038	6,12 or 24	
	MB-372-10/Z008	MB-373-10/Z038	8,16 or 32	
0	MB-372-11/Z008	MB-373-11/Z038	8,16 or 32	
	MB-372-16/Z008	MB-373-16/Z038	8,16 or 32	

### Single-thread, Chainstitch, Button Sewing Machine with Knot-tying Mechanism

## **MB-377**

- The machine ties a secure knot to prevent the finished seam from coming undone from the last stitch. Since the knots are firmer than conventional ones, the hardly ever come undone. Even if the last stitch comes undone, the thread is not likely to come off, so the risk of losing buttons is dramatically reduced.
- Button-sewing specifications can be quickly swithced when changing between 4-holed buttons and 2-holed buttons or when changing the number of stitches (8 and 16 stitches *). This minimizes downtime during the specification changes.
  - * To sew buttons while setting the number of stitches to 32, the following optional parts (separately available) will be required.

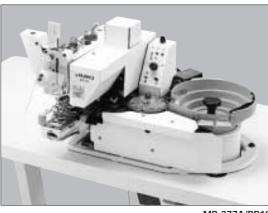


MB-377

## MB-377A/BR10 (with a button feeder)

• The three different operation modes are available: the automatic button feeding mode in which the machine continuously feeds the buttons in the feeder bowl, the non-feed mode in which the operator manually places the buttons in the sewing position one by one, and the small-lot sewing mode in whitch the operator sets the buttons in place for one garment (five or six buttons) in advance, upon which the buttons are automatically and continuously fed to the sewing position.

As a result the machine can be used as a small-lot production system by selecting the appropriate operation mode.

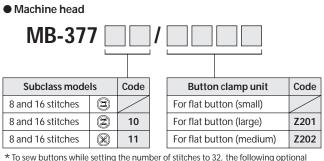


MB-377A/BR10

## SPECIFICATIONS

Model name	MB-377	MB-377A/BR10	
Sewing speed	Max. 1,500rpm, Normal 1,300rpm	Max. 1,500rpm, Normal 1,300rpm	
Amount of feed	Crosswise feed 2.5 ~ 6.5mm Lengthwise feed 0 ~ 6.5mm	Crosswise feed 2.2 ~ 3.8mm Lengthwise feed 0 ~ 3.8mm	
Applicable button	Type: Round-shaped flat button (2-holed, 4-holed) Size: 10 ~ 28mm Thickness: 1.8 ~ 3.5mm	<ul> <li>Type: Round-shaped flat button (2-holed, 4-holed)</li> <li>Size: 9 ~ 26mm</li> <li>A machine for button of which diameter is smaller than 10 or 19mm or more will be made to order.</li> <li>For button of which diameter is 16mm or more, a button clamp jaw lever for large buttons has to be used.</li> <li>A machine for such buttons that the distance between holes in the button exceeds 3.8mm will be made to order.</li> <li>Thickness: 1.8 ~ 3.5mm</li> </ul>	
Lift of the button clamp	9mm		
Needle (at the time of delivery)	TQ × 1 (#16	b) #14 ~ #16	
Lubrication	By ar	n oiler	
Lubricating oil	JUKI New Defrix Oil No.1	(equivalent to ISO VG7)	
Discrimination of button to be fed		Vibration system	
Button feed		By the horizontal, forced feed mechanism	
Button feed modes		Automatic feed mode, non-feed mode, and small-lot sewing mode	
Stitches without cross-over		Selected by means of a switch	
Weight	Weight of the machine head: 20kg	Total weight: 80kg	
Power consumption	Rating 200W	Rating 270W	

## 



* To sew buttons while setting the number of stitches to 32, the following optional parts (separately available) will be required. (Optional parts are shared by MB-377 and -377A.)

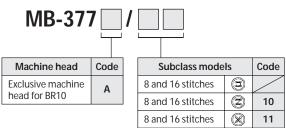
• Stitch number adjusting lever (Part No.: B2642-372-000)

• Screw for stitch number adjusting lever (Part No.: SD-0600361-SP)

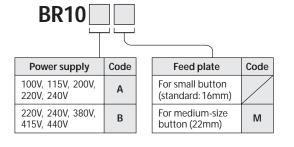
# 

## WHEN YOU PLACE ORDERS

### Machine head

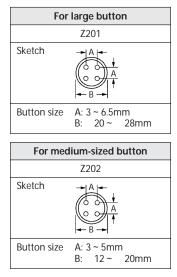


### Button feeder





## ATTACHMENTS FOR FLAT BUTTON



### **BUTTON CARRIER**

Configuration of button carrier							
For 4-holed button				For 2-holed button			
Distance A(mm): Distance between holes in button	B(mm): Diameter	Part No.	Code	Distance A(mm): Distance between holes in button	Distance B(mm): Diameter of set pin	Part No.	Code
Standard							
2.6	1.0	165-57902	Α	3.2	1.2	165-58009	В
			Opti	onal			
2.0	1.0	165-90507	Q	2.0	1.0	165-87305	E
2.2	1.0	165-90606	R	2.2	1.0	165-87404	F
2.4	1.0	165-88501	S	2.4	1.0	165-87503	G
2.4	1.2	165-88600	Т	2.4	1.2	165-87909	L
2.6	1.2	165-88709	U	2.6	1.0	165-87602	н
2.8	1.2	165-88808	v	2.6	1.2	165-88006	М
3.0	1.2	165-88907	W	2.8	1.0	165-87701	J
3.0	1.5	165-89806	F1	2.8	1.2	165-88105	N
3.1	1.0	165-87206	D	3.0	1.0	165-87800	к
3.1	1.2	165-89004	Х	3.0	1.2	165-88204	Р
3.1	1.4	165-89202	Z	3.8	1.2	165-87104	С
3.2	Tapere	165-89905	G1				
3.6	1.2	165-90705	H1				
4.0	1.2	165-89707	E1				

### OPTIONS

Description	Part No. (asm.)
Button clamp jaw lever (left) for large-sized button	MAZ-08822-0BAA
Button clamp jaw lever (right) for large-sized button	MAZ-08823-0BAA

Computer-controlled, High-speed, Lockstitch Button Sewing Machine

## LK-1903

- The machine provides the maximum number of revolutions of 2,500rpm. This allows the machine to demonstrate the highest sewing performance as compared with the conventional lockstitch button sewing machines. The machine has been developed also to reduce the time required to lift/lower the button clamp jaw lever, jump and trim the thread.
- The LK-1903 is pre-programmed as standard with 33 different sewing patterns. The machine permits easy changeover of sewing patterns for effortless execution of an inexhaustible range of sewing specifications. Moreover, the machine's upgraded flexibility allows the user to combine any of the sewing patterns stored in memory for cycle sewing.
- By electronically controlling the direction of the stitches during bartack sewing to prevent the seams from being undone, the overall quality of the finished seams is secured.

## LK-1903/BR25 (with a button feeder)

• The machine runs under three different operation modes: the automatic supply mode, in which buttons placed in the feeder bowl are continuously fed; the individual mode, in which the operator manually inserts buttons one by one; and the small-lot mode, in which buttons (five or six buttons) preliminarily prepared on the machine for one section of a garment are automatically and continuously fed. The machine is able to respond to diversified production systems regardless of the lot size by designating the appropriate operation mode from among the three different alternatives.

shell buttons to be attached to consistently garments without error.

- With its unique horizontally forced button-feed mechanism to eliminate button jamming due to static electricity, the machine is able to feed



LK-1903

7



LK-1903/BR25

## SPECIFICATIONS

Model name	LK-1903	LK-1903/BR25	
Sewing speed	Max. 2,500rpm (normal 2,200rpm)	Max. 2,300rpm (normal 2,200rpm)	
Button size	<b>Type:</b> Round-shaped, flat button <b>Size:</b> 8 ~ 32mm (standard 10 ~ 20mm)	<ul> <li>Type: Round-shaped, flat button (2-holed, 4-holed)</li> <li>Size: 9 ~ 20mm For small button: 10 ~ 15mm For medium-sized button: 12 ~ 18mm (The machine for sewing buttons of which diameter is less than 10mm or more than 18mm is available on an extra order.)</li> <li>Thickness: 1.8 ~ 3.5mm</li> </ul>	
Needle bar stroke	45.7mm		
Needle (at the time of delivery)	DP × 17 (#14)		
Hook		huttle hook	
Lift of the work clamp foot	Max. 13mm	Max. 11mm	
Input pattern	33 patterns are provided as standard		
Number of patterns that can be stored in memory	Max. 64 pattern		
Number of stitches that can be stored in memory	Max. 10,00	00 stitches	
Enlarging/Reducing facility		% (1% step), e by increasing/decreasing the stitch length	
Memory medium	EP-F	ROM	
Bobbin thread counter		is standard anged over to the No. of pcs. counter.)	
Supplying and sorting of button		By vibrator	
Feeding of buttons		Automatic supply mode, individual mode and small-lot mode	
Button supply mode		Horizontal forced button-feed mechanism	
Lubrication	Centralized oil	wick lubrication	
Lubricating oil	JUKI New Defrix Oil No.2	(equivalent to ISO VG32)	
Sewing machine motor	400W compact AC servon	notor (direct-drive system)	
Weight	Machine head (include motor) 41kg, Control box 16.5kg	Total weight 133kg (Include optional stand leg)	

LK-1903, 1903/BR25 (June, 2001) 1/4

## LK-1903_

## WHEN YOU PLACE ORDERS

#### Machine head

LK-190	)3S[	<b>-</b> [	
Application	Code		Button clamp jaw lever
Standard	S		For small button
			For medium-size button
Work clamp	o foot	Code	For large button
Electromagn	etic	S	For extra-small button
Pneumatic		А	For shank button

#### Control box

MC-590-				
Control box	Code	P	ower supply	Code
For sewing button	3		100 ~ 120V	С
For sewing shank	5	Single- phase	200 ~ 240V	К
button	-	100000	220 ~ 415V	R
			200 ~ 240V	D
		2	220 ~ 415V	L
		3-phase	220 ~ 415V for JE (not provided with a power switch)	М

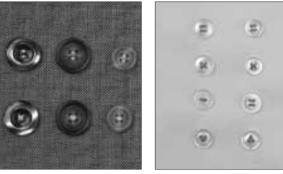
### • Table stand: optional

## **JT-K35**

* The table stand is not equipped with casters.

## OPTIONS

Model	Part No.	Applicable model	Feature
Q123	MAQ-123000A0	LK-1903	Button spacer. Commonly used for men's wear and ladies' wear.
Z099	141-34050	LK-1903	Attachment for sewing wrapped-around button (first process). Button-to-material distance is adjusable.



Responds to various button sizes and sewing patterns.

### SEWING PROGRAM TABLE

Code

301 302

303 304 305

→ X ←	Program	Stitch	Sewing	Standard	Standard		
	No.	shape	thread (pcs.)	length X (mm)	length Y (mm)		
	1•34	<b>E</b>	6-6				
	2•35	E	8-8				
	3	IJ	10-10				
	4	I	12-12				
	5•36	<b>E</b>	6-6				
	6•37	<b>\$</b>	8-8				
	7	×.	10-10				
	8	() () () () () () () () () () () () () (	12-12				
	9•38	×	6-6		3.4		
	10•39	×	8-8	3.4			
	11	S	10-10				
	12•40	×	6-6				
	13•41	×	8-8	-			
	14	×	10-10				
	15•42	×	6-6				
	16•43	X	8-8				
	17	×	10-10				
	18•44		6				
	19•45		8				
	20		10		0		
	21		12				
	22		16				
	23•46		6				
	24		10	0	3.4		
	25	Ĩ	12				
	26•47	(II)	6-6				
	27	$(\mathbf{i})$	10-10	3.4	3.4		
	28•48		6-6	J.4	J. <del>4</del>		
	29		10-10				
	30•49	$\bigtriangledown$	5-5-5				
	31	<b>V</b>	8-8-8				
	32•50		5-5-5	2.9	2.5		
	33		8-8-8				

* (1) Standard sewing lengths X and Y given above are given assuming that the scale is 100.
(2) Use the patterns No. 34 ~ 50 with hole diameter 1.5mm or less.

## FOR SEWING SHANK BUTTONS

Model name		LK-1903S-305									
Sewing speed			1,500rpm								
Needle (at the time of delivery)			TQ × 3 (#14)								
	Outside diameter	Diameter of hole in button	Position of hole in button	Configuration of shank							
Button configuration	8~ 20	1.5 or more		B (mm)         A (mm)           Min.         Max.           1         4         9           3         3         8           5         -         7							
Sewing pattern number			18, 19, 20, 21, 22								

* No model is provided with a button feeder.

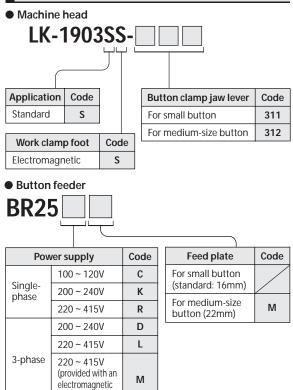
## MODELS CLASSIFIED BY BUTTON SIZES

			11/ 4000 004		LK-1903-302		11/ 4000 000			11/ 4000 004			
Model nan							LK-1903-303		LK-1903-304				
Button type			For small button		For medium-size bu	tton	For large button		For	For extra-small button			
Outside diamet can be adjusted			10~ 20		10~ 20		15~ 32		8~ 9	8~9 9~10 10~			
Sewing Length		gth	0~3.5		0~4.5		0~6.5		0~2.5	0 ~ 3.0	0~3	.5	
size (mm)	wid	th	0 ~ 3.5		0~4.5		0 ~ 6.5		0~2.5	0 ~ 3.0	0~3	.5	
	But nec heiç (mn	k ght	1.7 (2.2) (2.7) (0.9)		2.0 (2.2) (2.7)		2.7 (3.2)			1.7 (2.2)			
			141-48852	К	141-49058	L	MAZ-157070BB	D	MA	Z-158070BB		G	
Button clamp jaw lever	Part No.	Right	(MAZ-155070B0)	(MAZ-155070B0) B		В	(MAZ-157070BA)	Ε	(MA	Z-158070BA)		F	
Jaw lever		Rig	(MAZ-156070B0)	1AZ-156070B0) C (MAZ-156070B0) C									
			* (B2555-3720A0)										
			141-48951	141-49157	L	MAZ-157080BB	D	MA	MAZ-158080BB				
	-	Left	(MAZ-155080B0)	В	(MAZ-155080B0)	В	(MAZ-157080BA)	E	(MA	Z-158080BA)		F	
		Le	(MAZ-156080B0)	С	(MAZ-156080B0)	С							
			* (B2557-372-0A0)										
Needle hole guide (mm)	ļ	Ą	1.6 (1.8) * (1.1)		1.6		1.4		1.6 (1.8)				
	E	3	3.5		3.5		3.5			2.8			
B C	(	)	1.6		2.0		2.0			1.6			
<del>{</del> -∳-} <u></u> ‡}≓			MAZ-15501000							MAZ-15801000			
	Part	No.	(141-49603)		MAZ-15601000		MAZ-15701000	Ī		(141-49900)			
			* (D2426-284-Y00)	)				ĺ		-			
Feed plate			MAZ-15502000 (	3.5)	MAZ-15602000 (	10)	MAZ-15702000 ( 1	2.5)	MA	Z-15502000 (	8.5)		

Notes: 1. Parts of which part number is shown in parentheses are optional. 2. "B", "C", "D", "E", "F", "G", "K" and "L" are the markers engraved on the attachments. 3. Please install all of the parts marked " * " on 0.9mm set up.

## LK-1903/BR25_

## WHEN YOU PLACE ORDERS



INIODELS		733			JIZLJ		
Model nar	ne		LK-1903-311/BR2	5	LK-1903-312/BR2	5	
Button type	Button type		For small buttor	1	For medium-size button		
Outside diamet			10~ 15	12~ 18			
Sewing	Len	gth	0 ~ 3.5		0 ~ 4.5		
size (mm)	wid	lth	0 ~ 3.5		0 ~ 4.5		
	But nec hei		1.7mm (2.2mm)		2.7mm		
			141-90458	Р	MAZ-166070B0	J	
	Part No.	Right	(MAZ-165070B0)	Н		-	
Button clamp jaw lever		Riç			-		
Jawievei					-	-	
		Left	141-90557	Р	MAZ-166080B0	J	
			(MAZ-165080B0)	Н	-	-	
		Ľ					
					-	-	
Needle hole guide (mm)		A	1.6 (1.8)		1.6		
	I	В	3.5		3.5		
B C	(	С	1.6		2.0		
			MAZ-15501000				
	Part	No.	(141-49603)		MAZ-15601000		
-11-77			-				
Feed plate			MAZ-15502000 (	8.5)	MAZ-15602000 (	10)	

MODELS CLASSEIED BY BUTTON SIZES

Notes: 1. Parts of which part number is shown in parentheses are optional. 2. "H", "J" and "P" are the markers engraved on the attachments.

Configuration of button carrier

**BUTTON CARRIER** 

## SHAPE OF BUTTON

switch)

	Applicable button	Inapplicable carrier
Shape of button	← t 1.2mm or more	Button without indented part (concavo-convex shape button)
Remarks	Thickness of button should be 1.8mm to 3.5mm.	Button with thin edge may not be fed by the button feeder.

## OPTIONS

#### Button spacer

(commonly used for men's wear and ladies wear)

Model	Applicable model	Part No.
Q124	LK-1903/BR25	MAQ-124000A0



For 2-holed button For 4-holed button Distance Distance A(mm): Distance A(mm): Distance Distance B(mm): Distance B(mm): Code Part No. Code Part No. between Diameter between Diameter holes in holes in of set pin of set pin button button Standard 2.6 1.0 165-57902 Α 3.2 1.2 165-58009 В Optional 2.0 1.0 165-90507 Q 2.0 1.0 165-87305 Ε 2.2 1.0 165-90606 R 2.2 1.0 165-87404 F 2.4 1.0 165-88501 S 2.4 1.0 165-87503 G 2.4 1.2 165-88600 Т 2.4 1.2 165-87909 L 2.6 1.2 165-88709 U 2.6 1.0 165-87602 Н 2.8 1.2 165-88808 ۷ 2.6 1.2 165-88006 Μ 3.0 1.2 165-88907 w 2.8 1.0 165-87701 J 3.0 165-89806 1.5 F1 2.8 1.2 165-88105 Ν 3.1 1.0 165-87206 D 3.0 1.0 165-87800 Κ 3.1 1.2 165-89004 Х 3.0 1.2 165-88204 Ρ 3.1 1.4 165-89202 Ζ 3.8 1.2 165-87107 С 3.2 Tapered 165-89905 G1 3.6 165-90705 H1 1.2 4.0 1.2 165-89707 E1

#### LK-1903, 1903/BR25 (June, 2001) **4/4** Downloaded from <u>www.Manualslib.com</u> manuals search engine

Computer-controlled, High-speed Bartacking Machine

## LK-1900

- The machine's maximum sewing speed of 2,700rpm, far exceeds the speeds of conventional bartacking machines, setting a new world record. Marked reductions have been achieved in the time required to lift/lower the presser foot, perform jumping, trim the thread, and operate the wiper, thereby reducing the total cycle time and ensuring higher productivity.
- The machine is provided as standard with 30 different patterns such as large bartacking, small bartacking, and linear bartacking in accordance with the needle entry pattern and number of stitches. The pattern that best suits the current sewing process can be selected in just a few easy steps.
- Sewing speed, the value set for the bobbin thread counter, and all other settings for the machine functions can be adjusted with ease via the operation panel.

As many as seven frequently used sewing patterns can be assigned to the function keys for single-key calling. Cycle sewing patterns combining several different sewing patterns can also be assigned to the function keys.

• The machine head's slim shape provides a larger space under the arm for easier handling of the material and continuous sewing works. The machine head is directly driven by a compact AC servomotor, upgrading responsiveness and achieving a higher stop accuracy. In addition, the machine is provided with a needle bar reverse function for stepping with the needle raised to the highest dead point. This permits easy setting of heavy-weight materials.

## LK-1904F (for lengthwise bartacking for foundation with bartacking length of 30mm)

- With its lengthwise sewing size of 30mm, the machine sews lengthwise bartacks in processes to butt the elastic waist tape for shorts, attach the shoulder straps to brassieres, etc. The machine is provided with a narrow-type work clamp foot that's ideally suited to the sewing of foundation.
- The machine can handle six different pattern types (29-, 39-, 45-, 58- and 75stitch bartacking and zigzag bartacking). The operator can select the bartacking pattern best suited to the process used. In addition, the sewing size can be changed with ease.

## LK-1901 (for eyelet buttonhole)

- The machine is provided with a material-drawing mechanism which draws the right and left parallel portions of an eyelet buttonhole near to one another. The machine performs bartacking with the right and left parallel portions of the eyelet buttonhole drawn near to one another after the buttonhole is clamped under the work clamp foot, thereby finishing highly durable and well-tensed eyelet buttonhole.
- The machine is provided with three different sewing patterns (21-, 28- and 36stitch bartacking) and enables easy switchover of sewing sizes. If the sewing patterns are assigned to the function keys on the operation panel, the sewing patterns can be called up or changed with single-key operation. The machine sews the most optimally suited bartacks on eyelet buttonholes on the front bodies of garments and, straight buttonholes that differ in stitch number and size on jacket lapels, thereby improving the finished quality of sewing products.
- The material drawing amount can be adjusted to 3mm at maximum. The material drawing mechanism can be switched ON/OFF in accordance with the setting of the memory switch. With these features, the material drawing mechanism can be used with greater flexibility.

#### Computer-controlled, High-speed Belt-loop-attaching Machine

## LK-1902

- The machine is provided as standard with six different linear bartacking patterns. Since the sewing size can be easily changed, the optimal number of stitches and sewing size can be speedily selected according to the belt-loop width. If the normally used patterns are assigned to the function keys, a desired pattern can be called up or changed with single-key operation.
- With its broadly curved feed bracket (presser arm), the machine permits easy placement of the material to be sewn. The slimly shaped bed and head design that allows free space under the arm demonstrates greater operability in handling materials on the machine and continuous processes. These features contribute substantially to increased productivity in belt-loop attachment processes.



LK-1900S



LK-1904F

8



LK-1901S



LK-1902S

## SPECIFICATIONS

Model name	LK-1900S	LK-1900H	LK-1900F	LK-1900M	LK-1904F				
Application	Standard	For heavy-weight materials	For foundation	For knit	For foundation				
Sewing speed	Max. 2,	700rpm		Nomal 2,000rpm					
Sewing area		20mm (L) ×	40mm (W)		30mm (L) x 30mm (W)				
Stitch length			0.1 ~ 10mm		·				
Needle bar stroke			41.2mm						
Lift of the work clamp foot		Ма	ax. 17mm (standard: 14m	m)					
Needle (at the time of delivery)	DP × 5 (#16)	DP × 17 (#19)	DP × 5 (#11)	DP × 5 (#11)	DP × 5 (#11)				
Hook			Standard shuttle hook		·				
Input pattern		30 patterns are prov	ided as standard.*		6 patterns are provided as standard.				
Number of stitches that can be stored in memory			Max. 10,000 stitches						
Number of patterns that can be input		94 patterns (For up	to 64 patterns, sewing c	lata can be added.)					
Enlarging/Reducing facility	20 ~ 200% (1% s	step), Pattern enlargement	reduction can be done	by increasing/decreasin	g the stitch length				
Bobbin thread counter	Provided a	is standard (The bobbin th	read counter can be cha	nged over to the No. of	pcs. counter.)				
Memory medium			EP-ROM						
Lubrication		Cer	ntralized oil wick lubricati	ion					
Lubricating oil		JUKI New De	frix Oil No. 2 (equivalent	to ISO VG32)					
Sewing machine motor		400W compact AC servomotor (direct-drive system)							
Power consumption			500VA						
Weight		Machine head (i	nclude motor) 41kg, Cor	ntrol box 16.5kg					

Model name	LK-1901S	LK-1902S	LK-1902H							
Application	Standard	Standard	For heavy-weight materials							
Sewing speed	Max. 2,700rpm									
Sewing area		20mm (L) × 40mm (W)								
Stitch length		0.1 ~ 10mm								
Needle bar stroke		41.2mm								
Lift of the work clamp foot		Max. 17mm (standard: 14mm)								
Needle (at the time of delivery)	DP × 5 (#16)	DP × 5 (#14)	DP × 17 (#19)							
Hook		Standard shuttle hook								
Available pattern numbers	11, 12, 13	17, 18, (19, 2 Call-up of pattern numbers marked with an a	20, 21, 22*) asterisk (*) is disabled at the time of delivery							
Material-drawing amount	Max. 3mm									
Number of stitches that can be stored in memory		Max. 10,000 stitches								
Number of patterns that can be input	94 pattern	s (For up to 64 patterns, sewing data can	be added.)							
Enlarging/Reducing facility	20 ~ 200% (1% step), Pattern enla	argement/reduction can be done by increa	using/decreasing the stitch length							
Bobbin thread counter	Provided as standard (The b	oobbin thread counter can be changed over	er to the No. of pcs. counter.)							
Memory medium		EP-ROM								
Lubrication		Centralized oil wick lubrication								
Lubricating oil	JUK	I New Defrix Oil No. 2 (equivalent to ISO VC	G32)							
Sewing machine motor	4000	400W compact AC servomotor (direct-drive system)								
Power consumption		500VA								
Weight	Machir	ne head (include motor) 41kg, Control box	16.5kg							

*Call-up of sewing patterns that do not match the work clamp foot mounted at the time of delivery are prohibited. However, it is possible to call them up by changing the setting of the memory switch.

### TABLE OF THE STANDARD PATTERNS — LK-1900, LK-1901, LK-1902

/	No.	Stitch diagram	Number of stitches		ving (mm)	(Note 2) No. of work		No.	Stitch diagram	Number of stitches	Sev size	ving (mm)	(Note 2) No. of work
/	140.	Strich diagram	Num	Length- wise	Cross- wise	clamp foot		140.	Stiter dayran	Num	Length- wise	Cross- wise	clamp foot
<u>,                                     </u>		AT 11111111111				1	·		·				1
	1			2.0	16	2 11		17		21	0	10	2 11
			-			1				+			1
	2	<b>HANNAN ANALANA</b>		2.0	10	2 11		18			0	10	2 11
			42			1				28			4
	3			2.5	16	7	Linear bartacking	19			0	25	6
	*	<b>5.</b>				4	lear bai						4
	4			3.0	24	6	Lin	20		36	0	25	6
DC	5	<b>4</b> ////////		2.0	10	1		21		41	0	25	4
Large bartacking	5	****	28	2.0		11				41		20	6
arge ba	*	100 A A A A A A	20			1			~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~				(
Ľ	6			2.5	16	7		22		44	0	35	(Note 3)
						1			S S S S S S S S S S S S S S S S S S S	(iii			
	7	MMMMM		2.0	10	2		23		(mollog) 28	20	4.0	
	*		36			1	bu			Ê			-
	8	₩₩₩₩₩₩		2.5	16	7	artacki	24		(HIO1109) 36	20	4.0	
						4	Lengthwise bartacking						3, 9
	9		56	3.0	24	6	Length	25		(WO1109) 42	20	4.0	
						4							
	* 10		64	3.0	24			26		(III0110g) 56	20	4.0	
		8 8 8 8 6 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8				6							
nhole)	11	<b>9</b> 0000	21	2.5	6			27		(III0110g) 18	20	0	
t butto		8 8 8 8 8					þ			ğ.			_
Small bartacking (eyelet buttonhole)	12	<b>MAAAAA</b>	28	2.5	6	8	Lengthwise linear bartacking	28		(Bottom)	10	0	
acking							tear ba			21			- 10
all bart.	13		36	2 5	6		wise lir	29		(BOLLOTT)	20	0	
Sma	13		30	2.5	6		.ength	29		(BOI	20		
		R R 80 A								(III)			
bu	14		14	2.0	8			30		(III0110g) 28	20	0	
Knit goods bartacking		a a 9a a a a					(Note)	1. Sew 2. Refe	l ving size shows the dimensions when th er the No. of work clamp foot to the sep	l le scale r arate tab	ate is 1	00%. vork cla	amp foot
oods b.	15		21	2.0	8	5		3. For	No. 22, modify the work clamp foot bla the patterns with * marks for sewing c	ink for u	se.		
Knit gu													
	16	₩₩₩₩₩	28	2.0	8								

#### Provided as standard

	1	2	3	4	5
	135-186	59 (asm.)	135-71955 (asm.)	135-48151 (asm.)	135-42964 (asm.)
Work clamp foot		4.5	23 5.6 12 12	40 ² 335	40 40 40 40 40 40 40 40 40 40
	141-16107	141-16800	141-16909	135-54803	141-16206
		(without knurl)	(without knurl)		
Feed plate					
Application code	S	F	F	Н	М
* Finger guard	135-3	33104	135-73407	135-48300	135-33104
Remarks	Standard accessory for S (standard) type machine head.	Standard accessory for F (foundation) type machine head. (1)	For lengthwise bartacking (packed together with accessories supplied with F- type machine head) (1)	Standard accessory for H (heavy-weight material) type machine head.	Standard accessory for M (knit and knitting fabric) type machine head.

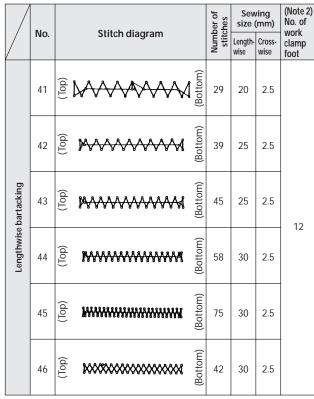
#### Options

(Work clamp foot and feed plates other than standard ones are optional parts.)

	6	7	8	9	10	11
	135-48151 (asm.)	135-48557 (asm.)	135-42451 (asm.)	135-71955 (asm.)	135-61360 (asm.)	135-18659 (asm.)
Work clamp foot	907 97 97 97 97 97 97 97 97 97 97 97 97 97	⁴⁰	40 42 42 40 40 40 40 40 40 40 40 40 40 40 40 40	23 5.6 12		04 20 338 328 328 328 328 328 328 328
	135-48003	141-16305	141-16602	141-16503	141-16701	141-16404
				(without knurl)	(without knurl)	(without knurl)
Feed plate			9'21 24			25 <u>G</u> <u>F</u> <u>29</u>
Application code	S	H S		F	F	F
* Finger guard	135-48300	135-3	33104	135-7	73407	135-33104
Remarks	For extra-large bartacking			For lengthwise bartacking (2)	For lengthwise linear bartacking	For small bartacking (3)

For JE: (1) Option (2) Packed together with accessories supplied with F-type machine head. (3) Standard accessory for F (foundation) type machine head. * Install a finger guard suitable for each work clamp foot when replacing the work clamp foot.

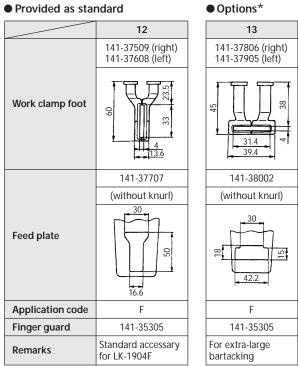
### TABLE OF THE STANDARD PATTERNS — LK-1904F



⁽Note) 1. Sewing size shows the dimensions when the scale rate is 100%. 2. Refer the No. of work clamp foot to the separate table of work clamp foot.

## TABLE OF THE WORK CLAMP FOOT - LK-1904F

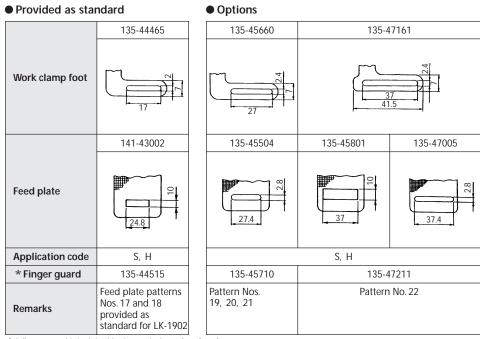
Provided as standard



* When the optional work-clamp foot is used for crosswise bartacking, create new pattern data.

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#### TABLE OF THE WORK CLAMP FOOT --LK-1902



* A finger guard is inclubed in the work clamp foot (asm.)

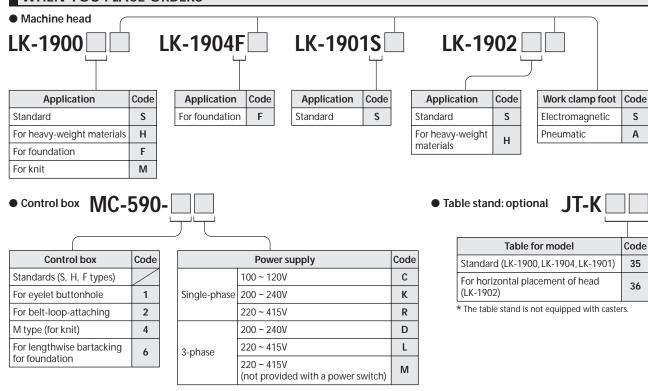
Name of parts	Туре	Part No.
Feed plate blank	Without knurl	141-20109
	With knuri	141-20307
T = 1.2	Without knurl/stainless steel t=0.8	141-20505
Work clamp foot face plate (asm.) $\textcircled{O}$ $\textcircled{O}$ $\textcircled{O}$ $\textcircled{O}$ $t = 3.2$	Face plate for presser blank	141-21263
Presser blank	blank With knurl/Processed (right)	
	With knurl/Processed (left)	141-21800
Needle hole guide	A=1.6 B=2.6 With relief slit Standard type	B2426-280-000
	A=1.6 B=2.0 Without relief slit F and M types	D2426-282-C00
	A=2.3 B=4.0 Without relief slit For heavy-weight material	141-09607
	A=2.7 B=3.7 Without relied slit For extra heavy-weight material	D2426-MMC-K00
Finger guard (1)	A=56.5 B=64	135-33104
	A=59 B=74 For extra-large bartacking	135-48300
Finger guard (2)	A=66.5 B=43 For lengthwise bartacking	135-73407
Finger guard (3)	A=21.5 B=35.5 For specially ordered work clamp	141-20000

#### • Foot pedal for standing work

Model	Part No.	Description
	M8520-580-0A0	2-pedal unit for standing work *
	M9012-590-0A0	Pedal switch conversion cable asm.
PK-57*	GBK-570010B0	1-pedal unit for standing work *
	M9013-590-0A0	Pedal switch conversion cable asm.

* To connect the cable asm. to the electrical box, a conversion cable (separately available) is necessary.

WHEN YOU PLACE ORDERS



LK-1900, 1904F, 1901, 1902 (June, 2001) 6/6 Downloaded from <u>www.Manualslib.com</u> manuals search engine High-speed, 1-needle, Cylinder-bed Lockstitch Bartacking Machine

## LK-1850 SERIES

- In addition to the capability of low-tension stitching, the prevention of loose stitches at the start and end of sewing using synthetic threads is assured. The use of JUKI's unique thread trimming system, coupled with the low-tension sewing capability, have further upgraded the sewing performance. The formation of even stitches of high quality is assured regardless of the type or size of threads used.
- The lower clamping plate has been flattened and the feed cam has been made compact by limiting the sewing size and the number of stitches. The result is a wider sewing area. Furthermore, the work clamp foot lift is as high as 17mm. By these improvements, a workpiece can be handled more easily without concern about the workpiece becoming caught in the cam.
- The machine features a higher sewing speed and shortened cycle time, and is provided with a new smooth thread winder. The machine has various other improvements that lead to higher efficiency, including a pedal that requires low pedaling pressure, a work clamp foot that ensures free finger action, and a face plate that allows the needle entry point to be seen at a glance.



LK-1850

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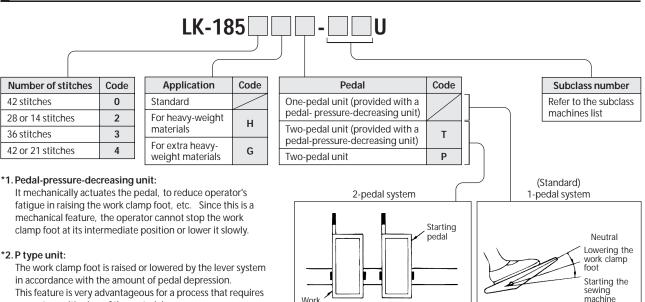
### **SPECIFICATIONS**

Model name	LK-1850 series			
Max. sewing speed	2,300rpm (1,800rpm for synthetic thread)			
Needle bar stroke	41.2mm			
Lift of the work clamp foot	Max. 17mm			
Needle (at the time of delivery)	DP × 5 (#16) #11 ~ #16, For JE: 134 (Nm100) Nm75 ~ Nm160 <h, g="" type=""> Di × 3 #23, For JE: 332 Nm160</h,>			
Hook	Standard shuttle hook			
Feed mechanism	Cam control system			
Stitch adjusting system	Provided with a nut-fixed feed adjusting lever			
Thread trimming system	Thread spreader interlocked with main shaft and thread trimmer interlocked with foot lifter			
Wiper	Interlocked with lifter			
Lubrication	Centralized oil wick lubrication			
Lubricating oil	JUKI New Defrix Oil No. 2 (equivalent to ISO VG32)			
Weight of the machine head	42.5kg			
Motor	Single-phase/3-phase 200W (1/4 HP) induction motor			

### WHEN YOU PLACE ORDERS

This feature is very advantageous for a process that requires

accurate positioning of the material.



Work

clamp foot lifting pedal

## SUBCLASS MACHINES

### • LK-1850 series of bartacking machines

		Number of		Sewing s Lengthwise	size (mm) Crosswise	Max. sewing	
Model	Name	stitches	Stitch diagram	Standard (min. ~ max.)	Standard (min. ~ max.)	speed (rpm)	Needle
LK-1850		42				2,300	DP × 5 #14, #16 134 Nm160
LK-1852-5	Large size bartacking machine	28		2.5 (1.5 ~ 3)	16 (8 ~ 16)	2,300	
LK-1853-15		36	144444444444444444444444444444444444444			2,300	
LK-1854-24	Extra large bartacking machine	42	Å <del>AAAAAAAA</del> A	3 (1.5 ~ 3.5)	24 (12 ~ 24)	2,300	DP × 5 #14, #16 134 Nm160
LK-1852-2	Small size - bartacking machine	28	Ţ <u>ŧŧŧŧŧ</u>	2 5 (1 5 - 2)	9 (4 - 9)	2,300	DP×5 #14 #16
LK-1854-11		21		2.5 (1.5 ~ 3)	8 (4 ~ 8)	2,300	#14, #16 134 Nm160
LK-1852-1	Eyelet buttonhole bartacking machine	28	<b>WWWW</b>	2.5 (1.5 ~ 3) 6 (		2,300	DP × 5 #14, #16 134 Nm160
LK-1854-4		21			6 (4 ~ 8)	2,300	
LK-1853-16		36				2,300	
LK-1852-3		28	M M M	2 (1.3 ~ 3) 6.5 (4	6.5 (4 ~ 8)	2,000	DP x 5 #11 134 Nm75
LK-1854-6	Knit goods bartacking machine	21				2,000	
LK-1852-22		14				2,000	
LK-1854-8	Crosswise straight-line label-attaching machine	21	(former part of stitch) (latter part of stitch)	0	34 (24 ~ 34)	2,000	DP × 5 #14 134 Nm160
LK-1854-12	Semicircular bartacking machine	42	terre the second	7 (6 ~ 7)	10 (8.6 ~ 10)	2,000	DP × 5 #11 134 Nm75
LK-1854-10		21		0	14 (6.5 ~ 14)	2,300	
LK-1852-20	Belt-loop attaching machine	28		0	14 (6.5 ~ 14)	2,300	DP × 5
LK-1852-30		28		0	25 (13 ~ 25)	2,300	#14, #16 134 Nm160
LK-1854-40		42		0	25 (18 ~ 25)	2,300	

LK-1850 SERIES (June, 2001) 2/4 Downloaded from <u>www.Manualslib.com</u> manuals search engine

### APPLICATIONS

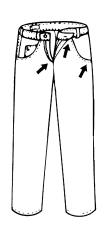


## SUBCLASS MACHINES

#### • LK-1850H/1850G series of bartacking machines

				Sewing s	ize (mm)			
Model	Name	Number of stitches	Stitch diagram	Lengthwise standard (Min. ~ Max.)	Crosswise standard (Min. ~ Max.)	Max. sewing speed (rpm)	Needle	
LK-1850H		42	<del>ᢔᢆᢆᢐᡐ᠋ᡷᢌᢢᡐᢤᢤᢤᢤᢤᢤᢤ</del> ᢌᢩ			2,000		
LK-1852H-5	Large size bar- tacking machine for heavy-weight materials	28	MAAAAAA	3 (1.5 ~ 3)	16 (8 ~ 16)	2,000	Di x 3 #23 332 Nm160	
LK-1853H-15		36	MAAAAAAA			2,000		
LK-1854H-24	Extra large bar- tacking machine for heavy-weight materials	42	<b>Å<del>~~~~~~~~~~</del>«</b>	3 (1.5 ~ 3)	24 (12 ~ 24)	2,000	Di x 3 #23 332 Nm160	
LK-1850G		42	₩₩₩₩₩₩₩			2,000		
LK-1852G-5	Large size bar- tacking machine for extra heavy- weight materials	28	P	3.5 (1.5 ~ 3.5)	16 (8 ~ 16)	2,000	Di x 3 #23 332 Nm160	
LK-1853G-15		36	₩ <del>₩₩₩₩</del> ₩			2,000		
LK-1854G-24	Extra large bar- tacking machine for extra heavy- weight materials	42	₽ <del>₩₩₩₩₩₩₩₩₩</del> ₩	3.5 (1.5 ~ 3.5)	24 (12 ~ 24)	2,000	Di x 3 #23 332 Nm160	

### **APPLICATIONS**

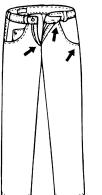


# LK-1850H LK-1852H-5 LK-1853H-15

Large-size bartacking for heavyweight materials, including jeans.

### • LK-1854H-24

Extra large bartacking for heavyweight materials, including jeans.



## ● LK-1850G ● LK-1852G-5

• LK-1853G-15 Extra large bartacking for extra

heavy-weight materials, including extra heavy jeans.

### • LK-1854G-24

Extra large bartacking for extra heavy-weight materials, including extra heavy jeans.

## Computer-controlled, High-speed Shape-tacking Machine Sewing area: $60mm (L) \times 100mm (W)$

# LK-1910

## $LK-1920 \ (\text{with an intermediate presser})$

- The machine can shape tack at a maximum sewing speed of 2,500rpm, dramatically reducing the cycle time.
- With this feature, the LK Series models provide upgraded sewing capabilities such as improved responsiveness to heavy-weight materials. Select either S type(standard type) or H type(for heavy-weight materials) to suit the use of your machine.
- Settings for machine functions such as the sewing speed and bobbin thread count can be easily adjusted via the operation panel, and cycle sewing programs for the production of combined patterns can be entered.
- The machine is provided as standard with an intermediate presser to prevent the material from flagging, thereby promising beautiful seams. Since height and stroke of the intermediate presser can be adjusted, quick responsiveness to changes of material thickness or the number of layers of materials is ensured. (LK-1920)

## $LK-1930 \ (\text{with an intermediate presser and pattern programming function})$

- The LK-1930 is provided with pattern programming function equivalent to that equipped in the AMS-210D computer-controlled cycle machine. With its larger storage capacity, the machine supports diversified sewing patterns. In addition, the sewing machine functions and patterns can be programmed through the operation panel.
- With its automatic correction feature, the machine can enlarge/reduce patterns without deforming them.
- Ample storage capacity: maximum of 360,000 stitches/691 patterns on one floppy disk. An EEP-ROM may be used.
- A maximum of 20,000 stitches can be input per pattern. With this large storage capacity, the machine supports embroidery patterns with large numbers of stitches.



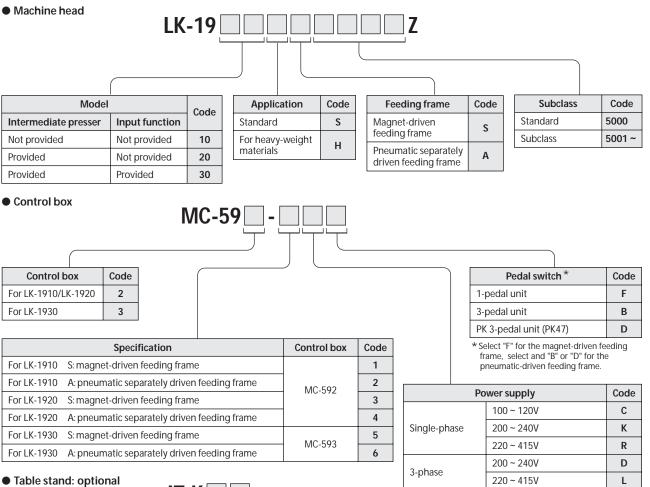
LK-1920

8



## SPECIFICATIONS

Model name	LK-1910S	LK-1910H	LK-1920S	LK-1920H	LK-1930S	LK-1930H
Application	Standard	For heavy-weight materials	Standard	For heavy-weight materials	Standard	For heavy-weight materials
Max. sewing speed		2,50	0rpm (when stitch	length is 3mm or	less)	
Sewing area			60mm (L) 🗙	100mm (W)		
Stitch length		0.1 ~ 1	I0mm		0.1 ~ 1	2.7mm
Needle bar stroke			41.2	2mm		
Lift of the feeding frame		Max. 22m	ım (electromagnet	ic), Max. 25mm (pr	neumatic)	
Lift of the intermediate presser				18r	mm	
Stroke of intermediate presser				Standard 4mm (On	nm and 4 ~ 10mm	)
Needle (at the time of delivery)	DP x 5 (#14)	DP x 17 (#18)	DP x 5 (#14)	DP x 17 (#18)	DP x 5 (#14)	DP x 17 (#18)
Hook			Double-capaci	ty shuttle hook		
Feed motion work clamp foot		R-theta int	ermittent feed (2-s	haft drive by stepp	oing motor)	
Number of stitches that can be stored in memory		Max. 10,00	00 stitches			000 stitches titches/pattern)
Number of patterns that can be input		64 pa	tterns		691 p	atterns
Input function		Not pr	ovided			as standard
Enlarging/Reducing facility	(by	20 ~ 200% y increasing/decrea		gth)	1 ~ 400% (by increasing/decreation) or the number	(0.1% step) asing the stitch length per of stitches)
Memory medium		EEP-	ROM			nicro-floppy disk n also be used.)
Bobbin thread counter			Provided a	as standard		
Lubrication			Centralized oil	wick lubrication		
Lubricating oil		JUKI N	ew Defrix Oil No.2	(equivalent to ISO	VG32)	
Sewing machine motor		400W c	ompact AC servon	notor (direct-drive	system)	
Power consumption	Single-phase, 3-phase 600W					
Weight	Machine	head (include mote	or) 46kg, control b	ox 16.5kg		(include motor) rol box 18kg



J	T-	Κ	
		l	

		Table stand	Code	
For LK-1910	S/1920	S: magnet-driven feeding frame	38	
For LK-1910	A/1920	A: pneumatic separately driven feeding frame	39	
For LK-1930	S: magn	S: magnet-driven feeding frame		
For LK-1930	A: pneur	pneumatic separately driven feeding frame		

* The table stand is not equipped with casters.
 * For the table stand (for the magnet-driven feeding frame, Code No. 38 and 40), two pedals (starting pedal and manual pedal) are packaged together.

LISTING OF DATA THAT CAN BE READ IN

					: Data that can	be read in x: Data t	hat cannot be read in
				Pattern data			
Models used	For LK-1910 LK-1920	For LK	C-1930	For LK-1900	For AMS-206C	For AMS-210C (Resolution: 0.16mm)	For AMS-210C AMS-210D
	EEP-ROM	3.5FD	EEP-ROM	EP-ROM	EEP-ROM	3.5FD	3.5FD
LK-1910/1920		×		×		×	×
LK-1930				×			

Memory medium * The above listing indicates interchangeability without the use of conversion software such as PGM-20.

Single-/3-phase

## FEEDING FRAME INTERCHANGEABILITY

					: Interchangeable	×: Not interchangeable
				Model name		
Models used	Part name	LK-1910/1920 /1930	For LK-1900	For AMS-206C	For AMS-210C (Resolution: 0.16mm	
LK-1910/1920/1930	Feeding frame		×	*		
LK-1910/1920/1930	Feed plate		×	×	×	×

* The memory switch setting has to be changed (the location of the origin has to be changed).

220 ~ 415V for CE (not provided with a power switch)

Μ

### OPTIONS

Model	Part No.	Descrip	tion	Feature	
PGM-20		Programming software for computer controlled sewing machine		Use the PGM-20 software (separately available) for creating pattern data. With the programming software, data can be created in an interactive processing manner using a general-purpose personal computer or ROM writer.	
FU02L				The device is best-suited to attaching small articles such as labels and emblems by sewing the entire circumference.	
	142-25056	Needle cooler		The needle cooler blows air to the needle, thereby preventing thread breakage caused by hot needle.	
	B5019-222-0B0	Thread tension cont	roller No. 3		
	BT-0400251EB	Air tube		The tension controller unit is used to partially change the needle thread tension	
	PV-150209000	Solenoid valve		during the sewing of a pattern.	
	142-04754	Solenoid valve conn	ector asm.		
	142-24760	Thread-tension-relea	asing device	This device requires if you want to change the sewing position without performing thread trimming.	
	B9211-850-0A0	Silicon oil tank			
	SS-7110840SP × 2	Setscrew		This device prevents breakage of synthetic threads.	
	GPK-57001B0	1-pedal unit for star	nding work		
PK-57	M9013-590-0A0	Junction cable			
	E9607-603-000	Clamp			
	B1601-210-D00A	A=2.2, B=3.6, C=38	.5 (standard)	Intermediate presser (LK-1920, LK1930)	
	B1601-210-D0BA	A=2.7, B=4.1, C=38	.5	с	
	B1601-210-D0CA	A=3.5, B=5.5, C=38	.5	t the A	
	B1601-210-D0E	A=1.6, B=2.6, C=37			
	B1601-210-D0FA	A=2.2, B=3.6, C=41	.5		
	B2553-210-D0B	Without knurl	~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~		
	B2553-210-D0A	With knurl	$\sim$	Monolithic feeding frame blank	
	B2554-210-D0A	Without knurl			
	B2554-210-D0B	With knurl (right)		Separately driven feeding frame blank	
	B2554-210-D0C	With knurl (left)			
	142-24109	Without knurl	~~~~	Feed plate	
	142-24000	With knurl		reeu plate	
	D2426-284-M00	A=1.6, B=2.6 Without relief slit	*S type	Needle hole guide	
	141-09607	A=2.3, B=4.0 Without relief slit	* H type		
	D2426-284-C00	A=1.6, B=2.0 Without relief slit For fashion and knit	garment		
	142-24307	A=2.0, B=3.0 Without relief slit			
	B2426-280-00D	A=2.5, B=3.5 Without relief slit			
	D2426-MMC-K0C	A=3.0, B=4.0 Without relief slit			

Computer-controlled Shape-tacking Machine with a Full-rotary 3 fold-Capacity Hook Sewing area: 60mm (L) × 100mm (W)

LK-1941ZA (for extra heavy-weight materials with a heat cutter) LK-1942HA (for heavy-weight materials with an intermediate presser) LK-1942GA (for extra heavy-weight materials with an intermediate presser)

- With its new electronic feed system, the operator can select and use the sewing pattern entered.
   When changing a sewing pattern, the conventional mechanical bartacking machine requires the replacement of a feed cam. Since the new electronic machine no longer uses a feed cam, this operation is no longer necessary and costs are substantially saved.
- The machine demonstrates a high-speed sewing capability of up to 2,200rpm and dramatically increased productivity.
- The machine is equipped as standard with a full-rotary 3 fold-capacity hook. The hook reduces the frequency of the bobbin thread replacement, enhancing efficiency in sewing with thick thread.
- The following features promise improved sewing capabilities for extra heavy-weight materials: A high-power, direct-drive motor that drives the needle with increased material-penetrating force; a higher-torque stepping motor that increases the feed efficiency, and a pneumatic work clamp that increases the material clamping force.

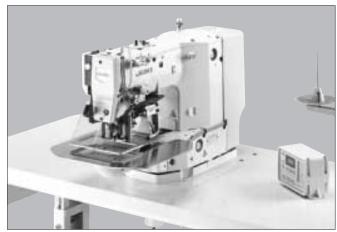
#### •LK-1941

The thread trimmer offers outstanding reliability and durability. The ideal application for the device is the sewing of seatbelts with thick synthetic threads. Unlike the thread trimmer using a knife, the heat cutter trims thick thread without fail and shortens the thread remaining at the seam end. It also offers improved durability to cut down on maintenance requirements. The heat cutter is designed to leave no thread chips on the hot wire section. This ensures consistent thread trimming at all times.

#### LK-1942

By equipping the LK-1942 as standard with an intermediate presser to prevent the material from flopping, beautifully finished seams are almost guaranteed.

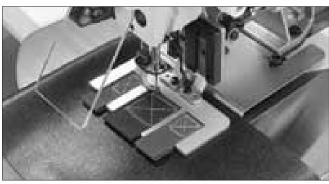
The height and stroke of the intermediate presser are both adjustable.



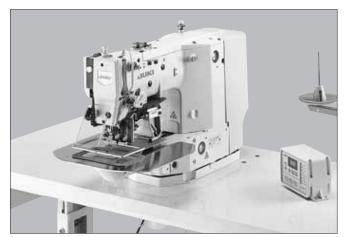
LK-1941ZA



LK-1941ZA



LK-1942GA



LK-1942HA

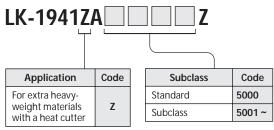
### SPECIFICATIONS

		r			
Model name	LK-1941ZA	LK-1942HA	LK-1942GA		
Application	For extra heavy-weight materials	For heavy-weight materials	For extra heavy-weight materials		
Max. sewing speed	2,200rpm (when stitch length is 3mm or less)				
Sewing area		60mm (L) × 100mm (W)			
Stitch length		0.1 ~ 10mm			
Needle bar stroke		41.2mm			
Lift of the feeding frame		Max. 25mm			
Lift of the intermediate presser		181	nm		
Stroke of intermediate presser		Standard 4mm (Or	nm and 4 ~ 10mm)		
Heat cutter	Provided as standard	Ор	tion		
Needle that can be trimmed	Synthetic only: #8 ~ #1 B92 ~ B277 30/3 ~ 8/3	#30 ~ #8 B46 ~ B92 60/3 ~ 30/3	#8 ~ #2 B92 ~ B207 30/3 ~ 10/3		
Needle (at the time of delivery)	DP × 17 (#25) #24 ~ #26	DP × 17 (#18) #18 ~ #20	DP × 17 (#23) #21 ~ #23		
Hook	Full-rotary 3 fold-capacity hook				
Feed motion work clamp foot	R-theta intermittent feed (2-shaft drive by stepping motor)				
Number of stitches that can be stored in memory		Max. 10,000 stitches			
Number of patterns that can be input		64 patterns			
Enlarging/Reducing facility	20 ~ 200% (1% step), by increasing/decreasing the stitch length				
Bobbin thread counter	Provided as standard				
Memory medium	EEP-ROM				
Lubrication		Centralized oil wick lubrication			
Lubricating oil	JUKI N	lew Defrix Oil No.2 (equivalent to ISO	VG32)		
Compressed air and air consumption		0.5MPa (5kgf/cm ² ), 1.3NQ/min			
Sewing machine motor	480W compact AC servomotor (direct-drive system)		system)		
Power consumption	Single-phase, 3-phase 600W				
Woight	Machine head (include motor) 46kg, Control box 16.5kg				
Weight	Heater unit 3.5kg				

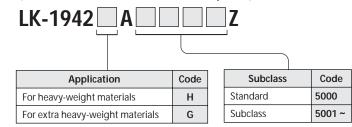
### WHEN YOU PLACE ORDERS

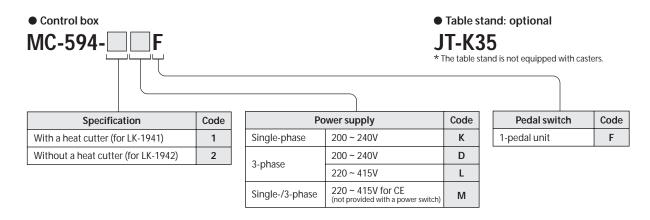
#### Machine head

(with a heat cutter, without an intermediate presser)



(without a heat cutter, with an intermediate presser)





### OPTIONS

Model	Part No.	Descrip	otion	Feature	
PGM-7		Handy programmin	ig device	Sewing patterns can be entered or modified through the handy programming device while holding it. Dedicated keys for frequently-used functions are provided on the handy programming device to cut down the operation time.	
	142-25056 Needle cooler			The needle cooler blows air to the needle, thereby preventing thread breakage caused by hot needle.	
	144-47056	Heat cutter Thread tension controller No. 3 Air tube Solenoid valve Solenoid valve connector asm. Silicon oil tank		The heat cutter cuts both needle threads and bobbin threads (#1 to #8 synthetic thread,) under the throat plate. (For the LK-1941 model, the heat cutter is equipped as standard.)	
	B5019-222-0B0				
	BT-0400251-EB			The tension controller unit is used to partially change the needle thread tension	
	PV-150209000			during the sewing of a pattern.	
	142-04754				
	B9211-850-0A0				
	SS-7110840SP × 2	Setscrew		This device prevents breakage of synthetic threads.	
	144-45050	Thread clamp devic	e	The device prevents stitch skipping and slip-off of the thread from the needle eyelet at the beginning of sewing. Designed with a mechanism to clamp the needle thread under the throat plate, the thread clamp device never interferes with the presser foot or other devices mounted on the machine.	
	142-24760	Thread-tension-rele	asing device	This device requires if you want to change the sewing position without performing thread trimming. (Only applicable to the LK-1942HA)	
רג אם	GPK-470010AB	3-pedal unit		This 2 nodal unit is required if you want to use a double step feeding from	
PK-47	M9025-580-0A0	Junction cable		This 3 pedal unit is required if you want to use a double-step feeding frame.	
	144-44202	Feed plate, blank	J.		
	144-44301	Belt positioning gu	ide	Work clamp, blank for seatbelts Knurled blank, designed for seatbelts, for machining that prevents slippage of	
	SM-9040603SC × 2	Setscrew		material more effectively than the standard one. Adjustable belt positioning	
	WP-0450826SC × 2	Washer of setscrew	for guide	guide can be used.	
	144-44004	Work clamp foot (ri	ght)		
	144-44103	Work clamp foot (le	eft)		
	B2553-210-D0B	Without knurl		Monolithic feeding frame blank	
	B2553-210-D0A	With knurl	$\sim$		
	B2554-210-D0A	Without knurl	$\frown$		
	B2554-210-D0B	With knurl (right)		Separately driven feeding frame blank	
	B2554-210-D0C	With knurl (left)	$\sim$		
	142-24109	Without knurl	~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~	Feed plate	
	142-24000	With knurl	$\searrow$	reeu plate	
	144-46009	Wiper	ę	Reverse sweeping wiper	
	144-45902	Wiper base		In some sewing processes, the wiper may interfere with the needle when it actuates. In such a case, the wiper can be placed at the retracted position.	
	144-39608	A=3.0, B=4.0 *H typ For mechanical thre		Needle hole guide	
	144-39707	A=4.0, B=5.0 *G typ For mechanical thre	ead trimmer	-	
	144-40002	A=3 × 4.4 (ellipitical *Z type (standard) For heat cutter (for			
	144-39400	A=2.0, B=3.0 For mechanical three	ead trimmer		
	144-39509	A=2.3, B=3.3 For mechanical thread trimmer			
	144-40101	A=3 × 4.4 (ellipitical For mechanical thre (for seatbelts)			
	144-39806	A=3.0, B=4.0 For heat cutter			
	144-39905	A=4.0, B=5.0 For heat cutter			

8

#### Computer-controlled Lockstitch Buttonholing Machine

# LBH-1700

- Many different buttonhole shapes can be selected on the operation panel. The machine is able to store as many as 89 different sewing patterns in memory to permit the free selection.
- The newly adopted basting stitch is effective on elastic materials such as knits. The basting stitch helps prevent distortion when sewing knit or stretchy materials.
- Needle thread tension controlled by active-tension. (electronic thread-tension-control system) Needle thread tension for sewing parallel and bartacking sections of buttonholes can be separately controlled through the operation panel and stored in memory according to various sewing conditions (e.g., type of thread, type of material and sewing speed).

The machine is able to change the needle thread tensions at the parallel and bartacking sections of the buttonhole, to produce a beautiful buttonhole shape.

This capability helps greatly in preventing thread breakage.

- Changeover between purl stitching and whip stitching can be performed easily on the operation panel.
- For double stitching, only the parallel portions of a buttonhole will be stitched under the double stitching mode while skipping the bartacking sections. This allows the bartacks of a buttonhole to remain soft.
- Knife replacement is no longer necessary when changing the buttonhole size. To support the small-lot production system where the buttonholing size is frequently changed or the cycle sewing for buttonholes that are different in size, the number of times the knife is dropped to cut the material can be automatically established according to the buttonholing size.
- Three different cycle sewing programs can be registered, each of which can store up to 15 different patterns in memory.
   Data on needle thread tension, buttonholing length, stitching shape, etc.,



LBH-1700SA



### SPECIFICATIONS

Model name	LBH-1700	
Max. sewing speed	3,600rpm	
Needle bar stroke	34.6mm	
Max. lift of the work clamp	12mm	
Number of stitches	Automatically computed from the size of the buttonhole and stitch pitch	
Buttonhole length (mm)	Displayed at the digital operation panel Knife size: 6.4 ~ 31.8 Stitch pitch: 0.2 ~ 0.7 Bartacking length: 0.7 ~ 5.0 Bartacking width (max.): 5.0 Knife groove width: 0 ~ 1.5	
Needle (at the time of delivery)	DP × 5 (#11J) #11J ~ #14J	
Hook	DP type, full-rotary hook	
Material feeding method	Intermittent feed by a stepping motor	
Number of patterns that can be input	Max. 89 patterns	
Machine head drive system	Compact AC servomotor (direct-drive system)	
Power consumption	400VA	
Lubrication	Automatic	
Lubricating oil	JUKI New Defrix oil No.1 (equivalent to ISO VG7)	
Weight	Machine head (include motor) 63kg, Control box 13.5kg	

### WHEN YOU PLACE ORDERS

BH

#### Machine head

Application

Standard

-1	700S	
	╘┰┙┕╼┰	

Work clamp lifter	Code
Standard (2-pedal unit)	Α*
Auto-lifter (magnet-driven type)	В
Auto-lifter (air-driven type)	С
* The auto lifter cannot be retrofitted to th	o machin

The auto-lifter cannot be retrofitted to the machine.

#### * Accessories for the work clamp and knife

Code

S

Part name	Size/Part No.	Accessory	
Work clamp 1	Knife size: 6.4 ~ 19.1mm	Factory installed on machine head	
Work clamp 2	Knife size: 6.4 ~ 25.4mm	Supplied as an accessory (1 pc.)	
Work clamp 3	Knife size: 6.4 ~ 31.8mm	Supplied as an accessory (1 pc)	
Knife 9.5mm (3/8")	Part No.: B2702-047-K00	Supplied as an accessory (1 pc.)	
Knife 12.7mm (1/2")	Part No.: B2702-047-L00	Factory installed on machine head	
Knife 15.9mm (5/8")	Part No.: B2702-047-M00	Supplied as an accessory (1 pc.)	
Knife 25.4mm (1")	Part No.: B2702-047-Q00	Supplied as an accessory (1 pc.)	
Knife 31.8mm (1-1/4")	Part No.: B2702-047-S00	Supplied as an accessory (1 pc.)	

#### • List of major functions of the operation panel

Item	Function
Pattern No.	Invokes patterns stored in memory.
Needle threading	Moves the needle bar to the far right position of its stroke when threading the needle.
Counter	UP counter To be used as the counter for the No. of pcs. DOWN counter To be used as the bobbin thread counter.
Thread tension	Establishes thread tension for sewing parallel sections and bartacking sections of buttonholes.
Programming of data on detailed stitching shape	Establishes data on detailed parts of the stitching shape such as the overedging width, parallel-section stitch pitch, lateral position correction of the bartacking groove, lateral position correction of the knife groove width, clearance, and material-cutting width.
Selection of stitching shape	Selects one of seven stitching shapes. Square*, radial and square*, half-moon (round)*, radial, half-moon and radial, radial with taper bar, radial with straight bartacking(* Three of the seven stitching shapes can be selected on the operation panel by a simple, one-touch operation.)
Selection between single/double stitching	Changes over between single stitching and double stitching.
Performance of the cloth cutting knife	Enables and disables the knife operation.
Work clamp selection	Selects the work clamp size.
Forward/backward travel of feed	Moves the feed forward/backward stitch by stitch.
Change of sewing speed	Changes the sewing speed with the slide speed controller.



#### • The machine is provided as standard with seven different stitching shapes.

	*		×		*	
Square*	Radial and square*	Half-moon (round)*	Radial	Square and half-moon (round)	Radial, with taper bar	Radial, with straight bartacking

* The buttonhole shapes marked with an asterisk (*) can be selected through the operation panel.

### **OPTIONS**

Model	Part No.	Description	Features	
Q060	MAQ-06000-0A0	For men's shirts	First buttonhole spacing guide	
Q061	MAQ-06100-0A0	For ladies' blouses	A ruler used to place the first buttonhole at a predetermined location on a men's shirt or ladies' blouse based on the shape of the collar.	
	B9402-771-000	For lateral buttonholes on the right front of the garment bodies	Buttonhole interval gauge	
	B9402-771-00A	For lateral buttonholes on the left front of the garment bodies	A ruler used to place the next buttonhole at a predetermined interval relative to the previously finished buttonhole.	
	B9401-761-000	For vertical buttonholes		
	G5001-198-0A0-A	Electric bobbin winder (asm.)		
	M8524-600-0A0 Power cord (asm.)		Can be mounted on the table for the operator's convenience.	
	B3221-771-0A0	Tension controller (asm.)		
	SK-3452000-SC × 4	Wood screws		
	M8525-600-0B0 Thread tension control knob (asm.)		The thread tension control knob is used to finely adjust the designated thread tension.	
	GPK-51001-0A0	2-pedal unit for standing work (asm.)	Pedal unit for standing work	
	M9013-590-0A0	Junction cable (asm.)		

LBH-1700 (June 2001) 2/2 Downloaded from www.Manualslib.com manuals search engine

Control box	MC-600
	L

Powers	supply	Code
Single-phase	220 ~ 240V	К
3-phase	220 ~ 240V	D
5-рпазе	220 ~ 415V	L
For CE Single-/3-ph (Not provided with	М	

Ogetet.
1. 1270
三種厚白
每個相關

**Operation panel** 

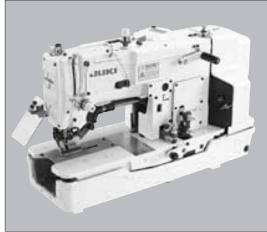
#### 1-needle, Lockstitch Buttonholing Machine

# LBH-780 SERIES

- The buttonholing position can be easily adjusted. This further enhances ease of operation. A newly introduced mechanism in the needle thread trimmer prevents interference with the positioning of buttonholes. The shape of the face plate is designed to provide sufficient clearance around the needle entry position. As a result, ease of operation is further improved.
- The work clamp can be lifted as high as 12mm. The machine is capable of sewing heavy-weight materials such as bulky knits. The maximum lift of the work clamp is 12mm, enabling the machine to make high-quality buttonholes in heavy-weight materials.
- The knife mechanism and stop-motion mechanism produce less noise when they actuate, thus contributing to a more comfortable working environment. Thanks to the simple design of the stop-motion mechanism and unique knife mechanism, the machine operates with low noise. The machine starts, decelerates and stops smoothly.

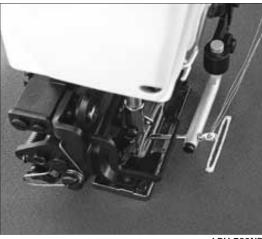
# LBH-780NV (for double-stitching with gimp) LBH-780NB (for double-stitching with gimp and gimp cutter)

- The machine neatly tucks in tetron gimps with consistency. Thanks to the improved locus of the gimp guide, the machine is flexibly adaptable to changes in the types of gimps to be used, easily switching operation to accommodate one to three pieces of tetron thread, or one sewing thread and one span thread. In addition, the gimp guide is designed so that it shifts vertically. This means that the relation between the needle and the gimp guide is uniform even if the material thickness varies, thus allowing the machine to tuck in gimps with consistency.
- A machine is designed for sewing soft-to-the-touch circular bartacks. It has been developed to sew circular bartacks on ladies' wear, a process that requires a very delicate finish.
- The gimp cutter dramatically promotes lobor-saving. (NB type) The length of remaining gimp after its trimming is only about 2mm. This eliminates the thread cropping procedure in the after-process, thereby increasing productivity. The distance between the gimpcutting scissors and the needle scarcely changes when sewing multilayered portions of the material, thus ensuring consistent gimp-cutting at any occasion.



LBH-782

9



LBH-782NB

	1011 700						
Model name	LBH-780	LBH-780NV	LBH-780NB				
Application	Buttonholing for ordinary cloth, knit, etc.	For double-stitching with gimp	For double-stitching with gimp and gimp cutter				
Sewing speed	3,600rpm	3,600rpm Max. 3,300rpm, Normal 3,000rpm					
Needle bar stroke		34.6mm					
Max. lift of the work clamp	12r	nm	11.5mm				
Max. thickness of material that can be used	4mm (with the work clamp lowered)						
Number of stitches		54 ~ 345 (by gear-change method)					
Lengh of buttonholes	6.4 ~ 38.1mm	9.5 ~ 38.1mm	11.5 ~ 38.1mm				
Needle		DP x 5 #11J, For JE: 134 Nm75					
Hook	DP	type, automatic-lubricating full-rotary h	ook				
Deceleration method		Belt-shifting method					
Lubrication		Automatic					
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)						
Motor	300W general-purpose motor (A 250W general-purpose motor can be used when the machine is used at a sewing speed of 3,100rpm or less.)						
Weight of the machine head		40kg					

### WHEN YOU PLACE ORDERS

Model

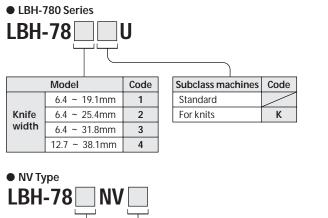
Knife

width

9.5 ~ 25.4mm

9.5 ~ 31.8mm

12.7 ~ 38.1mm



Code

2

3

4

● NB Type LBH-78 NB						
Code		Model	Code		Stitch formation	Code
		11.5 ~ 25.4mm	2		Square-type bartacking	
1	Knife width	11.5 ~ 31.8mm	3		Round-type bartacking	1
	wiath	12.7 ~ 38.1mm	4			

### LIST OF THE SUBCLASS MACHINES ACCORDING TO THEIR APPLICATIONS

Stitch formation

Square-type bartacking

Round-type bartacking

		A	Buttonholing size (in mm)								
Subclass		<b>G</b> B	Α	6.4 ~ 19.1	Α	A 6.4 ~ 25.4		6.4 ~ 31.8	Α	12.7 ~ 38.1	
models	Application		В	2.5 ~ 4.0	В	2.5 ~ 5.0	В	2.5 ~ 5.0	В	2.5 ~ 5.0	
		Stitch formation	С	Max. 22	С	Max. 33	С	Max. 40	С	Max. 47	
Standard type	Men's shirts, blouses, working wear, ladies' wear		L	.BH-781U	L	.BH-782U	L	.BH-783U	L	BH-784U	
<b>K</b> type: For Knits	Knitting fablic underwear, knit products including sweaters, cardigans and tights, medium-weight material including working wear.	(Kanana (Kanana)	L	BH-781KU	LI	BH-782KU	L	BH-783KU	LI	3H-784KU	
NV type : Double- stitching with gimp	Sweater, polo shirts, knits, and jersey wear made of the materials which need to be sewn with especially durable stitches.					l H-782NV H-782NV1		2 H-783NV H-783NV1		H-784NV H-784NV1	
NB type : Double- stitching with gimp and gimp cutter	Same with the application of the NV type models. NB type model is equipped with the automatic gimp cutter.				* 3 LBH-782NB LBH-782NB1			4 H-783NB H-783NB1	LBH-784NB LBH-784NB1		

*1...Dimension A : 9.5 ~ 25.4mm *2...Dimension A : 9.5 ~ 31.8mm *3...Dimension A : 11.5 ~ 25.4mm *4...Dimension A : 11.5 ~ 31.8mm

### OPTIONS

Model	Part No.	Description	Feature
Q060	MAQ-060000A0	Men's shirts	Spacer for first bottonholes This is a ruler to be used to set the first buttonhole at a predetermined position in
Q061	MAQ-061000A0	Ladies' blouses	accordance with the shape of the collar. Adjustable regardless of the dimensions and shape of collars.
Q066	MAQ-066000A0	Spacer for buttonholes on top- center plaits Buttonholes are positioned at right angles to the top-center plaits.	This is a ruler to be used for sewing lateral buttonholes in the process of buttonholing top-center plaits. The ruler is provided with four positioning pointers on the right and left. Each of the pointers can be shifted with a single motion.
SK-1		Pneumatic knife driving unit	The SK-1 pneumatic knife driving unit cuts the material by tapping a flat knife and nylon plate on the material. This prevents the tensing-up of texture yarns that so often occurs when sewing glossy synthetic materials.
AO17		Automatic single-pedal unit	

#### • Table of changing gears

	Small gear			Large gear				
Set	Set   Stitch No.   Part No.   Stitch No.			Stitch No.				
Α	54	B2936-761-000	345	B2937-761-000				
В	62	B2938-761-000	300	B2939-761-000				
С	66	B2940-761-000	285	B2941-761-000				
D	70	B2942-761-000	268	B2943-761-000				
E	74	B2944-761-000	252	B2945-761-000				
F	79	B2946-761-000	238	B2947-761-000				
G	83	B2928-761-000	225	B2929-761-000				
Н	88	B2948-761-000	212	B2949-761-000				
I	93	B2950-761-000	200	B2951-761-000				
J	100	B2930-761-000	190	B2931-761-000				
К	105	B2952-761-000	180	B2953-761-000				
L	110	B2932-761-000	170	B2933-761-000				
М	115	B2954-761-000	160	B2955-761-000				
N	123	B2934-761-000	152	B2935-761-000				
0	130	B2956-761-000	145	B2957-761-000				

#### • Table showing parts used in connection with knives

	Kn	ife	Work clamp check	Throat plate
	l l	4	В	С
No.	Size Part No.		Part No.	Part No.
1	6.4mm (1/4")	B2702-047-F00		
2	9.5mm (3/8")	B2702-047-K00		
3	12.7mm (1/2")	B2702-047-L00		
4	14.3mm (9/16")	B2702-047-V00	B1552-781-000-A	
5	15.9mm (5/8")	B2702-047-M00		B2402-771-000
6	19.1mm (3/4")	B2702-047-N00		
7	22.2mm (7/8")	B2702-047-P00		
8	25.4mm (1")	B2702-047-Q00	B1552-782-000	
9	31.8mm (1-1/4")	B2702-047-S00	B1552-783-000	
10	34.9mm (1-3/8")	B2745-774-00A B1552-784-000 B2402-		20100 221 000
11	38.1mm (1-1/2")	B2745-774-00B	B1552-764-000	B2402-774-000

Note: Standard model machine is used as the standard for work clamp check and throat plate.

High-Speed, 1-needle, Lockstitch Buttonholing Machine

# LBH-790 SERIES

- Thanks to the upper and lower scissors that cut and tuck in the thread without fail, the needle thread hauling mechanism that ensures sewing even on the overlapped section of a material and the improved thread path, as well as the capability of low-tension sewing, the machine can finish high-quality straight buttonholes with consistency regardless of the type of material and process.
- Threading procedure is simplified, the pressure required to depress the foot pedal is reduced, the pedal stroke is made smaller and the needle thread cutting scissors can be easily positioned at its stand-by position. All of these features are developed to help reduce the operator's fatigue and enhance ease of operation. Furthermore the hook timing and safety mechanism can be easily adjusted, thereby achieve a higher grade of maintenance ability. The machine ensures that maintenance works such as adjustment and replacement of the bobbin thread trimmer can be performed with greater ease.
- The machine head is designed while laying a great importance on ease of operation. The machine head has a wider sewing area, which enables the operator to handle the workpiece with ease. The side face of the machine head is cut in consideration of lateral installation of the machine head.

#### • Electronic-stop motor type

The machine equipped with an electronic-stop motor flexibly adapt to the material changing. The electronic-stop motor allows the sewing speed to be adjusted in accordance with the type of material to be sewn and thread to be used. Furthermore, the machine head now has no stop-motion mechanism. As a result, stop-motion noise is eliminated when stopping machine operation. This ensures quieter and more comfortable work environment.



LBH-791RS-1



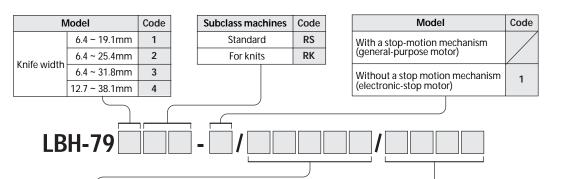
### SPECIFICATIONS

Model name	LBH-791R ~ LBH-794R	LBH-791R-1 ~ LBH-794R-1			
Туре	General-purpose motor type	Electronic-stop motor type			
Sewing speed	Max. 4,000rpm (n	ormal: 3,600rpm)			
Needle bar stroke	34.6	mm			
Max. lift of the work clamp check	14r	nm			
Number of stitches	56 ~ 370 (by gear	-change method)			
Buttonhole length	8.1mm th can be changed by replacing the work clamp check. ed for sewing large buttonholes.)				
Needle (at the time of delivery)	DP × 5 (#11	J) #9 ~ #14			
Hook	DP type, Automatic-lub	ricating full-rotary hook			
Lubrication	Autor	matic			
Lubricating oil	JUKI New Defrix oil No.1 (equivalent to ISO VG7)				
Motor to be used	300W general-purpose motor	400W electronic-stop motor			
Sewing speed control function	Not provided	Provided			
Stop-motion mechanism	Provided	Not provided			
Weight of the machine head	52kg	50kg			

### LIST OF SUBCLASS MACHINES ACCORDING TO THEIR APPLICATIONS

		H A		Bottonholing size (in mm)							
Subclass	Application	В	А	6.4 ~ 19.1	А	6.4 ~ 25.4	А	6.4 ~ 31.8	Α	12.7 ~ 38.1	
models	Application	Ь Сн	В	2.0 ~ 4.0	В	2.0 ~ 5.0	В	2.0 ~ 5.0	В	2.0 ~ 5.0	
		Stitch formation	С	9.8 ~ 24.8	С	9.8 ~ 32.2	С	9.8 ~ 39.7	С	16.7 ~ 47.2	
<b>RS</b> type: Standard	Men's shirts, ladies' blouses, work uniforms and ladies' wear	LBH-791RS LBH-791RS-1		LBH-792RS LBH-792RS-1		LBH-793RS LBH-793RS-1			LBH-794RS LBH-794RS-1		
<b>RK</b> type: Knits	Knits including knitted underwear, sweaters, cardigans and tights and medium-weight garments including work uniforms.	(Prosection Contraction)		LBH-791RK LBH-791RK-1		LBH-792RK LBH-792RK-1		LBH-793RK LBH-793RK-1		LBH-794RK LBH-794RK-1	

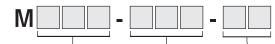
### WHEN YOU PLACE ORDERS



Automatic one-pedal unit							
For general-purpose motor	Code	For electronic-stop motor	Code				
Not provided		Not provided					
Magnet type	AO26	Magnet type	AO25				
Pneumatic type	AO26A	Pneumatic type	AO25A				

Knife drive mechanism							
For general-purpose motor	Code	For electronic-stop motor	Code				
Not provided		Not provided					
2-pedal type	SK3A	2-pedal type	SK2A				
AO26 magnet type	SK3B	AO25 magnet type	SK2B				
AO26 pneumatic type	SK3C	AO25 pneumatic type	SK2C				

#### • Electronic-stop motor



Motor			Code	Control box (MC-50A)		Code	Cont	roller (MC-405)	1	Code	
For General	Single-phase	100 ~ 115V	113		Single-phase	100 ~ 115V	230		Single-phase	100 ~ 115V	
		200 ~ 240V	114	For General	200 ~ 240V		For General	Single-phase	200 ~ 240V	01	
	3-phase	200 ~ 240V	101	Export	3-phase	200 ~ 240V	229 Exp	Export	3-phase	200 ~ 240V	
		380V	103		3-pilase	380V				380V	02
For CE	3-phase	380V	111	For CE	3-phase	380V	237	For CE	3-phase	380V	02

### OPTIONS

Model	Part No.	Des	cription	Feature
Q082	MAQ-08200-0A0	For men's shirts		
Q083	MAQ-08300-0A0	For ladies' blous	es	First buttonhole spacing gauge     A ruler to help sew the top buttonhole at an accurate distance from the collar.
-	137-71209	For vertical butto	onholes	
-	137-82909	For vertical butto	onholes: B	Buttonhole interval gauge
-	137-73502	For lateral butto	nholes (right)	A ruler used to place the next buttonhole at a predetermined interval relative to the
_	137-71308	For lateral butto	nholes (left)	previously finished buttonhole.
AO25	_	Magnet type	For electronic-stop	
AO25A	_	Pneumatic type	motor	<ul> <li>Automatic one-pedal unit</li> <li>The automatic one-pedal unit can be used for lifting/lowering the work clamp check</li> </ul>
AO26	_	Magnet type		and starting the sewing machine, thereby helping reduce the operator's fatigue and allowing him/her to operate the machine both rhythmically and comfortably.
AO26A	_	Pneumatic type	motor	allowing him/her to operate the machine both mythimically and comfortably.
SK2A	_	2-pedal type		
SK2B	_	Magnet type	For electronic-stop motor	Pneumatic knife drive mechanism
SK2C	_	Pneumatic type		The flat knife and nylon plate cuts the material by chopping. This means that the
SK3A	_	2-pedal type		cutting system prevents tensing-up of fabric yarns that is likely to occur when using glossy synthetic fabric.
SK3B	_	Magnet type	For general-purpose motor	glossy synthetic tubric.
SK3C	_	Pneumatic type		

Model	Application	Shape	Distance A	Distance B	Width of knife blade	Buttonhole length	Part No.
791RS	For light-weight materials	A B	30mm	6.6mm	19.1mm (3/4")	25mm	B1552-781-00A
792RS	For light-weight materials	A	40mm	6.6mm	25.4mm (1")	33mm	B1552-782-00A
	For portions	A	26mm 22mm	5.2mm 5.2mm	15.9mm (5/8") 12.7mm (1/2")	22mm 18mm	D1508-771-K0B D1508-771-K0C
791RK	For multi- layered portions	AB	7.3mm 11.3mm	0.9mm 0.9mm	15.9mm (5/8") 12.7mm (1/2")	22mm 18mm	D1508-771-K0E D1508-771-K0F
	For top-center plaits	1 A B	25.6mm	8.8mm	12.7mm (1/2")	18mm	D1508-771-K0H
	For portions	AB	37mm 29.5mm 22mm	5.2mm 5.2mm 5.2mm	25.4mm (1") 19.1mm (3/4") 12.7mm (1/2")	33mm 25.5mm 18mm	D1508-772-K0A D1508-772-K0B D1508-772-K0C
792RK	For multi- layered portions	A	7.8mm 15.3mm 22.8mm	0.9mm 0.9mm 0.9mm	25.4mm (1") 19.1mm (3/4") 12.7mm (1/2")	33mm 25.5mm 18mm	D1508-772-K0D D1508-772-K0E D1508-772-K0F
	For top-center plaits	1 A B	33.1mm	8.8mm	19.1mm (3/4")	25.5mm	D1508-772-K0H

• Optional parts (work clamp check for light-weight materials, knits and knitted fabric)

#### • Table showing parts used in connection with knives (for plain knife)

Plain kr	nife	Knife guard	Throat plate
	Ō		
Size (mm)	Part No.	Part No.	Part No.
6.4mm (1/4")	B2745-771-F00		
9.5mm (3/8")	B2745-771-K00		
12.7mm (1/2")	B2745-771-L00		
15.9mm (5/8")	B2745-771-M00	B2746-771-000	137-82800
19.1mm (3/4")	B2745-771-N00	D2740-771-000	137-02000
22.2mm (7/8")	B2745-771-P00		
25.4mm (1")	B2745-771-Q00		
28.6mm (1-1/8")	B2745-771-R00		

Large size p	olain knife	Knife guard	Throat plate
0			
38.1mm (1-1/2")	B2745-771-F00	137-39602	137-39404

9

### TABLE OF EXCHANGING GAUGE

#### • Table of changing gears

	Small gear			Larger gear		
Set	Stitch No.	Part No.	Stitch No.	Part No.		
Α	56	137-56200	370	137-56309		
В	60	137-56408	347	137-56507		
С	64	137-56606	326	137-56705		
D	68	137-56804	306	137-56903		
E	72	137-57000	288	137-57109		
F	76	137-57208	271	137-57307		
G	81	137-57406	256	137-57505		
Н	86	137-57604	242	137-57703		
I	91	137-57802	228	137-57901		
J	96	137-58008	216	137-58107		
к	101	137-58206	204	137-58305		
L	107	137-58404	194	137-58503		
М	113	137-58602	183	137-58701		
Ν	119	137-58800	174	137-58909		
0	126	137-59006	164	137-59105		
Р	133	137-59204	156	137-59303		
Q	140	137-59402	148	137-59501		

#### • Table showing parts used in connection with knives

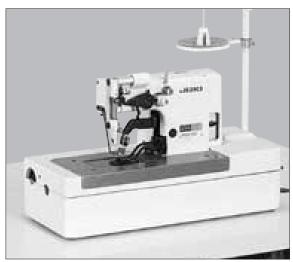
K	nife	Work clamp check	Presser foot asm.	Throat plate
Size	Size Part No.		Part No.	Part No.
6.4mm (1/4")	B2702-047-F00			
9.5mm (3/8")	B2702-047-K00			137-39107
12.7mm (1/2")	B2702-047-L00	B1552-781-000A	→ 139-26662	
14.3mm (9/16")	B2702-047-V00	D1508-771-K00A	¥ 137 20002	
15.9mm (5/8")	B2702-047-M00			
19.1mm (3/4")	B2702-047-N00			137-82305
22.2mm (7/8")	B2702-047-P00	B1552-782-000	→ 139-46454	
25.4mm (1")	B2702-047-Q00	D1508-772-K00		
31.8mm (1-1/4")	B2702-047-S00	B 1552-783-000 D1508-773-K00	→ 139-46553	
34.9mm (1-3/8")	B2745-774-00A	B1552-784-000	→ 139-46652	137-80408
38.1mm (1-1/2")	B2745-774-00B	D1508-774-K00	139-40032	137-82404

Note: Standard model machine is used as the standard for work clamp check and throat plate. Upper side of presser foot and throat plate number is specified for type RS (RS-1) and lower side is for type RK (RK-1).

#### Single-thread, Chainstitch Machine

# MBH-180 (buttonholing type) MBH-180S (decorative buttonhole type) MBH-180L (label attaching type)

- The machine demonstrates its improved capabilities to speed up the progress of work, it achieves a shorter cycle time and does not require bobbin thread changing.
- Consistent feed pitch ensures beautifully-finished, high quality seams.
- Sewing size and stitch length can be easily adjusted.
- The machine is provided with an auto-lifter and an automatic thread trimmer controlled by the one-pedal unit. This means that the operator can perform continuous operations with ease.
- For the MBH-180L, single-thread chainstitch and double chainstitch settings can be quickly changed over.
- Labels can be attached to men's shirts, blouse, sport shirts.



MBH-180

### **SPECIFICATIONS**

Max. stitch length     0.4 ~ 1m       Needle bar stroke     27mm	er garments Various label attaching processes				
Application     process for shirts     for men's upper       Max. sewing speed     3,300rpr       Sewing size     6.4 ~ 34.9mm (1/4" ~ 1-3/8")     * 6.4 ~ 22.2mm (1/4" ~ 1-3/8")       Overcasting width     1.6 ~ 2.4m       Max. stitch length     0.4 ~ 1m       Needle bar stroke     27mm	er garments processes				
Sewing size         6.4 ~ 34.9mm (1/4" ~ 1-3/8")         * 6.4 ~ 22.2mm ("           Overcasting width         1.6 ~ 2.4m           Max. stitch length         0.4 ~ 1m           Needle bar stroke         27mm					
Overcasting width     1.6 ~ 2.4n       Max. stitch length     0.4 ~ 1m       Needle bar stroke     27mm	pm				
Max. stitch length     0.4 ~ 1m       Needle bar stroke     27mm	n (1/4" ~ 7/8") 6.4 × 38.1mm (1/4" ~ 1-1/2")				
Needle bar stroke 27mm	1.6 ~ 2.4mm				
	0.4 ~ 1mm				
	m				
Max. lift of the presser foot 7mm (normal: 5mm)	2mm (when the presser foot is in it most advanced position)				
DB × 1 (#14) #11 ~ #16         DB × 1 (#14) #11           16 × 231 (Nm90) Nm75 ~ Nm100         16 × 231 (Nm90) Nm					
Lubrication By an oil	By an oiler				
Lubricating oil JUKI New Defrix Oil No.2 (eq					
Dimensions 470mm (W) × 212mm					

* The sewing size can be set to 38.1mm (1-1/2") at the maximum by changing the presser foot.

9

#### • Knife

Si	ze	Part No.	For knit **
	6.4mm (1/4")	B2701-180-F00	B2701-180-F0A
$\square$	9.5mm (3/8")	B2701-180-K00	B2701-180-K0A
	12.7mm (1/2")	B2701-180-L00	B2701-180-L0A
	14.4mm (9/16")	B2701-180-V00	B2701-180-V0A
	15.9mm (5/8")	B2701-180-M00 *	B2701-180-M0A
	19.1mm (3/4")	B2701-180-N00	B2701-180-N0A
	22.2mm (7/8")	B2701-180-P00	B2701-180-P0A
	25.4mm (1")	B2701-180-Q00	B2701-180-Q0A
Q -	28.6mm (1-1/8")	B2701-180-R00	B2701-180-R0A
	31.8mm (1-1/4")	B2701-180-S00	B2701-180-S0A
	34.9mm (1-3/8")	B2701-180-T00	B2701-180-T0A
	•	* Standard	** Special order parts

**^{**}** Special order parts

#### • Cloth clamp foot asm.

Part No.	Descr	iption	Applicable range
B1502-180-AA0 *	Cloth clamp foot, right asm.		
B1503-180-AA0 *	Cloth clamp foot, left asm.		For the knives range from
B1502-180-BA0	Cloth clamp foot, right asm.		6.4 ~ 34.9mm (1/4" ~ 1-3/8")
B1503-180-BA0	Cloth clamp foot, left asm.		
B1502-180-CA0	Cloth clamp foot, right asm.		
B1503-180-CA0	Cloth clamp foot, left asm.		For the knives range from
B1502-180-DA0	Cloth clamp foot, right asm.		6.4 ~ 19.1mm (1/4" ~ 3/4")
B1503-180-DA0	Cloth clamp foot, left asm.		

* Standard Mat

Mat		
Part No.	Clamp foot	Throat plate
B1501-180-A00 *	B1502-180-AA0 B1503-180-AA0 B1502-180-CA0 B1503-180-CA0	B1109-180-C0B B1109-180-C0A
B1501-180-B00 *	B1502-180-BA0 B1503-180-BA0 B1502-180-DA0 B1503-180-DA0	B1109-180-000
B1501-180-A0A	B1502-180-AA0 B1503-180-AA0 B1502-180-CA0 B1503-180-CA0	B1109-180-A00
B1501-180-A0B	B1502-180-AA0 B1503-180-AA0 B1502-180-CA0 B1503-180-CA0	B1109-180-B00

* Standard

Computer-controlled, Eyelet Buttonholing Machine with a Trimmer for Needle and Looper Thread with Gimp

MEB-3200SS (for men's and ladies' wear)
 MEB-3200RS (for combined use for lateral and longitudinal buttonholing: for men's and ladies' wear)
 MEB-3200RD (for combined use for lateral and longitudinal buttonholing: for men's and ladies' wear, lateral-installation machine head)
 MEB-3200JS (for jeans)
 MEB-3200CS (for cotton pants and working wear)
 An active tension mechanism (computer-controlled thread tension mechanism) that electronically controls the needle and looper thread tensions. Needle and looper thread tensions can be digitally established on the

operation panel according to sewing conditions. Data can be registered on a pattern-by-pattern basis to easily reproduce the same sewing conditions.

Thread tensions can be separately established for various sections of a buttonhole such as eyelet sections and parallel sections.

- The knife is controlled by a stepping motor. This enables easy adjustment of the knife pressure on the operation panel to suit the material to be used, thereby preventing irregular cutting.
   Selection between the cut-before knife and cut-after knife can be made on the operation panel.
- The right and left work clamps are separately driven by independent air cylinders. With this mechanism, the work clamps reliably clamp materials of different thicknesses to prevent the materials from flopping.
- JUKI has newly developed a machine head with a shallow recess. For the efficient sewing of longitudinal buttonholing.
- The computer controlled design eliminates most of the complicated mechanisms. This dramatically improves maintainability.



MEB-3200RS



MEB-3200SS

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### **SPECIFICATIONS**

Model name	MEB-3200SS	MEB-3200RS	MEB-3200RD	MEB-3200JS	MEB-3200CS		
Application	For men's and ladies' wear	For combined use for I buttonholing: for m		For jeans	For cotton pants and working wear		
Thread trimming style		Longer remaining thread	1	Shorter remaining thread			
Table stand	Standard	Standard	Lateral-installation machine head	Standard	Standard		
Stitch system		1-needle,	h a gimp)				
Max. sewing speed	400 ~ 2,200rpm (100rpm step)						
Sewing length	10 ~ 38mm (with thread trimmer) 10 ~ 50mm (in case looper thread trimming device is removed)			Work clamp type S 16 ~ 24 (26)mm: optional Work clamp type M 24 ~ 32 (34)mm: standard Work clamp type L 32 ~ 40 (42)mm: optional	Work clamp type S 16 ~ 24 (26)mm: standard Work clamp type M 24 ~ 32 (34)mm: optional Work clamp type L 32 ~ 40 (42)mm: optional		
				The figures in () parenthe	eses are in case of taper bar		
Stitch bite width	2.0 ~ 3.2mm						
(at the time of delivery)	(2.3mm)	(2.3mm)	(2.3mm)	(2.5mm)	(2.5mm)		
Taper bar length			0mm, 3~15mm				
Work clamp height			13mm (max. 16mm)				
Method for changing stitch shape			By selecting a program				
Buttonhole cutting method		By cut-before knife	or cut-after or without	buttonhole cutting			
Feed system		Interm	ittent feed by a stepping	g motor			
Method to drive the cloth-cutting knife		Vertic	ally driven by stepping	motor			
Needle (at the time of delivery)		D0 × 558 (Nm100) Nm90 ~ Nm110	)	D0 × 558 (Nm120) Nm120 ~ Nm130	D0 × 558 (Nm110) Nm110 ~ Nm120		
Lubrication		Automatio	c (looper and spreader: k	oy an oiler)			
Lubricating oil		JUKI New De	frix Oil No.2 (equivalent	to ISO VG32)			
Compressed air and air consumption		0.5MPa (	5kgf/cm²), 6NQ/min (8c	ycle/min)			
Power requirement and power consumption	Single-/3-phase, 550VA						
Dimensions		1,060mm	(W) × 790mm (D) × 1,2	30mm (H)			
Total weight			185kg				

* By selecting the left looper and left spreader, the range of stitch bite can be changed to 2.6 ~ 4.0mm from 2.0 ~ 3.2mm

MEB-3200SS, 3200RS, 3200RD, 3200JS, 3200CS (June, 2001) 1/4

### WHEN YOU PLACE ORDERS (COMPLETE)

Application

For combined use for lateral and

For men's and ladies' wear

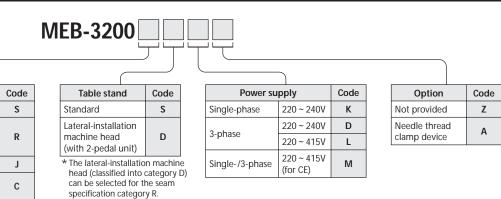
longitudinal buttonholing:

for men's and ladies' wear

For cotton pants and

For jeans

working wear



### EYLET SHAPES AND STRAIGHT BUTTONHOLE SHAPES

• The machine is provided as standard with 10 different stitching shape patterns. As many as 89 different patterns can be stored in memory and selected.

	***	**	***	*	*	*	*
							Buttonhole with a round bartack
Eyelet buttonhole Straight buttonhole	Eyelet bu	uttonhole		Straight buttonhole			

* Registered in standard patterns (S, R type)

** Registered in standard patterns (J, C type)

### LIST OF MAJOR FUNCTIONS OF THE OPERATION PANEL

Item	Function
Needle threading	The needle bar turns by 180 degrees to allow the operator to thread the machine head from this side of the machine.
Forward	Moves the feed forward stitch by stitch.
Backward	Moves the feed backward stitch by stitch.
Pattern No.	Displays and specifies a pattern number.
Data No.	Displays and specifies a data number.
Counter	Can be used as a counter for the number pieces. (The counter can either count up or count down.)
Needle thread tension	Displays and specifies data on needle thread tension.
Looper thread tension	Displays and specifies data on looper thread tension.
Programming of data on detailed stitching shape	Specifies data on the respective buttonhole shape sections. Cutting length, number of parallel buttonhole sections, number of buttonhole eyelet sections, cutting space, eyelet section space, taper bar length, number of taper bar sections, taper bar offset
Sewing speed	Specifies a sewing speed.
Sewing speed for eyelet section	Specifies a reduced speed for eyelet section
Knife ON/OFF	Switches between operation with and without the knife.
Cut-before knife	Establishes data on the cut-before knife.
Cut-after knife	Establishes data on the cut-after knife.
Knife No.	Selects the type number of knife to be used.
Automatic operation	Switches between automatic operation and manual operation.
Material-opening device	Selects the mode used to hold open the material-opening device.
Knife adjustment	Enters the cloth cutting knife adjusting mode.
Function	Activates the desired data setting using the memory switch.



**OPERATION PANEL** 

### LIST OF THE REPLACEMENT GAUGES

#### • Throat plate

Part name	Part No.	A	ppli	catio	n	Needle size
		S	R	J	С	Needle Size
Throat plate A (standard)	320-42707					Nm90 ~ Nm110
Throat plate B (for semi-wide stitch bite)	320-42905					Nm90 ~ Nm110
Throat plate C (for wide stitch bite)	320-43002					Nm90 ~ Nm110
Throat plate D (for narrow stitch bite)	320-43200					Nm90 ~ Nm110
Throat plate JA (standard)	320-43408					Nm120 ~ Nm130
Throat plate JB (for semi-wide stitch bite)	320-42814					Nm90 ~ Nm110
Throat plate JC (for wide stitch bite)	320-43119					Nm90 ~ Nm110
Throat plate JD (standard)	320-43606					Nm90 ~ Nm110
Throat plate JE (standard)	320-43507					Nm110 ~ Nm120
Throat plate JF (standard)	320-43309					Nm90 ~ Nm100

#### • Work clamp, complete

Part name	Part No.	Application				
Faithanie	Fait NO.	S	R	J	С	
Compensating work clamp, complete S, for eyelet buttonholes	320-28458					
Compensating work clamp, complete M, for eyelet buttonholes	320-28554					
Compensating work clamp, complete L, for eyelet buttonholes	320-29050					
Work clamp, complete for longitudinal buttonholes	320-31064					

#### Work clamp

Work clamp (left)							
Part name	Part No.	Application					
Part hame	Part NO.	S	R	J	С		
For eyelet buttonhole 40mm	140-10102						
For eyelet buttonhole 32mm 140-59604							
For eyelet buttonhole 22mm 140-59802							
For straight buttonhole 40mm	140-13908						
Compensating work clamp H, 40mm for eyelet buttonholes	140-58903						
Compensating work clamp M, 32mm for eyelet buttonholes 320-28706							
Compensating work clamp S, 24mm for eyelet buttonholes 320-28300							

Work clamp (right)							
Part name	Part No.	Application					
Part name	Part NO.	S	R	J	С		
For eyelet buttonhole 40mm	140-10003						
For eyelet buttonhole 32mm	140-59505						
For eyelet buttonhole 22mm 140-59703							
For straight buttonhole 40mm 140-13809							
Compensating work clamp H, 40mm for eyelet buttonholes 140-58804							
Compensating work clamp M, 32mm for eyelet buttonholes	140-28607						
Compensating work clamp S, 24mm for eyelet buttonholes 320-28201							

#### Presser support plate

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Part name	Part No.	Application				
Part name	Part No.	S	R	J	С	
Presser support plate (left) for eyelet buttonholes	320-27104					
Presser support plate J (left) M for eyelet buttonholes	320-28904					
Presser support plate (right) for eyelet buttonholes	320-27005					
Presser support plate J (right) M for eyelet buttonholes	320-28805					
Presser support plate (left) for straight buttonholes	320-29506					
Presser support plate (right) for straight buttonholes	320-29407					

: Provided as standard No symbol : Optional : Accessory - : Installation is invalid.

#### Cloth cutting knife

For eyelet buttonhole											
Part No.	Shape (mm)		Shape (mm) Max. cutting		/ maxil outling		Appli		cation		
Part NO.	Х	Y	length (mm)	S	R	J*	C*				
140-41206	2.9	4.4	38			L	L				
320-63604	2.9	4.4	24			S					
320-63703	2.9	4.4	32				М				
320-63802	2.1	3.2	38								
320-63901	2.1	3.2	24								
320-64008	2.1	3.2	32								
320-64107	3.2	5.4	38								
320-64206	3.2	5.4	24								
320-64305	3.2	5.4	32								

J, C Type L: Accessory for compensating work clamp L, complete, for eyelet buttonholes (optional)

J type S: Accessory for compensating work clamp S, complete, for eyelet buttonholes (optional)

C Type M: Accessory for compensating work clamp M, complete, for eyelet buttonholes (optional)

For straight buttonhole								
Part No.	Shape (mm) Max. cutting Ap				ppli	catio	n	
Part NO.	Х	Y	length (mm)	S	R	J*	C*	
140-41404	0	0	38					
320-65302	0	0	24					
320-65401	0	0	32					

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#### • Knife guard

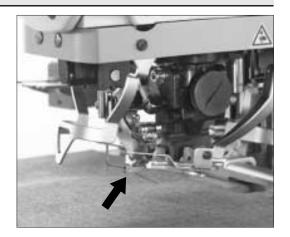
For eyelet buttonhole								
Size	Part No.	A	ppli	catio	n			
(mm)	Part NO.	S	R	J*	C*			
38	320-62101							
36	320-62200							
34	320-62309							
32	320-62408							
30	320-62507							
28	320-62606							
26	320-62705							
24	320-62804							
22	320-62903							
20	320-63000							
18	320-63109							
16	320-63208							
14	320-63307							
12	320-63406							
10	320-63505							

	For straight buttonhole							
Size	Part No.	A	ppli	catio	n			
(mm)	Part NO.	S	R	J*	C*			
40	140-42501							
36	320-64404							
34	320-64503							
32	140-42600							
30	320-64602							
28	320-64701							
26	140-42808							
24	320-64800							
22	140-42907							
20	320-64909							
18	320-65005							
16	140-43103							
14	320-65104							
12	320-65203							
10	140-43301							

* For the J, C type, use a cloth-cutting knife and knife guard that are equal in length to the maximum sewing length or shorter. (Maximum sewing length S: 24mm, M: 32mm, L: 40mm)

### NEEDLE THREAD CLAMP DEVICE

- The machine with the needle thread clamp device is available as optional model.
- It tucks the needle thread in the seam, thereby eliminating thread end securing work.
- It clamps the needle thread to from a beautiful seam without fail from the first stitch.
- * Optional part: Part No.: 320-24465



### OPTIONS

Part No.	Description	Feature
320-70054Marking lamp, asm.When placing the material on the machine, accurate lateral positioning is guarante (for MEB-3200SS, JS, CS)		When placing the material on the machine, accurate lateral positioning is guaranteed. (for MEB-3200SS, JS, CS)
M8590-513-0AA	Pedal switch, asm.	The work clamp can be lifted/lowered and the machine can be stand using the pedal switch.
M9014-620-0A0	Pedal switchcable, asm.	(The MEB-3200RD is provided as standard with the pedal switch, asm.)

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Marking lamp, asm.



Pedal switch, asm.

#### Single-thread, Chainstitch Basting Machine

# ML-111

- High efficient basting works at a sewing speed of 1,800rpm.
- Chainstitch is continuously formed with a single thread and by a blind looper which eliminates the need for a bobbin thread refilling. In addition, the basted seam can be easily undone.
- Basting works are efficiently done with a maximum stitch length of 10mm which is easily set up by a control dial.



ML-111

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### SPECIFICATIONS

I		
Model name	ML-111	
Max. sewing speed	1,800rpm	
Max. stitch length	10mm	
Needle bar stroke	35mm	
Lift of the presser foot	By hand: 5.5mm, By knee: 12mm	
Needle (at the time of delivery)	TV x 7 (#14) #11 ~ #14	
Thread take-up	Needle bar thread take up	
Feed dog	3-row feed dog	
Looper	Blind looper	
Lubrication	By an oiler	
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	
Distance from needle to machine arm	300mm	
Size of bed	476mm × 178mm	
Weight of the machine	29kg	

### APPLICATIONS

- The basting of the front edges, edge and stand of collars, flaps of men's and ladies' suits and coats.
- The basting of the waist bands, the flies of trousers slacks, etc.

Single-thread, Chainstitch Blindstitcher

# CB-638

Single-thread, Chainstitch Blindstitcher with Skip-stitch Device

CB-640 CB-641 (with universal throat plate) CB-643 (with book-seaming folder)

Single-thread, Differential Top-feed Chainstitch Blindstitcher with Skip-stitch Device

CB-671



CB-641

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### FEATURES

Model	Feature	Applications	
CB-638	One-piece-sole presser foot gives proper fullness to rolled lapels and collars.	For padding rolled lapels and collars of coats and jackets.	
CB-640	Short arm presser foot ensures fine finish especially when working on light-weight garments.	For hemming the bottoms of ladies' and children's dresses, skirts, slacks etc. For general blindstitching on blouses, foundation	
CB-641	Universal throat plate enables a single machine to blindstitch various materials independent of weight.	garments, shirts, slacks cardigans etc. CB-640: For light- and medium-weight materials CB-641: For light- , medium- and heavy-weight materials	
CB-643	This machine is for book-seaming edges of curtains and piece goods etc. It is fitted to turn up the edge automatically and eliminates the need for piping.	For hemming light- and medium-weight flare skirt. For curtains and piece goods.	
CB-671	The latest model capable of blindstitching the circular edges by its unique differential-feed system, even partially with pedal operation. Saves operator training time and increases your production rate.	For hemming light- and medium-weight flare skirt bottoms, round tablecloths and other circularedge workpieces.	

### SPECIFICATIONS

Model name	CB-638	CB-640	CB-641	CB-643	CB-671		
Stitch type	Single-thread chainstitch/Blindstitch (stitch type 103)						
Max. sewing speed		2,500rpm					
Stitch length			3 ~ 8mm				
Feed system		Top-1	eed		Differential top-feed		
Differential-feed ratio		Ma (main fe					
Skip stitch	Non-skip (1:1) stitch only	) Skip (2:1) stitch and Non-skip (1:1) stitch					
Max. lift of the presser foot		By knee: 9mm					
Needle (at the time of delivery)		LW × 6T (#14) #11	#16 43:45CC (Nm	90) Nm75, Nm100			
Thread		#1	00~#50, B33, Nm=12	0/3			
Penetration width		3 mm (fixed)					
Penetration depth	Max. 0.8 mm						
Lubrication	By an oiler						
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)						
Weight of the machine head	25kg		2	7kg			

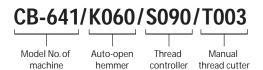
CB-638, 640, 641, 643, 671 (June, 2001) 1/2

### OPTIONS

	<b>D</b> N	Dent No. Description				Application				
Model	Part No.	De	escription	Feature		CB-640	CB-641	CB-643	CB-671	
T003	B4325-640-0A0	Manual thread cutter		Cuts sharply even tough thread like polyester and nylon thread by a single-touch operation, preventing any thread trimming failure and ensuring clear finish of seams. Using this Manual thread cutter together with electronic-stop motor controlling needle position you can highly promote working efficiency.						
H060	B4365-640-0A0	Uncurl	ing guide	Guides the workpiece steadily to the throat plate preventing light- weight or stretching materials from waving, curling or rising while being sewn.						
	B4366-640-0A0	30mm	A	Regulates the folding width for hemming (30, 35 or 40mm). Auto-open swing type hemmer permits prominent sections to pass						
K060	B4367-640-0A0	35mm		Auto-open Hemmer	smoothly and does not interrupt stitching. When the periphery of a skirt bottom has been completely bemmed, the front end of the bem					
	B4368-640-0A0	40mm	(swing type)	pushes up the hemmer to continue a smooth feed of the skirt. This makes the end of a seam smoothly overlap with its starting portion.						
S090	B6364-640-0A0	Thread controller		Provides the needle with more amount of thread to relax the stitch when sewing knits and other stretching fabrics. This prevents the sewing thread breakage in the stretching garments.						
	B4841-640-000	2mm	Ridge forming							
-	B4842-640-000	2.5mm	disc with							
	B4843-640-000	3mm	round point							

### WHEN YOU PLACE ORDERS

Please specify the necessary attachments of the sewing machine using our attachment codes as shown by an example given below:



#### **Pinpoint Saddle Stitching Machine**

# MP-200

- In addition to balloon-stitching (to produce seams with a hand-stitched touch), smooth sewing of chain-off stitches, and other outstanding sewing capabilities of the highly regarded Columbia 100, the MP-200 achieves a minmun needle gauge of 1.2mm for wider applicability.
- The machine head of the MP-200 is modeled after JUKI's lockstitch machine head to provide a wider area under the arm and optimize operability. In addition, the simply designed mechanisms of the machine head greatly facilitate maintenance works such as timing adjustments.
- The feed pitch can be reduced as desired by using the lever during sewing. This allows the operator to control the locations of the needle entry points on material edges.



MP-200

### SPECIFICATIONS

Model name		MP-200	
Max. sewing speed		2,000rpm	
Thread take-up		Link type, thread take-up	
Needle bar stroke		24.3mm	
Stitch length		3 ~ 7 stitches/inches (3.5 ~ 8.5mm) * Reverse feed stitching is disabled.	
Lift of the presser foot		By hand: 5.5mm, By knee: 12mm	
Needle width		1.2mm, 1.6mm, 2.0mm (The needle width can be chose by changing number of spacer gauges.)	
Needle	Needle	SCHMETZ 29-C-150 (#90) #80 ~ #140	
(at the time of delivery)	Looper	SCHMETZ 29-C-151 (#100) #80 ~ #140	
Distance from needle to machine arm 265mm		265mm	
Lubrication By an oiler		By an oiler	
Lubricating oil		JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	

### NEEDLE WIDTH

The needle width of MP-200 is factory-adjusted to 1.6mm at the time of delivery.

The setting can be chose to 1.2mm or 2.0mm by changing number of spacer gauges as shown in the below.

A single MP-200 supports these three needle width.

Needle width	Number of spacer gauges
1.2mm	
1.6mm	1
2.0mm	2

### USES OF PINPOINT STITCHING

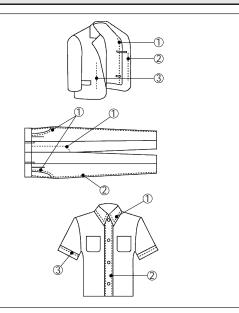
- Men's coats and jackets
- Topstitching on front facing
- O Star-shape tacking at the far side of front facing, star-shape tacking on front body (for preventing uneven material feed)

#### Slacks

- ① Topstitching on front pocket mouths and left top-center plait
- ② Side topstitching

#### Miscellaneous

- ① Topstitching on collars of coats, ladies' cut and sewn garments, knit shirts, etc.
- ② Topstitching on top-center plaits of coats, ladies' wear, shirts, etc.
- ③ Various kinds of topstitching on coats, ladies' wear, shirts, etc.



#### Post-bed, 1-needle, Lockstitch, Basting Machine

# LT-591

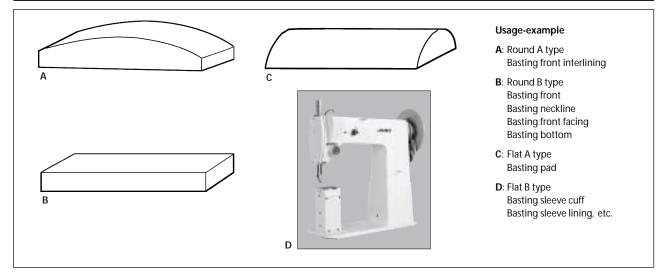
- In order to overcome the weakness of rapid consumption of the bobbin thread, the amount of wound bobbin thread is increased to over 5 times that of previous models. Thus, the bobbin thread changing time is more shortened than the previous models and naturally the production efficiency is greatly upped.
- As either a flat-bed type or a high wooden buck type auxiliary table can be used, the usage is very wide.
- When the treadle is stepped on, the machine starts and when the foot is released, the machine always stops at a required position.
   Therefore, the machine can be stopped at each stitch and thus, this is an ideal machine for basting of complicated process which demands accurate basting.



### SPECIFICATIONS

Model name	LT-591	
Max. sewing speed	600rpm	
Stitch length	Free	
Feed mechanism	Without feed mechanism (manual)	
Needle bar stroke	52.8mm	
Max. lift of the presser	By hand: 35mm	
Needle (at the time of delivery)	TV × 7 (#14)	
Hook	Vertical-axis large hook (dia. of bobbin: 37mm, amount of bobbin tread is over 5 times more than previous models)	
Operation system	Automatic stop system by pedal action	
Lubrication	By an oiler	
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	
Bed size	440mm × 178mm	
Weight of the machine head	53kg	

### KINDS OF HIGH WOODEN BUCK TABLE



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#### Compact-type, Computer-controlled Cycle Machine

# AMS-205C (electronic bartacking type) AMS-206C (electronic pattern sewing type)

- The machine is capable of running at a speed as high as 2,000rpm with the stitch length set at 3mm. Furthermore, jump speed has also been increased, thereby further enhancing productivity. Corresponding to the increased speed, durability and strength of the related components have been improved.
- Both the AMS-205C and -206C come equipped with a P-ROM that stores 12 types of bartackings as standard. The pattern enlarging/reducing feature enables the operator to enlarge/reduce the size of bartacks as required in accordance with the sewing product. The data memory capacity of the P-ROM is a maximum of 3,000 stitches, while a maximum of 32 patterns can also be stored in memory.
- The compact-sized AMS-205C/-206C have many different functions, including a speed-control function, a thread breakage detector, the capability to enlarge and reduce patterns, pattern cycle sewing, and 11 different error messages.



#### AMS-206CGL

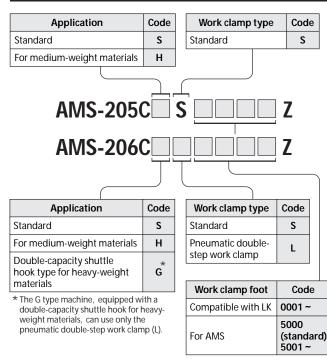
AMS-206C/PGM-5A

This is a computer-controlled cycle machine that is best-suited to sewing heavy-weight materials, including shoes, bags, seat belts, and sundry goods that are sewn with thread of #2 (B207, 10/3) to #30 (B46, 60/3).

The pressure to be applied onto the material by the pneumatic feeding frame (provided with a function to raise/lower the right and left frames independently) and that by the intermediate presser have been increased, which means that heavy materials can be securely clamped. At the same time, the heavy load applied by them prevents the material from flopping when using a thick needle.

Model name	AMS-205CS	AMS-205CH	AMS-206CS	AMS-206CH	AMS-206CGL	
Application	Standard	For medium-weight materials	Standard	For medium-weight materials	For heavy-weight materials	
Sewing area	40mm(L) × 50mm(W)					
Max. sewing speed		2,000rpm	(when stitch length is se	t to 3mm)		
Stitch length			0.2 ~ 6.2mm			
Needle bar stroke			41.2mm			
Lift of the feeding frame	Standard 12mr	n (max. 18mm)	Sta	andard 17mm (max. 18m	m)	
Intermediate presser				Provided as standard		
Lift of the intermediate presser				9.5mm		
Stroke of intermediate presser				6mm		
Needle (at the time of delivery)	DP × 5 (#14) For JE: 134 (Nm100)	DP × 17 (#18) For JE: 135 × 17 (Nm110)	DP × 5 (#14) For JE: 134 (Nm100)	DP × 17 (#18) For JE: 135 × 17 (Nm110)	DP × 17 (#23) For JE: SY3355 (Nm160)	
Thread	#60 ~ #30 B33 ~ B46 120/3 ~ 60/3	#50 ~ #8 B33 ~ B92 120/3 ~ 30/3	#60 ~ #30 B33 ~ B46 120/3 ~ 60/3	#50 ~ #8 B33 ~ B92 120/3 ~ 30/3	#30 ~ #2 B46 ~ B207 60/3 ~ 10/3	
Hook		La	arge-capacity shuttle hoo	ok	Double-capacity shuttle hook	
Memory medium			P-ROM			
Number of stitches that can be stored in memory			Max. 3,000 stitches			
Number of patterns that can be input			Max. 32 patterns			
Enlarging/Reducing facility		1 ~ 255% (1% step),	by increasing/decreasing	g of the stitch length		
Emergency stop switch				Provided as standard		
Bobbin thread counter			Provided as standard			
Compressed air and air consumption					0.55MPa(5.5kgf/cm²), 1.8N&/min	
Sewing machine motor		400W, 4P electro	onic-stop motor		550W, 2P electronic-stop motor	
Power consumption		Si	ngle-phase, 3-phase 1K\	/A		
Lubrication	Centralized oil wick lubrication					
Lubricating oil		JUKI New Defrix Oil No.2 (equivalent to ISO VG32)				
Total weight	120	lkg		125kg		
Dimensions	675mm (L) × 1,200mr	m (W) × 1,130mm (H)	705mm (	L) × 1,200mm (W) × 1,13	0mm (H)	

### WHEN YOU PLACE ORDERS



### SERVICE PATTERNS

Both the AMS-205C and AMS-206C come equipped with the P-ROM which stores 12 types of bartackings as standard.

No.	Stitch diagram	Number of stitches	Sewing area (mm)* (W) × (L)	Description		
1	······	42	16 × 2			
2	·····	36	16 × 2			
3	·~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~	28	16 × 2	Large bartacking		
4	******	56	16 × 2			
5	*******	36	8 <b>x</b> 2			
6	MAAAAAAA	28	8 <b>x</b> 2	Small bartacking		
7	₩₩₩₩	21	8 <b>x</b> 2			
8	terrorest contains sections without	28	14 <b>x</b> 0			
9		21	14 <b>x</b> 0	Linear bartacking		
10		36	16 <b>x</b> 0	1		
11	www.	28	8 <b>x</b> 2	Bartacking		
12	6444 <del>444</del> 4	21	8 × 2	for knitted fabric		

OPTIONS

Model	Description Feature			
PGM-5A	Handy programming device	Handy type of programming device provided with many different functions enable the operator to input data by operating the device near needle entries.		

Part No.	Description		Part No.	Descr	iption
B1601-210-000	Intermediate presser A $3.5 \times 5.5 \times$	@	B2553-206-0X0	Feeding frame assembly blank (without knurl)	
B1601-210-00B B1601-210-00C	Intermediate presser B $3.5 \times 5.5 \times$ Intermediate presser C $3.5 \times 10 \times$		B2553-206-0Y0	Feeding frame assembly blank (with knurl)	
B1601-210-00D	Intermediate presser D 2.2 × 3.6 ×	6 × 40.5		Feeding frame blank, right	
B1601-210-00E	Intermediate presser E 1.6 × 2.6 ×	: 6 × 40.5	B2572-206-0X0	(without knurl)	900 00 00 00 00 00 00 00 00 00 00 00 00
B1601-210-00G	Intermediate presser G 3 × 5 × 8 ×		B2572-206-0Y0	Feeding frame blank, right (with knurl)	
B1601-220-00G	Intermediate presser G 2.7 × 4.1 ×	:5×29.5 A× B×ℓ×L		Feeding frame blank, left	
B2426-210-00B	Needle hole guide B ( A= 2.0)		B2573-206-0X0	(without knurl)	
B2426-210-00C B2426-210-00D	Needle hole guide C ( $A= 1.6$ ) Needle hole guide D ( $A= 2.4$ )	A ++	B2573-206-0Y0	Feeding frame blank, left (with knurl)	
B2426-210-00F	Needle hole guide F ( $A = 3.0$ )		B2570-206-0A0	Right slide plate	A R
B2426-210-00G	Needle hole guide G ( A= 3.0)		B2571-206-0A0	Left slide plate	
B2551-205-000	Right work clamp foot		B2551-206-0A0	Slide plate assembly	
B2552-205-000	Left work clamp foot		D2331-200-0A0		
B2551-205-B00	Right work clamp foot for small bartacking	51 13	B2556-206-000	Feed plate	<b></b>
B2552-205-B00	Left work clamp foot for small bartacking		B2557-206-0A0	Large plastic feeding frame (asm.)	$\diamond$
B2551-205-C00	Right work clamp foot for	S S	B2587-210-000	Feeding frame material (A)	
	bartacking of knitted material		B2588-210-000	Feeding frame material (B)	
B2552-205-C00	Left work clamp foot for bartacking of knitted material		M1007-511-0A0	Foot switch fixed plate	
B2556-205-000	Feed plate		M8590-510-0A0	2 pedal	For both the AMS-205C and AMS-206C
B2556-205-B00	Feed plate for small bartacking	e	M8560-511-040	Foot switch (asm.)	
B2556-205-C00	Feed plate for bartacking of knitted material	<b>\$</b>		Manual pedal (asm.)	Exclusive to the AMS-206C
B2556-206-0X0	Feed plate blank (without knurl)	~ 3			Use with LK subclass
B2556-206-0Y0	Feed plate blank (with knurl)	• •	B2564-210-0A0	Auxiliary feed plate (asm.)	feed plate

AMS-205C, 206C (June, 2001) **2/2** Downloaded from <u>www.Manualslib.com</u> manuals search engine Computer-controlled Cycle Machine with an Input Function

## AMS-210D Sewing area: 60mm(L) × 130mm(W)

- With its newly designed thread take-up and shuttle hook, the machine reduces irregular stitches and provides consistent thread tension.
- The feeding frame and the intermediate presser have been improved to provide a higher pressure on the material. By securely clamping the material, they ensure consistent-quality seams free from uneven material feed.
- The sewing capability has been improved further, especially sewing heavy-weight materials with thick thread.
- High-speed performance of 2500rpm (when stitch length is set to 3mm)
- The lift of the feeding frame is now as high as 30mm (for pneumatic feeding frame), and the lift of the intermediate presser has also been extended to 20mm.

With these increased lifts, the material to be sewn can be easily placed on the machine.

• The machine incorporates a direct-drive mechanism that connects a compact AC servomotor directly to the main shaft. This transmits motor revolutions to the main shaft with no loss, thereby improves the machine's responsiveness.

# Computer-controlled Cycle Machine with an Input Function for Wider-area Perfect Stitching

## AMS-210D P TYPE Sewing area: 60mm(L) × 130mm(W)

- As a result of JUKI's thorough study of sewing performance, the area in which hitch stitches appears is reduced to one-third or less of the area produced with conventional cycle machines. Consequently, the sewing area finished with perfect stitches is enlarged, and the seam quality of top stitches is further upgraded.
- Since the feeding direction of the hitch stitching area is restricted to a range of 5° to 55°, each of the four different feeding directions (0°, 90°, 180° and 270°) used to sew the four sides of a rectangular label can be finished with perfect stitching.

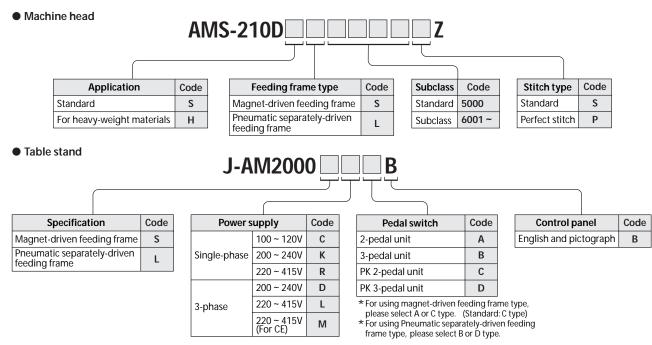


AMS-210D

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AMS-210D (P type)



WHEN YOU PLACE ORDERS

### SPECIFICATIONS

Madalasana	AMS	-210D	AMS-210D P TYPE					
Model name	AMS-210DS	AMS-210DH	AMS-210DS	AMS-210DH				
Application	Standard	For heavy-weight materials	Standard	For heavy-weight materials				
Sewing area	60mm (L) × 130 (W) mm							
Max. sewing speed	2,500rpm (when stitch length is set to 3mm) 2,300rpm (when stitch length is set to 4mm)							
Stitch length		0.1 ~ 1	2.7mm					
Needle bar stroke		41.2	mm					
Lift of the feeding frame		Max. 25mm, Pneu	matic: Max. 30mm					
Lift of the intermediate presser		Max. 2	20mm					
Stroke of intermediate presser		Standard 4mm (0.5 ~ 10mm)						
Needle (at the time of delivery)	DP × 5 (#14) For JE: 134 (Nm100)	DP × 17 (#18) For JE: 135 × 17 (Nm110)	DP × 5 (#14) For JE: 134 (Nm100)	DP × 17 (#18) For JE: 135 × 17 (Nm110)				
Thread	#80 ~ #20 B33 ~ B69 120/3 ~ 40/3	B33 ~ B69 B33 ~ B207 B33 ~ B46		#50 ~ #8 B33 ~ B92 120/3 ~ 30/3				
Hook	Double-capaci	ty shuttle hook	DP double-capa	acity shuttle hook				
Input function		Provided a	s standard					
Memory medium		2DD/2HD 3.5" m	nicro-floppy disk					
Number of stitches that can be stored in memory		Max. 360,000 stitches (ma	x. 20,000 stitches/pattern)					
Number of patterns that can be input		Max. 691 patterns (2D	D)/999 patterns (2HD)					
Enlarging/Reducing facility	1 ~ 400%	b (by increasing/decreasing the	stitch length or the number of	of stitches)				
Error detector function	Needle thread bre	eakage detector, temporary sto	pp (pause) switch, error code	indicating function				
Bobbin thread counter		Provided a	s standard					
Sewing machine motor		400W compact AC servor	notor (direct-drive system)					
Power consumption		Single-phase,	3-phase 600VA					
Lubrication		Auto	matic					
Lubricating oil		JUKI New Defrix Oil No.2	(equivalent to ISO VG32)					
Total weight		120	)kg					
Dimensions		710mm (L) × 1,200mr	m (W) × 1,200mm (H)					

### PROGRAMMING FUNCTIONS

- With its large memory, the machine responds to many different sewing patterns. Sewing settings can be established and sewing patterns programmed entirely through the operation panel.
- Ample storage capacity: maximum of 360,000 stitches on a floppy disk, or 691 patterns on a 2DD disk or 999 ones on a 2HD disk.
- A maximum of 20,000 stitches can be input per pattern. With this large storage capacity, the machine supports embroidery patterns with large numbers of stitches.
- A sewing pattern can be enlarged/reduced without changing the stitch length.
- Functions that are frequently used during pattern data input (regular stitching (linear, spline), point stitching, jumping, thread trimming, etc.) are allocated to specific keys on the operation panel. This reduces the time required for input of pattern data.



### OPTIONS

Model	Part No.	Description	Feature			
PGM-20		Programming software for computer controlled sewing machine	The PGM-20 is provided with many different input functions to permit interactive data creation, free from difficulties, using a general-purpose personal computer or digitizer.			
FU01S		Inverted clamp device for the magnet-driven feeding frame	The pneumatically driven inverted clamp device is best suited for the attachment of small parts of whose entire			
FU01L		Inverted clamp device for separately driven pneumatic feeding frame	peripheries need to be sewn such as labels and emblems.			
	B5019-222-0B0					
	PJ-0320525-03					
	PJ-0205000-02					
	B4717-223-C00					
	BT040-025-1EB	Thread tension controller No.3	The tension controller unit is used to partially change the needle thread tension during the sewing of a pattern.			
	BT060-040-1EB					
	B4712-215-0A0					
	SK-3312500-SE × 2					
	SS-6151812-TP					
	WP-0641601-SD × 5					
	B2120-215-0A0	Needle thread clamp device	This device prevents the thread from tangling at the start o			
	B4150-210-DA0	Junction cord	sewing.			
MU12		Milling unit	The milling unit can be installed on the machine to allow the operator to easily machine a feeding frame or feed plate.			
	B2593-210-DA0	Cassette holder fixing base (asm.)	The next material to be sewn can be placed between the top and bottom plates of the cassette holder while the			
	B2594-210-DA0	Cassette holder (asm.)	machine is still engaged in the sewing of the currently set material.			
	B2585-210-DB0	One-touch utility clamp for the magnet-driven feeding frame	The feeding frame and the feed plate can be quickly			
B2586-210-DB0		One-touch utility clamp for separately-driven pneumatic feeding frame	changed without any tools.			
	M8607-580-AA0	I/O expansion unit	The machine is provided with external input/output ports that are very convenient when re-modeling the machine with accessory devices attached.			

Part No.	Descrip	tion
B1601-210-D00A	Intermediate presser A $2.2 \times 3.6 \times 6 \times 29.5$	
B1601-210-D0BA	Intermediate presser B $2.7 \times 4.1 \times 6 \times 29.5$	
B1601-210-D0CA	Intermediate presser C $2.7 \times 5.5 \times 6 \times 29.5$	
B1601-210-D0E	Intermediate presser E $1.6 \times 2.6 \times 6 \times 29.5$	
B1601-210-D0FA	Intermediate presser F $2.2 \times 3.6 \times 9 \times 29.5$	A× B×Q×L [↑] →H <del>&lt;</del> B
B2553-210-D0A	Feeding frame blank (with knurl)	
B2553-210-D0B	Feeding frame blank (without knurl)	
B2554-210-D0A	Feeding frame blank (without knurl)	
B2554-210-D0B	Feeding frame blank, right (with knurl)	
B2554-210-D0C	Feeding frame blank, left (with knurl)	
B2556-210-D0A	Lower plate blank (with knurl)	
B2556-210-D0B	Lower plate blank (without knurl)	

Computer-controlled Cycle Machine with an Input Function for Topstitching Jean Pockets

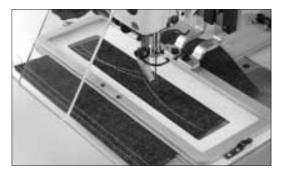
# AMS-210DHL6100SZ Sewing area: 60mm(L) × 220mm(W)

- Developed based on AMS-210D, the machine provides excellent sewing capabilities and operability, with an expanded sewing area is best suited for the "topstitching of hip pockets on jeans."
   * The AMS-210DHL6100SZ cannot be remodeled from the AMS-210D.
- The machine achieves a maximum sewing speed of 2,500rpm, substantially upgrading productivity(when the stitch length is equal to or shorter than 3mm). In addition, the machine inherits outstanding features of the AMS-210D such as one-touch calling of a sewing pattern, easier workpiece placement with the increased lift of the feeding frame, accurate workpiece positioning by the pneumatic monolithic feeding frame, and reduced bobbin-thread replacement with the newly adopted double-capacity shuttle hook.



AMS-210DHL6100SZ

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### SPECIFICATIONS

Model name	AMS-210DHL6100SZ			
Sewing area	60mm (L) × 220mm (W)			
Max. sewing speed	2,500rpm (when stitch length is set to 0.1 ~ 3.0mm) 2,300rpm (when stitch length is set to 3.1 ~ 3.8mm) 2,000rpm (when stitch length is set to 3.9 ~ 4.0mm)			
Stitch length	0.1 ~ 12.7mm			
Needle bar stroke	41.2mm			
Lift of the feeding frame	Standard 25mm (Max. 30mm)			
Lift of the intermediate presser	20mm			
Stroke of intermediate presser	Standard 4mm (0.5 ~ 10mm)			
Needle (at the time of delivery)	DP x 17 (#18), For JE: 135 x 17 (Nm110)			
Thread	#50 ~ #2, B33 ~ B207, Nm=120/3 ~ 10/3			
Hook	Double-capacity shuttle hook			
Memory medium	2DD/2HD 3.5" micro-floppy disk			
Number of stitches that can be stored in memory	Max. 360,000 stitches (max. 20,000 stitches/pattern)			
Number of patterns that can be input	Max. 691 patterns (2DD)/999 patterns (2HD)			
Enlarging/Reducing facility	$1 \sim 400\%$ (0.1% step), by increasing/decreasing the stitch length or the number of stitches			
Bobbin thread counter	Provided as standard			
Sewing machine motor	400W compact AC servomotor (direct-drive system)			
Power consumption	Single-phase, 3-phase 600VA			
Lubrication	Automatic			
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)			
Compressed air and air consumption	0.5 ~ 0.55MPa (5 ~ 5.5kgf/cm ² ), 1.8NØ/min			
Total weight	120kg			
Dimensions	710mm (L) × 1,200mm (W) × 1,200mm (H)			

Machine head Table stand **J-AM2000L** AMS-210DHL6100SZ В Power supply Code Pedal switch Code 100 ~ 120V С 2-pedal unit Α Single-phase 200~240V Κ PK 2-pedal unit С 220~415V R **Control panel** Code 200 ~ 240V D English and pictograph В 220~415V L 3-phase 220 ~ 415V (For CE) М

### **PROGRAMMING FUNCTIONS**

- With its large memory, the machine responds to many different sewing patterns. Sewing settings can be established and sewing patterns programmed entirely through the operation panel.
- Ample storage capacity: maximum of 360,000 stitches on a floppy disk, or 691 patterns on a 2DD disk or 999 ones on a 2HD disk.
- A maximum of 20,000 stitches can be input per pattern. With this large storage capacity, the machine supports embroidery patterns with large numbers of stitches.
- A sewing pattern can be enlarged/reduced without changing the stitch length.
- Functions that are frequently used during pattern data input (regular stitching (linear, spline), point stitching, jumping, thread trimming, etc.) are allocated to specific keys on the operation panel. This reduces the time required for input of pattern data.



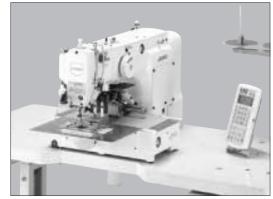
### OPTIONS

Model	Part No.	Description	Feature			
PGM-20		Programming software for computer controlled sewing machine	The PGM-20 is provided with many different input functions to permit interactive data creation, free from difficulties, using a general-purpose personal computer or digitizer.			
	B5019-222-0B0					
	PJ-0320525-03					
	PJ-0205000-02					
	B4717-223-C00					
	BT040-025-1EB	Thread tension controller No.3	The tension controller unit is used to partially change the			
	BT060-040-1EB		needle thread tension during the sewing of a pattern.			
	B4712-215-0A0					
	SK-3312500-SE × 2	1				
	SS-6151812-TP					
	WP-0641601-SD × 5					
	B4720-215-0B0	Needle cooler				
MU12		Milling unit	The milling unit can be installed on the machine to allow the operator to easily machine a feeding frame or feed plate.			
	B2585-210-DB0	One-touch utility clamp for the monolithic feeding frame	The feeding frame and the feed plate can be quickly			
	B2586-210-DB0	One-touch utility clamp for separately-driven pneumatic feeding frame	changed without any tools.			
	M8607-580-AA0	I/O expansion unit	The machine is provided with external input/output ports that are very convenient when re-modeling the machine with accessory devices attached.			

Computer-controlled Cycle Machine with an Input Function for Extra Heavy-weight materials

# AMS-210DHL6300SZ Sewing area: 60mm(L) × 130mm(W)

- Based on AMS-210D, the model that provides upgraded sewing capabilities and operability, AMS-210DHL6300 has been specifically developed as a computer-controlled cycle machine for seat belts. The machine has a sewing area of 60mm in length and 130mm in width, and is provided with a slide thread take-up lever that adequately tenses thick thread at all times, thereby ensuring the upgraded sewing capabilities required of a sewing machine for extra heavy-weight materials.
- With its maximum sewing speed of 2,000rpm (* at a stitch length of 4.0mm or less) and increased jump speed, the machine demonstrates higher productivity. The machine is provided with many different features to achieve increased productivity throughout the entire sewing work, including one-touch simple access to sewing patterns, accurate positioning of the material by a separately driven pneumatic feeding frame, easier placement of the material by an increased lift of the feeding frame (max. 30mm), and reduced frequency of bobbin-thread-replacement by adopting a double-capacity shuttle hook.
   * If the stitch length exceed 4.0mm, the machine will run at a speed equivalent to the standard sewing speed of the AMS-210D.
- The machine also provides helpful features for enhanced work comfort such as needle bar up-position-stop function to allow the needle bar to stop at its highest dead point and a direct-drive system that ensures outstanding responsiveness and reduced vibration and noise.



AMS-210DHL6300SZ

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### SPECIFICATIONS

Model name	AMS-210DHL6300SZ	
Sewing area	60mm (L) × 130mm (W)	
Max. sewing speed	2,000rpm (when stitch length is 4.0mm or less)	
Stitch length	0.1 ~ 12.7mm	
Needle bar stroke	41.2mm	
Lift of the feeding frame	Max. 30mm	
Lift of the intermediate presser	20mm	
Stroke of intermediate presser	Standard 4mm (0.5 ~ 10mm)	
Needle (at the time of delivery)	DP × 17 (#25)#22 ~ #26	
Hook	Double-capacity shuttle hook	
Treard take-up	Slide style	
Memory medium	2DD/2HD 3.5" micro-floppy disk	
Number of stitches that can be stored in memory	Max. 360,000 stitches (max. 20,000 stitches/pattern)	
Number of patterns that can be input	Max. 691 patterns (2DD)/999 patterns (2HD)	
Enlarging/Reducing facility	1 ~ 400% (0.1% step), by increasing/decreasing the stitch length or the number of stitches	
Bobbin thread counter	Provided as standard	
Sewing machine motor	400W compact AC servomotor (direct-drive type)	
Power consumption	Single-phase, 3-phase 600VA	
Lubrication	Automatic	
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)	
Compressed air and air consumption	0.5 ~ 0.55MPa (5 ~ 5.5kgf/cm²), 1.8NØ/min	
Total weight	120kg	
Dimensions	710mm (L) × 1,200mm (W) × 1,200mm (H)	

#### Machine head

• Table stand

AMS-210DHL6300SZ	J-AM2000				<b>B</b>				
	Power s	upply	Code		Pedal switch	Code	•		
		100 ~ 120V	С		3-pedal unit	В			
	Single-phase	200 ~ 240V	К		PK-47(3-pedal unit)	D			
		220 ~ 415V	R				_		
	3-phase	200 ~ 240V	D			Con	trol par	nel	Code
	3-priase	220 ~ 415V	L			English	and picto	ograph	В

### PROGRAMMING FUNCTIONS

- With its large memory, the machine responds to many different sewing patterns. Sewing settings can be established and sewing patterns programmed entirely through the operation panel.
- Ample storage capacity: maximum of 360,000 stitches on a floppy disk, or 691 patterns on a 2DD disk or 999 ones on a 2HD disk.
- A maximum of 20,000 stitches can be input per pattern. With this large storage capacity, the machine supports embroidery patterns with large numbers of stitches.
- A sewing pattern can be enlarged/reduced without changing the stitch length.
- Functions that are frequently used during pattern data input (regular stitching (linear, spline), point stitching, jumping, thread trimming, etc.) are allocated to specific keys on the operation panel. This reduces the time required for input of pattern data.



### OPTIONS

Model	Part No.	Description	Feature	
PGM-20		Programming software for computer controlled sewing machine	The PGM-20 is provided with many different input functions to permit interactive data creation, free from difficulties, using a general-purpose personal computer or digitizer.	
FU01L		Inverted clamp device for separately driven pneumatic feeding frame	The pneumatically driven inverted clamp device is best suited for the attachment of small parts of whose entire peripheries need to be sewn such as labels and emblems.	
	B5019-222-0B0			
	PJ-0320525-03			
	PJ-0205000-02			
	B4717-223-C00			
	BT040-025-1EB	Thread tension controller No.3	The tension controller unit is used to partially change the needle thread tension during the sewing of a pattern.	
	BT060-040-1EB			
	B4712-215-0A0			
	SK-3312500-SE × 2			
	SS-6151812-TP			
	WP-0641601-SD × 5			
	B4720-215-0B0	Needle cooler		
MU12		Milling unit	The milling unit can be installed on the machine to allow the operator to easily machine a feeding frame or feed plate	
	B2593-210-DA0	Cassette holder fixing base (asm.)	The next material to be sewn can be placed between the top and bottom plates of the cassette holder while the	
	B2594-210-DA0	Cassette holder (asm.)	machine is still engaged in the sewing of the currently set material.	
	B2585-210-DB0 One-touch utility clamp for the monolithic feeding frame		The feeding frame and the feed plate can be quickly	
	B2586-210-DB0	One-touch utility clamp for separately-driven pneumatic feeding frame	changed without any tools.	
	M8607-580-AA0	I/O expansion unit	The machine is provided with external input/output ports that are very convenient when re-modeling the machine with accessory devices attached.	

Computer-controlled Cycle Machine with an Input Function

# AMS-215D Sewing area: 110mm(L) × 220mm(W) AMS-221D Sewing area: 160mm(L) × 250mm(W)

- The machine runs at a sewing speed of 2,500rpm the highest speed achieved in a machine provided with only a medium-sized sewing area. Its jump speed and thread trimming speed are also extremely high, effectively doubling those of conventional machines. With its shortened cycle time, the machine dramatically increases productivity.
- With its direct-drive machine head (beltless) directly joined to a compact AC servomotor, the machine provides improved responsiveness and upgraded stop accuracy. Vibration and noise are reduced even during high-speed operation, thereby achieving a comfortable working environment.
- The machine is configured with JUKI's unique X Y feed mechanism built into the bed. Stabilized by the outstanding strength and rigidity of its feed mechanism, the machine promises the increased feed accuracy required to produce high-quality seams even in difficult sewing processes such as decorative pattern stitching.
- Since the X Y feed mechanism is built into the bed, the space under the arm is both increased and flattened. It allows the operator to place sewing products easily.

[Space under the arm] AMS-215D: Sewing area+253mm

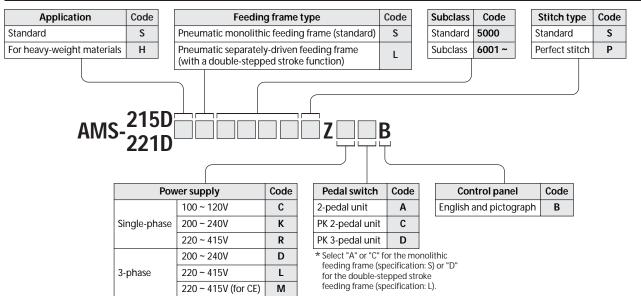
AMS-221D: Sewing area+246mm

Computer-controlled Cycle Machine with an Input Function for Wider-area Perfect Stitching

# AMS-215DP TYPESewing area: 110mm(L) × 220mm(W)AMS-221DP TYPESewing area: 160mm(L) × 250mm(W)

- As a result of JUKI's thorough study of sewing performance, the area in which hitch stitches appears is reduced to one-third or less of the area produced with conventional cycle machines. Consequently, the sewing area finished with perfect stitches is enlarged, and the seam quality of top stitches is further upgraded.
- Since the feeding direction of the hitch stitching area is restricted to a range of 5° to 55°, each of the four different feeding directions (0°, 90°, 180° and 270°) used to sew the four sides of a rectangular label can be finished with perfect stitching.









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AMS-221DSS

### SPECIFICATIONS

	AMS-	215D	AMS-215D	P TYPE	AMS-	221D	AMS-221D	AMS-221D P TYPE	
Model name	AMS-215DS	AMS-215DH	AMS-215DS	AMS-215DH	AMS-221DS	AMS-221DH	AMS-221DS	AMS-221DH	
Application	Standard	For heavy- weight materials	Standard	For heavy- weight materials	Standard	For heavy- weight materials	Standard	For heavy- weight materials	
Sewing area	110mm (L) × 220mm (W) 160mm (L) × 250mm (W)								
Max. sewing speed	2,500rpm (when stitch length is 3mm or less)								
Stitch length				0.1 ~ 1	2.7mm				
Needle bar stroke				41.2	mm				
Lift of the feeding frame				Standard 25mn	n (max. 30mm)				
Lift of the intermediate presser				20r	nm				
Stroke of intermediate presser				Standard 4mm	n (0.5 ~ 10mm)				
Needle (at the time of delivery)	DP × 5 (#14) For JE: 134 (Nm100)	DP × 17 (#18) For JE: 135 × 17 (Nm110)	DP × 5 (#14) For JE: 134 (Nm100)	DP × 17 (#18) For JE: 135 × 17 (Nm110)	DP × 5 (#14) For JE: 134 (Nm100)	DP × 17 (#18) For JE: 135 × 17 (Nm110)	DP × 5 (#14) For JE: 134 (Nm100)	DP × 17 (#18) For JE: 135 × 17 (Nm110)	
Thread	#80 ~ #20 B33 ~ B69 120/3 ~ 40/3	#50 ~ #2 B33 ~ B207 120/3 ~ 10/3	#60 ~ #30 B33 ~ B46 120/3 ~ 60/3	#50 ~ #8 B33 ~ B92 120/3 ~ 30/3	#80 ~ #20 B33 ~ B69 120/3 ~ 40/3	#50 ~ #2 B33 ~ B207 120/3 ~ 10/3	#60 ~ #30 B33 ~ B46 120/3 ~ 60/3	#50 ~ #8 B33 ~ B92 120/3 ~ 30/3	
Hook		capacity e hook	DP double-capacity Double-capacity DP double-capacit shuttle hook shuttle hook shuttle hook						
Memory medium			2	2DD/2HD 3.5" m	nicro-floppy dis	k			
Space under the arm		Sewing are	a + 253mm			Sewing are	a + 246mm		
Number of stitches that can be stored in memory	Max. 360,000 stitches(max. 20,000 stitches/pattern)								
Number of patterns that can be input			Max. 6	91 patterns (2D	D)/999 patterns	s (2HD)			
Enlarging/Reducing facility	1 ~ 400% (0.1% step), by increasing/decreasing the stitch length or the number of stitches								
Bobbin thread counter	Provided as standard								
Sewing machine motor	400W compact AC servomotor (direct-drive system)								
Power consumption	Single-phase, 3-phase 600VA								
Compressed air and air consumption	0.5 ~ 0.55MPa (5 ~ 5.5kgf/cm ² ), 1.8N@/min								
Lubrication				Autor	matic				
Lubricating oil			JUKI New	Defrix Oil No.2	(equivalent to l	SO VG32)			
Total weight				175	skg				
Dimensions	960m	m (L) × 1,200mi	m (W) × 1,200m	nm (H)	1,005n	nm (L) × 1,200m	nm (W) × 1,200r	mm (H)	

### PROGRAMMING FUNCTIONS

- With its large memory, the machine responds to many different sewing patterns. Sewing settings can be established and sewing patterns programmed entirely through the operation panel.
- Ample storage capacity: maximum of 360,000 stitches on a floppy disk, or 691 patterns on a 2DD disk or 999 ones on a 2HD disk.
- A maximum of 20,000 stitches can be input per pattern. With this large storage capacity, the machine supports embroidery patterns with large numbers of stitches.
- A sewing pattern can be enlarged/reduced without changing the stitch length.
- Functions that are frequently used during pattern data input (regular stitching (linear, spline), point stitching, jumping, thread trimming, etc.) are allocated to specific keys on the operation panel. This reduces the time required for input of pattern data.



### OPTIONS

Model	Part No.	Description	Feature		
PGM-20		Programming software for computer controlled sewing machine	The PGM-20 is provided with many different input functions to permit interactive data creation, free from difficulties, using a general-purpose personal computer or digitizer.		
FU03		Pneumatic inverted clamp device	The device is designed for installation on the machine provided with a double-stepped stroke feeding frame (specification: L).		
	B5019-222-0B0				
	PV-150209000				
	142-04754	Thread tension controller No.3	The tension controller unit is used to partially change the		
	PX-500014000	- Inread tension controller No.3	needle thread tension during the sewing of a pattern.		
	SS-6152212SP				
	WP-0612516SD × 2				
	B2120-215-0A0	Needle thread clamp device	This device prevents the thread from tangling at the start o sewing.		
	B4150-210-DA0	Junction cord			
	B4720-221-DB0	Needle cooler			
MU13		Milling unit (for AMS-215D)	The milling unit can be installed on the machine to allow the operator to easily machine a feeding frame or feed		
MU14		Milling unit (for AMS-221D)	plate.		
	B2581-221-DA0	Cassette holder fixing base (asm.)	The next material to be sewn can be placed between the top and bottom plates of the cassette holder while the		
	B2582-221-0A0	Cassette holder (asm.)	machine is still engaged in the sewing of the currently set material.		
	B2640-215-0B0				
	B2641-215-0A0 × 2	One-touch utility clamp	The feeding frame and the feed plate can be quickly changed without any tools.		
	SS-6150610SP × 4				
	M8607-580-AA0	I/O expansion unit	The machine is provided with external input/output ports that are very convenient when re-modeling the machine with accessory devices attached.		

Part No.	De	scription
B1601-210-D00A	Intermediate presser A $2.2 \times 3.6 \times 6 \times 29.5$	Mh7
B1601-210-D0BA	Intermediate presser B $2.7 \times 4.1 \times 6 \times 29.5$	
B1601-210-D0CA	Intermediate presser C $2.7 \times 5.5 \times 6 \times 29.5$	
B1601-210-D0E	Intermediate presser E $1.6 \times 2.6 \times 6 \times 29.5$	
B1601-210-D0FA	Intermediate presser F $2.2 \times 3.6 \times 9 \times 29.5$	A× B×ℓ×L [↑] →H <del>&lt;</del> B
B2587-220-000	Work clamp paper material (A)	
B2588-220-000	Work clamp paper material (B)	
B2595-220-00A	Presser cloth sheet	
B2595-220-00B	Presser cloth sheet B	
B2622-215-D00	Feeding frame blank, right (with knurl)	
B2623-215-D00	Feeding frame blank, left (with knurl)	AMS-215D
B2626-215-D00	Feeding frame blank (with knurl)	
B2622-221-000	Feeding frame blank, right (with knurl)	
B2623-221-000	Feeding frame blank, left (with knurl)	AMS-221D
B2626-221-000	2-step feeding frame blank	
B2620-215-D00	Feeding frame blank plate (with knurl)	AMS-215D
B2620-215-D00	Feeding frame blank plate (without knurl)	AIVIS-215D
B2620-221-000	Feeding frame blank plate (with knurl)	AMS-221D
B2621-221-000	Feeding frame blank plate	AMIS-221D
B2552-215-D0A	Lower plate blank (without knurl)	
B2552-215-D0B	Lower plate blank (with knurl)	AMS-215D
B2552-215-D0C	Lower plate blank (0.5mm)	
B2552-221-D0A	Lower plate blank (without knurl)	
B2552-221-D0B	Lower plate blank (with knurl)	AMS-221D
B2552-221-D0C	Lower plate blank (0.5mm)	

#### Computer-controlled Cycle Machine with an Input Function

# AMS-223C Sewing area: 200mm(L) × 300mm(W) AMS-224C Sewing area: 250mm(L) × 400mm(W)

- Best-suited for sewing processes to attach small parts onto shoes or bags, attach pockets onto garments, sew decorative stitches, etc.
- There is sufficient area under the arm (sewing area + free space 290mm (AMS-223C) or 240mm (AMS-224C)).
- The feeding frame can go up as high as 30mm, which means that a heavyweight material can be handled with ease.
- The feeding frame can also be manually lowered. This allows the operator to finely adjust the position of the material to be sewn.
- The machine is capable of sewing at a speed as high as 2,000rpm (when the stitch length is set to 3mm (AMS-223C) or 2.7mm (AMS-224C)).
- The machine is equipped with a large hook which reduces the frequency that the bobbin thread needs to be replaced.
- The machine ensures accurate stitching with a resolution as precise as 0.1mm.
- The newly-developed XY mechanism further improves strength and rigidity of the feed.
- Thread trimming mechanism ensures highly-improved reliability.

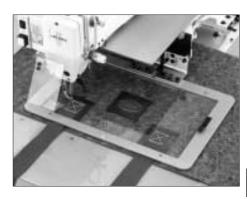
# Computer-controlled Cycle Machine with an Input Function for Wider Area Perfect Stitching

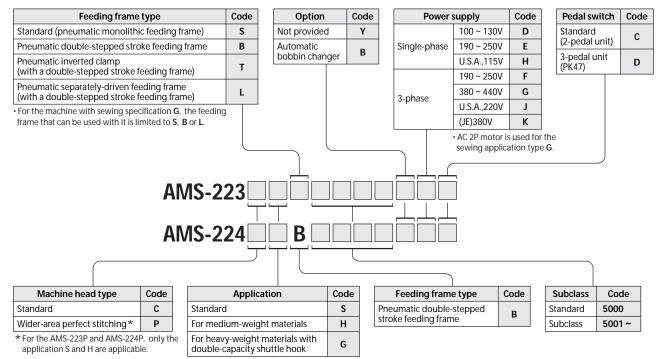
# AMS-223P Sewing area: 200mm(L) × 300mm(W) AMS-224P Sewing area: 250mm(L) × 400mm(W)

- As a result of JUKI's thorough study of sewing performance, the area in which hitch stitches appears is reduced to one-third or less of the area produced with conventional cycle machines. Consequently, the sewing area finished with perfect stitches is enlarged, and the seam quality of top stitches is further upgraded.
- Since the feeding direction of the hitch stitching area is restricted to a range of 5° to 55°, each of the four different feeding directions (0°, 90°, 180° and 270°) used to sew the four sides of a rectangular label can be finished with perfect stitching.



AMS-223C





### WHEN YOU PLACE ORDERS

### SPECIFICATIONS

SILOIIIOAIIONS							
Model name	AMS-223CS	AMS-223CH	AMS-223CG	AMS-223PS	AMS-223PH		
Application	Standard	For medium-weight materials	For heavy-weight materials	Standard	For medium-weight materials		
Sewing area	200mm (L) × 300mm (W)						
Max. sewing speed	2,000rpm (when stitch length is set to 3mm)						
Stitch length	0.1 ~ 12.7mm						
Needle bar stroke	41.2mm						
Lift of the feeding frame		Si	tandard 25mm (max. 30mm)	1			
Lift of the intermediate presser			20mm				
Stroke of intermediate presser		5	Standard 4mm (0.3 ~ 7mm)				
Needle (at the time of delivery)	DP × 5 (#14) For JE: 134 (Nm100)	DP × 17 (#18) For JE: 135 × 17 (Nm110)	DP × 17 (#23) For JE: SY3355 (Nm160)	DP × 5 (#14) For JE: 134 (Nm100)	DP × 17 (#18) For JE: 135 × 17 (Nm110)		
Thread	#60 ~ #30 B33 ~ B46	#50 ~ #8 B33 ~ B92	#8 ~ #2 B92 ~ B207	#60 ~ #30 B33 ~ B46	#50 ~ #8 B33 ~ B92		
Input function	120/3 ~ 60/3	120/3 ~ 30/3 Provided as stand	120/3 ~ 10/3 lard (can also be connected	120/3 ~ 60/3 to the PGM-5A)	120/3 ~ 30/3		
Hook	Large-capacity	shuttle hook	Double-capacity shuttle hook	DP large-capa	city shuttle hook		
Memory medium			2DD/3.5"micro-floppy disk				
Free space under the arm			Sewing area + 290mm				
Number of stitches that can		May 17/00	5	oc/pattorn)			
be stored in memory Number of patterns that		IVIAX. 176,00	0 stitches (max. 4,000 stitche	es/pattern)			
can be input	0.1 - 10	00% (0.1%  stop) by increase	Max. 691 patterns	angth or the number of	fatitabas		
Enlarging/Reducing facility Bobbin thread counter	0.1~40	o o (u. 1% step), by increa	nsing/decreasing the stitch le Provided as standard	engun or the number of	1 311101183		
Compressed air and		0.55	5MPa (5.5kgf/cm ² ), 1.8NQ/m	in			
air consumption	400W		550W, 2P		DW, 4P		
Sewing machine motor Power consumption	electronic-s		electronic-stop motor Single-phase, 3-phase 1KVA	electronic	c-stop motor		
ubrication			Automatic				
ubricating oil		JUKI New D	efrix Oil No.2 (equivalent to	ISO VG32)			
Neight	290kg						
Dimensions		1,190mn	n (L) × 1,230mm (W) × 1,285	mm (H)			
Model name	AMS-224CS	AMS-224CH	AMS-224CG	AMS-224PS	AMS-224PH		
Application	Standard	For medium-weight materials	For heavy-weight materials	Standard	For medium-weight		
Sewing area			250mm (L) × 400mm (W)				
Max. sewing speed		2,000rpm	(when stitch length is set to	2.7mm)			
Stitch length	0.1 ~ 12.7mm						
			41.2mm				
Needle bar stroke							
Needle bar stroke Lift of the feeding frame		Si	41.2mm tandard 25mm (max. 30mm)	)			
Needle bar stroke Lift of the feeding frame Lift of the intermediate		St		)			
Needle bar stroke Lift of the feeding frame Lift of the intermediate presser Stroke of intermediate presser			tandard 25mm (max. 30mm)				
Needle bar stroke Lift of the feeding frame Lift of the intermediate presser Stroke of intermediate	DP x 5 (#14) For JE: 134 (Nm100)		tandard 25mm (max. 30mm) 20mm	DP × 5 (#14) For JE: 134 (Nm100)	DP x 17 (#18) For JE: 135 x 17 (Nm110)		
Needle bar stroke Lift of the feeding frame Lift of the intermediate presser Stroke of intermediate presser Needle (at the time of delivery)	For JE: 134	DP × 17 (#18) For JE: 135 × 17	tandard 25mm (max. 30mm) 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355	DP × 5 (#14) For JE: 134	For JE: 135 × 17		
Veedle bar stroke Lift of the feeding frame Lift of the intermediate presser Stroke of intermediate presser Veedle (at the time of delivery)	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3	tandard 25mm (max. 30mm) 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207	DP × 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3	For JE: 135 × 17 (Nm110) #50 ~ #8 B33 ~ B92		
Needle bar stroke Lift of the feeding frame Lift of the intermediate presser Stroke of intermediate presser Needle (at the time of delivery) Thread	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46	DP × 17 (#18) For JE: 135 × 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stanc	tandard 25mm (max. 30mm) 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3	DP × 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A)	For JE: 135 × 17 (Nm110) #50 ~ #8 B33 ~ B92		
Veedle bar stroke Lift of the feeding frame Lift of the intermediate oresser Stroke of intermediate oresser Veedle Vat the time of delivery) Fhread nput function Hook	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stanc	andard 25mm (max. 30mm) 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 dard (can also be connected Double-capacity	DP × 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A)	For JE: 135 × 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3		
Veedle bar stroke ift of the feeding frame ift of the intermediate oresser Stroke of intermediate oresser Veedle at the time of delivery) Thread nput function Hook Memory medium	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stanc	20mm 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 dard (can also be connected Double-capacity shuttle hook	DP × 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A)	For JE: 135 × 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3		
Veedle bar stroke Lift of the feeding frame Lift of the intermediate oresser Stroke of intermediate oresser Veedle at the time of delivery) Thread Input function Hook Vemory medium Free space under the arm Vumber of stitches that can	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stand	tandard 25mm (max. 30mm) 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 dard (can also be connected Double-capacity shuttle hook 2DD/3.5" micro-floppy disk Sewing area + 240mm	DP × 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A) DP large-capa	For JE: 135 × 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3		
Veedle bar stroke ift of the feeding frame ift of the intermediate oresser Stroke of intermediate oresser Veedle (at the time of delivery) Fhread nput function Hook Vemory medium Free space under the arm Number of stitches that can be stored in memory Number of patterns that	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stand	andard 25mm (max. 30mm) 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 lard (can also be connected Double-capacity shuttle hook 2DD/3.5" micro-floppy disk Sewing area + 240mm 0 stitches (max. 4,000 stitche	DP × 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A) DP large-capa	For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3		
Veedle bar stroke Lift of the feeding frame Lift of the intermediate oresser Stroke of intermediate oresser Veedle at the time of delivery) Thread Input function Hook Memory medium Free space under the arm Number of stitches that can be stored in memory Number of patterns that can be input	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 Large-capacity	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stand shuttle hook Max. 176,00	tandard 25mm (max. 30mm) 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 tard (can also be connected Double-capacity shuttle hook 2DD/3.5" micro-floppy disk Sewing area + 240mm 0 stitches (max. 4,000 stitche Max. 691 patterns	DP × 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A) DP large-capa	For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 city shuttle hook		
Veedle bar stroke ift of the feeding frame ift of the intermediate oresser Stroke of intermediate oresser Veedle (at the time of delivery) Fhread nput function Hook Vemory medium Free space under the arm Number of stitches that can be stored in memory Number of patterns that can be input Enlarging/Reducing facility	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 Large-capacity	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stand shuttle hook Max. 176,00	tandard 25mm (max. 30mm) 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 tard (can also be connected Double-capacity shuttle hook 2DD/3.5" micro-floppy disk Sewing area + 240mm 0 stitches (max. 4,000 stitche Max. 691 patterns tising/decreasing the stitch left	DP × 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A) DP large-capa	For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 city shuttle hook		
Needle bar stroke         Lift of the feeding frame         Lift of the intermediate         presser         Stroke of intermediate         presser         Needle         (at the time of delivery)         Thread         Input function         Hook         Memory medium         Free space under the arm         Number of stitches that can be stored in memory         Number of patterns that         can be input         Enlarging/Reducing facility         Bobbin thread counter         Compressed air and	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 Large-capacity	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stand shuttle hook Max. 176,00	tandard 25mm (max. 30mm) 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 tard (can also be connected Double-capacity shuttle hook 2DD/3.5" micro-floppy disk Sewing area + 240mm 0 stitches (max. 4,000 stitche Max. 691 patterns	DP x 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A) DP large-capa es/pattern)	For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 city shuttle hook		
Needle bar stroke Lift of the feeding frame Lift of the intermediate presser Stroke of intermediate presser Needle (at the time of delivery) Thread Input function Hook Memory medium Free space under the arm Number of stitches that can be stored in memory Number of patterns that can be input Enlarging/Reducing facility Bobbin thread counter Compressed air and air consumption	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 Large-capacity 0.1 ~ 40	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stand shuttle hook Max. 176,00 00% (0.1% step), by increa 0.55	20mm 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 lard (can also be connected Double-capacity shuttle hook 2DD/3.5" micro-floppy disk Sewing area + 240mm 0 stitches (max. 4,000 stitche Max. 691 patterns sing/decreasing the stitch le Provided as standard 5MPa (5.5kgf/cm ² ), 1.8N0/m	DP x 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A) DP large-capa es/pattern) ength or the number of in	For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 city shuttle hook		
Needle bar stroke Lift of the feeding frame Lift of the intermediate presser Stroke of intermediate presser Needle (at the time of delivery) Thread Input function Hook Memory medium Free space under the arm Number of stitches that can be stored in memory Number of patterns that can be input Enlarging/Reducing facility Bobbin thread counter Compressed air and air consumption Sewing machine motor	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 Large-capacity 0.1 ~ 40	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stance shuttle hook Max. 176,00 00% (0.1% step), by increas 0.55 0.55	20mm 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 lard (can also be connected Double-capacity shuttle hook 2DD/3.5" micro-floppy disk Sewing area + 240mm 0 stitches (max. 4,000 stitche Max. 691 patterns sising/decreasing the stitch le Provided as standard 550W, 2P electronic-stop motor	DP x 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A) DP large-capa es/pattern) ength or the number of in	For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 city shuttle hook		
Needle bar stroke Lift of the feeding frame Lift of the intermediate presser Stroke of intermediate presser Needle (at the time of delivery) Thread Input function Hook Memory medium Free space under the arm Number of stitches that can be stored in memory Number of patterns that can be input Enlarging/Reducing facility Bobbin thread counter Compressed air and air consumption Sewing machine motor Power consumption	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 Large-capacity 0.1 ~ 40	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stance shuttle hook Max. 176,00 00% (0.1% step), by increas 0.55 0.55	20mm 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 lard (can also be connected Double-capacity shuttle hook 2DD/3.5" micro-floppy disk Sewing area + 240mm 0 stitches (max. 4,000 stitche Max. 691 patterns sising/decreasing the stitch le Provided as standard 550W, 2P electronic-stop motor Single-phase, 3-phase 1KVA	DP x 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A) DP large-capa es/pattern) ength or the number of in	For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 city shuttle hook f stitches		
Needle bar stroke         Lift of the feeding frame         Lift of the intermediate         presser         Stroke of intermediate         presser         Needle         (at the time of delivery)         Thread         Input function         Hook         Memory medium         Free space under the arm         Number of stitches that can be stored in memory         Number of patterns that can be stored in thread counter         Compressed air and air consumption         Sewing machine motor         Power consumption         Lubrication	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 Large-capacity 0.1 ~ 40	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stand shuttle hook Max. 176,00 00% (0.1% step), by increa 0.5! /, 4P top motor	20mm 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 lard (can also be connected Double-capacity shuttle hook 2DD/3.5" micro-floppy disk Sewing area + 240mm 0 stitches (max. 4,000 stitche Max. 691 patterns sising/decreasing the stitch le Provided as standard 550W, 2P electronic-stop motor	DP x 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A) DP large-capa es/pattern) ength or the number of in 400 electronic	For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 city shuttle hook		
Needle bar stroke Lift of the feeding frame Lift of the intermediate presser Stroke of intermediate presser Needle	For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 Large-capacity 0.1 ~ 40	DP x 17 (#18) For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 Provided as stand shuttle hook Max. 176,00 00% (0.1% step), by increa 0.5! /, 4P top motor	tandard 25mm (max. 30mm) 20mm Standard 4mm (0.3 ~ 7mm) DP × 17 (#23) For JE: SY3355 (Nm160) #8 ~ #2 B92 ~ B207 120/3 ~ 10/3 lard (can also be connected Double-capacity shuttle hook 2DD/3.5" micro-floppy disk Sewing area + 240mm 0 stitches (max. 4,000 stitche Max. 691 patterns asing/decreasing the stitch le Provided as standard 5MPa (5.5kgf/cm ² ), 1.8N0/m 550W, 2P electronic-stop motor Single-phase, 3-phase 1KVA Automatic	DP x 5 (#14) For JE: 134 (Nm100) #60 ~ #30 B33 ~ B46 120/3 ~ 60/3 to the PGM-5A) DP large-capa es/pattern) ength or the number of in 400 electronic	For JE: 135 x 17 (Nm110) #50 ~ #8 B33 ~ B92 120/3 ~ 30/3 city shuttle hook		

AMS-223C, 224C, 223P, 224P (June, 2001) **2/4** Downloaded from <u>www.Manualslib.com</u> manuals search engine

### OPTIONS

Model	Part No.	Description		Feature		
PGM-5A		Handy programming device		Handy type of programming device provided with many different functions enable the operator to input data by operating the device near needle entries.		
	B5019-222-0B0					
	PV-150209000					
	142-04754	Thread tension controller No.3		The tension controller unit is used to partially change the		
	PX-5000014000	Thread tension controller No.5		needle thread tension during the sewing of a pattern.		
	SS-6152212SP	_				
	WP-0612516SD × 2	1				
	B2120-215-0A0	Needle thread clamp device		This device prevents the thread from tangling at the start of		
	B4150-210-DA0	Junction cord		sewing.		
	B4720-215-DB0	Needle cooler		The needle cooler blows air to the needle, thereby preventing thread breakage caused by hot needle.		
MU08		Milling unit	AMS-223	The milling unit can be installed on the machine to allow the		
MU11		Milling unit	AMS-224	operator to easily machine a feeding frame or feed plate.		
	B2581-223-CA0	Cassette holder fixing base (asm.)	AMS-223			
	B2582-223-CA0	Cassette holder (asm.)	AIVIS-223	The next material to be sewn can be placed between the top and bottom plates of the cassette holder while the machine		
	B2581-224-CA0	Cassette holder fixing base (asm.)		is still engaged in the sewing of the currently set material.		
	B2582-224-CA0	Cassette holder (asm.)	AMS-224			
	B2640-215-0B0					
	B2641-215-0A0 × 2	One-touch utility clamp		The feeding frame and the feed plate can be quickly changed without any tools.		
	SS-6150610SP × 4			without any tools.		

Part No.		D	escription		
B1601-220-000	Intermediate presser A $2.2 \times 3.6 \times 6 \times 29.5$	ล		a	0
B1601-220-00B	Intermediate presser B $3.5 \times 5.5 \times 6 \times 29.5$	U			
B1601-220-00C	Intermediate presser C $2.2 \times 3.6 \times 12 \times 6 \times 29.5$	] [[			A L
B1601-220-00D	Intermediate presser D 2.2 x 12 x 34.5				B
B1601-220-00E	Intermediate presser E 1.6 × 2.6 × 6 × 29.5	] *	_U ▶H∢ B	0	
B1601-220-00F	Intermediate presser F $2.2 \times 3.6 \times 9 \times 29.5$			∳ <del>&gt;⊢&lt;</del> B	
B1601-220-00G	Intermediate presser G 2.7 × 4.1 × 5 × 29.5		B×ℓ×L	A× B× C×ℓ×L	A× B×L
B1601-220-0A0	Intermediate foot (asm) $2.2 \times 10 \times 6 \times 29.5$	A, B, E,	F and G type	C type	D type
B2587-220-000	Work clamp paper material (A)				
B2588-220-000	Work clamp paper material (B)			~	
B2595-220-00A	Presser cloth sheet (t=1mm)			$\sim$	
B2595-220-00B	Presser cloth sheet B (t=3mm)			~	
B2595-220-00B	Presser cloth sheet (t=2mm)				
B2622-223-C00	Feeding frame blank, right (with knurl)			$\sim$ $\sim$	
B2623-223-C00	Feeding frame blank, left (with knurl)			$\langle \rangle \langle \rangle$	
B2626-223-C00	2-step feeding frame blank (without knurl)			~ ~	
B2620-223-C00	Feeding frame blank plate (with knurl)				
B2621-223-C00	Feeding frame blank plate (without knurl)				
B2556-223-C0B	Lower plate blank (without knurl)				
B2556-223-COC	Lower plate blank (with knurl)	AMS-223		$\sim \sim \sim$	
B2556-223-C0D	Lower plate blank (0.5mm, without knurl)			$\sim$	
B2556-224-C0A	Lower plate blank (without knurl)	AMS-224		-	
B2426-210-00A	Needle hole guide A ( A = 1.6)				
B2426-210-00B	Needle hole guide B ( A = 2.0)			٨	
B2426-210-00C	Needle hole guide C ( A = 1.6)			$\rightarrow \frac{A}{k}$	
B2426-210-00D	Needle hole guide D ( $A = 2.4$ )			(H)	
B2426-210-00F	Needle hole guide F ( $A = 3.0$ )	]			
B2426-210-00G	Needle hole guide G ( A = 3.0)				
B2426-210-00H	Needle hole guide H ( A = 3.0)				

### CONTROL PANEL

- The operator can easily create a sewing pattern on the spot by inputting sewing pattern data through the control panel according to a sewing sample or the feeding frame.
- The control panel is very helpful to the operator to input pattern data, to operate the sewing machine and to use the milling unit.
- As many as 176,000 stitches or 691 patterns can be stored in memory.
- As many as 4,000 stitches can be input for one sewing pattern.
   If the combination mode is used, as many as 20,000 stitches can be input for a pattern.

Automatic Bobbin Changer for AMS

### **BK SERIES** BK-2: AMS-223C, AMS-224C BK-5: AMS-223P, AMS-224P

- All you need to do is set a magazine packed with bobbin cases onto the main unit of the AMS. The machine will automatically replace the bobbin thread whenever necessary (complete replacement only takes five seconds). One magazine can store a maximum of ten bobbin cases.
- The magazine can be easily attached/removed without any tools. This device is designed for attaching on the existing machine. Consequently, BK-series can be attached to your AMS in use with ease.
- Bobbin replacement time can be set using the bobbin counter on the operation panel. The bobbin can also be replaced manually.
- The main unit of the device does not require compressed air for operation. The electrical circuit board is installed inside the control box of the AMS. Therefore the device can be smoothly installed on the machine, and only a small space is required for the installation.

### SPECIFICATIONS

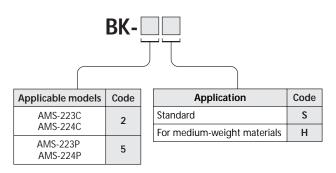
Number of bobbins that can be set in a magazine	Max. 10 pcs.	
Period of time required to replace a bobbin	Approx. 5 sec.	
Power supply	Can be connected through the main unit of AMS	





AMS-223C/BK2

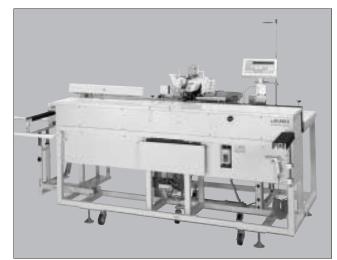
### WHEN YOU PLACE ORDERS



#### High-speed, Computer-controlled, Dry-head, Single-thread Chainstitch, Button Sewing Indexer

# ACF-164-1800

- The machine is equipped with a computer-controlled singlethread chainstitch button sewing machine.
   Adoption of a no lubricated machine head eliminates oil stains on sewing products. No oiling is required.
- Thanks to its computer-controlled feed, the machine now offers 39 different sewing patterns as standard.
   The machine responds to many different sewing specifications with greater ease end flexibility.
- Since the machine does not have a stop-motion mechanism, it requires no maintenance and offers a quiet work environment.
- The machine is provided as standard with a sewing thread tension change-over type "thread-fray-prevention function" to improve seam quality.
- The machine incorporates a high-speed machine head that offers a maximum sewing speed of 1,800rpm and a button feeder with higher button-supplying capacity for increased productivity.
- The stepping motor controls the material feed in increments of 0.1mm to ensure accurate button sewing at all times.
- One to 20 buttons can be sewn on every garment. Twenty patterns can be stored in memory.
- The machine can sew buttons on ladies' wear by changing the operation mode. In addition, with the use of optional attachments, it can also sew buttons on finished garments and long-sized garment.



ACF-164-1800



### SPECIFICATIONS

Model name	ACF-164-1800		
Machine head	MB-1800D/BR12		
Stitch system	Single-thread, chainstitch		
Sewing speed	Max. 1,800rpm		
Applicable button	Type: Flat round button         Size:       9 ~ 26mm         * Buttons with diameters smaller than 10mm or larger than 16mm are available by special order.		
Stitching shape	$\begin{array}{c} \hline \hline , \hline , \hline , \lor , \lor , \lor , \swarrow , \swarrow , \land \neg , 1  I, - , 1 \\ \hline \bigtriangleup , \bigtriangledown , \checkmark , \diamondsuit , \triangleright \\ (Button carrier for 3-holed buttons is available by special order.) \end{array}$		
Needle (at the time of delivery)	TQ × 7 (#16) #14 ~ #20		
Number of button to be sewn	1 ~ 20pcs.		
Number of patterns that can be stored in memory	20 patterns		
Power requirement/ Power consumption	Single-, 3-phase 200V/Power rating 600VA		
Compressed air	0.5MPa (5kgf/cm ² )		
Air consumption	20NQ/min		
Lubrication	No lubrication (machine head installed)		
Dimensions	1,860mm(W) × 970mm(D) × 920mm(H)		
Total weight	260kg		

### WHEN YOU PLACE ORDERS

ACF-164-1800					
	Power su	upply	Code		
For General	Single- phase	220V	D		
Export	3-phase	200V, 220V, 240V	Q		
For CE	3-phase	380V	L		

Options	Code
Not provided	Z
Second work clamp	В
Cloth suction device (MC16)	E
Second work clamp + Cloth suction device (MC16)	BE
· · · · ·	

* Other options are separately available.

### APPLICATIONS SIZE OF CLOTH

	A	Feeding intervals	25 ~ 650mm (0.1mm steps) *	
F	В	Total feeding amount	Standard: 650mm (optional size: Max. 1,200mm)	
	С	Distance from the top end of the garment body to the first button	Standard: 40 ~ 140mm (optional size: Min. 20mm)	
	A Dista	Distance from the side end of the garment body to the button	12 ~ 25mm	
	E	Applicable size of the germont to be solve	Width: 220 ~ 420mm	
	$\frac{1}{E}$ Applicable size of the garment to be sewn		Length: 400 ~ 880mm	
* Button intervals can be respectively				

espectively changed as desired

# **BUTTON CARRIER**

Configuration of button carrier							
For 4-holed button				For 2-holed button			
Distance A(mm): Distance between holes in button	Distance B(mm): Diameter of set pin	Part No.	Code	Distance A(mm): Distance between holes in button	Distance B(mm): Diameter of set pin	Part No.	Code
	Standard			Standard (	Packed together with	accessories.)	
2.6	1.0	165-57902	Α	3.2	1.2	165-58009	В
			Opti	tional			
2.0	1.0	165-90507	Q	2.0	1.0	165-87305	Е
2.2	1.0	165-90606	R	2.2	1.0	165-87404	F
2.4	1.0	165-88501	S	2.4	1.0	165-87503	G
2.4	1.2	165-88600	Т	2.4	1.2	165-87909	L
2.6	1.2	165-88709	U	2.6	1.0	165-87602	Н
2.8	1.2	165-88808	V	2.6	1.2	165-88006	М
3.0	1.2	165-88907	W	2.8	1.0	165-87701	J
3.0	1.5	165-89806	F1	2.8	1.2	165-88105	Ν
3.1	1.0	165-87206	D	3.0	1.0	165-87800	К
3.1	1.2	165-89004	Х	3.0	1.2	165-88204	Р
3.1	1.4	165-89202	Z	3.8	1.2	165-87107	С
3.2	Taper	165-89905	G1				
3.6	1.2	165-90705	H1	2.8 *	1.0	182-13603	J1
4.0	1.2	165-89707	E1				

# OPTIONS

* For vertical 2-hole buttons ** For 3-holed buttons is available by special order.

Model	Part No.	Description	Feature		
	G5510-164-0A0	Auxiliary feed plate	This part feeds heavy sewing products such as finished garments with great reliability.		
	G5508-164-0A0	Clamp for light-weight materials	This part clamps easy-to-slack materials such as light cottons and silks to ensure reliable feeding.		
	G5501-164-0A0	Auxiliary clamp	The auxiliary clamp prevents long-sized sewing products from slacking in the direction of feed.		
	G5509-164-000	Auxiliary clamp for the 1st button with shorter distance	This clamp is used when there is only a short distance between the top of the garment body and the first button (40mm or less). (Applicable distance: 20 to 140mm)		
	G5514-164-0A0	Second work clamp*	This part is effective when sewing slippery materials. It clamps the stacked materials at all times.		
MC16		Cloth suction device*	The cloth suction device consistently feeds front facings that are not pressed, that are not topstitched, or that have a crease.		

ACF-164-1800 (June, 2001) 2/2 Downloaded from <u>www.Manualslib.com</u> manuals search engine

* Specify at the time of order where necessary.

Computer-controlled, Lockstitch, Button Sewing Indexer

# ACF-164-1903

**SPECIFICATIONS** 

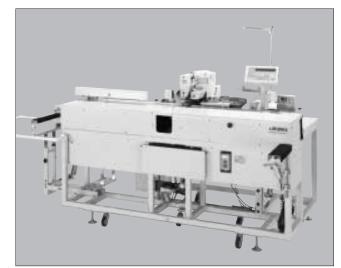
- The machine incorporates a high-speed machine head that offers a maximum sewing speed of 2,300rpm and a button feeder with higher button-supplying capacity for increased productivity.
- The machine can sew buttons on ladies' wear by changing the operation mode. In addition, with the optional attachments, it can also sew buttons on finished garments and long-sized garment.

Various options are available to further improve workability.

• Since the machine does not have a stop-motion mechanism, it requires no maintenance and offers a quiet work environment.

Fastening stitches at the end of sewing ensures upgraded seam quality while preventing the thread from fraying. The machine is provided as standard with 29 different sewing patterns. This allows the machine to easily respond to many different sewing specifications.

 The stepping motor controls the material feed in increments of 0.1mm to ensure accurate button sewing at all times.
 One to 20 buttons can be sewn on every garment.
 Twenty patterns can be stored in memory.
 The machine is equipped as standard with a stacker that can accurately stack a great many garments.



ACF-164-1903

Model name	ACF-164-1903		
Machine head	LK-1903/BR26		
Stitch system	Lockstitch		
Max. sewing speed	2,300rpm (normal: 2,000rpm)		
Needle (at the time of delivery)	DP x 17 (#14)		
Number of button to be sewn	1 ~ 20pcs.		
Number of patterns that can be stored in memory	20 patterns		
Lubrication	Centralized oil wick lubrication (machine head)		
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)		
Power consumption	600VA		
Compressed air	0.5MPa (5kgf/cm ² )		
Air consumption	20N&/min		
Dimensions	1,860mm (W) x 970mm (D) x 920mm (H)		
Total weight	270kg		

### WHEN YOU PLACE ORDERS

A	CF-16	94-1903		
Po	ower suppl	ly	Code	Optior
	Single-	220V	D	Not provide
For General Export	phase	240V	E	Cloth suction
		200V, 220V, 240V	Q	device (MC
	3-phase	380V, 415V, 440V	Т	* Other optio
For North America		220V	К	
For CE	3-phase	380V	L	
		415V	М	]

Option	Code	
Not provided	Z	
Cloth suction device (MC16)*	E	

* Other options are separately available.

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### APPLICATIONS SIZE OF CLOTH

	A	Feeding intervals	25 ~ 650mm (0.1mm steps) *
	В	Total feeding amount	Standard: 650mm (optional size: Max. 1,200mm)
F O A B C		Distance from the top end of the garment body to the first button	Standard: 40 ~ 140mm (optional size: Min. 20mm)
	D	Distance from the side end of the garment body to the button	12 ~ 25mm
	E	Applicable size of the germont to be solve	Width: 220 ~ 420mm
$\begin{array}{c c} \downarrow & \downarrow \\ \hline F \\ F \\$		Length: 400 ~ 880mm	
			* Button intervals can be respectively

* Button intervals can be respectively changed as desired

# **BUTTON CARRIER**

	Configuration of button carrier						
For 4-holed button				For 2-holed buttor	า		
				2			
Distance A(mm): Distance between holes in button	Distance B(mm): Diameter of set pin	Part No.	Code	Distance A(mm): Distance between holes in button	Distance B(mm): Diameter of set pin	Part No.	Code
	Standard			Standard (	Packed together with	accessories.)	
2.6	1.0	165-57902	Α	3.2	1.2	165-58009	В
			Opti	onal			
2.0	1.0	165-90507	Q	2.0	1.0	165-87305	E
2.2	1.0	165-90606	R	2.2	1.0	165-87404	F
2.4	1.0	165-88501	S	2.4	1.0	165-87503	G
2.4	1.2	165-88600	Т	2.4	1.2	165-87909	L
2.6	1.2	165-88709	U	2.6	1.0	165-87602	Н
2.8	1.2	165-88808	V	2.6	1.2	165-88006	М
3.0	1.2	165-88907	W	2.8	1.0	165-87701	J
3.0	1.5	165-89806	F1	2.8	1.2	165-88105	Ν
3.1	1.0	165-87206	D	3.0	1.0	165-87800	К
3.1	1.2	165-89004	Х	3.0	1.2	165-88204	Р
3.1	1.4	165-89202	Z	3.8	1.2	165-87107	С
3.2	Taper	165-89905	G1				
3.6	1.2	165-90705	H1	2.8 *	1.0	182-13603	J1
4.0	1.2	165-89707	E1				

# OPTIONS

Model	Part No.	Description	Feature
	G5510-164-0A0	Auxiliary feed plate	This part feeds heavy sewing products such as finished garments with great reliability.
	G5514-164-0A0	Second work clamp	This part is effective when sewing slippery materials. It clamps the stacked materials at all times.
	G5508-164-0A0	Clamp for light-weight materials	This part clamps easy-to-slack materials such as light cottons and silks to ensure reliable feeding.
	G5501-164-0A0	Auxiliary clamp	The auxiliary clamp prevents long-sized sewing products from slacking in the direction of feed.
	G5509-164-000	Auxiliary clamp for the 1st button with shorter distance	This clamp is used when there is only a short distance between the top of the garment body and the first button (40mm or less). (Applicable distance: 20 to 140mm)
MC16		Cloth suction device	The cloth suction device consistently feeds front facings that are not pressed, that are not topstitched, or that have a crease. * Specify at the time of order where necessary.

* For vertical 2-hole buttons

ACF-164-1903 (June, 2001) **2/2** Downloaded from <u>www.Manualslib.com</u> manuals search engine Automatic Buttonholing Indexer

#### ACF-172-791RS (for sewing garment bodies) ACF-172-791RA (for sewing finished products with a garment body stacker) ACF-172-791RB (for sewing finished products without a garment body stacker)

- The machine incorporates a head that is capable of running at a normal speed of 3,600rpm and a pneumatic knife driving device. As a result, the machine cycle time has been shortened, thereby promising higher productivity.
- The presetting unit enables the operator to set the next garment body to be sewn on the machine while the current garment body is being sewn, so higher operation rate is promised even when the operator attends several sewing machines. (When RS types or RA types sew garment bodies.)
- The encoder detects the motion of the machine during sewing and moves the conveyer, preventing the material from being deformed. The stepping motor controls the material feed amount in 0.1mm steps. This means that buttonholes can be consistently sewn at accurate intervals.



#### • ACF-172-791RS

This is a subclass model exclusively used for sewing garment bodies. Highly efficient operation is promised by using the presetting unit in combination with a garment body stacker, leading to higher productivity.

#### • ACF-172-791RB

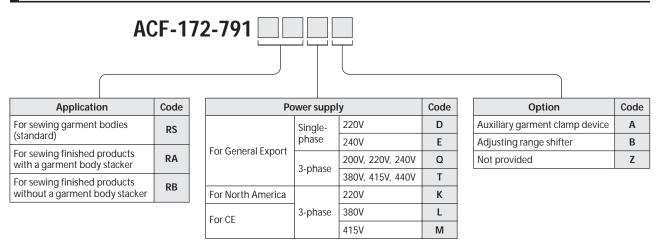
This is a subclass model exclusively used for sewing finished products. The machine is capable of sewing buttonholes on ladies' wear by changing over the feeding direction.

Model name	ACF-172-791RS	ACF-172-791RA	ACF-172-791RB		
Machine head	LBH-791RS/SK (exclusive machine head equipped with a pneumatic knife driving device)				
Max. sewing speed	4,000rpm, normal 3,600rpm (be sure to use core yarn thread (saba #120) at 4,000rpm)				
Stitch length	9.8 ~ 24.8mm (3/8 ~ 1 inch)				
Knife size		6.4 ~ 19.1mm (1/4 ~ 3/4 inch)			
Number of stitches		101 ~ 204			
Lift of the work clamp foot		Max. 14mm			
Needle (at the time of delivery)		DP × 5 (#11J) #11J ~ #14J			
Material feed system		Stepping motor			
Feed direction		Left Right			
Unit controlling the feeding amount		Min. 0.1mm			
Number of patterns that can be stored in memory	20 patterns				
Number of buttonholes	1 ~ 20pcs.				
Capability of sewing ladies' wear	Possible				
Presetting unit	Provided as standard (only when sewing garment bodies)				
Capability of sewing finished products	Impossible	Poss	ible		
Garment body stacker	Provided a	is standard			
Pair stacking	Possible	Possible (only when sewing garment bodies)	Impossible		
Lubrication		Automatic (machine head)			
Lubricating oil	JUKI	New Defrix Oil No.1 (equivalent to ISO	VG7)		
Power requirement Power consumption	Single-phase, 3-phase/1,000VA				
Compressed air and air consumption	0.5MPa (5kgf/cm ² ), 240NQ/min 0.5MPa (5kgf/cm ² ), 20NQ/min		m²), 20N&/min		
Dimensions		1,910mm (W) × 850mm (D)			
Total weight	320kg	350kg	320kg		

### SPECIFICATIONS

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ACF-172-791RS, 172-791RA, 172-791RB (June, 2001) 1/2



### APPLICATIONS SIZE OF CLOTH

A	Buttonhole interval	20 ~ 610mm (0.1mm steps) (Each interval between each two of buttonholes can be separately changed.)	
В	Total feeding amount	610mm	
С	Distance from the top end of the garment body to the first buttonhole	Max. 140mm (It can be set a value larger than 140mm by using the jump function.)	
D	Distance from the front side end of the garment body to the buttonhole	7 ~ 21mm	
E	Applicable size of the garment	Width: 220 ~ 420mm	
F	body to be sewn	Length: 400 ~ 880mm	L

### OPTIONS

Part No.	Description	Description Feature	
G5501-172-0A0	Auxiliary garment clamp device	The auxiliary garment clamp unit effectively clamps a garment which cannot be securely clamped by vacuum (such as georgette, which air easily passes through because of its coarseness, and when the top center strip becomes excessively warped.)	
G5516-172-0A0	Adjusting range shifter	The adjusting range shifter, used for changing the distance from the side edge of the material to the buttonhole, is changed from the standard adjusting range of 7 to 21mm to a range of 12 to 26mm.	Contraction of the second seco

* The optional devices can be attached only to the RS type.

#### Decorative Sleeve Buttonholing Indexer

# ACF-182

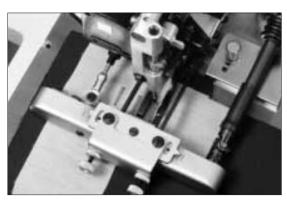
- Automatic fine decorative sleeve buttonholing at uniform intervals can be achieved by simply setting the material in position.
- The left and right material clamping mechanism enables stable overlap operation.
- Setting the material feed or the number of overedging stitches, selecting alternate sewing or the material feed direction etc., can be achieved by one-touch panel operation.

# SPECIFICATIONS

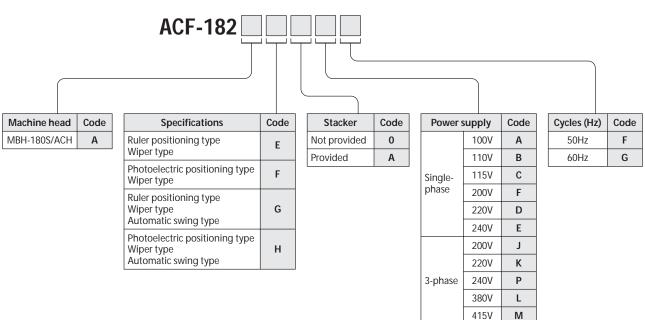
Model name	ACF-182	
Machine head	MBH-180S/ACH	
Max. sewing speed	2,700rpm	
Stitch length	6.4 ~ 22.2mm	
Stitch width	1.6 ~ 2.4mm	
Stitch pitch	0.4 ~ 0.8mm	
Needle bar stroke	27mm	
Lift of the presser foot	5mm	
Needle (at the time of delivery)	SCHMETZ 16 × 231 #90, 1738 #75	
No. of decorative sleeve buttonhole	1 ~ 99	
Distance decorative sleeve buttonhole	1 ~ 999mm	
Speed of cloth feed	100mm/sec	
Lubrication	By an oiler (machine head)	
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)	
Power consumption	270W	
Compressed air	0.5MPa (5kgf/cm ² )	
Air consumption	10NØ/min	



ACF-182



### WHEN YOU PLACE ORDERS



Computer-controlled, Single-thread Chainstitch, Button Neck Wrapping Machine

# AMB-187N (for flat button)

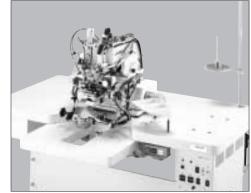
- The AMB series uses the proven MB-373 (single-thread chainstitch button sewing machine with a thread trimmer) as its base and combines it with the X-Y control mechanism. With its micro-computer control, the machine allows any operator to finish beautifully-sewn buttons with consistency. The machine is also provided with a fastening stitching function that prevents stitches from fraying.
- The single unit of the machine is able to sew four-holed buttons and twoholed buttons with/without neck wraps. The operator is only required to position a button and the material on the machine and start the machine. The machine sews the button and wraps its neck in one cycle.
- Operation mode can be easily changed over between the neck wrapping mode and without-neck-wrapping mode with ease.
  - * Optional parts are necessary for sewing buttons without button neck.
- The machine is adaptable to buttons of which outside diameter is 8 to 32mm. The micro-computer facilitates changes in the sewing data including the distance between the holes in button, the number of neck wraps, the stitch shape etc., thereby minimizing any loss of time when changing the specification.

# AMB-189N (for flat button, shank button and marble button)

- The AMB-189N can be used not only for sewing flat buttons without button necks or with neck wraps, but also for sewing shank buttons and marble buttons with neck wraps.
- The sewing mode of the machine can be easily shifted to suit the type of buttons to be sewn only by changing the sewing No. switch on the operation panel. Button chuck does not need to be changed to suit the type of buttons to be used. Quick change-over between flat button sewing mode and shank button (marble button) sewing mode increases operating efficiency of the sewing machine.
- The depth of tie stitches can be set in increments of every 0.05mm. With its cycle sewing function that permits automatic change-over of depth of tie stitches, the machine eliminates loss in production.
- Data such as a sewing pattern, distance between holes in a button and the number of tie stitches appear on the liquid crystal display to allow the operator to easily modify data or change over the sewing pattern while checking the information given on the LCD. With this operation box, the operator can create, as desired, a program for sewing patterns that are frequently used.

# AMB-187NR (for flat button with a button loader) AMB-189NR ^{(for flat button, shank button and marble button} with a button loader)

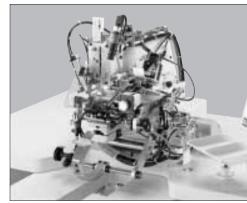
- The button loader allows the operator to set the next button to be sewn on the machine while the sewing machine is still engaged in the current button operation the material, thereby improving productivity. Furthermore, the operator can position a button on the loader without any possibility of error. This eliminates the operator fatigue caused by the conventional button-positioning procedure.
- To sew buttons with different shapes from the one being currently sewn, the machine can be adapted by only replacing the carrier pin(AMB-187NR, AMB-189NR)or the button set pin (AMB-189NR).



AMB-187N



AMB-189N



AMB-189NR

13

### **SPECIFICATIONS**

Model name	AMB-187N	AMB-189N	
Machine head	MB-376 (exclusive head)		
Max. sewing speed	850rpm		
Needle bar stroke	58.6	mm	
Needle (at the time of delivery)	Button with neck wraps: SM × 332EXTLG (Nm90) Nm80, Nm100		
Needle (at the time of derivery)	Button without neck wraps: SM × 332EXTLG (#14BUT) #16, #18		
Thread	Cotton thread, supn thread: #60	0 ~ #30, B33 ~ B46, 120/3 ~ 60/3	
Type of sewing		on sewing with/without neck wraps ing for four- holed flat buttons	
		Shank and marble button sewing with neck wrap	
Outside diameter of button	8 ~ 32mm 8 ~ 32mm 21 ~ 32mm: Button chuck, small 21 ~ 32mm: Button chuck, large		
Number of stitches	2 ~ 30 (can be set in 2-stitch steps)	2 ~ 32 (can be set in 2-stitch steps)	
Number of neck wraps	2 ~ 44 (can be set in 2-stitch steps)	2 ~ 46 (can be set in 2-stitch steps)	
Button neck height	For four-holed and two-holed flat button sewing with neck wraps: 1.5 ~ 6mm (0mm for sewing buttons without neck wraps)		
Button neck neight		Shank and marble button sewing with neck wraps $0 \sim 3 \text{mm}$	
Number of stay stitches	One to be selected one	from among 0, 1, and 2	
Stay stitch feeding amount	0 ~ 3mm (to be set in	increments of 0.2mm)	
Lubrication	By an	oiler	
Lubricating oil	JUKI New Defrix Oil No.1	(equivalent to ISO VG7)	
Power requirement	Single-phase 100V, 110V, 120V, 200V, 220V, 240V 3-phase 200V, 220V, 240V, 380V, 415V, 440V		
Power consumption	450W		
Compressed air and air consumption	0.5MPa (5.0kgf/cm ² ), 15NQ/min		
Dimensions	1,100mm (W) × 810n	nm (L) × 1,500mm (H)	
Adjustment of the height of table	Height of the top face of	the table 750 ~ 1,030mm	
Total weight	120	Dkg	

# WHEN YOU PLACE ORDERS

Power supply

100 ~ 130V

190 ~ 250V

190 ~ 250V

380V (for JE)

415V

440V

220V (for North America)

380V (for General Export)

w

К

L

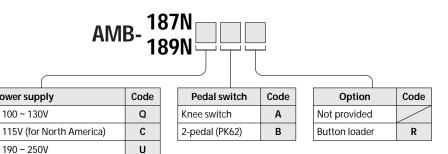
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М

Ν

Single-phase

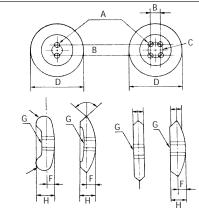
3-phase



AMB-187N, 189N, 187NR, 189	NR (June, 2001	) 2/4
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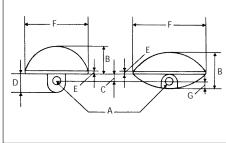
### APPLICABLE BUTTON REQUIREMENTS

### AMB-187N/AMB-187NR, AMB-189N/AMB-189NR



	271V/AIVID-1071NK			
	Specifications for 4-holed and 2-holed buttons			
A	Buttonhole diameter	Needle: For #12 - #16 needles, 1.5mm or more Needle: For #12 - #18 needles, 2mm or more		
В	Distance between the button holes	2 ~ 5mm(±0.15mm)		
с	Buttonholes	All holes must be located equidistantly from the center of each button		
D	Outside diameter	Min. 8mm Max. 32mm Line size ± 0.25mm or less		
E1	Button with a round edge	The button must have a radius of 3mm or less		
E2	Button with a V-shaped edge	Within 120 °		
E	Button with an angular edge	The thickness must be 5mm or less		
F	Bulge	5mm or less		
G	Area around the holes	Must be smooth		
н	Thickness	8mm or less		

### AMB-189N/AMB-189NR

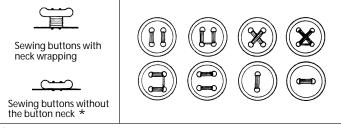


	Specifications for shank and marble buttons		
Α	Button hole diameter	1.5mm or more	
В	Thickness	6.8mm or less	
с	Distance between the bottom of button head to the center of hole of button	Shank button: 1mm ~ 6mm Marble button: 1.5mm or more	
D	Button shank length	8mm or less	
Е	Straight section on the side of button	3.5mm or less	
F	Outside diameter	Min. 8mm, Max. 32mm	
G	Distance between the center of hole of button and the bottom of button	2mm or less	

(Caution) If a button loader (optional) is used, some buttons cannot be used because of the shape. So, be careful.

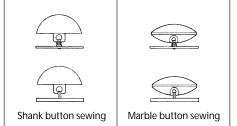
### KINDS OF BUTTON AND STITCH SHAPES

### AMB-187N/AMB-187NR, AMB-189N/AMB-189NR



* Optional parts are necessary for sewing buttons without button neck.

### AMB-189N/AMB-189NR



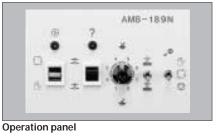
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### **OPERATION PANEL/OPERATION BOX**

### AMB-189N/AMB-189NR

Selection of sewing No. (selection of sewing pattern)									
		Flat button (4-holed or 2-holed)					Shank button, marble button		
	1	2	3	4	5	6	7	8	
With neck wraps			X		I		-11.2 -	-12.4	
*	1	2	3	4	5	6	7	8	
Without neck wraps					$(\mathbf{i})$	ÎÌ			

The machine is provided with 16 sewing patterns, i.e., eight patterns for sewing buttons with neck wraps and eight patterns for sewing buttons without neck wraps. (DIP switch is used to change over the sewing mode between the aforementioned two kinds of buttons sewing.) * Optional parts are necessary for sewing buttons without button neck.





### PRODUCTION CAPACITY

Model name	AMB-187N, AMB-189N	AMB-189N
Production capacity	1,843 pcs/8 hours	2,327 pcs/8 hours
Conditions	4-holed buttons The number of tie stitches: 8 x 2 The number of neck wraps: 10 Without cross-over stitches/Stay stitch: 1 Allowance rate: 25%	Shank buttons Number of tie stitches: 8 Number of neck wraps: 6 Allowance rate: 25%

# OPTIONS

# AMB-187N/AMB-187NR, AMB-189N/AMB-189NR AMB-189N/AMB-189NR

Part No.	Description	Remarks
250-05208	Feed plate	For heavy-weight materials
250-09051	Button sewing unit for sewing buttons without button neck	
250-09101	Knife cover for sewing buttons without button neck	For sewing buttons without the button neck
178-28906	Feed plate for large buttons	
178-29102	Feed plate for small buttons	

Part No.	Description	Remarks
179-66656	Tongue(asm.) Trianguler(for 1.2mm)	-1.2 ⊨ 1.2mm
179-66458	Tongue(asm.) Trianguler(for 2.4mm)	

### BUTTON CARRIERS FOR AMB-189NR, AMB-189NR

		For 4-holed button				For 2-holed button			
Button carrier configuration		A A	<u></u> <u> </u>			A			
	Dimension A(mm) Distance between holes in a button	Dimension B(mm) carrier pin diameter	Part No.	Symbol	Dimension A(mm) Distance between holes in a button		Part No.	Symbol	
Standard	2.8	1.4	178-57004	E	3.4	1.4	178-58606	Т	
Stanuaru	3.4	1.4	178-57400	н	4.2	1.4	178-58804	V	
	2.0	1.0	178-56600	A	2.0	1.0	178-58802	М	
	2.4	1.2	178-56709	В	2.4	1.2	178-58101	N	
	2.6	1.2	178-56808	С	2.6	1.2	178-58200	Р	
	2.8	1.2	178-56907	D	2.8	1.2	178-58309	Q	
	3.0	1.2	178-57103	F	3.0	1.2	178-58408	R	
Optional	3.0	1.4	178-57202	F1	3.2	1.4	178-58507	S	
	3.2	1.4	178-57301	G	4.0	1.4	178-58705	U	
	3.6	1.4	178-57509	J	4.4	1.4	178-58903	W	
	4.0	1.4	178-57608	К	4.6	1.4	178-59000	Х	
	4.0	1.8	178-57707	K1	4.8	1.4	178-59109	Y	
	5.0	1.8	178-57806	L	5.0	1.4	178-59208	Z	

### BUTTON SET PINS FOR AMB-189NR (PROVIDED AS STANDARD)

Buttor	n set pin	Marble button	Shank button		Metallic button
Description	Part No.				
A for marble button	179-74056	Use A	20mr	n or less Use A for shank buttons with a round-hole in shank	
B for shank button	179-74254			Use B Shank buttons of which A and A' are 1.5 to 2.0mm	
C for shank button	179-74452			Use C Shank buttons of which A and A' are 2.0mm or more	
D for metallic button	179-74551			_	15mm or more Use D 2mm or more

AMB-187N, 189N, 187NR, 189NR (June, 2001) 4/4 Downloaded from <u>www.Manualslib.com</u> manuals search engine

* Buttons that are not given in the above table are available by special order.

#### Electronic Handstitching Machine (for soft-to-the-touch stitch type)

# FLS-350NA (standard) FLS-350NB (for thick thread)

• Thorough studies on stitch structure helped us design a machine that could sew softer-feeling stitches. The machine produces consistentquality soft-feeling stitches with just the right slack to make them look as if they're just lying over the fabric.

In addition, the regulating knob permits easy adjustment of stitch formation and provides a wider adjustment range.

- The machine can handle a wider variety of threads. It supports not only JUKI-specified threads, but also commercially available synthetic threads that are easier to purchase. (Please use the commercially available brands of synthetic thread designated by JUKI.)
- By pressing the thread-feeding switch with a material placed on the machine, the machine head rotates by 150 degrees, causing the lower looper to automatically draw in a 1,200mm length of thread.
   This eliminates the nimble finger-work conventionally required to measure the length of synthetic thread and arrange cut-to-length pieces of thread.
- FLS-350NB for thick thread (low-count thread) is now available. The machine is provided with specifications that are best suited to the topstitching of ladies' wear.



FLS-350NA

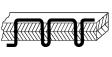
### SPECIFICATIONS

	FLS-350NA	FLS-350NB
Model name	Standard	Standard     For thick thread       Standard     For thick thread       m (specified thread)     300rpm (specified thread)       Max. 8mm     Max. 8mm       NN DPN1032B/38     ORGAN DPN1032B1/49       IETZ 1032B1/38, 36     SCHMETZ 1032B1/49       stitching thread:     Svew Wax Silk       9ht-weight materials)     ONUKI LIMITED.       ACE CROWN (Tetoron) #8       *5 NB3, Nm=120/3     #30 ~ #8, B46 ~ B92, Nm=60/3 ~ 3       Max. 1,200mm     Max. 1,000mm
Max. sewing speed	400rpm (specified thread) 300rpm (synthetic thread)	300rpm (specified thread)
Amount of feed	Max.	8mm
Needle (at the time of delivery)	ORGAN DPN1032B/38 SCHMETZ 1032B1/38, 36	
Thread (JUKI-specified threads)	<ul> <li>Handstitching thread:</li> <li>FUJIX's New Wax Silk</li> <li>(for light-weight materials)</li> <li>Synthetic thread:</li> <li>FUJIX's KING FIT #60</li> </ul>	ONUKI LIMITED.
	#60~#50, B33, Nm=120/3	#30 ~ #8, B46 ~ B92, Nm=60/3 ~ 30/3
Sewing thread length	Max. 1,200mm	Max. 1,000mm
Seam length	Max. 1,000mm	Max. 800mm
Lift of the presser foot	7r	nm
Lubrication	By ar	n oiler
Lubricating oil	JUKI New Defrix Oil No.2	(equivalent to ISO VG32)
Power consumption	70	WO
Dimensions	1,200mm (W) × 800	mm (D) × 870mm (H)
Total weight	30	Okg



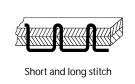
TYPES OF STITCHES

Saddle stitch



Long and short stitch

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### WHEN YOU PLACE ORDERS

	F	LS	-35	ON			
Appli	cation	Code			Destinatio	on	Code
Standar	d	Α			For General Ex	kport	Е
For thic	k thread	В			For JE (CE)		D
Pov	ver suppl	y	Code				
	100V ~ 1	20V	Α				
Single- phase	200V ~ 2	240V	Е				
phase	380V		Н				
3-	200 ~ 2	40V	D				
phase	380V		L				

### OPTIONS

Part No.	Description	Feature
HL-008423063	ROM for matching normal-/reverse- feed stitches	The reverse-feed stitch length is fixed at a factory setting of 1 to 2mm, but it can be easily matched to the normal-feed stitch length by appropriately replacing the ROM.
252-49962	Needle bar (for needle size #38)	This needle bar is to be used when you remodel your FLS-350NB to FLS-350NA.
167-99660	Needle bar for thick thread (for needle size #49)	This needle bar is to be used when you remodel your FLS-350NA to FLS-350NB.
166-52257	Stitch ruler	For the FLS-350NB (provided as standard for the FLS-350NA)
252-42553	Suspended ruler	For the FLS-350NA (provided as standard for the FLS-350NB)
251-56654	Stitch change-over hand switch	

FLS-350NA, 350NB (June, 2001) 1/1

#### Automatic Serging Machine

# ASN-395L (standard air pressure type) ASN-395T (standard airless type) ASN-397 (high -grade type)

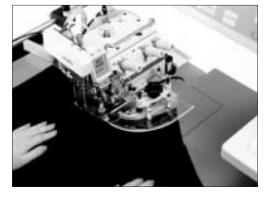
- The MO-3904 model newly-developed super high-speed overlock machine head is adopted. The machine ensures consistent sewing performance even at the max sewing speed of 8,000rpm, thereby improving productivity by a large margin. The machine securely clamps the material and feeds it straight without fail, ensuring smooth and speedy sewing performance.
- The machine incorporates a newly-developed material edge guide. This means that the machine is capable of finishing light-weight materials with neither curled nor rolled-in edges and can sew curves with consistency while preventing stitches from slipping off the edge of the material. Furthermore, the machine can sew with low thread tension to suit the type of material to be sewn. Consequently, the machine achieves excellent seam quality when sewing soft and delicate materials.
- ASN-397

The sensor detects sharp in-curves or out-curves of files and seats of slacks and automatically adjusts the sewing speed. This means that the procedure of manually changing the sewing speed at curves of the material is no longer necessary. Thanks to this mechanism, the operator can operate the sewing machine without any trouble in areas where the material edge is rolled in. Partial shirring can be performed by setting data in the stitching program. The sensor functions according to the specified data and instructs the machine to perform partial shirring, thereby preventing trouble caused by improper stretching/shirring of the material.



ASN-395L

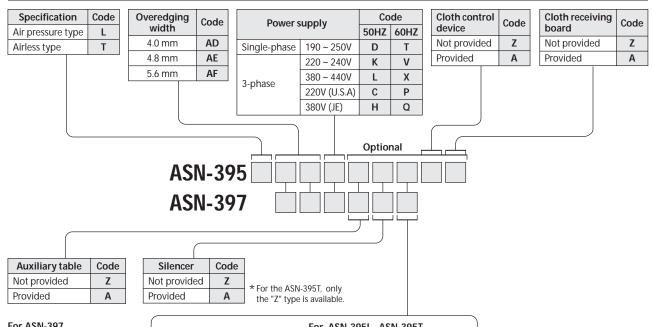
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### SPECIFICATIONS

Model name	ASN-397	ASN-395L	ASN-395T			
Machine head		Exclusive for MO-3904				
Max. sewing speed		8,000rpm				
Stitch length		0.8 ~ 4mm				
Lift of the presser foot	Max. 7mm					
Overedging width		4.0mm, 4.8mm, 5.6mm				
Needle (at the time of delivery)		DC × 27 (#11) #9 ~ #14				
Chain-off thread trimmer		T038 (suction type side cutter)				
Sewing specifications	Cloth size : W	10R or more (40R or more when cloth idth 400mm or less Ingth 480mm or more (length for whi mited to 1.				
Class of work	Men	's slacks, one-piece, skirt, pants, coa	t etc.			
Speed control function	Can be set at either "automatic" or "manual"					
Cloth control device (sharp curve sewing device)	Provided as standard	ded as standard Option				
Cloth receiving board	Provided as standard	Opt	ion			
Curve detecting function	Both out-curve and in-curve are detected					
Curl blower and table air blower	Provided as standard					
Table lifting device	Provided as standard					
Partial shirring device	Built-in differential-feed mechanism	Deferential-feed mechanism (option)				
Stacker	Opt	tion				
Lubrication		Automatic (machine head)				
Lubricating oil	JUKI N	lew Defrix Oil No.2 (equivalent to ISO	VG32)			
Power requirement		) ~ 250V, 3-phase 220 ~ 240V, 380 ~ 4				
Power consumption		OW	50HZ: 835W, 60H: 905W			
Compressed air and air consumption	0.5MPa (5kgf/cm ² ), 220NQ /min (when the stacker is used: 250NQ /min)	,				
Dimensions (mm)	Single stacker 1200 Main body Maximum Field Single stacker 1200 Main body Maximum Field Single stacker 1270 How How How How How How How How How How					
Total weight	200kg (when all the optional devices are installed: 230kg)	190kg (when all the optional devices are installed: 220kg)	200kg (when all the optional devices are installed: 210kg)			

### WHEN YOU PLACE ORDERS



				/	FOF ASIN-39
	Optional device				
d Cod	Cloth feed		2-pedal	Stacker	
	device	feed pedal	unit	SS42	SS40
Z					
Α					
В					
С					
D					
E					
K					
L					
M					
N					

Optional device						
Stac		Differential-	2-pedal	Air blower	Cloth feed	Cod
SS40	SS42	feed device	unit		device	
						Z
						Α
						В
						С
						D
						Ε
						F
						G
						н
						J
						К
						L
						Μ
						Ν
						Р
						Q
						R
						S

* For the ASN-395T, only the "Z" type is available.

### **OPTIONS**

Model	Part No.	Description	Feature	397	395L	395T
SS40	GSS-400000B0	Single stacker	The max. number of garments that can be stacked is 70.			
SS42	GSS-420010B0	Double stacker	The max. number of pieces of garments that can be stacked is 140.			
	G5925-397-0A0	Cloth feed device				
	GMC-08042000	Silencer	Silencer for chain-off thread suction device			
	G5422-397-0A0	2-pedal unit	Stacker pedal + Differential-feed pedal			
	G5425-397-0A0	Stacker pedal				
	G5427-397-0A0	Differential-feed pedal	This pedal is required when manually operating the machine.			
	G5603-395-0B0	Differential-feed device		S		
	G5540-395-0A0	Air blower	The air blower provides smooth feed of material.	S		
	G5050-395-0A0					
	G5051-395-0A0	Cloth control device	The ball-based control mechanism demonstrates its performance when sewing small parts or sharp curves.			
	G5050-397-0A0					
	G5060-397-0A0	Cloth receiving board		S		
G5420-397-0A0 Au		Auxiliary table	The part facilitates handling of long-size materials such as slacks and white overalls.			

* For the ASN-395T, any device that needs compressed air for operation cannot be installed.

S: Provided as standard

#### Automatic Pocket Setter

# AVP-870

- In the exclusive machine head, a distance between the throat plate and the blade point of the hook is small. As a result, the blade point of the hook tucks thread loops with consistency, achieving neatly finished seams with no thread breakage. Furthermore, the machine head's sewing speed runs as high as 3,500rpm, allowing better productivity.
- Data on how to fold a pocket piece in accordance with the type of material to be sewn can be specified on the control panel. Also, the position of the presser foot can be finely adjusted on the control panel.
   Consequently, the width of pockets (positions of the right and left-hand edges of a pocket piece) can be adjusted with ease and adjustment results can be checked on the control panel.
- When changing the pocket style to be sewn, only three different parts of the machine need to be changed accordingly. They can be replaced very quickly.



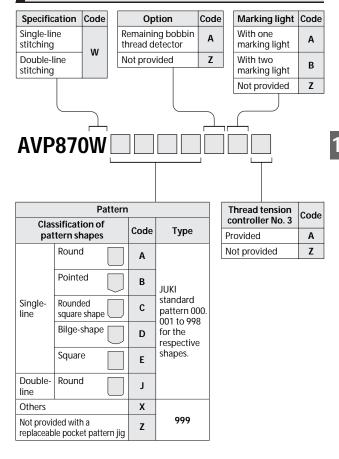
AVP-870

• The machine comes with a machine head with a long arm, which means that the space under the arm is very wide. As a result, large-sized sewing products can be sewn by using this machine. Furthermore, a longer distance is provided between the folder and the machine head. This means that the operator can set a large garment body on the machine without worrying about interference between the garment body and the folder.

### SPECIFICATIONS

Model name	AVP-870	
Machine head	Long-arm lockstitch machine with an automatic thread trimmer (exclusive machine head)	
Max. sewing speed	3,500rpm	
Sewing area	260mm (L) × 240mm (W)	
Stitch length	0.1 ~ 3.4mm	
Needle bar stroke	30.7mm	
Needle (at the time of delivery)	SINGER DELTA-U1515-1 (#9)	
Hook	Horizontal-axis full-rotary hook	
Size of bobbin and bobbin case	Standard	
Stacking capacity	120 pcs.	
Number of patterns that can be stored in memory	Max. 691	
Memory medium	2DD/2HD 3.5" micro-floppy disk	
Time required to replace a pattern style jig	Within 2 minutes	
Cycle time	10 seconds (sewing speed: 3,500rpm, stitch length: 2mm)	
Feeding method	AC servomotor, X-Y clamp device	
Lubrication	Automatic (machine head)	
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	
Power requirement	Single-phase 200V, 240V	
Power consumption	800VA	
Compressed air and air consumption	0.5MPa (5.0kgf/cm ² ), 120NØ/min	
Total weight	640kg	
Dimensions	1,850mm (W) × 1,830mm (D) × 1,200mm (H)	

### WHEN YOU PLACE ORDERS



### OPTIONS

Model	Model Part No. Description		Feature				
PGM-6	1-6 Handy programming device		If the handy programming device is connected to the main unit of the pocket setter, sewing data can be established and modified.				
	Marking light		The marking light helps you easily position a pocket and garment body on the machine.				
M8548-570-0A0 Bobbin thread remaining amount detecting device			The detecting device warns the operator to replace the bobbin thread before it runs out. This prevents sewing troubles such as re-sewing.				

# Automatic Pocket Setter (for jeans) AVP-875S

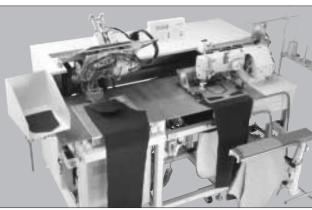
- The machine automatizes a series of pocket-setting processes, concurrently folding and sewing sequential pocket cloths in the production line, thereby resulting in substantial labor savings. With its newly developed large-hooked zigzag stitching lockstitch machine head, the machine runs at a maximum sewing speed of 4,000rpm and executes all of its operations with split-second response. The sum result: dramatically reduced cycle time and increased productivity.
- A pocket cloth is folded on the table surface and properly tensed by a pocket style jig to create sharp creases without material slippage or bulging. The pocket cloth is vertically shifted and pulled to the suitable tautness for placement on the garment body. This prevents the pocket cloth from slipping out of the correct position and makes it easy to adjust folding timing. With this pocket-folding and pocket-positioning mechanism, the machine is widely adaptable to various materials.
- It takes only about five minutes to replace the pocket style jig including adjustment. Any tools are unnecessary for its attachment/removement. The pocket style jig can be attached/ removed without the use of any tools.
- The folding unit is sufficiently spaced from the machine head. This means large garment bodies do not interfere with each other even when right and left garment bodies are alternately processed on the table. The machine widely adapts to materials of various sizes and many different sewing specifications.

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- When the AVP-875 is equipped with the AW-2, the production capacity results in increase by as much as 10%.
- Bobbin replacement by AW-2 is fully synchronized with the sewing operation of the AVP-875.



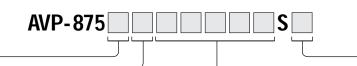
AVP-875A



### SPECIFICATIONS

Model name	AVP-875S	AVP-875A				
Machine head	High-speed, 1-needle, lockstitch, zigzag stitching machine (exclusive machine head)					
Max. sewing speed	4,000rpm					
Sewing area	250mm (L) ×	240mm (W)				
Stitch length	0.1 ~ 6.0mm					
Needle bar stroke	35r	nm				
Needle (at the time of delivery)	SCHMETZ 134SE	S SERV7(Nm130)				
Hook	Horizontal-axis	full-rotary hook				
Automatic bobbin winding and feed device (AW-2)	_ *	Provided as standard				
Size of bobbin and bobbin case	1.7 fold	1.4 fold (specifically designed for the AW-2)				
Bobbin thread replacement	Manual	Automatic (AW-2)				
Needle thread breakage detection	ead breakage detection Provided as standard					
Stacking capacity	Max. 64 pieces of jeans bodies					
Number of patterns that can be stored in memory	Max. 691 pattern					
Memory medium	2DD/2HD 3.5" m	nicro-floppy disk				
Feeding method	AC servomotor,	X-Y clamp drive				
Lubrication	Automatic (m	,				
Lubricating oil	JUKI New Defrix Oil No.1	(equivalent to ISO VG7)				
Power requirement	Single-phase 200 ~ 240V, 3-phas	se 200V, 200 ~ 240V, 380 ~ 440V				
Power consumption	600VA					
Compressed air	0.5MPa (5.	0.5MPa (5.0kgf/cm ² )				
Air consumption	120NØ/min	220NQ/min (max.)				
Total weight	600	Okg				
Dimensions		660 → ↓ unit 1,160 ↓ Stacker 700 ↓ (Unit: mm)				

### WHEN YOU PLACE ORDERS



Туре	Type Code			Pocket style jig					Option		
Standard With AW	-		Configuration	Code	Kind	Label-inserting device	Code	Garment put base	Marking light	Code	
			Not used	Z	999	Not provided	Z	Not provided	Not provided	Z	
Pow	Power supply Code		Round-bottom type	Α				Provided	Not provided	Α	
Single-		<u> </u>	Blade-shape bottom type	В				Not provided	Provided	В	
phase	200 ~ 240V	E	Trapezoidal-bottom type	С	001 ~ 998	Not provided	: Z	Provided	Provided	С	
	200 ~ 240V	Р	Bilge-shaped-bottom type	D	for each configuration	Provided	: A				
3-phase	380 ~ 440V	Ν	Square-bottom type	E							
	200V for CE	М	Others	Х	]						

### TRIAL CALCULATION OF PRODUCTIVITY TRIAL CALCURATION CONDITIONS

	AVP-875S	AVP-875A	
Time lost due to causes other than bobbin replacement	3,775 seconds in 8 hours	3,946 seconds in 8 hours	
Time lost due to bobbin replacement	2,664 seconds in 8 hours	0 seconds in 8 hours	
Total time lost in one day (allowance rate)	6,421 seconds in 8 hours (29 %)	3,946 seconds in 8 hours (16 %)	
Daily production (8-hour operation)	2,131 pockets	2,367 pockets	
Effect of introduction of AW-2	Production: Increase by 236 pockets in 8 hours (11 % increase) Time lost: Reduced by 2,475 seconds in 8 hours (39 % reduction) Allowance rate: 13 % decrease		

Thread: Span #20 Bobbin thread consumption: 1.2 m/pocket Time required to manually replace the bobbin: 25 sec/case Cycle time: 10.5 sec/pocket Allowance rate (excluding bobbin replacement): 15 %

* The time lost for the AVP-875 includes the time required to operate the AW-2 (189 seconds in 8 hours).

* Daily production and effect of introduction of the AW-2 vary with sewing conditions.

### OPTIONS

Model	odel Part No. Description		Feature		
PGM-6	PGM-6 Handy programming device		If the handy programming device is connected to the main unit of the pocket setter, sewing da can be established and modified.		
	G9001-875-0A0 Marking light		The marking light helps you easily position a pocket and garment body on the machine.		
	G9011-875-0B0 Garment put base		When mounted on the main unit, the garment put base is quite helpful of sewing either right or left garment bodies in succession.		
	Label-inserting device		A label can be inserted either into the right- or left-hand side of a pocket cloth. A cylinder-type label-inserting device that can be directly mounted on the pattern board is also available. When placing on order for a pocket style jig, specify a label-inserting device, if necessary.		

### PRE-FOLDED POCKET STYLE (OPTIONAL)

- This is a pocket style jig to be used exclusively for sewing pocket pieces onto the garment body after they have been folded in a separate process.
- The pre-folded pocket style jig consists of three components, i.e., the "clamp frame," "clamp upper plate" and "clamp lower plate." Changes in pocket size and design are accommodated by replacing the clamp upper plate and lower plate with appropriate ones. The clamp upper plate and lower plate are less expensive than the conventional pocket style jigs. The use of the pre-folded pocket jig in highly flexible small-lot production reduces the running costs of the AVP-875.
- The clamp upper plate and lower plate can be attached and removed to and from the clamp frame quickly and easily.
- Even when using the pre-folded pocket style jig, the machine can sew at speeds as high as 4,000rpm, dramatically boosting productivity.
- The folding mechanism of the pocket setter does not support a trapezoidal-design pocket. With the pre-folded pocket style jig, however, this type of pocket piece can be sewn onto a garment body if it has been folded into a trapezoidal shape in advance.

Part No.	Description		
G6132-875-0A0	Clamp frame (asm.)		
G6133-875-0A0 Clamp upper plate blank (asm.) (clamp upper plate/lower plate, combined			
G6131-875-0A0 Magnet mounting plate (asm.) (magnet for retaining the upper plate			



Clamp frame (asm.)



Clamp upper plate (machined)



Clamp lower plate (machined)

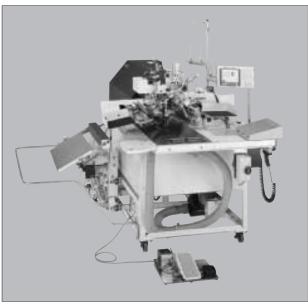
Lockstitch, Automatic Welting Machine with an Automatic Welting Patch Feeder

# APW-297 (for straight pocket with flap) APW-298 (for slanted pocket with flap)

- Newly developed welting patch cutting device and automatic flap/ pocket bag feeder are now optionally available.
   These components work to upgrade seam quality and further increase productivity over all processes, including the afterprocess.
- The length of thread remaining after thread trimming is further reduced and results in cutting operation of thread picking.
- As many as 100 different patterns can be stored in memory and 10 different cycle sewing programs can be established.

• APW-298

The function to separately drive the needle bars allows flexible setting of the welt angle, - a key advantage in the flexible sewing of various kinds of pocket shapes such as slant pockets and welt pockets.



APW-298

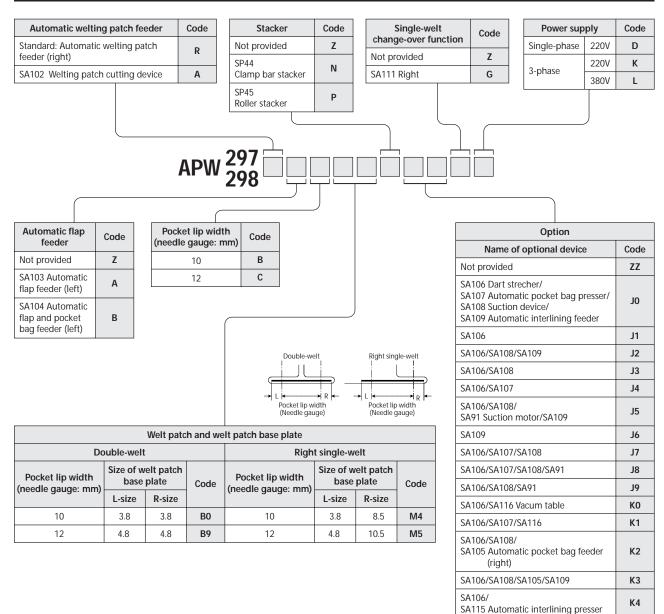
### SPECIFICATIONS

Model name     For straight pocket with flap     For slanted poc       Max. sewing speed     3,000rpm (1,000 ~ 3,000rpm)       Stitch length     Regular stitching     Standard: 2.5mm (2.0 ~ 3.4mm)       Stitching     Safety stitching     Standard: 1.0mm (0.5 ~ 1.5mm)       stitching     Back-tack stitching     Standard: 2.0mm (0.5 ~ 3.4mm)       Kinds of welts     Parallel double welt, parallel single welt (with/without flaps)     Parallel double welt, parallel single welt trapezoidal stitching (not be standard)	parallel single welt, nt single welt,			
Regular stitching         Standard: 2.5mm (2.0 ~ 3.4mm)           Iength         Fastening stitching         Safety stitching         Standard: 2.5mm (0.5 ~ 3.4mm)           Back-tack stitching         Standard: 2.0mm (0.5 ~ 3.4mm)         Standard: 2.0mm (0.5 ~ 3.4mm)           Kinds of welts         Parallel double welt, parallel single welt         Parallel double welt, slant double we	nt single welt,			
Stitch length         Fastening stitching         Safety stitching         Standard: 1.0mm (0.5 ~ 1.5mm)           Kinds of welts         Back-tack stitching         Standard: 2.0mm (0.5 ~ 3.4mm)	nt single welt,			
length         Fastening stitching         Safety stitching         Standard: 1.0mm (0.5 ~ 1.5mm)           Back-tack stitching         Back-tack stitching         Standard: 2.0mm (0.5 ~ 3.4mm)           Kinds of welts         Parallel double welt, parallel single welt slant double welt, slart         Parallel double welt, parallel single welt	nt single welt,			
stitching     Back-tack stitching     Standard: 2.0mm (0.5 ~ 3.4mm)       Kinds of welts     Parallel double welt, parallel single welt     Parallel double welt, parallel single welt	nt single welt,			
Kinds of welts Parallel double welt, barallel single welt slant double welt, slant double	nt single welt,			
Sewing length (welt length)       18 ~ 180mm* (in increments of 1mm) (as small as 25mm when the corner knife is used)				
Number of patterns that can be stored in memory         100 patterns				
Number of cycles that can be stored in memory         10 programs (1 program         Combination of 5 patterns at the max	ximum)			
Needle gauge 10mm, 12mm, 14mm (optional **)				
Needle (at the time of delivery)         ORGAN Mt x 190 Standard (#16) #16 ~ #18 SCHMETZ 190R Standard (Nm100) Nm100 ~ Nm110         ORGAN DP x 17 Standard (# SCHMETZ SY3355 Standard (#				
Needle bar stroke 34.4mm 33.4m	nm			
Thread SPUN #50	SPUN #50			
Hook Vertical-axis 1.6 fold-capacity hook	Vertical-axis 1.6 fold-capacity hook			
Machine head         2-needle, needle-feed, lockstitch machine with a center knife         2-needle, needle-feed, lock with an organized split needle-feed, lock				
Machine head motor Compact AC servomotor (direct-drive system)				
Thread take-up Slide type				
Lubrication         By an oiler (machine head and hook)	By an oiler (machine head and hook)			
Lubricating oil         JUKI New Defrix oil No. 2 (equivalent to ISO VG32)				
Needle-feed system Stepping motor control				
Cloth feeding system By a servomotor drive	By a servomotor drive			
Automatic welting patch feeder Provided as standard	Provided as standard			
Bobbin thread remaining amount         Provided as standard           detecting device         Provided as standard	Provided as standard			
Bobbin winder         By an external motor				
Power consumption 550W				
Compressed air and air consumption 0.5MPa (5.0kgf/cm ² ), 40N0/min				
Total weight 330kg 350k	<g< th=""></g<>			
Dimensions (excluding the stacker)980mm (W) x 1,650mm (D) x 1,200mm (H)				

* The machine also supports longer sewing length (220mm).

** When the needle gauge of 14mm is used, the corresponding optional parts must be purchased.

### WHEN YOU PLACE ORDERS



The same optional parts are offered for the

APW-297 and APW-298.

### NEWLY DEVELOPED DEVICES (OPTIONAL)

Since option	Since optional parts can't be retrofitted to the machine after purchase, be sure to specify any that you may need when placing your order.					
Model	Description	Feature				
SA102	Welting patch cutting device	<ul> <li>The knife is motor-driven. To cut the welting patch as short as possible, it automatically adjusts itself to the sewing length established on the operation panel. This enables more consistent welting patch feed and folding operations.</li> <li>The welting patch cutting knife is located under the welting patch table. This keeps the knife from damaging the garment body. In addition, the knife can be changed with ease.</li> <li>Welting patch cutting, a job conventionally done by hand in the after-process, is no longer required. The result is a substantial reduction in the processing time.</li> <li>The clamp exclusively used during welting patches cutting allows the cutting device to cut welting patch cutting.</li> </ul>				
SA103	Automatic flap feeder  • The fulcrum at the center of the automatic flap feeder claw clamps flaps securely and automatically feeds the the sewing position. This promises increased productivity.					
SA104	Automatic flap and pocket bag feeder	<ul> <li>The device works to sew the flap and pocket bag at the same time with the pocket bag placed on the flap.</li> <li>Simultaneous sewing of a flap and pocket bag produces beautifully finished welts free from uneven material feed In addition, there's no longer any need to attach the pocket bag on the flap side, a task normally required in the after process.</li> </ul>				
SA105	Automatic pocket bag feeder (right)	• This device is intended to be used with SA104 (automatic flap and pocket bag feeder) to automatically sew pocket bags on both sides of a welting patch.				

# OPTIONS

The same optional parts are offered for the APW-297 and APW-298. They can be retrofitted to either machine.							
Model	Part No.	Description	Feature				
SA73N	GSA-730000A0B	Auxiliary receiving plate (right)	This is the receiving plate for accessories for welting patches, etc.				
SA106	GSA-106000A0	Dart stretcher	The dart stretcher holds the end of the material when making a welt on a darted part of the material to make it easier to set the darted part and improve the reliability of the welting.				
SA107	GSA-107000A0	Automatic pocket bag presser	The automatic pocket bag presser is used to hold pocket bags under the garment body when welting and pocket bag sewing are performed concurrently.				
SA109	GSA-109000A0	Automatic interlining feeder	To improve workability, the automatic interlining feeder automatically delivers rolled interlining cloth onto the table and cuts it.				
SA110	GSA-110000A0	Stand for standing work	This stand is mounted under the main body of the machine to adjust the height of the main body to standing work.				
SA111	GSA-111000A0	Right single-welt and double- welt changeover device	Ple- The device opens/closes the clamp foot by fingertip control. This enables easy changeover of the sewing machine specification between double-welt and right-single-welt types simply by changing the binder.				
SA112	GSA-112000A0	Shim device	This device encloses a garment body between its upper and lower parts and feeds it to the needle entry area. It is especially useful for difficult-to-feed garment bodies.				
SA115	GSA-115000A0	Automatic interlining presser	This device is used for securing interlining under garment body for sewing.				
SA116	GSA-116000A0	Table for vacuum type					
SA108	GSA-108000A0	Suction device	The device picks up the garment body by suction force to facilitate setting of materials on the machine. Use the device with a suction motor (SA91).				
SA91	GSA-910000A0	Suction motor	This is the blower motor for the suction device (SA108).				
SP44		Clamp bar stacker	Since the main body of the stacker swings around to catch a material, even smaller garment bodies can be consistently stacked (350 mm from the pocket position at the minimum). Stacked garment bodies are secured with the bar. This prevents a stacked garment body from slipping down.				
SP45		Roller stacker	This is a stacker suited for small articles that cannot be feed by a bar stacker or grasping stacker.				

#### Lockstitch, Automatic Welting Machine

# APW-194N (for without pocket type) APW-195N (for flap sewing type) APW-196N (for slant pocket sewing type)

- Productivity is increased by equipping the machine with a sewing speed capability of 2,500rpm.
- With its improved material-clamping force during jumping and its newly adopted Teflon-coated binder that provides smoother material feed, the machine can reliably feed garment bodies and welting patches made of slippery materials to the sewing position.
   The result is beautifully finished seams with no slippage between the garment fabric and welting patch.
- The machine also retains data on ten different patterns, including data on stitching length, stacker operation, etc. Cycle sewing with up to five combined patterns can be executed. With this feature, the machine offers higher productivity in welting on semi-custom-made garments under one-pattern-one-garment sewing system.
- The machine offers improved welting capabilities and is compactly designed to allow efficient use in limited production spaces.

#### • APW-194N

The corner knife intervals can be automatically and accurately adjusted simply by setting a sewing length on the operation panel, ensuring that welts are finished with consistent quality at all times.

#### • APW-195N, APW-196N

When attaching flaps, the flap sensor detects the flap length for the accurate adjustment of the sewing length and corner knife intervals. Since the machine produces welts of consistent quality regardless of the welting length, it can be widely used for the continuous sewing of welts of different lengths.



#### • APW-196N

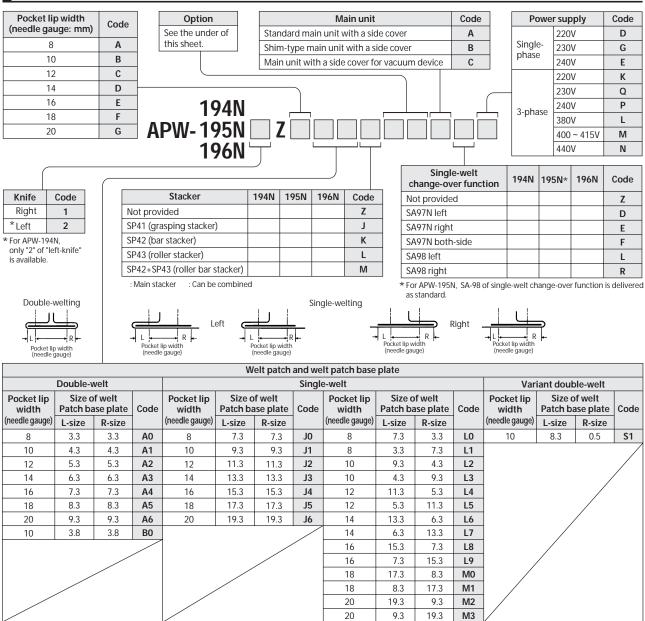
The machine is provided as standard with a turrettype set of seven pairs of corner knives that can be quickly selected and switched over in a single-motion. Sewing of welts requiring different cutting angles and depths can be easily set to respond to the pattern invoked on the operation panel.

### **SPECIFICATIONS**

	Mode	el name	APW-194N	APW-195N	APW-196N			
	IVIOUE	ername	For without pocket type	For flap sewing type	For slanted pocket sewing type			
Sewing speed			Normal 2,500rpm (1,000 ~ 2,500rpm)					
	Regular stitching		Standard: 2.0mm (2.0 ~ 3.4mm)					
Stitch length	Fastening	Safety stitching	Standard: 1.0mm (0.5 ~ 1.5mm)					
.o.g	stitching	Back-tack stitching		Standard: 2.0mm (1.0 ~ 3.4mm)				
Kinds of welts			Parallel double-welt, parallel single- welt parallel variant double-welt (without flaps)	Parallel double-welt, parallel single- welt parallel variant double-welt (with/without flaps)	Parallel double-welt, parallel single- welt slant double-welt, slant single- welt trapezoidal stitching (with/without flaps)			
Sewing	g length (we	It length)	* By using the corresponding opti	nm: 35 ~ 180mm, Needle gauge 14mm ional device, sewing length can be set t of 21mm or less, neither the center kni	to 18mm or more.			
	er of patterr in memory	s that can be		10 patterns				
Cycle s	ewing		Possible (max. 5 different patterns can be combined)					
Needle	gauge		8, 10, 12, 14, 16, 18, 20mm					
Needle (at the time of delivery)		e of delivery)	ORGAN Mt × 190 (#1 SCHMETZ 190R (Nm	ORGAN DP x 17 (#16) #16 ~ #18 SCHMETZ SY3335 (Nm100) Nm100 ~ Nm110				
Needle	bar stroke		34.4mm 33.4mm					
Thread			SPUN #50					
Hook			Vertical-axis full-rotary 1.6 fold-capacity hook					
Machir	ne head				2-needle, lockstitch machine with an organized split needle bar and a center knife			
Thread	l take-up		Slide type					
Lubrica	ation		By an oiler (machine head and hook)					
Lubrica	ating oil		JUKI New Defrix Oil No.2 (equivalent to ISO VG32)					
Cloth f	eed system		By a servomotor drive					
Bobbin thread remaining amount detecting device		naining amount	Provided as standard					
Power consumption			500W					
Compr	essed air an	d air consumption		0.5MPa (5.0kgf/cm²), 40NQ/min				
Total w	/eight		200kg 220kg					
Dimensions (excluding the stacker)			735mm (W) × 1,250mm (D) × 1,200mm (H)					
Height	of table			820mm				

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### WHEN YOU PLACE ORDERS



	Options									
	O: Can be attached to the machine S: Provided as standard (not included in options) with the machine									
			APW-194N	1		APW-195N	l		APW-1941	1
Code	Name of optional devices		Table type	•		Table type			Table type	ڊ ا
		Standard	Shim	Vacuum	Standard	Shim	Vacuum	Standard	Shim	Vacuum
ZZ	Not provided									
A2	SA84 Dart stretcher	0	0	0	0	0	0	0	0	0
A6	SA92 Pocket bag clamping device		S							
A7	SA88 Table stand for standing work	0	0	0	0	0	0	0	0	0
A8	SA89 Small welt sewing device									
B1	SA94 Center reference device	0	0	0	0	0	0	0	0	0
B8	SA84/SA92									
E9	SA101 Pocket bag clamping device	S		S	0		0	0		0
F1	SA84/SA101									
F3	SA84/SA89/SA90N/SA101						0			0
G0	SA86N Automatic interlining feeder									
G1	SA84/SA86N	0		0	0		0	0		0
G2	SA86N/SA89									
G3	SA90N Suction device			0			0			0
G4	SA90N/SA91									
G5	SA96N Flap presser device	0	0	0						
G6	SA84/SA96N									
G7	SA88/SA96N	0	0	0						
H1	SA84/SA92/SA90N									

### OPTIONS

Model	Part No.	Description	Feature
SA84	GSA-840000A0A	Dart stretcher	The dart stretcher holds the end of the material when making a welt on a darted part of the material to make it easier to set the darted part and improve the reliability of the welting.
	GSA-85000DA0B	Needle gauge: 8, 10, 12mm	Shim device
SA85N	GSA-85000EA0B	Needle gauge: 14, 16mm	This device encloses a garment body between its upper and lower parts and feeds it to the needle entry area. It is especially useful for difficult-to-feed
	GSA-85000FA0B	Needle gauge: 18, 20mm	garment bodies.
CAO/N	GSA-86000DA0	Needle gauge: 8 ~ 16mm	Automatic interlining feeder
SA86N	GSA-86000EA0	Needle gauge: 18, 20mm	To improve workability, the automatic interlining feeder automatically delivers rolled interlining cloth onto the table and cuts it.
SA88	GSA-880000A0	Stand for standing work	This stand is mounted under the main body of the machine to adjust the height of the main body to standing work.
SA89	GSA-890000A0A	Small-welt sewing device	This device is designed for the sewing of small welts as short as 35mm or less. The smallest possible welt size is 18mm. (Neither the center knife nor corner knife can be used for welts measuring 21mm or less.)
	GSA-90000GA0	Needle gauge: 8 ~ 12mm	Suction device (for sim type table)
SA90N	GSA-90000HA0	Needle gauge: 14, 16mm	The device picks up the garment body by suction force to facilitate setting of materials on the machine.
	GSA-90000IA0	Needle gauge: 18, 20mm	Use the device with a suction motor (SA91).
SA91	GSA-910000A0	Suction motor (for sim type table)	This is the blower motor for the suction device (SA90N).
SA92	GSA-920000A0	Automatic pocket bag presser (for sim type table)	The automatic pocket bag presser is used to hold pocket bags under the garment body when welting and pocket bag sewing are performed
SA101		Automatic pocket bag presser (for standard table and vacuum type table)	concurrently. * This device equipped as standard for APW-194N. (SA92 or SA101)
SA94	GSA-94000CA0	Center reference device	This optional device is useful to sew welts oriented longitudinally from the center of maximum-sized welts. It is intended for the sewing of welts with darts placed in the direct front-to-back center of the welting length.
SA96N	GSA-96000AA0B	Needle gauge: 8 ~ 14mm	The device is effective when used for souring welts with flags
JATON	GSA-96000BA0B	Needle gauge: 16 ~ 20mm	The device is effective when used for sewing welts with flaps.
	GSA-97000GA0A	Needle gauge: 8 ~ 14mm (for left)	Single-welt and double-welt change-over device (for APW-195N, APW-196N)
	GSA-97000HA0A	Needle gauge: 16 ~ 20mm (for left)	The clamp foot can be moved by fingertip control. The sewing machine is well suited for the sewing of welts on upper garments since its specification can be
SA97N	GSA-97000IA0A	Needle gauge: 8 ~ 14mm (for right)	easily changed over between double-welt type and single-welt type simply by
0,1,7,11	GSA-97000JA0A	Needle gauge: 16 ~ 20mm (for right)	changing a binder. The machine comes in three different types: the left single- welt type for sewing left single-welts, the right single-welt type for sewing right
	GSA-97000IA0A	Needle gauge: 8 ~ 14mm (for double)	ones, and the double-side welt type designed to change over the welt type
	GSA-97000JA0A	Needle gauge: 16 ~ 20mm (for double)	between the left and right single-welt types.
SA98	GSA-980000A0	Single-welt and double-welt change-over device	The clamp foot can be shifted by a simple one-touch operation. Changeover between double-welt and single-welt sewing can be easily accomplished by replacing the binder. The single-welt changeover function comes in two different types: the right-hand single-welt type and left-hand single-welt type. * This device equipped as standard for APW-195N.
SP41		Grasping stacker	The general-purpose stacker has a wide range of applications, including men's wear, ladies' wear, sportswear, jumpers, etc.
SP42		Bar stacker	This stacker is suited to welting on the hip pockets of slacks, pants of working uniforms, etc.
SP43		Roller stacker	This is a stacker suited for small articles that cannot be feed by a bar stacker or grasping stacker.
		·	

# SEWING MACHINE COMPONENTS

Needle gauge	Throat plate asm.		Needle clamp asm.	Knife	Needle thread counter knife	Needle thread clamp plate	
				0	Ĩ	0	
I I V	For knife, left	For knife, right*	and a	$\mathcal{D}$			
1	Part No.	Part No.	Part No.	Part No.	Part No.	Part No.	
8mm (5/16")	164-01150	164-02356	G1402-116-JA0	251-37100			
10mm (25/64")	164-01259	164-02455	G1402-116-BA0	231-37100			
12mm (15/32")	164-01358	164-02554	G1402-116-CA0	164-09500	164-09906	164-10201	
14mm (35/64")	164-01457	164-02653	G1402-116-DA0	104-09300	104-09900	104-10201	
16mm (5/8")	164-01556	164-02752	G1402-116-EA0	164-10508			
18mm (45/64")	164-01655	164-02851	G1402-116-FA0	104-10306			
20mm (25/32")	164-01754	164-02950	G1402-116-GA0	164-11100	164-11308	164-11407	

* For APW-195N, APW-196N

### WELT PATCH BASE PLATE COMPONENTS

		1	
R		_	
С		р- , Ь_	(
L			
	Welt pa	ich ruler	







Clamp foot collar setscrew

	Single-welt					
		Welt pach ruler Clamp foot spacer		Clamp foot collar setscrew	Foot collar	
Needle gauge	Size (mm)	Part No.	Т	Part No.	Part No.	Part No.
	L 7.3	253-11713	7	169-15506		
	R 7.3	203-11713	7	169-15506		
8mm (5/16")	L 7.3	253-12414	7	169-15506		
	R 3.3	203-12414	3	169-15100		
	L 3.3	050 10115	3	169-15100		
	R 7.3	203-13110	253-13115 7 169-15506 SM 6052002 TD	SM-6052002-TP		
	L 9.3	253-11812	9	169-15605	SIVI-8052002-TP	
	R 9.3	253-11812	9	169-15605		
10mm (25/64")	L 9.3	253-12513 —	9	169-15605		
1011111 (25/64 )	R 4.3		4	169-15209		
	L 4.3	253-13214	4	169-15209		
	R 9.3	203-13214	9	169-15605		
	L 11.3	253-11911	11	169-15704		
	R 11.3	203-11911	11	169-15704	SM-6052502-TP	
10mm (12/20")	L 11.3	050 10/10	11	169-15704		169-08709
12mm (13/32")	R 5.3	253-12612	5	169-15308		(L=31)
	L 5.3	050 40040	5	169-15308	SM-6052002-TP	
	R 11.3	253-13313	11	169-15704		
14mm (35/64")	L 13.3	253-12018	13	169-15803	SM-6052502-TP	
	R 13.3		13	169-15803		
	L 13.3	253-12711	13	169-15803		
	R 6.3		6	169-15407		
	L 6.3		6	169-15407	SM-6052002-TP	
	R 13.3	253-13412	13	169-15803	SM-6052502-TP	
	L 15.3	050 40447	22	169-16009		
	R 15.3	253-12117 22		169-16009	SM-6053502-TP	
1 ( (5 (0))	L 15.3	050 10010	22	169-16009		
16mm (5/8")	R 7.3	253-12810	14	169-15902		
	L 7.3	050 40544	14	169-15902	SM-6053002-TP	
	R 15.3	253-13511	22	169-16009	SM-6053502-TP	
	L 17.3	DED 1001/	24	169-19201		
	R 17.3	253-12216	24	169-19201	SM-6053002-TP	
10mm (4E/(4")	L 17.3	252 12010	24	169-19201	7	
18mm (45/64")	R 8.3	253-12919	15	169-19102		
	L 8.3	252 12/10	15	169-19102	SM-6052002-TP	
	R 17.3	253-13610	24	169-19201		169-19003
	L 19.3	252 10215	26	168-95609		107-17003
	R 19.3	253-12315	26	168-95609		
20	L 19.3	050 4004 (	26	168-95609		
20mm (25/32")	R 9.3	253-13016	16	169-19300		
	L 9.3	050 10710	16	169-19300	SM-6052002-TP	
	R 19.3	253-13719	26	168-95609	SM-6053002-TP	

			Double-welt					
			Welt pach ruler	Clamp foot spacer (right and left each one)				
Needle gauge	Siz	ze (mm)	Part No.	Т	Part No.	Part No.	Part No.	
8mm (5/16")	L	3.3	253-11010	3	169-15100			
01111 (5/10.)	R	3.3	255-11010	5	109-15100			
10mm (25/64")	L	4.3	253-11119	4	169-15209			
1011111 (23/04 )	R	4.3	255-11117	4 107-13207	SM-6052002-TP			
12mm (13/32")	L	5.3	253-11218	5 169-15308	160-15308	5101-0052002-11	169-08709	
1211111 (13/32 )	R	5.3	255-11210			107-00707		
14mm (35/64")	L	6.3	253-11317	6 169-15407	169-15/07			
1411111 (55/04 )	R	6.3	200-11017					
16mm (5/8")	L	7.3	253-11416	14 169-15902	14 140 15000			
	R	7.3	255-11410					
18mm (45/64")	L	8.3	253-11515	15	169-19102	SM-6053002-TP		
101111 (43/04 )	R	8.3	200 11010	13 109-19102		3IVI-0033002-1P	169-19003	
20mm (25/32")	L	9.3	253-11614	16	169-19300		107-17003	
201111 (23/32)	R	9.3	233 11014	10	107 17500			

APW-194N, 195N, 196N (June, 2001) **4/4** Downloaded from <u>www.Manualslib.com</u> manuals search engine

#### Automatic 2-needle Belt-loop Attaching Machine

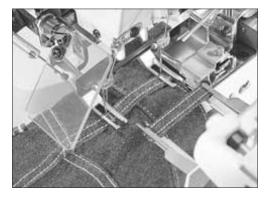
# MOL-254

- The new machine head specifically developed for belt-loop attaching machines runs at a maximum sewing speed of 2,500rpm and is equipped with a direct-drive system that improves startup performance and shortens sewing time.
- The belt-loop feeding device is now provided with a halfway standby capability for subsequent belt-loops, and its faster belt-loop supply action shortens the time required for supplying belt-loops and helps speed up the machine time to 1.2 seconds per belt-loop (with 28 stitches).
- Belt-loops are fed out by the conventional gear-roller feeding mechanism and also drawn out by the new drawing mechanism on the clamp device. Supported by these two mechanisms, the folding fork catches "curled" or "creased" belt-loops every time and supplies them to the head.
- The machine preliminarily detects each splice in the belt-loops and efficiently disposes them. This means that even when the machine carries out the splice-disposal procedure, the belt-loop feeding device can complete its belt-loop supply action and supply the next belt-loop well before the machine starts to sew. As a result, the operator can perform rhythmical and efficient sewing work with no delay in cycle time.
- The number of stitches to sew a belt-loop can be switched between; 28-, 36- and 42-stitches, and the bartacking size can be easily changed through the operating panel. What's more, the user can create his/her own original sewing patterns in addition to the standard ones using JUKI's PGM-20 programming software developed for computer-controlled sewing machines.



MOL-254

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### **SPECIFICATIONS**

Model name	MOL-254
Machine head	Computer-controlled, 2-needle, lockstitch bartacking machine
Max. sewing speed	2,500rpm
Thread take up	Link type
Needle bar stroke	45.7mm
Thread	Spun thread, cotton thread #50 ~ #30, B33 ~ B46, Nm=120/3 ~ 60/3
Needle (at the time of delivery)	DP × 17 (#21) #19 ~ #21
Hook	Horizontal-axis 1.8 fold-capacity shuttle hook
Lift of the presser foot	21mm
Number of stitches	28, 36, 42 (selectable on the operating panel)
Needle gauge	40 ~ 70mm (1-37/64" ~ 2-3/4")
Bartacking length	7 ~ 22mm (9/32" ~ 55/64") adjustable in increments of 0.1mm
Bartacking width	1 ~ 3.2mm (3/64" ~ 1/8") adjustable in increments of 0.1mm
Number of pieces of bartacking data that can be stored in memory	9 (99 patterns if optional ROM is added)
Belt-loop width	9 ~ 20mm (23/64" ~ 25/32")
Finished length of belt-loop	48 ~ 78mm (1-57/64" ~ 3-5/64")
Machine time	1.2 sec./belt-loop (28 stitch)
Positioning of the front hook	Driven by motor (the distance between the hook can be established in increments of 0.01mm)
Bobbin winder	Electric type (provided as standard)
Lubrication	Centralized oil wick lubrication (machine head)
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)
Power requirement and power consumption	Single-/3-phase, 350VA
Compressed air and air consumption	0.5MPa (5kgf/cm ² ), 32NQ/min
Total weight	230kg
Dimensions	1,200mm (W) × 800mm (D) × 1,350mm (H: in its lowest end)
Height of the top surface of the throat plate as from the floor surface	920 $\sim$ 1,250mm (provided with the adjustable stand capability)

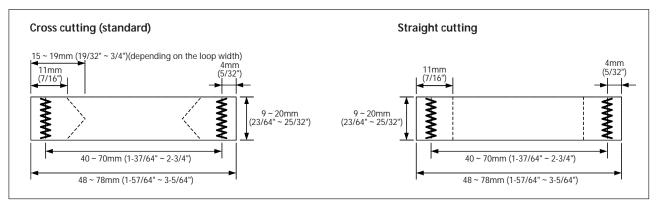
### WHEN YOU PLACE ORDERS

MOL-254							
Powe	er supply	Code		Option		Code	
	200 ~ 240V	D	N	o options		Z	
Single-/3-phase	220 ~ 400V	L	B	elt-loop tension releasing c	levice (fullness)	Α	
	220 ~ 400V (For CE)	М	B	elt-loop feeding device		В	
			A	ir gun		С	
			N	eedle cooler		D	
			N	eedle thread breakage det	ector	E	

* Enter codes of required options in alphabetical order.

### FINISHED BELT-LOOP STITCH SIZE

- The applicable loop width for the cross-cutting device is increased. In this model, both the cross-cutting device and the straight-cutting device can now cut loop up to 20mm width.
- * The machine is factory-equipped with a cross-cutting device at the time of delivery.



### OPTIONS

Part No.	Description	Feature
G5700-254-0A0	Belt-loop tension releasing (fullness)	The device slackens the belt-loop when attaching it on the garment body.
G5730-254-0A0	Belt-loop feeding device (belt-loop slackener)	The cylinder type belt-loop feeding device supports the belt-loop feeding of the main unit.
G5760-254-0A0	Air gun assembly	
G5770-254-0A0	Needle cooler	The device cools the frictional heat generated by the needle during sewing.
G5780-254-0A0	Needle thread breakage detector	The device detects breakages in the needle thread by means of a thread take-up spring. If a needle thread breakage is detected, the device halts the sewing of the next loop.

### **MAJOR SPARE PARTS**

Part No.	Description	Remarks
G5412-254-000	Upper knife (loop cut knife)	Exclusive to MOL-254
B1818-210-D0B	Shuttle, H type	Also used with the AMS-210D
B1817-210-DAC	Shuttle race ring complete, C type	Also used with the AMS-210D
138-82501	Needle hole guide	Also used with the MOL-154
138-81255	Moving knife junction	Also used with the MOL-154
138-81008	Lower plate blank	Also used with the MOL-154
HL-0084230-00	EP-ROM for data	Also used with the LK-1900

1-needle, Lockstitch Machine for Leather and Heavy-weight Materials

# DDL-8700L

- This is a newly designed JUKI's unique lockstitch machine. The machine is able to sew at a pitch as long as 7mm for both normal and reverse feed directions. With the adoption of a feed mechanism and thread take-up lever, the machine achieves increased efficiency of feed and well-tensed stitches. It is a basic lockstitch machine suited for the sewing of leather or heavy-weight sewing products such as bags, pouches and purses.
- The machine head was remodeled to achieve an optimumly balanced and highly rigid machine head frame. With its reduced vibration and noise and easy operation of the feed lever at the time of reverse stitching, the machine promises to make sewing work more comfortable.

The wider distance from the machine arm to the needle on the front of the machine head, smoothened design of the machine head, larger needle bar stroke (35mm), and higher lift of the presser foot (13mm) enable easy handling of heavy-weight material. In addition, the machine is equipped with a handwheel that is larger than normal for easy turning.

• By adopting the locus best suited to the sewing of leather and heavy-weight materials, the machine smoothly feeds heavy-weight materials without stitch gathering even on multi-layered portions. The machine also uses a Teflon presser foot that offers sharp-curve sewing capability to prevent from scratch on the material.



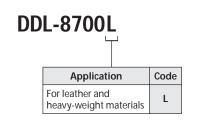
Model name	DDL-8700L		
Max. sewing speed	4,000rpm (for stitch length less than 5mm) 3,500rpm (for stitch length up to 7mm)		
Max. stitch length	7mm (normal/reverse feed)		
Needle bar stroke	35mm		
Lift of the presser foot	By hand: 5.5mm, By knee: 13mm		
Needle (at the time of delivery)	DB × 1 (#21) #16 ~ #23 or DP × 5		
Presser foot	Teflon presser foot		
Feed dog	3-row		
Hook	Automatic-lubricating full-rotary hook		
Lubrication	Automatic		
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)		
Weight of the machine head	28kg		



DDL-8700L



### WHEN YOU PLACE ORDERS



1-needle, Top & Bottom-feed, Lockstitch Machine

# DU-140 DU-141NH (with a double-capacity hook) $DU-141H-7 \ ({\rm with \ a \ double-capacity \ hook \ and \ an \ automatic \ thread \ trimmer} \ )$

- With its unique thread take-up mechanism, feed mechanism, and hook, the machine feeds difficult-to-feed materials and multilayered portions of material with great precision, thereby producing beautifully finished seams of consistent quality.
- The stitch length is adjusted in the range of 0 to 9mm both in the normal and reverse directions by operating the stitch dial. This feature allows the machine to be used in wider applications such as decorative stitching, which requires a larger pitch and sewing of tent sheets. The reversefeed sewing length is also adjustable.

#### DU-141H-7

The knife is driven by a thread trimming cam ideal for cutting thick threads at a sharp angle.

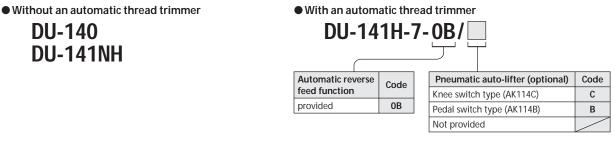


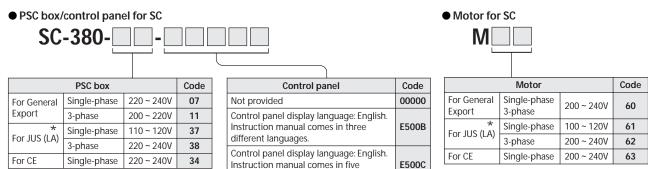
DU-141H-7-0B/XC-E500

### **SPECIFICATIONS**

Model name	DU-140	DU-141NH	DU-141H-7			
	D0-140		D0-1411-7			
Max. sewing speed	2,000rpm					
Max. stitch length		9mm (normal/reverse feed)				
Needle bar stroke	35mm 37mm					
Lift of the presser foot	By hand: 7mm,	By knee: 15mm	By hand: 6mm, By knee: 15mm			
Thread take-up		Link type				
Alternating vertical movement		2 ~ 5mm				
Hook	Horizontal-axis full-rotary hook	III-rotary hook Horizontal-axis full-rotary double-capacity hook				
Needle (at the time of delivery)	DB x 1 (DP x 17) (#21) #14 ~ #23 DB x 1 (DP x 17) (#21) #14 ~ #23, For JE: 1738 (Nm130)					
Thread	#40 ~ #8, B33 ~ B92, Nm=90/3 ~ 30/3					
Lubrication		By an oiler (hook: automatic)				
Lubricating oil	JUK	(I New Defrix Oil No.1 (equivalent to ISO V	G7)			
Distance from needle to machine arm	265mm	270	mm			
Bed size		477mm × 178mm				
Weight of the machine head	32	34kg				
Automatic reverse feed function			Provided as standard			
Power requirement			Single-phase 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V			

### WHEN YOU PLACE ORDERS





different languages.

* JUS: North America and Central and South America.

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Do

# EXCHANGEABLE GAUGE PARTS

### ● For DU-140, DU-141NH, DU-141H-7, DU-580

Description	Throat plate	Feed dog	Notes
Standard	D1109-560-E00 (D=2.6) D1109-560-E0A (D=4.2) D1109-560-E0B (D=3.0)	D1613-560-E00	Stitch length: max. 8mm
	B1109-201-H0B (D=3.5) B1109-555-H0B (D=2.6)	B1609-201-000A	Stitch length: max. 8mm
		B1609-201-000B	Stitch length: max. 10mm
	B1105-141-000 (D=2.0) B1105-141-H00 (D=2.6)	В1613-141-НООА	Stitch length: max. 9mm
Single-lined feed dog for sewing gloves and shoes	114-05800	114-05701	Exclusive parts Roller presser foot asm for DDL: B1524-560-RB0 Narrow type walking foot for DU: B1526-141-HAB B1526-141-H0T

### • For DU-140, DU-141NH, DU-141H-7

Description	Wall	king foot	Presser foot	Notes
Standard	B1526-141-H0A	The second se	B1525-141-HA0	
For piping	B1527-141-H0		В1527-141-НАО	Piping size B: 3.2mm (1/8") F: 6.4mm (1/4") C: 4.0mm (5/32") H: 7.9mm (5/16") D: 4.8mm (3/16") K: 9.5mm (3/8") E: 5.6mm (7/32")
Cut-out tail for piping	B1528-141-H0	Î,		
Double groove	B1529-141-H0		B1526-141-HAW	Piping size B: 3.2mm (1/8") F: 6.4mm (1/4") C: 4.0mm (5/32") H: 7.9mm (5/16") D: 4.8mm (3/16") K: 9.5mm (3/8") E: 5.6mm (7/32")
Left-hand	B1526-141-H0Q		B1526-141-HAU	
Right-hand	B1526-141-HOR		B1526-141-HAS	
Narrow type for sewing gloves and shoes	B1526-141-H0T	Ľ	B1526-141-HAB	Stitch length: max. 6mm Exclusive parts Feed dog: 114-05701 Throat plate: 114-05800
For attaching zippers	B1527-141-H0X	J.	B1526-141-HOX	Without hardening (blank)

DU-140, 141NH, 141H-7 (June, 2001) **2/2** Downloaded from <u>www.Manualslib.com</u> manuals search engine 1-needle, Unison-feed, Lockstitch Machine with a Large Hook

# DNU-241H DNU-241HS (with a safety device for hook) DNU-241H-7 (with an automatic thread trimmer)

- The unison-feed mechanism feeds the material strongly and smoothly, achieving consistent seam quality (max. stitch length of 8mm).
   The mechanism demonstrates its features particularly well in piping and binding tape attachment processes.
- The attachment is essential when sewing heavy-weight materials. The machine is equipped with an attachment mounting seat.
- The double-capacity hook allows the frequency of bobbin winding to be reduced and leading to a higher degree of efficiency.

#### • DNU-241HS

When the thread is caught in the hook or any other sewing trouble occurs, the safety device for hook will automatically operate to prevent the machine from being damaged.

#### • DNU-241H-7

Consisting only of a moving knife and counter knife, the simple and well-balanced thread trimming mechanism is capable of cutting thick thread up to #8 without fail.



DNU-241H



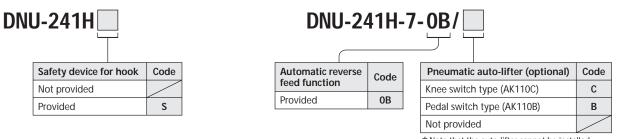
DNU-241H-7-0B/XC-E500

SPEC		TION	S
JALE	лгіса		3

Model name	DNU-241H	DNU-241HS	DNU-241H-7
Max. sewing speed	2,000	Orpm	2,400rpm
Max. stitch length		8mm (normal/reverse feed)	
Needle bar stroke	33.4	mm	38mm
Lift of the presser foot	By hand: 9mm,	By knee: 12mm	By hand: 9mm, By knee: 15mm
Thread take-up		Slide type	
Alternating vertical movement		3 ~ 6mm	
Hook	Horiz	zontal-axis full-rotary double-capacity	hook
Needle (at the time of delivery)	DP × 17 (#23)#16 ~ #23		DP × 17 (#23)#16 ~ #23 For JE: 135 × 17(Nm160)
Thread	#40 ~ #8, B33 ~ B92, Nm=90/3 ~ 30/3		
Safety mechanism	Provided as standard		
Lubrication	By an oiler (hook: automatic)		
Lubricating oil	JUKI New Defrix Oil No. 1 (equivalent to ISO VG7)		
Distance from needle to machine arm	264mm		
Bed size	477mm × 178mm		
Weight of the machine head	31kg		35kg
Automatic reverse feed function			Provided as standard
Power requirement	Single-phase 100 ~ 120V, 220 ~ 3-phase 200 ~ 220V, 220 ~ 240V		

### WHEN YOU PLACE ORDERS

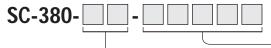
#### • Without an automatic thread trimmer



With an automatic thread trimmer

* Note that the auto-lifter cannot be installed on the machine after the set-up.

#### • PSC box/control panel for SC



PSC box			
For Conoral Export	Single-phase	220 ~ 240V	07
For General Export	3-phase	220 ~ 220V	11
For JUS (LA)*	Single-phase	110 ~ 120V	37
FOI JUS (LA)	3-phase	220 ~ 240V	38
For CE	Single-phase	220 ~ 240V	34

Control panel	
Not provided	00000
Control panel display language: English. Instruction manual comes in three different languages.	E500B
Control panel display language: English. Instruction manual comes in five different languages.	E500C

#### Motor for SC



Motor				
For General Export	Single-phase 3-phase	200 ~ 240V	60	
For JUS (LA)*	Single-phase	100 ~ 120V	61	
FOI JUS (LA)	3-phase	200 ~ 240V	62	
For CE	Single-phase	200 ~ 240V	63	

* JUS: North America and Central and South America.

### EXCHANGEABLE GAUGE PARTS

### • For DNU-241H(S), DNU-241H-7

Description	Throat plate	Feed dog	Notes
Standard (without groove)	B1105-241-H00A	D1613-241-E00	Needle hole: 4 × 2.5mm
For thin needles		D1613-241-EOA	Needle hole: 2.6 × 2.2mm
With groove		D1613-241-EOB	Needle hole: 4 x 2.5mm

#### • For DNU-241H(S), DNU-241H-7, DNU-261H

Description	Pre	esser foot	Walking foot	Notes
Standard	B1525-241-HA0	le la	В1470-241-НАО	6.2 6.2
	B1525-053-0A0	e la	B1470-053-000 (D=2.8) B1470-053-C00 (D=2.3)	For LU & LS Stitch length: max. 10mm
	B1525-562-BA0	0	B1470-562-B00	4.5
	B1525-563-E00	e	B1470-563-E00	2.3 ₁₀ Stitch length: max. 10mm
Left-hand type	B1524-245-0A0	e	B1470-245-000	DSC-245(-7), 246(-7) standard Stitch length: max. 6mm
	B1529-245-0AD (special order)	le Hi	B1476-245-00D (special order)	4.1
	B1529-245-0AC (special order)		B1476-245-00C (special order)	4.1.5.7 Stitch length: max. 6mm
	B1529-245-0AB (special order)	le the second se	B1476-245-00B (special order)	Stitch length: max. 8mm With teeth

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#### • For DNU-241H(S), DNU-241H-S, DNU-261H

Description	B1529-245-0AF	ser foot	Walkin B1476-245-00F	91001	Notes Stitch length: max. 6mm
Left-hand type	(special order)	0 6.2 4	(special order)	2.16	With teeth
For binding	MAQ-092080A0 (with teeth)	0 0 8.3	MAQ-09207000	10	Stitch length: max. 10mm
	MAQ-093080A0 (with teeth)	(a)	MAQ-09307000	5 85 <b>(</b>	DSC-246V(-7) standard Stitch length: max. 10mm
		8.3	MAN-10452000	The the	DSC-245V(-7) standard Stitch length: max. 10mm
Right-hand type	B1529-245-00A	0.7.5	B1476-245-00A	2.2 5.5	Stitch length: max. 8mm With teeth
Wide type	103-25157	e f	103-25306	2.3 2.8	Stitch length: max. 10mm Exclusive parts (for LU-1114) Throat plate: 103-25009 Feed dog: 103-25207
For leather (without teeth)	103-26304	o H	103-26205	2.3 L 2.3 L 2.8	Stitch length: max. 6mm Without finger guard Exclusive parts (for LU-1114) Throat plate: 103-26403 Feed dog: 103-26106
For piping	B1530-245-00		B1478-245-000 (commonly used for every size)	V I	Stitch length: max. 8mm Piping size C : 4.0mm (5/32") H: 7.9mm (5/16") D: 4.8mm (3/16") K : 9.5mm (3/8") F : 6.4mm (1/4")
Cut-out tail for piping	B1531-245-00		B1478-245-00	T I	Stitch length: max. 8mm Piping size C : 4.0mm (5/32") D: 4.8mm (3/16") F : 6.4mm (1/4") H: 7.9mm (5/16")
For piping (with knurled foot)	B1525-245-00		B1472-245-00		Stitch length: max. 8mm Piping size D: 4.8mm (3/16") F : 6.4mm (1/4") H: 7.9mm (5/16") K : 9.5mm (3/18")
	B1526-245-00	La La	B1473-245-00	Lugar.	Stitch length: max. 8mm Piping size D: 4.8mm (3/16") F : 6.4mm (1/4")
	B1527-245-00 (special order)		B1474-245-00 (special order)		Stitch length: max. 8mm Piping size C : 4.0mm (5/32") H: 7.9mm (5/16") D: 4.8mm (3/16") K : 9.5mm (3/8") F : 6.4mm (1/4")
Double groove	B1528-245-00		B1475-245-00B (commonly used for every size)	K.	Stitch length: max. 8mm Piping size B : 3.2mm (1/8") H: 7.9mm (5/16") D: 4.8mm (3/16") K : 9.5mm (3/8") F : 6.4mm (1/4")

# LU-1508 LU-1508H (for extra heavy-weight materials) LU-1510 (with an automatic lubricating mechanism) LU-1510-7 (with an automatic lubricating mechanism and an automatic the

• The new mechanism with a rectangular feeding motion promises consistent feed of materials of all thickness without stitch gathering.

The lower orbit of the feed dog prevents the material from flopping and reduces operating noise and vibration.

#### Rectangular feed LU-1508, LU-1510, LU-1510-7

Compared with the elliptical feed, the rectangular feed helps reduces gathered stitches.

#### Complete rectangular feed LU-1508H

The locus of the "needle" and "feed" motions are nearly rectangular. This prevents stitch gathering and provides efficient feed on multi-layered portions of material.

- With the adoption of a new rectangular feed mechanism, an alternating vertical movement mechanism, and a unisonfeed mechanism, the machine can feed heavy-weight materials powerfully and smoothly. Well tensed seams are consistently produced without pitch errors.
- Even when a heavy-weight material is used, the presser foot lift does not decrease. This means that the presser foot comes into contact with the material at exactly the same time that it does when sewing lighter-weight sections of the material. As a result, the walking foot retains the material with a consistent pressure to prevent irregular stitches.

#### ● LU-1508H

- The maximum stitch length is 10mm. The complete rectangular feed locus enables accurate feed of extra heavyweight materials while preventing stitch gathering.
- · With its sufficient needle bar stroke of 38mm and long 190R needle, the machine supports the sewing of extra heavyweight materials.
- · The machine comes with an extra large steel handwheel with a diameter as large as 175.



LU-1510-7-0BB/XC-E500

#### • LU-1510, LU-1510-7

- · The machine is equipped with a bottom-feed adjusting mechanism that adjusts the amount of bottom-feed while keeping the needle-feed fixed. With the mechanism, the machine can prevent uneven material feed without changing stitch pitches.
- · Automatic lubricating mechanism improves maintainability. The machine is provided with a sub oil pan and double filter to keep dust from entering the oil.

#### • LU-1510-7

- The machine comes with JUKI's proven thread trimming mechanism. With its robust knife and cam configuration, the thread trimmer reliably cuts threads as thick as #5.
- · The vertical strokes of presser foot and walking foot (their alternating vertical movement) can be easily changed using a large dial mounted on the top surface of the machine head.
- · In addition the sewing speed is automatically adjusted with the set value. With this feature, ideal sewing conditions are maintained at all times.

## WHEN YOU PLACE ORDERS

 With an automatic thread trimmer Without an automatic thread trimmer Motor for SC LU-1510 LU-1510-7-0B IU-1508 Application Code Pneumatic auto-lifter Code Motor Code Standard Knee switch type (AK119A) For General Single-phase Α 200 ~ 240V 60 3-phase Export For extra heavy-weight Pedal switch type (AK119B) В н Single-phase materials 100~120V 61 Not provided For JUS (LA) 3-phase 200 ~ 240V 62 • PSC box/control panel for SC For CE Single-phase 200 ~ 240V 63 SC-380-PSC box Code **Control panel** Code Single-phase 220 ~ 240V 07 Not provided 00000 For General Export 3-phase 200~220V 11 Control panel display language: English.

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Instruction manual comes in three different languages

Instruction manual comes in five different languages.

Control panel display language: English.

For CE	Single-phase	220 ~ 240V	
FOI JUS (LA)	3-phase	220 ~ 240V	
For JUS (LA)*	single-phase	110~1200	

* JUS: North America and Central and South America.

E500B

E500C

# SPECIFICATIONS

Model name	LU-1508	LU-1508H	LU-1510	LU-1510-7		
Application	For heavy-weight materials	For extra heavy-weight materials	For heavy-weight materials			
Max. sewing speed	2,500rpm	2,000rpm	2,500rpm	3,000rpm		
Max. stitch length	9mm (normal/reverse feed)	10mm (normal/reverse feed)	9mm (normal/reverse feed)			
Needle bar stroke	36mm	38mm	36mm			
Lift of the presser foot		By hand: 9mm, By	knee: 16mm (max)			
Alternating vertical movement		2.5 ~ 6.5mm		1 ~ 6.5mm		
Dial for adjustment of alternating vertical movement				Provide as standard		
Thread take-up		Slide	type			
Hook		Vertical-axis doub	le-capacity hook			
Needle (at the time of delivery)	135 × 17 (Nm160) Nm125 ~ Nm180 DP × 17 #23	Standard 190R or 135 × 17 (Nm160) Nm125 ~ Nm180 MT190 #23	135 x 17 (Nm160) Nm125 ~ Nm180 DP x 17 #23			
Thread	#30~#5, B46 ~ B138 Nm=60/3 ~ 20/3	#20~#1, B69 ~ B207 Nm=40/3 ~ 15/3	#30~#5, B46 ~ B138 Nm=60/3 ~ 20/3			
Feed dog motion	Rectangular	Complete rectangular	Rectangular			
Feed differential			Provided as standard			
Handwheel	Large, aluminum	Extra large, steel	Large, a	luminum		
Pitch changing method		Вус	lail			
Bobbin winder		Built on the n	nachine head			
Knee-lifter mechanism		Built on the n	nachine head			
Safety mechanism		Provided a	s standard			
Lubrication	By an oiler (ho	ok: automatic)	Auto	matic		
Lubricating oil		JUKI New Defrix	c Oil No.1 (equivalent to ISO V	G7)		
Distance from needle to machine arm/Bed size		255mm/517n	nm × 178mm			
Weight of the machine head	42.5kg	44.5kg	43kg	48kg		
One-touch type reverse feed function		Option		Provided as standard		
Compressed air and air consumption			0.5MPa (5kgf/cm ² ), 0.3NQ/min			
Power requirement				Single-phase 110 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V		

# OPTIONS

Model	Part No.		Description	Feature	
AK119A	GAK-A19010A0	Knee switch type Pneumatic auto-lifter			
AK119B	GAK-A19010B0	Pedal switch type	Pheumatic auto-lifter	Applicable model: LU-1510-7	
AK120A	GAK-A20010A0	Knee switch type Pneumatic auto-lifter			
AK120B	GAK-A20010B0	Pedal switch type	(provided with an air regulator)	Applicable model: LU-1508, LU-1508H, LU-1510	
	213-48552	Pneumatic one-toucl (provided with an air	h type reverse feed stitching device regulator)	Applicable model: LU-1508, LU-1508H, LU-1510 * To use an auto-lifter and reverse feed stitching device in combination, select AK119A or AK119B	
	MAH-152010A0				
H152 SS-7151610-SP × 2 WP-0621016-SD × 2					
		Suspended ruler			
	WP-0610002-KN × 2			( Charles -	
	MAY-BL6B10A0	Core dia. 6 ~ 10mm	Disting holder		
	MAY-BL6B20A0	Core dia. 2 ~ 5mm	Piping holder		
PK75		3-pedal unit		Applicable model: LU-1510-7 Highly operable 3-pedal unit for standing work.	
	210-06507				
	NS-6110530-SP				
	210-06408	Additional spring for	presser bar		
	210-16101				
	210-06002 × 3				

## EXCHANGEABLE GAUGE PARTS

Description	Throat plate	Feed dog	Notes
Lower fittings standard	B1109-563-000 (area: 33.2 × 6.6)	213-49303 (needle hole: 2.5 x 7.2) (groove in front and back)	Equipped on LU-1508, LU-1508H, LU-1510 Stitch length up to 9mm (10mm in case of LU-1508H)
(equipped on machine)		213-49204 (needle hole: $2.5 \times 3.5$ ) (groove in front and back) $3.5 + 2.5 \times 2.5 = 20$	Equipped on LU-1510-7 Stitch length up to 9mm
Lower fittings standard		B1613-563-000 (needle hole: 2.5 × 7.2) (groove at back) 7.2 2.5	Equipped on LU-563N Stitch length up to 9mm Not applicable to LU-1510-7
Lower fittings (no groove)	B1109-053-00A (area: 31.7 × 6.6)	B1613-053-000 (needle hole: 2.5 x 7.2) (No groove) 7.2 2.5	Stitch length up to 9mm Not applicable to LU-1510-7
Lower fittings for thin needle		B1613-563-B00 (needle hole: 2.4) B1613-053-B00 (needle hole: 1.9)	Stitch length up to 9mm Not applicable to LU-1510-7
Fitting for piping	B1109-562-A00 (area: 31.7 × 8.8)	B1613-562-A00 (needle hole: 2.5 × 8)	Stitch length up to 9mm Not applicable to LU-1510-7
Lower fittings for tape binding	B1109-563-C00 (area: 30.2 × 6.8)	B1613-563-C00 (needle hole: 2.5)	Stitch length up to 7mm Not applicable to LU-1510-7
Description	Presser foot	Walking foot	Notes
	B1525-241-HA0	B1470-241-H00 (width: 6.2, needle hole: 2.8)	Equipped on LU-1508, LU-1508H LU-1510, LU-1510-7 Stitch length up to 10mm
	<b>e</b>	D1470-241-EOA (width: 6.2, needle hole: 2.8) (front-open)	Stitch length up to 10mm
Upper fittings standard		213-50004 (width: 6.2, needle hole: 2.8) (with groove, teeth at the toe)	Stitch length up to 10mm Suitable for thick thread.
	B1525-053-0A0	B1470-053-000 (width: 4.5, needle hole: 2.8)	Stitch length up to 10mm.
		B1470-053-C00 (width: 4.5, needle hole: 2.3)	Stitch length up to 10mm
	B1524-245-0A0 (width: 9.6mm)	B1470-245-000 (width: 6, needle hole: 2.2) (front-open)	Stitch length up to 6mm
Upper fittings left handed	B1529-245-0AC (width: 7.7mm) (with groove)	B1476-245-00C (width: 5.7, needle hole: 2.3) (with teeth)	Stitch length up to 6mm

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Description	Presse	r foot	Walking foot		Notes
Upper fittings	B1529-245-0AD (width 6.7mm) (with teeth)	4.9	B1476-245-00D (width 4.1, needle hole: 2.6) (with teeth)	Ĩ.	Stitch length up to 8mm
left handed	B1525-563-SAD (width 9.4mm) (with teeth)	e e	103-38309 (width 4.5, needle hole: 2.2) (with teeth at the toe)	1.2	Stitch length up to 10mm
	MAQ-093080A0 (width 17mm) (with teeth)	•	MAN-10452000 (width 13.5, needle hole: 2.5) (with teeth at the toe)		Stitch length up to 10mm
Upper fittings for binding		8.3	MAQ-09307000 (width 13.5, needle hole: 2.5)		Stitch length up to 10mm
	MAQ-092080A0 (width 13.5mm) (with teeth)	8.3	MAQ-09207000 (width 10, needle hole: 2.5)	Ĩ	Stitch length up to 10mm
Upper fittings right handed	B1529-245-00A (width 9.5mm) (with teeth)	7.5	B1476-245-00A (width 5.5, needle hole: 2.6) (with teeth)	Ű	Stitch length up to 8mm
	B1525-563-E00	<b>e</b> 15.5	B1470-563-E00 (width 10, needle hole: 2.5 × 5)	V	Stitch length up to 10mm
Upper fittings wide	103-25157	e 13	103-25306 (width 8, needle hole: 2.3)	Ŷ	Stitch length up to 10mm
	103-26304		103-26205 (width 8, needle hole: 2.3)		Stitch length up to 6mm
	В1530-245-0А * :[D, F, H, K]	16.4	B1478-245-000 (width 4.5, needle hole: 2.1) (universal, regardless of size)	V.	Stitch length up to 8mm Selection of presser foot: C : 4.0mm (5/32") D : 4.8mm (3/16") F : 6.4mm (1/4") H : 7.9mm (5/16") K : 9.5mm (3/8")
Upper fittings for piping	B1527-245-00 * :[C, D, F, H, K]	16.4	B1474-245-00 * :[D, F, H ,K] (width 13, needle hole: 2.4) (with teeth)		Stitch length up to 8mm Selection of presser foot: C : 4.0mm (5/32") D : 4.8mm (3/16") F : 6.4mm (1/4") H : 7.9mm (5/16") K : 9.5mm (3/8")
	B1525-245-0A * :[D, F, H, K] (width 16.6mm) (with teeth)	11.1	B1472-245-00 * :[D, F, H ,K] (width 8.2, needle hole: 2.7) (with teeth)		Stitch length up to 8mm Selection of presser foot: D : 4.8mm (3/16") F : 6.4mm (1/4") H : 7.9mm (5/16") K : 9.5mm (3/8")
Upper fittings for piping (back cut)	B1531-245-0A * :[D, F, H]		B1479-245-00 * :[D, F, H] (width 5.9, needle hole: 2.4)		Stitch length up to 8mm Selection of presser foot: D: 4.8mm (3/16") F : 6.4mm (1/4") H : 7.9mm (5/16")
Upper fittings for piping (double groove)	B1528-245-00 * :[B, D, F, H, K]		B1575-245-00B (width 4.5, needle hole: 2.1) (universal, regardless of size)	V	Stitch length up to 8mm Selection of presser foot: (width) B : 3.2mm (1/8") -19.0mm D : 4.8mm (3/16") -19.0mm F : 6.4mm (1/4") -19.0mm H : 7.9mm (5/16") -24.0mm K : 9.5mm (3/8") -22.5mm

LU-1508, 1508H, 1510, 1510-7 (June, 2001) 4/4 Downloaded from <u>www.Manualslib.com</u> manuals search engine

2-needle, Unison-feed, Lockstitch Machine with Vertical-axis Large Hooks

LU-1560 (with an automatic lubricating mechanism) LU-1565 (with an organized split needle bar) LU-1560-7 (with an automatic lubricating mechanism and an automatic thread trimmer)

 The new mechanism with a rectangular feeding motion promises consistent feed of materials of all thickness without the risk of stitch gathering.

The reduced lift of the feed dog helps prevent the material from flopping and reduces operating noise and vibration.

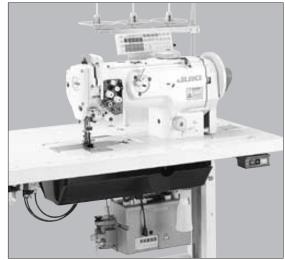
- **Rectangular feed** LU-1560, LU-1565, LU-1560-7 Compared with the elliptical feed, the rectangular feed helps reduce gathered stitches.
- With the adoption of a new rectangular feed mechanism, an alternating vertical movement mechanism, and a unison feed mechanism, the machine can feed heavy-weight materials powerfully and smoothly. Well tensed seams are consistently produced without pitch errors.
- The machine has adopted a new mechanism that does not change the ratio of alternate vertical movement of the walking foot and presser foot even when the material thickness changes.

Even when a heavy-weight material is used, the presser foot lift does not decrease. This means that the presser foot comes into contact with the material at exactly the same time that it does when sewing lighter-weight sections of the material. As a result, the walking foot retains the material with a consistent pressure to prevent irregular stitches.

#### • LU-1560, LU-1560-7

 Automatic lubricating mechanism improves maintainability. The sub oil pan and double filter prevent dust from entering the oil.

LU-1565



LU-1560-7-0BB/XC-E500

#### • LU-1560-7

- The machine comes with JUKI's proven thread trimming mechanism. With its robust knife and cam configuration, the thread trimmer reliably cuts threads as thick as #5.
- The vertical strokes of presser foot and walking foot (their alternating vertical movement) can be easily changed using a large dial mounted on the top surface of the machine head.
- In addition the sewing speed is automatically adjusted with the set value. With this feature, ideal sewing conditions are maintained at all times.

#### • LU-1565

- The organized split needle bar mechanism makes it possible to stop or reset the left or right needle by operating a onetouch utility lever.
- The machine produces neatly finished stitches at corner parts of the material.

## WHEN YOU PLACE ORDERS

Without an automatic thread trimmer

LU	-15	60		
			1	

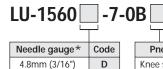
Needle gauge*	Code
4.8mm (3/16")	D
6.4mm (1/4")	F
7.9mm (5/16")	Н
9.5mm (3/8")	К
12.7mm (1/2")	L

Needle gauge*	Code
4.8mm (3/16")	D
6.4mm (1/4")	F
7.9mm (5/16")	Н

#### With an automatic thread trimmer

6.4mm (1/4")

7.9mm (5/16") 9.5mm (3/8") 12.7mm (1/2")



L

ode	Pneumatic auto-lifter
D	Knee switch type (AK119A)
F	Pedal switch type (AK119B)
Н	Not provided
К	

Code

Α

В

* The needle gauge (attached with a circle ( )) in the table below are prepared as optional parts (separately available).

		Needle gauge										
Model name	3.2mm (1/8")	4.8mm (3/16")	6.4mm (1/4")	7.9mm (5/16")	9.5mm (3/8")	12.7mm (1/2")	15.9mm (5/8")	19.1mm (3/4")	22.2mm (7/8")	25.4mm (1")	28.6mm (1-1/8")	31.8mm (1-1/4")
LU-1560												
LU-1560-7												-
LU-1565	-						-	-	-	-	-	-

#### • PSC box/control panel for SC



	Code		
For General	Single-phase	220 ~ 240V	07
Export	3-phase	200 ~ 220V	11
* For JUS (LA)	Single-phase	110 ~ 120V	37
FUI JUS (LA)	3-phase	220 ~ 240V	38
For CE	Single-phase	220 ~ 240V	34
* JUS: North A	merica and Cent	ral and South A	America.

Control panel	Code
Not provided	00000
Control panel display language: English. Instruction manual comes in three different languages.	E500B
Control panel display language: English. Instruction manual comes in five different languages.	E500C

#### Motor for SC

	Motor		Code
For General Export	Single-phase 3-phase	200 ~ 240V	60
* For JUS (LA)	Single-phase	100 ~ 120V	61
FUI JUS (LA)	3-phase	200 ~ 240V	62
For CE	Single-phase	200 ~ 240V	63

# SPECIFICATIONS

		[	1			
Model name	LU-1560	LU-1560-7	LU-1565			
Model Hame		With an automatic thread trimmer	With an organized split needle bar			
Application		For heavy-weight materials				
Max. sewing speed	2,500	Orpm	2,000rpm			
Max. stitch length		9mm (normal/reverse feed)				
Needle bar stroke	36r	nm	33.4mm			
Lift of the presser foot	By hand: 9mm, By	knee: 16mm (max.)	By hand: 9mm, By knee: 13mm (max.)			
Needle gauge (mm)		9, 9.5, 12.7 '16", 3/8", 1/2")	4.8, 6.4, 7.9 (3/16", 1/4", 5/16")			
Organized spilt needle bar			Provide as standard			
Alternating vertical movement	2.5 ~ 6.5mm	1 ~ 6.5mm	2.5 ~ 6.5mm			
Dial for adjustment of alternating vertical movement		Provide as standard				
Thread take-up	Slide type					
Hook		Vertical-axis double-capacity hook				
Needle (at the time of delivery)	135 × 17 (Nm160) Nm125 ~ Nm180 or DP × 17 #23					
Thread	#30 ~ #5, B46 ~ B138, Nm=60/3 ~ 30/3					
Feed dog motion	Rectangular					
Handwheel	Large, aluminum					
Pitch changing method		By dial				
Bobbin winder		Built on the machine head				
Knee-lifter mechanism		Built on the machine head				
Safety mechanism		Provided as standard				
Lubrication	Auto	matic	By an oiler (hook: automatic)			
Lubricating oil	JUKI	New Defrix Oil No.1 (equivalent to ISO	VG7)			
Distance from needle to machine arm/Bed size	255mm/517mm × 178mm					
Weight of the machine head	45kg	51kg	45kg			
One-touch type reverse feed function	Option	Provided as standard	Option			
Compressed air and air consumption		0.5MPa (5kgf/cm²), 0.3N&/min				
Power requirement		Single-phase 110 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V				

## OPTIONS

Model	Part No.		Description	Feature	
AK119A	GAK-A19010A0	Knee switch type	Pneumatic auto-lifter		
AK119B	GAK-A19010B0	Pedal switch type	Pheumatic auto-litter	Applicable model: LU-1560-7	
AK120A	GAK-A20010A0	Knee switch type	Pneumatic auto-lifter	Applicable model: 111 1540, 111 1545	
AK120B	GAK-A20010B0	Pedal switch type	(provided with an air regulator)	Applicable model: LU-1560, LU-1565	
	213-48552	Pneumatic one-toucl (provided with an air	n type reverse feed stitching device regulator)	Applicable model: LU-1560, LU-1565 * To use an auto-lifter and reverse feed stitching device in combination, select AK119A or AK119B	
	MAH-152010A0				
H152	SS-7151610-SP × 2			2 mg	
HI52	WP-0621016-SD × 2	- Suspended ruler		No. 10 Acres	
	WP-0610002-KN × 2			C. C	
	MAY-BL6B10A0	Core dia. 6 ~ 10mm	Piping holder		
	MAY-BL6B20A0	Core dia. 2 ~ 5mm			
PK75		3-pedal unit		Applicable model: LU-1560-7 Highly operable 3-pedal unit for standing work.	
	210-06507				
	NS-6110530-SP				
210-06408		Additional spring for	presser bar		
	210-16101				
	210-06002 × 3				

# EXCHANGEABLE GAUGE PARTS

## LU-1560

Code	Needle gauge size	Throat plate	Needle clamp asm.	Presser foot asm.	Walking foot asm. Needle hole 2.5 with groove	Feed dog Needle hole 2.5 × 3.5	Slide plate, left	Slide plate, right
		FILM.				<u>2.5 × 3.5</u>	le le	Te
	3.2mm (1/8")	213-68709	213-71554	213-70853	213-72255	213-69400		
D	4.8mm (3/16")	213-66109	213-68154	213-67651	213-72354	213-66604		
F	6.4mm (1/4")	213-66208	213-68253	213-67750	213-72453	213-66703	213-65606	213-65002
н	7.9mm (5/16")	213-66307	213-68352	213-67859	213-72552	213-66802		
к	9.5mm (3/8")	213-66406	213-68451	213-67958	213-72651	213-66901		
L	12.7mm (1/2")	213-66505	213-68550	213-68055	213-72750	213-67008		
	15.9mm (5/8")	213-68808	213-71653	213-70952	213-72859	213-69509	213-65705	213-65101
	19.1mm (3/4")	213-68907	213-71752	213-71059	213-72958	213-69608		
	22.2mm (7/8")	213-69004	213-71851	213-71158	213-73055	213-69707		
	25.4mm (1")	213-69103	213-71950	213-71257	213-73154	213-69806	213-65804	213-65200
	28.6mm (1-1/8")	213-69202	213-72057	213-71356	213-73253	213-69905	213-03004	213-03200
	31.8mm (1-1/4")	213-69301	213-72156	213-71455	213-73352	213-70002		

#### LU-1560

Code	Needle gauge size	Walking foot asm. Needle hole 2.6 × 7 slit
		(option)
	3.2mm (1/8")	213-73451
D	4.8mm (3/16")	213-73550
F	6.4mm (1/4")	213-73659
Н	7.9mm (5/16")	213-73758
К	9.5mm (3/8")	213-73857
L	12.7mm (1/2")	213-73956
	15.9mm (5/8")	213-74053
	19.1mm (3/4")	213-74152
	22.2mm (7/8")	213-74251
	25.4mm (1")	213-74350
	28.6mm (1-1/8")	213-74459
	31.8mm (1-1/4")	213-74558

#### LU-1560-7

Code	Needle gauge size	Throat plate	Needle clamp asm.	Presser foot asm.	Walking foot asm. Needle hole 2.5	Feed dog Needle hole 2.5 × 3.5	Slide plate, left	Slide plate, right
		A CONTRACTOR		•		2.5 × 3.5	10 Jac	
	3.2mm (1/8")	213-68709	213-71554	213-70853	213-70150	213-69400		
D	4.8mm (3/16")	213-66109	213-68154	213-67651	213-67156	213-66604		
F	6.4mm (1/4")	213-66208	213-68253	213-67750	213-67255	213-66703	213-65606	213-65002
Н	7.9mm (5/16")	213-66307	213-68352	213-67859	213-67354	213-66802		
к	9.5mm (3/8")	213-66406	213-68451	213-67958	213-67453	213-66901		
L	12.7mm (1/2")	213-66505	213-68550	213-68055	213-67552	213-67008		
	15.9mm (5/8")	213-68808	213-71653	213-70952	213-70259	213-69509	213-65705	213-65101
	19.1mm (3/4")	213-68907	213-71752	213-71059	213-70358	213-69608		
	22.2mm (7/8")	213-69004	213-71851	213-71158	213-70457	213-69707		
	25.4mm (1")	213-69103	213-71950	213-71257	213-70556	213-69806	213-65804	213-65200
	28.6mm (1-1/8")	213-69202	213-72057	213-71356	213-70655	213-69905		

#### LU-1565

Code	Needle gauge size	Throat plate	Needle clamp asm., left	Needle clamp asm., right	Presser foot asm.	Walking foot asm. Needle hole 2.6 × 7 with groove & teeth	Feed dog Needle hole 2.6 × 7
		A Constant					2.6 × 7
D	4.8mm (3/16")	B1109-521-D00	B1402-526-DALA	B1402-526-DARA	213-67651	B1470-521-D00	B1613-521-D00
F	6.4mm (1/4")	B1109-521-F00	B1402-526-FALA	B1402-526-FARA	213-67750	B1470-521-F00	B1613-521-F00
н	7.9mm (5/16")	B1109-521-H00	B1402-526-HALA	B1402-526-HARA	213-67859	B1470-521-H00	B1613-521-H00
	9.5mm (3/8")	B1109-521-K00	B1402-526-KALA	B1402-526-KARA	213-67958	B1470-521-K00	B1613-521-K00
	12.7mm (1/2")	B1109-521-L00	B1402-526-LALA	B1402-526-LARA	213-68055	B1470-521-L00	B1613-521-L00

## LU-1565

Code	Needle gauge size	Slide plate, left	Slide plate, right	Walking foot asm. Needle hole 2.6 × 7 slit	Feed dog Needle hole 2.6 × 5	Feed dog Needle hole 2
		e Je	Te	(option)	2.6 × 5 (option)	(option)
D	4.8mm (3/16")		1 500	213-73550	B1613-521-D0A	B1613-521-D0B
F	6.4mm (1/4")	B1112-521-F00		213-73659	B1613-521-F0A	B1613-521-F0B
Н	7.9mm (5/16")	B1112-521-E00	213-77304	213-73758	B1613-521-H0A	B1613-521-H0B
	9.5mm (3/8")			213-73857	B1613-521-K0A	B1613-521-K0B
	12.7mm (1/2")	B1112-521-J00		213-73956	B1613-521-L0A	B1613-521-L0B

## LU-1560, LU-1560-7, LU-1565 (option)

Description	Presser foot	Walking foot	Notes
Upper fittings for french-seam	(a) 213-74657 (width: 21.4mm) (b) 213-74756 (width: 23.0mm) (c) 213-74855 (width: 26.0mm)	(a) 213-72552 (needle hole: 2.5) (with groove) (b) 213-74756 (needle hole: 2.5) (with groove) (c) 213-74855 (needle hole: 2.5) (with groove)	For LU-1560 and LU-1565. Needle distance: (a) 7.9mm (5/16") (b) 9.5mm (3/8") (c) 12.7mm (1/2")
(with center guide)		(a) 213-67354 (needle hole: 2.5) (with groove) (b) 213-67453 (needle hole: 2.5) (with groove) (c) 213-67552 (needle hole: 2.5) (with groove)	For LU-1560-7. Needle distance: (a) 7.9mm (5/16") (b) 9.5mm (3/8") (c) 12.7mm (1/2")

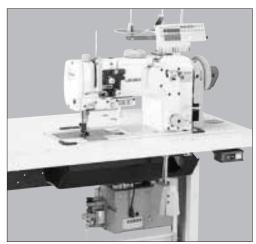
High-speed, 1-needle, Unison-feed, Lockstitch Machine with a Large Hook and an Automatic Thread Trimmer

LU-2210N-7 (1.6 fold-capacity hook) LU-2210W-7 (double-capacity hook)

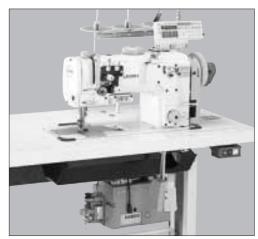
High-speed, 2-needle, Unison-feed, Lockstitch Machine with Large Hooks and an Automatic Thread Trimmer

LU-2260N-7 (1.6 fold-capacity hook) LU-2260W-7 (double-capacity hook)

- Thanks to its remarkable feed efficiency and improved feed cam unit, the machine smoothly feeds materials at high speeds while preventing stitch gathering. The machine is also equipped with a new box-type feed locus that enables the production of beautifully finished seams free from material flopping.
- The rigid movement of the knife-driving shaft and ideal shape of the cam enable the thread trimmer to trim thread as thick as #5. Further-more, no adjustment is necessary after changing the thread count.
- The vertical strokes of the presser foot and walking foot (their alternating vertical movement) can be easily changed using a large dial mounted on the top surface of the machine head. In addition, the sewing speed is automatically adjusted with the set value. With this feature, ideal sewing conditions are maintained at all times.
- The LU-2210N-7 and -2260N-7 are equipped with a vertical-axis 1.6 foldcapacity hook, and the LU-2210W-7 and -2260W-7 with a vertical-axis double-capacity hook. These hooks promote highly efficient operation by reducing the frequency of bobbin thread replacement.



LU-2210N-7-0B/XC-E500



LU-2260N-7-0B/XC-E500

14

Model name	LU-2210N-7	LU-2210W-7	LU-2260N-7	LU-2260W-7	
Model hame	1-ne	1-needle 2-needle			
Max. sewing speed		3,500	)rpm		
Max. stitch length	9mm (normal	/reverse feed)	6mm (normal	/reverse feed)	
Needle bar stroke		33.8	mm		
Needle gauge (mm)			6, 8, 10 (stand	dard), 12, 20*	
Lift of the presser foot		By hand: 9mm, By	knee: 16mm (max)		
Auto lifter		Provided as standard (pn	eumatic auto-lifter: AK79)		
Thread take-up		Link	type		
Alternating vertical movement	1 ~ 6.5mm				
Hook	Vertical-axis 1.6 fold-capacity hook			Vertical-axis double-capacity hook	
Needle (at the time of delivery)	134 × 35 (Nm140)	Nm100 ~ Nm180	134 × 35 (Nm140) Nm100 ~ Nm160		
Thread	#30 ~ #4, B46 ~ B13	88, Nm=60/3 ~ 20/3	#20 ~ #5, B64 ~ B13	38, Nm=40/3 ~ 20/3	
Safety mechanism		Provided a	s standard		
Lubrication		Auto	matic		
Lubricating oil		JUKI New Defrix Oil No.1	(equivalent to ISO VG7)		
Distance from needle to machine arm		264	mm		
Bed size		517mm >	< 178mm		
Weight of the machine head	55	kg	58	lkg	
Automatic reverse feed function	Provided as standard				
Compressed air and air consumption	0.5MPa (5kgf/cm ² ), 0.3NQ /min				
Power requirement		Single-phase 100 ~ 3-phase 200 ~ 220			

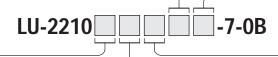
#### **SPECIFICATIONS**

* Configured for needle gauge widths from 4mm to 36mm (LU-2260N-7) and 4mm to 30mm (LU-2260W-7). Note that gauges not given above are also available on special order.

## WHEN YOU PLACE ORDERS

Feed dog	Code
Standard (with groove)	S
Without groove	Α
For thin thread (2.5mm × 1.6mm)	W

	DL function	Code
]	Provided with DL function/push button type	А
]	Provided with DL function/knee switch type	В
	Not provided with DL function	Z



Hook	Code
1.6 fold-capacity hook	N
Double-capacity hook	W

Walking foot	Code
Standard	Α
For urethane	В
Right single-sided presser	С
Left single-sided presser	D
For piping 3mm	E
For piping 4mm	F
For piping 5mm	G
For piping 6mm	Н
Adjustable type for piping 3mm	J
Adjustable type for piping 4mm	К
Adjustable type for piping 5mm	L
Adjustable type for piping 6mm	М

Presser foot	Code
Standard	А
For material with overlapped sections	В
For urethane	С
Right single-sided presser	D
Left single-sided presser	E
For piping 3mm	F
For piping 4mm	G
For piping 5mm	Н
For piping 6mm	J
Pressing face is reduce	К



Hook		Code	Stitch length	Code	Needle gauge	Code		Vaking foot/	Code							
1.6 fold-capacity	/ hook	Ν	6mm	S	6mm	В		Presser foot/feed dog								
Double-capacity	/ hook	W			8mm	С		Standard	S							
					10mm (standard)	D										
					12mm	E		DL fu	Inction			Code				
					20mm	J		Provided with DL fund	ction/pus	sh butto	on type	Α				
								Provided with DL fund	ction/kne	e switc	h type	В				
								Not provided with DL	function			Z				

• PSC box/control panel for SC



	(				
PSC box					
For General Export	Single-phase	220 ~ 240V	07		
	3-phase	200 ~ 220V	11		
For JUS (LA)*	Single-phase	110 ~ 120V	37		
FOI JUS (LA)	3-phase	220 ~ 240V	38		
For CE	Single-phase	220 ~ 240V	34		

Control panel	Code
Not provided	00000
Control panel display language: English. Instruction manual comes in three different languages.	E500B
Control panel display language: English. Instruction manual comes in five different languages.	E500C

#### Motor for SC

M							
	Motor						
For General Export	Single-phase 3-phase	220 ~ 240V	60				
For JUS (LA)*	Single-phase	110 ~ 120V	61				
FOI JUS (LA)	3-phase	220 ~ 240V	62				
For CE	Single-phase	220 ~ 240V	63				

* JUS: North America and Central and South America.

LU-2210N-7, 2210W-7, 2260N-7, 2260W-7 (June, 2001) 2/4 Downloaded from www.Manualslib.com manuals search engine

## INTERCHANGEABLE GAUGE PARTS

## LU-2210N-7, LU-2210W-7

Sewing condi	tions	Walking fo	ot	Presser foot			
Standard		A Standard 107-11653		A Standard 107-12552			
For material with overlapped section Allows the smooth feed of multi-layered portions of the material			an C	K     Standard (pressing face is reduced)       107-58456       B     For material with overlapped section			
For light-weight sponge Used for resilient materials including sponge				107-12651 C For urethane 107-12750	<u>v</u>		
For heavy-weight sponge Used for more resilient materials	Thick	B For urethane	al con				
Right single-sided presser Used for sewing material edges	1mm	C Right single-sided presser 107-11851	99 J	D Right single-sided presser 107-12859			
Left single-sided presser Used for sewing material edges	Imm	D Left single-sided presser 107-11950	99 9	E Left single-sided presser 107-12958			
For piping Used for the general piping process		E ~ H For piping 3 107-45354 4 107-45453 5 107-45552 6 107-45651	9 <b>9</b>	F ~ J For piping	\$ }		
For piping The position of the needle can be adjusted according to the pipe to be sewn	Adjustable	J~M Adjustable presser for piping 3 107-46352 4 107-46451 5 107-46550 6 107-46659		3 107-47350 4 107-47459 5 107-47558 6 107-47657	- All All All All All All All All All Al		
Wide type To be used when a sewing product cannot be smoothly fed		(special order) 107-12057	and the second sec	(special order) 			

	Feed dog								
3.3mm 2.2mm			3.3mm 2.2mm		2.5mm 1.6mm	3.3mm 2.2mm			
	107-17106		107-17205		107-17304	107-39001			
s	Standard	A	Without a groove Used when the needle thread does not interlace consisting with the bobbin thread at the start of sewing.	В	For thin thread	Wide type (special order)			

Throa	t plate
Co Co Co	Co C
107-01704	107-02009
Standard	Wide type (special order)

#### LU-2260N-7, LU-2260W-7

Needle gauge	Typical*	Needle	Presser	Walking	Needle	Feed dog	Slide plate		
Needle gauge	part No.	clamp	foot	foot	plate	reeddog	Left	Right	
			e Jag	64 ⁵	S CONTRACTOR				
4mm (special order)	107-84551	107-77555	107-81557	107-83058	107-84502	107-80005			
6mm	107-84650	107-77654	107-81656	107-83157	107-84601	107-80104	107-86309	107-01803	
8mm	107-84759	107-77753	107-81755	107-83256	107-84700	107-80203			
10mm (special order)	107-84858	107-77852	107-81755	107-83355	107-84809	107-80302		107-86002	
12mm	107-84957	107-77951	107-80401	107-83454	107-84908	107-80401	107-86408		
14mm (special order)	107-85053	107-78058	107-82050	107-83553	107-85004	107-80500	107-00400		
16mm (special order)	107-85152	107-78157	107-82159	107-83652	107-85103	107-80609			
18mm (special order)	107-85251	107-78256	107-82258	107-83751	107-85202	107-80708			
20mm	107-85350	107-78355	107-82357	107-83850	107-85301	107-80807			
22mm (special order)	107-85459	107-78454	107-82456	107-83959	107-85400	107-80906	107-86507	107-86101	
24mm (special order)	107-85558	107-78553	107-82555	107-84056	107-85509	107-81003			
30mm (special order)	107-85657	107-78652	107-82654	107-84155	107-85608	107-81102			
36mm (special order)	107-85756	107-78751	107-82753	107-84254	107-85707	107-81201	107-86606	107-86200	

* The right and left slide plates are not included in the parts represented by the typical part numbers.

# OPTIONS

Model name	Feature
DL device	A function to instantaneously change over the alternating vertical movement of the walking foot and presser foot (DL) is optionally available with the machine. With this function, the alternating vertical movement of the walking foot and presser foot can be changed over to the maximum value simply by turning on the switch.

# 

# ATTACHMENT

Part name	Part No.	
H152 (suspended ruler)	MAH-152010A0	

Push-button type

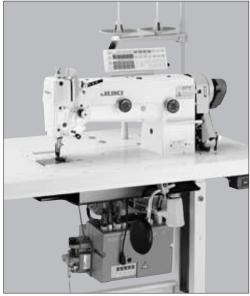
1-needle, Lockstitch, Zigzag Stitching Machine with a Large Hook

# LZH-1290 LZH-1290-7 (with an automatic thread trimmer)

- With its newly incorporated triangular cam, the machine uniformly tenses thread in zigzag strokes regardless of the needle position, and the needle always enters the material at right angles. This prevents the needle from swaying during zigzag stitching.
- The machine offers outstanding capabilities for the sewing of sports shoes and leather shoes that require a wider zigzag width. The zigzag width can be quickly and easily adjusted by the dial mounted on the front face of the machine.
- To ensure smooth sewing of heavy-weight materials, the lift of the presser foot is as high as 14mm (13mm for the LZH-1290-7).
- By reducing the frequency of bobbin thread replacement, the newly introduced horizontal-axis double-capacity hook contributes to increased efficiency in sewing. This feature is extremely helpful when sewing with thick thread.

#### • LZH-1290-7

The machine's unique thread trimmer mechanism allows the thread trimmer to cut the thread when the needle is either at the left or right end of its zigzag stroke. This mechanism also eliminates the need for adjustment even when the thread count is changed.



LZH-1290-7-0B/XC-E500



#### SPECIFICATIONS

Model name	LZH-1290	LZH-1290-7	
Max. sewing speed	2,000rpm		
Max. stitch length	6mm (normal/reverse feed)		
Zigzag width	Max. 8mm (adjus	stable to 10mm)	
Zigzag width adjustment method	Ву с	dial	
Needle bar stroke	35n	nm	
Lift of the presser foot	By hand: 6mm, By knee: 14mm	By hand: 6mm, By knee: 13mm	
Thread take-up	Link type		
Hook	Horizontal-axis full-rotary double-capacity hook		
Needle (at the time of delivery)	SY1906 (Nm110) Nm90 ~ Nm110		
Thread	#50 ~ #8, B33 ~ B92, Nm=120/3 ~ 30/3		
Lubrication	By an oiler (hook: automatic)		
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)		
Distance from needle to machine arm	n 295mm		
Bed size	477mm × 178mm		
Weight of the machine head	35kg	39kg	
Automatic reverse feed function		Provide as standard	
Power requirement		Single-phase 100 ~ 120V, 220 ~ 240V, 3-phase 200 ~ 220V, 220 ~ 240V	

WHEN YOU PLACE ORDERS

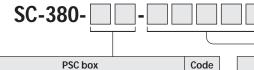
Without an automatic thread trimmer

# LZH-1290

• With an automatic thread trimmer

# LZH-1290-7-0B/

#### • PSC box/control panel for SC



220 ~ 240V

200 ~ 220V

110 ~ 120V

220 ~ 240V

220 ~ 240V

07

11

37

38

34

Control panel	Code
Not provided	00000
Control panel display language: English. Instruction manual comes in three different languages.	E500B
Control panel display language: English. Instruction manual comes in five different languages.	E500C

Motor for SC

Μ

For General Export

For JUS (LA)*

For CE

Motor

3-phase Single-phase

3-phase

Single-phase

Single-phase

Code

60

61

62

63

220 ~ 240V

110~120V

220 ~ 240V

220 ~ 240V

* JUS: North America and Central and South America.

Single-phase

Single-phase

Single-phase

3-phase

3-phase

## GAUGE

For JUS (LA)*

For CE

For General Export

Туре	Standard	For frictional * material	For zigzag * width of 10mm	Provided with * a center guide	3-row feed dog *	
Presser foot	100-86353	100-86379 (pearl-bright finish)			100-85850	
		23300	100-75505	100-93318	100-75711	
Throat plate						
Feed dog				110-83319	100-83525	
Remarks	Zigzag width: Max. 8mm	Zigzag width: Max. 8mm The pearl-bright finish presser foot has the same surface smoothness as the teflon-finish type, but its rigidity is markedly superior.	Zigzag width: Max. 10mm	Zigzag width: Max. 8mm	Zigzag width: Max. 6mm	

LZH-1290, 1290-7 (June, 2001) 2/2 Downloaded from <u>www.Manualslib.com</u> manuals search engine * Gauges other than the standard one are optionally available.

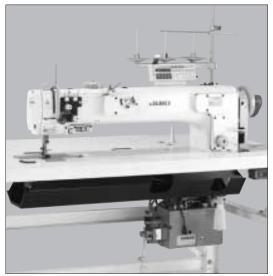
# Long-arm, Unison-feed, Lockstitch Machine with a Vertical-axis Large Hook and an Automatic Thread Trimmer

# LU-2216N-7 (1-needle) LU-2266N-7 (2-needle)

- Both the LU-2216N-7 (1-needle) and LU-2266N-7 (2-needle) achieve the maximum sewing speed of 3,000rpm. With this capability, the machine demonstrates higher productivity when sewing long lengths of materials.
- With the long distance from the machine arm to the center of the needle, a full 650mm, the machine is ideally suited to reinforcement stitching processes for attaching tape and intermediate sewing processes such as topstitching for large work pieces.
- With its powerful feed and optimal feed locus, the machine smoothly feeds materials without stitch gathering even when running at a higher sewing speed.

The standard machine lets the operator adjust the vertical stroke of the walking foot and presser foot (DL device).
 In processes such as the sewing of heavy-weight materials or hard-to-feed multi-layered portions, a press on the DL switch instantly changes over the vertical stroke of the walking foot and presser foot.
 The result is beautifully produced seams without stitch gathering.

• The vertical stroke of the walking foot and presser foot can be easily set and changed.



LU-2266N-7-0B/XC-E500

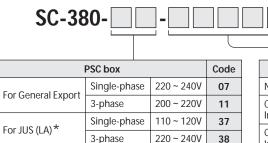


## SPECIFICATIONS

Model name	LU-2216N-7	LU-2266N-7	
Model hame	1-needle	2-needle	
Max. sewing speed	3,000rpm		
Max. stitch length	9mm (normal/reverse feed) 6mm (normal/reverse feed)		
Needle bar stroke	36r	nm	
Needle gauge		10mm (standard)	
Lift of the presser foot	By hand: 9mm	, Auto: 16mm	
Auto lifter	Provide as standard (pne	umatic auto-lifter: AK115)	
Thread take-up	Link	type	
Alternating vertical movement	1 ~ 6.5mm		
DL device	Provide as standard		
Hook	Vertical axis 1.6 fold-capacity hook		
Needle (at the time of delivery)	134 x 35 (Nm140) Nm100 ~ Nm180 134 x 35 (Nm140) Nm100 ~ Nm16		
Thread	#30 ~ #4, B46 ~ B138, Nm=60/3 ~ 20/3 #20 ~ #5, B69 ~ B138, Nm=40		
Safety mechanism	Provided a	s standard	
Lubrication	Auto	matic	
Lubricating oil	JUKI New Defrix Oil No.1	(equivalent to ISO VG7)	
Distance from needle to machine arm	650	mm	
Bed size	917mm × 178mm		
Weight of the machine head	90kg 95kg		
Automatic reverse feed function	Provided as standard		
Compressed air and air consumption	0.5MPa (5kgf/cm ² ), 0.3NØ/min.		
Power requirement	Single-phase 110 ~ 120V, 220 ~ 240V, 3-phase 200 ~ 220V, 220 ~ 240V		

LU-2216NAASB-7-0B				LU-2266N	SDSE	8-7-0B			
Walking foot	Code	Presser foot	Code	Feed dog	Code	Needle gauge	Code	Walking foot	
Standard*	Α	Standard*	Α	Standard*	S	10mm (standard) *	D	Presser foot Feed dog	Code
* Any gauge other 1	* Any gauge other than the standard is available on a part order. (See the table of replaceable gauges.)				Standard*	S			

#### • PSC box/control panel for SC



220 ~ 240V

34

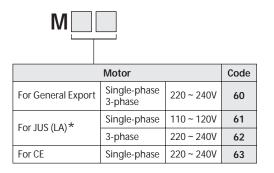
Control panel	
Not provided	00000
Control panel display language: English. Instruction manual comes in three different languages.	E500B
Control panel display language: English. Instruction manual comes in five different languages.	E500C

* JUS: North America and Central and South America.

Single-phase

#### Motor for SC

For CE



## GAUGE PARTS

#### • Some gauge used in the LU-2210N/-2260N Series

The gauge (hook, bobbincase, walking foot, presser foot and feed) used in the LU-2210N/-2260N series is also used in this model. All of the parts used in your LU-2210N/-2260N sewing machines can also be used in the LU-2216N/-2266N machines. In addition, the knife and thread tension components are also the same.

#### ATTACHMENT

Part name	Part No.
H152 (suspended ruler)	MAH-152010A0

1-needle, Top & Bottom-feed, Long-arm, Lockstitch Machine

# **DU-580**

- Free space under the arm is as wide as 500mm. Thanks to this wide free space under the arm, the machine is widely applicable to heavyweight materials and long-sized materials.
- The efficiency of feed is doubled, thereby improving the ability of the feed mechanism to feed the material straight.
- The hinged walking foot and the feed dog feed the material placed between them, synchronizing with each other.
- The stitch length can be adjusted within the range of 0 to 9mm by using the dial. Thanks to this feature, this machine is widely applicable to the sewing of tents, which need to be sewn with coarse stitches, or longsized materials including car seats, and materials sewn with a thick thread. Reverse feed stitches of the same length as the normal feed stitches can be sewn only by depressing the lever.



DU-580

15

• Since the machine is equipped with a double-capacity hook, the frequency of bobbin replacement is reduced, thereby leading to higher efficiency.

## **SPECIFICATIONS**

Model name	DU-580
Max. sewing speed	1,500rpm
Max. stitch length	9mm (normal/reverse feed)
Needle bar stroke	35mm
Lift of the presser foot	By hand: 7mm, By knee: 15mm
Thread take-up	Link type
Alternating vertical movement	2 ~ 5mm
Hook	Horizontal-axis full-rotary double-capacity hook
Needle (at the time of delivery)	DB × 1 (DP × 17) (#21) #14 ~ #23, For JE: 1738 (Nm130)
Thread	#40 ~ #8, B33 ~ B92, Nm=90/3 ~ 30/3
Lubrication	By an oiler (hook: automatic)
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)
Distance from needle to machine arm	500mm
Bed size	715mm × 178mm
Weight of the machine head	49kg

## WHEN YOU PLACE ORDERS

# **DU-580**

## EXCHANGEABLE GAUGE PARTS

Description	Throat plate	Feed dog	Notes
Standard	D1109-560-E00 (D=2.6) D1109-560-E0A (D=4.2) D1109-560-E0B (D=3.0)	D1613-560-E00	Stitch length: max. 8mm
	B1109-201-H0B (D=3.5) B1109-555-H0B (D=2.6)	B1609-201-000A	Stitch length: max. 8mm
		B1609-201-000B	Stitch length: max. 10mm
	B1105-141-000 (D=2.0) B1105-141-H00 (D=2.6)	B1613-141-H00A	Stitch length: max. 9mm
Single-lined feed dog for sewing gloves and shoes	114-05800	114-05701	Exclusive parts Roller presser foot asm for DDL: B1524-560-RB0 Narrow type walking foot for DU: B1526-141-HAB B1526-141-HOT

1-needle, Unison-feed, Long  $\operatorname{Arm}$  Lockstitch Machine with a Large Hook

# **DNU-261H**

- With its unison-feed mechanism that ensures a smooth and steady feed of materials, the machine provides consistent seam quality with no material slippage.
- The alternating vertical movement of the walking foot and presser foot can be widely adjusted in the range of 3 to 6mm. With this feature, the machine is able to flexibly adapt to various kinds of heavy-weight materials.
- With the wide 635mm of free space under the arm, a large material can be sewn with spreading on the bed.
- The presser foot goes up as high as 15mm to ensure easy placements/removal of extra heavy-weight materials.
- Since the machine incorporates a horizontal-axis double-capacity hook, the frequency of bobbin thread replacement is reduced, further increasing efficiency.
- Stitch length is adjustable by up to 8mm with a stitch dial. The stitch length is also adjustable for reverse feed stitching.



DNU-261H

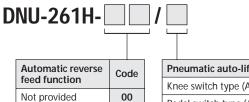


## SPECIFICATIONS

Model name	DNU-261H
Max. sewing speed	1,500rpm
Max. stitch length	8mm (normal/reverse feed)
Needle bar stroke	38mm
Lift of the presser foot	By hand: 9mm, By knee: 15mm
Thread take-up	Slide type
Alternating vertical movement	3 ~ 6mm
Hook	Horizontal-axis full-rotary double-capacity hook
Needle (at the time of delivery)	DB x 17 (#23) #16 ~ #23, For JE: 135 x 17 (Nm160)
Thread	#40 ~ #8, B33 ~ B92, Nm=90/3 ~ 30/3
Lubrication	By an oiler (hook: automatic)
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)
Distance from needle to machine arm	635mm
Bed size	850mm × 178mm
Weight of the machine head	59kg

## WHEN YOU PLACE ORDERS

Provided



**0B** 

Pneumatic auto-lifter (optional)	Code
Knee switch type (AK70A)	Α
Pedal switch type (AK70B)	В
Not provided	

Cylinder-bed, 1-needle, Top & Bottom-feed, Lockstitch Machine

# DSU-145 DSU-145-7 (with an automatic thread trimmer)

- The top & bottom-feed mechanism provides upgraded feed efficiency, feeding heavy-weight material steadily and smoothly. Even when the machine runs at a high speed, this highly accurate feed mechanism promises consistent sewing performance with no irregular feed pitch.
- The diameter of the cylinder-bed is as small as 50mm.
   This allows the machine to sew sharp curves of bags, shoes and various small articles smoothly and easily.
- The machine comes with a horizontal-axis double-capacity hook. With double the amount of thread wound on the bobbin compared with the regular hook, sewing efficiency is further improved.
- By adopting an automatic lubrication system that automatically feeds oil to the hook, the need for hook maintenance is eliminated.

#### • DSU-145-7

With its horizontal-cutting mechanism, the automatic thread trimmer cuts various kinds high-to low-count threads.





DSU-145-7-0B/XC-E500

Model name	DSU-145	DSU-145-7	
Max. sewing speed	2,000rpm		
Max. stitch length	6mm (normal	/reverse feed)	
Needle bar stroke	37r	nm	
Lift of the presser foot	By hand: 7mm, By knee: 15mm	By hand: 6mm, By knee: 13mm	
Thread take-up	Link	type	
Alternating vertical movement	2~5	imm	
Hook	Horizontal-axis full-rotary double-capacity hook		
Needle (at the time of delivery)	DP × 17 (#21) #14 ~ #21, For JE: 135 × 17 (Nm130)		
Thread	#50 ~ #8, B33 ~ B92, Nm=120/3 ~ 30/3		
Lubrication	By an oiler (hook: automatic)		
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)		
Cylinder-bed diameter	50mm		
Distance from needle to machine arm	270mm		
Weight of the machine head	36kg	39kg	
Automatic reverse feed function		Provided as standard	
Power requirement		Single-phase 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V	

## WHEN YOU PLACE ORDERS

• Without an automatic thread trimmer

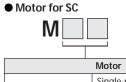
# **DSU-145**

With an automatic thread trimmer

DSU-145-7-0B/	
Pneumatic auto-lifter (optional)	Code
Knee switch type (AK114C)	С
Pedal switch type (AK114B)	В
Not provided	

## • PSC box/control panel for SC SC-380-

			$\subseteq$
PSC box			
For General Export	Single-phase	220 ~ 240V	07
	3-phase	200 ~ 220V	11
For JUS (LA)*	Single-phase	110 ~ 120V	37
	3-phase	220 ~ 240V	38
For CE	Single-phase	220 ~ 240V	34



	IVIOTOF			Code
	For General Export	Single-phase 3-phase	220 ~ 240V	60
	For JUS (LA)*	Single-phase	110 ~ 120V	61
		3-phase	220 ~ 240V	62
	For CE	Single-phase	220 ~ 240V	63

Control panel	
Not provided	00000
Control panel display language: English. Instruction manual comes in three different languages.	E500B
Control panel display language: English. Instruction manual comes in five different languages.	E500C

# EXCHANGEABLE GAUGE PARTS

## • For DSU-145 (-7)

Description	Walk	ing foot	Presser foot	Notes
Standard	B1526-141-H0A		B1525-141-HA0	
For piping	B1527-141-H0		В1527-141-НАО	Piping size B: 3.2mm (1/8") F: 6.4mm (1/4") C: 4.0mm (5/32") H: 7.9mm (5/16") D: 4.8mm (3/16") K: 9.5mm (3/8") E: 5.6mm (7/32")
Cut-out tail for piping	B1528-141-H0	FJ PJ		
Double groove	B1529-141-H0		B1526-141-HAW	Piping size B: 3.2mm (1/8") F: 6.4mm (1/4") C: 4.0mm (5/32") H: 7.9mm (5/16") D: 4.8mm (3/16") K: 9.5mm (3/8") E: 5.6mm (7/32")
Left-hand	B1526-141-H0Q		B1526-141-HAU	
Right-hand	B1526-141-H0R		B1526-141-HAS	
Narrow type for sewing gloves and shoes	B1526-141-H0T	Ľ	B1526-141-HAB	Stitch length: max. 6mm Exclusive parts Feed dog: 114-05701 Throat plate: 114-05800
For attaching zippers	B1527-141-H0X	J.	В1526-141-НОХ	Without hardening (blank)

#### • For DSU-145 (-7)

Description	Throat plate	Feed dog	Notes
Standard	D1105-145-E00 (A: 3.0 B: 2.2mm)	D1613-145-E00 (A: 45 B: 1.6mm) D1613-145-E0A (A: 67 B: 1.7mm)	
	A DEC		
Three-lined feed dog	D1105-145-E0B	D1613-145-E0B	
Single-lined feed dog for sewing gloves	D1105-145-EOT	D1613-145-EOT	Exclusive parts Presser foot: B1526-141-H0T Walking foot: B1526-141-H0B

Cylinder-bed, 1-needle, Unison-feed, Lockstitch Machine

DSC-244 (with standard hook) DSC-244-7 (with standard hook and an automatic thread trimmer) DSC-245 (with standard hook, an automatically lubricated for hook) DSC-245-7 (with standard hook, an automatically lubricated for hook) DSC-245-7 (with standard hook, an automatically lubricated for hook) DSC-246 (with a double-capacity hook) DSC-246-7 (with a double-capacity hook and an automatic thread trimmer)

- The unison-feed provides the optimal feed efficiency by feeding heavy-weight materials smoothly and firmly.
- The diameter of the cylinder is as small as 46mm for a standard hook or 50mm for a double-capacity hook. The small-diameter cylinder is quite helpful for handling bags, shoes, and other small articles smoothly and easily.
- The horizontal feed is best-suited for attaching piping tape. (V Type) The feed mechanism that can synchronize the binder in the piping-tape attachment process in the sewing of shoes.

(Parts to be changed are optionally available.)

#### • DSC-245

The machine is equipped with a new automatic hooklubricating system that automatically lubricates the hook. With this feature, a maintenance-free hook has finally materialized.



DSC-245-7-0B/XC-E500

#### • DSC-246

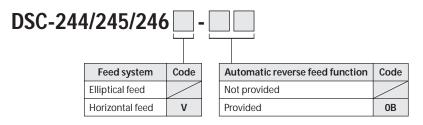
The hook accommodates thread twice as long as that for a standard hook. It also reduces the frequency of bobbin thread replacement, thereby enabling the operator to smoothly conduct sewing with a higher degree of efficiency.

#### • DSC-244-7, DSC-245-7, DSC-246-7

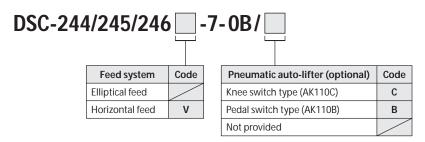
With its horizontal-cutting mechanism, the automatic thread trimmer cuts various kinds high-to low-count threads.

Model name	DSC-244	DSC-245	DSC-246
Max. sewing speed	2,200rpm		
Max. stitch length	6mm (normal/reverse feed)		
Needle bar stroke	36r	nm	38mm
Lift of the presser foot		By hand: 9mm, By knee: 15mm	
Thread take-up		Slide type	
Alternating vertical movement		2.3 ~ 4.8mm	
Hook		full-rotary hook	Horizontal-axis full-rotary double-capacity hook
Needle (at the time of delivery)	DP × 17 (#18 For JE: 135 ×		DP × 17 (#21) #14 ~ #23 For JE: 135 × 17 (Nm130)
Thread	#50 ~ #20, B33 ~ B	69, Nm=120/3 ~ 40/3	#50 ~ #8, B33 ~ B92, Nm=120/3 ~ 30/3
Lubrication	By an oiler	By an oiler (hook: automatic)	By an oiler
Lubricating oil	JUKI N	lew Defrix Oil No. 1 (equivalent to IS	O VG7)
Cylinder-bed diameter	46mm 50mm		
Distance from needle to machine arm	264mm		
Weight of the machine head	36kg		
Model name	DSC-244-7 DSC-245-7		DSC-246-7
Max. sewing speed	2,200rpm		
Max. stitch length	6mm (normal/reverse feed)		
Needle bar stroke	36r	36mm	
Lift of the presser foot	By hand: 8mm,	By knee: 13mm	By hand: 8mm, By knee: 14mm
Thread take-up		Slide type	
Alternating vertical movement		2.3 ~ 4.8mm	
Hook	Horizontal-axis full-rotary hook		Horizontal-axis full-rotary double-capacity hook
Needle (at the time of delivery)	DP × 17 (#18) #14 ~ #21 For JE: 135 × 17 (Nm110)		DP × 17 (#21) #14 ~ #23 For JE: 135 × 17 (Nm130)
Thread	#50 ~ #20, B33 ~ B	69, Nm=120/3 ~ 40/3	#50 ~ #8, B33 ~ B92, Nm=120/3 ~ 30/3
Lubrication	By an oiler	By an oiler (hook: automatic)	By an oiler
Lubricating oil	JUKI New Defrix Oil No. 1 (equivalent to ISO VG7)		
Cylinder-bed diameter	46mm 50mm		50mm
Distance from needle to machine arm	264mm		
Weight of the machine head	39kg		
Automatic reverse feed function	Provided as standard		
Power requirement	Single-phase 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V		

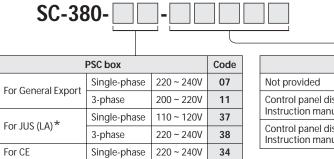
#### Without an automatic thread trimmer



• With an automatic thread trimmer



• PSC box/control panel for SC



Control panel	Code
Not provided	00000
Control panel display language: English. Instruction manual comes in three different languages.	E500B
Control panel display language: English. Instruction manual comes in five different languages.	E500C

#### Motor for SC

	Motor		Code
For General Export	Single-phase 3-phase	220 ~ 240V	60
For JUS (LA)*	Single-phase	110 ~ 120V	61
F0I JUS (LA)	3-phase	220 ~ 240V	62
For CE	Single-phase	220 ~ 240V	63

* JUS: North America and Central and South America.

# EXCHANGEABLE GAUGE PARTS

#### • For DSC-244 (-7), 245 (-7), 246 (-7)

Description	Pres	ser foot	Walkin	ig foot	Notes
Standard	B1525-241-HA0	e 13	B1470-241-HA0		For DNU Stitch length: max. 10mm
	B1525-053-0A0	G 13	B1470-053-000 (D B1470-053-C00 (D	=2.8)	For LU & LS Stitch length: max. 10mm
	B1525-562-BA0	(°) 13	B1470-562-B00		Stitch length: max. 10mm With teeth
	B1525-563-E00	0	B1470-563-E00		Stitch length: max. 10mm
Left-hand type	B1524-245-0A0	6.6	B1470-245-000		DSC-245(-7), 246(-7) standard Stitch length: max. 6mm
	B1529-245-0AD (special order)	Ø 5.9	B1476-245-00D (special order)		Stitch length: max. 8mm With teeth
	B1529-245-0AC (special order)	6.1	B1476-245-00C (special order)		Stitch length: max. 6mm With teeth
	B1529-245-0AB (special order)	e de la construcción de la const	B1476-245-00B (special order)		Stitch length: max. 8mm With teeth
	B1529-245-0AF (special order)	0 6-2 6-2	B1476-245-00F (special order)	TIEID	Stitch length: max. 6mm With teeth
For binding	MAQ-092080A0 (with teeth)	8.3	MAQ-09207000		Stitch length: max. 10mm
	MAQ-093080A0 (with teeth)	٢	MAQ-09307000		DSC-246V(-7) standard Stitch length: max. 10mm
		8.3	MAN-10452000	F to	DSC-245V(-7) standard Stitch length: max. 10mm

DSC-244, 244-7, 245, 245-7, 246, 246-7 (June, 2001) 3/5

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#### • For DSC-244(-7), 245(-7), 246(-7)

For leather (without teath)         103-26304         103-26205         Stitch length max.6mm Without hear guidt (without teath)         Stitch length max.6mm Without hear guidt (without teath)           For piping         B1530-245-00         Image: State	Description	Presser foot	Walking foot	Notes
Image: Section of the section of t	Right-hand type	B1529-245-00A	B1476-245-00A	
For leather (without teeth)     103-26304     103-26205     Stitch length: max. 6mm       for piping     B1530-245-00     B1478-245-00     Stitch length: max. 8mm       for piping     B1531-245-00     B1478-245-00     Stitch length: max. 8mm       Cut-out tail for piping     B1531-245-00     B1478-245-00     Stitch length: max. 8mm       For piping     B1532-245-00     B1478-245-00     Stitch length: max. 8mm       For piping     B1525-245-00     B1472-245-00     Stitch length: max. 8mm       For piping     B1525-245-00     B1473-245-00     Stitch length: max. 8mm       B1525-245-00     Ji     B1473-245-00     Stitch length: max. 8mm       B1525-245-00     Ji     B1473-245-00     Stitch length: max. 8mm       Dauble groove     B1528-245-00     B1473-245-00     Stitch length: max. 8mm       Dauble groove     B1528-245-00     Stitch length: max. 8mm     Stitch length: max. 8mm       B1900     B1175-245-00     Stitch length: max. 8mm     Stitch length: max. 8mm       B1175-245-00     Stitch length: max. 8mm     Stitch length:				55
(without teeth)       Image: Second Sec	Wide type	103-25157	5 5	Exclusive parts (for LU-1114) Throat plate: 103-25009
Cut-out tail for piping       B1531-245-00       B1478-245-00       Stitch length: max.8mm         For piping (with knurled foot)       B1525-245-00       B1472-245-00       Stitch length: max.8mm         B1526-245-00       B1472-245-00       Stitch length: max.8mm       Piping size (2 4 0 mm (3/16'))         B1525-245-00       B1472-245-00       Stitch length: max.8mm       Piping size (2 4 0 mm (3/16'))         B1526-245-00       B1472-245-00       Stitch length: max.8mm       Piping size (2 4 0 mm (3/16'))         B1526-245-00       B1472-245-00       Stitch length: max.8mm       Piping size (2 4 0 mm (3/16'))         B1526-245-00       B1472-245-00       Stitch length: max.8mm       Piping size (2 4 0 mm (3/16'))         B1526-245-00       B1472-245-00       Stitch length: max.8mm       Piping size (2 4 0 mm (3/16'))         B1527-245-00       B1527-245-00       B1472-245-00       Stitch length: max.8mm         Double groove       B1528-245-00       B1472-245-00       Stitch length: max.8mm         Double groove       B1528-245-00       B1472-245-00       Stitch length: max.8mm         B1476-245-00       Stitch length: max.8mm       Piping size (2 4 0 mm (3/16'))       F: 6 4 mm (1/4')         Double groove       B1528-245-00       B1472-245-00       Stitch length: max.8mm         B1476-245-00		103-26304	5 5 2.3 2.3 2.3 2.3 2.3 2.3 2.3 2.3 2.3 2.3	Without finger guard Exclusive parts (for LU-1114) / Throat plate: 103-26403
Piping size (with knurled foot)         Piping size (w	For piping	B1530-245-00	(commonly used for every size)	Piping size C : 4.0mm (5/32") H: 7.9mm (5/16") D: 4.8mm (3/16") K : 9.5mm (3/8") F : 6.4mm (1/4")
(with knurled foot)       Image: Street and Stre	Cut-out tail for piping	B1531-245-00		Piping size C : 4.0mm (5/32") D: 4.8mm (3/16") F : 6.4mm (1/4") H: 7.9mm (5/16")
Piping size       D: 4.8mm (3/16")         F: 6.4mm (1/4")       F: 6.4mm (1/4")         B1527-245-00       B1474-245-00         (special order)       B1474-245-00         (special order)       If         If       B1528-245-00         B1528-245-00       B1475-245-00B         If       B1475-245-00B         If       Stitch length: max. 8mm         Piping size       C: 4.0mm (5/32") H: 7.9mn         Double groove       B1528-245-00         B1475-245-00B       Stitch length: max. 8mm         Piping size       Stitch length: max. 8mm         Double groove       B1475-245-00B         If       Stitch length: max. 8mm         Double groove       B1475-245-00B         If       Stitch length: max. 8mm         Piping size       B: 3.2mm (1/8") H: 7.9mn         Double groove       B1475-245-00B         If       Stitch length: max. 8mm         Piping size       B: 3.2mm (1/8") H: 7.9mn         Diagram       Diagram		B1525-245-00		Piping size D: 4.8mm (3/16") F : 6.4mm (1/4") H: 7.9mm (5/16")
(special order)       (special order)       Piping size         C: 4.0mm (5/32") H: 7.9mn         D: 4.8mm (3/16") K: 9.5mn         F: 6.4mm (1/4")         Double groove         B1528-245-00         B1528-245-00         C: 4.0mm (1/4")         Stitch length: max. 8mm         Piping size         B: 3.2mm (1/8") H: 7.9mn         D: 4.8mm (3/16") K: 9.5mn		B1526-245-00		Piping size D: 4.8mm (3/16") F : 6.4mm (1/4")
(commonly used for every size) D: 4.8mm (3/16") K : 9.5mm			(special order)	Piping size C : 4.0mm (5/32") H: 7.9mm (5/16") D: 4.8mm (3/16") K : 9.5mm (3/8") F : 6.4mm (1/4")
	Double groove		(commonly used	Piping size B : 3.2mm (1/8") H: 7.9mm (5/16") D: 4.8mm (3/16") K : 9.5mm (3/8")

#### • For DSC-245, 245-7, 246, 246-7

Description	Throat plate	Feed dog	Notes
Standard (with groove)	DSC-245: B1105-245-000 DSC-245-7: D1105-245-E00 DSC-246: 211-31206 DSC-246-7: 211-32006	DSC-245: B1613-245-000 DSC-245-7: D1613-245-E00 DSC-246: 211-35009 DSC-246-7: 211-34002	
Without groove		DSC-245: B1613-245-00A	
		DSC-245-7: B1613-245-E0A DSC-246: 211-35108 DSC-246-7: 211-34101	
For thin needle		DSC-245: B1613-245-00B DSC-245-7: B1613-245-E0B DSC-246-7: 211-34200	
		(Parties)	
Round type	DSC-245: B1105-245-00C (R=28) DSC-245-7: D1105-245-E0C (R=28)	DSC-245: B1613-245-00C DSC-245-7: D1613-245-E0C	
		Carrier Sal	

• For DSC-245V, 245V-7, 246V, 246V-7

Description	Throat plate	Feed dog	Notes
Standard (width: 14mm)	DSC-245V: MAQ-09201000 DSC-246V: 211-40108	DSC-245V: MAN-10451000 DSC-246V: 213-05206 (without groove)	Exclusive parts Walking foot: MAN-10452000 Presser foot: MAQ-093080A0
		DSC-245V: MAQ-09309000 DSC-245V-7: MAQ-09509000 DSC-246V: 211-42203 DSC-246V-7: 211-43201 (with groove)	Exclusive parts Walking foot: MAQ-09307000 Presser foot: MAQ-093080A0
	DSC-245V-7: MAQ-09401000 DSC-246V-7: 211-41106	DSC-245V-7: 213-05107 DSC-246V-7: 211-43409 (without groove)	
Narrow type (width: 14mm)		DSC-245V: MAQ-09209000 DSC-245V-7: MAQ-09409000 DSC-246V: 211-42104 (with groove)	Exclusive parts Walking foot: MAQ-09207000 Presser foot: MAQ-093080A0
		DSC-245V-7: 213-05008 DSC-246V-7: 211-43102 (without groove)	
		and the second s	

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# Cylinder-bed, 1-needle, Lockstitch Machine with a Vertical-axis Large Hook

# LS-321 (needle-feed)

- By integrating the needle bar frame with its driving shaft, needle sway is eliminated and consistent, direct-drive sewing is enabled.
- Since the machine incorporates a vertical-axis 1.6 fold-capacity hook, the frequency of bobbin thread replacement is reduce, further increasing efficiency.

# LS-341N (unison-feed)

- With its unison-feed mechanism that perfectly synchronizes the presser foot, needle, and feed, the machine performs accurate stitching free from slippage between the upper and lower cloths.
- With its newly designed throat plate, the machine is able to sew cylindrical articles with diameters as narrow as 40mm. This enhances the machine's ability to smoothly sew not only bags and shoes, but also small articles such as wallets.
- The alternating vertical movement of the walking foot and presser foot can be widely adjusted in the range of 2.3 to 6.0mm. With this feature, the machine is able to flexibly adapt to various kind of heavy-weight materials.

# $LS-341N-7 \ (\text{unison-feed with an automatic thread trimmer})$

- The machine is provided not only with the standard type of throat plate and feed dog, but also with gauges to be used for the sewing of small articles. These gauges are especially useful for sewing of curves of bags and leather cages.
- The thread trimmer is able to cut threads in the count range from #30 to #5 (B33 ~ B92, Nm 90/3 ~ 20/3), widely responding to shoe and furniture sewing processes.

Thick threads are trimmed without fail, and no re-adjustment is required even when the thread count is changed.

• With just a light press on the touch-sensitive button, reverse feed stitching is actuated. When sewing 3-dimensional articles, the suspended ruler can be lifted up out of the way.



LS-341N-7-0B/XC-E500



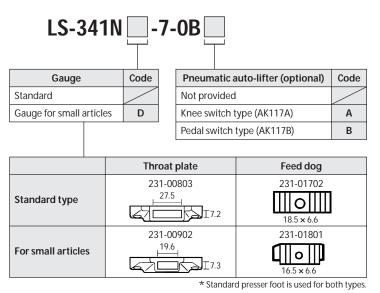
# SPECIFICATIONS

Model name	LS-321	LS-341N	LS-341N-7		
Feed system	Needle-feed				
Max. sewing speed	2,400rpm 2,000rpm				
Max. stitch length		6mm (normal/reverse feed)			
Needle bar stroke		33.4mm			
Lift of the presser foot	By hand: 7mm, By knee: 12mm	By hand: 8.5mm	By knee: 15mm		
Thread take-up		Slide type			
Alternating vertical movement		2.3 ~	6mm		
Hook	Vertical-axis 1.6 fold-capacity hook				
Needle	DP × 5 (#14) #14 ~ #16 For JE: 135 × 5 (Nm90)	DP × 17 (#23) #14 ~ #24 For JE: 135 × 17 (Nm160)	DP × 17 (#23) #16 ~ #24 For JE: 135 × 17 (Nm160)		
(at the time of delivery)			D Type: 135 × 17 (Nm110) Nm100 ~ Nm130 or DP × 17		
Thread	#50 ~ #30, B33 ~ B46 Nm=120/3 ~ 60/3	#40 ~ #8, B33 ~ B92 Nm=90/3 ~ 20/3	#30 ~ #5, B46 ~ B138 Nm=60/3 ~ 15/3		
Safety mechanism		Provided as standard			
Lubrication		By an oiler			
Lubricating oil	JUKI	New Defrix Oil No.1 (equivalent to ISO V	/G7)		
Distance from needle to machine arm		250mm			
Cylinder-bed diameter	72mm				
Weight of the machine head	36kg 38kg				
Automatic reverse feed function	Provided as standard				
Power requirement			Single-phase 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V		

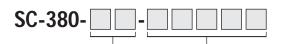
Without an automatic thread trimmer

LS-321 LS-341N

• With an automatic thread trimmer



#### • PSC box/control panel for SC



PSC box					
For Coporal Export	Single-phase	220 ~ 240V	07		
For General Export	3-phase	200 ~ 220V	11		
For JUS (LA)*	Single-phase	110 ~ 120V	37		
FOI JUS (LA)	3-phase	220 ~ 240V	38		
For CE	Single-phase	220 ~ 240V	34		

Control panel	Code
Not provided	00000
Control panel display language: English. Instruction manual comes in three different languages.	E500B
Control panel display language: English. Instruction manual comes in five different languages.	E500C

#### Motor for SC

M[			
	Motor		Code
For General Export	Single-phase 3-phase	220 ~ 240V	60
For JUS (LA)*	Single-phase	110 ~ 120V	61
FUI JUS (LA)	3-phase	220 ~ 240V	62
For CE	Single-phase	220 ~ 240V	63

* JUS: North America and Central and South America.

# EXCHANGEABLE GAUGE PARTS

Description	Pres	ser foot	Walking fo	oot	Notes
Standard	B1525-241-HA0	13	B1470-241-HA0	6.2	For DNU Stitch length: max. 10mm
	B1525-053-0A0	0	B1470-053-000 (D=2.8) B1470-053-C00 (D=2.3)	4.5	For LU & LS Stitch length: max. 10mm
	B1525-562-BA0	13	B1470-562-B00	4.5	Stitch length: max. 10mm With teeth
	B1525-563-E00	15.5	B1470-563-E00	2.310	Stitch length: max. 10mm
eft-hand type	B1524-245-0A0	6.6	B1470-245-000	6	DSC-245(-7), 246(-7) standard Stitch length: max. 6mm
	B1529-245-0AD (special order)	5.9	B1476-245-00D (special order)	4.1	Stitch length: max. 8mm With teeth
	B1529-245-0AC (special order)	6.1	B1476-245-00C (special order)	4.1 5.7	Stitch length: max. 6mm With teeth
	B1529-245-0AB (special order)	e e	B1476-245-00B (special order)	3.8 7	Stitch length: max. 8mm With teeth
	B1529-245-0AF (special order)	6.2	B1476-245-00F (special order)	2.16 E	Stitch length: max. 6mm With teeth
or binding	MAQ-092080A0 (with teeth)	0 (8.3	MAQ-09207000	10	Stitch length: max. 10mm

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Description	Press	er foot	Walkin	g foot	Notes
For binding	MAQ-093080A0 (with teeth)	โอ	MAQ-09307000		DSC-246V(-7) standard Stitch length: max. 10mm
		8.3	MAN-10452000	The ter	DSC-245V(-7) standard Stitch length: max. 10mm
Right-hand type	B1529-245-00A	0.7.5	B1476-245-00A	2255	Stitch length: max. 8mm With teeth
Wide type	103-25157	S S S	103-25306	2.3 2.8	Stitch length: max. 10mm Exclusive parts (for LU-1114) Throat plate: 103-25009 Feed dog: 103-25207
For leather (without teeth)	103-26304	S - 5	103-26205	2.3 U 2.3 U 2.8	Stitch length: max. 6mm Without finger guard Exclusive parts (for LU-1114) Throat plate: 103-26403 Feed dog: 103-26106
For piping	B1530-245-00		B1478-245-000 (commonly used for every size)	Ŵ.	Stitch length: max. 8mm Piping size C : 4.0mm (5/32") H: 7.9mm (5/16") D: 4.8mm (3/16") K : 9.5mm (3/8") F : 6.4mm (1/4")
Cut-out tail for piping	B1531-245-00	0.	B1478-245-00	Ŷ.	Stitch length: max. 8mm Piping size C : 4.0mm (5/32") D: 4.8mm (3/16") F : 6.4mm (1/4") H: 7.9mm (5/16")
For piping (with knurled foot)	B1525-245-00		B1472-245-00		Stitch length: max. 8mm Piping size D: 4.8mm (3/16") F : 6.4mm (1/4") H: 7.9mm (5/16") K : 9.5mm (3/18")
	B1526-245-00		B1473-245-00	Lucon.	Stitch length: max. 8mm Piping size D: 4.8mm (3/16") F : 6.4mm (1/4")
	B1527-245-00 (special order)		B1474-245-00 (special order)		Stitch length: max. 8mm Piping size C : 4.0mm (5/32") H: 7.9mm (5/16") D: 4.8mm (3/16") K : 9.5mm (3/8") F : 6.4mm (1/4")
Double groove	B1528-245-00		B1475-245-00B (commonly used for every size)		Stitch length: max. 8mm Piping size B : 3.2mm (1/8") H: 7.9mm (5/16") D: 4.8mm (3/16") K : 9.5mm (3/8") F : 6.4mm (1/4")

1-needle, Post-bed, Unison-feed, Lockstitch Machine

# PLC-1610 PLC-1610-7 (with an automatic thread trimmer)

- The post-shaped bed minimizes bed's diameter, thereby providing easy operation for three-dimensional sewing.
- Equipped with a unison-feed system that perfectly synchronizes the presser foot, feed dog and needle, the machine feeds large-sized materials smoothly and forcefully. This results in consistent sewing performance at high speeds without irregular feed.
- The presser foot rises up to 15mm. This allows the operator to place/remove heavy-weight materials such as urethane on/from the machine with ease. The machine is equipped as standard with a pneumatic auto-lifter.
- The vertical stroke (alternating vertical movement) of the presser foot and walking foot can be adjusted to 8mm at the maximum to accommodate the thickness of multi-layered portions of the material.
- With its vertical-axis 1.6 fold hook, the frequency of bobbin thread replacement is reduced. This hook increases efficiency and offers special advantages when using thick threads.

#### • PLC-1610-7

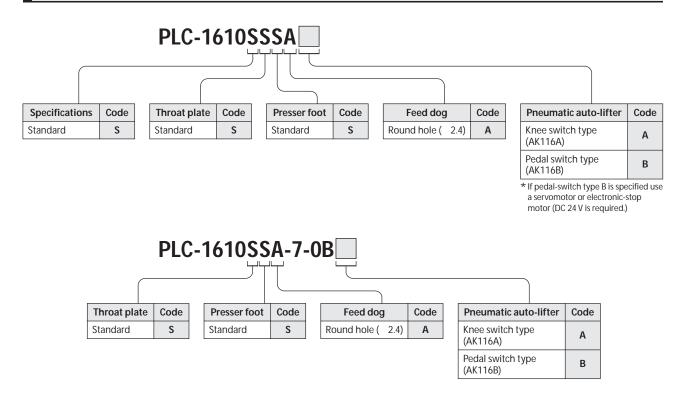
The machine is provided with a highly reliable thread trimmer that cuts thick thread without fail. No need for additional adjustment even when thread number count is changed.



PLC-1610-7-0B/XC-E500

## **SPECIFICATIONS**

Model name	PLC-1610	PLC-1610-7	
Max. sewing speed	2,000rpm		
Max. stitch length	6mm (normal/reverse feed)		
Needle bar stroke	33.4	mm	
Lift of the presser foot	By hand: 10mn	n, Auto: 15mm	
Auto lifter	Provided as standard (pne	eumatic auto-lifter: AK116)	
Thread take-up	Slide	type	
Alternating vertical movement	2 ~ 8mm		
Hook	Vertical-axis 1.6 fold-capacity hook		
Needle (at the time of delivery)	134 x 35 (Nm140) Nm110 ~ Nm160 (equivalent to #22, #18 ~ #23)		
Thread	#30 ~ #5, B46 ~ B138, Nm=60/3 ~ 15/3		
Lubrication	By an oiler		
Lubricating oil	JUKI New Defrix Oil No.1	(equivalent to ISO VG7)	
Compressed air and air consumption	0.5MPa (5kgf/cr	m²), 0.3NQ/min	
Safety mechanism	Provided a	s standard	
Bobbin winder	Built on the r	machine arm	
Post height	161.7	7mm	
Bed size	517mm × 178mm		
Weight of the machine head	48kg 50kg		
Automatic reverse feed function	Provided as standard		
Power requirement		Single-phase 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V	



• PSC box/control panel for SC



				_				
PSC box		Code Control pa		nel	Code			
	Single-phas	se 220 ~ 240V	07		Not provided		00000	
	3-phase	200 ~ 220V	11		Control panel display language: E		E500B	
	Single-phas	se 110 ~ 120V	37		Instruction manual comes in three different language			
	3-phase	220 ~ 240V	38		Control panel display language: E Instruction manual comes in five		E500C	
	Single-phas	se 220 ~ 240V	34			5 5		

#### Motor for SC

For General Export

For JUS (LA)*

For CE

M[			
	Motor		Code
For General Export	Single-phase 3-phase	220 ~ 240V	60
For JUS (LA)*	Single-phase	110 ~ 120V	61
	3-phase	220 ~ 240V	62
For CE	Single-phase	220 ~ 240V	63

* JUS: North America and Central and South America.

#### 2-needle, Post-bed, Unison-feed, Lockstitch Machine

# PLC-1660

- The post-shaped bed minimizes bed's diameter, thereby providing easy operation for three-dimensional sewing.
- Equipped with a unison-feed system that perfectly synchronizes the presser foot, feed dog and needle, the machine feeds large-sized materials smoothly and forcefully. This results in consistent sewing performance at high speeds without irregular feed.
- The presser foot rises up as high as 15mm. This allows the operator to place/remove heavy-weight materials such as urethane on/from the machine with ease. The machine is equipped as standard with a pneumatic auto-lifter.
- The vertical stroke (alternating vertical movement) of the presser foot and walking foot can be adjusted to 8mm at the maximum to accommodate the thickness of multi-layered portions of the material to be used.
- With its vertical-axis 1.6 fold hook, the frequency of bobbin thread replacement is reduced. This hook helps to upgrade efficiency and offers special advantages when using thick threads.

# PLC-1660L (thick-thread long-pitch type)

• With its large-sized thread take-up lever and wide-diameter pulley, the machine can handle threads as thick as #1 (B207, Nm=8/3) and the stitch length can be set to 10mm at the maximum.

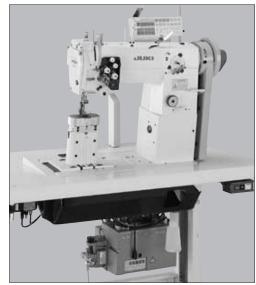
# PLC-1665 (with organized split needle bars)

• With its organized split needle bars, the machine produces wellbalanced beautiful topstitch-seams at the corners of materials.

# PLC-1660-7 (with an automatic thread trimmer)

- •The machines is provided with a highly reliable thread trimmer that cuts thick thread without fail. The thread trimmer trims thread with consistency and absolutely. No need for additional adjustment even when thread number count is changed.
- Reverse-feed stitching operation can be started simply by pressing the one-touch-type reverse-feed button.

Furthermore, if a suspended ruler is attached on the machine or a 3dimensional sewing product is sewn, the button can be shifted upward to prevent interruption.



PLC-1660-7-0B/XC-E500

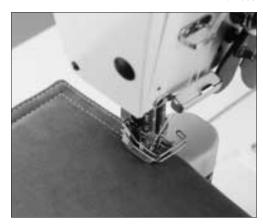


PLC-1660L



PLC-1665

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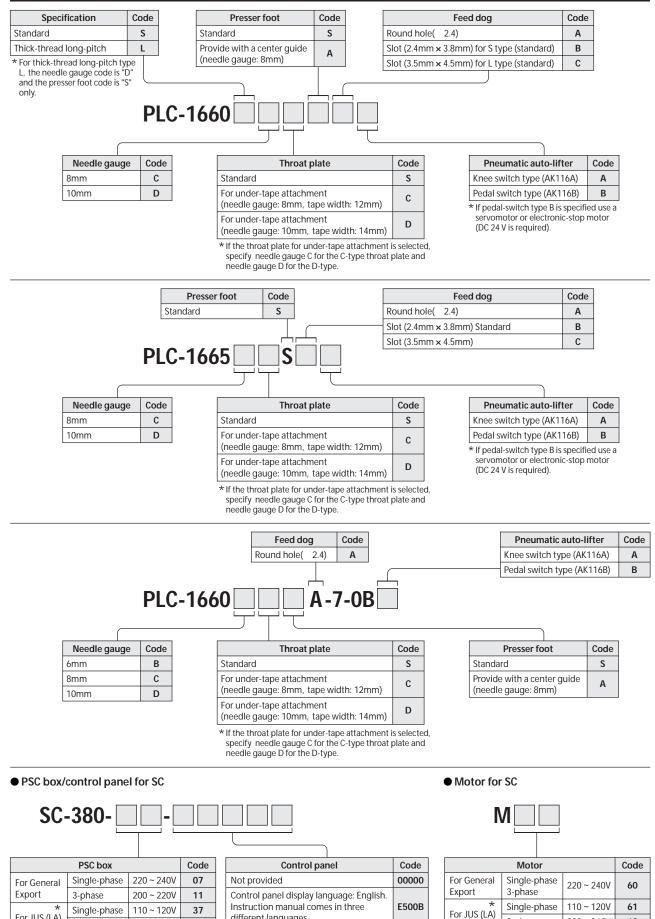
PLC-1660, 1660L, 1665, 1660-7 (June, 2001) 1/3

## SPECIFICATIONS

Model name	PLC-1660	PLC-1660L	
wodername		Thick-thread long-pitch type	
Max. sewing speed	2,000rpm	Stitch length: 6mm or less (2,000rpm) Stitch length: 6 ~ 10mm (1,200rpm)	
Max. stitch length	6mm (normal/reverse feed)	10mm (normal/reverse feed)	
Needle bar stroke	33.4mm		
Needle gauge (mm)	8, 10	10	
Lift of the presser foot	By hand: 10mm, Auto: 15mm		
Auto lifter	Provided as standard (pneumatic auto-lifter: AK116)		
Thread take-up	Slide type	Slide type (large)	
Alternating vertical movement	2 ~ 8mm		
Hook	Vertical-axis 1.6 fold-capacity hook		
Needle (at the time of delivery)	134 × 35 (Nm140) Nm110 ~ Nm160 (equivalent to #22, #18 ~ #23)	134 × 35 (Nm180) Nm140 ~ Nm200 (equivalent to #24, #22 ~ #25 )	
Thread	#30 ~ #5, B46 ~ B138, Nm=60/3 ~ 15/3	#8~#1, B92~B207, Nm=30/3~8/3	
Lubrication	By an oiler		
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)		
Compressed air and air consumption	0.5MPa (5kgf/cm²), 0.3N&/min		
Safety mechanism	Provided as standard		
Bobbin winder	Built on the machine arm		
Post height	161.7mm		
Bed size	517mm × 178mm		
Weight of the machine head	49kg		

Model name	PLC-1665	PLC-1660-7	
Model Hame	With organized split needle bars	With an automatic thread trimmer	
Max. sewing speed	1,800rpm	2,000rpm	
Max. stitch length	6mm (normal/	(reverse feed)	
Needle bar stroke	33.4	mm	
Needle gauge (mm)	8, 10	6, 8, 10	
Lift of the presser foot	By hand: 10mm, Auto: 15mm		
Auto lifter	Provided as standard (pneumatic auto-lifter: AK116)		
Thread take-up	Slide type		
Alternating vertical movement	2 ~ 8mm		
Hook	Vertical-axis 1.6 fold-capacity hook		
Needle (at the time of delivery)	134 x 35 (Nm140) Nm110 ~ Nm160 (equivalent to #22, #18 ~ #23)		
Thread	#30 ~ #5, B46 ~ B138, Nm=60/3 ~ 15/3		
Lubrication	By an oiler		
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)		
Compressed air and air consumption	0.5MPa (5kgf/cm ² ), 0.3NØ/min		
Safety mechanism	Provided as standard		
Bobbin winder	Built on the machine arm		
Post height	161.7mm		
Bed size	517mm × 178mm		
Weight of the machine head	48kg	51kg	
Automatic reverse feed function		Provided as standard	
Power requirement		Single-phase 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V	

## WHEN YOU PLACE ORDERS



different languages.

different languages.

Control panel display language: English.

Instruction manual comes in five

38

34

220~240V

220~240V

Downloaded from www.Manualslib.com manuals search engine

3-phase

Single-phase

* JUS: North America and Central and South America

For JUS (LA)

For CF

220 ~ 240V

220 ~ 240V

62

63

3-phase

For CE

E500C

Single-phase

1-needle, High Post-bed, Unison-feed, Lockstitch Machine

# PLC-1690 (with a vertical-axis 1.6 fold-capacity hook) PLC-1691 (with a vertical-axis standard hook)

- The newly developed high post-bed machine has a post with a compactfinished top to support difficult sewing processes that conventional machines can't handle such as bottom sewing or gore sewing. The distance from the needle entry to the right end of the bed, the most important design feature of the machine, is as short as 2.8mm. The PLC-1690 comes in two different types: one with a "flat-surface type (S)" and another with a "curved-surface type (A)". You can select the type that best fits your needs.
- The PLC-1691 is provided with a vertical-axis standard hook and the top end of its post is minimized in size. With its outstanding sharp-curve sewing capability and operability, the machine is ready to sew diversely designed articles such as bags with narrow gores.
- The machine is designed to handle the basic processes required for the sewing of bags. With the new increase in the alternating vertical movement of the walking foot and presser foot to a maximum of 7mm, the machine can now handle sewing materials with many multi-layered portions. In addition, the lift of the presser foot is large* enough to allow the operator to easily set and remove sewing materials on the * PLC-1690S: 15mm PLC-1690A, PLC-1691: 10.5mm machines.
- A bobbin winder is mounted on the front surface of the machine arm. Stitch length can be adjusted with the stitch dial. In addition, the large-sized handwheel (175) can be easily turned by the operator when performing one-stitch sewing.



PCL-1691

## SPECIFICATIONS

Mandal warran	PLC-1690S	PLC-1690A	PLC-1691
Model name	Throat plate: flat-surface type	Throat plate: curved-surface type	
Max. sewing speed	1,600rpm		
Max. stitch length	6mm (normal/reverse feed)		
Needle bar stroke	38mm		36mm
Lift of the presser foot	By hand: 10mm, By knee: 15mm	By hand: 5.5mm, By knee: 10.5mm	
Thread take-up	Slide type		
Alternating vertical movement	2 ~ 7mm		
Hook	Vertical-axis 1.6 fold-capacity hook Vertical-axis standard h		Vertical-axis standard hook
Needle (at the time of delivery)	134 × 35 (Nm120) Nm100 ~ Nm140		
Thread	#30 ~ #8, B46 ~ B92, Nm=60/3 ~ 30/3		
Lubrication	By an oiler		
Lubricating oil	JUKI New Defrix Oil No. 1 (equivalent to ISO VG7)		
Safety mechanism	Provided as standard		
Bobbin wider	Built on the machine arm		
Post height	420mm	424.5mm	
Post position	Left		
Bed size	517mm × 178mm		
Weight of the machine head	57kg		

## WHEN YOU PLACE ORDERS

PLC-1690	
Throat plate	Code
Flat-surface type (Standard)	S
Curved-surface type	Α

Pneumatic auto-lifter	Cod
Not provided	
Knee switch type (AK116A)	Α

ode

**PLC-1691** 

Pedal switch type (AK116B) В * If pedal-switch type B is specified use a servomotor

or electronic-stop motor (DC 24 V is required).

#### Post-bed, Bottom-feed Lockstitch Machine

# PLH-981 (1-needle) PLH-982 (2-needle)

- With JUKI's unique slide thread take-up lever, feed mechanism, and vertical-axis hook, the machine provides well-tensed, neatly finished seams every time.
- The stitch length can easily be adjusted with the stitch dial. Reverse-feed stitching is actuated by a simple press of the lever. The machine incorporates a large pulley that can be turned smoothly by hand.
- The face plate is designed to provide a clear view of the needle entry area and enable smooth thread feeding.

#### Post-bed, Needle-feed Lockstitch Machine

# $\frac{PLN-985}{PLN-986} (1-needle)$

• With a needle-feed mechanism that operates in synchronization with the bottom-feed, the machine produces beautiful seams free from slippage even when sewing slippery or hard-to-feed materials.





PLH-981





PLH-981



PLN-986

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#### SPECIFICATIONS

Model name	PLH-981	PLH-982	PLN-985	PLN-986	
wodel name	1-needle	2-needle	1-needle	2-needle	
Feed system	Bottom-feed Needle-feed			e-feed	
Max. sewing speed	2,500rpm				
Max. stitch length	4mm (normal/reverse feed)				
Needle bar stroke	36mm 33.4mm			mm	
Needle gauge (mm)	1.2, 1.6, 2.0, 2.4 (standard)			2.0, 2.4 (standard)	
Lift of the presser foot	By hand: 7mm, By knee: 10mm By hand: 6.5mm, By knee: 9mm			m, By knee: 9mm	
Thread take-up	Slide type				
Hook	Vertical-axis hook				
Needle (at the time of delivery)	DP × 5 (#18) #16 ~ #21 DP × 5 (#16) #16 ~ #21			) #16 ~ #21	
Thread	#40 ~ #8, B33 ~ B92, Nm=90/3 ~ 30/3				
Lubrication	By an oiler				
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)				
Post height	178mm 179mm			mm	
Bed size	517mm × 178mm				
Weight of the machine head	36	kg	40	kg	

• 1-needle, Bottom-feed

# PLH-981

• 2-needle, Bottom-feed

# Needle gauge Code 1.2mm 12 1.6mm 16 2.0mm 20 2.4mm (standard) 24

• 1-needle, Needle-feed

# PLN-985

• 2-needle, Needle-feed

PLN-9	86B		
	Needle gauge		Code
	1.6mm		16
	2.4mm (standard)		24

#### GAUGE TABLE (2-NEEDLE TYPE)

Model name	Needle gauge	Gauge set	Needle clamp	Needle guide	Throat plate	Feed dog
PLH-982				<pre>{</pre>	et :: 19	
	1.2mm	210-16357	210-17405	210-18908	210-16308	210-21100
	1.6mm	210-16159	210-17405	210-10900	210-16100	210-21100
	2.0mm	210-16258	210-17504	210-18809	210-16209	210-21209
	2.4mm (standard)	210-16050	210-17504	210-16609	210-16019	210-21308

PLN-986				PL.	all a	
	1.6mm	210-32156	210-17405	210-33006	210-32107	210-31109
	2.4mm (standard)	210-32255	210-17504	210-33105	210-32206	210-31208

#### 1-needle, Semi-long Flat-bed, Lockstitch Machine with a Large Shuttle-hook for Extra Heavy-weight Materials

# $\frac{TU-273}{(\mathsf{top}\ \&\ \mathsf{bottom-feed})} \\ TNU-243 \\ (\mathsf{unison-feed}) \\ \end{array}$

- The machine has a wider free space under the machine arm to allow the operator to easily place and remove a large sewing products.
- The machine comes with a large shuttle-hook. This type of shuttle-hook helps to reduce the frequency of bobbin thread replacement and is best suited for the sewing of extra heavy-weight materials sewn with lower-count threads.
- The lifting range of the presser foot is as high as 20mm for smooth placement/removal of extra heavy-weight materials.

#### • TU-273

The top-feed amount is adjustable within the range of  $\pm 20\%$  of the bottom-feed amount.

#### • TNU-243

Thanks to the TNU-243's unison-feed mechanism, the machine's higher feed efficiency guarantees the output of high-quality seams free from uneven material feed.



TNU-243



#### SPECIFICATIONS

Model name	TU-273 TNU-243			
Feed system	Top & bottom-feed Unison-feed			
Max. sewing speed	800rpm			
Max. stitch length	15mm (normal/reverse feed)			
Needle bar stroke	56mm			
Lift of the presser foot	By hand: 12mm, By pedal: 20mm			
Alternating vertical movement	4 ~ 8mm			
Thread take-up	Cam-type			
Hook	Large shuttle-hook			
Needle (at the time of delivery)	794 (Nm230) Nm130 ~ Nm280 or DY × 3 #21 ~ #28			
Thread	#8 ~ #0, B92 ~ B277, Nm=30/3 ~ 8/3			
Lubrication	By an oiler			
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)			
Bobbin wider	Built on the machine arm			
Distance from needle to machine arm	420mm			
Bed size	656mm × 253mm			
Weight of the machine head	65kg			

#### WHEN YOU PLACE ORDERS

Auto-lifter	Code
Not provided	
Knee switch type (AK72A)	Α
Pedal switch type (AK72B)	В

# Unison-feed, Long Arm Lockstitch Machine with Vertical-axis Large Hook

# LG-158 (2-needle) LG-158-1 (1-needle)

- With its 750mm wide space under the arm and a handwheel mounted at the middle of the arm, the machine is ideal for the sewing of heavy-weight materials such as tents and sheets. A large material can be sewn with spreading on the bed.
- With its unison-feed mechanism that ensures a smooth and steady feed of materials, the machine provides consistent seam quality with no material slippage. Eleven different kinds of needle gauges are prepared for the LG-158. The most suitable gauge for the current machine use can easily be selected.
- Since the machine incorporates a vertical-axis large hook, the frequency of bobbin thread replacement is reduced, further increasing efficiency.
- The bobbin winder is installed at the front face of the arm for easy operation.
- The presser foot goes up as high as 21.5mm to ensure easy placement/removal of extra heavy-weight materials.





#### WHEN YOU PLACE ORDERS

#### SPECIFICATIONS

Model nameLG-158LG-158-12-needle1-needleMax. sewing speed1,500rpmMax. stitch length10mm (normal/reverse feed)Needle bar stroke46.9mmNeedle gaugeStandard 19.1mm (3/4")Lift of the presser footBy pedal: 21.5mmThread take-upSide typeAlternating vertical movement6 ~ 19mmHookVertical-axis large hookNeedle (at the time of delivery)DD x 1 (#25)Thread#20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3Safety mechanismProvided as standardBobbin winderBuilt on the machine arm				
2-needle1-needleMax. sewing speed1,500rpmMax. stitch length10mm (normal/reverse feed)Needle bar stroke46.9mmNeedle gaugeStandard 19.1mm (3/4")Lift of the presser footBy pedal: 21.5mmThread take-upSide typeAlternating vertical movement6 ~ 19mmHookVertical-axis large hookNeedle (at the time of delivery)DD x 1 (#25)Thread#20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3Safety mechanismProvided as standardBobbin winderBuilt on the machine arm	Model name	LG-158	LG-158-1	
Max. stitch length10mm (normal/reverse feed)Needle bar stroke46.9mmNeedle gaugeStandard 19.1mm (3/4")Lift of the presser footBy pedal: 21.5mmThread take-upSide typeAlternating vertical movement6 ~ 19mmHookVertical-axis large hookNeedle (at the time of delivery)DD x 1 (#25)Thread#20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3Safety mechanismProvided as standardBobbin winderBuilt on the machine arm	Wodername	2-needle	1-needle	
Needle bar stroke       46.9mm         Needle gauge       Standard 19.1mm (3/4")         Lift of the presser foot       By pedal: 21.5mm         Thread take-up       Side type         Alternating vertical movement       6 ~ 19mm         Hook       Vertical-axis large hook         Needle (at the time of delivery)       DD x 1 (#25)         Thread       #20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3         Safety mechanism       Provided as standard         Bobbin winder       Built on the machine arm	Max. sewing speed	1,500rpm		
Needle gaugeStandard 19.1mm (3/4")Lift of the presser footBy pedal: 21.5mmThread take-upSide typeAlternating vertical movement6 ~ 19mmHookVertical-axis large hookNeedle (at the time of delivery)DD x 1 (#25)Thread#20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3Safety mechanismProvided as standardBobbin winderBuilt on the machine arm	Max. stitch length	10mm (normal/reverse feed)		
Lift of the presser foot     By pedal: 21.5mm       Thread take-up     Side type       Alternating vertical movement     6 ~ 19mm       Hook     Vertical-axis large hook       Needle (at the time of delivery)     DD x 1 (#25)       Thread     #20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3       Safety mechanism     Provided as standard       Bobbin winder     Built on the machine arm	Needle bar stroke	46.9mm		
Thread take-up     Side type       Alternating vertical movement     6 ~ 19mm       Hook     Vertical-axis large hook       Needle (at the time of delivery)     DD × 1 (#25)       Thread     #20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3       Safety mechanism     Provided as standard       Bobbin winder     Built on the machine arm	Needle gauge	Standard 19.1mm (3/4")		
Alternating vertical movement       6 ~ 19mm         Hook       Vertical-axis large hook         Needle (at the time of delivery)       DD x 1 (#25)         Thread       #20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3         Safety mechanism       Provided as standard         Bobbin winder       Built on the machine arm	Lift of the presser foot	By pedal: 21.5mm		
HookVertical-axis large hookNeedle (at the time of delivery)DD x 1 (#25)Thread#20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3Safety mechanismProvided as standardBobbin winderBuilt on the machine arm	Thread take-up	Side type		
Needle (at the time of delivery)     DD × 1 (#25)       Thread     #20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3       Safety mechanism     Provided as standard       Bobbin winder     Built on the machine arm	Alternating vertical movement	6 ~ 19mm		
Thread#20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3Safety mechanismProvided as standardBobbin winderBuilt on the machine arm	Hook	Vertical-axis large hook		
Safety mechanism         Provided as standard           Bobbin winder         Built on the machine arm	Needle (at the time of delivery)	DD × 1 (#25)		
Bobbin winder         Built on the machine arm	Thread	#20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3		
	Safety mechanism	Provided as standard		
	Bobbin winder	Built on the machine arm		
Lubrication By an oiler	Lubrication	By an oiler		
Lubricating oil         JUKI New Oil No.1 (equivalent to ISO VG7)	Lubricating oil	JUKI New Oil No.1 (equivalent to ISO VG7)		
Distance from needle to machine arm 750mm	Distance from needle to machine arm	<b>n</b> 750mm		
Bed size 1,088mm × 230mm	Bed size	1,088mm × 230mm		
Weight of the machine head 108kg	Weight of the machine head	108	Bkg	

# LG-158-1

Needle gauge (mm)	Code
6.4 (1/4")	F
7.9 (5/16")	Н
9.5 (3/8")	К
12.7 (1/2")	L
15.9 (5/8")	М
19.1 (3/4") Standard	N
25.4 (1")	Q
31.8 (1-1/4")	S
38.1 (1-1/2")	U
50.8 (2")	2
63.5 (2-1/2")	3

LG-158

#### EXCHANGEABLE GAUGE PARTS

Needle gauge (mm)	Needle clamp asm.	Presser foot	Walking foot	Throat plate	Feed dog	Slide plate Left	Slide plate Right
				(and	A A A A A A A A A A A A A A A A A A A		9
6.4 (1/4")	B1401-057-FAB	B1525-057-F00	B1470-158-FB0	B1109-057-F00	B1613-057-F00	B1112-057-F00	B1113-057-F00
7.9 (5/16")	B1401-057-HAB	B1525-057-H00	B1470-158-HB0	B1109-057-H00	B1613-057-H00	B1112-057-H00	B1113-057-H00
9.5 (3/8")	B1401-057-KAB	B1525-057-K00	B1470-158-KB0	B1109-057-K00	B1613-057-K00	B1112-057-K00	B1113-057-K00
12.7 (1/2")	B1401-057-LAB	B1525-057-L00	B1470-158-LB0	B1109-057-L00	B1613-057-L00	B1112-057-L00	B1113-057-L00
15.9 (5/8")	B1401-057-MAB	B1525-057-M00	B1470-158-MB0	B1109-057-M00	B1613-057-M00	B1112-057-M00	B1113-057-M00
19.1 (3/4")	B1401-057-NAB	B1525-057-N00	B1470-158-NB0	B1109-057-N00	B1613-057-N00	B1112-057-N00	B1113-057-N00
25.4 (1")	B1401-057-QAB	B1525-057-Q00	B1470-158-QB0	B1109-057-Q00	B1613-057-Q00	B1112-057-Q00	B1113-057-Q00
31.8 (1-1/4")	B1401-057-SAB	B1525-057-S00	B1470-158-SB0	B1109-057-S00	B1613-057-S00	B1112-057-S00	B1113-057-S00
38.1 (1-1/2")	B1401-057-UAB	B1525-057-U00	B1470-158-UB0	B1109-057-U00	B1613-057-U00	B1112-057-U00	B1113-057-U00
50.8 (2")	B1401-057-2AB	B1525-057-200	B1470-158-2B0	B1109-057-200	B1613-057-200	B1112-057-200	B1113-057-200
63.5 (2-1/2")	B1401-057-3AB	B1525-057-300	B1470-158-3B0	B1109-057-300	B1613-057-300	B1112-057-300	B1113-057-300

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1-needle, Semi-long Cylinder-bed, Lockstitch Machine with a Large Shuttle-hook for Extra Heavy-weight Materials

TSH-411 (bottom-feed) TSN-421 (needle-feed) TSU-471 (top & bottom-feed) TSC-441 (unison-feed)

- The machine has a wider free space under the machine arm to allow the operator to easily place and remove a large sewing products. In addition, the machine has outstanding capabilities in the sewing of sharp curves.
- The lifting range of the presser foot is up to 20mm for smooth placement/removal of extra heavy-weight materials.
- The machine comes with a large shuttle-hook. This type of shuttle-hook helps to reduce the frequency of bobbin thread replacement and is best suited for the sewing of extra heavy-weight materials sewn with lower-count threads.



TSC-441

18

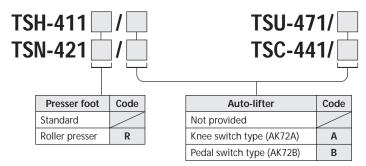
#### FEATURES

Model name	Feature	Application
TSH-411	The TSH-411 can be modified to sew sharp curves by replacing the presser foot with a roller presser.	Decorative stitches on shoes, bag handles, etc.
TSN-421	With its bottom-feed and feed-dog feed, the machine sews articles entirely free from uneven material feed.	Shoes, seat belts, etc.
TSU-471	The top-feed amount is adjustable within the range of $\pm$ 30% of the bottom-feed.	Gloves, tents, bags, bag handles, shirring, tape-attachment with a binder installed on the machine, etc.
TSC-441	A top & bottom-feed mechanism has been added to the machine's needle-feed system. This ensures a higher feed efficiency and the production of higher-quality seams without uneven material feed.	Bags, pouches, shoes, seat belts, etc.

#### **SPECIFICATIONS**

Model name	TSH-411 TSN-421 TSU-471 TSC-441					
Feed system	Bottom-feed	Needle-feed	Top & bottom-feed	Unison-feed		
Max. sewing speed		800	)rpm			
Max. stitch length	11mm (normal/reverse feed)					
Needle bar stroke		56mm				
Lift of the presser foot	By hand: 12mm, By pedal: 20mm					
Thread take-up	Cam-type					
Alternating vertical movement	4 ~ 8mm					
Hook	Large capacity shuttle hook					
Needle (at the time of delivery)	794 (Nm230) Nm130 ~ Nm280					
Thread	#8 ~ #0, B92 ~ B277, Nm=30/3 ~ 8/3					
Lubrication	By an oiler					
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)					
Bobbin winder	Built on the machine arm					
Distance from needle to machine arm	420mm					
Cylinder-bed diameter	81mm					
Weight of the machine head		56	5kg			

#### WHEN YOU PLACE ORDERS



Super-long Cylinder-bed, 1-needle, Lockstitch Machine with a Large Shuttle-hook for Extra Heavy-weight Materials

## TSC-461

- It is equipped with a free space under the arm as wide as 950mm, which means that the machine is capable of sewing large materials, long-sized materials and tubular sewn products with ease.
- The lift of the presser foot is high as 20mm. The lifting amount of the presser foot is sufficient to sew extra heavy-weight materials.
- The machine comes with a large shuttle hook and large bobbin which have been exclusively designed for sewing extra heavy-weight materials: these reduce the frequency of bobbin replacement, thereby leading to higher efficiency in sewing extra heavy-weight materials using thick threads. When compared with the conventional 45K bobbin, the amount of thread wound around the newly developed large bobbin is increased by 50%.



TSC-461

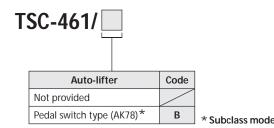
#### Applications

Carrying bags, transportation equipment, sporting goods.

#### SPECIFICATIONS

Model name	TSC-461
Max. sewing speed	650rpm
Max. stitch length	11mm (normal/reverse feed)
Needle bar stroke	56mm
Lift of the presser foot	By hand: 12mm, By pedal: 20mm
Reverse feed stitching method	By lever
Thread take-up	Cam type thread take-up
Alternating vertical movement	4 ~ 8mm
Hook	Large capacity shuttle hook
Needle (at the time of delivery)	794 (Nm230) Nm=130 ~ Nm280
Thread	#8 ~ #0, B92 ~ B277, Nm=30/3 ~ 8/3
Lubrication	By an oiler
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)
Bobbin wider	Built on the machine arm
Top-feed method	Interlocked with the bottom-feed mechanism
Distance from needle to machine arm	950mm

#### WHEN YOU PLACE ORDERS



#### * Subclass model: TSC-461/AK78

The conventional presser foot lifting pedal needs to be operated applying a considerably high pressure on it, which means that the operator gets tired of depressing the pedal. This machine, however, allows the operator to lightly lift the presser foot using the pedal. Thanks to the micro computer-controlled motor, the needle stop position can be controlled as desired.

# AC SERVOMOTOR/ELECTRONIC-STOP MOTOR SERIES

#### AC SERVOMOTOR/CONTROLLER SC-800

- The servomotor starts up and stops with high speed and extreme accuracy. With its proven reliability and quality, the machine offers further upgraded efficiency and comfort in operation.
- The introduction of a compact AC servomotor reduces the total weight of the machine and helps reduce vibration and noise during operation. The controller is completely shielded by an aluminum frame to absorb external impacts such as static electricity.



SC-800

#### CONTROL PANEL

- The control panel can be selected according to the process.
- A series of function has been developed to allow the operator to make a choice on the panel in accordance with the process in which the sewing machine is to be used.
- The control panel is provided with many different kinds of functions, which means that it can respond to any sewing need.

1-needle, lockstitch machine	LH-series	LZ-series
CP-60	CP-60B	CP-60B
CP-160	CP-160B	CP-160B
CP-360	CP-360B	



CP-60, CP-60B

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	Blan	, 9999		2.9

CP-160, CP-160B



CP-360, CP-360B

#### CONTROL PANEL SPECIFICATIONS

N.	E contra c	D'stand	00 (0	00.4/0	00.0/0
No.	Function	Pictgraph	CP-60	CP-160	CP-360
1	Power indicator lamp (LED)				
2	Max. speed limitation variable resistor				
3	Thread trimming prohibition switch	×			
4	Soft-start				
5	Automatic count back			**	**
6	Material edge sensor ON/OFF switch	(	**	*	*
7	Function of detecting the remaining amount of bobbin thread				
8	Automatic thread trimming switch	×			
9	Back tack pattern switch				
10	Overlapped stitching pattern switch				
11	Bobbin thread counter				
12	Needle up/down compensating switch				
13	One-shot automatic stitching switch	0			
14	Double back tack switch	[M] [N]			
15	Key lock	-9			
16	Constant-dimension stitching pattern	ALB1 ACD Fel			
17	Programmable seam length	C C C C B			
18	Production counter	<u>\.2.3.</u>			
19	Programmed stitching pattern	<b>Þ</b>			
20	Combined stitching pattern switch	••			
21	Re-sewing switch	ſ			
22	Teaching switch	T			
23	Presser foot lifting time setting switch	LL sec			

Designated on the control box.

- Operative when the machine is equipped with a remaining bobbin thread detector (AE: optional).
- ** Operative when the machine is equipped with a material edge sensor (ED: optional).

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#### PSC BOX/CONTROL PANEL/MOTOR FOR SC

• 1-needle, lockstitch machine SC800-D Α **Control box** Code **Pulley belt** Code **Control panel** Code S 060 Standard Lockstitch for general fabric CP-60 D Pulley: 75, Belt: 38 inches CP-160 160 Optional unit A Α (for the ED-2 and the AE-4) CP-360 360 • LH-3100 series **SC800** B Н **Control box** Code **Pulley belt** Code **Control panel** Code Standard S For LH CP-60 060 н 75, Belt: 39 inches Pulley: CP-160 160 CP-360 360 LZ-2280N series **SC800-**SZ-В **Control panel** Code **Control box** Code **Pulley belt** Code For zigzag stitching machine Pulley: 75, Belt: 40 inches Standard S CP-60 060 Ζ CP-160 160 DLU-5494N-7 SC801-AD-560 **Control box** Code Pulley belt Code **Control panel** Code Optional unit A Α Lockstitch for general fabric CP-560 560 D Pulley: 75, Belt: 38 inches LH-3162-7, LH-3182-7 SC804-**SH-660B** Code **Control box Pulley belt** Code **Control panel** Code S CP-660 Standard For LH 660 Н 75, Belt: 39 inches Pulley:

	Р	SC box		Code
	Single-phase	* PFL	Japanese, English, Chinese	07
For General	220V	PFL	English, German, French, Spanish, Italy	08
Export	Export 3-phase		Japanese, English, Chinese	11
	220V	PFL	English, German, French, Spanish, Italy	12
For CE	Single-phase 230V	* PFL	English, German, French, Spanish, Italy	34
** For JUS	Single-phase 120V	* PFL	English, German, French, Spanish, Italy	37
(LA)	3-phase 220V	* PFL	English, German, French, Spanish, Italy	38

* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

** JUS: North America and Central and South America.

SC-800, SC-380, EC-10B, SC-350 (June, 2001) **2/6** Downloaded from <u>www.Manualslib.com</u> manuals search engine

#### AC SERVOMOTOR/CONTROLLER SC-380

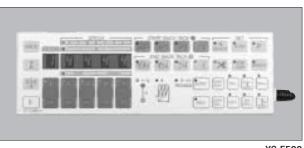
- The SC-380 is provided with many different standard functions, including speed-control, soft-start, automatic reverse stitching with the specified number of stitches, constantdimension stitching, and overlapped (multi-layered) stitching. These functions ensure sewing performance optimally suited to the material and process.
- With its higher torque under low-speed sewing, the SC-380 enables the machine to smoothly start sewing operation. The unit is also provided with additional capabilities to enhance the sewing of extra-heavy-weight materials by increasing the cloth-penetrating force of the needle for the first stitch, reversing the rotation direction of the motor to bring the needle to its upper end position after thread trimming, etc. With these capabilities, the sewing machine is able to demonstrate optimal sewing performance both widely and smoothly when working with heavy-weight materials.



SC-380

#### CONTROLLER PANEL (OPTION)

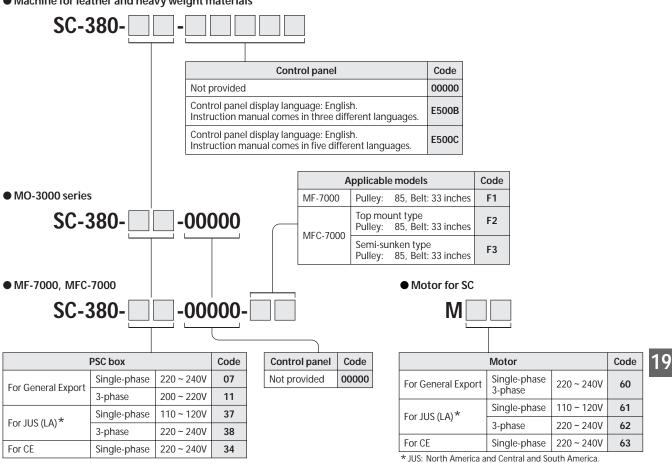
- The XC-E500 is provided with program sewing and a host of other functions that contribute to increased efficiency.
- The XC-E500 can be installed on the top of the sewing machine. All functions provided by the XC-E500 can only be specified through the control panel.
- Data programmed in the control panel can be transferred to another sewing machine unit.



XC-E500

#### PSC BOX/CONTROL PANEL/MOTOR FOR SC

• Machine for leather and heavy weight materials



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#### **ELECTRONIC-STOP MOTOR/** CONTROL BOX EC-10B

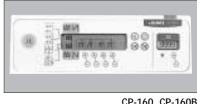
- The EC-10B enables the sewing machine to perform thread trimming, stop with its needle up/down, perform automatic reverse feed stitching at sewing start and sewing end, and perform one-touch reverse feed stitching with a switch. Needless to say, the number of reverse feed stitches can be specified.
- A contactless electromagnetic coupling is adopted. This means that the clutch disc does not require any maintenance. Furthermore, cooling efficiency is enhanced, there by preventing the motor from running at very hot temperatures.
- In addition to the EC-10B's error-identification and signal input/output checking modes, the machine features a new resistor pack system for identification of sewing machine used for improved maintainability.



EC-10B

#### CONTROLLER PANEL CP-160 (OPTION)

- Along with its standard functions, the control panel offers users a bobbin thread counter for higher efficiency and pattern sewing. Functions such as multilayer stitching, constant-dimension sewing, and rectangle stitching.
- The easy-to-read control panel facilitates function selection and easy input of sewing data such as the number of stitches.
- 1-needle, lockstitch machine: CP-160
- LH-3100 series, LZ-2280N series: CP-160B



CP-160, CP-160B

• The optional ED-2 material edge sensor can be attached to the control panel. (for 1-needle, lockstitch machine)

#### CONTROL PANEL SPECIFICATIONS

No.	Function	EC-10	B	EC10B/ (optic	
1	Automatic thread trimmer				
2	Automatic back tack function				
3	Wiper				
4	Soft-start				
5	Auto-lifter		ł	÷	
6	Support for sewing machine for standing use		*	*	
7	Stop with needle up/down				
8	Normal stop with needle up				
9	Normal stop with needle down				
10	Automatic back tack stitching at sewing start		Ŋ		N
11	Automatic stitching at sewing end		N		N
12	Back tack pattern switch	(0 ~ 15 stit	tches)	(0 ~ 19 stitches)	
13	Max speed limitation variable resistor				*/ **
14	Thread trimming prohibition switch				8
15	Needle up/down compensating switch				
16	Double back tack switch for start				[M]
17	Double back tack switch for end				[N]
18	Overlapped stitching pattern switch				
19	Constant-dimension stitching pattern				ALB1 ACD ACD
20	Programmable seam length				BSAA c_cN B
21	Bobbin thread counter				■
22	Material edge sensor			***	

Specified inside the control box.

• Operative when the machine is equipped with an auto-lifter (AK83: optional).

• Pedal unit (PK-70, or 71: optionally available) for standing work can be attached to the sewing machine.

 Operative when the machine is equipped with a material edge sensor (ED-2:optional). (for 1-needle, lock stitch machine)

#### PSC BOX/CONTROL PANEL/MOTOR FOR EC-10B

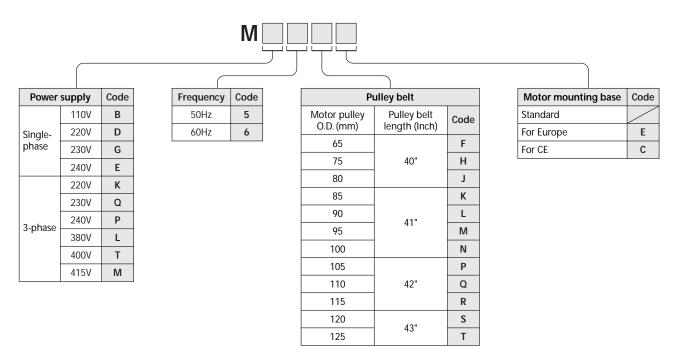


	Power supply				
	For General Export	220V	PFL	F	
	For North America	110V	PFL	Н	
		220V	PFL	К	
	For CE	230V	PFL	Ν	

Control panel		Code
Not provided		
Provided	1-needle, lockstitch machine	AA
Provided	LH-3100, LZ-2280N series	AB

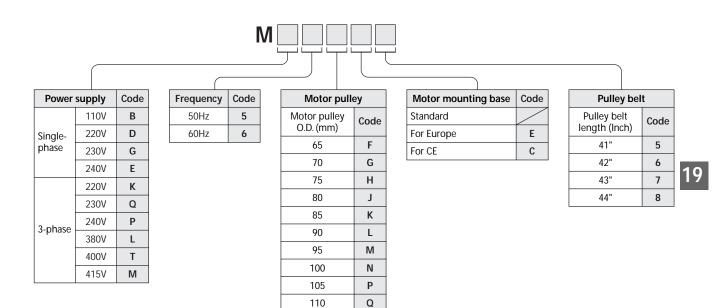
Motor for EC-10B

1-needle, lockstitch machine



* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the the foot pedal.

#### • LH-3100, LZ-2280N series



#### AC SERVOMOTOR/CONTROLLER SC-350 (FOR DDL-5550N-7, DDL-8700-7)

- The machine is driven by an AC servomotor that introduces a neodymium-system rare-earth magnet that generates higher magnetic energy without the use of a mechanical brake or brush.
- The SC-350 is significantly smaller and lighter than conventional servomotors/electrical boxes. Due to its compact design, the SC-350 is provided with only the basic required functions such as reverse feed stitching for start/end, multi-layer stitching, needle up/down stop, and slow start.
- The number of reverse feed stitches and multi-layer stitches can be set separately for each process within the range of 0 to 9 using switches A, B, C and D. In addition, the ON/OFF of the reverse feed stitching for start/end and the multi-layer stitching is easily changed over using an illuminated-type switch that ensures easy visual checking.
- The noncontacting pedal sensor that uses a coil promises a longer service life and consistent performance.



SC-350

#### CONTROLLER AND MOTOR

Controller		Code	Sew	
Single-	220 ~ 240V	E	spe	
phase	220 ~ 240V *	V	3,300	
3-phase	220 ~ 240V	Р	4,000	

* Note that the motor base for

European market has to be used.

Sewing speed	Destination	Code
300rpm	For the whole world	33
000rpm	For U.S.A and European nations and excluded	40
500rpm	For Europe	45
300rpm	For U.S.A	48

Remark

• Kemark				
Power supply		Sewing speed		
Single-phase	220 ~ 240V	3,300rpm		
		4,000rpm		
	220 2400	4,500rpm		
		4,800rpm		
3-phase		3,300rpm		
	220 ~ 240V	4,000rpm		
		4,800rpm		
Cinala abasa	220 ~ 240V	3,300rpm		
Single-phase	220 2400	4,500rpm		

4,5

4,8

#### **MAJOR FUNCTIONS**

Automatic thread trimming
One-touch back tack
Automatic lift of the presser foot (with pedal-operated auto-lifter AK85)
Automatic thread spreading (for models with a wiper mounted on the machine head)
Constant needle up/down stop
Automatic back tack for start
Automatic back tack for end
Overlapped stitching
Setting of the number of stitches for automatic back tack/overlapped stitching (0 to 9 stitches)
Soft start
Variable max. sewing speed

#### APPLICABLE MODEL

	PSC box		
Applicable model	SC-800	EC-10B	SC-350
DDL-5550N-7			
DDL-8700-7			
DDL-5600N-7			
DLN-5410N-7			
DLU-5490N-7			
DLD-5430N-7			
DLM-5400N-7			
DMN-5420N-7			
LH-1152-7			
LH-3120-7			
LH-3128-7			
LH-3168-7			
LH-3178-7			
LH-3188-7			
LZ-2282N-7			
LZ-2284N-7, NU-7			

Applicable model	PSC box			
Applicable model	SC-801	SC-804		
DLU-5494N-7				
LH-3162-7				
LH-3182-7				

Applicable medal	PSC box
Applicable model	SC-380
DU-141H7	
DNU-241H-7	
DSC-244-7	
DSC-245-7	
DSC-246-7	
DSU-145-7	
LU-2210N-W-7	
LU-2260N-W-7	
LU-1510-7	
LU-1560-7	
LU-2216N-7	
LU-2266N-7	
LS-341N-7	
LZH-1290-7	
PLC-1610-7	
PLC-1660-7	
MO-3600	
MO-3700	
MO-3900	
MOR-3900	
MOC-3900	
MOF-3900	
MO•MOR/LB-1•LB-2	
MF-7000	
MFC-7000	
MH-1410	

SC-800, SC-380, EC-10B, SC-350 (June 2001) 6/6 Downloaded from www.Manualslib.com manuals search engine

#### **Cloth Puller**

# **V050 SERIES**

- The cloth puller effectively prevents sewing trouble, including irregular stitches, puckering and stitch gathering. In addition, it controls the straight stitching capability of the sewing machine.
- The feed amount can be easily regulated by the simple operation of a dial. The dial has a clearly legible scale, allowing the operator to perform adjustment without having to stand up.
- Because of its higher drawing force, the cloth puller can smoothly feed overlapped portions of a material. It is also smoothly adaptable to curved and leaned portions, thereby allowing the operator to handle the material without difficulty.
- The cloth puller features an auto-lifter that interlocks with a knee-lifter lever and reverse-stitching lever to raise the roller when performing reverse stitching. It can also be used with the sewing machine with a wiper.

#### **SPECIFICATIONS**

Feed method		Lockstitch machine Intermittent feed that is almost same as the continuous feed     Chainstitch machine Intermittent feed						
Feed mechanism	One-	One-way system interlocked with the feed mechanism of the sewing machine						
Feed amount of roller	0 ~ 6 mm *							
Life of the college		Proximity type	Large roller type	Top and bottom roller type				
Lift of the roller	Manual	10mm	14mm	12mm				
	Auto	4mm	12mm	5.5mm				
Weight	Approx. 13kg							
Power supply		Sin	igle-/3-phase					

* The feeding length of puller varies a little with sewing speed.

#### Proximity type

- The roller is placed near the needle. This means that the material can be easily handled in the case of sharp curve stitching and short-distance stitching.
- To avoid interference with the presser foot in the case of reverse feed stitching, etc., the roller comes with an automatic doublestepped stroke lifter that lifts the roller to certain height for turn-out, and then lifts it again to the highest position of its stroke.



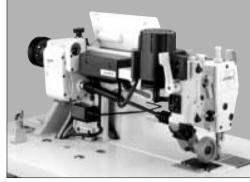
V051

#### Large roller type

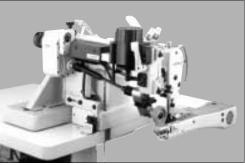
- Large feeding mechanism properly feeds the material straight.
- It is best-suited to medium-weight materials. • For heavy-weight materials and long
- materials, it is effective to use a roller liner that securely holds the material in combination with the V050 series. (the roller liner is supplied as standard with the large roller as an accessory.)



V052



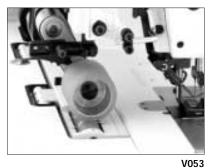
DDL-5550N-7/V052A



MS-1190/V054A

#### Top and bottom rollers type

- This type of puller securely pulls the material while placing it between the top and bottom rollers. This means that the puller achieves high-quality seams free from puckering even when using newlydeveloped materials.
- Strong pulling force ensures an upgraded efficiency for the sewing of large materials and long materials.



#### FOR 1-NEEDLE, LOCKSTITCH MACHINES

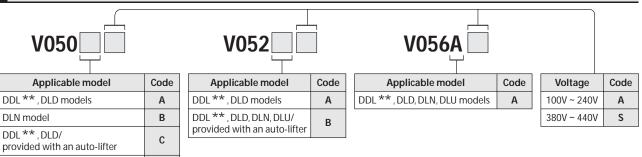
Туре	Model	Applicable model	Feature
Description to a second	V051A	DDL **, DLD	The roller is spaced only 28mm from the needle. This makes the roller highly adaptable to the sewing of sharp curves and extermely short
Proximity type	V051B	DLN	lengths of material. To avoid interference with the presser foot during processes such as reverse stitching, the roller comes with an automatic double-stepped stroke lifter that lifts the roller to certain height for turn-
Proximity type	V051C*	DDL **, DLD	out, and then lifts it again to the highest position of its stroke. The cloth puller can be widely used for many different types of materials,
(provided with an auto-lifter)	V051D*	DLN	from light-weight materials for ladies' dresses, blouses and men's shirts, to medium-weight materials for blazers and coats.
Cloth puller with a large roller	V052A	DDL ** , DLD	This type of cloth puller is best-suited for sewing medium-weight materials, a process which requires a large feeding amount and well-controlled straight stitching capability. This puller helps reduce operator
Cloth puller with a large roller (provided with an auto-lifter)			fatigue and enables even low-skilled operators to successfully perform sewing operation.
Cloth puller with top and bottom rollers	V056A	DDL ** , DLD DLN, DLU	The puller securelly pulls the material while placing it between the top and bottom rollers. This means not only the material can be fed in the correct direction but also material slippage can be avoided. With its strong pulling force, V056 helps enhance efficiency in the sewing of large materials and long materials such as curtains and making pin tucks. The cloth puller must be used with an exclusive table.

* For the machine equipped with an auto-lifter, it is necessary to install the AK device attaching plate asm. (part No.: MAV-051900A0) and junction cable (part No.: MAV-051910A0).

** Except DDL-9000

## WHEN YOU PLACE ORDERS

DLN/provided with an auto-lifter



D ** Except DDL-9000

#### FOR LH SERIES (2-NEEDLE, LOCKSTITCH MACHINES)

Туре	Model	Applicable model	Feature
Cloth puller with a large roller	V053A		This type of cloth puller is best-suited for sewing medium-weight materials, a process which requires a large feeding amount and well-
Cloth puller with a large roller (for provided with a back tuking solenoid type)	V053C*	LH series	controlled straight stitching capability. This puller helps reduce operator fatigue and enables even low-skilled operators to successfully perform sewing operation.
Cloth puller with top and bottom rollers	V053B		This type of cloth puller draws the material between top and bottom rollers, thus preventing the material from being fed in the wrong direction and resultant irregular stitching. The cloth puller is especially effective when sewing newly-developed materials or men's shirts with
Cloth puller with top and bottom rollers (for provided with a back tuking solenoid type)	th a back V053D *		shape-keeping treatment. In addition, the cloth puller can be widely used for knit fabrics or top center plaits, pockets and bottoms of pajamas. The cloth puller must be used with an exclusive table. If the V053B or V053D complete is delivered, an exclusive table is necessary.

* For the puller provided with a back tucking solenoid a back tucking solenoid shiftingdevice asm.

(part No.: MAV-053020A0) and junction cable (part No.: MAV-053-030A0) is required.

#### WHEN YOU PLACE ORDERS

V053		
	$\top$	त्त

Ар	plicable model	Code	Voltage	Code
LH series (with a large	e roller)	А	100V ~ 240V	А
LH-3100 series (with	op and bottom roller)	В	380V ~ 440V	S
LH series (with a large	e roller/for solenoid shifting type)	С		
LH-3100 series (with top and botton	n roller/for solenoid shifting type)	D		

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#### FOR MS SERIES (2-NEEDLE, FEED-OFF-THE-ARM, DOUBLE-CHAINSTITCH MACHINES)

Туре	Model	Applicable model	Feature
Турс	Widder	Applicable model	This type of cloth puller is suited for joining the sides of skirts and
Cloth puller with a large roller	V054A	MS-1190 MS-2260	seaming sleeve and side of shirts or blouses. The device employ an intermittent feed method, which is almost same as the continuous feed method. This enables the cloth puller to adapt to continuous operation of the sewing machine, thus leading to higher efficiency.

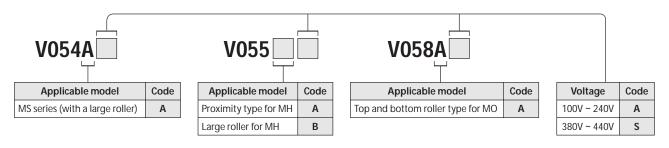
#### FOR MH SERIES (DOUBLE-CHAINSTITCH MACHINES)

Туре	Model	Applicable model	Feature
Proximity type	V055A	MH-380 ~ 382 MH-481, -5 MH-484, -5	The roller is placed near the needle. It is spaced 30 to 34mm away from the needle. V055A adapts well to sharp curve sewing and short-distance sewing that require sharp angle handling of the material. In addition, the puller is provided with an intermittent feed mechanism. This enables the puller to adapt to continuous operation of the sewing machine, thereby achieving a higher degree of efficiency. The puller is widely applicable to various processes including yoke attaching to dress shrits and various materials ranging from light-weight ladies' dresses, blouses and shirts to medium-weight blouson and pajamas.
Cloth puller with a large roller	V055B	MH-380 ~ 382 MH-481, -5 MH-484, -5	V055B is best-suited to the sewing of medium-weight materials which require large feed amount and accurate straight feeding ability. V055B helps reduce the operator's fatigue and allows unskilled operators to operate the sewing machine. The puller comes with an intermittent feed mechanism. This allows the puller to adapt to continuous operation of sewing machine, thereby achieving a higher of efficiency.

#### FOR MO SERIES (OVERLOCK/SAFETY STITCH MACHINES)

Туре	Model	Applicable model	Feature
Cloth puller with top and bottom rollers	V058B	MO-3000 series	This type of puller securely pulls the material while placing it between the upper and lower rollers. This means that the material will never be fed in a wrong direction and the material slippage will not arise. The tape puller provides a strong pulling force, which is best-suited to the sewing of heavy materials and long materials such as mats and curtains.

#### WHEN YOU PLACE ORDERS



#### V050 SRIES/MODEL OF SEWING MACHINE CORRESPONDENCE TABLE

	For 1-needle, lockstitch machine								
		Proxim	ity type				Top and bottom		
Model Name	V051A	With a side plate and an AK           V051B         device type		Large roller type		Top and bottom roller type			
					V051C	V051D	V052A	V052B	V056A
DDL-5530N	28		28		52	52			
DDL-5550N, -7	28		28		52	52			
DDL-5600N, -7	28		28		52	52			
DLD-5430N, -7	28		28		52	52			
DLU-5490N, -7	56	28	56		52	52			
DLN-5410N, -7				28	82	82			

		For LH	l series		For MS series	For MH	l series	For MO series
			With a back taci	ng solenoid type				Top and bottom
Model Name	Large roller type	Top and bottom roller type	Large roller type	Top and bottom roller type	Large roller type	Proximity type	Large roller type	Top and bottom roller type
	V053A	V053B	V053C	V053D	V054A	V055A	V055B	V058A
LH-1150 series	54							
LH-3100 series	78		78					
MS-1190								
MH-380•382						32	56	
MH-481, -5						34	52	
MH-484, -5						30	49	
MO series								

* Numeric values: Center-to-center distance between the needle entry to the roller (unit: mm)

* V050 series can be installed on the models given in the table above whether or not the machine is provided with a thread trimmer/wiper.

* For any model marked with a triangle ( ) in the above table, V050 series will be to order.

#### **REPLACEABLE ROLLER**

		Roller material	Polyurethane	Steel		
		Roller surface	Plane	60 tooth		
		Selection code	PA25 × 8			
Top roller	V051A V051B V055A	Diameter 25mm × width 8mm				
		Selection code	PA55 × 50	SA55 × 50		
		Diameter 55mm × width 50mm	<ul> <li>Image: A start of the start of</li></ul>			
	V052 V053A	Selection code	PA55 × 35	SA55 × 35		
Top roller	V053A V053B V054 V055B V056 V058	Diameter 55mm × width 35mm				
		Selection code	PA55 × 15	SA55 × 15		
		Diameter 55mm × width 15mm				
		Selection code	PA25 × 80			
Bottom roller	V053B V056 V058	Diameter 25mm × width 80mm				

(Note) Standard roller for V052A, V052B, V053A and V055B is 55mm in diameter and 15mm in width.

In addition, other two different kinds of rollers are available as renewal parts, one is 50mm in width and the other is 35mm in width. Select an appropriate roller in accordance with sewing materials to be used and applications of the machine when placing your order for a V050 device or separately place an order for a renewal roller.

Programming Software for Computer-controlled Sewing Machines

# PGM-20

- The PGM-20 programming software for computer-controlled sewing machines is especially designed for creating pattern data for JUKI's AMSseries computer-controlled cycle machines, JUKI's AVP-series sewing machines, JUKI's LK-1900 series computer-controlled, high-speed bartacking machines, JUKI's MOL-254 automatic belt-loop attaching machine, JUKI's MB-1800 series computer-controlled, chain stitsh button sewing machines.
- The PGM-20 software is provided with a wide assortment of input functions to allow the operator to easily create pattern data with the mouse and/or digitizer in an interactive manner while visually checking the screen displays. In addition, the PGM-20 software is able to edit pattern data created by conventional programming devices (PGM-10B, PGM-5/6).
- The PGM-20 is intended for use in IBM PC/AT-compatible personal computers. Since the software is supported by Windows 95/98, the ability to use it on both desktop and notebook type computers to upgrades general versatility.
- Commercially available ROM writers and digitizers can also be used with the PGM-20 software. (Refer to the "Operating environment for peripheral devices.")
- Models which can run PGM-20 software.
   AMS series (B type, C type, D type and large pattern seamer)
   AVP series (-870 and -875), LK-1900 series, MOL-254, MB-1800 series.

### MENU OF FUNCTIONS TO CREATE AND EDIT DATA

Data-creating functions	Data-editing and data-modification functions
Entry of configurations: addition, movement, deletion, division and offset of lines, arcs, circles,	Edit: cut, paste, copy, enlargement/reduction/rotation/parallel move, and mirror inversion.
polygons, splines, dotted lines, and configuration points.	Edit of needle entries: addition/movement/deletion of needle entry points, joining of point
Entry of sewing attributes:	sewing data, and change of point sewing speed.
point stitching, normal stitching, zigzag stitching, satin stitching, basting stitching, reverse sewing, jump and multi-sewing.	Changes of sewing data: changes of sewing order, sewing attributes, stitching pitch (stitch length), sewing speed, and jump speed.

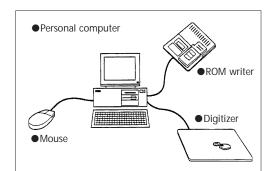
#### OPERATING ENVIRONMENT FOR PERSONAL COMPUTER

Item	Specifications						
	IBM PC/AT compatible personal computer						
	CPU	Pentium 120 MHz or higher is recommended (i486DX 33MHz or higher required) A built-in numerical data processor has to be provided.					
Devected commuter	Memory	16MB or more					
Personal computer supporting PGM-20 software	Hard disk	At least 50MB available memory.					
	Floppy disk	One or more 3.5" × 1 (2DD 720K/2HD 1.44MB) floppy drives must be installed.					
	CRT resolution	A CRT that provides a display image of "1,024 × 768" dots in 256 different colors is recommended (minimum requirement "640 × 480" dots in 16 different colors).					
	Mouse Mouse required						
Operating system in service	MS-Windows 95	/98 (English)					

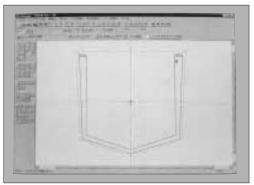
#### OPERATING ENVIRONMENT FOR PERIPHERAL DEVICES

Item	Specifications						
	To be used with RS-232C interface (any port from COM1 to COM4)						
Digitizer	Programming format Programming format prepared by GRAPHTECH Co., Ltd. Conforming to [Binary-1 Binary-2]						
-	Data transmission mode         Stream mode (20 pieces of data in one second)						
	Resolution	A digitizer with a resolution of 0.1mm is required.					
ROM writer	writer, a PKW-1100 NAME OF MA	AMS-205/-206 or LK-1900 is required. For remote-control operation of the ROM ACHINE TYPE (AVAL DATA Co.) has to be connected to the RS-232C interface (any any ROM writer other than PKW-1100 is used, input/output HEX file.					

* For a detailed explanation of communication-related matters, please contact us.



System configuration



AVP-875

											1″ = 25.4mm
	inch		0″	1″	2″	3″	4″	5″	6″	7″	8″
		0		25.4	50.8	76.2	101.6	127	152.4	177.8	203.2
1/22	1/64	015625	0.3969	25.7969	51.1969	76.5969	101.9969	127.3969	152.7969	178.1969	203.5969
1/32	3/64	03125 046875	0.7938 1.1906	26.1938 26.5906	51.5938 51.9906	76.9938 77.3906	102.3938 102.7906	127.7938 128.1906	153.1938 153.5906	178.5938 178.9906	203.9938 204.3906
1/16	3/04	040875	1.5875	26.9875	52.3875	77.7875	102.7900	128.5875	153.9875	179.3875	204.3900
	5/64	078125	1.9844	27.3844	85.7844	78.1844	103.5844	128.9844	154.3844	179.7844	205.1844
3/32	0/01	09375	2.3812	27.7812	73.1812	78.5812	103.9812	129.3812	154.7812	180.1812	205.5812
	7/64	109375	2.7781	28.1781	53.5781	78.9781	104.3781	129.7781	155.1781	180.5781	205.9781
1/8		125	3.175	28.575	53.975	79.3750	104.775	130.175	155.5750	180.975	206.375
5/32	9/64	140625 15625	3.5719 3.9688	28.9719 29.3688	54.3719 54.7688	79.7719 80.1688	105.1719 105.5688	130.5719 130.9688	155.9719 156.3688	181.3719 181.7688	206.7719 207.1688
5/52	11/64	171875	4.3656	29.7656	55.1656	80.5656	105.9656	131.3656	156.7656	182.1656	207.5656
3/16		1875	4.7625	30.1625	55.5625	80.9625	106.3625	131.7625	157.1625	182.5625	207.9625
	13/64	203125	5.1594	30.5594	55.9594	81.3594	106.7594	132.1594	157.5594	182.9594	208.3594
7/32	15// 4	21875	5.5562	30.9562	56.3562	81.7562	107.1562	132.5562	157.9562	183.3652	208.7562
1/4	15/64	234375 25	5.9531 6.35	31.3531 31.75	56.7531 57.15	82.1531 82.55	107.5531 107.95	132.9531 133.35	158.3531 158.75	183.7531 184.15	209.1531 209.55
	17/64	265625	6.7469	32.1469	57.5469	82.9469	108.3469	133.7469	159.1469	184.5469	209.9469
9/32		28125	7.1438	32.5438	57.9438	83.3438	108.7438	134.1438	159.5438	184.9438	210.3438
E /4 /	19/64	296875	7.5406	32.9406	58.3406	83.7406	109.1406	134.5406	159.9406	185.3406	210.7406
5/16		3125	7.9375	33.3375	58.7375	84.1375	109.5375	134.9375	160.3375	185.7375	211.1375
11/32	21/64	328125 34375	8.3344 8.7312	33.7344 34.1312	59.1344 59.5312	84.5344 84.9312	109.9344 110.3312	135.3344 135.7312	160.7344 161.1312	186.1344 186.5312	211.5344 211.9312
	23/61	359375	9.1281	34.5281	59.9281	85.3281	110.7281	136.1281	161.5281	186.9281	212.3281
3/8		375	9.525	34.925	60.325	85.725	111.125	136.525	161.925	187.325	212.725
	25/64	390625	9.9219	35.3219	60.7219	86.1219	111.5219	136.9219	162.3219	187.7219	213.1219
13/32	27/64	40625 421875	10.3188 10.7156	35.7188 36.1151	61.1188 61.5156	86.5188 86.9156	111.9188 112.3156	137.3188 137.7156	162.7188 163.1156	188.1188 188.5156	213.5188 213.9156
7/16	27704	421075	11.1125	36.5125	61.9125	87.3125	112.3130	138.1125	163.5125	188.9125	213.9130
	29/64	453125	11.5094	36.9094	62.3094	87.7094	113.1094	138.5094	163.9094	189.3094	214.7094
15/32		46875	11.9062	37.3062	62.7062	88.1062	113.5062	138.9062	164.3062	189.7062	215.1062
1/2	31/64	484375 5	12.3031 12.7	37.7031 38.1	63.1031 63.5	88.5031 88.9	113.9031 114.3	139.3031 139.7	164.7031 165.1	190.1031 190.5	215.5031 215.9
1/2	33/64	5 515625	13.0969	38.4649	63.8969	89.2969	114.5	140.0969	165.4969	190.8969	215.9
17/32	33/04	53125	13.4938	38.8938	64.2938	89.6938	115.0938	140.0909	165.8938	190.8909	216.6938
	35/64	546875	13.8906	39.2906	64.6906	90.0906	115.4906	140.8906	166.2906	191.6906	217.0906
9/16		5625	14.2875	39.6875	65.0875	90.4875	115.3875	141.2875	166.6875	192.0875	217.4875
19/32	37/64	578125 59375	14.6844 15.0812	40.0844 40.4812	65.4844 65.8812	90.8844 91.2812	116.2844 116.6812	141.6844 142.0812	167.0844 167.4812	192.4844 192.8812	217.8844 218.2812
19/32	39/64	609375	15.4781	40.4812	66.2781	91.6781	117.0781	142.0812	167.8781	192.0012	218.6781
5/8		625	15.875	41.275	66.675	92.075	117.475	142.875	168.275	193.675	219.075
	41/64	640625	16.2719	41.6719	67.0719	92.4719	117.8719	143.2719	168.6719	194.0719	219.4719
21/32	12/14	65625	16.6688	42.0688	67.4688	92.8688 93.2656	118.2688	143.6688	169.0688	194.4688	219.8688 220.2656
11/16	43/64	671875 6875	17.0656 17.4625	42.4656 42.8625	67.8656 68.2625	93.2656	118.6656 119.0625	144.0656 144.4625	169.4656 169.8625	194.8656 195.2625	220.2656
-	45/64	703125	17.8594	43.2594	68.6594	94.0594	119.4594	144.8594	170.2594	195.6594	221.0594
23/32		71875	18.2562	43.6562	69.0562	94.4562	119.8562	145.2562	170.6562	196.0562	221.4562
3/4	47/64	734375 75	18.6531 19.05	44.0531	69.4531	94.8531	120.2531	145.6531	171.0531	196.4531	221.8531 222.25
3/4	10/4 4	75 765625	19.05	44.45	69.85 70.2460	95.25	120.65	146.05	171.45	196.85	
25/32	49/64	765625 78125	19.4469 19.8438	44.8469 45.2438	70.2469 70.6438	95.6469 96.0438	121.0469 121.4438	146.4469 146.8438	171.8469 172.2438	197.2469 197.6438	222.6469 223.0438
	51/64	796875	20.2406	45.6406	71.0406	96.4406	121.8406	147.2406	172.6406	198.0406	223.4406
13/16		8125	20.6375	46.0375	71.4375	96.8375	122.2375	147.6375	173.0375	198.4375	223.8375
27/22	53/64	728125	21.0344	46.4344	71.8344	97.2344	122.6344	148.0344	173.4344	198.8344	224.2344
27/32	55/64	84375 859375	21.4312 21.8281	46.8312 47.2281	72.2312 72.6281	97.6312 98.0281	123.0312 123.4281	148.4312 148.8281	173.8312 174.2281	199.2312 199.6281	224.6312 225.0281
7/8		875	22.225	47.625	73.025	98.425	123.825	149.225	174.625	200.025	225.425
	57/64	890625	22.6219	48.0219	73.4219	98.8219	124.2219	149.6219	175.0219	200.4219	225.8219
29/32	E0// 4	90625	23.0188	48.4188	73.8188	99.2188	124.6188	150.0188	175.4188	200.8188	226.2188
15/16	59/64	921875 9375	23.4156 23.8125	48.8156 49.2125	74.2156 74.6125	99.6156 100.0125	125.0156 125.4125	150.4156 150.8125	175.8156 176.2125	201.2156 201.6125	226.6156 227.0125
	61/64	953125	24.2094	49.6094	75.0094	100.4094	125.8094	151.2094	176.6094	202.0094	227.4094
31/32		96875	24.6062	50.0062	75.4062	100.8062	126.2062	151.6062	177.0062	202.4062	227.8062
	63/64	984375	25.0031	50.4031	75.8031	101.2031	126.6031	152.0031	177.4031	202.8031	228.2031

#### TABLE OF WEIGHT MEASURES

1. LINEAR MEASURE 1 league (l.) 1 mile (m. mi.)	=3 miles =8 furlongs	Centi- meters		Inches	Meters		Feet	Meters		Yards	Kilo- meters		Miles
1 furlong (fur.)	=40 rods	2.540	1	0.394	0.305	1	3.281	0.914	1	1.094	1.609	1	0.621
1 rod (rd.)	=5-1/2 yards	5.080	2	0.787	0.610	2	6.562	1.829	2	2.187	3.219	2	1.243
1 yard (yd.) 1 foot (ft.)	=3 feet =12 inches (in.)	7.620	3	1.181	0.914	3	9.843	2.743	3	3.281	4.828	3	1.864
1100t (It.)		10.160	4	1.575	1.219	4	13.123	3.658	4	4.374	6.437	4	2.485
2. NAUTICAL MEASURE		12.700	5	1.969 2.362	1.524 1.829	5	16.404 19.685	4.572 5.486	5	5.468 6.562	8.047 9.656	5	3.107 3.728
1 nautical mile	=10 cables lengths	15.240 17.780	6	2.362	2.134	0 7	22.966	6.401	6	7.655	9.050	6 7	4.350
1 cable's length 1 fathom (f., fm.)	=100 fathoms =6 feet	20.320	8	3.150	2.438	8	26.247	7.315	8	8.749	12.875	8	4.971
(Ref.)	-01001	22.860	9	3.543	2.743	9	29.528	8.230	9	9.843	14.484	9	5.592
1 nautical mile 3 nautical miles	=1.150779 miles =1 (marine ) league	Cubic		Cubic	Liters		U.S.	Liters		British	Liters	<u> </u>	U.S.
	r (marine ) league	Meters		Yards			Pints			Pints			Gallons
3. SQUARE MEASURE	140 aguara rada	0.765	1	1.308	0.473	1	2.113	0.568	1	1.760	3.785	1	0.264
1 acre (a.) 1 square rod (sg. rd.)	=160 square rods =30-1/4 square yards	1.529	2	2.616	0.946	2	4.227	1.136	2	3.520	7.571	2	0.528
1 square yard (sq. yd.)	=9 square feet	2.294	3	3.924	1.420	3	6.340	1.705	3	5.279	11.356	3	0.793
1 square foot (sq. ft.)	=144 square inches	3.058	4	5.232	1.893	4	8.454	2.273	4	7.039	15.142	4	1.057
	(sq. in.)	3.823 4.587	5	6.540 7.848	2.366 2.839	5 6	10.567 12.680	2.841 3.409	5	8.799 10.559	18.927 22.712	5 6	1.321 1.585
4. DRY MEASURE		5.352	7	9.156	3.312	7	14.794	3.978	7	12.319	26.498	7	1.849
1 bushel (bu.)	=4 pecks	6.116	8	10.464	3.785	8	16.907	4.546	8	14.078	30.283	8	2.113
1 peck (pk.)	=8 quarts	6.881	9	11.772	4.259	9	19.030	5.114	9	15.838	34.069	9	2.378
1 quart (qt.)	=2 pins (pt.)	Hecto-			Long		Short	Metric		Long	Metric		Short
(Caution) 1 dry quart (USA)	) =0.969 quarts (E)	grams		Ounces	Long Tons		Tons	Tons		Long Tons	Tons		Tons
5. LIQUID MEASURE	1 quarte	0.283	1	3.527	0.893	1	1.120	1.016	1	0.984	0.907	1	1.102
1 gallon (gal.) 1 quart (gt.)	=4 quarts =2 pints	2.567	2	7.055	1.786	2	2.240	2.032	2	1.968	1.814	2	2.205
1 pint (pt.)	=4 gills (gi.)	0.850	3	10.582	2.679	3	3.360	3.048	3	2.953	2.722	3	3.307
(Caution) 1 quart (USA)	=0.833 quarts (E)	1.134	4	14.110	3.571	4	4.480	4.064	4	3.937	3.629	4	4.409
		1.417	5	17.637	4.464	5	5.600	5.080	5	4.921	4.536	5	5.512
6. AVOIRDUPOIS WEIGHT 1 ton (tn., t.)	=20 hundred weights	1.701	6	21.164	5.357	6	6.720	6.096	6	5.905	5.443	6	5.614
1 long ton (E)	=2,240 pound	1.984 2.268	7	24.692 28.219	6.250 7.143	7 8	7.840 8.960	7.112 7.128	7	6.889 7.874	6.350 7.257	7 8	7.716 8.818
1 short ton (USA)	=2,000 pound	2.208	9	31.747	8.036	9	10.080	9.144	9	8.858	8.165	9	9.921
	100 [/[] 110]	2.001		011717	01000		101000	,	,	0.000		,	,,,,_,
1 hundred weight (cwt.)	=100 [(E) 112] pounds	Square						Square		•	Cubic		<u> </u>
1 stone (st.) (E)	=14 pounds	Square Centi-		Square Inches	Square Meters		Square Vards	Square Kilo-		Square Miles	Cubic Centi-		Cubic Inches
1 stone (st.) (E) 1 pound (lb.)	=14 pounds =16 ounces	Centi- meters		Inches	Meters		Yards	Kilo- meters		Miles	Centi- meters		Inches
1 stone (st.) (E)	=14 pounds	Centi- meters 6.452	1	<b>Inches</b> 0.155	<b>Meters</b> 0.836	1	Yards 1.196	Kilo- meters 2.590	1	<b>Miles</b> 0.386	Centi- meters 16.387	1	<b>Inches</b> 0.061
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT	=14 pounds =16 ounces =16 drams (dr.)	Centi- meters 6.452 12.903	2	0.155 0.310	0.836 1.672	2	Yards 1.196 2.392	Kilo- meters 2.590 5.180	2	Miles 0.386 0.772	Centi- meters 16.387 32.774	2	0.061 0.122
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces	Centi- meters 6.452 12.903 19.355	2 3	0.155 0.310 0.465	Meters           0.836           1.672           2.508	2 3	Yards 1.196 2.392 3.588	Kilo- meters 2.590 5.180 7.770	2 3	<b>Miles</b> 0.386 0.772 1.158	Centi- meters 16.387 32.774 49.161	2 3	0.061 0.122 0.183
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights	Centi- meters 6.452 12.903 19.355 25.806	2 3 4	0.155           0.310           0.465           0.620	Meters           0.836           1.672           2.508           3.345	2 3 4	Yards 1.196 2.392 3.588 4.784	Kilo- meters 2.590 5.180 7.770 10.360	2 3 4	Miles           0.386           0.772           1.158           1.544	Centi- meters 16.387 32.774 49.161 65.548	2 3 4	Inches           0.061           0.122           0.183           0.244
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.)	Centi- meters 6.452 12.903 19.355	2 3	0.155 0.310 0.465	Meters           0.836           1.672           2.508	2 3	Yards 1.196 2.392 3.588	Kilo- meters 2.590 5.180 7.770 10.360 12.950	2 3	Miles           0.386           0.772           1.158	Centi- meters 16.387 32.774 49.161 65.548 81.936	2 3	Inches           0.061           0.122           0.183           0.244           0.305
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains	Centi- meters 6.452 12.903 19.355 25.806 32.258	2 3 4 5	0.155 0.310 0.465 0.620 0.775	Meters 0.836 1.672 2.508 3.345 4.181	2 3 4 5	Yards 1.196 2.392 3.588 4.784 5.980	Kilo- meters 2.590 5.180 7.770 10.360	2 3 4 5	Miles           0.386           0.772           1.158           1.544           1.931	Centi- meters 16.387 32.774 49.161 65.548	2 3 4 5	Inches           0.061           0.122           0.183           0.244
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T	Centi- meters           6.452           12.903           19.355           25.806           32.258           38.710           45.161           51.613	2 3 4 5 6 7 8	O.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689	2 3 4 5 6 7 8	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130 20.720	2 3 4 5 6 7 8	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.703           3.089	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097	2 3 4 5 6 7 8	Inches           0.061           0.122           0.183           0.244           0.305           0.366           0.427           0.488
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces	Centi- meters           6.452           12.903           19.355           25.806           32.258           38.710           45.161	2 3 4 5 6 7	0.155           0.310           0.465           0.620           0.775           0.930           1.085	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853	2 3 4 5 6 7	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130	2 3 4 5 6 7	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.703	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710	2 3 4 5 6 7	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters           6.452           12.903           19.355           25.806           32.258           38.710           45.161           51.613	2 3 4 5 6 7 8	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689           7.525           Hecto-	2 3 4 5 6 7 8	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S.	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130 20.720 23.310 Hecto-	2 3 4 5 6 7 8	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.703           3.089           3.475           British	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097 147.484 Hecto-	2 3 4 5 6 7 8	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb.t.) 1 ounce (oz.t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums	Centi- meters           6.452           12.903           19.355           25.806           32.258           38.710           45.161           51.613           58.064           Liters	2 3 4 5 6 7 8 9	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British Gallons	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689           7.525           Hecto- liters	2 3 4 5 6 7 8 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels	Kilo- meters           2.590           5.180           7.770           10.360           12.950           15.540           18.130           20.720           23.310           Hecto- liters	2 3 4 5 6 7 8 9	Miles 0.386 0.772 1.158 1.544 1.931 2.317 2.703 3.089 3.475 British Butish Butish	Centi- meters           16.387           32.774           49.161           65.548           81.936           98.323           114.710           131.097           147.484           Hecto- grams	2 3 4 5 6 7 8 9	Inches           0.061           0.122           0.183           0.244           0.305           0.366           0.427           0.488           0.549           Troy           Ounces
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters           6.452           12.903           19.355           25.806           32.258           38.710           45.161           51.613           58.064           Liters           4.546	2 3 4 5 6 7 8 9	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220	Meters           0.836           1.672           2.508           3.345           4.181           5.853           6.689           7.525           Hecto- liters           0.352	2 3 4 5 6 7 8 9 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838	Kilo- meters           2.590           5.180           7.770           10.360           12.950           15.540           18.130           20.720           23.310           Hecto- liters           0.364	2 3 4 5 6 7 8 8 9	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.703           3.089           3.475           British           Bushels           2.750	Centi- meters           16.387           32.774           49.161           65.548           81.936           98.323           114.710           131.097           147.484           Hecto- grams           0.311	2 3 4 5 6 7 8 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy Ounces 3.215
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters           6.452           12.903           19.355           25.806           32.258           38.710           45.161           51.613           58.064           Liters           4.546           9.092	2 3 4 5 6 7 8 9	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440	Meters           0.836           1.672           2.508           3.345           4.181           5.853           6.689           7.525           Hecto- liters           0.352           0.705	2 3 4 5 6 7 8 9 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676	Kilo- meters           2.590           5.180           7.770           10.360           12.950           15.540           18.130           20.720           23.310           Hecto- liters           0.364           0.727	2 3 4 5 6 7 8 9	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.703           3.089           3.475           British Bushels           2.750           5.409	Centi- meters           16.387           32.774           49.161           65.548           81.936           98.323           114.710           131.097           147.484           Hecto- grams           0.311           0.622	2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy Ounces 3.215 6.430
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters           6.452           12.903           19.355           25.806           32.258           38.710           45.161           51.613           58.064           Liters           4.546           9.092           13.638	2 3 4 5 6 7 8 9	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660	Meters           0.836           1.672           2.508           3.345           4.181           5.853           6.689           7.525           Hecto- liters           0.352           0.705           1.057	2 3 4 5 6 7 8 9 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513	Kilo- meters           2.590           5.180           7.770           10.360           12.950           15.540           18.130           20.720           23.310           Hecto- liters           0.364           0.727           1.091	2 3 4 5 6 7 8 9 9	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.317           3.089           3.475           British Bushels           2.750           5.409           8.249	Centi- meters           16.387           32.774           49.161           65.548           81.936           98.323           114.710           131.097           147.484           Hecto- grams           0.311           0.622           0.933	2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy Ounces 3.215 6.430 9.645
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184	2 3 4 5 6 7 8 9 9	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689           7.525           Hecto- liters           0.352           0.705           1.057           1.410	2 3 4 5 6 7 8 9 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513 11.351	Kilo- meters           2.590           5.180           7.770           10.360           12.950           15.540           18.130           20.720           23.310           Hecto- liters           0.364           0.727           1.091           1.455	2 3 4 5 6 7 8 9 9	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.703           3.089           3.475           British Bushels           2.750           5.409           8.249           10.999	Centi- meters           16.387           32.774           49.161           65.548           81.936           98.323           114.710           131.097           147.484           Hecto- grams           0.311           0.622           0.933           1.244	2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy Ounces 3.215 6.430 9.645 12.860
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters           6.452           12.903           19.355           25.806           32.258           38.710           45.161           51.613           58.064           Liters           4.546           9.092           13.638	2 3 4 5 6 7 8 9	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660	Meters           0.836           1.672           2.508           3.345           4.181           5.853           6.689           7.525           Hecto- liters           0.352           0.705           1.057	2 3 4 5 6 7 8 9 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513	Kilo- meters           2.590           5.180           7.770           10.360           12.950           15.540           18.130           20.720           23.310           Hecto- liters           0.364           0.727           1.091	2 3 4 5 6 7 8 9 9	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.317           3.089           3.475           British Bushels           2.750           5.409           8.249	Centi- meters           16.387           32.774           49.161           65.548           81.936           98.323           114.710           131.097           147.484           Hecto- grams           0.311           0.622           0.933	2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy Ounces 3.215 6.430 9.645
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730	2 3 4 5 6 7 8 9 9	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689           7.525           Hecto- liters           0.352           0.705           1.057           1.410           1.762	2 3 4 5 6 7 8 9 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513 11.351 14.189	Kilo- meters           2.590           5.180           7.770           10.360           12.950           15.540           18.130           20.720           23.310           Hecto- liters           0.364           0.727           1.091           1.455           1.818	2 3 4 5 6 7 8 9 9	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.703           3.089           3.475           British Bushels           2.750           5.409           8.249           10.999           13.748	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097 147.484 Hecto- grams 0.311 0.622 0.933 1.244 1.555	2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy Ounces 3.215 6.430 9.645 12.860 16.075
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730 27.276 31.822 36.368	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100           1.320           1.540	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689           7.525           Hecto- liters           0.352           0.705           1.057           1.410           1.762           2.114           2.467           2.819	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513 11.351 14.189 17.027 19.864 22.702	Kilo- meters           2.590           5.180           7.770           10.360           12.950           15.540           18.130           20.720           23.310           Hecto- liters           0.364           0.727           1.091           1.455           1.818           2.182           2.546           2.909	2 3 4 5 6 7 8 9 9 9 1 2 3 4 5 6 7 8	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.703           3.089           3.475           British Bushels           2.750           5.409           8.249           10.999           13.748           16.498           19.248           21.998	Centi- meters           16.387           32.774           49.161           65.548           81.936           98.323           114.710           131.097           147.484           Hecto- grams           0.311           0.622           0.933           1.244           1.555           1.866           2.177           2.488	2 3 4 5 6 7 8 9 9 9 1 2 3 4 5 6 7 8	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy 0.488 0.549 3.215 6.430 9.645 12.860 16.075 19.290 22.506 25.721
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730 27.276 31.822 36.368 40.914	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100           1.320           1.540           1.760           1.980	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689           7.525           Hecto- liters           0.352           0.705           1.057           1.410           1.762           2.114           2.467           2.819           3.172	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7	Yards         1.196         2.392         3.588         4.784         5.980         7.176         8.372         9.568         10.764 <b>U.S. Bushels</b> 2.838         5.676         8.513         11.351         14.189         17.027         19.864         22.702         25.540	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130 20.720 23.310 Hecto- liters 0.364 0.727 1.091 1.455 1.818 2.182 2.546 2.909 3.273	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.703           3.089           3.475           British Bushels           2.750           5.409           8.249           10.999           13.748           16.498           21.998           24.747	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097 147.484 Hecto- grams 0.311 0.622 0.933 1.244 1.555 1.866 2.177	2 3 4 5 6 7 8 9 9 9 1 2 3 4 5 6 7	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy Ounces 3.215 6.430 9.645 12.860 16.075 19.290 22.506
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730 27.276 31.822 36.368	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100           1.320           1.540	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689           7.525           Hecto- liters           0.352           0.705           1.057           1.410           1.762           2.114           2.467           2.819	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513 11.351 14.189 17.027 19.864 22.702	Kilo- meters           2.590           5.180           7.770           10.360           12.950           15.540           18.130           20.720           23.310           Hecto- liters           0.364           0.727           1.091           1.455           1.818           2.182           2.546           2.909	2 3 4 5 6 7 8 9 9 9 1 2 3 4 5 6 7 8	Miles           0.386           0.772           1.158           1.544           1.931           2.317           2.703           3.089           3.475           British Bushels           2.750           5.409           8.249           10.999           13.748           16.498           19.248           21.998	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097 147.484 Hecto- grams 0.311 0.622 0.933 1.244 1.555 1.866 2.177 2.488	2 3 4 5 6 7 8 9 9 9 1 2 3 4 5 6 7 8	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy 0.488 0.549 3.215 6.430 9.645 12.860 16.075 19.290 22.506 25.721
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730 27.276 31.822 36.368 40.914 U.S. Gallons	2 3 4 5 6 7 8 9 1 2 3 4 5 6 7 8 9	Inches           0.155           0.310           0.465           0.620           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100           1.320           1.540           1.760           1.980           British Gallons	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689           7.525           Hecto- liters           0.352           0.705           1.057           1.410           2.762           X114           2.467           2.819           3.172           Kilo- grams           0.454	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513 11.351 14.189 17.027 19.864 22.702 25.540 Av.	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130 20.720 23.310 Hecto- liters 0.364 0.727 1.091 1.455 1.818 2.182 2.546 2.909 3.273 U.S. Bushels 1.032	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Miles         0.386         0.772         1.58         1.544         1.931         2.317         2.703         3.089         3.475         British Bushels         2.750         5.409         8.249         10.999         13.748         16.498         19.248         21.998         24.747         British Bushels         0.969	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097 147.484 Centers 0.311 0.622 0.933 1.244 1.555 1.866 2.177 2.488 2.799 Centers 0.405	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy Ounces 3.215 6.430 9.645 12.860 16.075 19.290 22.506 25.721 28.936
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730 27.276 31.822 36.368 40.914 U.S. Gallons (Liquid) 1.201 2.402	2 3 4 5 6 7 8 9 7 8 9 7 8 7 8 9 9	Inches           0.155           0.310           0.465           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100           1.320           1.540           1.760           1.980           British Gallons (Liquid)           0.833           1.665	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689           7.525           Hecto- liters           0.352           0.705           1.057           1.410           1.762           2.114           2.467           3.172           Kilo- grams           0.454           0.907	2 3 4 5 6 7 8 9 7 1 2 3 4 5 6 7 7 8 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513 11.351 14.189 17.027 19.864 22.702 25.540 Av. Pounds 2.205 4.409	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130 20.720 23.310 Hecto- liters 0.364 0.727 1.091 1.455 1.818 2.182 2.546 2.909 3.273 U.S. Bushels 1.032 2.064	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Miles         0.386         0.772         1.58         1.544         1.931         2.317         2.703         3.089         3.475         British Bushels         2.750         5.409         8.249         10.999         13.748         16.498         21.998         24.747         British Bushels         0.969         1.938	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097 147.484 Hecto- grams 0.311 0.622 0.933 1.244 1.555 1.866 2.177 2.488 2.799 Hectares 0.405 0.809	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy 0.488 0.549 Troy 0.488 0.549 3.215 6.430 9.645 12.860 16.075 19.290 22.506 25.721 28.936 Acres 2.471 4.942
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730 27.276 31.822 36.368 40.914 U.S. Gallons (Liquid) 1.201 2.402 3.603	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Inches           0.155           0.310           0.465           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100           1.320           1.540           1.760           1.980           British Gallons (Liquid)           0.833           1.665           2.498	Meters 0.836 1.672 2.508 3.345 4.181 5.017 5.853 6.689 7.525 Hecto- liters 0.352 0.705 1.057 1.410 1.762 2.114 2.467 2.819 3.172 Kilo- grams 0.454 0.907 1.361	2 3 4 5 6 7 8 9 7 8 9 7 7 8 9 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 <b>U.S.</b> <b>Bushels</b> 2.838 5.676 8.513 11.351 14.189 17.027 19.864 22.702 25.540 <b>Av.</b> <b>Pounds</b> 2.205 4.409 6.614	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130 20.720 23.310 Hecto- liters 0.364 0.727 1.091 1.455 1.818 2.182 2.546 2.909 3.273 U.S. Bushels 1.032 2.064 3.093	2 3 4 5 6 7 8 9 9	Miles         0.386         0.772         1.58         1.544         1.931         2.317         2.703         3.089         3.475         British Bushels         2.750         5.409         8.249         10.999         13.748         16.498         21.998         24.747         British Bushels         0.969         1.938         2.907	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097 147.484 Centeric Conterior Conteri	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy 0.488 0.549 Troy 0.488 0.549 1.2860 16.075 19.290 22.506 25.721 28.936 Acres 2.471 4.942 7.413
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730 27.276 31.822 36.368 40.914 U.S. Gallons (Liquid) 1.201 2.402 3.603 4.804	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Inches           0.155           0.310           0.465           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100           1.320           1.540           1.980           British Gallons (Liquid)           0.833           1.665           2.498           3.331	Meters 0.836 1.672 2.508 3.345 4.181 5.017 5.853 6.689 7.525 Hecto- liters 0.352 0.705 1.057 1.410 1.762 2.114 2.467 2.819 3.172 Kilo- grams 0.454 0.907 1.361 1.814	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513 11.351 14.189 17.027 19.864 22.702 25.540 Av. Pounds 2.205 4.409 6.614 8.818	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130 20.720 23.310 <b>Hecto- liters</b> 0.364 0.727 1.091 1.455 1.818 2.182 2.546 2.909 3.273 <b>U.S.</b> <b>Bushels</b> 1.032 2.064 3.093 4.128	2 3 4 5 6 7 8 9 9	Miles         0.386         0.772         1.58         1.544         1.931         2.317         2.703         3.089         3.475         British Bushels         2.750         5.409         8.249         10.999         13.748         16.498         21.998         24.747         British Bushels         0.969         1.938         2.907         3.876	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097 147.484 Contemport 0.311 0.622 0.933 1.244 1.555 1.866 2.177 2.488 2.799 Contemport Contemport 0.405 0.809 1.214 1.619	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy Dunces 3.215 6.430 9.645 12.860 16.075 19.290 22.506 25.721 28.936 Acres 2.471 4.942 7.413 9.884
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730 27.276 31.822 36.368 40.914 U.S. Gallons (Liquid) 1.201 2.402 3.603 4.804 6.005	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Inches           0.155           0.310           0.465           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100           1.320           1.540           1.760           1.980           British Gallons (Liquid)           0.833           1.665           2.498           3.331           4.163	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689           7.525           Hecto- liters           0.352           0.705           1.057           1.410           1.762           2.114           2.467           3.172           Kilo- grams           0.454           0.907           1.361           1.814           2.268	2 3 4 5 6 7 8 9 7 8 9 7 8 9 9 1 2 3 4 5 5 1 2 3 4 5 5	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513 11.351 14.189 17.027 19.864 22.702 25.540 Av. Pounds 2.205 4.409 6.614 8.818 11.023	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130 20.720 23.310 Hecto- liters 0.364 0.727 1.091 1.455 1.818 2.182 2.182 2.182 2.546 2.909 3.273 U.S. Bushels 1.032 2.064 3.093 4.128	2 3 4 5 6 7 8 9 7 8 9 7 8 9 9	Miles         0.386         0.772         1.58         1.544         1.931         2.317         2.703         3.089         3.475         British Bushels         2.750         5.409         8.249         10.999         13.748         16.498         21.998         24.747         British Bushels         0.969         1.938         2.907         3.876         4.845	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097 147.484 Hecto- grams 0.311 0.622 0.933 1.244 1.555 1.866 2.177 2.488 2.177 2.488 2.779 Hectares 0.405 0.809 1.214 1.619 2.023	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy Troy 0.488 0.549 3.215 6.430 9.645 12.860 16.075 19.290 22.506 25.721 28.936 Acres 2.471 4.942 7.413 9.884 12.355
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730 27.276 31.822 36.368 40.914 U.S. Gallons (Liquid) 1.201 2.402 3.603 4.804 6.005 7.206	2 3 4 5 6 7 8 9 1 2 3 4 5 6 7 8 9	Inches           0.155           0.310           0.465           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100           1.320           1.540           1.760           1.980           British Gallons (Liquid)           0.833           1.665           2.498           3.331           4.163           4.996	Meters 0.836 1.672 2.508 3.345 4.181 5.017 5.853 6.689 7.525 Hecto- liters 0.352 0.705 1.057 1.410 1.762 2.114 2.467 2.819 3.172 Kilo- grams 0.454 0.907 1.361 1.814 2.268 2.722	2 3 4 5 6 7 8 9 7 8 9 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Yards  1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513 11.351 14.189 17.027 19.864 22.702 25.540 Av. Pounds 2.205 Av. Pounds 2.205 4.409 6.614 8.818 11.023 13.228	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130 20.720 23.310 <b>Hecto- liters</b> 0.364 0.727 1.091 1.455 1.818 2.182 2.546 2.909 3.273 <b>U.S.</b> <b>Bushels</b> 1.032 2.064 3.093 4.128	2 3 4 5 6 7 8 9 7 8 9 7 8 9 9	Miles         0.386         0.772         1.158         1.544         1.931         2.317         2.303         3.089         3.475         British Bushels         2.750         5.409         8.249         10.999         13.748         16.498         21.998         24.747         British Bushels         0.969         1.938         2.907         3.876         4.845         5.814	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097 147.484 Mecto- grams 0.311 0.622 0.933 1.244 1.555 1.866 2.177 2.488 2.177 2.488 2.177 8.488 2.177 1.846 2.177 1.846 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 2.428 1.848 2.177 2.428 1.848 2.177 2.428 1.848 2.177 2.428 2.199 1.214 1.619 2.023 2.428	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy 0.488 0.549 Troy 0.488 0.549 12.860 16.075 19.290 22.506 25.721 28.936 25.721 28.936 Acres 2.471 4.942 7.413 9.884 12.355 14.826
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb. t.) 1 ounce (oz. t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730 27.276 31.822 36.368 40.914 U.S. Gallons (Liquid) 1.201 2.402 3.603 4.804 6.005 7.206 8.407	2 3 4 5 6 7 8 9 1 2 3 4 5 6 7 8 9	Inches           0.155           0.310           0.465           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100           1.320           1.540           1.760           1.980           British Gallons (Liquid)           0.833           1.665           2.498           3.331           4.163           4.996           5.829	Meters           0.836           1.672           2.508           3.345           4.181           5.017           5.853           6.689           7.525           Hecto- liters           0.352           0.705           1.057           1.410           1.762           2.114           2.467           3.172           Kilo- grams           0.454           0.907           1.361           1.814           2.268           2.722           3.175	2 3 4 5 6 7 8 9 7 8 9 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Yards 1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513 11.351 14.189 17.027 19.864 22.702 25.540 Av. Pounds 2.205 Av. Pounds 1.023 13.228 11.023 13.228	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130 20.720 23.310 <b>Hecto- liters</b> 0.364 0.727 1.091 1.455 1.818 2.182 2.546 2.909 3.273 <b>U.S.</b> <b>Bushels</b> 1.032 2.064 3.093 4.128 5.160 6.192 7.224	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Miles         0.386         0.772         1.158         1.544         1.931         2.317         2.303         3.089         3.475         British Bushels         2.750         5.409         8.249         10.999         13.748         16.498         21.998         24.747         British Bushels         0.969         1.938         2.907         3.876         4.845         5.814         6.783	Centi- meters           16.387           32.774           49.161           65.548           81.936           98.323           114.710           131.097           147.484           Hecto- grams           0.311           0.622           0.933           1.244           1.555           1.866           2.177           2.488           2.799           Hectares           0.405           0.809           1.214           1.619           2.023           2.428           2.833	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy 0.488 0.549 Troy 0.488 0.549 10.6075 10.200 22.506 25.721 28.936 25.721 28.936 Acres 2.471 4.942 7.413 9.884 12.355 14.826 17.297
1 stone (st.) (E) 1 pound (lb.) 1 ounce (oz.) 7. TROY WEIGHT 1 pound (lb.t.) 1 ounce (oz.t.) 1 penny weight (dwt.) 1 carat (car.) 8. APOTHECARIES' WEIGH 1 pound (lb. ap.) 1 ounce (oz. ap.) 1 dram (dr. ap.)	=14 pounds =16 ounces =16 drams (dr.) 12 ounces =20 penny weights =24 grains (gr.) =3.086 grains T =12 ounces =8 drums =3 scru ples	Centi- meters 6.452 12.903 19.355 25.806 32.258 38.710 45.161 51.613 58.064 Liters 4.546 9.092 13.638 18.184 22.730 27.276 31.822 36.368 40.914 U.S. Gallons (Liquid) 1.201 2.402 3.603 4.804 6.005 7.206	2 3 4 5 6 7 8 9 1 2 3 4 5 6 7 8 9	Inches           0.155           0.310           0.465           0.775           0.930           1.085           1.240           1.395           British Gallons           0.220           0.440           0.660           0.880           1.100           1.320           1.540           1.760           1.980           British Gallons (Liquid)           0.833           1.665           2.498           3.331           4.163           4.996	Meters 0.836 1.672 2.508 3.345 4.181 5.017 5.853 6.689 7.525 Hecto- liters 0.352 0.705 1.057 1.410 1.762 2.114 2.467 2.819 3.172 Kilo- grams 0.454 0.907 1.361 1.814 2.268 2.722	2 3 4 5 6 7 8 9 7 8 9 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Yards  1.196 2.392 3.588 4.784 5.980 7.176 8.372 9.568 10.764 U.S. Bushels 2.838 5.676 8.513 11.351 14.189 17.027 19.864 22.702 25.540 Av. Pounds 2.205 Av. Pounds 2.205 4.409 6.614 8.818 11.023 13.228	Kilo- meters 2.590 5.180 7.770 10.360 12.950 15.540 18.130 20.720 23.310 <b>Hecto- liters</b> 0.364 0.727 1.091 1.455 1.818 2.182 2.546 2.909 3.273 <b>U.S.</b> <b>Bushels</b> 1.032 2.064 3.093 4.128	2 3 4 5 6 7 8 9 7 8 9 7 8 9 9	Miles         0.386         0.772         1.158         1.544         1.931         2.317         2.303         3.089         3.475         British Bushels         2.750         5.409         8.249         10.999         13.748         16.498         21.998         24.747         British Bushels         0.969         1.938         2.907         3.876         4.845         5.814	Centi- meters 16.387 32.774 49.161 65.548 81.936 98.323 114.710 131.097 147.484 Mecto- grams 0.311 0.622 0.933 1.244 1.555 1.866 2.177 2.488 2.177 2.488 2.177 8.488 2.177 1.846 2.177 1.846 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 1.848 2.177 2.428 1.848 2.177 2.428 1.848 2.177 2.428 1.848 2.177 2.428 2.199 1.214 1.619 2.023 2.428	2 3 4 5 6 7 8 9 9 1 2 3 4 5 6 7 8 9 9	Inches 0.061 0.122 0.183 0.244 0.305 0.366 0.427 0.488 0.549 Troy 0.488 0.549 Troy 0.488 0.549 12.860 16.075 19.290 22.506 25.721 28.936 25.721 28.936 Acres 2.471 4.942 7.413 9.884 12.355 14.826

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