

# **JUKI®**

## **INDUSTRIAL SEWING MACHINES**

# **HAND BOOK**



## **JUKI CORPORATION**

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# 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	4,000rpm	3,500rpm
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		
Needle (at the time of delivery)	DB x 1 (#14) For JE: 134 (Nm75)	DA x 1 (#9) For JE: 134 (Nm65)	DB x 1 (#21) For JE: 134 (Nm130)
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 materials
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	By hand: 4mm, By knee: 9mm	By hand: 5.5mm, By knee: 13mm
Needle (at the time of delivery)	DB x 1 (#14) For JE: 134 (Nm75)	DA x 1 (#9) For JE: 134 (Nm65)	DB x 1 (#21) For JE: 134 (Nm130)
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	4mm		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 x 1 (#14) For JE: 134 (Nm75)	DA x 1 (#9) For JE: 134 (Nm65)	DB x 1 (#21) For JE: 134 (Nm130)
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	81kg		

## WHEN YOU PLACE ORDERS

DDL-5530N  DDL-5550N  DDL-5550N  -7-

Application	Code
For medium-weight materials	/
For light-weight materials	A
For heavy-weight materials	H

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

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

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

SC800-    D-    A

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

Control box	Code
Standard	S
Optional unit A (for the ED-2 and the AE-4)	A

Control panel	Code
CP-60	060
CP-160	160
CP-360	360

Pulley belt	Code
Lockstitch for general fabric	D

\* 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-04000A0	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)

**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.



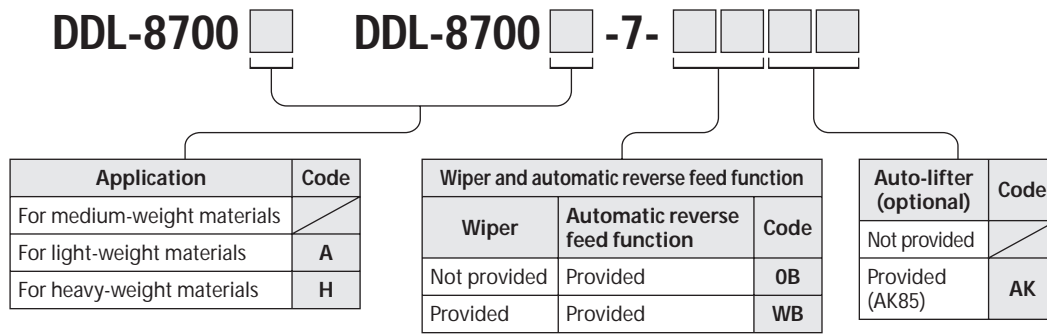
DDL-8700-7-WB/CP-160

**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	4,000rpm	
Max. stitch length	5mm	4mm	5mm
Needle bar stroke	30.7mm		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 x 1 (#14) #9 ~ #18 For JE: 134 (Nm90)	DA x 1 (#9) #9 ~ #11 For JE: 134 (Nm65)	DB x 1 (#21) #19 ~ #23 For JE: 134 (Nm130)
Feed dog	4-row		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		

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	4mm		5mm
Needle bar stroke	30.7mm		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 x 1 (#14) #9 ~ #18 For JE: 134 (Nm90)	DA x 1 (#9) #9 ~ #11 For JE: 134 (Nm65)	DB x 1 (#21) #19 ~ #23 For JE: 134 (Nm130)
Feed dog	4-row		3-row
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		
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		

## WHEN YOU PLACE ORDERS



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

**SC800-**    **D-**    **A**

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

Control box	Code
Standard	<b>S</b>
Optional unit A (for the ED-2 and the AE-4)	<b>A</b>

Control panel	Code
CP-60	<b>060</b>
CP-160	<b>160</b>
CP-360	<b>360</b>

Pulley belt	Code
Lockstitch for general fabric	<b>D</b>

\* 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.



DDL-9000DS-WB/CP-160D

## SPECIFICATIONS

Model name	DDL-9000DS	DDL-9000DF	DDL-9000SS	DDL-9000SH
	Dry head type		Minute-quantity lubrication type	
Application	For light- to medium-weight materials	For extra light-weight materials and foundation	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	5mm	
Needle bar stroke	30.7mm		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 x 1 (#14) #9 ~ #18 For JE: 134 (Nm75) Nm65 ~ Nm110	DB x 1 (#9) #8 ~ #11 For JE: 134 (Nm65) Nm60 ~ Nm75	DB x 1 (#14) #9 ~ #18 For JE: 134 (Nm75) Nm65 ~ Nm110	DB x 1 (#21) #20 ~ #23 For JE: 134 (Nm130) Nm120 ~ Nm160
Hook	Exclusive no-lubrication hook (plastic hook with special-purpose race surface)		Automatic lubrication hook	
Lubrication	No lubrication		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	300mm			
Size of bed	517mm x 178mm			
Bobbin thread winder	Built-in the machine head			
Micro-lifter screw	Provided as standard			
Machine head drive	Compact AC servomotor (direct-drive system)			
Automatic reverse feed function	Provided as standard (built-in solenoid type)			
Power requirement	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V			
Power consumption	Power rating 400VA			
Total weight	84.5kg			

## WHEN YOU PLACE ORDERS

DDL-9000   -

Machine head type	Code	Application	Code	Wiper and automatic reverse feed function			Device and attachment	Code
Dry head	D	For light- to medium-weight materials	S	Wiper	Automatic reverse feed function	Code	Not provided	
Minute-quantity lubrication	S	For heavy-weight materials	H*	Not provided	Provided	OB	Auto-lifter (pedal-driven)	AK118
		For extra light-weight materials and foundation	F*	Provided	Provided	WB		

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

● PSC box/control panel

SC900-   S-    D

PSC box			Code	Wiper	Code
For General Export	Single-phase	200 ~ 240V	07	Not provided	000
	3-phase	200 ~ 240V	11	CP-160	160
For CE	Single-phase	220 ~ 240V	34	CP-360	360
	3-phase	200 ~ 240V	38		
For JUS (LA)*	Single-phase	100 ~ 120V	37		
	3-phase	200 ~ 240V	38		

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

## OPTIONS

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

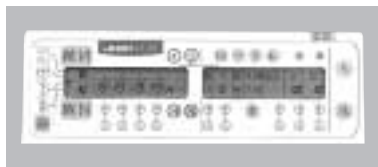
- The motor acceleration can be selected from three setting (standard, slow, rapid) by operator's preference.
- The function-setting switch is provided with two new capabilities: reverse feed and repeat. In addition, the switch has a reset capability to restore the machine to the default settings.



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)		○	○
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		○	○
14	Double back tack switch		○	○
15	Key lock		○	○
16	Constant-dimension stitching pattern		○	○
17	Programable seam length		○	○
18	Production counter			○
19	Programmed stitching pattern			○
20	Combined stitching pattern switch			○
21	Re-sewing switch			○
22	Teaching switch			○
23	Presser foot lifting time setting switch			○

△ ● Designated on the control box.

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

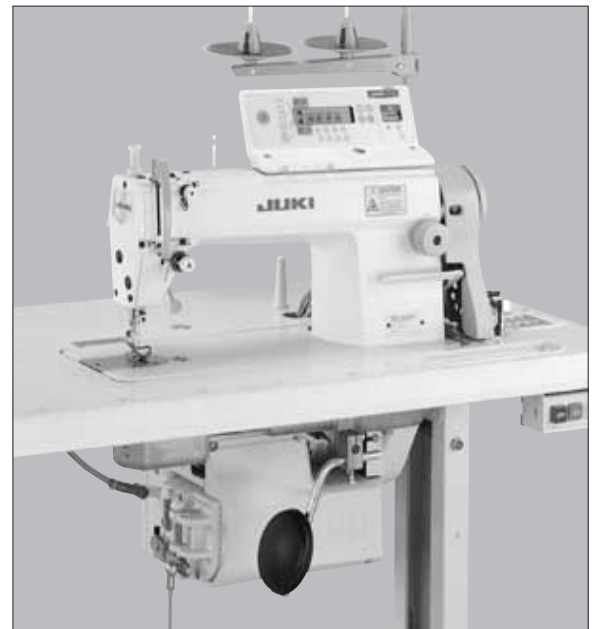
\*\* ● Operative when the machine is equipped with a material edge sensor (ED: optional).



## 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	3,000rpm	
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	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)		

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	3,000rpm	
Max. stitch length	5mm (normal/reverse feed)	8mm, 5mm (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	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	81kg		

## WHEN YOU PLACE ORDERS

DDL-5600N  -7-

Application	Code
For jeans	J
For heavy-weight materials	L
For leather shoes (with roller presser 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

SC800-    D-    A

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

Control box	Code
Standard	S
Optional unit A (for the ED-2 and the AE-4)	A

Control panel	Code
CP-60	060
CP-160	160
CP-360	360

Pulley belt	Code
Lockstitch for general fabric	D

\* 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-5 *	GAE-050000A0	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.

\* 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)

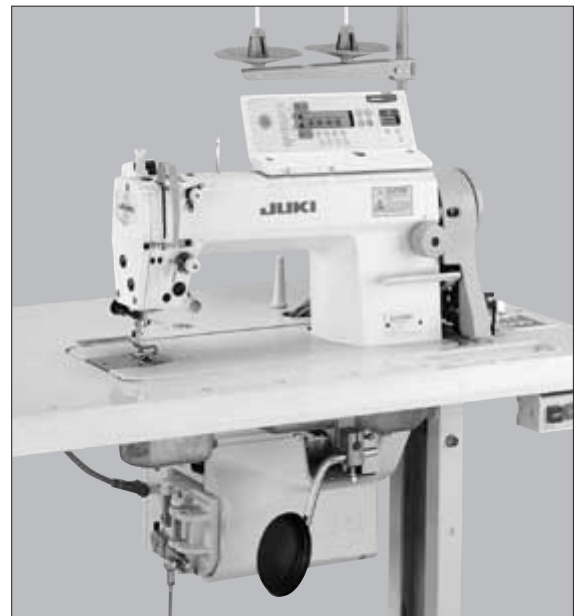
# DLN-5410N

## 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 ( $\pm 15\%$ ), 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 x 1 (#14) For JE: 134 (Nm90)	DB x 1 (#21) For JE: 134 (Nm130)	DB x 1 (#21) For JE: 134 (Nm130)
Hook	Automatic-lubricating full-rotary hook		
Lubrication	Automatic		
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)		

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	4,000rpm	
Max. stitch length	4mm	4.5mm	
Needle bar stroke	30.7mm		33mm
Lift of the presser foot	By hand: 5.5mm, By knee: 13mm		
Needle (at the time of delivery)	DB x 1 (#14) For JE: 134 (Nm90)	DB x 1 (#21) For JE: 134 (Nm130)	DB x 1 (#21) For JE: 134 (Nm130)
Hook	Automatic-lubricating full-rotary hook		Automatic-lubricating double-capacity full-rotary hook
Thread			#30 ~ #8, B46 ~ B92, Nm60/3 ~ 30/3
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	83kg		

## WHEN YOU PLACE ORDERS

DLN-5410N

DLN-5410N  -7-

Application	Code
For light- to medium-weight materials	/
For heavy-weight materials	H
For heavy-weight materials (long stitch length type)	L

Application	Code
For light- to medium-weight materials	/
For heavy-weight materials	H
For jeans	J

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

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

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

SC800-    D-    A

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

Control box	Code
Standard	S
Optional unit A (for the ED-2 and the AE-4)	A

Control panel	Code
CP-60	060
CP-160	160
CP-360	360

Pulley belt	Code
Lockstitch for general fabric	D

\* 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)



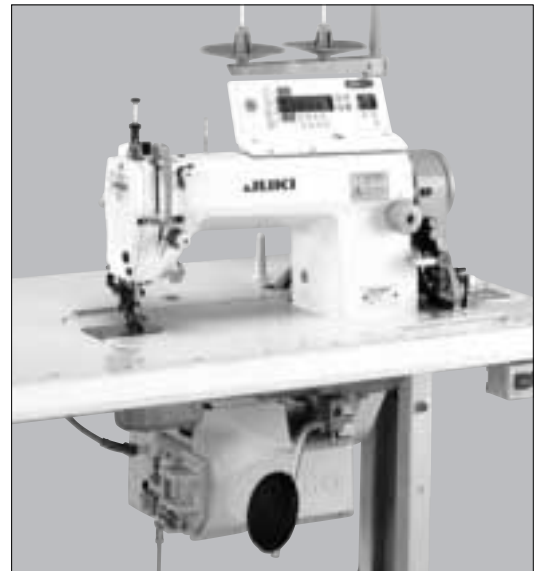
Material edge sensor (ED-2)

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	5mm	
Max. top-feed amount	8mm	
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)	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: 30kg	Total weight: 83kg

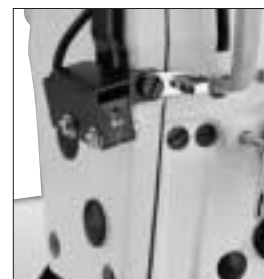
### OPTIONS

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)

## WHEN YOU PLACE ORDERS

DLU-5490N

DLU-5490N   -7-

Application	Code	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 topstitching	C	For bottom hemming	M*
		For piping	N*
To prevent it from catching materials	CG	For zipper attaching (left)	P
For sewing sharp curves	D	For preventing puckering	S

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

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

\* 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 -    A

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

Control box	Code
Standard	S
Optional unit A (for the ED-2 and the AE-4)	A

Control panel	Code
CP-60	060
CP-160	160
CP-360	360

Pulley belt	Code
Lockstitch for general fabric	D

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

## WHEN YOU PLACE ORDERS

DLU-5494N   -7-

### Gauge set

Application	Code
For light-weight materials (standard)	BB

Note: Various gauges other than those shown are also available.

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

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

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

SC801-   AD-560

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

Control box	Code
Optional unit A	A

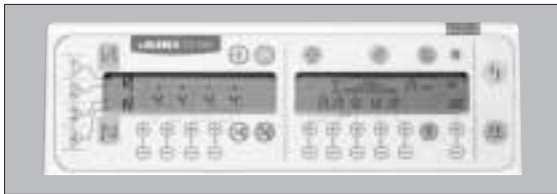
Control panel	Code
CP-560	560

Pulley belt	Code
Lockstitch for general fabric	D

\* 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	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.
	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	5mm	
Max. top-feed amount	Shirring 1:1.5 (Max. 1:3), Stretching 1:0.5	
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	
Weight	Machine head: 29kg	Total weight: 82kg

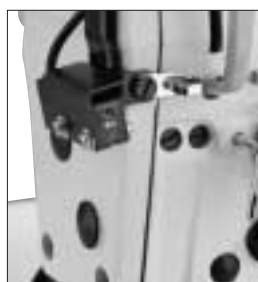
### OPTIONS

Model	Part No.	Description	Feature
AK85		Auto-lifter	
AE-4 *	GAE-040000AO	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-7-□□□□

Wiper and automatic reverse feed function			Auto-lifter (optional)	
Wiper	Automatic reverse feed function	Code	Code	
Not provided	Provided	OB	Not provided	
Provided	Provided	WB	Provided (AK85) AK	

● PSC box/control panel/motor for SC

SC800-□□□□D-□□□□A

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

Pulley belt		Code
Lockstitch for general fabric		D

\* 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

Model name	DLM-5200N	DLM-5210N
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 x 1 (#14), For JE: 134 (Nm90)	
Hook	Automatic-lubricating full-rotary hook	
Max. thickness of the material to be cut	4mm	
Lubrication	Automatic	
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 type	
Distance between the needle and the knife	Code
3.2mm (1/8") standard	D
2.4mm (3/32")	C
4.0mm (5/32")	E
4.8mm (3/16")	F
6.4mm (1/4")	H
9.5mm (3/8")	M









DLM-5210N/N01

Type of binder	Code
Rolled hem	N011
Clean finish, top and bottom	N015

Finished width		
N011	N015	Code
5mm		A
6mm		B
7mm		C
	9.5mm	E

# DLM-5200N

## 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
									
C	2.4mm (3/32")	113-46004	B1115-530-OAD	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-OAD	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-OAF	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-OAF	B1190-522-T00	113-46905	113-46400	B1524-522-NB0A	B1613-522-N00A	B4121-522-000
H	6.4mm (1/4")	113-46004	B1115-530-OAF	B1190-522-U00	113-47101	113-46509	B1524-012-0BA	B1613-522-W00A	B4121-522-000
M	9.5mm (3/8")	113-46103	B1115-530-OAM	B1190-522-V00	113-47309	113-46509	B1524-012-0BA	B1613-522-W00A	B4121-522-000

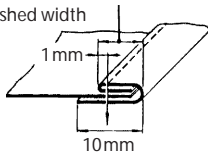
■ This is made to order as an auxiliary part only

CA	2.0mm (5/64")	113-46004	B1115-530-OAD	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-OAF	B1190-522-U0A	113-47101	113-46509	B1524-012-0BA	B1613-522-A0A	B4121-522-000
K	7.9mm (5/16")	113-46103	B1115-530-OAM	B1190-522-Y0B	113-47101	113-46509	B1524-012-0BA	B1613-522-W00A	B4121-522-000

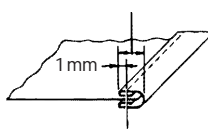
# DLM-5210N/ N011, N015

## ATTACHMENTS

### ● N011

Rolled hem 	N011 Semi-fold Binder (cut-before knife, rolled hem) Exclusive sub-gauge					
	Finished width	Tape width	Part No. of the attachment	Gauge	Presser foot (asm.)	Front knife
	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
	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	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
	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

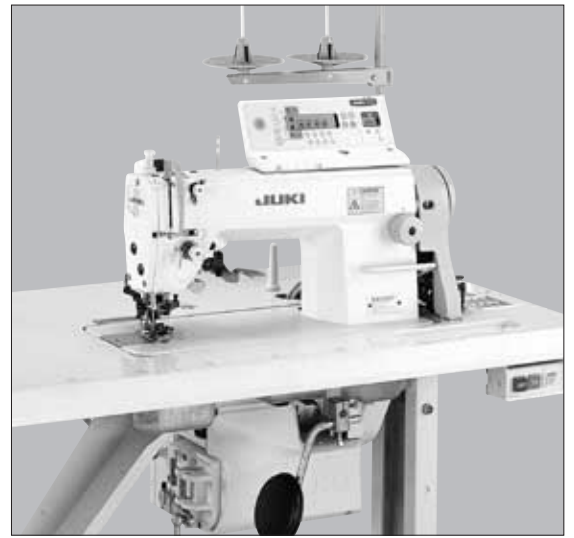
1-needle, Bottom-feed Lockstitch Machine with an Edge Trimmer and an Automatic Thread Trimmer

## 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

## SPECIFICATIONS

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	30.7mm	
Lift of the presser foot	By hand : 5.5mm, By knee : 10mm	
Needle (at the time of delivery)	DB × 1 (#14) #9 ~ #18, For JE: 134 (Nm90)	
Hook	Automatic-lubricating full-rotary hook	
Max. thickness of the material to be cut	4mm	
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	83kg	84kg

## 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.

\* 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.

## WHEN YOU PLACE ORDERS

**DLM-5400N**  -7-

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

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

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

**DMN-5420N**   -7-

Sub-gauge type	
Distance between the needle and the knife	Code
3.2mm (1/8") standard	D
4.0mm (5/32")	E
4.8mm (3/16")	F
5.6mm (7/32")	G
6.4mm (1/4")	H
9.5mm (3/8")	M

Feed dog	Code
Standard	A
Coarse feed dog	B

Wiper and automatic reverse feed function		
Wiper	Automatic reverse feed function	Code
Not provided	Not provided	00
Not provided	Provided	OB
Provided	Provided	WB

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

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

**SC800-**    **D-**    **A**

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

Control box	Code
Standard	S
Optional unit A (for the ED-2 and the AE-4)	A









Control panel	Code
CP-60	060
CP-160	160
CP-360	360

Pulley belt	Code
Lockstitch for general fabric	D

\* 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.

**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
									
** 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
H	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
M	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







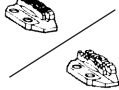

■ This is made to order as an auxiliary part only.

** 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
CB	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
K	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
									
** 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
H	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
M	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 made to order as an auxiliary part only.

Coarse feed dog

* 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
K	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-3168-7-WB/CP-160B

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	3,000rpm			
Max. stitch length	4mm (normal/reverse feed)	5mm (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	Vertical-axis regular hook			
Needle (at the time of delivery)	DP x 5 (#9) #9 ~ #14	DP x 5 (#9) #9 ~ #14	DP x 5 (#14) #11 ~ #18	DP x 5 (#21) #18 ~ #22
Organized split needle bar mechanism	Not provided			
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 x 178mm			
Weight of the machine head	38kg			

Model name	LH-3168A	LH-3168S	LH-3168G	LH-3178S	LH-3178G	LH-3188G
Feed system	Needle-feed					
Application	For light-weight materials	For medium-weight materials	For jeans and heavy-weight materials	For medium-weight materials	For jeans and heavy-weight materials	
Max. sewing speed	3,000rpm					
Max. stitch length	5mm (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	Vertical-axis regular hook			Vertical-axis double-capacity hook		
Needle (at the time of delivery)	DP x 5 (#9) #9 ~ #14	DP x 5 (#14) #11 ~ #18	DP x 5 (#21) #18 ~ #22	DP x 5 (#14) #11 ~ #18	DP x 5 (#21) #18 ~ #22	
Organized split needle bar mechanism	Provided as standard			Not provided		Provided as standard
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 x 178mm					
Weight of the machine head	38kg					

## ● 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-weight materials		For medium-weight materials	For jeans and heavy-weight materials
Max. sewing speed	3,000rpm			
Max. stitch length	4mm (normal/reverse feed)	5mm (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, By knee lifter with wiper: 9mm			
Hook	Vertical-axis regular hook			
Needle (at the time of delivery)	DP x 5 (#11) #11 ~ #14	DP x 5 (#11) #11 ~ #14	DP x 5 (#14) #11 ~ #18	DP x 5 (#21) #18 ~ #22
Organized split needle bar mechanism	Not provided			
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 x 178mm			
Weight of the machine head	43kg			
Power requirement	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V			

Model name	LH-3168A-7	LH-3168S-7	LH-3168G-7	LH-3178S-7	LH-3178G-7	LH-3188G-7
Feed system	Needle-feed					
Application	For light-weight materials	For medium-weight materials	For jeans and heavy-weight materials	For medium-weight materials	For jeans and heavy-weight materials	
Max. sewing speed	3,000rpm					
Max. stitch length	5mm (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, By knee lifter with wiper: 9mm					
Hook	Vertical-axis regular hook			Vertical-axis double-capacity hook		
Needle (at the time of delivery)	DP x 5 (#11) #11 ~ #14	DP x 5 (#14) #11 ~ #18	DP x 5 (#21) #18 ~ #22	DP x 5 (#14) #11 ~ #18	DP x 5 (#21) #18 ~ #22	DP x 5 (#21) #18 ~ #22
Organized split needle bar mechanism	Provided as standard			Not provided		Provided as standard
Lubrication	Fully automatic lubrication system by means of a plunger pump					
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)					
Automatic reverse feed function	Provided as standard					
Distance from needle to machine arm	245mm					
Bed size	517mm x 178mm					
Weight of the machine head	43kg					
Power requirement	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V					

# WHEN YOU PLACE ORDERS

## ● With an automatic thread trimmer

Type	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

Application	Code
For light-weight materials	A
For medium-weight materials	S
For jeans and heavy-weight materials	G

Wiper and automatic reverse feed function		
Wiper	Automatic reverse feed function	Code
Not provided	Not provided	00
	Provided	0B
Provided	Not provided	W0
	Provided	WB

Auto-lifter	Code
Not provided	/
Pedal switch type (AK89)	89

LH-31 [ ] [ ] [ ] [ ] -7- [ ] [ ] [ ] [ ]

Code		A	B	C	D	E	F	G	H	K	W	L	M	N	P	Q	R	S
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
	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
Model name	Spec.																	
LH-3120-7	A																	
LH-3128-7	A																	
	S																	
LH-3168-7	G																	
	A																	
LH-3178-7	S																	
	G																	
LH-3188-7	G																	

\* 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

SC800- [ ] [ ] [ ] H- [ ] [ ] [ ] B

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

Control box	Code
Standard	S
Optional unit B (for without a bobbin thread clamp)	B

Control panel	Code
CP-60	060
CP-160	160
CP-360	360

Pulley belt	Code
For LH	H

\* 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

Type	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

Application	Code
For light-weight materials	A
For medium-weight materials	S
For jeans and heavy-weight materials	G

LH-31 

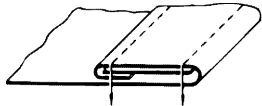
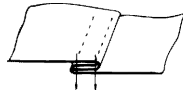
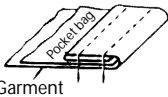
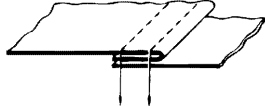
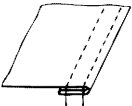
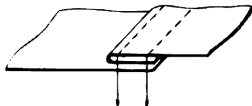
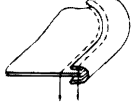
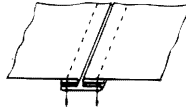
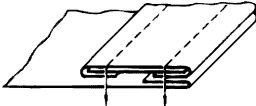

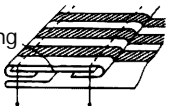
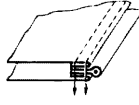
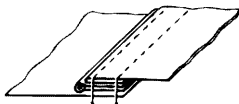
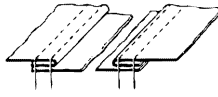

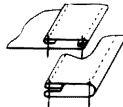
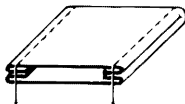


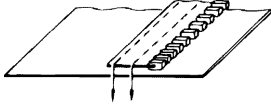

Code		A	B	C	D	E	F	G	H	K	W	L	M	N	P	Q	R	S	T	U		
Model name	Needle gauge	mm	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8	34.9	38.1	
	Spec.	inch	3/32	1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4	1-3/8	1-1/2	
LH-3120	A																					
LH-3128	A																					
	S																					
	G																					
LH-3168	A																					
	S																					
	G																					
LH-3178	S																					
	G																					
LH-3188	G																					

\* 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 (L045)	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
Pocket binder (clean finish top and bottom) (N054)	To tape attaching process to bind edges of pocket bags of slacks, pants, skirts, etc. 	S type	Tape attaching foot with center guide (B006)	For opening seam of brassieres, body suits etc. 	LH-3128F A type S type
Top center plait (folder) (M315)	For attaching formal top center plait on men's shirts, etc. 	A type S type	Sewing edge guide (H010)	Edge guide applicable to runstitching process and decorative stitching process 	S type G type
Center plait folder (from neck down) (M037)	For making front facing from the neck side. Interlining 	A type S type	Sewing roller guide (H011)	Edge guide for runstitch process using vinylcoated cloth or man-made leather. 	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	Presser foot with guide (B009)	Lapping seam process and counterstitching process for denim, drill, wool, gabardine, etc. 	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	Compensating presser foot (B020)	For making top center plaits of knit shirts, blouses, etc. and for making belts of ladies' wear 	S type G type
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	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
Lapping seam folder (M170)	For lapping seam in the various joining process including joining sides of jeans, work uniforms, pantaloons etc. 	S type G type	Zipper guide (Q090)	For runstitching left fly of pants and zippers 	S type
			Zipper folder (S004B)	Attaching zippers on skirts, jumpers, matcovers, etc. 	LH-3128S

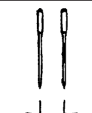



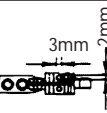
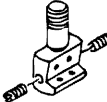
\* The part numbers are designated according to needle gauge and specification.  
Be sure to confirm the part number of the attachment you need when placing your order with us.

# TABLE OF EXCHANGE PARTS FOR LH3100 SERIES

## LH-3128




Needle gauge size		Throat plate	Feed dog			Presser foot asm.		
Code								
A	2.4mm (3/32")	226-25008	226-35007			226-37557		
B	3.2mm (1/8")	226-25107	226-30107			226-37656		
C	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-DOH	226-37854	101-52759	226-40353
E	5.6mm (7/32")	226-25404	226-35403	226-30503	B1613-512-EOH	226-37953	101-52858	226-40452
F	6.4mm (1/4")	226-25503	226-35502	226-30602	B1613-512-FOH	226-38050	101-52957	226-40551
G	7.1mm (9/32")	226-25602	226-35700	226-30800	B1613-512-GOH	226-38258	101-53054	226-40759
H	7.9mm (5/16")	226-25701	226-35809	226-30909	B1613-512-HOH	226-38357	101-53153	226-40858
K	9.5mm (3/8")	226-25800	226-35908	226-31006	B1613-512-KOH	226-38456	101-53252	226-40957
W	11.1mm (7/16")	226-25909	226-36005	226-31105	*	226-38555	101-53351	226-41054
L	12.7mm (1/2")	226-26006	226-36203	226-31303	B1613-512-LOH	226-38753	101-53450	226-41252
M	15.9mm (5/8")	226-26105	226-36302	226-31402	B1613-512-MOH	226-38852	101-53559	226-41351
N	19.1mm (3/4")	226-26204	226-36401	226-31501	B1613-512-NOH	226-38951	101-53658	226-41450
P	22.2mm (7/8")	226-26303	226-36609	226-31709	B1613-512-POH	226-39157	101-53757	226-41658
Q	25.4mm (1")	226-26402	226-36708	226-31808	B1613-512-QOH	226-39256	101-53856	226-41757
R	28.6mm (1-1/8")	226-26501	226-36807	226-31907	B1613-512-ROH	226-39355	101-53955	226-41856
S	31.8mm (1-1/4")	226-26600	226-36906	226-32004	B1613-512-SOH	226-39454	101-54052	226-41955
T	34.9mm (1-3/8")	226-26709	226-37003	226-32103	B1613-512-TOH	226-39553	101-54151	226-42052
U	38.1mm (1-1/2")	226-25808	226-37102	226-32202	B1613-512-UOH	226-39652	101-54250	226-42151
Stitch spec.	S	Spec. common						
	A							
	G							


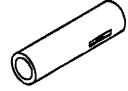
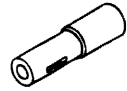
## LH-3128-7

Needle gauge size		Throat plate with thread trimmer	Feed dog (with thread trimmer)			Needle clamp asm.
Code						
A	2.4mm (3/32")	226-60104	226-65004			101-47551
B	3.2mm (1/8")	226-60203	226-65103			101-47650
C	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
H	7.9mm (5/16")	226-60807	226-65806	102-38400	102-39507	101-48252
K	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
M	15.9mm (5/8")	226-61201	226-66309	102-38806	102-39903	101-48658
N	19.1mm (3/4")	226-61300	226-66408	102-38905	101-71106	101-48757
P	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
T	34.9mm (1-3/8")					101-49250
U	38.1mm (1-1/2")					101-49359
Stitch spec.	S	Spec. common				Spec. common
	A					
	G					


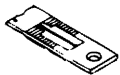



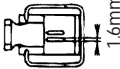
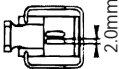

Standard spec.  
Substandard spec.  
\* Special order

# LH-3128/3128-7








Needle 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

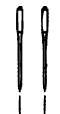
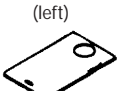
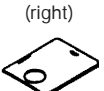
Needle gauge size		Front metal	Inner metal
Code			
A   P	2.4mm (3/32")   22.2mm (7/8")	B1802-512-0A0A	B1803-515-0A0
Q   U	25.4mm (1")   38.1mm (1-1/2")	B1802-512-0AB	101-12357




## LH-3168

Needle gauge size		Throat plate	Feed dog			Presser foot asm.		
Code								(tipdivided) 
B	3.2mm (1/8")	226-25107	226-30107			226-37656		
C	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-DOH	226-37854	101-52759	226-40353
E	5.6mm (7/32")	226-25404	226-35403	226-30503	B1613-512-EOH	226-37953	101-52858	226-40452
F	6.4mm (1/4")	226-25503	226-35502	226-30602	B1613-512-FOH	226-38050	101-52957	226-40551
G	7.1mm (9/32")	226-25602	226-35700	226-30800	B1613-512-GOH	226-38258	101-53054	226-40759
H	7.9mm (5/16")	226-25701	226-35809	226-30909	B1613-512-HOH	226-38357	101-53153	226-40858
K	9.5mm (3/8")	226-25800	226-35908	226-31006	B1613-512-KOH	226-38456	101-53252	226-40957
L	12.7mm (1/2")	226-26006	226-36203	226-31303	B1613-512-LOH	226-38753	101-53450	226-41252
M	15.9mm (5/8")	226-26105	226-36302	226-31402	B1613-512-MOH	226-38852	101-53559	226-41351
N	19.1mm (3/4")	226-26204	226-36401	226-31501	B1613-512-NOH	226-38951	101-53658	226-41450
Q	25.4mm (1")	226-26402	226-36708	226-31808	B1613-512-QOH	226-39256	101-53856	226-41757
Stitch spec.	S	Spec. common						★
	A							
	G						★	




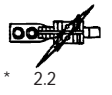


## LH-3168-7

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





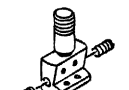

Needle gauge size		Bed slide asm. (with thread trimmer)	
Code		Bed slide asm. (left) 	Bed slide asm. (right) 
B	3.2mm (1/8")	226-50857	226-50352
K	9.5mm (3/8")		
L	12.7mm (1/2")	226-50956	226-50451
N	19.1mm (3/4")		
Q	25.4mm (1")	226-51053	226-50550

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

# LH-3178

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



# LH-3178-7

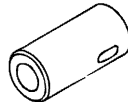
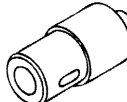
Needle gauge size		Throat plate with thread trimmer	Feed dog (with thread trimmer)		Needle clamp asm.	Presser foot asm.
Code						
A	2.4mm (3/32")					
B	3.2mm (1/8")	226-60203	226-65103		101-47650	102-22255
C	4.0mm (5/32")	226-60302	102-37907		101-47759	102-22354
D	4.8mm (3/16")	226-60401	102-38004	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
H	7.9mm (5/16")	226-60807	102-38400	228-21607	101-48252	226-40858
K	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
M	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
P	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	
T	34.9mm (1-3/8")				101-49250	
U	38.1mm (1-1/2")				101-49359	
Stitch spec.	S	Spec. common			Spec. common	
	G					

Standard spec.


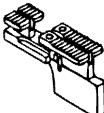

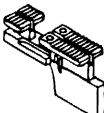
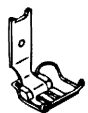



## LH-3178/3178-7




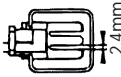
Needle gauge size		Bed slide asm. (with thread trimmer)	
Code		Bed slide asm. (left)	Bed slide asm. (right)
A	2.4mm (3/32")		
W	11.4mm (7/16")		
L	12.7mm (1/2")		
N	19.1mm (3/4")		
P	22.2mm (7/8")		
Q	28.6mm (1-1/8")		
S	31.8mm (1-1/4")		
U	38.1mm (1-1/2")		

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


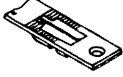

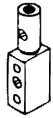

### ● Chain-off thread gauge

Needle 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
						
D	4.8mm (3/16")	228-35003	228-35557	228-35201	106-91053	B1524-512-DBH
F	6.4mm (1/4")	228-35102	228-35656	228-35300	106-98652	B1524-512-FBE


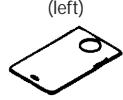
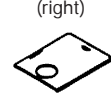
**LH-3188**


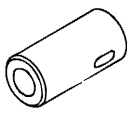
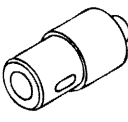
Needle gauge size		Throat plate	Feed dog	Presser foot asm.
Code				(tipdivided) 
B	3.2mm (1/8")			
C	4.0mm (5/32")			
D	4.8mm (3/16")	226-25305	228-15401	228-16557
E	5.6mm (7/32")	226-25404	228-15500	228-16656
F	6.4mm (1/4")	226-25503	228-15609	228-16755
G	7.1mm (9/32")	226-25602	228-15708	228-16854
H	7.9mm (5/16")	226-25701	228-15807	228-16953
K	9.5mm (3/8")	226-25800	228-15906	228-17050
L	12.7mm (1/2")	226-26006	228-16003	228-17159
M	15.9mm (5/8")			
N	19.1mm (3/4")			
Q	25.4mm (1")			
Stitch spec.	S	Spec. common		
	A			
	G			

**LH-3188-7**



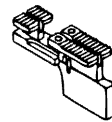

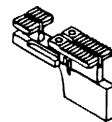
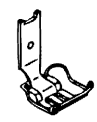

Needle gauge size		Throat plate with thread trimmer	Feed dog (with thread trimmer)	Needle clamp asm. Left	Needle clamp asm. Right
Code					
B	3.2mm (1/8")				
C	4.0mm (5/32")				
D	4.8mm (3/16")	226-60401	228-21201	B1402-528-DALA	B1402-528-DARA
E	5.6mm (7/32")	226-60500	228-21300	B1402-528-EAL	B1402-528-EAR
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
H	7.9mm (5/16")	226-60807	228-21607	B1402-528-HALA	B1402-528-HARA
K	9.5mm (3/8")	226-60906	228-21706	B1402-528-KALA	B1402-528-KARA
L	12.7mm (1/2")	226-61102	228-21805	B1402-528-LAL	B1402-528-LAR
M	15.9mm (5/8")				
N	19.1mm (3/4")				
Q	25.4mm (1")				
Stitch spec.	S	Spec. common		Spec. common	
	A				
	G				

**LH-3188/3188-7**








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

Needle gauge size		Front metal	Inner metal
Code			
A	2.4mm (3/32")	B1802-512-0A0A	B1803-515-0A0
P	22.2mm (7/8")		
Q	25.4mm (1")	B1802-512-0A0B	101-12357
U	38.1mm (1-1/2")		








● Chain-off thread gauge

Needle gauge size	Throat plate (without thread trimmer)	Feed dog (without thread trimmer)	Throat plate (with thread trimmer)	Feed dog (with thread trimmer)	Presser foot asm.	Feed dog screw	
Code							
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	




## LH-3120

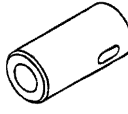
Needle gauge size		Throat plate		Feed dog		Presser foot asm.	Needle clamp asm.
Code							
A	2.4mm (3/32")						
B	3.2mm (1/8")	228-45200		228-47206		103-91852	101-47650
C	4.0mm (5/32")						
D	4.8mm (3/16")	228-45408		228-47404		103-92058	101-47858
E	5.6mm (7/32")						
F	6.4mm (1/4")	228-45606		228-47602		103-92256	101-48054
G	7.1mm (9/32")						
H	7.9mm (5/16")						
K	9.5mm (3/8")						
W	11.1mm (7/16")						
L	12.7mm (1/2")		228-46109		228-48105	103-92751	101-48559
M	15.9mm (5/8")						
N	19.1mm (3/4")		228-46307		228-48303	103-93056	101-48757
P	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")						
T	34.9mm (1-3/8")						
U	38.1mm (1-1/2")						
Stitch spec.	A					Spec. common	Spec. common

## LH-3120-7

Needle gauge size		Throat plate		Feed dog		Presser foot asm.	Needle clamp asm.
Code							
A	2.4mm (3/32")						
B	3.2mm (1/8")	228-53204		228-55209		103-91852	101-47650
C	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")						
H	7.9mm (5/16")						
K	9.5mm (3/8")						
W	11.1mm (7/16")						
L	12.7mm (1/2")		228-54103		228-56108	103-92751	101-48559
M	15.9mm (5/8")						
N	19.1mm (3/4")		228-54301		228-56306	103-93056	101-48757
P	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")						
T	34.9mm (1-3/8")						
U	38.1mm (1-1/2")						
Stitch spec.	A						

## LH-3120/3120-7

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

Needle gauge size	Front metal	Inner metal
	Code	
A	2.4mm (3/32")	
P	22.2mm (7/8")	B1802-512-0A0A
Q	25.4mm (1")	
U	38.1mm (1-1/2")	B1802-512-0A0B
		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 x 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 x 178mm
Weight of the machine head	43kg

## WHEN YOU PLACE ORDERS

Needle gauge	Code	Feed	Code	Automatic reverse feed function	Code	Hook	Code
3.2mm (1/8")	B	Needle-feed	A	Not provided	00	Latch hook	S
4.8mm (3/16")	D	Bottom-feed*	B	Provided	0B	Hook with a non-rotational bobbin	C
6.4mm (1/4")	F	* For the "Bottom-feed: B," only the needle gauges B, D, and F are applicable.		* Refer to the combination availability table.			
7.1mm (9/32")	G						
7.9mm (5/16")	H						

LH-3126F [ ] [ ] - [ ] [ ] - [ ] [ ] [ ] [ ]

Attachment	Code
Standard throat plate, standard slide plate, standard presser foot	1
Throat plate for tape-attachment, slide plate for tape-attachment, presser foot for tape-attachment	4*

\* For the above category 4, select the feed category A (needle-feed).

Auto-lifter	Code
Not provided	Z
Pedal switch type (AK89)*	P

\* For the AK89, select the motor compatibility category 1 (SC-800 or EC-10B).

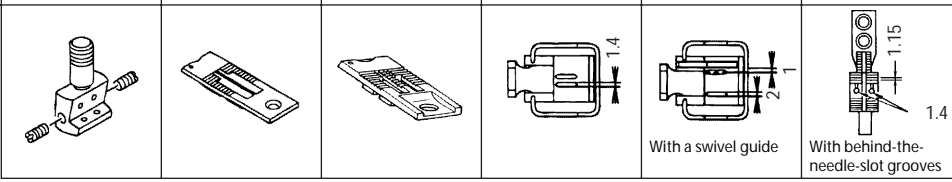
Motor*	Code
Compatible with clutch motor (without synchronizer and resistor pack)	0
Compatible with SC-800 and EC-10B (with built-in synchronizer and resistor pack)	1

\* Refer to the combination availability table.

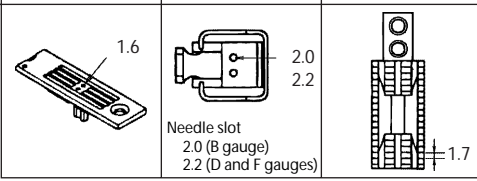
Combination availability table				
Automatic reverse feed function	Motor	Clutch motor	SC-800	EC-10B
0 (not provided)	Where "0" is selected		x	x
	Where "1" is selected	x		
B (provided)	Where "0" is selected	x	x	x
	Where "1" is selected	x		

●Gauges installed at the time of delivery

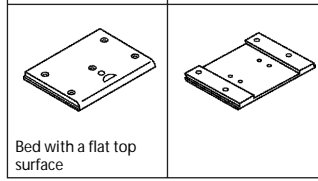
Gauge size		Needle-feed gauges					
Code		Needle clamp	Throat plate		Presser foot		Feed dog (small pitch)
			Standard type	For tape attachment	Standard type	For tape attachment	
B	3.2mm (1/8")	101-47650	226-25107	232-06808	226-27152	226-47051	B1613-512-B0B
D	4.8mm (3/16")	101-47858	226-25305	B1109-512-DOB	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
H	7.9mm (5/16")	101-48252	226-25701	B1109-512-H0B	226-27756	226-47556	B1613-512-H0B



Gauge size		Bottom-feed gauges		
Code		Throat plate	Presser foot	Feed dog
		B	3.2mm (1/8")	228-45200
D	4.8mm (3/16")	228-45408	103-92058	232-05305
F	6.4mm (1/4")	228-45606	103-92256	232-05503

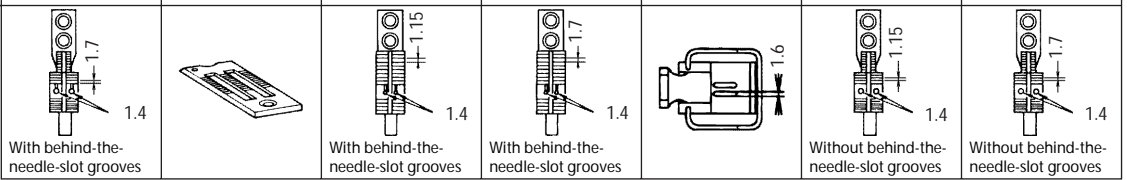


Common gauges for needle-feed and bottom-feed	
Slide plate (front)	
Standard type	For tape attachment
B1110-051-0A0	232-06709

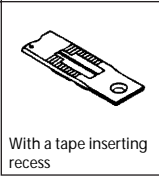


●Optional gauges

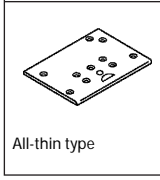
Gauge size		Needle-feed gauges						
Code		Feed dog (large pitch)	Rectangular feed			For light-weight materials		
			Throat plate	Feed dog (small pitch)	Feed dog (large pitch)	Presser foot	Feed dog (small pitch)	Feed dog (large pitch)
B	3.2mm (1/8")	101-08108	B1109-528-B00	101-86302	101-40804	226-37656	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
H	7.9mm (5/16")					226-38357	226-35809	226-34604



Gauge size		Needle-feed gauges	
Code		Throat plate	For tape attachment
		B	3.2mm (1/8")
D	4.8mm (3/16")	226-28200	
F	6.4mm (1/4")	226-28408	
G	7.1mm (9/32")	226-28507	
H	7.9mm (5/16")	226-28606	



Common gauges for needle-feed and bottom-feed	
Slide plate (front)	
For tape attachment	
226-08558	



OPTIONS

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.

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

## 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 heavy-weight materials	
Max. sewing speed	3,000rpm			
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	Vertical-axis regular hook (cap type)			Vertical-axis double-capacity hook (cap type)
Needle (at the time of delivery)	DP x 5 (#11) #11 ~ #14	DP x 5 (#14) #11 ~ #18	DP x 5 (#21) #18 ~ #22, For JE: 134 (Nm130)	
Thread take-up	Slide type			
Needle bar stroke	33.4mm			
Lubrication	Fully automatic lubrication system by means of a plunger pump			
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)			
Organized split needle bar	Provided as standard			
Distance from needle to machine arm	245mm			
Bed size	517mm x 178mm			
Weight of the machine head	43Kg			
Power requirement	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V			

## 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)

## WHEN YOU PLACE ORDERS

Type	Code
Needle-feed with an organized split needle bar	62
Needle-feed with an organized split needle bar and large hooks	82

Application	Code
For light-weight materials	A
For medium-weight materials	S
For jeans and heavy-weight materials	G

Wiper and automatic reverse feed function		
Wiper	Automatic reverse feed function	Code
Not provided	Not provided	00
	Provided	0B
Provided	Not provided	W0
	Provided	WB

Auto-lifter	Code
Not provided	Z
Pedal switch type (AK89)	A

LH-31     -7-

Code		B	C	D	E	F	G	H	K	L	M	N	Q
Needle gauge	mm	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	12.7	15.9	19.1	25.4
	inch	1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	1/2	5/8	3/4	1
Model name	Spec.												
	A												
	S												
LH-3162-7	G												
LH-3182-7	G												

Options	Code
Not provided	Z
With a compensation stitching switch (reverse feed control lever mounting type)	A
With a compensation stitching switch (foot switch type)	B

\* 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

SC804-   SH-660B

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

Control box	Code
Standard (PK-70/-71 can be used for this feature)	S

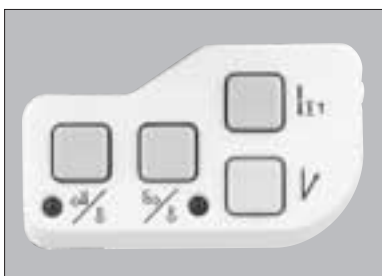
Control panel	Code
CP-660B	660

Pully belt	Code
75: 39 inch (for LH-3100 series)	H

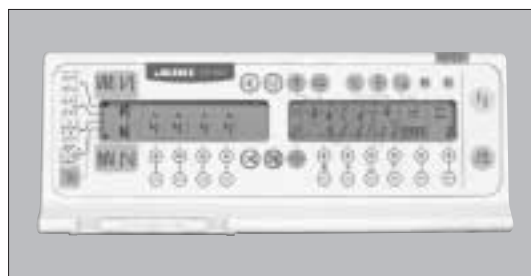
\* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

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

### ● Corner stitching hand-operated switches



### ● Control panel CP-660B



### ● Servomotor/Controller SC-804



2-needle, Needle-feed, Lockstitch Machine

# 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.



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

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-feed				Bottom-feed
Max. sewing speed	4,500rpm				3,500rpm
Max. stitch length	4mm			6mm	4mm
Lift of the presser foot	By hand: 5.5mm, By knee: 10mm				
Hook	Vertical-axis regular hook				
Needle (at the time of delivery)	SG x 1906 (#9) #9 ~ #16 For JE: 134 (Nm65)	DP x 5 (#14) #11 ~ #22 For JE: 134 (Nm90)	SG x 1965 (#9) #9 ~ #11 For JE: 134 (Nm65)	DP x 5 (#21) #18 ~ #22 For JE: 134 (Nm130)	DP x 5 (#11) #9 ~ #16 For JE: 134 (Nm75)
Thread take-up	Link type				
Needle bar stroke	33.4mm				
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 x 178mm				
Weight of the machine head	38Kg				

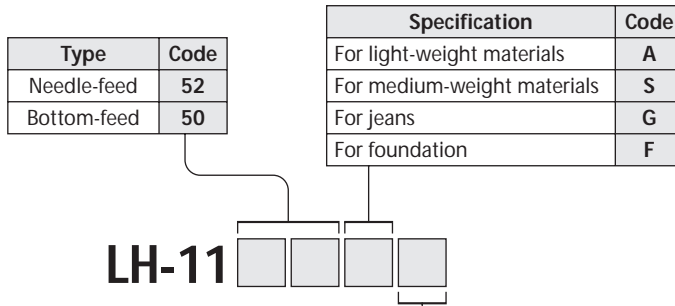
● With an automatic thread trimmer

Model name	LH-1152S-7	LH-1152G-7
Application	For medium-weight materials	For jeans
Feed method	Needle-feed	
Max. sewing speed	4,500rpm	
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 x 5 (#21) #18 ~ #22, For JE: 134 (Nm130)
Thread take-up	Link type	
Needle bar stroke	33.4mm	
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 x 178mm	
Weight of the machine head	43Kg	
Power requirement	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V	



## WHEN YOU PLACE ORDERS

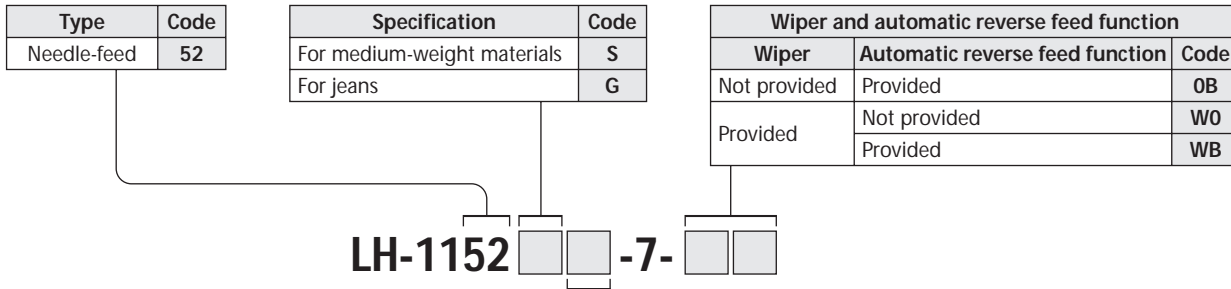
### ● Without an automatic thread trimmer



Code		A	B	C	D	E	F	G	H	K	W	L	M	N	P	Q	R	S	T	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	
	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	
Model name	Spec.																				
	A																				
	S																				
	G																				
LH-1152	F																				
LH-1150	A																				

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

### ● With an automatic thread trimmer



Code		A	B	C	D	E	F	G	H	K	W	L	M	N	P	Q	R	S	
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	
	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	
Model name	Spec.																		
	S																		
LH-1152-7	G																		

\* 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

**SC800-** [ ] [ ] [ ] **H-** [ ] [ ] [ ] **B**

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

Control box	Code
Standard	S
Optional unit A (for use by a standing operator)	A

Control panel	Code
CP-60	060
CP-160	160
CP-360	360

Pulley belt	Code
For LH	H

### ● Auto-lifter for SC

- Auto-lifter mounted on the machine head

**AK109**

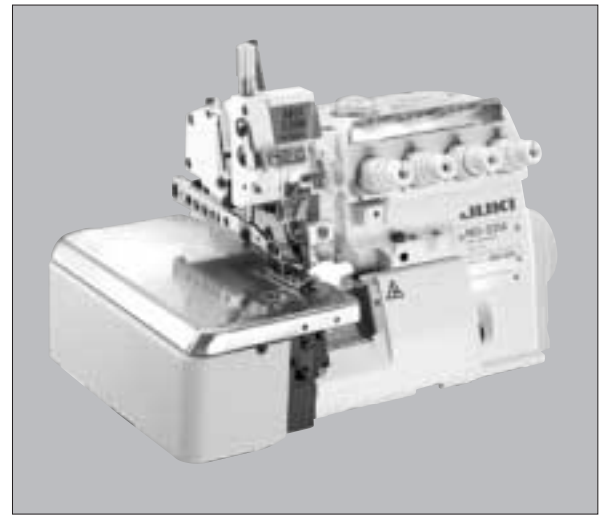
Device	Code
Pedal switch type	109

\* 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.

# 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 1:0.8 (max. 1:0.6)		
Needle bar stroke	25.5mm		
Inclination angle of the needle	20°		
Needle	DC x 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	Needle bar method and upper / lower bushing		
Upper knife	Carbide flat knife		
Opening/closing of cloth plate	By one-touch type open/close mechanism		
Opening/closing of looper cover	By one-touch type open/close mechanism		
Looper thread cam position guide mechanism			One-touch type flap mechanism
Threading marker	Thread path is colored		
Needle cooler	Provided as standard		
Weight of the machine head	25kg		
Lubrication	Automatic		
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)		

## WHEN YOU PLACE ORDERS

### MO-3314 E-BE6-44H/G41/Q148

Model No. Code

Subclass Code

Device & attachment

Special specification	Code
General spec.	E
Soft chain	B

Stitch style in the U.S.A.	Code
504	04
505	05
514	14
516	16
3-needle safety stitch	43

Needle gauge (mm)	Overedging width (mm)	Feed dog	Code
	4.0	2-row	0E4
	4.8	3-row	0F6
2.0	4.0	3-row	BE6
3.2	4.0	2-row	DE4
3.2	4.0	3-row	DE6
4.8	4.8	3-row	FF6
4.8	6.4	3-row	FH6
4.8 +2.0	3.2	3-row	FBD6

Material	Application	Special machine	Code
For medium- to heavy-weight materials	For runstitching	Upper looper extra high throw type	40H
	For blind stitch hemming		41H
	For attaching tape		44H
	For runstitching		50H
For extra heavy-weight materials	For runstitching		60H

## SUBCLASS MACHINE LIST

Seams	Model No.	Materials * L ~ H	Number of needles	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
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### 1-needle overlock

#### ● For runstitching in general fabric

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

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

	MO-3304E-0E4-40H	L ~ H	1	3	-	4.0	2	3.6	1:0.8 ~ 1:1.9	6.5	DC x 27 #11	6,500	Upper looper extra high throw type
	MO-3304E-0F6-50H	M ~ H	1	3	-	4.8	3	3.6	1:0.8 ~ 1:1.9	6.5	DC x 27 #14	6,500	

#### ● For backlatch ★Z192 : Backlatch attachment

	MO-3304B-0E4-40H /Z192	L ~ M	1	3	-	4.0	2	3.6	1:0.8 ~ 1:1.9	6.5	DC x 27 #11	6,500	Upper looper extra high throw type
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#### ● For blind stitch hemming ★L121 : Blind stitch hemming attachment

	MO-3305E-0E4-41H /L121	L ~ M	1	3	-	4.0	2	3.6	1:0.8 ~ 1:1.9	6.5	DC x 27 #9	6,500	Upper looper extra high throw type
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### 2-needle overlock

#### ● For runstitching in general fabric

	MO-3314E-BE6-40H	L ~ H	2	4	2.0	4.0	3	3.6	1:0.8 ~ 1:1.9	6.5	DC x 27 #11	6,500	Upper looper extra high throw type
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#### ● For tape attaching ★G41 : Tape attaching presser foot ★Q148 : Tape guide

	MO-3314E-BE6-44H /G41/Q148	M ~ H	2	4	2.0	4.0	3	3.6	1:0.8 ~ 1:1.9	6.5	DC x 27 #14	6,500	Upper looper extra high throw type
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### Safety stitching

#### ● For runstitching in general fabric

	MO-3316E-DE4-40H	L ~ H	2	5	3.2	4.0	2	3.6	1:0.8 ~ 1:1.9	6.5	DC x 27 #11	6,500	Upper looper extra high throw type
	MO-3316E-DE6-40H	L ~ H	2	5	3.2	4.0	3	3.6	1:0.8 ~ 1:1.9	6.5	DC x 27 #11	6,500	
	MO-3316E-FF6-40H	L ~ H	2	5	4.8	4.8	3	3.6	1:0.8 ~ 1:1.9	6.5	DC x 27 #11	6,500	
	MO-3316E-FF6-50H	M ~ H	2	5	4.8	4.8	3	3.6	1:0.8 ~ 1:1.9	6	DC x 27 #16	6,500	
	MO-3316E-FH6-50H	M ~ H	2	5	4.8	6.4	3	3.6	1:0.8 ~ 1:1.9	6	DC x 27 #16	6,500	
	MO-3316E-FF6-60H	H ~ EH	2	5	4.8	4.8	3	3.6	1:0.8 ~ 1:1.9	6	DC x 27 #21	6,500	
	MO-3316E-FH6-60H	H ~ EH	2	5	4.8	6.4	3	3.6	1:0.8 ~ 1:1.9	6	DC x 27 #21	6,500	

### 3-needle safety stitching

#### ● For multi-purpose runstitching

	MO-3343E-FBD6-40H	L ~ H	3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,500	Upper looper extra high throw type
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## DEVICES AND ATTACHMENTS

Model	Part No.	Description	Feature
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#### ● Chain-off thread trimming device

T041	MAT-041000AC	Pneumatic flat cutter	
T045	MAT-045000AA	Pneumatic side cutter	
T052	MAT-052001A0	One-touch type tape cutter and chain-off thread trimming device (electromagnetic type)	For 100, 115, 200, 240V
	MAT-052002A0		For 220, 380, 415, 440V

#### ● Chain-off thread suction device

MC-4		Pneumatic chain-off thread suction device	
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#### ● Air regulator (option)

• Air regulator (F.R. unit asm.) Part No.: PF-0552010-B0 • Fixing screw for F.R. unit asm. Part No.: GMD-0108000 x 2  
• Tube connector (male) Part No.: F1021-003-000 • One-touch connector Part No.: GAS-12063000 (\* Selection parts instead of the tube connector.)

#### ● Gathering device

S169	MAS-169000A0	Swing-type gathering device (interlocked with the pedal for safety stitch)	The separating plate opens interlocked with the foot pedal, to enable easy placement of a material on the machine. The manual lever is also mounted for easy opening/closing of the attachment.
S170	MAS-170000A0	Swing-type gathering device (interlocked with the pedal for overlock)	

#### ● Guide, Ruler

H153	MAH-153000A0	Cloth edge guide ruler (for overlock)	A swing type cloth edge guide
H154	MAH-154000A0	Cloth edge guide ruler (for safety stitch)	
L121	MAL-121000A0	Blind stitch hemming attachment	Blind stitch hemming for knitted fabric and knits
Q148	MAQ-148010A0	Tape guide	To be placed on the eye guard of the face plate. It is designed to be used for tape of width 7mm or less.

#### ● Presser foot

G41	124-66850	Tape-attaching presser foot	It is designed to be used with Q148 (tape guide).
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#### ● Miscellaneous

Z192	MAZ-192010A0	Backlatch attachment (for 1-needle overlock)	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.
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# 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

## 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 ~ 4mm		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 New Defrix Oil No.2 (equivalent to ISO VG32)		
Needle cooler	Optional: By silicon oil lubricating unit for the needle tip		
Needle thread heat remover	Optional: By silicon oil lubricating unit for the needle thread		

## SUBCLASS MACHINE LIST

\* EL = Extra light-weight materials L = Light-weight materials M = Medium-weight materials H = Heavy-weight materials EH = Extra heavy-weight materials

Seams	Model No.	Materials	Number of needles	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
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- 1-needle overlock
- For runstitching in general fabric
- For the machine attached with a triangle ( ), the number of kinds of overedging width is two or more.
 

A - 1.6mm	D - 3.2mm	G - 5.6mm
B - 2.0mm	E - 4.0mm	H - 6.4mm
C - 2.4mm	F - 4.8mm	
- The total overedging width: Needle 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 extra high throw type
	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	Upper looper extra high throw type/ For soft-chains
	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 extra high throw type
	MO-3604E-0 6-50H/F	M ~ H	1	3	-	4.8, 6.4	3	4	1:0.7 ~ 1:2	7	DC × 27 #14	6,000	Upper looper extra high throw type

- For blind hemming L121: Blind stitch hemming attachment

	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 extra high throw type
	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	

- For rolled hemming (folded downward)

	MO-3604E-0A4-150	EL ~ L	1	3	-	1.6	2	4	1:0.7 ~ 1:2	5	DC × 1 #8	6,000	
	MO-3604E-0A5-150/F		1	3	-	1.6	1	4	1:0.7 ~ 1:2	5	DC × 1 #8	6,000	

- For backlatch Z173: Backlatch device

	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
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													Remarks
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■ 2-needle overlock

● For runstitching in general fabric

	MO-3612E-CE4-40H	L~H	2	4	2.4	4.0	2	4	1:0.7~1:2	7	DC x 27 #11	6,000	Upper looper extra high throw type
	MO-3612E-0 6-40H	L~H	2	4	2.4	3.2, 4.0	3	4	1:0.7~1:2	7	DC x 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 x 27 #11	6,000	
	MO-3614E-BE4-40H/F	L~M	2	4	2.0	4.0	2	4	1:0.7~1:2	7	DC x 27 #11	6,000	
	MO-3614E-DE4-20H	L~H	2	4	3.2	4.0	2	4	1:0.7~1:2	7	DC x 27 #11	6,000	
	MO-3614E-BE6-40H/F	L~H	2	4	2.0	4.0	3	4	1:0.7~1:2	7	DC x 27 #11	6,000	

● For tape attaching G39: Tape attaching presser foot Q141: Tape guide

	MO-3614E-BE6-44H /G39/Q141	M~H	2	4	2.0	4.0	3	3.2	1:0.7~1:2	7	DC x 27 #14	6,000	Upper looper extra high throw type
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■ Safety stitching

● For runstitching in general fabric

	MO-3616E-BE4-40H/F	L~H	2	5	2.0	4.0	2	4	1:0.7~1:2	7	DC x 27 #11	6,000	Upper looper extra high throw type
	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 x 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 x 27 #11	6,000	
	MO-3616E-FF6-40H/F	L~H	2	5	4.8	4.8	3	4	1:0.7~1:2	7	DC x 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 x 27 #16	6,000	Upper looper extra high throw type (with tractor presser foot)
	MO-3616E-FF6-50H/F /G32	M~H	2	5	4.8	4.8	3	4	1:0.7~1:2	7	DC x 27 #16	6,000	Upper looper extra high throw type (for jeans)
	MO-3616E-F 6-60H/F	H~EH	2	5	4.8	4.8, 6.4	3	4	1:0.7~1:2	6	DC x 27 #21	6,000	

■ 2-needle double chainstitching

● For rolling-in tape N077: Blinder (clean finish top and bottom)

	MO-3645E-DD4-360 /F/N077	L~M	2	5	3.2	3.2	2	4	1:0.7~1:2	6.5	DC x 27 #11	6,000	
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■ 3-needle safety stitching

● For multi-purpose runstitching

	MO-3643E-FBD6-40H /F	L~M	3	6	4.8 +2.0	3.2	3	4	1:0.7~1:2	7	DC x 27 #11	6,000	Upper looper extra high throw type
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## WHEN YOU PLACE ORDERS

(Note) Some combinations are not available.

Needle gauge (mm)	Code	Overedging width (mm)	Code	Material	Code	Application	Code	Special machine	Code
1-needle	O	1.6	A	For extra light- to light-weight materials	1	For runstitching	0	Standard	O
1.6	A	2.0	B	For light- to medium-weight materials	2	For blind hemming	1	Upper looper extra high throw type	H
2.0	B	2.4	C		3	For gathering	2		
2.4	C	3.2	D	For medium- to heavy-weight materials	4	For piping	3		
3.2	D	4.0	E		5	For attaching tape	4		
4.0	E	4.8	F	For extra heavy-weight materials	6	For binding	5		
4.8	F	5.6	G		Jeans etc.	6	For binding tape	6	
6.8	R	6.4	H			For piping & gathering	B		
2.0 + 2.0	B.B								
3.2 + 2.0	D.B								
4.8 + 2.0	F.B								

Subclass Code  
**MO-3614 E -BE6-44H/ F /G39/Q141/T039**

Model No. Code

Stitch type in the U.S.A.	Code
503	03
504	04
505	05
512	12
514	14
515	15
516	16
3-needle safety stitch	43
2-needle double chain stitch	45

Special specification	Code
General spec.	E
Soft chain	B

Feed dog	Code
1-row	5
2-row	4
3-row	6

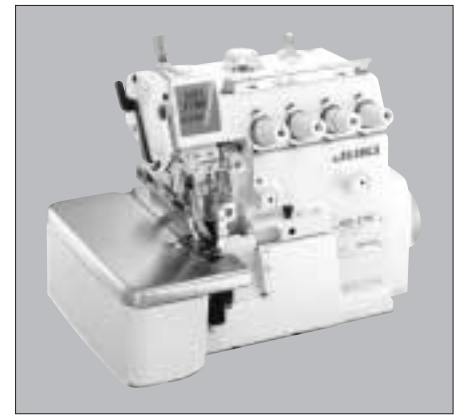
Gauges		
Classification	Parts	Symbol
Upper knife *	Square knife	K
	Flat knife	F
	Corrugated square knife	W
Replacement gauge	Throat plate	E01 ~
	Feed dog	F01 ~
	Presser foot	G01 ~
	Looper	H01 ~

Device & attachment

\* 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.

# 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

## 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 ~ 4mm (for special type machine, stitch length as long as 5mm is available)		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 gathering 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 x 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 VG32)		
Needle cooler	Optional: By silicon oil lubricating unit for the needle tip		
Needle thread heat remover	Optional: By silicon oil lubricating unit for the needle thread		

## SUBCLASS MACHINE LIST

\* EL = Extra light-weight materials    H = Heavy-weight materials  
 L = Light-weight materials    EH = Extra heavy-weight materials  
 M = Medium-weight materials

Seams	Model No.	Materials	Number of needles	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
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■ 1-needle overlock

● For runstitching in general fabric

● For the machine attached with a triangle ( ), the number of kinds of overedging width is two or more.

A - 1.6mm	D - 3.2mm	G - 5.6mm
B - 2.0mm	E - 4.0mm	H - 6.4mm
C - 2.4mm	F - 4.8mm	

● The total overedging width: Needle gauge + Overedging width

	MO-3703E-0E4-300	L ~ M	1	2	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	For serging
	MO-3704E-0D4-306		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC x 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 x 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 x 27 #11	7,000	
	MO-3704E-0 6-500	M ~ H	1	3	-	4.8, 5.6, 6.4	3	4	1:0.7 ~ 1:2	7	DC x 27 #14	7,000	
	MO-3704E-0F6-50H		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #14	7,000	Upper looper extra high throw type
	MO-3704B-0 4-300	L ~ M	1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	For soft-chains
	MO-3704B-0D6-300		1	3	-	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3704B-0D4-306		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3704E-0E4-40K/F		1	3	-	4.0	2	4	1:0.7 ~ 1:2	5.5	DC x 27 #11	7,000	Upper looper extra high throw type (For JHK)

														Remarks
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● For blind hemming L121: Blind stitch hemming attachment L122: Blind stitch hemming attachment (with automatic folder edge controlled hemming device)

	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 x 27 #9	7,000	
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● For rolled hemming (folded downward)

	MO-3704E-0 5-150	EL ~ L	1	3	-	1.6, 2.0	1	4	1:0.7 ~ 1:2	5	DC x 27 #8	7,000	
	MO-3704E-0 4-150		1	3	-	1.6, 2.0	2	4	1:0.7 ~ 1:2	5	DC x 27 #8	7,000	
	MO-3704E-0 5-156		1	3	-	1.6	1	4	1:0.7 ~ 1:2	5	DC x 27 #8	7,000	

● For Backlach Z173: Backlach attachment

	MO-3704B-0E4-300 /Z173	L ~ M	1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	For soft-chains
	MO-3704B-0E4-40H /Z173		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3704S-0D4-300 /Z173		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	

● For gathering S160: Swing-type gathering device (interlocked with pedal) S162: Swing-type gathering device (manual-lever operated)

	MO-3704E-0F6-320 /S160, S162	L ~ M	1	3	-	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC x 27 #11	7,000	
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● For piping M075: Piping folder (to be commonly used with knit materials) M076: Ready-made piping folder  
Diameter of gimp: To use a gimp whose diameter is greater than 2 to 2.5mm the machine will be made to order.

	MO-3704E-0F6-330 /M075, M076	L ~ M	1	3	-	4.8	3	4	1:0.7 ~ 1:2	5	DC x 27 #11	7,000	
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● For tape attaching G40: Tape attaching presser foot Q141: Tape guide

	MO-3704E-0F6-340 /G40/Q141	L ~ M	1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
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■ 2-needle overlock

● For runstitching in general fabric

	MO-3714E-B 4-307	L ~ M	2	4	2.0	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3714E-B 6-307		2	4	2.0	3.2, 4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3714E-BF6-20H		2	4	2.0	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3714E-B 6-40H	M ~ H	2	4	2.0	4, 4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	Upper looper extra high throw type
	MO-3714E-C 6-40H		2	4	2.4	4, 4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3712E-CD6-40H		2	4	2.4	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3712E-DF6-507		2	4	3.2	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #14	7,000	

● For gathering S160: Swing-type gathering device (interlocked with pedal) S162: Swing-type gathering device (manual-lever operated)

	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 x 27 #11	7,000	
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● For piping M075: Piping folder (to be commonly used with knit materials) M076: Ready-made piping folder  
Diameter of gimp: To use a gimp whose diameter is greater than 2 to 2.5mm the machine will be made to order.

	MO-3714E-BE6-337 /M075, M076	L ~ M	2	4	2.0	4.0	3	3.2	1:0.7 ~ 1:2	5	DC x 27 #11	7,000	
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● For tape attaching G39, G02, G20: Tape attaching presser foot Q141: Tape guide

	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 x 27 #11	7,000	
	MO-3714E-BE6-44H/F /G39/Q141	M ~ H	2	4	2.0	4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,000	Upper looper extra high throw type
	MO-3714E-BE7-44H/F /G02/Q141		2	4	2.0	4.0	4	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,000	
	MO-3714E-CE7-44H /G39/Q141	L ~ H	2	4	2.4	4.0	4	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,000	Upper looper extra high throw type (For JHK)
	MO-3714E-BE6-40K/F /G20/Q141		2	4	2.0	4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #11	7,000	
	MO-3714E-BE6-40K/F /G39/Q141		2	4	2.0	4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #11	7,000	

															Remarks
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■ Safety stitching

● For runstitching in general fabric

	MO-3715E-DE4-300	L ~ M	2	4	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3716E-BD4-300		2	4	2	3.2	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3716E-D 4-300		2	5	3.2	3.2, 4.0, 4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3716E-D 6-300		2	5	3.2	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC x 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 x 27 #11	7,000	
	MO-3716E-FF6-300		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3716E-D 6-500	M ~ H	2	5	3.2	3.2, 4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	7,000	
	MO-3716E-FF6-500		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	7,000	
	MO-3716E-FF6-50H		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	7,000	Upper looper extra high throw type
	MO-3716E-RH6-50H		2	5	6.8	6.4	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	7,000	
	MO-3716B-D 4-300	L ~ M	2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	For soft-chains
	MO-3716E-DE4-40K/F		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	Upper looper extra high throw type (For JHK)
	MO-3716E-FF6-50K/F /F26/G09	M ~ H	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	6	DC x 27 #16	7,000	

● For newly-developed synthetic fabric

	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 x 27 #11	7,000	
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● For jeans

	MO-3716E-FF6-50H /F26/G32	H ~ EH	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	5	DC x 27 #16	7,000	Upper looper extra high throw type
	MO-3716E-FH6-60H		2	5	4.8	6.4	3	4	1:0.7 ~ 1:2	5	DC x 27 #21	6,500	
	MO-3716E-FH6-60K/F		2	5	4.8	6.4	3	4.5	1:0.6 ~ 1:1.7	5	DC x 27 #21	6,500	Upper looper extra high throw type (For JHK)

● For gathering S159: Swing-type gathering device (interlocked with pedal) S161: Swing-type gathering device (manual-lever operated)

	MO-3716E-DE4-320 /S159, S161	L ~ M	2	5	3.2	4.0	2	3.2	1:0.9 ~ 1:2.6	6	DC x 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 x 27 #11	7,000	
	MO-3716E-FF6-320 /S159, S161		2	5	4.8	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC x 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 x 27 #14	7,000	Upper looper extra high throw type

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

Diameter of gimp: To use a gimp whose diameter is greater than 2 to 2.5mm the machine.

	MO-3716E-DE4-330 /M075, M076	L ~ M	2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	5	DC x 27 #11	7,000	
	MO-3716E-FF6-330 /M075, M076		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	5	DC x 27 #14	7,000	

● For piping & gathering M077: Piping folder for gathering

	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 x 27 #11	7,000	
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● For rolling-in tape N067: Binder for attaching reinforcement tape

	MO-3716E-DD4-360 /N067	L ~ M	2	5	3.2	3.2	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-3745E-DD4-360 /N077		2	5	3.2	3.2	2	4	1:0.7 ~ 1:1	5	DC x 27 #11	7,000	For binding periphery

■ 3-needle safety stitching

● For runstitching in general fabric Q141: Tape guide

	MO-3743E-DBD6-307	L ~ M	3	6	3.2 +2.0	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3743E-FBD6-307		3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3743E-FBD6-347 /G07/Q141		3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3743E-FBD6-50H	M ~ H	3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	7,000	



# WHEN YOU PLACE ORDERS

(Note) Some combinations are not available.

Needle gauge (mm)	Code
1-needle	O
0.8	Z
1.2	X
1.6	A
2.0	B
2.4	C
3.2	D
4.0	E
4.8	F
6.8	R
2.0 + 2.0	B.B
3.2 + 2.0	D.B
4.8 + 2.0	F.B

Overedging width (mm)	Code
1.6	A
2.0	B
2.4	C
3.2	D
4.0	E
4.8	F
5.6	G
6.4	H

Material		Code
For extra light- to light-weight materials		1
For light- to medium-weight materials	Training wear, knit, etc.	2
	Standard (for dress skirts to sport wear)	3
For medium- to heavy-weight materials	Knit sweater, bulky etc.	4
	Standard (general fabrics, jeans etc.)	5
For extra heavy-weight materials		6

Application	Code
For runstitching	0
For blind hemming	1
For gathering	2
For piping	3
For attaching tape	4
For binding	5
For binding tape	6
For piping & gathering	B

Special machine	Code
Standard	0
Throat plate and feed dog both provided with a lip	6
Upper looper high throw type	7
Commonly used for blind hemming and runstitching	B
Upper looper high throw type commonly used for blind hemming and runstitching	D
Adjustable overedging width (by replacing throat plate)	E
For swim suits	F
Upper looper extra high throw type	H
JUKI Hong Kong spec. (upper looper extra high throw type)	K
For newly-developed synthetic fabric	N

Subclass Code

**MO-3714 E -BD6-347/ F /G39/Q141/T039**

Model No. Code

Stitch type in the U.S.A.	Code
501	01
502	02
503	03
504	04
505	05
506	06
507	07
512	12
514	14
515	15
516	16
540	40
3-needle safety stitch	43
2-needle double chain	45

Special specification	Code
General spec.	E
Soft chain	B
Soft chain, Schiesser type	S

Feed dog	Code
1-row	5
2-row	4
3-row	6
4-row	7

Gauges		
Classification	Parts	Symbol
Upper knife *	Square knife	K
	Flat knife	F
	Corrugated square knife	W
Replacement gauge	Throat plate	E01 ~
	Feed dog	F01 ~
	Presser foot	G01 ~
	Looper	H01 ~

Device & attachment

\* 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.

# 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

## 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	9,000rpm		8,000rpm
Stitch length	0.8 ~ 4mm (for special type machine, stitch length as long as 5mm is available)		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 gathering 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 x 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 VG32)		
Needle cooler	Provided as standard: By silicon oil lubricating unit for the needle tip		
Needle thread heat remover	Provided as standard: By silicon oil lubricating unit for the needle thread		

## SUBCLASS MACHINE LIST

\* EL = Extra light-weight materials    H = Heavy-weight materials  
 L = Light-weight materials    EH = Extra heavy-weight materials  
 M = Medium-weight materials

Seams	Model No.	Materials *	Number of needles	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
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### 1-needle overlock

#### ● For runstitching in general fabric

● For the machine attached with a triangle ( ), the number of kinds of overedging width is two or more.

A - 1.6mm	D - 3.2mm	G - 5.6mm
B - 2.0mm	E - 4.0mm	H - 6.4mm
C - 2.4mm	F - 4.8mm	

● The total overedging width: Needle gauge + Overedging width

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

														Remarks
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- **For blind hemming** L121: Blind stitch hemming attachment L122: Blind stitch hemming attachment (with automatic folder edge controlled hemming device)  
L123: Spring-type folded-edge controlled bottom hemming device

	MO-3903E-0 4-210 /L121, L122, L123	L ~ M	1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	5.5	DC x 27 #9	8,500	
	MO3905E-0 4-210 /L121, L122, L123		1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #9	9,000	

- **For rolled hemming (folded downward)**

	MO-3904E-0 5-150	EL ~ L	1	3	-	1.6, 2.0	1	4	1:0.7 ~ 1:2	5	DC x 27 #8	9,000	
	MO-3904E-0 4-150		1	3	-	1.6, 2.0	2	4	1:0.7 ~ 1:2	5	DC x 27 #8	9,000	
	MO-3904E-0 5-156		1	3	-	1.6	1	4	1:0.7 ~ 1:2	5	DC x 27 #8	9,000	

- **For Backlach** Z173: Backlach attachment

	MO-3904B-0 4-300 /Z173	L ~ M	1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	9,000	For soft-chains
	MO-3904B-0 6-300 /Z173		1	3	-	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	9,000	
	MO-3904S-0D4-300 /Z173		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	9,000	

- **For gathering** S160: Swing-type gathering device (interlocked with pedal) S162: Swing-type gathering device (manual-lever operated)

	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 x 27 #11	7,000	
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- **For piping** M075: Piping folder (to be commonly used with knit materials) M076: Ready-made piping folder  
Diameter of gimp: To use a gimp whose diameter is greater than 2 to 2.5mm the machine will be made to order.

	MO-3904E-0F6-330 /M075, M076	L ~ M	1	3	-	4.8	3	4	1:0.7 ~ 1:2	5	DC x 27 #11	7,000	
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- **For gathering and piping** M077: Piping folder for gathering

	MO-3904E-0F6-3B0 /S160, S162/M077	L ~ M	1	3	-	4.8	3	3.2	1:0.9 ~ 1:2.6	5	DC x 27 #11	7,000	
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- **For tape attaching** G40: Tape attaching presser foot Q141: Tape guide

	MO-3904E-0F6-340 /G40/Q141	L ~ M	1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-3904E-0F6-44H /G40/Q141	M ~ H	1	3	-	4.8	3	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,000	For knits extra high throw type

- **For upturn felling** K006: Upturn feller

	MO-3905E-0F5-3C0 /K006	L ~ M	1	3	-	4.8	1	4	1:0.7 ~ 1:2	6	DC x 27 #14	7,000	
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- 2-needle overlock

- **For runstitching in general fabric**

	MO-3914E-XB5-100	EL ~ L	2	4	1.2	2.0	1	4	1:0.7 ~ 1:2	5	DC x C47 #9	9,000	For sewing tip and crotch of panty hoses
	MO-3914E-AD4-307	L ~ M	2	4	1.6	3.2	2	4	1:0.7 ~ 1:2	6	DC x 3 #11	8,000	Upper looper high throw type
	MO-3914E-B 4-307		2	4	2.0	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	
	MO-3914E-B 6-307		2	4	2.0	3.2, 4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	
	MO-3914E-B 6-40H		M ~ H	2	4	2.0	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #14	
	MO-3914E-C 6-40H	2		4	2.4	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #14	7,500	
	MO-3914E-DF6-50G	2		4	3.2	4.8	3	4	1:0.7 ~ 1:2	7	DC x 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 x 27 #14	7,500	For imitation safety-stitching

- **For gathering** S160: Swing-type gathering device (interlocked with pedal) S162: Swing-type gathering device (manual-lever operated)

	MO-3914E-B 6-327 /S160, S162	L ~ M	2	4	2.0	3.2, 4.0, 4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC x 27 #11	7,000	Upper looper high throw type
	MO-3912E-DF6-327 /S160, S162		2	4	3.2	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC x 27 #11	7,000	

- **For piping** M075: Piping folder (to be commonly used with knit materials) M076: Ready-made piping folder  
Diameter of gimp: To use a gimp whose diameter is greater than 2 to 2.5mm the machine will be made to order.

	MO-3914E-B 4-337 /M075, M076	L ~ M	2	4	2.0	3.2, 4.0	2	4	1:0.7 ~ 1:2	5	DC x 27 #11	7,000	Upper looper high throw type
	MO-3914E-B 6-337 /M075, M076		2	4	2.0	3.2, 4.0	3	4	1:0.7 ~ 1:2	5	DC x 27 #11	7,000	

- **For gathering and piping** M077: Piping folder for gathering.

	MO-3914E-BD6-3B7 /S160, S162/M077	L ~ M	2	4	2.0	3.2	3	3.2	1:0.9 ~ 1:2.6	5	DC x 27 #11	7,000	Upper looper high throw type
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														Remarks
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● For tape attaching G39, G02, G20: Tape attaching presser foot Q141: Tape guide

	MO-3914E-BD6-347 /G20/Q141	L ~ M	2	4	2.0	3.2	3	3.2	1:0.9 ~ 1:2.6	7	DC x 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 x 27 #11	7,000	
	MO-3914E-B 6-44H /G39/Q141	M ~ H	2	4	2.0	3.2, 4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,000	Upper looper extra high throw type
	MO-3914E-B 7-44H /G02/Q141		2	4	2.0	3.2, 4.0	4	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,000	
	MO-3914E-CE7-44H /G02/Q141		2	4	2.4	4.0	4	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,000	
	MO-3914E-B 6-40K/F /G20/Q141	L ~ H	2	4	2.0	3.2, 4.0	3	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,500	
	MO-3914E-B 6-40K/F /G39/Q141		2	4	2.0	3.2, 4.0, 4.8	3	3.2	1:0.9 ~ 1:2.6	7	DC x 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 x 27 #14	7,000	

■ Safety stitching

● For runstitching in general fabric

	MO-3915E-DE4-300	L ~ M	2	4	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	
	MO-3915E-FF6-300		2	4	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	
	MO-3916E-AE4-300		2	5	1.6	4.0	2	4	1:0.7 ~ 1:2	7	DC x 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 x 27 #11	8,000	
	MO-3916E-CE4-300		2	5	2.4	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	
	MO-3916E-D 4-300		2	5	3.2	3.2, 4.0, 4.8	2	4	1:0.7 ~ 1:2	7	DC x 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 x 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 x 27 #11	8,000	
	MO-3916E-FF6-300		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 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 x 27 #11	7,500	Upper looper extra high throw type
	MO-3916E-D 6-500	M ~ H	2	5	3.2	3.2, 4.8, 6.4	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	8,000	
	MO-3916E-F 6-500		2	5	4.8	4.8, 6.4	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	8,000	
	MO-3916E-DF6-50H		2	5	3.2	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	7,500	Upper looper extra high throw type
	MO-3916E-FF6-50H		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	7,500	
	MO-3916E-RH6-50H	2	5	6.8	6.4	3	4	1:0.7 ~ 1:2	7	DC x 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 x 27 #16	7,500	For jeans
	MO-3916B-D 4-300	L ~ M	2	5	3.2	3.2, 4.0, 4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	For soft-chains
	MO-3916B-D 6-300		2	5	3.2	3.2, 4.0, 4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	
	MO-3916B-FF6-300		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	
	MO-3916E-D 4-300 /G12		2	5	3.2	3.2, 4.0	2	4	1:0.7 ~ 1:2	6	DC x 27 #11	8,000	For sewing sharp curves
MO-3916E-FF6-300 /G13	2		5	4.8	4.8	3	4	1:0.7 ~ 1:2	6	DC x 27 #11	8,000		
MO-3916E-D 4-40K/F	2		5	3.2	3.2, 4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,500	Upper looper extra high throw type	
MO-3916E-FF6-50K/F /F26/G09	M ~ H	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	6	DC x 27 #16	7,500		
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 x 27 #21	7,000	Extra high throw type For jeans	

● For gathering S159: Swing-type gathering device (interlocked with pedal) S161: Swing-type gathering device (manual-lever operated)

	MO-3916E-D 4-320 /S159, S161	L ~ M	2	5	3.2	3.2, 4.0	2	3.2	1:0.9 ~ 1:2.6	6	DC x 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 x 27 #11	7,000	
	MO-3916E-FF6-320 /S159, S161		2	5	4.8	4.8	3	3.2	1:0.9 ~ 1:2.6	6	DC x 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 x 27 #14	7,000	Upper looper extra high throw type
	MO-3916E-RH6-42H /S159, S161		2	5	6.8	6.4	3	3.2	1:0.9 ~ 1:2.6	5	DC x 27 #14	7,000	

															Remarks
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● **For piping** M075: Piping folder (to be commonly used with knit materials) M076: Ready-made piping folder  
 Diameter of gimp: To use a gimp whose diameter is greater than 2 to 2.5mm the machine.

	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 x 27 #11	7,000	
	MO-3916E-FF6-330 /M075, M076		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	5	DC x 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 x 27 #11	7,000	
	MO-3916E-FF6-3B0 /S159, S161/M077		2	5	4.8	4.8	3	3.2	1:0.9 ~ 1:2.6	5	DC x 27 #11	7,000	

● **For rolling-in tape** N067D: Binder for attaching reinforcement tape

	MO-3916E-DD4-360 /N067	L ~ M	2	5	3.2	3.2	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	For rolling in reinforcement tapes
	MO-3916E-FF6-360 /N067D		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-3945E-DD4-360 /N077		2	5	3.2	3.2	2	4	1:0.7 ~ 1:1	5	DC x 27 #11	7,000	2-needle type for double-chainstitch on pocket bags
	MO-3945E-ED4-360 /N077		2	5	4.0	3.2	2	4	1:0.7 ~ 1:1	5	DC x 27 #11	7,000	

■ 3-needle safety stitching

● **For runstitching in general fabric** Q141: Tape guide

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

## WHEN YOU PLACE ORDERS

(Note) Some combinations are not available.

Needle gauge (mm)	Code	Overedging width (mm)	Code	Material	Code	Application	Code	Special machine	Code
1-needle	0	1.6	A	For extra light- to light-weight materials	1	For runstitching	0	Standard	0
0.8	Z	2.0	B	For light- to medium-weight materials	2	For blind hemming	1	Throat plate and feed dog both provided with a lip	6
1.2	X	2.4	C			Training wear, knit, etc.	For gathering	2	Upper looper high throw type
1.6	A	3.2	D	For medium- to heavy-weight materials	3	For piping	3	Commonly used for blind hemming and runstitching	B
2.0	B	4.0	E			Standard (for dress skirts to sport wear)	For attaching tape	4	Upper looper high throw type commonly used for blind hemming and runstitching
2.4	C	4.8	F	For extra heavy-weight materials	4	For binding	5	Adjustable overedging width (by replacing throat plate)	E
3.2	D	5.6	G			Knit sweater, bulky etc.	For binding tape	6	For swim suits
4.0	E	6.4	H	For extra heavy-weight materials	5	For piping & gathering	B	Upper looper extra high throw type	H
4.8	F	8.0	K			Standard (general fabrics, jeans etc.)			JUKI Hong Kong spec. (upper looper extra high throw type)
6.8	R			Jeans etc.	6				
2.0 + 2.0	B.B								
3.2 + 2.0	D.B								
4.8 + 2.0	F.B								

Subclass Code  
**MO-3914 E-BD6-347/ F/G39/Q141/T039**

Stitch type in the U.S.A.	Code
501	01
502	02
503	03
504	04
505	05
506	06
507	07
512	12
514	14
515	15
516	16
540	40
3-needle safety stitch	43
2-needle double chain stitch	45

Special specification	Code
General spec.	E
Soft chain	B
Soft chain, Schiesser type	S

Feed dog	Code
1-row	5
2-row	4
3-row	6
4-row	7

Gauges		
Classification	Parts	Symbol
Upper knife *	Square knife	K
	Flat knife	F
	Corrugated square knife	W
Replacement gauge	Throat plate	E01 ~
	Feed dog	F01 ~
	Presser foot	G01 ~
	Looper	H01 ~

Device & attachment

\* 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.

# DEVICES AND ATTACHMENTS

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

Model	Part No.	Description	Feature	Application		
				MO-3600	MO-3700	MO-3900

### ● Chain-off thread trimming device

T039	MAT-039001A0	One-touch type tape cutter and chain-off thread trimming device (electromagnetic type)	For 110, 115, 220, 240V					
	MAT-039002A0		For 220, 380, 415, 440V					
T040	MAT-040001A0	Automatic tape cutter and chain-off thread trimming device (number-off-stitch control and electromagnetic type)	For semi-sunken type	For 110, 115, 220, 240V				
	MAT-040002A0			For 220, 380, 415, 440V				
	MAT-040001AA		For fully-sunken type	For 110, 115, 220, 240V				
	MAT-040002AA			For 220, 380, 415, 440V				
T041	MAT-041000A0A	Pneumatic flat cutter						
T042	MAT-042000A0	Pneumatic side cutter						
T047	MAT-047000A0	Pneumatic flat cutter						

### ● 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 (pedal type)					
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 (operated by pedal)					
AK52	GAK-520000A0	Pneumatic type (with chain-off thread suction device)					
AK65	GAK-650000A0	Electromagnetic type					
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	Autolifter 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)
		MC-9	(MC-9 is equipped with an auto-lifter)
T040	+	MC-7A	AK32 (any motor will do) AK65 (with an electronic-stop motor or AC servomotor)
		MC-5	AK32 (any motor will do)
		MC-24	AK32 (any motor will do)
T041 or T042	+	*	AK52 (any motor will do)
		MC-4	AK65 (with an electronic-stop motor or AC servomotor)
		MC-7A · MC-8	AK65 (with an electronic-stop motor or AC servomotor)
		MC-9	(MC-9 is equipped with an auto-lifter)

\* AK52 is equipped with a chain-off thread suction device.

### ● Garthering device

S159	MAS-159000A0	Swing-type gathering device (interlocked with pedal/S159 is used with a safety stitch machine)	The attachment opens with the presser foot pedal. This facilitates material setting on the machine. Furthermore, a knee-control type differential-feed adjusting device is built in the attachment. It controls a differential-feed ratio as desired, thereby enabling the operator to make beautiful gathers.			
S160	MAS-160000A0	Swing-type gathering device (interlocked with pedal/S160 is used with an overlock machine)				
S161	MAS-161000A0	Swing-type gathering device (lever-operated/S161 is used with a safety stitch machine)	The attachment is used to perform two different processes, joining fabric process and gathering process, at a time. The attachment can be opened/closed by using the lever (manually operated). The differential-feed ratio is controlled with the knee lever.			
S162	MAS-162000A0	Swing-type gathering device (lever-operated/S162 is used with an overlock machine)				

Model	Part No.	Description	Feature	Application		
				MO-3600	MO-3700	MO-3900

### ● Blind hemming device

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

### ● 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)					
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	Backlatch 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 releasing device (for 1-needle overlock machine with needle thread 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	Needle cooler (for overlock machine)	Needle cooler By silicon oil lubricating unit for the needle tip.				S	
	118-56051	Needle cooler (for safety stitch machine)						
	121-47203	Cloth waste cover (for overlock machine)						
	121-47302	Cloth waste cover (for overlock machine, overedging width 8mm over)						
	121-03305	SS-7091410SP						121-02950
	121-03511	SS-6111440SP						121-03107
	118-02402	NS-6110420SP						118-02006
	SS-7110710SP × 2	121-02810						
	121-38400	121-38301	SM-4040855SP	Needle thread heat remover			S	
	121-38152	TA-0950806R0		By silicon oil lubricating unit for the needle thread.				

S: Provided as standard

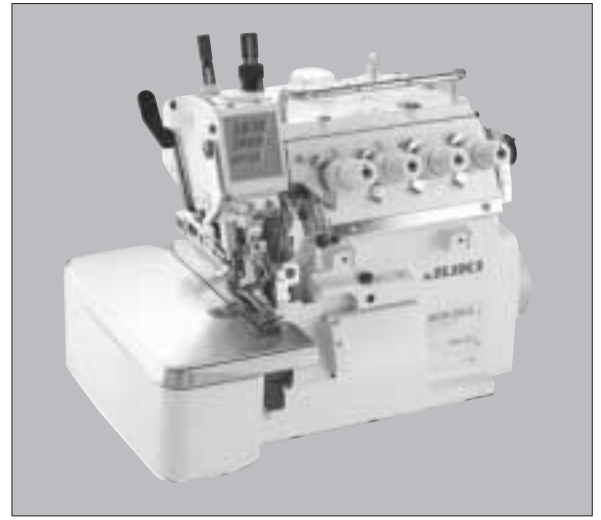
### ● Cloth puller

V058A		Electromagnetic cloth puller (top and bottom roller type)	For table top type				
V058B			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	514	516
Feed system	Variable top-feed (rake-in type)		
Max. sewing speed	Longitudinal stroke of top-feed is 6mm or less: 7,000rpm		
	Longitudinal stroke of top-feed is 6mm to 8.5mm: 6,000rpm		
Stitch length	0.8 ~ 4mm (for special type machine, stitch length 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 gathering 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 x 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 New Defrix Oil No.2 (equivalent to ISO VG32)		
Needle cooler	Provided as standard: By silicon oil lubricating unit for the needle tip		
Needle thread heat remover	Provided as standard: By silicon oil lubricating unit for the needle thread		




# SUBCLASS MACHINE LIST

 Seams	 Model No.	 Materials *	 Number of needles	 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)	 Needle system	 Max. sewing speed (rpm)	Remarks
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\* EL = Extra light-weight materials      H = Heavy-weight materials  
 L = Light-weight materials                EH = Extra heavy-weight materials  
 M = Medium-weight materials


■ 1-needle overlock

● For runstitching in general fabric

	MOR-3904E-0D4-300	L ~ M	1	3	-	3.2	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #11	7,000	
	MOR-3904E-0E4-300		1	3	-	4.0	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #11	7,000	
	MOR-3904E-0F4-300		1	3	-	4.8	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #11	7,000	
	MOR-3904B-0D4-306		1	3	-	3.2	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 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 x 27 #11	7,000	
	MOR-3904E-0E6-300		1	3	-	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #11	7,000	
	MOR-3904E-0F6-300	1	3	-	4.8	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #11	7,000		
	MOR-3904E-0F6-500	M ~ H	1	3	-	4.8	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #14	7,000	
	MOR-3904E-0G6-500		1	3	-	5.6	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #14	7,000	
	MOR-3904E-0H6-500		1	3	-	6.4	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #14	7,000	
	MOR-3904E-0H4-50M		1	3	-	6.4	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #14	7,000	For zipper attaching


● For blind hemming

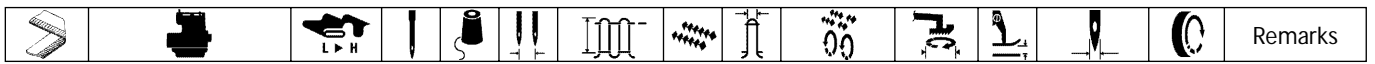
★L121: Blind stitch hemming attachment    ★L122: Blind stitch hemming attachment (with automatic preventer of stitch deviation)

	MOR-3905E-0D4-210 /L121	L ~ M	1	3	-	3.2	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #9	7,000	
	MOR-3905E-0E4-210 /L121		1	3	-	4.0	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #9	7,000	
	MOR-3905E-0D4-210 /L122		1	3	-	3.2	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 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 x 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 x 27 #11	6,000	
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■ 2-needle overlock

● For runstitching in general fabric

	MOR-3914E-BD4-307	L ~ M	2	4	2.0	3.2	2	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC x 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 x 27 #11	7,000	
	MOR-3914E-BD6-307		2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC x 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 x 27 #11	7,000	
	MOR-3914E-BD6-40H	M ~ H	2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC x 27 #11	7,000	Upper looper extra high throw type
	MOR-3914E-BE6-40H		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC x 27 #11	7,000	
	MOR-3914E-BF6-40H		2	4	2.0	4.8	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC x 27 #11	7,000	
	MOR-3914E-CE6-40H		2	4	2.4	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC x 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 x 27 #11	6,000	
	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 x 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 x 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 x 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 x 27 #11	7,000	
	MOR-3914E-BE6-347 /L01/Q141		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC x 27 #11	7,000	
	MOR-3914E-BE6-44H /L01/Q141	M ~ H	2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC x 27 #14	7,000	Upper looper extra high throw type
	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 x 27 #14	7,000	
	MOR-3914E-BD7-44H /L07/Q141		2	4	2.0	3.2	4	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC x 27 #14	7,000	
	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 x 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 x 27 #14	7,000	

															Remarks
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■ Safety stitching

● For runstitching in general fabric

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

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

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

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

	MOR-3916E-DD4-330 /M075	L ~ M	2	5	3.2	3.2	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 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 x 27 #11	7,000	
	MOR-3916E-DE6-330 /M075		2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 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 x 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 x 27 #11	7,000	

■ 3-needle safety stitching

● Multi-purpose runstitching

	MOR-3943E-DBD6-307	L ~ M	3	6	3.2 +2.0	3.2	3	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 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 x 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 x 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 x 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 x 27 #11	7,000	

## DEVICES AND ATTACHMENTS

3

Model	Part No.	Description	Feature
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### ● Chain-off thread trimming device

T039	MAT-039003A0	One-touch type tape cutter and chain-off thread trimming device (electromagnetic type)	For 110, 115, 220, 240V	
	MAT-039004A0		For 220, 380, 415, 440V	
T040	MAT-040005A0	Automatic tape cutter and chain-off thread trimming device (number-off-stitch control electromagnetic type)	For semi-sunken type	For 110, 115, 220, 240V
	MAT-040006A0			For 220, 380, 415, 440V
	MAT-040005AA		For fully-sunken type	For 110, 115, 220, 240V
	MAT-040006AA			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)	
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### ● Chain-off thread suction device

MC-4		Pneumatic chain-off thread suction device (pedal type)	
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

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)
T040	+	MC-7A	AK32 (any motor will do) AK65 (with an electronic-stop motor or AC servomotor)
		MC-5	AK32 (any motor will do)
		MC-24	AK32 (any motor will do)
T041 or T045	+	*	AK52 (any motor will do)
		MC-4	AK65 (with an electronic-stop motor or AC servomotor)
		MC-7A • MC-8	AK65 (with an electronic-stop motor or AC servomotor)
		MC-9	(MC-9 is equipped with an auto-lifter)

\* AK52 is equipped with a chain-off thread suction device.

### ● Gathering device

S167	MAS-167000A0	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 blind hemming in knits	
L122	MAL-122001A0	Automatic folded-edge controlled blind hemming device (The attachment automatically detects the overlapped section of a material. Then, it makes the needle enter the material deeper to prevent stitch deviation.)	Flat upper knife	For 110, 115, 220, 240V
	MAL-122002A0			For 220, 380, 415, 440V
	MAL-122001AA		Square upper knife	For 110, 115, 220, 240V
	MAL-122002AA			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
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### ● Piping

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)	This folder is to be used together with upper-cloth gathering device S167.
	MAM-2220J0B0	Piping folder upper-cloth gathering (finished width 9mm. tape width 20mm)	
M224	MAM-2240N0A0	Ready-made piping folder for upper-cloth gathering	

### ● Guide, Ruler

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

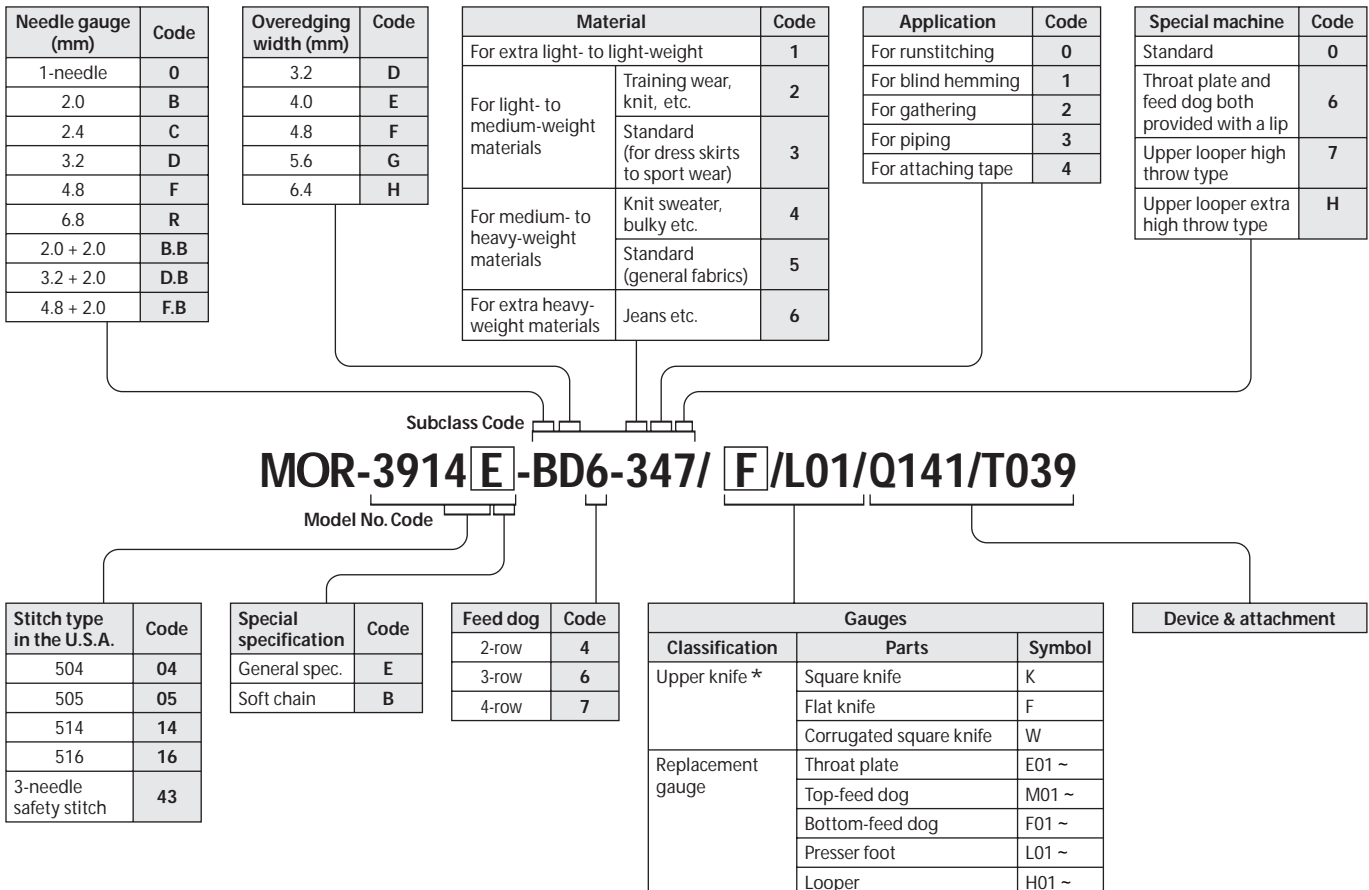
V058A	Electromagnetic cloth puller (top and bottom roller type)	For table top type
V058B		For semi-sunken type
V058C		For fully-sunken type
V068A	Pneumatic cloth puller (top and bottom roller type)	For table top type
V068C		For fully-sunken type

### ● Tape reel

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

## 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.

Super-high-speed, Cylinder-bed, Overlock Machine

## MOC-3900 SERIES

- A small-diameter cylinder 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 fatigue.
- The machines in the MOC-3900 series incorporate 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



MOF-3914

### SPECIFICATIONS

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: 6,000rpm	
Stitch length	0.8 ~ 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, 4.8	
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 x 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		7mm	6.5mm
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	28kg			
Lubrication	Automatic			
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)			
Needle cooler	By silicon oil lubricating unit for the needle tip			
Needle thread heat remover	By silicon oil lubricating unit for the needle thread			

# SUBCLASS MACHINE LIST

Seams	Model No.	Materials	Number of needles	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
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- 1-needle overlock
- For runstitching

For the machine attached with a triangle ( ), the number of kinds of overedging width is two or more.

B - 2.0mm D - 3.2mm E - 4.0mm F - 4.8mm

The total overedging width: Needle gauge + Overedging width

\* L = Light-weight materials M = Medium-weight materials H = Heavy-weight materials

	MOC-3904E-0 4-300	L ~ M	1	3	-	3.2, 4.0	2	3.5	1: 0.8 ~ 1: 2.3	6.5	DC x 27 #11	8,500	Upper looper high throw type
	MOC-3904E-0F4-307		1	3	-	4.8	2	3.5	1: 0.8 ~ 1: 2.3	7	DC x 27 #11	8,000	
	MOC-3904E-0 6-307		1	3	-	3.2, 4.0	3	3.5	1: 0.8 ~ 1: 2.3	7	DC x 27 #11	8,000	
	MOC-3904E-0F6-40H	M ~ H	1	3	-	4.8	3	3.5	1: 0.8 ~ 1: 2.3	7	DC x 27 #11	7,500	Upper looper extra high throw type

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

	MOC-3903E-0 4-210 /L124	L ~ M	1	2	-	3.2, 4.0	2	3.5	1: 0.8 ~ 1: 2.3	5.5	DC x 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 x 27 #9	8,500	
	MOC-3905E-0 4-210 /L124		1	3	-	3.2, 4.0	2	3.5	1: 0.8 ~ 1: 2.3	5.5	DC x 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 x 27 #9	8,500	

- 2-needle overlock
- For runstitching

	MOC-3914E-B 4-307	L ~ M	2	4	2.0	2.0, 3.2, 4.0	2	3.5	1: 0.8 ~ 1: 2.3	7	DC x 27 #11	8,000	Upper looper high throw type
	MOC-3914E-B 6-307		2	4	2.0	3.2, 4.0, 4.8	3	3.5	1: 0.8 ~ 1: 2.3	7	DC x 27 #11	8,000	
	MOC-3914E-CE4-307		2	4	2.4	4.0	2	3.5	1: 0.8 ~ 1: 2.3	7	DC x 27 #11	8,000	
	MOC-3914E-CE6-307		2	4	2.4	4.0	3	3.5	1: 0.8 ~ 1: 2.3	7	DC x 27 #11	8,000	
	MOC-3914E-B 6-40H	M ~ H	2	4	2.0	3.2, 4.0, 4.8	3	3.5	1: 0.8 ~ 1: 2.3	7	DC x 27 #11	7,500	Upper looper extra high throw type
	MOC-3914E-C 6-40H		2	4	2.4	4.0, 4.8	3	3.5	1: 0.8 ~ 1: 2.3	7	DC x 27 #11	7,500	

## WHEN YOU PLACE ORDERS

(Note) Some combinations are not available.

Needle gauge (mm)	Code	Overedging width (mm)	Code	Material	Code	Application	Code	Special machine	Code
1-needle	0	2.0	B	For light- to medium-weight materials	2	For runstitching	0	Standard	0
2.0	B	3.2	D		3	For blind hemming	1	Upper looper high throw type	7
2.4	C	4.0	E	For medium- to heavy-weight materials	4			Upper looper extra high throw type	H
		4.8	F						

Subclass Code

## MOC-3904E-0E6-307/ F /P02/Q01/T043/SY35

Model No. Code

Stitch type in the U.S.A.	Code	Special specification	Code	Feed dog	Code	Device & attachment
504	04	General spec.	E	2-row	4	
505	05			3-row	6	
514	14					

Gauges		
Classification	Parts	Symbol
Upper knife *	Square knife	K
	Flat knife	F
	Corrugated square knife	W
Replacement gauge	Throat plate	P01 ~
	Feed dog	Q01

Built-in synchronizer	
Maximum sewing speed of the machine head	Code
8,000rpm	SY35

Note 1: Be sure to specify the built-in synchronizer when the newly-developed servomotor is used with each machine.

Note 2: When the built-in synchronizer is installed on the machine, the maximum sewing speed will be obtained by subtracting 500 s.p.m. from the maximum sewing speed of the machine head shown in the table above.

\* 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.

# SUBCLASS MACHINE LIST

Seams	Model No.	Materials * L ~ H	Number of needles	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)	Needle system	Max. sewing speed (rpm)	Remarks
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■ 1-needle overlock

● For runstitching

● The total overedging width:  
Needle gauge + Overedging width

\* L = Light-weight materials  
M = Medium-weight materials  
H = Heavy-weight materials

	MOF-3904E-0E4-300	L ~ H	1	3	-	4.0	2	3.5	1:0.8 ~ 1:2.3	1 ~ 7.5	7	DC x 27 #11	7,000	Upper looper high throw type
	MOF-3904E-0F4-307		1	3	-	4.8	2	3.5	1:0.8 ~ 1:2.3	1 ~ 7.5	7	DC x 27 #11	7,000	
	MOF-3904E-0D6-307		1	3	-	3.2	3	3.5	1:0.8 ~ 1:2.3	1 ~ 7.5	7	DC x 27 #11	7,000	
	MOF-3904E-0E6-307		1	3	-	4.0	3	3.5	1:0.8 ~ 1:2.3	1 ~ 7.5	7	DC x 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 x 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	L ~ M	1	3	-	3.2	2	3.5	1:0.8 ~ 1:2.3	1 ~ 7.5	7	DC x 27 #9	7,000	
	MOF-3905E-0D4-210 /L125		1	3	-	3.2	2	3.5	1:0.8 ~ 1:2.3	1 ~ 7.5	7	DC x 27 #9	7,000	
	MOF-3905E-0E4-210 /L124		1	3	-	4.0	2	3.5	1:0.8 ~ 1:2.3	1 ~ 7.5	7	DC x 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 x 27 #9	7,000	

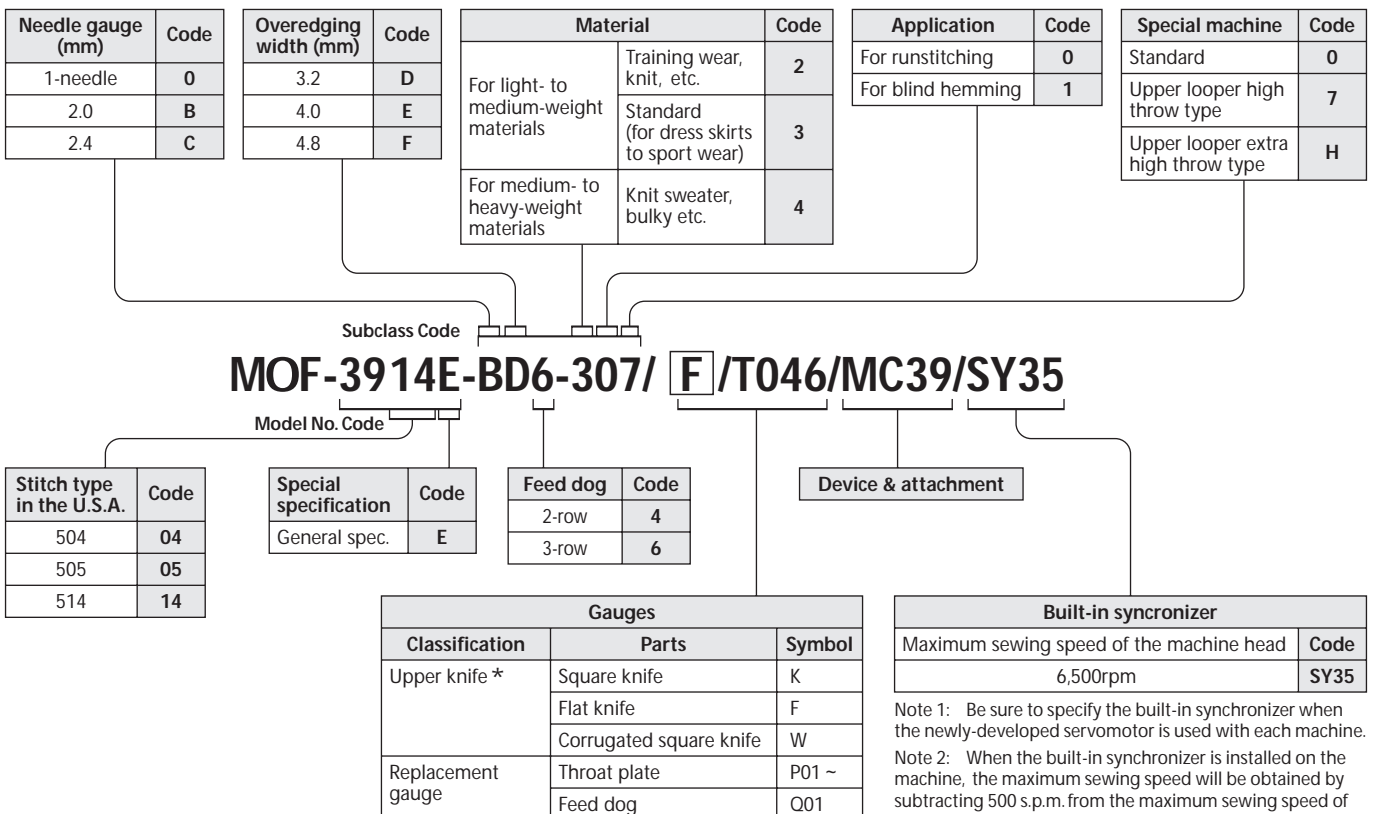
■ 2-needle overlock

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

Note 1: Be sure to specify the built-in synchronizer when the newly-developed servomotor is used with each machine.

Note 2: When the built-in synchronizer is installed on the machine, the maximum sewing speed will be obtained by subtracting 500 s.p.m. from the maximum sewing speed of the machine head shown in the table above.



## DEVICES AND ATTACHMENTS

### MOC-3900, MOF-3900 SERIES

Model	Part No.	Description	Feature	Application	
				MOC-3900	MOF-3900

#### ● 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			
L125	MAL-125001A0	Automatic folded-edge controlled blind hemming device (The attachment automatically detects the overlapped section of a material. Then, it makes the needle enter the material deeper to prevent stitch deviation.)	Flate upper knife	For 110, 115, 220, 240V	
	MAL-125002A0			For 220, 380, 415, 440V	
	MAL-125001AA		Square upper knife	For 110, 115, 220, 240V	
	MAL-125002AA			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		Electromagnetic cloth puller (top and bottom roller type)	For table top type		
V058B			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		

#### ● Tape reel

V059	MAV-059000AA	Tension-free feeder			
R001	MAR-001000A0	Tape reel			
R002	MAR-002010A0				
R006	MAR-006010A0				
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

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 x 5	GROZ-BECKERT 142 x 5	GROZ-BECKERT 142 x 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 VG32)		
Needle cooler	Optional: By silicon oil lubricating unit for the needle tip		
Needle thread heat remover	Optional: By silicon oil lubricating unit for the needle thread		

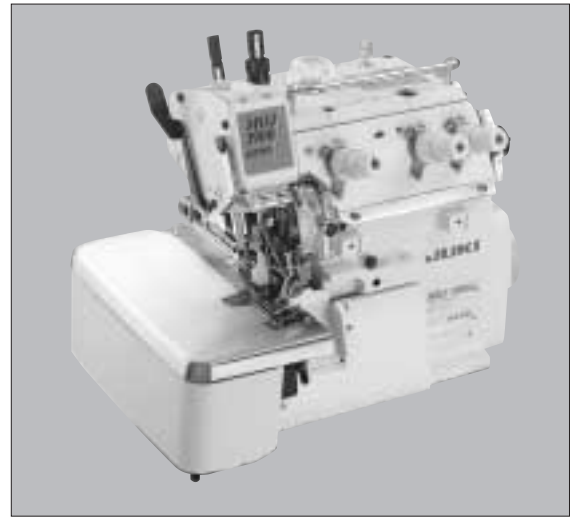
### SUBCLASS MACHINE LIST

Seams	Model No.	Number of needles	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-ON6-3D1	1	2	-	20	3	5	1:3.8 ~ 1:0.6	5	Groz 142 x 5 #100	5,500	For splicing fabrics
	MOG-3704E-OF6-600	1	3	-	4.8	3	5	1:3.8 ~ 1:0.6	8	Groz 142 x 5 #130	6,000	For runstitching extra heavy-weight materials such as denim and drill.
	MOG-3704E-OM6-600	1	3	-	10	3	5	1:3.8 ~ 1:0.6	8	Groz 142 x 5 #130	5,500	For serging extra heavy-weight materials such as denim and drill.
	MOG-3705E-OM6-700	1	3	-	10	3	5	1:3.8 ~ 1:0.6	7	Organ DC x 1 #24	4,500	For overedging carpets, mats for entrance halls, etc.
	MOG-3705E-OM6-7E0	1	3	-	10	3	5	1:3.8 ~ 1:0.6	7	Organ DC x 1 #24	4,500	For overedging car mats.
	MOG-3714E-CH6-600	2	4	2.6	6.4	3	4	1:3.8 ~ 1:0.6	8	Groz 142 x 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 x 5 #130	6,000	For safety stitching extra heavy-weight materials such as denim and drill.
	MOG-3716E-FH6-700	2	5	4.8	6.4	3	5	1:3.8 ~ 1:0.6	8	Groz 142 x 5 #130	6,000	
	MOG-3716E-FM6-700	2	5	4.8	10	3	5	1:3.8 ~ 1:0.6	8	Groz 142 x 5 #130	4,500	

**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	Longitudinal stroke of top-feed is 6mm or less : 6,000rpm		
	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 x 5 (#130)	GROZ-BECKERT 142 x 5 (#110)	GROZ-BECKERT 142 x 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 VG32)		
Needle cooler	By silicon oil lubricating unit for the needle tip		
Needle thread heat remover	By silicon oil lubricating unit for the needle thread		

**SUBCLASS MACHINE LIST**

Seams	Model No.	Number of needles	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)	Needle 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 x 5 #130	6,000	For runstitching extra heavy-weight materials such as denim and drill.
	MOJ-3914E-CH6-600	2	4	2.6	6.4	3	4	1:3.8 ~ 1:0.6	8	1 ~ 8.5	Groz 142 x 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 x 5 #130	6,000	For safety stitching extra heavy-weight materials such as denim and drill.
	MOJ-3916E-FH6-700	2	5	4.8	6.4	3	5	1:3.8 ~ 1:0.6	8	1 ~ 8.5	Groz 142 x 5 #130	6,000	
	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 x 5 #130	6,000	

## DEVICES AND ATTACHMENTS

### MOG-3700 SERIES, MOJ-3900 SERIES

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

#### ● Chain-off thread trimming device

T039	MAT-039001A0	One-touch type tape cutter and chain-off thread trimming device (electromagnetic type)	For 110, 115, 220, 240V		
	MAT-039002A0		For 220, 380, 415, 440V		
T040	MAT-040001A0	Automatic tape cutter and chain-off thread trimming device (number-off-stitch control and electromagnetic type)	For semi-sunken type	For 110, 115, 220, 240V	
	MAT-040002A0		For fully-sunken type	For 220, 380, 415, 440V	
	MAT-040001AA		For 110, 115, 220, 240V		
	MAT-040002AA		For 220, 380, 415, 440V		
T048	MAT-048010A0	Pneumatic flat cutter (for overlock stitch machine)			
	MAT-040010B0				
T050	MAT-050010A0	Pneumatic flat cutter (for safety stitch machine)			
	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	+	MC-7A • MC-8	AK25
		MC-9	
T040	+	MC-5 • MC-24	AK32
T048 or T050	+	MC-4	AK52
		MC-7A • MC-8	AK25
		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**

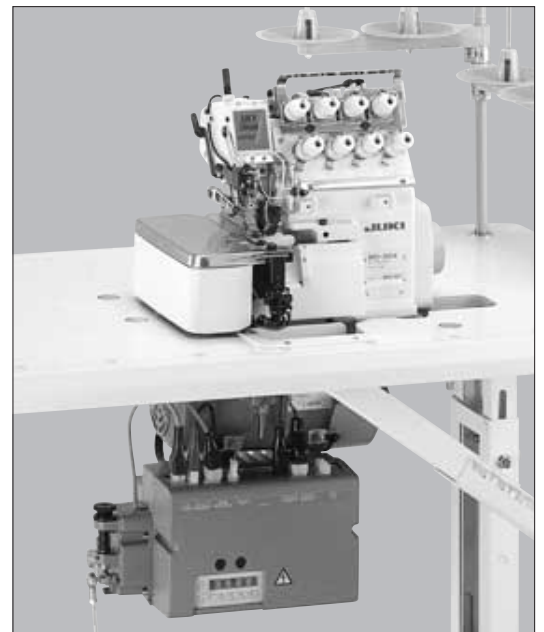
(1-Needle)

**MOR-3904E-0E6-300/LB-1**

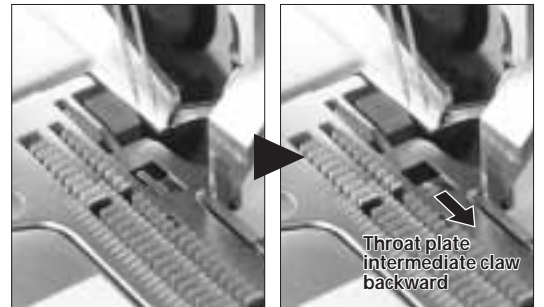
(2-Needle)

**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**

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

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

**WHEN YOU PLACE ORDERS**

● **Overlock Machine**

(1-NEEDLE) **MO-3**  **04E-0E6-300/LB-1**

Model	Code
MO-3604E	6
MO-3704E	7
MO-3904E	9

(2-NEEDLE) **MO-3**  **14E-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** **SC-380-**   **-00000**

PSC box			Code
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

● **Motor for SC**

**M**

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

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

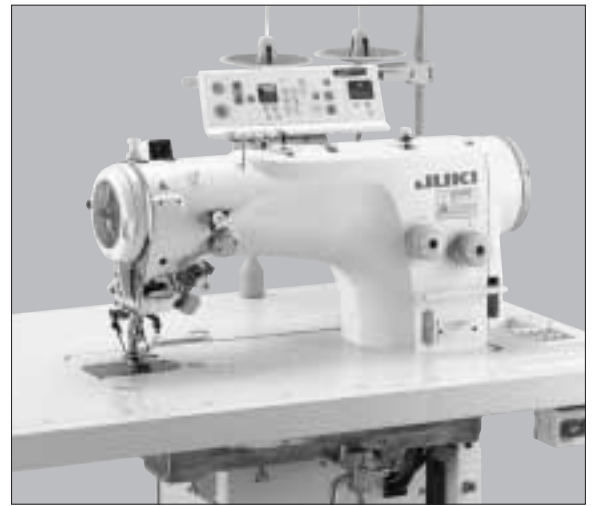
Computer-controlled, Direct-drive, High-speed, 1-needle, Lockstitch, Zigzag Stitching Machine

## LZ-2290SS

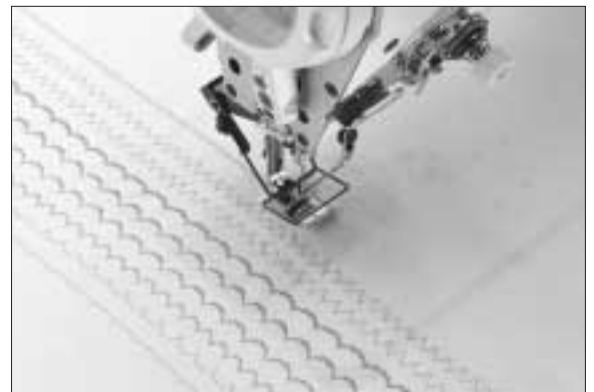
**LZ-2290SS-7** (with an automatic thread trimmer)

**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



## SPECIFICATIONS

Model name	LZ-2290SS	LZ-2290SS-0B	LZ-2290SS-7	LZ-2290SU-7
		Standard		
Max. sewing speed	5,000rpm			4,500rpm
	(for standard zigzag stitching, the zigzag width has to be set to 4mm or less)			
Max. zigzag width	Standard zigzag: 8mm/ 2-step, 3-step zigzag: 10mm (in increments 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 titanium-treated inner hook)			
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 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 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	98kg		100kg	

## WHEN YOU PLACE ORDERS

### Without an automatic thread trimmer

**LZ-2290SS-**

Machine head type	Code	Push-button-type reverse feed switch	Code
Standard	S	Not provided	/
		Provided	OB

Application	Code
Standard	S

### With an automatic thread trimmer

**LZ-2290S**  -7-  **B**

Machine head type	Code	Wiper	Code	Device/attachment	Code
Standard	S	Not provided	0	With no device/attachment	/
		Provided	W	Auto-lifter (pedal-driven)	AK121

Application	Code
Standard	S
Anti-material-slip type	U

### PSC box/control panel

**SC905-**   **S-760**

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

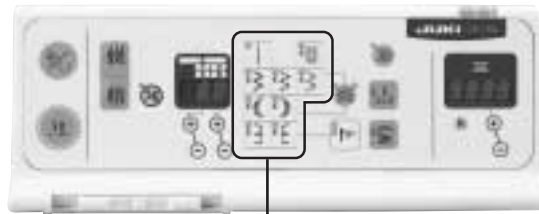
\* JUS: North America and Central and South America.



AK121

## 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

Name of pattern	Straight stitch	Standard zigzag	2-step zigzag	3-step zigzag	Scallop (left)				Scallop (right)				Blind stitch (left)	Blind stitch (right)	Custom pattern	
					Standard	Crescent	Equal-width	Equal-width	Standard	Crescent	Equal-width	Equal-width				
Stitch pattern																
Number of stitches		2	4	6	24				12	24				12	2 + α	Max. 64
Pattern selection key																

## OPTIONS

Model	Part No.	Description	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	The aforementioned parts are used when a lockstitching type presser foot is installed on the machine.
	D1502-583-H00	Presser connecting rod	
	SS-7091110-SP	Screw	
	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 consistent stitch formation.
	235-22550	Bobbin case asm.	
	235-23004	Bobbin	
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	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 productivity without interrupting the sewing work.
S189B	MAS-189000AB		

# LIST OF THE MAJOR GAUGES

Max. zigzag width/ Max. feed pitch	Throat plate	Feed dog	Presser foot (with finger guard)	Remarks
	100-41010 	100-47017 1.6 Max. feed amount: 2mm	With a recess on the reverse side of the presser foot 225-80369 	
	100-41101 	225-80104 1.6 Max. feed amount: 2mm	225-80260 Light-in-weight type 	
	225-80005 	225-80500 1.15 Max. feed amount: 2mm	Light-in-weight type with the front fulcrum 225-80765 	<ul style="list-style-type: none"> <li>• Suited to sewing tasks that require frequent changes in the needle throw position.</li> </ul>
	225-82100 	225-82209 1.6 Max. feed amount: 2mm		
	225-82704 	225-82803 1.5 Max. feed amount: 2mm	235-03154 Light-in-weight type 	
	225-82407 	225-81508 1.5 Max. feed amount: 2mm	235-03204 Front fulcrum type 	
	225-82506 	225-48804 1.5 Max. feed amount: 1.3mm	225-80864 	
		225-82506 	225-40009 1.7 Max. feed amount: 5mm	
	225-45008 	225-45107 1.7 Max. feed amount: 2.5mm	225-45362 Light-in-weight type 	
	225-45511 	225-45610 1.15 Max. feed amount: 1.6mm	Light-in-weight type with the front fulcrum 225-45867 	



Max. zigzag width/ Max. feed pitch	Throat plate	Feed dog	Presser foot (with finger guard)	Remarks	
	225-48705 	225-48804  Max. feed amount: 1.3mm	225-48960 Light-in-weight type 		
  	225-48507 	225-48408  Max. feed amount: 2.5mm	225-47962 Light-in-weight type   225-48663 Light-in-weight type 225-48671 (finger guard: small) 	<ul style="list-style-type: none"> <li>• For standard zigzag stitching</li> <li>• The 5mm-feed is suited to tape-attaching process where the elastic tape is sewn with stretched.</li> </ul>	
	225-48010 	225-48119  Max. feed amount: 2.5mm			225-41601  Max. feed amount: 5mm
	225-49000 	225-49109  Max. feed amount: 2.5mm			225-41809  Max. feed amount: 5mm
	225-49208 	225-49307  Max. feed amount: 2.5mm			225-41700  Max. feed amount: 5mm
	225-46519 	225-46717  1.15	225-46618  1.5	225-46964 Light-in-weight type 	
	225-46212 	225-46410  1.15	225-46311  1.5	Light-in-weight type with the front fulcrum 225-47269 	
	MAD-04060000 	MAD-04070000  1.5	MAD-040500A0 	<ul style="list-style-type: none"> <li>• For attaching tape to brassieres, etc.</li> </ul>	
	225-49604 	225-49703  1.15	225-49869 Light-in-weight type 		

• Max. feed is 5mm for the LZ-2290SS. Since the max. feed is 2.5mm for the LZ-2290SU, gauges have to be selected with care.  
• In addition to the above-listed ones, many different gauges and attachments for zigzag stitching are available.  
Please contact us for details.

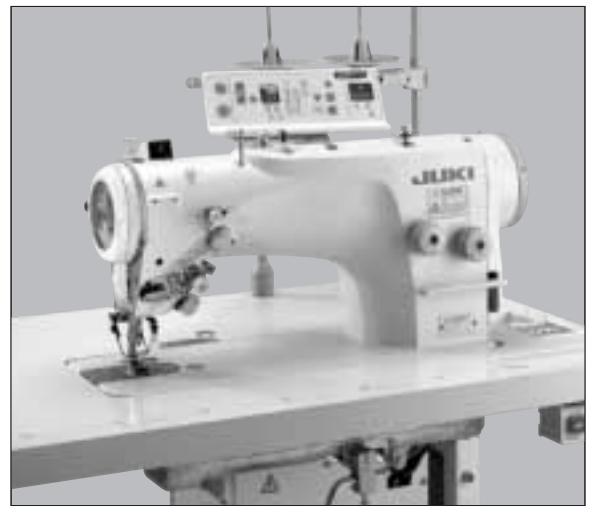
Computer-controlled, Direct-drive, High-speed, 1-needle, Lockstitch, Zigzag Stitching Machine [Dry-head type]

## 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



## SPECIFICATIONS

Model name	LZ-2290DS	LZ-2290DS-0B	LZ-2290DS-7	LZ-2290DU-7
		Standard		
Max. sewing speed	4,000rpm (for standard zigzag stitching, the zigzag width has to be set to 5mm or less)			
Max. zigzag width	Standard zigzag: 8mm/2-step, 3-step zigzag: 10mm (in increments 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 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 x 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	No lubrication			
Distance from needle to machine arm	300mm			
Bed size	517mm x 178mm			
Power requirement and power consumption	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V/Power rating 600VA			
Total weight	98kg		100kg	

## WHEN YOU PLACE ORDERS

### ● Without an automatic thread trimmer

LZ-2290DS-

Machine head type	Code	Push-button-type reverse feed switch	Code
Dry head	D		Not provided
Application		Provided	OB
Standard	S		

### ● With an automatic thread trimmer

LZ-2290D  -7-WB

Machine head type	Code	Wiper	Code	Device/attachment	Code
Dry head	D	Provided	W		With no device/attachment
Application				Auto-lifter (pedal-driven)	AK121
Standard	S				
Anti-material-slip type	U				

### ● PSC box/control panel

SC905-   S-760

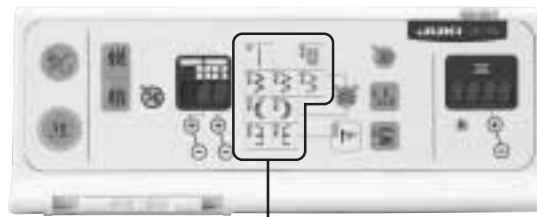
PSC box			Code
For General Export	Single-phase	220V PFL	07
	3-phase	220V PFL	11
For CE	Single-phase	230V PFL	34
For JUS (LA) *	Single-phase	120V PFL	37
	3-phase	220V PFL	38

\* 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.



Operation panel CP-760

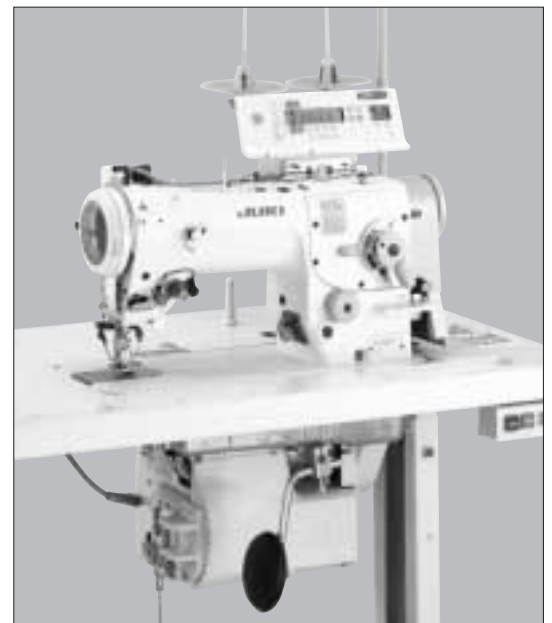
Name of pattern	Straight stitch	Standard zigzag	2-step zigzag	3-step zigzag	Scallop (left)				Scallop (right)				Blind stitch (left)	Blind stitch (right)	Custom pattern
					Standard	Crescent	Equal-width	Equal-width	Standard	Crescent	Equal-width	Equal-width			
Stitch pattern															
Number of stitches		2	4	6	24		12		24		12		2 + α		Max. 64
Pattern selection key															

## OPTIONS

Model	Part No.	Description	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	The aforementioned parts are used when a lockstitching type presser foot is installed on the machine.
	D1502-583-H00	Presser connecting rod	
	SS-7091110-SP	Screw	
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	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 productivity without interrupting the sewing work.
S189B	MAS-189000AB		

## 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

### 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 function and an automatic thread trimmer)

- 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.




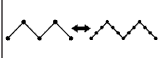


### LZ-2280NU (standard zigzag/with an anti-material-slip capability)

#### 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)



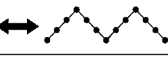
- With its newly developed feed mechanism, the machine prevents "uneven feed of the upper and lower cloths" when sewing girdles and body suits made of slippery, elastic materials.
- Drop-feed sewing machines have been widely said to feed in the lower cloth more quickly than the upper cloth. However,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

## SPECIFICATIONS

Model name	Without an automatic thread trimmer	LZ-2280N	LZ-2281N	LZ-2282N	LZ-2284N	LZ-2286N	LZ-2288N	LZ-2285N
	With an automatic thread trimmer			LZ-2282N-7	LZ-2284N-7			
Stitch system	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						Refer to the specifications for pattern cam		
Max. sewing speed	5,500rpm	5,000rpm						4,000rpm
Max. zigzag width (mm)	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. feeding amount (mm)	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	
Min. cutting allowance of lower knife (mm)			3.0					
Lower knife driving method			AC motor					
Lift of the presser foot (mm)	By hand: 5.5, By knee: 10.0		By hand: 4.0 By knee: 8.5		By hand: 5.5, By knee: 10.0			By hand: 5.5 By knee: 8.0
Hook	DP hook (with a titanium-treated inner hook)							
Thread take-up	Rotary type							
Lubrication	Fully automatic							
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)							
Needle (at the time of delivery)	SCHMETZ 438 (Nm75), ORGAN DP x 5 (#10)							SCHMETZ 438SUK (#80)
Needle position changing mechanism	Provided as standard							
Reverse feed stitching mechanism	Provided as standard							
Needle throw direction change-over mechanism						Provided as standard		
Needle throw pattern cam	Triangular cam				Grooved cam			
Number of pattern cams specified						11 *		

\* LZ-2288N: Selectable from 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 name	Without an automatic thread trimmer	LZ-2280NU	LZ-2284NU
	With an automatic thread trimmer		LZ-2284NU-7
Stitch system			
Max. sewing speed	4,500rpm		

## WHEN YOU PLACE ORDERS

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

LZ-228    -

Type	Code
Standard zigzag	0N
Standard zigzag/with an anti-material-slip capability	0NU
Standard wider zigzag (with a gauge for 5mm zigzag width)	1NA
Standard wider zigzag (with a gauge for 8mm zigzag width)	1NB
Standard zigzag/with a lower knife	2N
With a standard/3-step zigzag stitching pattern changeover function	4N
With a standard/3-step zigzag stitching pattern changeover function and an anti-material-slip capability	4NU
With a standard/3-step zigzag stitching pattern changeover function and with a tape attaching foot capability	4NT
3-step zigzag	6N
3-step zigzag/with a tape attaching foot	6NT
With changeable pattern cams/Standard zigzag	8NA
With changeable pattern cams/3-step zigzag	8NB
With changeable pattern cams/2-step zigzag	8NC
With changeable pattern cams/Standard scalloping	8ND
With changeable pattern cams/Crescent scalloping	8NE
Fagoting	5N

Automatic reverse feed function	Code
Provided	0B
Not provided	

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

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

LZ-228    -7-

Type	Code
Standard zigzag/with a lower knife	2N
With a standard/3-step zigzag stitching pattern changeover function	4N
With a standard/3-step zigzag stitching pattern changeover function and an anti-material-slip capability	4NU

Wiper and automatic reverse feed function		
Wiper	Automatic reverse feed function	Code
Not provided	Not provided	00
	Provided	0B
Provided	Not provided	W0
	Provided	WB

Auto-lifter	Code
Provided (AK83)	AK
Not provided	

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

SC800-   SZ-    B

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

Pulley belt	Code
For zigzag stitching machine	Z

Control panel	Code
CP-60	060
CP-160	160




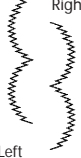


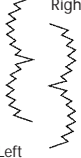
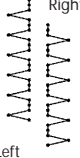
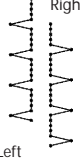
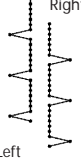
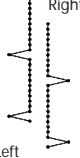
\* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

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

## OPTIONS

Model	Part No.	Description	Feature
	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	The aforementioned parts are used when a lockstitching type presser foot is installed on the machine.
	D1502-583-H00	Presser connecting rod	
	SS-7091110-SP	Screw	
	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 consistent stitch formation.
	235-22550	Bobbin case asm.	
	235-23004	Bobbin	
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	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 productivity without interrupting the sewing work.
S189B	MAS-189000AB		
RF-1		Pedal-operated reverse feed stitching device	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				 Right Left	 Right Left	 Right Left	 Right Left	 Right Left	 Right Left	 Right Left	 Right 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

Max. zigzag width/ Max. feed pitch	Throat plate	Feed dog	Presser foot (with finger guard)	Remarks
	100-41010 	100-47017 1.6 Max. feed amount: 2mm	With a recess on the reverse side of the presser foot 225-80369 	
	100-41101 	225-80104 1.6 Max. feed amount: 2mm	225-80260 Light-in-weight type 	
	225-80005 	225-80500 1.15 Max. feed amount: 2mm	Light-in-weight type with the front fulcrum 225-80765 	
	225-82100 	225-82209 1.6 Max. feed amount: 2mm		
	225-82704 	225-82803 1.5 Max. feed amount: 2mm	235-03154 Light-in-weight type 	
	225-82407 	225-81508 1.5 Max. feed amount: 2mm	235-03204 Front fulcrum type 	
	225-82506 	225-48804 1.5 Max. feed amount: 1.3mm	225-80864 	
	225-82506 	225-40009 1.7 Max. feed amount: 5mm	MAB-109000B0 Max. 15.6 20.6 10.4 1.8 Presser foot with a tape guide	
	225-45008 	225-45107 1.7 Max. feed amount: 2.5mm	225-45362 Light-in-weight type 	
	225-45511 	225-45610 1.15 Max. feed amount: 1.6mm	Light-in-weight type with the front fulcrum 225-45867 	



Max. zigzag width/ Max. feed pitch	Throat plate	Feed dog	Presser foot (with finger guard)	Remarks	
	225-48705 	225-48804  Max. feed amount: 1.3mm	225-48960 Light-in-weight type 		
 	225-48507 	225-48408  Max. feed amount: 2.5mm	225-47962 Light-in-weight type   225-48663 Light-in-weight type 225-48671 (finger guard: small) 	<ul style="list-style-type: none"> <li>• For standard zigzag stitching</li> <li>• The 5mm-feed is suited to tape-attaching process where the elastic tape is sewn with stretched.</li> </ul>	
	225-48010 	225-48119  Max. feed amount: 2.5mm			225-41601  Max. feed amount: 5mm
	225-49000 	225-49109  Max. feed amount: 2.5mm			225-41809  Max. feed amount: 5mm
	225-49208 	225-49307  Max. feed amount: 2.5mm			225-41700  Max. feed amount: 5mm
	225-46519 	225-46717  1.15	225-46618  1.5	225-46964 Light-in-weight type 	
	225-46212 	225-46410  1.15	225-46311  1.5	Light-in-weight type with the front fulcrum 225-47269 	
	MAD-04060000 	MAD-04070000  1.5	MAD-040500A0 	<ul style="list-style-type: none"> <li>• For attaching tape to brassieres, etc.</li> </ul>	
	225-49604 	225-49703  1.15	225-49869 Light-in-weight type 		

• In addition to the above-listed ones, many different gauges and attachments for zigzag stitching are available. Please contact us for details.

## 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

## 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.



LZ-391N

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

### LZ-586

- 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-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)

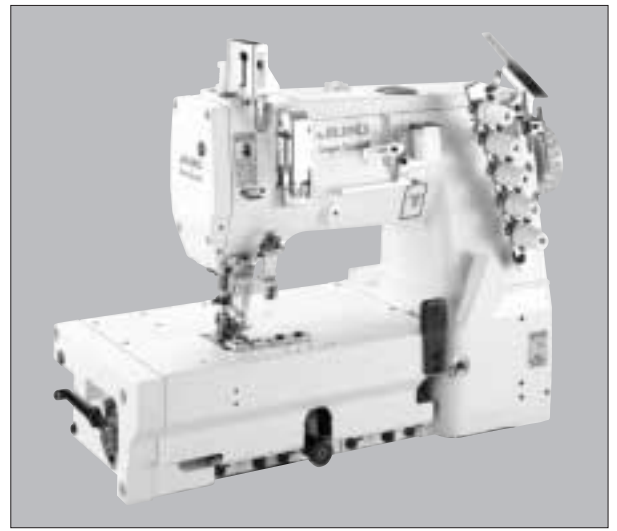
## ATTACHMENTS

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

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## 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	Automatic			
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)			

## WHEN YOU PLACE ORDERS

Stitch type	Code
2-needle bottom covering stitch	406
3-needle bottom covering stitch	407
2-needle top & bottom covering stitch	602
3-needle top & bottom covering stitch	605

Stitch length (mm)			
2-needle	3-needle	Application	Code
1.6 ~ 2.1	1.6 ~ 2.1	Hemmer Lap seam	A
	1.8 ~ 2.5		B
1.8 ~ 3.2	2.5 ~ 3.2	Collarette/Elastic	C
1.6 ~ 3.2	1.6 ~ 2.8		D

Needle gauge (mm)			Code
	2-needle	3-needle	
3.2		×	32
4.0		×	40
4.8			48
5.6			56
6.4			64

MF-7    U-    -    /MD6/TC3

Application	Description of subclass	Code
For universal	Hemming and coverseam (foldingover-overlock seam and flattening out)	U03
	Hemming and coverseam (foldingover-overlock seam and flattening out and collarette) by retrofit kit	U06
For collarette	Basic style. Easy conversion to hem or coverseam	C02
For attaching elastic	Fabric under trimmer	E12
For hemming	Basic style with hem guide	H01
For lap seam	Tandem differential-feed	L01

Device & attachment

## DEVICES AND ATTACHMENTS

Model	Description	Applicable models				Application
		7406	7407	7602	7605	

### ● Elastic tape metering device

MD1	Single stage function top tape metering device Pulse motor type					For E12
MD2	Two stage function top tape metering device Pulse motor type					
MD6	Single stage function top tape metering device Mechanical type					

### ● Elastic tape cutter

TC2	Pneumatic type					Collarette/Elastic
TC3	Electromagnetic type					
TC4	Pneumatic type (fast-action type)					

### ● Chain cutter

CC1	Pneumatic type chain-off thread cutter (mounted horizontal venturi suction)					
-----	--	--	--	--	--	--

### ● Thread trimming device

UT12	Pneumatic type (mechanical wiper + auto-lifter)					
UT13	Pneumatic type (top and bottom thread trimmer + auto-lifter)					

### ● Cloth puller

PL5						
-----	--	--	--	--	--	--



MD1



TC4



UT13

## 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

### C02 ⇒ U06

Kit No.: 29480FC02U06J

+

Sewing parts			
Parts name	Parts No.		
Needle gauge	5.6mm	6.4mm	
Needle clamp	50318AM56	50318AM64	
Presser foot	50320CD56		
Differential-feed dog	50326BP	50326BW	
Main feed dog	50305BW	50305CB	
Throat plate	50324DF56	50324DF64	










### U06 ⇒ C02

Kit No.: 29480FU06C02J

+

Sewing parts					
Parts name	Parts No.				
Needle gauge	4.0 mm	4.8 mm	5.6 mm	6.4 mm	
Needle clamp	50318AM40	50318AM48	50318AM56	50318AM64	
Presser foot	50320CB40	50320CB48	50320CB56		
Differential-feed dog	50326BV		50326BT		
Main feed dog	50305BZ		50305BX		
Throat plate	50324AU40	50324AU48	50324AU56	50324AU64	

# SUBCLASS MACHINE LIST

 Seams	 Model No.	 Number of needles	 Number of threads	 Needle gauge (mm)	 Max. stitch length (mm)	 Bottom differential feed ratio	 Presser lifting amount (mm)	 Max. sewing speed (rpm)	Devices
---	---	---	---	---	---	---	---	---	---------

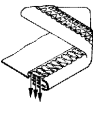
● For universal (hemming, coverseam: foldingover-overlock seam, coverseam: flattening out)

* 1	MF-7605U-U03-B56	3	5	5.6	1.8 ~ 2.5	1: 0.4 ~ 1: 2.8	8	6,500	UT13, CC1
	MF-7605U-U03-B64			6.4					PL5

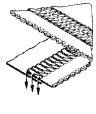
● For universal (hemming, coverseam: foldingover-overlock seam, coverseam: flattening out, collarett) by retrofit kit

* 2	MF-7605U-U06-B56	3	5	5.6	1.8 ~ 2.5	1: 0.4 ~ 1: 2.8	8	6,500	UT13
	MF-7605U-U06-B64			6.4					PL5

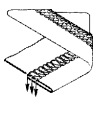
● For collarett

	MF-7602U-C02-B40	2	4	4.0	1.8 ~ 2.5	1: 0.3 ~ 1: 3.6	8	6,500	TC2/3/4
	MF-7605U-C02-B48	3	5	4.8					
	MF-7605U-C02-B56			5.6					
	MF-7605U-C02-B64			6.4					

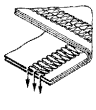
● For attaching elastic

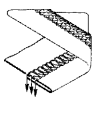
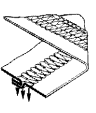
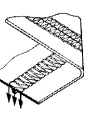
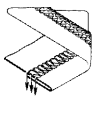

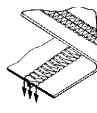
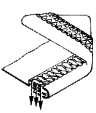
	MF-7602U-E12-B40/MD1	2	4	4.0	1.6 ~ 2.8	1: 0.3 ~ 1: 3.0	7	5,500	TC2/3/4
	MF-7602U-E12-B40/MD2								
	MF-7602U-E12-B40/MD6								
	MF-7605U-E12-B48/MD1	3	5	5.6					
	MF-7605U-E12-B48/MD2								
	MF-7605U-E12-B48/MD6								
	MF-7605U-E12-B56/MD1								
	MF-7605U-E12-B56/MD2								
	MF-7605U-E12-B56/MD6								
	MF-7605U-E12-B64/MD1								
MF-7605U-E12-B64/MD2									
MF-7605U-E12-B64/MD6									

● For hemming

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

● For lap seam

	MF-7605U-L01-B48	3	5	4.8	1.8 ~ 2.5	1: 0.4 ~ 1: 2.4	8	6,500	UT13, CC1
	MF-7605U-L01-B56			5.6					
	MF-7605U-L01-B64			6.4					

* 1				* 2				
-----	---	---	---	-----	--	---	---	---

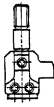
# GAUGE PARTS CONSTRUCTION CHART OF MF-7000 SERIES

MF-7406-C01-D  
MF-7602-C01-D

I.D

3.2 US50318AM32  
4.0 US50318AM40

3.2 (50318AM32) (FD)  
4.0 (50318AM40) (FE)




MF-7407-C01-D  
MF-7605-C01-D

I.D

4.8 S50318AM48  
5.6 US50318AM56  
6.4 US50318AM64

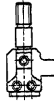
4.8 (50318AM48) (FF)  
5.6 (50318AM56) (FG)  
6.4 (50318AM64) (FH)



MF-7602-C02-B

I.D

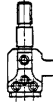
4.0 US50318AM40  
4.0 (50318AM40) (FE)



MF-7605-C02-B

I.D

4.8 US50318AM48  
4.8 (50318AM48) (FF)




MF-7605-C02-B

I.D

5.6 US50318AM56  
6.4 US50318AM64

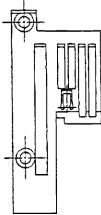
5.6 (50318AM56) (FG)  
6.4 (50318AM64) (FH)



S.T.T

3.2 30121701  
4.0 30121800

3.2 (34724XX8) (D)  
4.0 (34724XX10) (D)

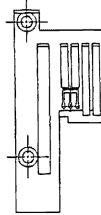


D type  
N.B. R8

S.T.T

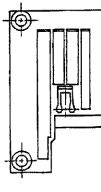
4.8 US34724XX48  
5.6 30122303  
6.4 US34724XX64

4.8 (34724XX48) (D)  
5.6 (50324AF) (D)  
6.4 (34724XX64) (D)



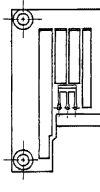
D type  
N.B. R8

4.0 US50324AU40  
4.0 (50324AU40) (B)



B type  
N.B. 2

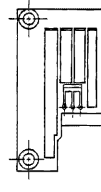
4.8 US50324AU48  
4.8 (50324AU48) (B)



B type  
N.B. 2

5.6 US50324AU56  
6.4 US50324AU64


5.6 (50324AU56) (B)  
6.4 (50324AU64) (B)



B type  
N.B. 2


ID

US0050305AZ  
(50305AZ) (XP)




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(50305AU) (WV)




ID

4.0 US0050305BZ  
4.8 (50305BZ) (ZN)




ID

5.6 US0050305BX  
6.4 (50305BX) (ZL)



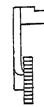
ID

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(50326AZ) (XL)



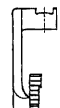
ID

US0050326AG  
(50326AG) (WS)



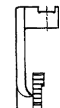
ID

4.0 US0050326BV  
4.8 (50326BV) (ZS)

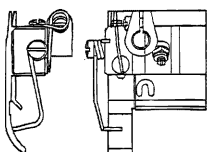


ID

5.6 US0050326BT  
6.4 (50326BT) (ZK)



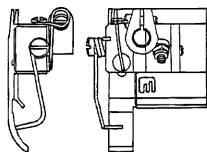
3.2 30485551 (50320U-8)  
4.0 30485650 (50320U-12)



ID

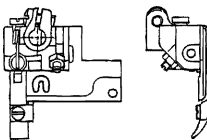
4.8 30485759  
(50320V48) (DV)

5.6 30485858  
6.4 (50320V-16)



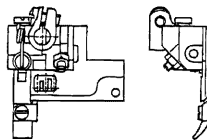
ID

4.0 US50320CB40  
(50320CB40) (EY)



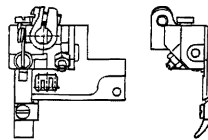
ID

4.8 US50320CB48  
(50320CB48) (EZ)



ID

5.6 US50320CB56  
6.4 (50320CB56) (ES)



**MF-7602-E11-B**  
**MF-7602-E12-B**

4.0 US50318AM40 I.D  
4.0 (50318AM40) (FE)

**MF-7605-E11-B**  
**MF-7605-E12-B**

4.8 US50318AM48 I.D  
4.8 (50318AM48) (FF)

**MF-7605-E11-B**  
**MF-7605-E12-B**

5.6 US50318AM56 I.D  
6.4 US50318AM64  
5.6 (50318AM56) (FG)  
6.4 (50318AM64) (FH)

4.0 US50324CZ40  
4.0 (50324CZ40) (B)

4.8 US50324CZ48  
4.8 (50324CZ48) (B)

5.6 US50324CZ56  
6.4 US50324CZ64  
5.6 (50324CZ56) (B)  
6.4 (50324CZ64) (B)

US0050305CE ID  
(50305CE) (AAA)

US0050305CD ID  
(50305CD) (ZZ)

US0050326BZ ID  
(50326BZ) (AAB)

US0050326BY ID  
(50326BY) (ZY)

US50320CE40 ID  
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US50320CE48 ID  
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5.6 } US50320CE56 ID  
6.4 } (50320CE56) (EV)

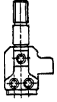


MF-7406-H01-A , C  
MF-7602-H01-A , C

I.D

3.2 US50318AM32  
4.0 US50318AM40

(50318AM32) (FD)  
(50318AM40) (FE)

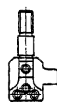


MF-7407-H01-A , B , C  
MF-7605-H01-A , B , C

I.D

4.8 S50318AM48  
5.6 US50318AM56  
6.4 US50318AM64

4.8 (50318AM48) (FF)  
5.6 (50318AM56) (FG)  
6.4 (50318AM64) (FH)

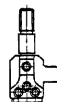


MF-7605-K02-D

I.D

4.8 US50318AM48  
5.6 US50318AM56

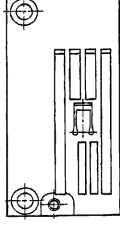
4.8 (50318AM48) (FF)  
5.6 (50318AM56) (FG)



S.T.T

3.2 US50324BL32  
30281406  
4.0 US50324BL40  
30281505

(50324BL32) (A)  
(34724F8) (C)  
(50324BL40) (A)  
(34724F10) (C)



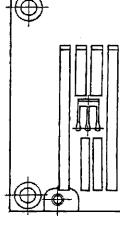
A type  
N.B. R 0.5

C type  
N.B. 2.7

S.T.T

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US50324BS48  
US034724F48  
5.6 US50324BL56  
US50324BS56  
30281604  
6.4 US50324BL64  
US50324BS64  
US034724F64

4.8 (50324BL48) (A)  
(50324BS48) (B)  
(34724F48) (C)  
5.6 (50324BL56) (A)  
(50324BS56) (B)  
(34724F56) (C)  
6.4 (50324BL64) (A)  
(50324BS64) (B)  
(34724F64) (C)



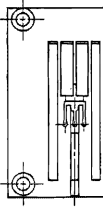
A type  
N.B. R 0.5

B type  
N.B. 2

C type  
N.B. 2.7


4.8 US050324D48  
5.6 US050324D56

4.8 (50324D48)  
5.6 (50324D56)

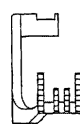


D type  
N.B. R 8


ID  
US0050305BM  
(50305BM) (XM)



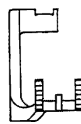
ID  
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(50326AY) (XN)



ID  
US0050305BT  
(50305BT) (YW)

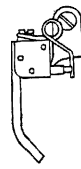
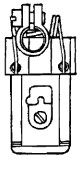


ID  
US0050326BM  
(50326BM) (YX)



ID

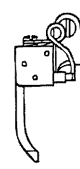
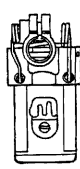
3.2 } 30120455  
4.0 } (50320AH) (DF)

ID


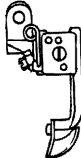
4.8 30485353  
(50320T48) (DT)

5.6 } 30485452  
6.4 } (50320T60) (DR)

ID

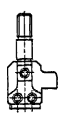
4.8 US0050320BU (ED)  
5.6 US0050320BV (EE)

MF-7602-L01-A , C00

I.D

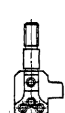
3.2	US50318AM32	
4.0	US50318AM40	
3.2	(50318AM32)	(FD)
4.0	(50318AM40)	(FE)



MF-7605-L01-A , B , C

I.D

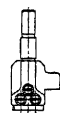
4.8	US50318AM48	
5.6	US50318AM56	
6.4	US50318AM64	
4.8	(50318AM48)	(FF)
5.6	(50318AM56)	(FG)
6.4	(50318AM64)	(FH)



MF-7605-L21-A , B , C

I.D




5.6	US50318AM56	
6.4	US50318AM64	
5.6	(50318AM56)	(FG)
6.4	(50318AM64)	(FH)



5





S.T.T

3.2	US50324BN32	
	US50324BM32	
4.0	US50324BN40	
	US50324BM40	
3.2	(50324BN32)	(A)
	(50324BM32)	(C)
4.0	(50324BN40)	(A)
	(50324BM40)	(C)





S.T.T

4.8	US50324BN48	
	US50324BR48	
	US50324BM48	
5.6	US50324BN56	
	US50324BR56	
	US50324BM56	
6.4	US50324BN64	
	US50324BR64	
	US50324BM64	
4.8	(50324BN48)	(A)
	(50324BR48)	(B)
	(50324BM48)	(C)
5.6	(50324BN56)	(A)
	(50324BR56)	(B)
	(50324BM56)	(C)
6.4	(50324BN64)	(A)
	(50324BR64)	(B)
	(50324BM64)	(C)


S.T.T

5.6	US50324BN56	
	US50324BR56	
	US50324BM56	
6.4	US50324BN64	
	US50324BR64	
	US50324BM64	
5.6	(50324BN56)	(A)
	(50324BR56)	(B)
	(50324BM56)	(C)
6.4	(50324BN64)	(A)
	(50324BR64)	(B)
	(50324BM64)	(C)


I.D

US0050305AN (50305AN) (WN)




I.D

US0050326AE (50326AE) (WP)




I.D

US0050305AV (50305AV) (XJ)



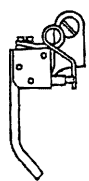
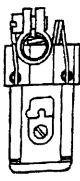
I.D

US0050326AX (50326AX) (XK)



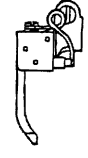

I.D

3.2	} 30120455 (50320AH)	(DF)
4.0		

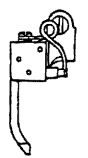
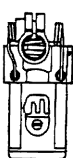
I.D

4.8	} 30485353 (50320T48)	(DT)
5.6		
5.6	} 30485452 (50320T60)	(DR)
6.4		

I.D

5.6	} 30485452 (50320T60)	(DR)
6.4		





**MF-7605-U03-B**

I.D

5.6 US50318AM56  
6.4 US50318AM64

5.6 (50318AM56) (FG)  
6.4 (50318AM64) (FH)




**MF-7605-U05-B**

I.D

5.6 US50318AM56  
6.4 US50318AM64

5.6 (50318AM56) (FG)  
6.4 (50318AM64) (FH)

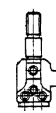


**MF-7605-U06-B**

I.D

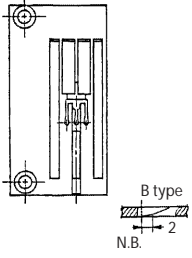
5.6 US50318AM56  
6.4 US50318AM64

5.6 (50318AM56) (FG)  
6.4 (50318AM64) (FH)



5.6 US50324DE56  
6.4 US50324DE64

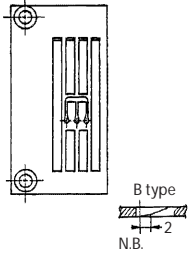
5.6 (50324DE56)  
6.4 (50324DE64)



B type  
N.B. 2

5.6 US50324DF56  
6.4 US50324DF64

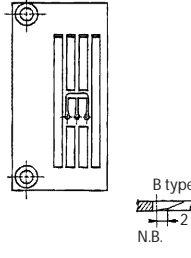
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6.4 (50324DF64)



B type  
N.B. 2

5.6 US50324DF56  
6.4 US50324DF64


5.6 (50324DF56)  
6.4 (50324DF64)



B type  
N.B. 2


ID

US0050305BT  
(50305BT) (YW)




ID

5.6 US0050305BW  
(50305BW) (ZC)




ID

6.4 US0050305CB  
(50305CB) (ZU)




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5.6 US0050305BW  
(50305BW) (ZC)




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6.4 US0050305CB  
(50305CB) (ZU)




ID

US0050326BR  
(50326BR) (ZE)




ID

5.6 US0050326BP  
(50326BP) (ZD)




ID

6.4 US0050326BW  
(50326BW) (ZW)




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5.6 US0050326BP  
(50326BP) (ZD)



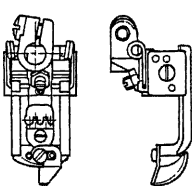
ID

6.4 US0050326BW  
(50326BW) (ZW)

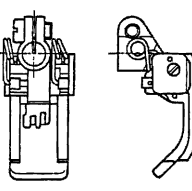


ID

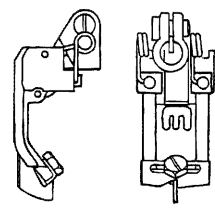
5.6 } US50320BZ56  
6.4 } (50320BZ56) (EM)



5.6 } US50320BX56  
6.4 } (50320BX56)



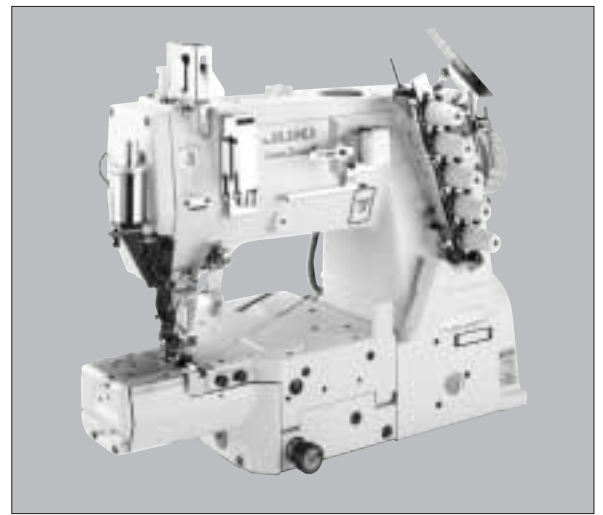
5.6 } US50320CD56  
6.4 } (50320CD56)



## 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

Stitch type	Code	Stitch length (mm)				Needle gauge (mm)	2-needle	3-needle	Code		
2-needle bottom covering stitch	406	2-needle	3-needle	Application	Code	3.2		×	32		
3-needle bottom covering stitch	407	1.6 ~ 2.1	1.6 ~ 2.1			Hemmer	A	4.0		×	40
2-needle top & bottom covering stitch	602		1.8 ~ 2.5					Collarette/elastic /coverseam	D	4.8	
3-needle top & bottom covering stitch	605	1.8 ~ 3.2	2.5 ~ 3.2	1.6 ~ 3.2	1.6 ~ 3.2	5.6					56
						6.4			64		

MFC-7    U-    -    /UT5

Device & attachment

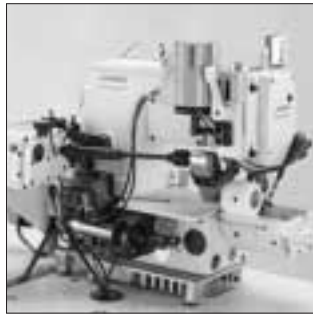
Application	Description of subclass	Code
For universal	Hemming and coverseam (foldingover-overlock seam and flattening out)	U03
	Hemming and coverseam (foldingover-overlock seam and flattening out and collarette) by retrofit kit	U06
	Hemming and coverseam (foldingover-overlock seam and flattening out) including conversion parts	U02
For collarette	Basic style. Easy conversion to hem or coverseam	C02
For hemming	Left hand fabric trimmer	H21
	For hemming with left hand fabric trimmer & rear puller	H31
	With puller. On pre-closed waists and neck, arm, and leg openings with pre-attached elastic.	H11
For attaching elastic	Preclosed elastic tape attaching & fabric under trimmer for waistband to brief	E11
	Preclosed elastic tape attaching & fabric under trimmer for waistband to brief (with rear puller)	E61
For hemming	Basic style with hem guide	H01
For coverseam	Standard fixed seam guide for light-weight materials	K01
	Adjustable seam guide for medium-to heavy-weight materials	K02

## DEVICES AND ATTACHMENTS

Model	Description	Applicable models				Application
		7406	7407	7602	7605	
<b>● Thread trimming device</b>						
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-lifter)					
UT5	Pneumatic type (top & bottom thread trimmer + auto-lifter)					
<b>● Cloth puller</b>						
PL1	(not apply with UT1, UT2)					For H11, E61
PL4	(It can be attached after the setup.)					
<b>● Smooth cloth puller</b>						
PL1S	Rubber type					
<b>● Roller tensioner</b>						
TR04	Fixed roller tensioner					
TR05	Pneumatic roller tensioner					
TR06	Fixed roller tensioner					
<b>● Cloth chip suction device</b>						
MC-34	Monolithic type					
<b>● Pneumatic hem binder</b>						
AH3	Pneumatic hem binder					For U02/U03/U06, H01, H21



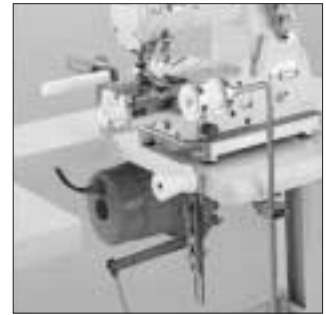
UT5



PL4



TR04



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

### 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 ⇒ U06

Kit No.: 29480CC02U06J

+

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










### U06 ⇒ C02

Kit No.: 29480CU06C02J

+

Sewing parts			
Parts name	Parts No.		
Needle gauge	5.6 mm	6.4 mm	
Needle clamp	50318AN56	50318AN64	
Presser foot	50320CB56		
Differential-feed dog	50326BS		
Main feed dog	50305BY		
Throat plate	50324AU56	50324AU64	

# SUBCLASS MACHINE LIST

 Seams	 Model No.	 Number of needles	 Number of threads	 Needle gauge (mm)	 Max. stitch length (mm)	 Bottom differential feed ratio	 Presser lifting amount (mm)	 Max. sewing speed (rpm)	Devices
---	---	---	---	---	---	---	---	---	---------

● For universal (hemming, coverseam: foldingover-overlock seam, coverseam: flattening out)

* 1	MFC-7407U-U03-B56	3	4	5.6	1.8 ~ 2.5	1: 0.3 ~ 1: 2.7	7	6,500	UT1/3/4
	MFC-7407U-U03-B64			6.4					PL4, AH3
	MFC-7605U-U03-B56		5	5.6					UT2/5
	MFC-7605U-U03-B64			6.4					PL4, AH3


● For universal (hemming, coverseam: foldingover-overlock seam, coverseam: flattening out, collarett) by retrofit kit

* 2	MFC-7605U-U06-B56	3	5	5.6	1.8 ~ 2.5	1: 0.3 ~ 1: 2.7	7	6,500	UT2/5
	MFC-7605U-U06-B64			6.4					PL4, AH3


● For universal (hemming, coverseam: folding over-overlock seam, coverseam: flattening out) including conversion parts

* 1	MFC-7602U-U02-B48	2	4	4.8	1.8 ~ 2.5	1: 0.3 ~ 1: 2.7	7	6,500	UT2/5, PL4, AH3
	MFC-7605U-U02-B56	3	5	5.6					TR04/TR05/TR06


● For collarett

	MFC-7605U-C02-B56	3	5	5.6	1.8 ~ 2.5	1: 0.3 ~ 1: 3.0	6	6,500	
	MFC-7605U-C02-B64			6.4					


● For hemming with left hand fabric trimmer

	MFC-7605U-H21-B56	3	5	5.6	1.6 ~ 3.2	1: 0.3 ~ 1: 2.7	7	5,500	UT2/5, AH3
	MFC-7605U-H21-B64			6.4					


● For hemming with left hand fabric trimmer & rear puller

	MFC-7605U-H31-B56/PL1	3	5	5.6	1.6 ~ 3.2	1: 0.3 ~ 1: 2.7	7	5,500	UT5
	MFC-7605U-H31-B56/PL1S			6.4					
	MFC-7605U-H31-B64/PL1								
	MFC-7605U-H31-B64/PL1S								


● For hemming with close-coupled roller puller for pre-attached 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
	MFC-7605U-H11-B56/PL1S								


● For attaching pre-closed elastic waistband to underwear (with right fabric trimmer)

	MFC-7605U-E11-D56	3	5	5.6	1.6 ~ 3.0	1: 0.3 ~ 1: 2.4	6	5,500	UT2/5
	MFC-7605U-E11-D64			6.4					PL4, TR04/TR05/TR06


● For attaching pre-closed elastic waistband to underwear (with right fabric trimmer & rear puller)








	MFC-7605U-E61-D56/PL1	3	5	5.6	1.6 ~ 3.2	1: 0.3 ~ 1: 2.7	6	5,500	UT5
	MFC-7605U-E61-D56/PL1S			6.4					
	MFC-7605U-E61-D64/PL1								
	MFC-7605U-E61-D64/PL1S								

● For hemming

	MFC-7602U-H01-A40	2	4	4.0	1.6 ~ 2.1	1: 0.3 ~ 1: 2.7	7	6,500	UT2/5, AH3
	MFC-7602U-H01-A48			4.8					
	MFC-7605U-H01-B56	3	5	5.6					
	MFC-7605U-H01-B64			6.4					

● For coverseam (with adjustable seam guide medium to heavy fabrics)

	MFC-7602U-K02-D56	2	4	5.6	1.6 ~ 3.2	1: 0.3 ~ 1: 2.4	7	6,500	UT2/5	
	MFC-7602U-K02-D64			6.4					UT4	
	MFC-7406U-K02-D56		3	5					5.6	UT2/5
	MFC-7605U-K02-D56								5.6	
MFC-7605U-K02-D64	6.4									

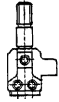
* 1				* 2				
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# GAUGE PARTS CONSTRUCTION CHART OF MFC-7000 SERIES

## MFC-7602-C01-D

I.D

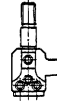
3.2	US50318AN32	
4.0	US50318AN40	
4.8	US50318AN48	
3.2	(50318AN32)	(FR)
4.0	(50318AN40)	(FJ)
4.8	(50318AN48)	(FK)



## MFC-7605-C01-D

I.D

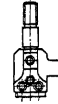
5.6	US50318AN56	
6.4	US50318AN64	
5.6	(50318AN56)	(FL)
6.4	(50318AN64)	(FM)



## MFC-7605-C02-B

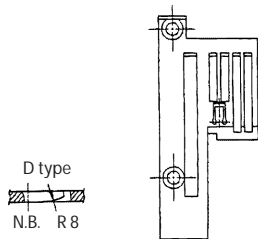
I.D

5.6	US50318AN56	
6.4	US50318AN64	
	(50318AN56)	(FL)
	(50318AN64)	(FM)



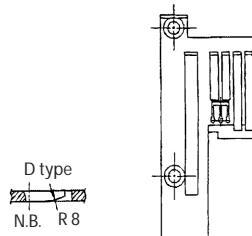
S.T.T

3.2	30121701	
4.0	30121800	
4.8	US50324XX48	
3.2	(34724XX8)	(D)
4.0	(34724XX10)	(D)
4.8	(50324XX48)	(D)



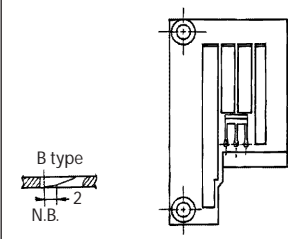
S.T.T

5.6	30287205	
6.4	US34724XX64	
5.6	(34724XX56)	(D)
6.4	(34724XX64)	(D)



S.T.T

5.6	US50324AU56	
6.4	US50324AU64	
	(50324AU56)	
	(50324AU64)	



ID

30283501		
30283600		
30256705		
(34805TD8)	(LT8)	
(34805TH)	(LQ)	
(77L(SCREW))		



ID

30283709		
30283600		
30256705		
(34805TD16)	(LT16)	
(34805TH)	(LQ)	
(77L (SCREW))		



ID

US0050305BY		
(50305BY)	(ZM)	



ID

30283105		
(34726XX10)	(LX)	



ID

30283204		
(34726XX16)	(LXA)	

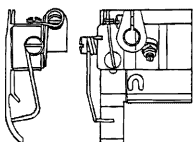


ID

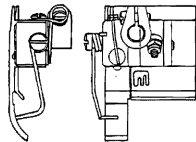
US0050326BS		
(50326BS)	(ZJ)	



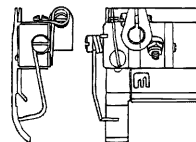
3.2	30485551	(50320U-8)
4.0	30485650	(50320U-12)



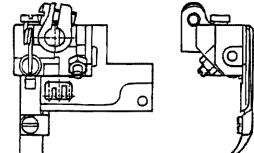
4.8	30485759	(50320V48) (DV)
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30485858	(50320V-16)
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5.6	US50320CB56	ID
6.4		(50320CB56)



MFC-7406-E11-D  
MFC-7602-E11-D  
MFC-7406-E61-D  
MFC-7602-E61-D

MFC-7407-E11-D  
MFC-7605-E11-D  
MFC-7407-E61-D  
MFC-7605-E61-D

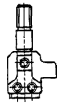
MFC-7406-H01-A , C  
MFC-7602-H01-A , C

MFC-7407-H01-A , B , C  
MFC-7605-H01-A , B , C

I.D

4.0 US50318AN40  
4.8 US50318AN48

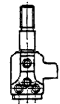
4.0 (50318AN40) (FJ)  
4.8 (50318AN48) (FK)



I.D

5.6 US50318AN56  
6.4 US50318AN64

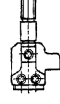
5.6 (50318AN56) (FL)  
6.4 (50318AN64) (FM)



I.D

3.2 US50318AN32  
4.0 US50318AN40  
4.8 US50318AN48

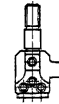
3.2 (50318AN32) (FR)  
4.0 (50318AN40) (FJ)  
4.8 (50318AN48) (FK)



I.D

5.6 US50318AN56  
6.4 US50318AN64

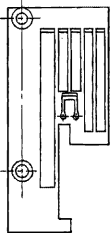
5.6 (50318AN56) (FL)  
6.4 (50318AN64) (FM)



S.T.T

4.0 US34724TB40  
4.8 US34724TB48

4.0 (34724TB40) (D)  
4.8 (34724TB48) (D)

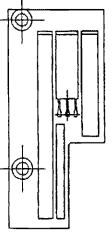


D type  
N.B. R 8

S.T.T

5.6 US34724TB56  
6.4 US34724TB64

5.6 (34724TB56) (D)  
6.4 (34724TB64) (D)

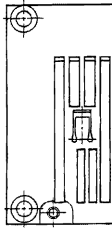


D type  
N.B. R 8

S.T.T

3.2 US50324BL32  
30281406  
4.0 US50324BL40  
30281505  
4.8 US50328BL48  
US050324F48

3.2 (50324BL32) (A)  
(34724F8) (C)  
4.0 (50324BL40) (A)  
(34724F10) (C)  
4.8 (50328BL48) (A)  
(34724F48) (C)



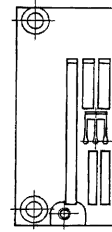
A type  
N.B. R 0.5

C type  
N.B. 2.7

S.T.T

5.6 US50324BL56  
US50324BS56  
30281604  
6.4 US50324BL64  
US50324BS64  
US034724F64

5.6 (50324BL56) (A)  
(50324BS56) (B)  
(34724F56) (C)  
6.4 (50324BL64) (A)  
(50324BS64) (B)  
(34724F64) (C)



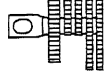
A type  
N.B. R 0.5

B type  
N.B. 2

C type  
N.B. 2

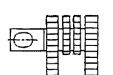
ID

30199103  
(34705BW) (LB)



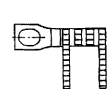
ID

30153001  
(34705TB) (KN)



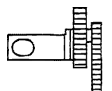
ID

30051700  
(34705F) (KE)



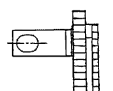
ID

30199004  
(34726TB10) (KPA)



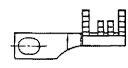
ID

30172803  
(34726TB16) (KP)

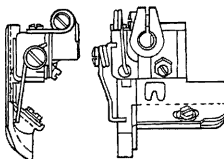


ID

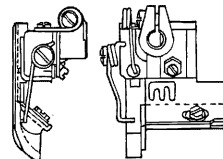
30051601  
(34726F) (KF)



4.0 US34720TB40  
(34720TB40)  
4.8 US34720TB48  
(34720TB48)

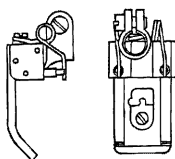


US34720TB64 (34720TB64)



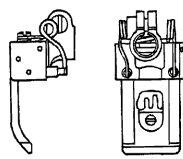
ID

3.2 } 30120455  
4.0 } (50320AH) (DF)



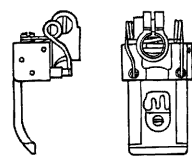
ID

4.8 30485353  
(50320T48) (DT)



ID

5.6 } 30485452  
6.4 } (50320T60) (DR)





MFC-7406-H11-A , C  
MFC-7602-H11-A , C

MFC-7407-H11-A , B , C  
MFC-7605-H11-A , B , C

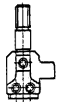
MFC-7406-H21-A , C  
MFC-7602-H21-A , C  
MFC-7406-H31-A , C  
MFC-7602-H31-A , C

MFC-7407-H21-A , B , C  
MFC-7605-H21-A , B , C  
MFC-7407-H31-A , B , C  
MFC-7605-H31-A , B , C

I.D

4.0 US50318AN40  
4.8 US50318AN48

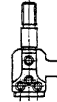
4.0 (50318AN40) (FJ)  
4.8 (50318AN48) (FK)



I.D

5.6 US50318AN56  
6.4 US50318AN64

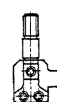
5.6 (50318AN56) (FL)  
6.4 (50318AN64) (FM)



I.D

4.0 US50318AN40  
4.8 US50318AN48

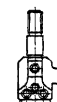
4.0 (50318AN40) (FJ)  
4.8 (50318AN48) (FK)



I.D

5.6 US50318AN56  
6.4 US50318AN64

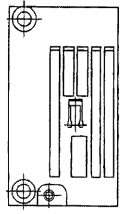
5.6 (50318AN56) (FL)  
6.4 (50318AN64) (FM)



S.T.T

4.0 US50324CJ40  
30173009  
4.8 US50324CJ48  
US034724E48

4.0 (50324CJ40) (A)  
(34724E-10) (C)  
4.8 (50328CJ48) (A)  
(34724E48) (C)



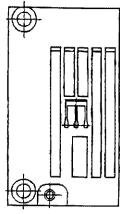
A type  
N.B. R 0.5

C type  
N.B. 2.7

S.T.T

5.6 US50324CK56  
US50324CL56  
US034724E56  
6.4 US50324CK64  
US50324CL64  
US034724E64

5.6 (50324CK56) (A)  
(50324CL56) (B)  
(34724E56) (C)  
6.4 (50324CK64) (A)  
(50324CL64) (B)  
(34724E64) (C)



A type  
N.B. R 0.5

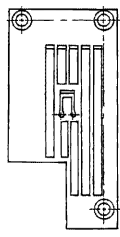
B type  
N.B. 2

C type  
N.B. 2.7

S.T.T

4.0 US50324FR40  
US50324FT40  
4.8 US50324FR48  
US50324FT48

4.0 (50324FR40) (A)  
(50324FT40) (C)  
4.8 (50324FR48) (A)  
(50324FT48) (C)



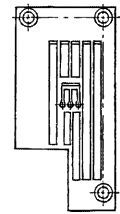
A type  
N.B. R 0.5

C type  
N.B. 2.7

S.T.T

5.6 US50324FR56  
US50324FS56  
US50324FT56  
6.4 US50324FR64  
US50324FS64  
US50324FT64

5.6 (50324FR56) (A)  
(50324FS56) (B)  
(50324FT56) (C)  
6.4 (50324FR64) (A)  
(50324FS64) (B)  
(50324FT64) (C)



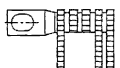
A type  
N.B. R 0.5

B type  
N.B. 2

C type  
N.B. 2.7

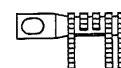
ID

30373609  
(34705DG) (KT)



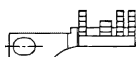
I.D

US0050305FT  
(50305FT) (ZT)



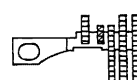
ID

30152805  
(34726DG) (KU)



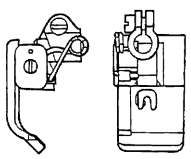
I.D

US0050326FT  
(50326FT) (ZH)



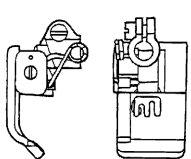
ID

4.0 } US50320BE40  
4.8 } (50320BE40) (DY)



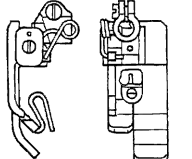
ID

5.6 } US50320BF64  
6.4 } (50320BF64) (DZ)



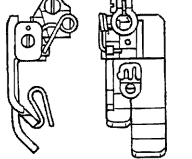
I.D

4.0 } US50320CA40  
4.8 } (50320CA40) (EP)



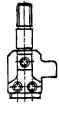
I.D

5.6 } US50320CA56  
6.4 } (50320CA56) (ER)

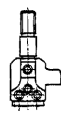


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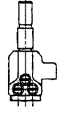
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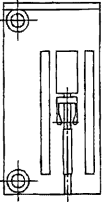
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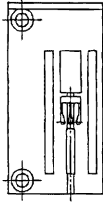


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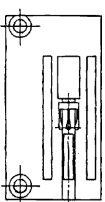
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N.B. R 8

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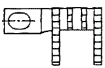
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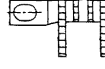


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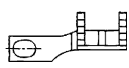
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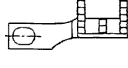
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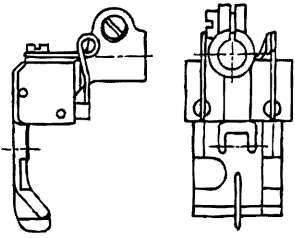
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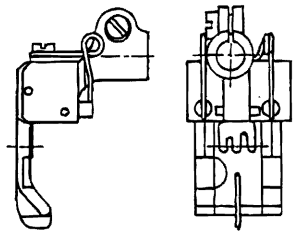
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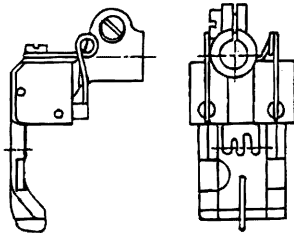
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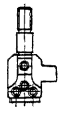


**MFC-7605-U03-B**

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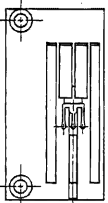
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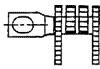
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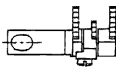
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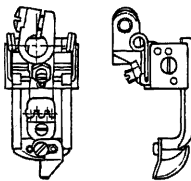
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**MFC-7605-U05-B**

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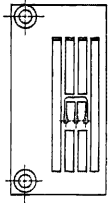
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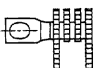
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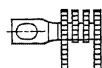
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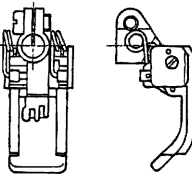
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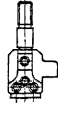


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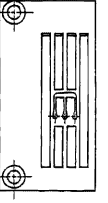
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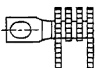
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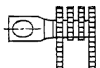
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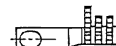
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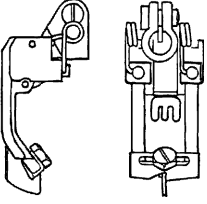


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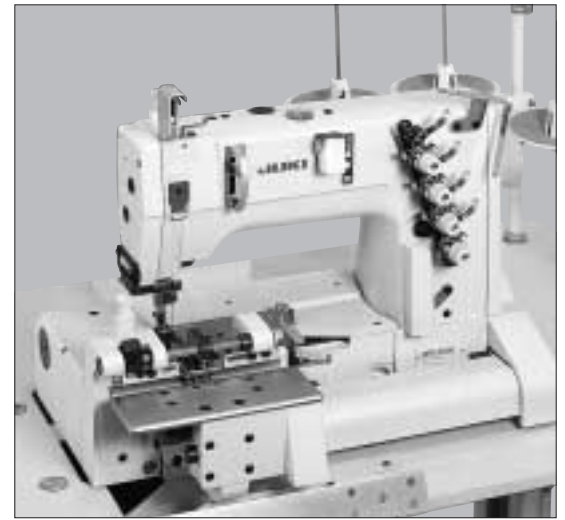
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High-speed, 2-needle, 3-thread, Bottom Covering Stitch,  
Belt-loop Making Machine

# MFB-2600

- The sewing 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

## 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 x 1 (#11) #11 ~ #14 or UY128GAS (#75) #75 ~ #90
Lubrication	Automatic
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)

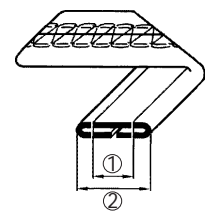
## WHEN YOU PLACE ORDERS

### MFB-2600

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

Application	Code
For light-wight materials	A
For medinum-weight materials	B
For heavy-weight materials	H

Finished width (mm)	Code	Finished width (mm)	Code
8	H	15	Q
9	J	16	R
10	K	17	S
11	L	18	T
12	M	19	U
13	N	20	V
14	P		



①: Needle gauge  
②: Finished width

## NEEDLE GAUGE: FINISHED WIDTH

Application	Finished width		H	J	K	L	M	N	P	Q	R	S	T	U	V
	Needle gauge		8mm	9mm	10mm	11mm	12mm	13mm	14mm	15mm	16mm	17mm	18mm	19mm	20mm
A (light-weight materials)	F	4.8mm													
	G	5.6mm													
	H	6.4mm													
B (medium-weight materials)	F	4.8mm													
	G	5.6mm													
	H	6.4mm													
H (heavy-weight materials)	G	5.6mm													
	H	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.



MH-380

6

## SPECIFICATIONS

Model name	MH-380	MH-382
	Parallel 2-needle	Tandem 2-needle
Max. sewing speed	6,000rpm	
Stitch length	4mm	
Lift of the presser foot	By hand: 5.5mm, By knee: 10mm	
Needle bar stroke	30mm	
Needle (at the time of delivery)	TV x 7 (#14) #9 ~ #21	
Thread take-up	Needle bar thread take-up	
Stitch length adjustment	By stitch dial (lockstitch)	
Condensation stitches	By lever for condensation stitching	
Looper system	Rocking type looper	
Looper stroke	22.6mm	
Elliptical motion	2.4 ~ 3.7mm	
Lubrication	Automatic	
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	
Needle cooler	Optional	

## WHEN YOU PLACE ORDERS

MH-380  U

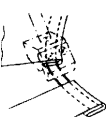
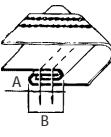
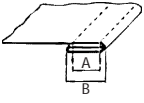
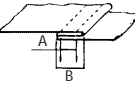
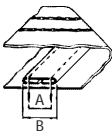
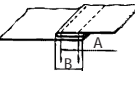
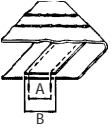
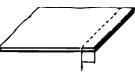
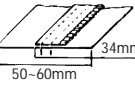
MH-382U

Needle gauge	Code	B	C	D	E	F	H	K	L
	mm	3.2	4.0	4.8	5.6	6.4	7.9	9.5	12.7
	inch	1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2

## APPLICATIONS

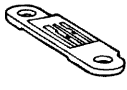




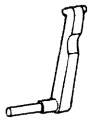
Model	Application
MH-380 (parallel 2-needle)	<ul style="list-style-type: none"> <li>• Sewing sides of slacks</li> <li>• Hemming or welting garment parts</li> <li>• Attaching lining tape</li> </ul>
MH-382 (tandem 2-needle)	<ul style="list-style-type: none"> <li>• Joining seat of slacks</li> </ul>

# DEVICES AND ATTACHMENTS

<p>● Chain-off thread cutter</p> <p><b>AT-8</b></p> 	<p><b>Applicable machines:</b> MH-380, MH-382  <b>Class of work:</b> Jeans, Working wear  <b>Applications:</b> 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 for continuous sewing on pocket openings of jeans or working wear.</p> <table border="1"> <thead> <tr> <th>Guide width mm (in)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>Tandem 2-needle</td> <td>GAT-08000AC</td> </tr> <tr> <td>4.0 (5/32)</td> <td>GAT-08000CAC</td> </tr> <tr> <td>4.8 (3/16)</td> <td>GAT-08000DAC</td> </tr> <tr> <td>6.4 (1/4)</td> <td>GAT-08000FAC</td> </tr> <tr> <td>7.9 (5/16)</td> <td>GAT-08000HAC</td> </tr> </tbody> </table>	Guide width mm (in)	Part No.	Tandem 2-needle	GAT-08000AC	4.0 (5/32)	GAT-08000CAC	4.8 (3/16)	GAT-08000DAC	6.4 (1/4)	GAT-08000FAC	7.9 (5/16)	GAT-08000HAC	<p>● Lap seam folder (Reverse)</p> <p><b>M052</b></p>  <p>A: Needle gauge B: Finished width</p>	<p><b>Applicable machines:</b> MH-380  <b>Class of work:</b> Jeans, Working pants, Pants, Overalls  <b>Applications:</b> Sew side seams  <b>Materials:</b> Medium heavy-weight materials and heavy-weight materials such as denim, drill, etc.</p> <table border="1"> <thead> <tr> <th>Finished width (mm)</th> <th>Needle gauge mm (in)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>17</td> <td>12.7 (1/2)</td> <td>MAM-0520S0A0</td> </tr> <tr> <td>14</td> <td>9.5 (3/8)</td> <td>MAM-0520P0A0</td> </tr> <tr> <td>12</td> <td>7.9 (5/16)</td> <td>MAM-0520M0A0</td> </tr> <tr> <td>10</td> <td>6.4 (1/4)</td> <td>MAM-0520K0A0</td> </tr> <tr> <td>10</td> <td>5.6 (7/32)</td> <td>MAM-0520K0A0</td> </tr> <tr> <td>9</td> <td>4.8 (3/16)</td> <td>MAM-0520J0A0</td> </tr> </tbody> </table>	Finished width (mm)	Needle gauge mm (in)	Part No.	17	12.7 (1/2)	MAM-0520S0A0	14	9.5 (3/8)	MAM-0520P0A0	12	7.9 (5/16)	MAM-0520M0A0	10	6.4 (1/4)	MAM-0520K0A0	10	5.6 (7/32)	MAM-0520K0A0	9	4.8 (3/16)	MAM-0520J0A0																			
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<p>● Down turn hemmer</p> <p><b>L050</b></p>  <p>A: Needle gauge B: Finished width</p>	<p><b>Applicable machines:</b> MH-380  <b>Class of work:</b> Jeans, Working pants  <b>Applications:</b> Hem jeans hip pocket mouth, especially suit for sections where high quality straight stitch is required.</p> <table border="1"> <thead> <tr> <th>Finished width (mm)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>14</td> <td>MAL-0500P0A0</td> </tr> <tr> <td>12</td> <td>MAL-0500M0A0</td> </tr> <tr> <td>11</td> <td>MAL-0500L0A0</td> </tr> <tr> <td>10</td> <td>MAL-0500K0A0</td> </tr> </tbody> </table>	Finished width (mm)	Part No.	14	MAL-0500P0A0	12	MAL-0500M0A0	11	MAL-0500L0A0	10	MAL-0500K0A0	<p>● Left feed top stitch folder</p> <p><b>M054</b></p>  <p>A: Needle gauge B: Finished width</p>	<p><b>Applicable machines:</b> MH-380  <b>Class of work:</b> Jeans, Working pants, Jackets, Skirts  <b>Applications:</b> Sew side seams. Attach flat faces of garments.</p> <table border="1"> <thead> <tr> <th>Finished width (mm)</th> <th>Needle gauge mm (in)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>17</td> <td>12.7 (1/2)</td> <td>MAM-0540S0A0</td> </tr> <tr> <td>14</td> <td>9.5 (3/8)</td> <td>MAM-0540P0A0</td> </tr> <tr> <td>12</td> <td>7.9 (5/16)</td> <td>MAM-0540M0A0</td> </tr> <tr> <td>10</td> <td>6.4 (1/4)</td> <td>MAM-0540K0A0</td> </tr> <tr> <td>10</td> <td>5.6 (7/32)</td> <td>MAM-0540K0A0</td> </tr> <tr> <td>9</td> <td>4.8 (3/16)</td> <td>MAM-0540J0A0</td> </tr> <tr> <td>8</td> <td>4.0 (5/32)</td> <td>MAM-0540H0A0</td> </tr> </tbody> </table>	Finished width (mm)	Needle gauge mm (in)	Part No.	17	12.7 (1/2)	MAM-0540S0A0	14	9.5 (3/8)	MAM-0540P0A0	12	7.9 (5/16)	MAM-0540M0A0	10	6.4 (1/4)	MAM-0540K0A0	10	5.6 (7/32)	MAM-0540K0A0	9	4.8 (3/16)	MAM-0540J0A0	8	4.0 (5/32)	MAM-0540H0A0																		
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<p>● Tape cutter</p> <p><b>AT28</b></p>	<p>■ SPECIFICATIONS</p> <p><b>Applicable model :</b> MH-380 (Cannot be use with the thread trimmer type.)  <b>Operating method :</b> Air drive by an air switch  <b>Applications :</b> Cutting various tapes related to attaching reinforcement tape and decorative tape  <b>Cut specifications :</b> Knife width 20mm  Cutting range of the knife 16mm or less  <b>Air pressure :</b> 0.15-0.5 MPa (1.5-5.0kgf/cm<sup>2</sup>)</p> <p>■ WHEN YOU PLACE ORDERS</p> <p><b>AT28</b></p> <table border="1"> <thead> <tr> <th>Switch</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>Finger switch</td> <td>A</td> </tr> <tr> <td>Knee switch</td> <td>B</td> </tr> </tbody> </table> <p>* Needle gauges, 1/8, 5/32, 3/16, 3/8 and 1/2, should be specially orderd.</p> <table border="1"> <thead> <tr> <th>Needle gauge mm (in)</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>3.2 (1/8")</td> <td>B</td> </tr> <tr> <td>4.0 (5/32")</td> <td>C</td> </tr> <tr> <td>4.8 (3/16")</td> <td>D</td> </tr> <tr> <td>5.6 (7/32")</td> <td>E</td> </tr> <tr> <td>6.4 (1/4")</td> <td>F</td> </tr> <tr> <td>7.9 (5/16")</td> <td>H</td> </tr> <tr> <td>9.5 (3/8")</td> <td>K</td> </tr> <tr> <td>12.7 (1/2")</td> <td>L</td> </tr> </tbody> </table>			Switch	Code	Finger switch	A	Knee switch	B	Needle gauge mm (in)	Code	3.2 (1/8")	B	4.0 (5/32")	C	4.8 (3/16")	D	5.6 (7/32")	E	6.4 (1/4")	F	7.9 (5/16")	H	9.5 (3/8")	K	12.7 (1/2")	L																												
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# TABLE OF EXCHANGING GAUGE SETS





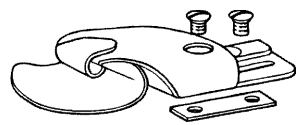
## MH-380

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

## MH-382

	B1103-382-000	B1406-038-BA0	B1524-382-0B0	B1613-382-000	B2311-382-000	B2312-382-000
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## MH-380

Description Gauge components	Right looper	Left looper	Bed slide asm.	Bed slide asm.	Folder		
					M	MH	H
							
3.2mm (1/8")	B2030-380-000	B2031-380-000	B1104-380-AA0	B1108-380-BA0	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")					B9126-038-DAA	B9126-038-DAB	B9126-038-DAC
5.6mm (7/32")					B9126-038-EAA	B9126-038-EAB	B9126-038-EAC
6.4mm (1/4")					B9126-038-FAA	B9126-038-FAB	B9126-038-FAC
7.9mm (5/16")					B9126-038-HAA	B9126-038-HAB	B9126-038-HAC
9.5mm (3/8")							
12.7mm (1/2")							
			B1104-380-LA0	B1108-380-LA0			

## MH-382

	B2030-380-000	B2031-380-000	B1104-380-A00	B1108-380-B00			
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### 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

M (for light weight materials) = A
MH (for medium heavy weight materials) = B
H (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

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 heavy-weight 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	Bottom-feed		Differential-feed		Bottom & variable top-feed
Max. sewing speed	5,500rpm				4,500rpm
Stitch length	1 ~ 4mm		Main feed: 1 ~ 4mm Differential-feed: 1 ~ 5.6mm		1 ~ 5mm
Top-feed amount					0 ~ 7mm
Differential-feed ratio					Max. gathering stitching 1: 3.0 (standard 1: 1.5) Max. stretch stitching 1: 0.5
Lift of the presser foot	By hand: 5mm, By knee: 10mm				By hand: 5mm, By knee: 7mm
Needle bar stroke	30mm				33mm
Needle (at the time of the delivery)	TV x 7 (#11) #9 ~ #18				TV x 7 (#11) #9 ~ #21
Stitch length adjustment	By dial				
Safety stitch	Condensation stitch/reverse stitching (by feed lever)				
Looper system	Inclined crank				
Looper stroke	21.5mm				
Looper stroke of the front and rear	2.1 ~ 3.3mm				3.2mm
Speed control		* (1)		* (1)	* (1)
Lubrication	Automatic				
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)				
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 stitching 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	Remarks	Application				
				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, differential-feed dog			×		
S061	MAS-061000A0	Attachment for intermittent gathering (foot pedal type)				×		

## REPLACEABLE GAUGE TABLE

### ● MH-481, MH-481-5(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.			

### ● MH-484, MH-484-5(4)

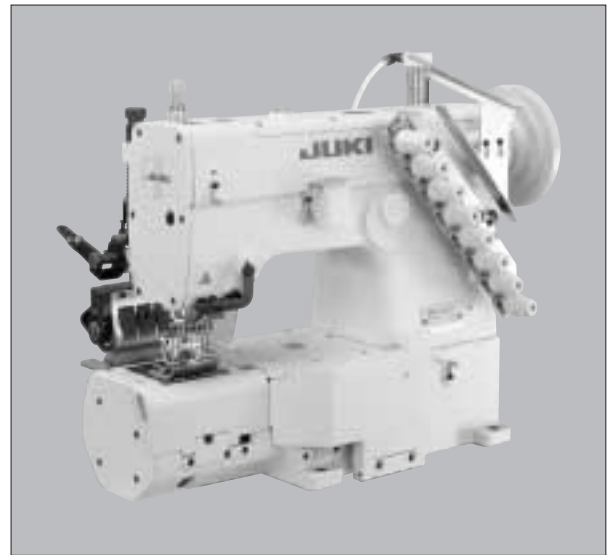
Usage	Throat plate	Main feed dog	Differential-feed dog	Presser foot
Light-weight materials	B1103-484-B00			
Medium-weight material (standard)	B1103-484-F00	B1613-484-F00	B1653-484-F00	B1524-481-CC0
Urethan pad		B1613-484-G00	B1653-484-G00	
Reverse feed dog			B1653-484-C00	
Gathering one piece of material				B1524-481-DA0
• S060 and S061 are optionally available. (Use the presser foot, main feed dog and differential-feed dog exclusive for this attachment)				

### ● MH-486-5(4)

● MH-486 -5(4)					
Code	Usage	Throat plate	Feed dag	Walking foot	Presser foot
	Standard type for general runstitch (rake-in type)	B1103-481-F00	B1613-481-F00	B3026-487-000	B1524-486-0A0
B	For medium turning stitch, gathering stitch (rake-in type: for preventing uneven matelal feed)			B3026-487-000	B1524-486-BA0
D	For sharp turning stitch (pull-in type: for Preventing Puckering)			B3026-487-D00	B1524-486-DA0
M	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 needle-feed 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 (at the time of delivery)	DV x 57 (#21) #18 ~ #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% ~ +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.

## WHEN YOU PLACE ORDERS

MH-1410  /      /

Needle gauge	Code
2-needle: 31.8mm (1-1/4")	A
2-needle: 34.9mm (1-3/8")	B
2-needle: 38.1mm (1-1/2")	C
4-needle: 6.4mm + 25.4mm + 6.4mm (1/4" + 1" + 1/4")	D

\* 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.

Pneumatic auto-lifter	Code
Not provided	
provided	AK122

Cloth puller	Code
Not provided	
provided	V072

\* The V072 cannot be retrofitted to your machine after the setup. Designate one when placing order for the machine.

## 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.



MS-1190

## 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 changed 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 catch 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.



MS-1261/045

## 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	
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")	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	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-fixed 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

**MS-1190**   /

Optional device-1    Optional device-2

Application	Code
For light-weight materials (standard)	M
For medium-weight materials	

Needle gauge	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

Optional device-1	Code
Not provided	M
V045	
Rubber	V045R
Steel	V045S
V046	
Rubber	V046R
Steel	V046S

Optional device-2		Code
Not provided		M
Chain-off thread cutter (AT 27)	Without cloth puller	
	For V045	Knee switch type <b>G</b>
		Pedal switch type <b>A</b>
	For V046	Knee switch type <b>H</b>
		Pedal switch type <b>B</b>
	Knee switch type <b>J</b>	
Needle cooler (CL-3)		<b>C</b>
Needle cooler with folder air blow type		<b>D</b>
Silicon oil lubricating		<b>E</b>
Pneumatic auto-lifter AK81	Pedal switch type	<b>P</b>
	Knee switch type	<b>K</b>
A + C + E + K		<b>01</b>
A + D + E + K		<b>02</b>
A + C + P		<b>03</b>

**MS-1260D**

Optional device-1    Optional device-2

Needle gauge	Code
4.8mm (3/16")	D

**MS-1261**   /

Optional device-1    Optional device-2

Application	Code
For light-weight materials (standard)	M
For medium-weight materials	

Needle gauge	Code
5.6mm (7/32")	E
6.4mm (1/4")	F
7.2mm (9/32")	G
8.0mm (5/16")	H
9.6mm (3/8")	K

## OPTIONS

Model	Part No.	Description	Feature
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### ●Cloth puller

V045	MAV-04500AA0	Made of rubber	Top roller type	The cloth puller is an auxiliary tool for smooth feed of the material. The top roller type cloth puller (V045) can be used for medium- to extra heavy-weight materials for 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 that is soft on material, or steel cloth puller that securely clamps the materials.
	MAV-04500A0	Made of steel		
V046	MAV-04600AA0	Made of rubber	Top and bottom roller type	
	MAV-04600A0	Made of steel		

### ●Chain-off thread cutter

AT27	GAT-27000AA0	Pedal switch type	Without cloth puller	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 types of cloth pullers and whether or not the machine is equipped with a cloth puller.
	GAT-27000CA0	Knee switch type		
	GAT-27000AA0	Pedal switch type	For V045	
	GAT-27000DA0	Knee switch type		
	GAT-27000BA0	Pedal switch type	For V046	
	GAT-27000EA0	Knee switch type		

### ●Needle cooler

CL-3	GCL-03000AA0	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) available, and this allows the material to be easily rolled in at the sewing start.
	GCL-03000AA0	With an auxiliary blower for light-weight materials.	

### ●Silicon oil lubricating unit for the needle thread

	129-45168	For MS-1190 series	Silicon oil lubricating unit is an auxiliary device to reduce the frequency of thread breakage caused by a hot needle.
	129-76254	For MS-1260 series	

### ●Pneumatic auto-lifter

AK81	GAK-81000AA0	Pedal switch type	The pneumatic auto-lifter helps reduce the operator's fatigue and enables the operator to operate the sewing machine rhythmically.
	GAK-81000AA0	Knee switch type	

# TABLE OF EXCHANGING GAUGE PARTS

## MS-1190

		1	2	3	4	5	6	7
Description		Gauge set (with finger guard)	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog	Looper asm. (L)	Looper asm. (R)
Needle gauge size								
Code	Size							
B	3.2mm (1/8")	129-23561	129-23504	129-26051	129-27869	129-32307	129-41555	129-40656
C	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
H	7.9mm (5/16")		129-24007	129-26457	129-28354	129-32802	129-41951	129-41050

		8	9	10	11	12	13	14
Description		Lap seam folder asm.			Feed dog asm. (with removing needle holder)	Looper needle guide (for removing needle holder)	Throat plate (for chain-off thread)	Feed (for chain-off thread)
		M295	M296	M297				
Needle gauge size								
Code	Size							
B	3.2mm (1/8")	MAM-2950AAAA	MAM-2960AAAA	MAM-2970AAAA	129-32653	129-43007	129-23306	129-32208
C	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		
H	7.9mm (5/16")			MAM-2970GGAA				

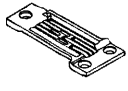
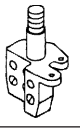

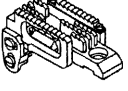
Folder mark: **M295** - Extra light-weight materials, **M296** - Light-weight materials (MS-1190 standard equipment), **M297** - Medium-weight materials (MS-1190M standard equipment)  
The folder is not included in gauge set. For code H, throat plate, presser foot and feed dog for MS-1190 are used. Also,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

## MS-1190M

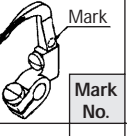
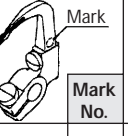
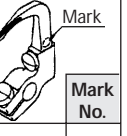
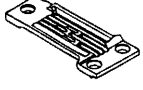
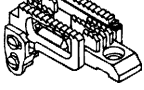
		1	2	3	4	5	6	7
Description		Gauge set (with finger guard)	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog	Looper asm. (L)	Looper asm. (R)
Needle gauge size								
Code	Size							
B	3.2mm (1/8")	129-80561	129-80504	129-26051	129-82666	129-83508	129-41555	129-40656
C	4.0mm (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
Description		Lap seam folder asm.		Throat plate (for chain-off thread)	Feed (for chain-off thread)
		M296	M297		
Needle gauge size					
Code	Size				
B	3.2mm (1/8")	MAM-2960AAAA	MAM-2970AAAA	129-80900	129-83706
C	4.0mm (5/32")	MAM-2960BBAA	MAM-2970BBAA		
D	4.8mm (3/16")	MAM-2960CCAA	MAM-2970CCAA		
E	5.6mm (7/32")	MAM-2960DDAA	MAM-2970DDAA		
F	6.4mm (1/4")	MAM-2960EEAA	MAM-2970EEAA		


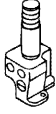

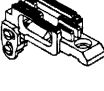
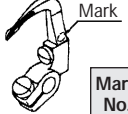

## MS-1261/V045 (for extra heavy-weight materials)



		1	2	3	4	5
Description		Gauge set (with finger guard)	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog asm.
Needle gauge size						
Code	Size					
E	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
H	8.0mm (5/16")	129-53568	129-53501	129-56553	129-60365	129-63658
K	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			
Description		Looper (L)	Looper (R)	Looper (C)	Description		Gauge set	Throat plate	Feed dog asm.			
Needle gauge size		 Mark	 Mark	 Mark	Needle gauge size							
Code	Size				Code	Size						
E	5.6mm (7/32")	129-68558	1	129-68855	1	129-69150	1	E	5.6mm (7/32")	129-72253	129-72204	129-74259
F	6.4mm (1/4")	↑	1	↑	1	↑	1	F	6.4mm (1/4")	129-72154	129-72105	129-74150
G	7.2mm (9/32")	↑	1	↑	1	↑	1	G	7.2mm (9/32")	129-72352	129-72303	129-74358
H	8.0mm (5/16")	129-68657	2	129-68954	2	↑	1	H	8.0mm (5/16")	129-72451	129-72402	129-74457
K	9.5mm (3/8")	↑	2	↑	2	↑	1	K	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		Gauge set (with finger guard)	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog asm.	Looper (L)	Looper (R)			
Needle gauge size							 Mark	 Mark			
Code	Size										
MS-1260/V045	D	4.8mm (3/16")	129-77963	129-77906	129-25954	129-78268	129-78755	129-79258	3	129-79357	2
MS-1261/V045	E	5.6mm (7/32")		129-72907			129-75058				
	F	6.4mm (1/4")		129-72808			129-74952				
	G	7.2mm (9/32")		129-73004			129-75157				
	H	8.0mm (5/16")		129-73103			129-75256				
	K	9.5mm (3/8")		129-73202			129-75355				

		8	9
Description		Looper (C)	Thread guide
Needle gauge size			
Code	Size		
MS-1260/V045	D	4.8mm (3/16")	B1130-051-000
MS-1261/V045	E	5.6mm (7/32")	↑
	F	6.4mm (1/4")	↑
	G	7.2mm (9/32")	↑
	H	8.0mm (5/16")	↑
	K	9.5mm (3/8")	↑

10. Spacer for presser				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	↑	2
③	0.8	129-73707	Adjusting plate D	SS-5060410SP	2
④	1.0	129-62106	Adjusting plate A	↑	2
⑤	1.2	129-73806	Adjusting plate E	↑	2

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						
Code	Size					
E	5.6mm (7/32")					
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
H	8.0mm (5/16")	129-73178	129-73103	129-56553	129-60381	129-75256
K	9.5mm (3/8")	129-73277	129-73202	129-56652	129-60480	129-75355

		6	7	8			
Description		Looper (L)	Looper (R)	Looper (C)			
Needle gauge size							
Code	Size						
		Mark No.	Mark No.	Mark No.			
E	5.6mm (7/32")	129-68558	1	129-68855	1	129-69150	1
F	6.4mm (1/4")	↑	1	↑	1	↑	1
G	7.2mm (9/32")	↑	1	↑	1	↑	1
H	8.0mm (5/16")	129-68657	2	129-68954	2	↑	1
K	9.5mm (3/8")	↑	2	↑	2	↑	1

		1	2	3
Description		Folder asm.		
Needle gauge size		M297	M298	M299
Mark		MH	H	XH
Code	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
H	8.0mm (5/16")	MAM-2970GGBA	MAM-2980DDBA	MAM-2990DDBA
K	9.5mm (3/8")	MAM-2970HHBA	MAM-2980EEBA	MAM-2990EEBA

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
Description		Roller asm.	
Needle gauge size		Steel roller	Urethane roller
Code	Size		
D	4.8mm (3/16")	MAV-045450A0	MAV-045500B0
E	5.6mm (7/32")	↑	↑
F	6.4mm (1/4")	↑	↑
G	7.2mm (9/32")	↑	↑
H	8.0mm (5/16")	↑	↑
K	9.5mm (3/8")	↑	↑

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)

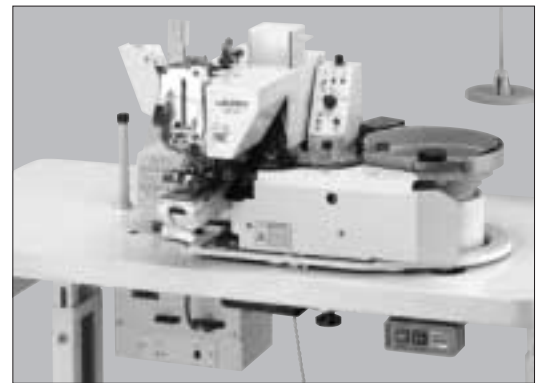
- The machine has 55 different stitching patterns as standard. In addition to the sewing shapes, the buttonhole intervals and number of stitches can also be changed on the operation panel. The machine completely supports many different button specifications to increase its range of applicability, reduce 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-tension-changeover "thread-fray-prevention function." Since the machine is designed to use a long needle (TQ x 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-1800B

**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 be 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	1,800rpm		
Amount of feed	Crosswise feed 0 ~ 10mm/Lengthwise feed 0 ~ 6.5mm		Crosswise feed 0 ~ 4.0mm/Lengthwise feed 0 ~ 4.0mm
Applicable button	<b>Type:</b> Round-shaped flat button <b>Size:</b> 10 ~ 28mm <b>Attachment:</b> • For small button ( 10 ~ 12mm) • For medium button ( 12 ~ 20mm) • For large button ( 20mm or more) <b>Thickness:</b> 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.		<b>Type:</b> Round-shaped flat button <b>Size:</b> 9 ~ 26mm • Machines can be custom ordered for the sewing of button diameters outside the standard range less than 10mm and less, 19mm and over. • For button of which diameter is 16mm or more, a button clamp jaw lever for large buttons has to be used. <b>Thickness:</b> 1.8 ~ 3.5mm
	<b>Type:</b> Shank button, wrapped-around button, snap, metal button, stay button, label (exclusive attachments have to be used.)		
Stitching shape			
Wiper unit	Options	Provided as standard	
Lift of the button clamp	Max. 14mm		
Needle bar stroke	48.6mm		
Needle (at the time of delivery)	TQ x 7 (#16) #14 ~ #20		
Feed system	By stepping motor		
Knot-tying mechanism	Provided as standard		
Lubrication	No lubrication		
Discrimination of button to be feed			Vibration system
Button feed			By the horizontal, forced feed mechanism
Button feed mode			Automatic feed mode, non-feed mode, and small-lot sewing mode
Power requirement	Single-phase 220 ~ 240V, 100 ~ 120V (by changing over the PWB connector)		Single-phase 100V, 115V, 200V, 220V, 240V
Power consumption	150W		250W
Weight	Machine head, circuit board 25kg		Machine head, circuit board + control box for BR + device + table 56.5kg

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

## WHEN YOU PLACE ORDERS

### ● Machine head, Circuit board



Specification	Code	Attachment	Code
Without a wiper unit	S	For flat button (small)	
With a wiper unit	B	For flat button (medium)	M

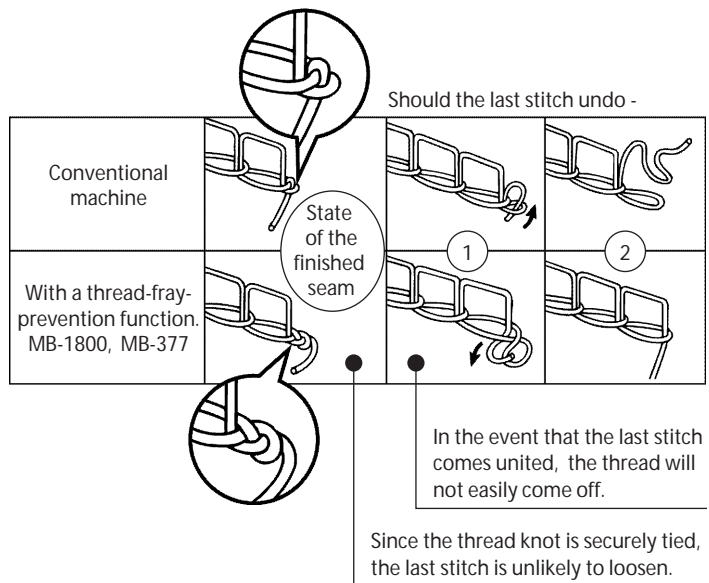
## OPTIONS

Model	Part No.	Description	Feature
	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. (Part No.: M9013-590-0A0)
PK-57	GPK-570010B0	2-step pedal unit for standing work	

## PATTERN DATA TABLE

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

## DIFFERENCE IN KNOT-TYING METHOD



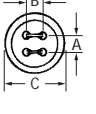
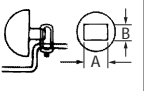



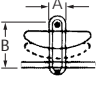


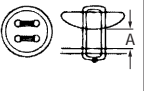




● Attaching flat button (small)



● Space pin (accessory)

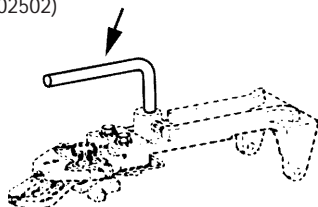
\* For all stitch shapes, three different pieces of data can be established by selecting the number of stitches and stitch pitch within the respective data setting ranges.

# ATTACHMENT TABLE

Application		Sketch		For MB-1800	For MB-373	For MB-377	
For flat button	Small- to large-button thickness 5.0mm	Left		Button size A: 0 ~ 6.5mm B: 0 ~ 6.5mm C: 10 ~ 28mm	D2556-372-CAA	← Common	← Common
		Right		Button size A: 0 ~ 6.5mm B: 0 ~ 6.5mm C: 10 ~ 28mm	D2558-372-CAA	←	←
	Large-button thickness 3.5mm			Button size A: 0 ~ 6.5mm B: 0 ~ 6.5mm C: 20 ~ 28mm	146-17559	MAZ-031000AA *	MAZ-201010A0 *
	Medium-button thickness 3.5mm			Button size A: 0 ~ 4.5mm B: 0 ~ 4.5mm C: 12 ~ 20mm	D2529-373-B00A	←	←
Small-button thickness 3.5mm		Button size A: 0 ~ 3.5mm B: 0 ~ 3.5mm C: 10 ~ 12mm	B2529-373-000	←	←		
For shank button			Button diameter: 16mm or less Shank size A: 5 ~ 6mm B: 2.5 ~ 3mm	146-17658	B2401-373-0BA *	Not prepared	
			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 *		
For wrapped-around button	1st process		Button-to-material distance A: 5.5mm	B2447-372-0A0	←		
			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	←		
	2nd process			B2440-373-0A0	←		
			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 button			To be used in combination with the B2447-372-0A0 or 141-34050. For the 141-34050 A: 3.5mm or more	MAZ-039010A0	←		
For label attaching			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).

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

## WHEN YOU PLACE ORDERS

● Machine head, Circuit board: with a button feeder

**MB-1800A**  / **BR10**

Attachment	Code	Power supply		Code
For flat button (small)	M	For General Export	100 ~ 240V	A
For flat button (medium)		For CE	220 ~ 240V	C

Feed plate	Code
Standard 16 (For small-button)	M
22 (For medium-button)	

## 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

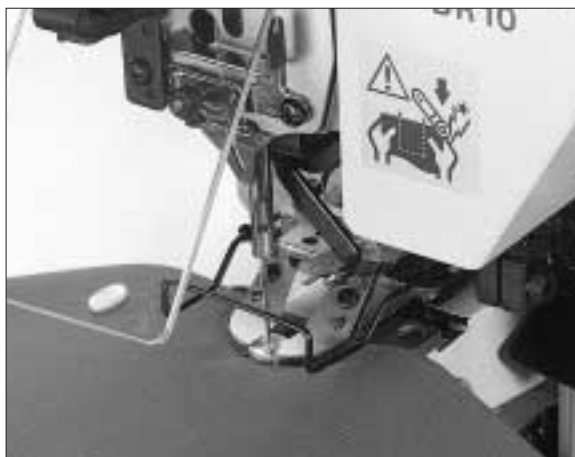
## SHAPE OF BUTTON

	Applicable button	Inapplicable carrier
Shape of button		
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







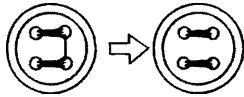



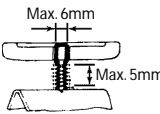

Configuration of button carrier							
For 4-holed button				For 2-holed button			
Distance A (mm): Distance between holes in button	Distance B (mm): Diameter of set pin	Part No.	Code	Distance A (mm): Distance between holes in button	Distance B (mm): Diameter of set pin	Part No.	Code
<b>Standard</b>							
2.6	1.0	165-57902	A	3.2	1.2	165-58009	B
<b>Optional</b>							
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	T	2.4	1.2	165-87909	L
2.6	1.2	165-88709	U	2.6	1.0	165-87602	H
2.8	1.2	165-88808	V	2.6	1.2	165-88006	M
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	K
3.1	1.2	165-89004	X	3.0	1.2	165-88204	P
3.1	1.4	165-89202	Z	3.8	1.2	165-87107	C
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





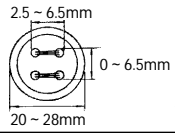
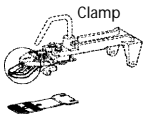
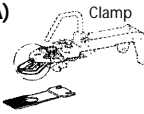
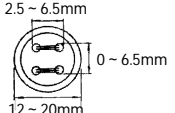
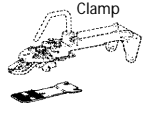
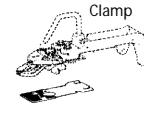
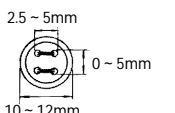
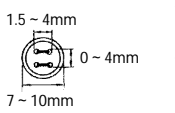
## TABLE OF MB-372 & 373 SERIES

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

	Button size in common with the attachments of MB-372 series & MB-373 series	Attachments for MB-372 series	Attachments for MB-373 series
Large flat button		<b>Z001 (MAZ-00100-00A)</b> Attachment for sewing large button 	<b>Z031 (MAZ-03100-0AA)</b> Attachment for sewing large button 
Medium size flat button		<b>Z002 (D2529-372-B00)</b> Attachment for sewing medium size button 	<b>Z032 (D2529-373-B00)</b> Attachment for sewing medium size button 
Small flat button	 <p>This size buttons are sewn without attachments.</p>	<b>Standard clamp</b>	<b>Standard clamp</b>
Extremely small flat button	 <p>This size buttons can be sewn only by MB-372-16 without attachments. [Exclusive machines for this button size]</p>		

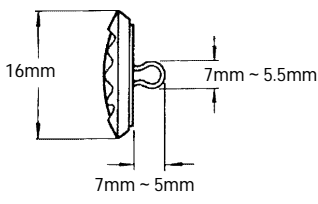
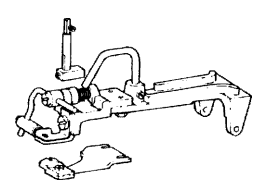
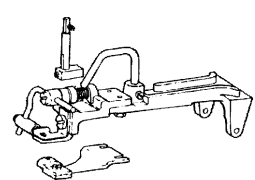
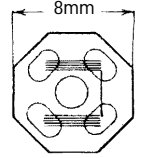
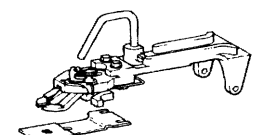
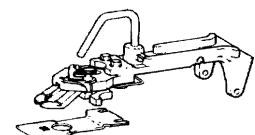
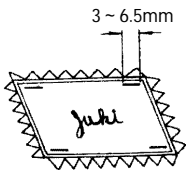
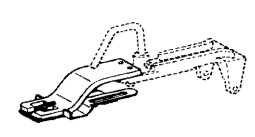
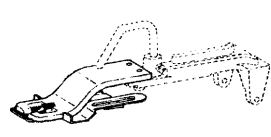
## ■ Wrapped-around button

	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		<b>Z004 (B2447-372-0A0)</b> Attachment for sewing wrapped-around button (first process)	<b>Z004 (B2447-372-0A0)</b> Attachment for sewing wrapped-around button (first process) (In common with MB-372 series)
Wrapped-around button (first process) (Note) Distance between the cloth and button is adjustable	<p>A: 9 ~ 12mm (Z011) 9 ~ 18mm (Z041) A: 9 ~ 12mm (Z099)</p>	<b>Z011 (MAT-61100ZA0)</b> Attachment for sewing wrapped-around button (first process) <b>Z099 (131-34050)</b> Attachment for sewing wrapped-around button (first process)	<b>Z041 (MAZ-041010A0)</b> Attachment for sewing wrapped-around button (first process)
Wrapped-around button with stay button (first process)		<b>Z009 (MAT-60901ZA0)</b> Clamp Use this attachment in combination with Z004, Z011 or Z041.	<b>Z039 (MAZ-0390100A0)</b> Use this attachment in combination with Z004 or Z041.
Wrapped-around button with or without stay button (second process)	<p>* 25mm in case of (A) 23mm in case of (B) Cross section of button (A) (B)</p>	<b>Z005 (B2440-372-0A0)</b> Attachment for sewing wrapped-around button (second process)	<b>Z035 (B2440-373-0A0)</b> Attachment for sewing wrapped-around button (second process)
Wrapped-around button (second process)		<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.		<b>Z172 (MAZ-172000A0)</b> For flat button and button with neck wrap (first process)	

## ■ 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	<p>Possible sewing sizes of A : B A=6mm, B=3mm or A=5mm, B=2.5mm</p>	<b>Z003 (B2401-372-0BA)</b> Attachment for sewing shank button	<b>Z033 (B2401-373-0BA)</b> 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.		<b>Z010 (MAZ-010000AA)</b> Attachment for sewing shank button	<b>Z040 (MAZ-040000AA)</b> Attachment for sewing shank button
Button with a shank A: 5mm A clearance provided between the material and button is small.		<b>Z010B (MAZ-010001AA)</b> Attachment for sewing shank button	<b>Z040B (MAZ-04000BAA)</b> Attachment for sewing shank button
















■ Metal button, Snap & Label

	Button size in common with the attachments of MB-372 series & MB-373 series	Attachments for MB-372 series	Attachments for MB-373 series
Metal button		<b>Z008 (B2520-372-0AA)</b> Attachment for sewing metal button 	<b>Z038 (B2420-373-0AA)</b> Attachment for sewing metal button 
Snap		<b>Z007 (B2552-372-BAA)</b> Attachment for sewing snap 	<b>Z037 (B2552-373-BAA)</b> Attachment for sewing snap 
Label		<b>Z014 (MAT-61401ZBA)</b> Attachment for sewing label 	<b>Z044 (MAT-64401ZBA)</b> Attachment for sewing label 

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
Small button 	MB-372	MB-373	8,16 or 32		
	MB-372-4	MB-373-4	6,12 or 24		
	MB-372-5	MB-373-5	6,12 or 24		
	MB-372-6	MB-373-6	6,12 or 24		
	MB-372-10	MB-373-10	8,16 or 32		
	MB-372-11	MB-373-11	8,16 or 32		
	MB-372-12	MB-373-12	8,16 or 32		
	MB-372-14	MB-373-14	8,16 or 32		
	MB-372-17	MB-373-17	18, or 36		
	MB-372/Z025/AO14	MB-373/Z025/AO14	8,16 or 32		
	MB-372-10/Z025/AO14	MB-373-10/Z025/AO14			
	MB-372-4/Z025/AO14	MB-373-4/Z025/AO14	6,12 or 24		
	MB-372-5/Z025/AO14	MB-373-5/Z025/AO14			
	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		



■ Flat button

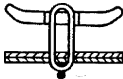
















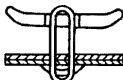
















	MB-372	MB-373	Number of stitches	Stitch shape	Remarks
Medium size button 	MB-372/Z002	MB-373/Z032	8,16 or 32		
	MB-372-4/Z002	MB-373-4/Z032	6,12 or 24		
	MB-372-5/Z002	MB-373-5/Z032	6,12 or 24		
	MB-372-6/Z002	MB-373-6/Z032	6,12 or 24		
	MB-372-10/Z002	MB-373-10/Z032	8,16 or 32		
	MB-372-11/Z002	MB-373-11/Z032	8,16 or 32		
	MB-372-12/Z002	MB-373-12/Z032	8,16 or 32		
	MB-372-14/Z002	MB-373-14/Z032	8,16 or 32		
	MB-372-17/Z002	MB-373-17/Z032	18 or 36		
	MB-372/Z002/Z025/AO14	MB-373/Z032/Z025/AO14	8,16 or 32		
	MB-372-10/Z002/Z025/AO14	MB-373-10/Z032/Z025/AO14			
	MB-372-4/Z002/Z025/AO14	MB-373-4/Z032/Z025/AO14	6,12 or 24		
	MB-372-5/Z002/Z025/AO14	MB-373-5/Z032/Z025/AO14			
	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		
Large button 	MB-372/Z001	MB-373/Z031	8,16 or 32		
	MB-372-4/Z001	MB-373-4/Z031	6,12 or 24		
	MB-372-5/Z001	MB-373-5/Z031	6,12 or 24		
	MB-372-6/Z001	MB-373-6/Z031	6,12 or 24		
	MB-372-10/Z001	MB-373-10/Z031	8,16 or 32		
	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	8,16 or 32		
	MB-372-10/Z001/Z025/AO14	MB-373-10/Z031/Z025/AO14			
	MB-372-4/Z001/Z025/AO14	MB-373-4/Z031/Z025/AO14	6,12 or 24		
	MB-372-5/Z001/Z025/AO14	MB-373-5/Z031/Z025/AO14			
	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		

■ Extremely small flat button

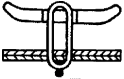














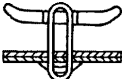














Extremely small flat button 	MB-372-16	MB-373-16	8,16 or 32		
	MB-372-16/Z025/AO14	MB-373-16/Z025/AO14	8,16 or 32		
Wrapped-around button (first process)	MB-372-16/Z004	MB-373-16/Z004	8,16 or 32		Distance between the cloth and button is not adjustable
	MB-372-16/Z172	MB-373-16/Z172	8,16 or 32		
	MB-372-16/Z004/Z025/AO14	MB-373-16/Z004/Z025/AO14	8,16 or 32		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		

■ Wrapped-around button

● Medium size

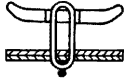









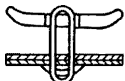









	MB-372	MB-373	Number of stitches	Stitch shape	Remarks
Medium size wrapped-around button (first process)  	MB-372/Z002/Z004	MB-373/Z032/Z004	8,16 or 32		Distance between the cloth and button is not adjustable.
	MB-372-4/Z002/Z004	MB-373-4/Z032/Z004	6,12 or 24		
	MB-372-5/Z002/Z004	MB-373-5/Z032/Z004	6,12 or 24		
	MB-372-6/Z002/Z004	MB-373-6/Z032/Z004	6,12 or 24		
	MB-372-10/Z002/Z004	MB-373-10/Z032/Z004	8,16 or 32		
	MB-372-11/Z002/Z004	MB-373-11/Z032/Z004	8,16 or 32		
	MB-372-12/Z002/Z004	MB-373-12/Z032/Z004	8,16 or 32		
	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		Distance between the cloth and button is adjustable.
	MB-372-10/Z002/Z011, Z041	MB-373-10/Z032/Z011, Z041	8,16 or 32		
	MB-372/Z002/Z011, Z041/Z025/AO14	MB-373/Z032/Z011, Z041/Z025/AO14	8,16 or 32		
	MB-372-10/Z002/Z011, Z041/Z025/AO14	MB-373-10/Z032/Z011, Z041/Z025/AO14			
	MB-372-4/Z002/Z011, Z041/Z025/AO14	MB-373-4/Z032/Z011, Z041/Z025/AO14	6,12 or 24		
	MB-372-5/Z002/Z011, Z041/Z025/AO14	MB-373-5/Z032/Z011, Z041/Z025/AO14			
	MB-372-11/Z002/Z011, Z041/Z025/AO14	MB-373-11/Z032/Z011, Z041/Z025/AO14	8,16 or 32		
	Medium size wrapped-around button with stay button (first process)  	MB-372/Z004/Z009	MB-373/Z004/Z039	8,16 or 32	
MB-372-4/Z004/Z009		MB-373-4/Z004/Z039	6,12 or 24		
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		
MB-372-11/Z004/Z009		MB-373-11/Z004/Z039	8,16 or 32		
MB-372-12/Z004/Z009		MB-373-12/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/Z009/Z011, Z041		MB-373-5/Z039/Z011, Z041	6,12 or 24		Distance between the cloth and button is adjustable.
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	8,16 or 32		
MB-372-10/Z009/Z011, Z041/Z025/AO14		MB-373-10/Z039/Z011, Z041/Z025/AO14			
MB-372-4/Z009/Z011, Z041/Z025/AO14		MB-373-4/Z039/Z011, Z041/Z025/AO14	6,12 or 24		
MB-372-5/Z009/Z011, Z041/Z025/AO14		MB-373-5/Z039/Z011, Z041/Z025/AO14			
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
<p>Large size wrapped-around button (first process)</p> 	MB-372/Z001/Z004	MB-373/Z031/Z004	8,16 or 32		Distance between the cloth and button is not adjustable.
	MB-372-4/Z001/Z004	MB-373-4/Z031/Z004	6,12 or 24		
	MB-372-5/Z001/Z004	MB-373-5/Z031/Z004	6,12 or 24		
	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		
	MB-372-11/Z001/Z004	MB-373-11/Z031/Z004	8,16 or 32		
	MB-372-12/Z001/Z004	MB-373-12/Z031/Z004	8,16 or 32		
	MB-372-14/Z001/Z004	MB-373-14/Z031/Z004			
	MB-37217/Z001/Z004	MB-373-17/Z031/Z004			Distance between the cloth and button is adjustable.
	MB-372-5/Z001/Z011, Z041	MB-373-5/Z031/Z011, Z041	6,12 or 24		
	MB-372-10/Z001/Z011, Z041	MB-373-10/Z031/Z011, Z041	8,16 or 32		
	MB-372/Z001/Z011, Z041/Z025/AO14	MB-373/Z031/Z011, Z041/Z025/AO14	8,16 or 32		
	MB-372-10/Z001/Z011, Z041/Z025/AO14	MB-373-10/Z031/Z011, Z041/Z025/AO14			
	MB-372-4/Z001/Z011, Z041/Z025/AO14	MB-373-4/Z031/Z011, Z041/Z025/AO14	6,12 or 24		
	MB-372-5/Z001/Z011, Z041/Z025/AO14	MB-373-5/Z031/Z011, Z041/Z025/AO14	8,16 or 32		
	MB-372-11/Z001/Z011, Z041/Z025/AO14	MB-373-11/Z031/Z011, Z041/Z025/AO14			
	<p>Large size wrapped-around button with stay button (first process)</p> 	MB-372/Z001/Z004/Z009	MB-373/Z031/Z004/Z039	8,16 or 32	
MB-372-4/Z001/Z004/Z009		MB-373-4/Z031/Z004/Z039	6,12 or 24		
MB-372-5/Z001/Z004/Z009		MB-373-5/Z031/Z004/Z039	6,12 or 24		
MB-372-6/Z001/Z004/Z009		MB-373-6/Z031/Z004/Z039	6,12 or 24		
MB-372-10/Z001/Z004/Z009		MB-373-10/Z031/Z004/Z039	8,16 or 32		
MB-372-11/Z001/Z004/Z009		MB-373-11/Z031/Z004/Z039	8,16 or 32		
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		Distance between the cloth and button is adjustable.
MB-372-5/Z001/Z009/Z011, Z041		MB-373-5/Z031/Z039/Z011, Z041	6,12 or 24		
MB-372-10/Z001/Z009/Z011, Z041		MB-373-10/Z031/Z039/Z011, Z041	8,16 or 32		
MB-372/Z001/Z009/Z011, Z041/Z025/AO14		MB-373/Z031/Z039/Z011, Z041/Z025/AO14	8,16 or 32		
MB-372-10/Z001/Z009/Z011, Z041/Z025/AO14		MB-373-10/Z031/Z039/Z011, Z041/Z025/AO14			
MB-372-4/Z001/Z009/Z011, Z041/Z025/AO14		MB-373-4/Z031/Z039/Z011, Z041/Z025/AO14	6,12 or 24		
MB-372-5/Z001/Z009/Z011, Z041/Z025/AO14		MB-373-5/Z031/Z039/Z011, Z041/Z025/AO14	8,16 or 32		
MB-372-11/Z001/Z009/Z011, Z041/Z025/AO14		MB-373-11/Z031/Z039/Z011, Z041/Z025/AO14			

■ Flat button and wrapped-around button (first process)


● Medium size

	MB-372	MB-373	Number of stitches	Stitch shape	Remarks
<p>Medium size wrapped-around button (first process)</p> 	MB-372/Z002/Z172	MB-373/Z032/Z172	8,16 or 32		Distance between the cloth and button is not adjustable.
	MB-372-4/Z002/Z172	MB-373-4/Z032/Z172	6,12 or 24		
	MB-372-5/Z002/Z172	MB-373-5/Z032/Z172	6,12 or 24		
	MB-372-6/Z002/Z172	MB-373-6/Z032/Z172	6,12 or 24		
	MB-372-10/Z002/Z172	MB-373-10/Z032/Z172	8,16 or 32		
	MB-372-11/Z002/Z172	MB-373-11/Z032/Z172	8,16 or 32		
	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	18 or 36		
<p>Medium size wrapped-around button with stay button (first process)</p> 	MB-372/Z009/Z172	MB-373/Z039/Z172	8,16 or 32		Distance between the cloth and button is not adjustable.
	MB-372-4/Z009/Z172	MB-373-4/Z039/Z172	6,12 or 24		
	MB-372-5/Z009/Z172	MB-373-5/Z039/Z172	6,12 or 24		
	MB-372-6/Z009/Z172	MB-373-6/Z039/Z172	6,12 or 24		
	MB-372-10/Z009/Z172	MB-373-10/Z039/Z172	8,16 or 32		
	MB-372-11/Z009/Z172	MB-373-11/Z039/Z172	8,16 or 32		
	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

<p>Large size wrapped-around button (first process)</p> 	MB-372/Z001/Z172	MB-373/Z031/Z172	8,16 or 32		Distance between the cloth and button is not adjustable.
	MB-372-4/Z001/Z172	MB-373-4/Z031/Z172	6,12 or 24		
	MB-372-5/Z001/Z172	MB-373-5/Z031/Z172	6,12 or 24		
	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		
	MB-372-11/Z001/Z172	MB-373-11/Z031/Z172	8,16 or 32		
	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		
<p>Large size wrapped-around button with stay button (first process)</p> 	MB-372/Z001/Z172/Z009	MB-373/Z031/Z172/Z039	8,16 or 32		Distance between the cloth and button is not adjustable.
	MB-372-4/Z001/Z172/Z009	MB-373-4/Z031/Z172/Z039	6,12 or 24		
	MB-372-5/Z001/Z172/Z009	MB-373-5/Z031/Z172/Z039	6,12 or 24		
	MB-372-6/Z001/Z172/Z009	MB-373-6/Z031/Z172/Z039	6,12 or 24		
	MB-372-10/Z001/Z172/Z009	MB-373-10/Z031/Z172/Z039	8,16 or 32		
	MB-372-11/Z001/Z172/Z009	MB-373-11/Z031/Z172/Z039	8,16 or 32		
	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
Medium and large size wrapped-around button (second process) 	MB-372/Z005	MB-373/Z035	8,16 or 32		
	MB-372-4/Z005	MB-373-4/Z035	6,12 or 24		
	MB-372-5/Z005	MB-373-5/Z035	6,12 or 24		
	MB-372-10/Z005	MB-373-10/Z035	8,16 or 32		
	MB-372-11/Z005	MB-373-11/Z035	8,16 or 32		
	MB-372-15/Z005	MB-373-15/Z005	16 or 32		
	MB-372-15/Z016	MB-373-15/Z046	16 or 32		

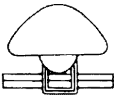
■ **Snap**


Snap 	MB-372/Z007	MB-373/Z037	8,16 or 32		
	MB-372-4/Z007	MB-373-4/Z037	6,12 or 24		
	MB-372-6/Z007	MB-373-6/Z037	6,12 or 24		
	MB-372-12/Z007	MB-373-12/Z037	8,16 or 32		
	MB-372-16/Z007	MB-373-16/Z037	8,16 or 32		
	MB-372/Z007/Z025/AO14	MB-373/Z037/Z025/AO14	8,16 or 32		
	MB-372-4/Z007/Z025/AO14	MB-373-4/Z037/Z025/AO14	6,12 or 24		
	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		
	MB-372-12/Z007/Z025/AO14	MB-373-12/Z037/Z025/AO14	8,16 or 32		

■ **Label**

Label 	MB-372/Z014	MB-373/Z044	8,16 or 32		
	MB-372-4/Z014	MB-373-4/Z044	6,12 or 24		
	MB-372-5/Z014	MB-373-5/Z044	6,12 or 24		
	MB-372-10/Z014	MB-373-10/Z044	8,16 or 32		
	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
Shank button 	MB-372/Z003	MB-373/Z033	8,16 or 32		Standardized button size
	MB-372-4/Z003	MB-373-4/Z033	6,12 or 24		
	MB-372-5/Z003	MB-373-5/Z033	6,12 or 24		
	MB-372-10/Z003	MB-373-10/Z033	8,16 or 32		
	MB-372-11/Z003	MB-373-11/Z033	8,16 or 32		
	MB-372-16/Z003	MB-373-16/Z033	8,16 or 32		
	MB-372/Z010	MB-373/Z040	8,16 or 32		A little different button size from the standardized size
	MB-372-4/Z010	MB-373-4/Z040	6,12 or 24		
	MB-372-5/Z010	MB-373-5/Z040	6,12 or 24		
	MB-372-10/Z010	MB-373-10/Z040	8,16 or 32		
	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		

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

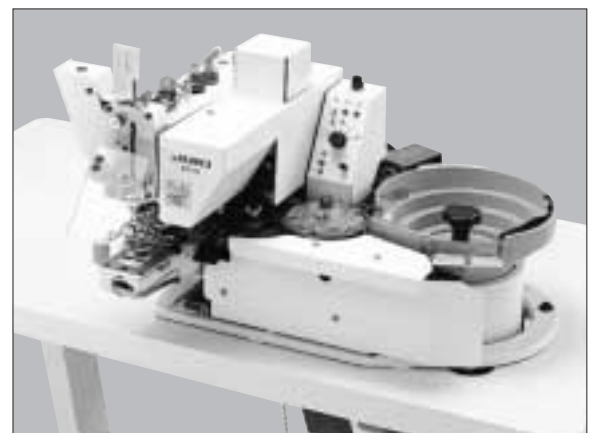
- The machine ties a secure knot to prevent the finished seam from coming undone from the last stitch. Since the knots are firmer than conventional ones, the hardly ever come undone. Even if the last stitch comes undone, the thread is not likely to come off, so the risk of losing buttons is dramatically reduced.
- Button-sewing specifications can be quickly switched 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 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 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	<b>Type:</b> Round-shaped flat button (2-holed, 4-holed) <b>Size:</b> 10 ~ 28mm <b>Thickness:</b> 1.8 ~ 3.5mm	<b>Type:</b> Round-shaped flat button (2-holed, 4-holed) <b>Size:</b> 9 ~ 26mm • A machine for button of which diameter is smaller than 10 or 19mm or more will be made to order. For button of which diameter is 16mm or more, a button clamp jaw lever for large buttons has to be used. • A machine for such buttons that the distance between holes in the button exceeds 3.8mm will be made to order. <b>Thickness:</b> 1.8 ~ 3.5mm
Lift of the button clamp	9mm	
Needle (at the time of delivery)	TQ x 1 (#16) #14 ~ #16	
Lubrication	By an 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

# MB-377

## WHEN YOU PLACE ORDERS

### ● Machine head

MB-377   /

Subclass models	Code	Button clamp unit	Code
8 and 16 stitches	/	For flat button (small)	/
8 and 16 stitches	10	For flat button (large)	Z201
8 and 16 stitches	11	For flat button (medium)	Z202

\* 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)

## ATTACHMENTS FOR FLAT BUTTON

For large button	
Z201	
Sketch	
Button size	A: 3 ~ 6.5mm B: 20 ~ 28mm

For medium-sized button	
Z202	
Sketch	
Button size	A: 3 ~ 5mm B: 12 ~ 20mm

# MB-377A/BR10

## WHEN YOU PLACE ORDERS

### ● Machine head

MB-377  /

Machine head	Code	Subclass models	Code
Exclusive machine head for BR10	A	8 and 16 stitches	/
		8 and 16 stitches	10
		8 and 16 stitches	11

### ● Button feeder

BR10

Power supply	Code	Feed plate	Code
100V, 115V, 200V, 220V, 240V	A	For small button (standard: 16mm)	/
220V, 240V, 380V, 415V, 440V	B	For medium-size button (22mm)	M



## 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
<b>Standard</b>							
2.6	1.0	165-57902	A	3.2	1.2	165-58009	B
<b>Optional</b>							
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	T	2.4	1.2	165-87909	L
2.6	1.2	165-88709	U	2.6	1.0	165-87602	H
2.8	1.2	165-88808	V	2.6	1.2	165-88006	M
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	K
3.1	1.2	165-89004	X	3.0	1.2	165-88204	P
3.1	1.4	165-89202	Z	3.8	1.2	165-87104	C
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

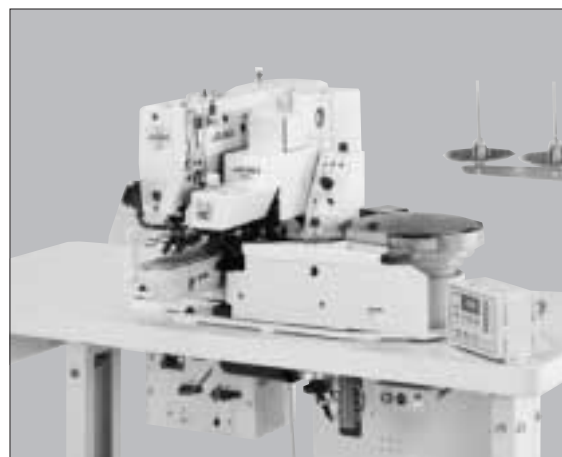
- The machine provides the maximum number of revolutions of 2,500rpm. This allows the machine to demonstrate the highest sewing performance as compared with the conventional lockstitch button sewing machines. The machine has been developed also to reduce the time required to lift/lower the button clamp 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.
- With its unique horizontally forced button-feed mechanism to eliminate button jamming due to static electricity, the machine is able to feed shell buttons to be attached to consistently garments without error.



LK-1903



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	Type: Round-shaped, flat button Size: 8 ~ 32mm (standard 10 ~ 20mm)	Type: Round-shaped, flat button (2-holed, 4-holed) 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.) Thickness: 1.8 ~ 3.5mm
Needle bar stroke	45.7mm	
Needle (at the time of delivery)	DP x 17 (#14)	
Hook	Standard shuttle 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. 10,000 stitches	
Enlarging/Reducing facility	20% ~ 200% (1% step), Pattern enlargement/reduction can be done by increasing/decreasing the stitch length	
Memory medium	EP-ROM	
Bobbin thread counter	Provided as standard (The bobbin thread counter can be changed 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 servomotor (direct-drive system)	
Weight	Machine head (include motor) 41kg, Control box 16.5kg	Total weight 133kg (Include optional stand leg)

# LK-1903

## WHEN YOU PLACE ORDERS

### ● Machine head

**LK-1903S**  -

Application	Code
Standard	S

Work clamp foot	Code
Electromagnetic	S
Pneumatic	A

Button clamp jaw lever	Code
For small button	301
For medium-size button	302
For large button	303
For extra-small button	304
For shank button	305

### ● Control box

**MC-590-**

Control box	Code
For sewing button	3
For sewing shank button	5

Power supply		Code
Single-phase	100 ~ 120V	C
	200 ~ 240V	K
	220 ~ 415V	R
3-phase	200 ~ 240V	D
	220 ~ 415V	L
	220 ~ 415V for JE (not provided with a power switch)	M

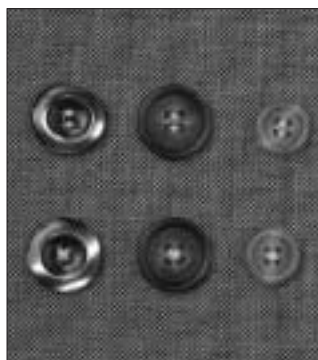
### ● Table stand: optional

**JT-K35**

\* The table stand is not equipped with casters.

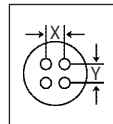
## OPTIONS

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 adjustable.



● Responds to various button sizes and sewing patterns.

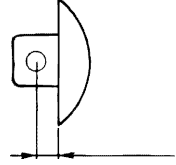
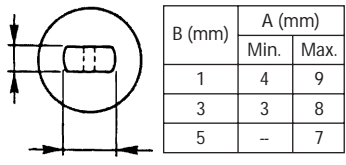
## SEWING PROGRAM TABLE



Program No.	Stitch shape	Sewing thread (pcs.)	Standard length X (mm)	Standard length Y (mm)
1 • 34		6-6	3.4	3.4
2 • 35		8-8		
3		10-10		
4		12-12		
5 • 36		6-6		
6 • 37		8-8		
7		10-10		
8		12-12		
9 • 38		6-6		
10 • 39		8-8		
11		10-10		
12 • 40		6-6		
13 • 41		8-8		
14		10-10		
15 • 42		6-6		
16 • 43		8-8		
17		10-10		
18 • 44		6	0	0
19 • 45		8		
20		10		
21		12		
22		16	0	3.4
23 • 46		6		
24		10		
25		12	3.4	3.4
26 • 47		6-6		
27		10-10		
28 • 48		6-6		
29		10-10	2.9	2.5
30 • 49		5-5-5		
31		8-8-8		
32 • 50		5-5-5		
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 x 3 (#14)																
Button configuration	Outside diameter	Diameter of hole in button	Position of hole in button	Configuration of shank													
	8 ~ 20	1.5 or more		 <table border="1" style="display: inline-table; vertical-align: middle;"> <thead> <tr> <th rowspan="2">B (mm)</th> <th colspan="2">A (mm)</th> </tr> <tr> <th>Min.</th> <th>Max.</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>4</td> <td>9</td> </tr> <tr> <td>3</td> <td>3</td> <td>8</td> </tr> <tr> <td>5</td> <td>-</td> <td>7</td> </tr> </tbody> </table>	B (mm)	A (mm)		Min.	Max.	1	4	9	3	3	8	5	-
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

Model name	LK-1903-301		LK-1903-302		LK-1903-303		LK-1903-304			
Button type	For small button		For medium-size button		For large button		For extra-small button			
Outside diameter that can be adjusted (mm)	10 ~ 20		10 ~ 20		15 ~ 32		8 ~ 9	9 ~ 10	10 ~ 15	
Sewing size (mm)	Length	0 ~ 3.5	0 ~ 4.5	0 ~ 4.5	0 ~ 6.5	0 ~ 6.5	0 ~ 2.5	0 ~ 3.0	0 ~ 3.5	
	width	0 ~ 3.5	0 ~ 4.5	0 ~ 4.5	0 ~ 6.5	0 ~ 6.5	0 ~ 2.5	0 ~ 3.0	0 ~ 3.5	
Button clamp jaw lever	Button neck height (mm)	1.7 (2.2) (2.7) (0.9)		2.0 (2.2) (2.7)		2.7 (3.2)		1.7 (2.2)		
		Part No.	Right	141-48852	K	141-49058	L	MAZ-157070BB	D	MAZ-158070BB
	(MAZ-155070B0)			B	(MAZ-155070B0)	B	(MAZ-157070BA)	E	(MAZ-158070BA)	F
	(MAZ-156070B0)			C	(MAZ-156070B0)	C	-	-	-	-
	* (B2555-3720A0)		-	-	-	-	-	-	-	
	Left		141-48951	K	141-49157	L	MAZ-157080BB	D	MAZ-158080BB	G
			(MAZ-155080B0)	B	(MAZ-155080B0)	B	(MAZ-157080BA)	E	(MAZ-158080BA)	F
		(MAZ-156080B0)	C	(MAZ-156080B0)	C	-	-	-	-	
* (B2557-372-0A0)	-	-	-	-	-	-	-			
Needle hole guide (mm)	A	1.6 (1.8) * (1.1)		1.6		1.4		1.6 (1.8)		
		3.5		3.5		3.5		2.8		
		1.6		2.0		2.0		1.6		
	Part No.	MAZ-15501000		MAZ-15601000		MAZ-15701000		MAZ-15801000		
		(141-49603)						(141-49900)		
* (D2426-284-Y00)		-								
Feed plate	MAZ-15502000 ( 8.5)		MAZ-15602000 ( 10)		MAZ-15702000 ( 12.5)		MAZ-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

### ● Machine head

**LK-1903SS-**

Application	Code
Standard	S

Work clamp foot	Code
Electromagnetic	S

Button clamp jaw lever	Code
For small button	311
For medium-size button	312

### ● Button feeder

**BR25**

Power supply		Code	Feed plate		Code
Single-phase	100 ~ 120V	C	For small button (standard: 16mm)		
	200 ~ 240V	K			
	220 ~ 415V	R	For medium-size button (22mm)		M
3-phase	200 ~ 240V	D			
	220 ~ 415V	L			
3-phase	220 ~ 415V (provided with an electromagnetic switch)	M			

## MODELS CLASSIFIED BY BUTTON SIZES

Model name	LK-1903-311/BR25		LK-1903-312/BR25		
Button type	For small button		For medium-size button		
Outside diameter that can be adjusted (mm)	10 ~ 15		12 ~ 18		
Sewing size (mm)	Length	0 ~ 3.5		0 ~ 4.5	
	width	0 ~ 3.5		0 ~ 4.5	
Button clamp jaw lever	Button neck height	1.7mm (2.2mm)		2.7mm	
		Part No.	Right	141-90458 (MAZ-165070B0)	P
Left			-	-	-
			-	-	-
Needle hole guide (mm)	Part No.	A	1.6 (1.8)		1.6
		B	3.5		3.5
	C	1.6		2.0	
		MAZ-15501000 (141-49603)		MAZ-15601000	
		-		-	
Feed plate		MAZ-15502000 ( 8.5)		MAZ-15602000 ( 10)	

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.

## SHAPE OF BUTTON

	Applicable button	Inapplicable carrier
Shape of button	1.2mm or more	1.2mm or less 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



## BUTTON CARRIER

Configuration of button carrier							
For 4-holed button				For 2-holed button			
A B				A B			
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
<b>Standard</b>							
2.6	1.0	165-57902	A	3.2	1.2	165-58009	B
<b>Optional</b>							
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	T	2.4	1.2	165-87909	L
2.6	1.2	165-88709	U	2.6	1.0	165-87602	H
2.8	1.2	165-88808	V	2.6	1.2	165-88006	M
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	K
3.1	1.2	165-89004	X	3.0	1.2	165-88204	P
3.1	1.4	165-89202	Z	3.8	1.2	165-87107	C
3.2	Tapered	165-89905	G1				
3.6	1.2	165-90705	H1				
4.0	1.2	165-89707	E1				

## 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 75-stitch 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 36-stitch 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



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		Normal 2,000rpm		
Sewing area	20mm (L) × 40mm (W)				30mm (L) × 30mm (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 × 17 (#19)	DP × 5 (#11)	DP × 5 (#11)	DP × 5 (#11)
Hook	Standard shuttle hook				
Input pattern	30 patterns are provided 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 data can be added.)				
Enlarging/Reducing facility	20 ~ 200% (1% step), Pattern enlargement/reduction can be done by increasing/decreasing the stitch length				
Bobbin thread counter	Provided as standard (The bobbin thread counter can be changed over to the No. of pcs. counter.)				
Memory medium	EP-ROM				
Lubrication	Centralized oil wick lubrication				
Lubricating oil	JUKI New Defrix Oil No. 2 (equivalent to ISO VG32)				
Sewing machine motor	400W compact AC servomotor (direct-drive system)				
Power consumption	500VA				
Weight	Machine head (include motor) 41kg, Control 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, 20, 21, 22*) Call-up of pattern numbers marked with an 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 patterns (For up to 64 patterns, sewing data can be added.)		
Enlarging/Reducing facility	20 ~ 200% (1% step), Pattern enlargement/reduction can be done by increasing/decreasing the stitch length		
Bobbin thread counter	Provided as standard (The bobbin thread counter can be changed over to the No. of pcs. counter.)		
Memory medium	EP-ROM		
Lubrication	Centralized oil wick lubrication		
Lubricating oil	JUKI New Defrix Oil No. 2 (equivalent to ISO VG32)		
Sewing machine motor	400W compact AC servomotor (direct-drive system)		
Power consumption	500VA		
Weight	Machine 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	Sewing size (mm)		(Note 2) No. of work clamp foot	
				Length-wise	Cross-wise		
Large bartacking	1		42	2.0	16	1	
						2	
						11	
		2		28	2.0	10	1
			2				
			11				
		3*		28	2.5	16	1
			7				
		4*		36	3.0	24	4
			6				
	5		56	2.0	10	1	
						2	
						11	
	6*		64	2.5	16	1	
						7	
	7		64	2.0	10	1	
						2	
						11	
	8*		56	2.5	16	1	
						7	
	9*		64	3.0	24	4	
						6	
	10*		21	2.5	6	4	
						6	
Small bartacking (eyelet buttonhole)	11		28	2.5	6	8	
	12					8	
	13					8	
Knit goods bartacking	14		21	2.0	8	5	
	15					5	
	16					5	

	No.	Stitch diagram	Number of stitches	Sewing size (mm)		(Note 2) No. of work clamp foot	
				Length-wise	Cross-wise		
Linear bartacking	17		28	0	10	1	
						2	
						11	
		18		41	0	25	1
			2				
			11				
	19		44	0	35	4	
		6					
	20		41	0	25	4	
						6	
						6	
	21		44	0	35	4	
						6	
	22		28	20	4.0	(Note 3)	
						28	
Lengthwise bartacking	23	(Top)  (Bottom)	56	20	4.0	3, 9	
	24	(Top)  (Bottom)					
	25	(Top)  (Bottom)					
	26	(Top)  (Bottom)					
Lengthwise linear bartacking	27	(Top)  (Bottom)	21	10	0	10	
	28	(Top)  (Bottom)					
	29	(Top)  (Bottom)					
	30	(Top)  (Bottom)					

(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.  
 3. For No. 22, modify the work clamp foot blank for use.  
 4. Use the patterns with \* marks for sewing denim.

# TABLE OF THE WORK CLAMP FOOT — LK-1900

## ● Provided as standard

	1	2	3	4	5
Work clamp foot	135-18659 (asm.)		135-71955 (asm.)	135-48151 (asm.)	135-42964 (asm.)
Feed plate	141-16107	141-16800 (without knurl)	141-16909 (without knurl)	135-54803	141-16206
Application code	S	F	F	H	M
* Finger guard	135-33104		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
Work clamp foot	135-48151 (asm.)	135-48557 (asm.)	135-42451 (asm.)	135-71955 (asm.)	135-61360 (asm.)	135-18659 (asm.)
Feed plate	135-48003	141-16305	141-16602	141-16503 (without knurl)	141-16701 (without knurl)	141-16404 (without knurl)
Application code	S	H	S	F	F	F
* Finger guard	135-48300	135-33104		135-73407		135-33104
Remarks	For extra-large bartacking	For small 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**

No.	Stitch diagram	Number of stitches	Sewing size (mm)		(Note 2) No. of work clamp foot
			Length-wise	Cross-wise	
Lengthwise bartacking	41  (Top) (Bottom)	29	20	2.5	12
	42  (Top) (Bottom)	39	25	2.5	
	43  (Top) (Bottom)	45	25	2.5	
	44  (Top) (Bottom)	58	30	2.5	
	45  (Top) (Bottom)	75	30	2.5	
	46  (Top) (Bottom)	42	30	2.5	

(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

● Options\*

	12	13
Work clamp foot	141-37509 (right) 141-37608 (left) 	141-37806 (right) 141-37905 (left) 
Feed plate	141-37707 (without knurl) 	141-38002 (without knurl) 
Application code	F	F
Finger guard	141-35305	141-35305
Remarks	Standard accessory for LK-1904F	For extra-large bartacking

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

**TABLE OF THE WORK CLAMP FOOT — LK-1902**

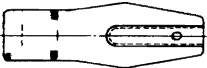
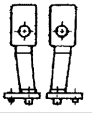

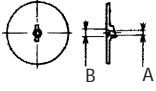
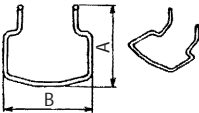
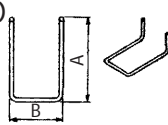
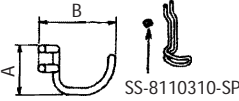
● Provided as standard

● Options

Work clamp foot	135-44465 	135-45660 	135-47161 	
Feed plate	141-43002 	135-45504 	135-45801 	135-47005 
Application code	S, H	S, H		
* Finger guard	135-44515			
Remarks	Feed plate patterns Nos. 17 and 18 provided as standard for LK-1902	135-45710 Pattern Nos. 19, 20, 21	135-47211 Pattern No. 22	

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

## OPTIONS

Name of parts	Type	Part No.
<b>Feed plate blank</b>  T = 1.2	Without knurl	141-20109
	With knuri	141-20307
	Without knurl/stainless steel t=0.8	141-20505
<b>Work clamp foot face plate (asm.)</b>  t = 3.2	Face plate for presser blank	141-21263
<b>Presser blank</b> 	With knurl/Processed (right)	141-21701
	With knurl/Processed (left)	141-21800
<b>Needle hole guide</b> 	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 relief slit For extra heavy-weight material	D2426-MMC-K00
<b>Finger guard (1)</b> 	A=56.5 B=64	135-33104
	A=59 B=74 For extra-large bartacking	135-48300
<b>Finger guard (2)</b> 	A=66.5 B=43 For lengthwise bartacking	135-73407
<b>Finger guard (3)</b>  SS-8110310-SP	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

### ● Machine head

LK-1900		LK-1904F		LK-1901S		LK-1902		Work clamp foot	
Application	Code	Application	Code	Application	Code	Application	Code	Work clamp foot	Code
Standard	S	For foundation	F	Standard	S	Standard	S	Electromagnetic	S
For heavy-weight materials	H					For heavy-weight materials	H	Pneumatic	A
For foundation	F								
For knit	M								

### ● Control box MC-590-

Control box		Power supply		Code
Standards (S, H, F types)				
For eyelet buttonhole	1	Single-phase	100 ~ 120V	C
For belt-loop-attaching	2		200 ~ 240V	K
M type (for knit)	4		220 ~ 415V	R
For lengthwise bartacking for foundation	6	3-phase	200 ~ 240V	D
			220 ~ 415V	L
			220 ~ 415V (not provided with a power switch)	M

### ● Table stand: optional JT-K

Table for model	Code
Standard (LK-1900, LK-1904, LK-1901)	35
For horizontal placement of head (LK-1902)	36

\* The table stand is not equipped with casters.

## 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

## 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 x 5 (#16) #11 ~ #16, For JE: 134 (Nm100) Nm75 ~ Nm160 <H, G type> Di x 3 #23, For JE: 332 Nm160
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

LK-185□□□-□□□U

Number of stitches	Code
42 stitches	0
28 or 14 stitches	2
36 stitches	3
42 or 21 stitches	4

Application	Code
Standard	/
For heavy-weight materials	H
For extra heavy-weight materials	G

Pedal	Code
One-pedal unit (provided with a pedal- pressure-decreasing unit)	/
Two-pedal unit (provided with a pedal- pressure-decreasing unit)	T
Two-pedal unit	P

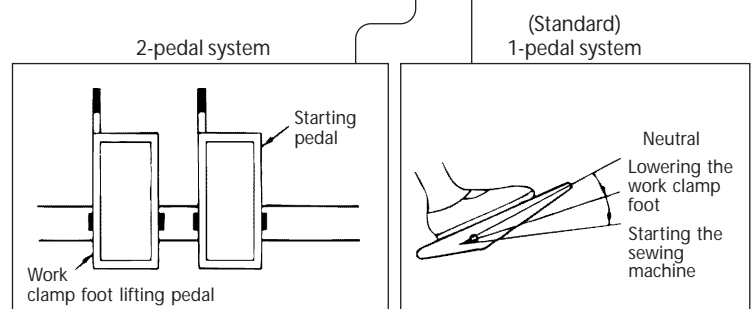
Subclass number
Refer to the subclass machines list

### \*1. Pedal-pressure-decreasing unit:

It mechanically actuates the pedal, to reduce operator's fatigue in raising the work clamp foot, etc. Since this is a mechanical feature, the operator cannot stop the work clamp foot at its intermediate position or lower it slowly.

### \*2. P type unit:

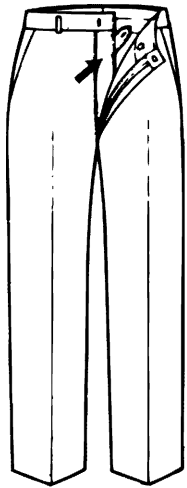
The work clamp foot is raised or lowered by the lever system in accordance with the amount of pedal depression. This feature is very advantageous for a process that requires accurate positioning of the material.



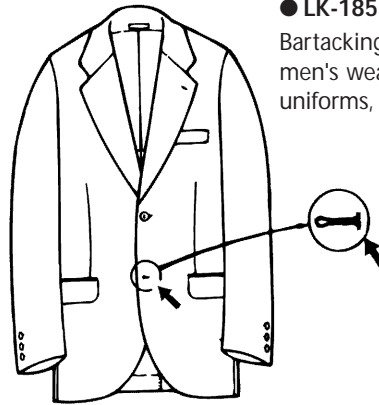
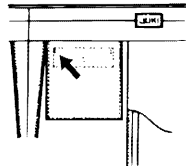
## SUBCLASS MACHINES

### ● LK-1850 series of bartacking machines

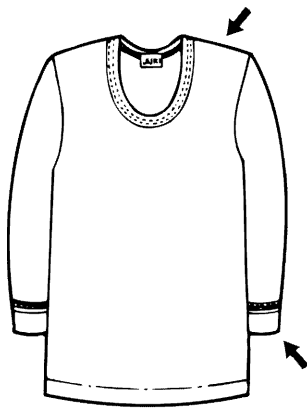
Model	Name	Number of stitches	Stitch diagram	Sewing size (mm)		Max. sewing speed (rpm)	Needle
				Lengthwise Standard (min. ~ max.)	Crosswise Standard (min. ~ max.)		
LK-1850	Large size bartacking machine	42		2.5 (1.5 ~ 3)	16 (8 ~ 16)	2,300	DP x 5 #14, #16 134 Nm160
LK-1852-5		28					
LK-1853-15		36					
LK-1854-24	Extra large bartacking machine	42		3 (1.5 ~ 3.5)	24 (12 ~ 24)	2,300	DP x 5 #14, #16 134 Nm160
LK-1852-2	Small size bartacking machine	28		2.5 (1.5 ~ 3)	8 (4 ~ 8)	2,300	DP x 5 #14, #16 134 Nm160
LK-1854-11		21					
LK-1852-1	Eyelet buttonhole bartacking machine	28		2.5 (1.5 ~ 3)	6 (4 ~ 8)	2,300	DP x 5 #14, #16 134 Nm160
LK-1854-4		21					
LK-1853-16		36					
LK-1852-3	Knit goods bartacking machine	28		2 (1.3 ~ 3)	6.5 (4 ~ 8)	2,000	DP x 5 #11 134 Nm75
LK-1854-6		21					
LK-1852-22		14					
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 x 5 #14 134 Nm160
LK-1854-12	Semicircular bartacking machine	42		7 (6 ~ 7)	10 (8.6 ~ 10)	2,000	DP x 5 #11 134 Nm75
LK-1854-10	Belt-loop attaching machine	21		0	14 (6.5 ~ 14)	2,300	DP x 5 #14, #16 134 Nm160
LK-1852-20		28		0	14 (6.5 ~ 14)	2,300	
LK-1852-30		28		0	25 (13 ~ 25)	2,300	
LK-1854-40		42		0	25 (18 ~ 25)	2,300	



- LK-1850      ● LK-1853-15
  - LK-1852-5   ● LK-1854-24
- Large bartacking for men's wear, ladies' wear, children's wear, work wear, jeans, etc.  
Various types of extra large bartacking
- LK-1852-2    ● LK-1854-11
- Small size bartacking for men's wear, coats, etc.

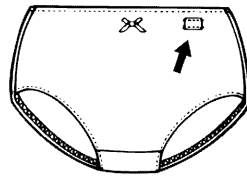


- LK-1852-1
  - LK-1854-4
  - LK-1853-16
- Bartacking eyelet buttonholes for men's wear, ladies' wear, school uniforms, coats, etc.

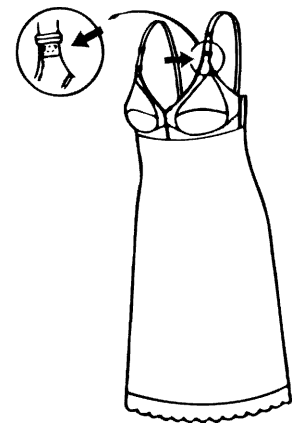


- LK-1852-3
- LK-1854-6
- LK-1852-22

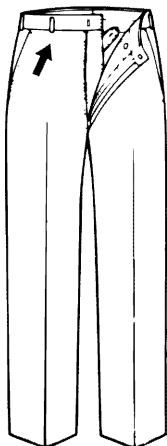
Bartacking for light-weight materials, including knit underwear.



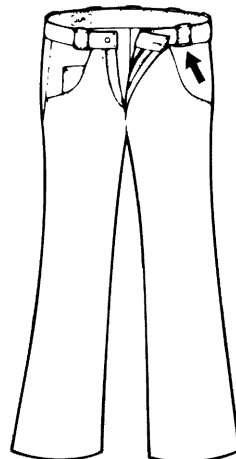
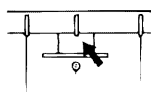
- LK-1854-8
- Attaching various kinds of labels.



- LK-1854-12
  - LK-1854-24
- Attaching straps to ladies' under gaments and semicircular bartacking on them.  
Various kinds of extra large bartacking.



- LK-1854-10
  - LK-1852-20
- Attaching belt-loops to various trousers and slacks.



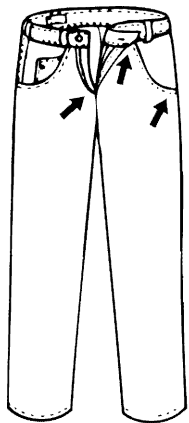
- LK-1852-30
  - LK-1854-40
- Attaching wide belt-loops to jeans, etc.

## SUBCLASS MACHINES

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

Model	Name	Number of stitches	Stitch diagram	Sewing size (mm)		Max. sewing speed (rpm)	Needle
				Lengthwise standard (Min. ~ Max.)	Crosswise standard (Min. ~ Max.)		
LK-1850H	Large size bartacking machine for heavy-weight materials	42		3 (1.5 ~ 3)	16 (8 ~ 16)	2,000	Di x 3 #23 332 Nm160
LK-1852H-5		28					
LK-1853H-15		36					
LK-1854H-24	Extra large bartacking machine for heavy-weight materials	42		3 (1.5 ~ 3)	24 (12 ~ 24)	2,000	Di x 3 #23 332 Nm160
LK-1850G	Large size bartacking machine for extra heavy-weight materials	42		3.5 (1.5 ~ 3.5)	16 (8 ~ 16)	2,000	Di x 3 #23 332 Nm160
LK-1852G-5		28					
LK-1853G-15		36					
LK-1854G-24	Extra large bartacking machine for extra heavy-weight materials	42		3.5 (1.5 ~ 3.5)	24 (12 ~ 24)	2,000	Di x 3 #23 332 Nm160

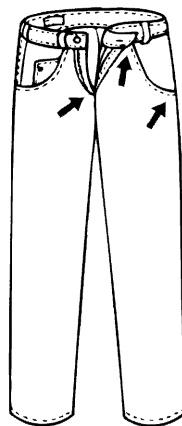
## APPLICATIONS



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

Large-size bartacking for heavy-weight materials, including jeans.

- LK-1854H-24
- Extra large bartacking for heavy-weight 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) x 100mm (W)

**LK-1910**

**LK-1920** (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-1920

**LK-1930** (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-1930

**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	2,500rpm (when stitch length is 3mm or less)					
Sewing area	60mm (L) x 100mm (W)					
Stitch length	0.1 ~ 10mm				0.1 ~ 12.7mm	
Needle bar stroke	41.2mm					
Lift of the feeding frame	Max. 22mm (electromagnetic), Max. 25mm (pneumatic)					
Lift of the intermediate presser	18mm					
Stroke of intermediate presser	Standard 4mm (0mm 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-capacity shuttle 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				Max. 360,000 stitches (Max. 20,000 stitches/pattern)	
Number of patterns that can be input	64 patterns				691 patterns	
Input function	Not provided				Provided as standard	
Enlarging/Reducing facility	20 ~ 200% (1% step) (by increasing/decreasing the stitch length)				1 ~ 400% (0.1% step) (by increasing/decreasing the stitch length or the number of stitches)	
Memory medium	EEP-ROM				2DD/2HD 3.5" micro-floppy disk (EEP-ROM can also be used.)	
Bobbin thread counter	Provided as standard					
Lubrication	Centralized oil wick lubrication					
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)					
Sewing machine motor	400W compact AC servomotor (direct-drive system)					
Power consumption	Single-phase, 3-phase 600W					
Weight	Machine head (include motor) 46kg, control box 16.5kg				Machine head (include motor) 46kg, control box 18kg	

## WHEN YOU PLACE ORDERS

### ● Machine head

LK-19         Z

Model		Code	Application	Code	Feeding frame	Code	Subclass	Code
Intermediate presser	Input function		Standard	S	Magnet-driven feeding frame	S	Standard	5000
Not provided	Not provided	10	For heavy-weight materials	H	Pneumatic separately driven feeding frame	A	Subclass	5001 ~
Provided	Not provided	20						
Provided	Provided	30						

### ● Control box

MC-59  -

Control box	Code
For LK-1910/LK-1920	2
For LK-1930	3

Specification	Control box	Code
For LK-1910 S: magnet-driven feeding frame	MC-592	1
For LK-1910 A: pneumatic separately driven feeding frame		2
For LK-1920 S: magnet-driven feeding frame		3
For LK-1920 A: pneumatic separately driven feeding frame		4
For LK-1930 S: magnet-driven feeding frame	MC-593	5
For LK-1930 A: pneumatic separately driven feeding frame		6

Pedal switch *	Code
1-pedal unit	F
3-pedal unit	B
PK 3-pedal unit (PK47)	D

\* Select "F" for the magnet-driven feeding frame, select and "B" or "D" for the pneumatic-driven feeding frame.

Power supply		Code
Single-phase	100 ~ 120V	C
	200 ~ 240V	K
	220 ~ 415V	R
3-phase	200 ~ 240V	D
	220 ~ 415V	L
Single-/3-phase	220 ~ 415V for CE (not provided with a power switch)	M

### ● Table stand: optional

JT-K

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: magnet-driven feeding frame	40
For LK-1930 A: pneumatic separately driven feeding frame	41

\* 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.

: Data that can be read in    × : Data that cannot be read in

Models used	Pattern data						
	For LK-1910 LK-1920	For LK-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.

## FEEDING FRAME INTERCHANGEABILITY




: Interchangeable    × : Not interchangeable

Models used	Part name	Model name				
		LK-1910/1920 /1930	For LK-1900	For AMS-206C	For AMS-210C (Resolution: 0.16mm)	For AMS-210C AMS-210D
LK-1910/1920/1930	Feeding frame		×	*		
	Feed plate		×	×	×	×

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



# OPTIONS

Model	Part No.	Description	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		Pneumatic inverted clamp device	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 controller No. 3	The tension controller unit is used to partially change the needle thread tension during the sewing of a pattern.	
	BT-0400251EB	Air tube		
	PV-150209000	Solenoid valve		
	142-04754	Solenoid valve connector asm.		
	142-24760	Thread-tension-releasing device	This device requires if you want to change the sewing position without performing thread trimming.	
	B9211-850-0A0	Silicon oil tank	This device prevents breakage of synthetic threads.	
	SS-7110840SP x 2	Setscrew		
PK-57	GPK-57001B0	1-pedal unit for standing work		
	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		
	B1601-210-D0CA	A=3.5, B=5.5, C=38.5		
	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		Monolithic feeding frame blank
	B2553-210-D0A	With knurl		
	B2554-210-D0A	Without knurl		Separately driven feeding frame blank
	B2554-210-D0B	With knurl (right)		
	B2554-210-D0C	With knurl (left)		
	142-24109	Without knurl		Feed plate
	142-24000	With knurl		
	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		

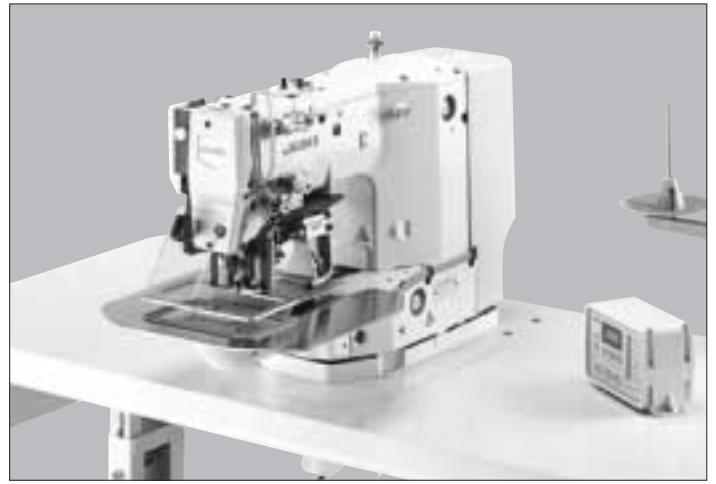
**Computer-controlled Shape-tacking Machine  
with a Full-rotary 3 fold-Capacity Hook**  
Sewing area: 60mm (L) × 100mm (W)

**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)

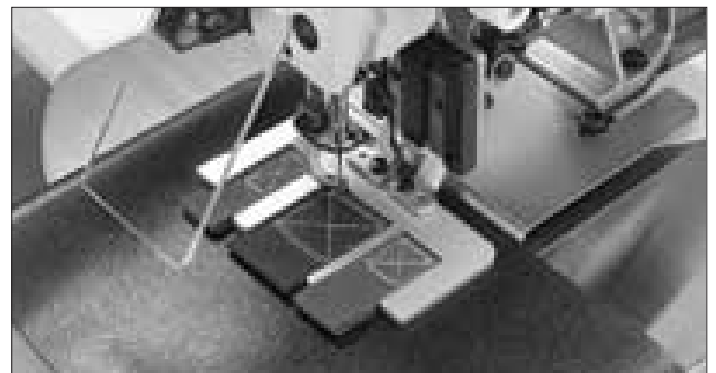
- With its new electronic feed system, the operator can select and use the sewing pattern entered. When changing a sewing pattern, the conventional mechanical bartacking machine requires the replacement of a feed cam. Since the new electronic machine no longer uses a feed cam, this operation is no longer 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

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	18mm		
Stroke of intermediate presser	Standard 4mm (0mm and 4 ~ 10mm)		
Heat cutter	Provided as standard	Option	
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 New Defrix Oil No.2 (equivalent to ISO VG32)		
Compressed air and air consumption	0.5MPa (5kgf/cm <sup>2</sup> ), 1.3Nl/min		
Sewing machine motor	480W compact AC servomotor (direct-drive system)		
Power consumption	Single-phase, 3-phase 600W		
Weight	Machine head (include motor) 46kg, Control box 16.5kg		
	Heater unit 3.5kg		

## WHEN YOU PLACE ORDERS

### ● Machine head

(with a heat cutter, without an intermediate presser)

LK-1941ZA □ □ □ □ Z

Application	Code
For extra heavy-weight materials with a heat cutter	Z

Subclass	Code
Standard	5000
Subclass	5001 ~

(without a heat cutter, with an intermediate presser)

LK-1942 □ A □ □ □ □ Z

Application	Code
For heavy-weight materials	H
For extra heavy-weight materials	G

Subclass	Code
Standard	5000
Subclass	5001 ~

### ● Control box

MC-594- □ □ F

Specification	Code
With a heat cutter (for LK-1941)	1
Without a heat cutter (for LK-1942)	2

Power supply		Code
Single-phase	200 ~ 240V	K
	200 ~ 240V	D
3-phase	220 ~ 415V	L
	220 ~ 415V for CE (not provided with a power switch)	M










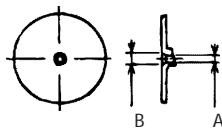
Pedal switch	Code
1-pedal unit	F

### ● Table stand: optional

JT-K35

\* The table stand is not equipped with casters.

## OPTIONS

Model	Part No.	Description	Feature
PGM-7		Handy programming 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	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	Thread tension controller No. 3	The tension controller unit is used to partially change the needle thread tension during the sewing of a pattern.
	BT-0400251-EB	Air tube	
	PV-150209000	Solenoid valve	
	142-04754	Solenoid valve connector asm.	
	B9211-850-0A0	Silicon oil tank	This device prevents breakage of synthetic threads.
	SS-7110840SP × 2	Setscrew	
	144-45050	Thread clamp device	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-releasing device	This device requires if you want to change the sewing position without performing thread trimming. (Only applicable to the LK-1942HA)
PK-47	GPK-470010AB	3-pedal unit	This 3 pedal unit is required if you want to use a double-step feeding frame.
	M9025-580-0A0	Junction cable	
	144-44202	Feed plate, blank 	Work clamp, blank for seatbelts Knurled blank, designed for seatbelts, for machining that prevents slippage of material more effectively than the standard one. Adjustable belt positioning guide can be used.
	144-44301	Belt positioning guide 	
	SM-9040603SC × 2	Setscrew	
	WP-0450826SC × 2	Washer of setscrew for guide	
	144-44004	Work clamp foot (right) 	
	144-44103	Work clamp foot (left) 	
	B2553-210-D0B	Without knurl 	Monolithic feeding frame blank
	B2553-210-D0A	With knurl	
	B2554-210-D0A	Without knurl 	Separately driven feeding frame blank
	B2554-210-D0B	With knurl (right)	
	B2554-210-D0C	With knurl (left)	
	142-24109	Without knurl 	Feed plate
	142-24000	With knurl	
	144-46009	Wiper 	Reverse sweeping wiper 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.
	144-45902	Wiper base 	
	144-39608	A=3.0, B=4.0 *H type For mechanical thread trimmer	Needle hole guide 
	144-39707	A=4.0, B=5.0 *G type For mechanical thread trimmer	
	144-40002	A=3 × 4.4 (elliptical), B=5.0 *Z type (standard) For heat cutter (for seatbelts)	
	144-39400	A=2.0, B=3.0 For mechanical thread trimmer	
	144-39509	A=2.3, B=3.3 For mechanical thread trimmer	
	144-40101	A=3 × 4.4 (elliptical), B=5.0 For mechanical thread trimmer (for seatbelts)	
	144-39806	A=3.0, B=4.0 For heat cutter	
	144-39905	A=4.0, B=5.0 For heat cutter	

## 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 x 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

### ● Machine head

# LBH-1700S

### ● Control box

# MC-600

Application	Code
Standard	S

Work clamp lifter	Code
Standard (2-pedal unit)	A*
Auto-lifter (magnet-driven type)	B
Auto-lifter (air-driven type)	C

\* The auto-lifter cannot be retrofitted to the machine.

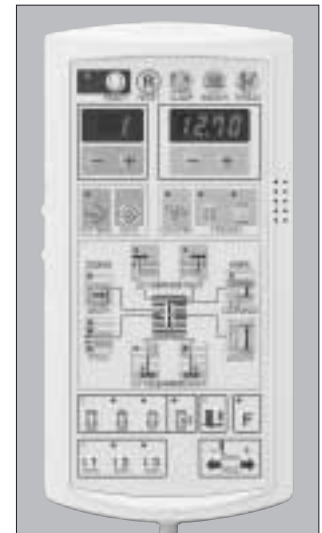
Power supply	Code
Single-phase	220 ~ 240V K
3-phase	220 ~ 240V D
	220 ~ 415V L
For CE Single-/3-phase 220V ~ 415V (Not provided with a power switch)	
	M

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

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.



Operation panel

### ● 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 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.
Q061	MAQ-06100-0A0	For ladies' blouses	
	B9402-771-000	For lateral buttonholes on the right front of the garment bodies	Buttonhole interval gauge A ruler used to place the next buttonhole at a predetermined interval relative to the previously finished buttonhole.
	B9402-771-00A	For lateral buttonholes on the left front of the garment bodies	
	B9401-761-000	For vertical buttonholes	
	G5001-198-0A0-A	Electric bobbin winder (asm.)	Can be mounted on the table for the operator's convenience.
	M8524-600-0A0	Power cord (asm.)	
	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.)	

## 1-needle, Lockstitch Buttonholing Machine

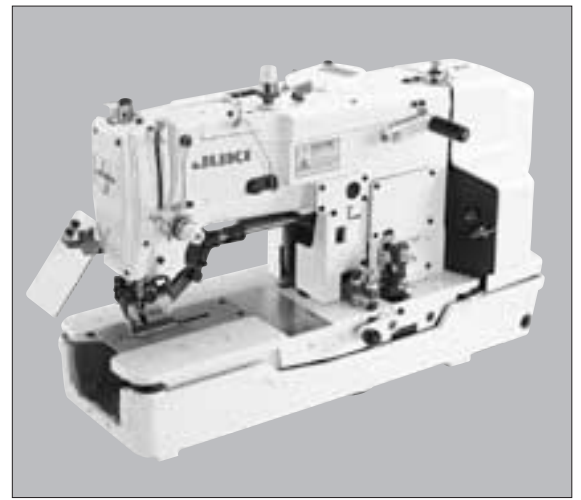
### LBH-780 SERIES

- 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 labor-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 gimp-cutting scissors and the needle scarcely changes when sewing multi-layered portions of the material, thus ensuring consistent gimp-cutting at any occasion.



LBH-782



LBH-782NB

## SPECIFICATIONS

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	Max. 3,300rpm, Normal 3,000rpm	
Needle bar stroke	34.6mm		
Max. lift of the work clamp	12mm	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)		
Length of buttonholes	6.4 ~ 38.1mm	9.5 ~ 38.1mm	11.5 ~ 38.1mm
Needle	DP × 5 #11J, For JE: 134 Nm75		
Hook	DP type, automatic-lubricating full-rotary hook		
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

### ● LBH-780 Series

LBH-78   U

Model		Code	Subclass machines		Code
Knife width	6.4 ~ 19.1mm	1	Standard	/	
	6.4 ~ 25.4mm	2	For knits		
	6.4 ~ 31.8mm	3			
	12.7 ~ 38.1mm	4			

### ● NV Type

LBH-78  NV

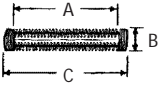




Model		Code	Stitch formation		Code
Knife width	9.5 ~ 25.4mm	2	Square-type bartacking	/	
	9.5 ~ 31.8mm	3	Round-type bartacking		
	12.7 ~ 38.1mm	4			

### ● NB Type

LBH-78  NB

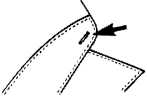
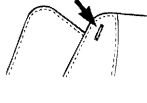
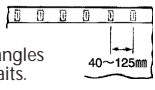
Model		Code	Stitch formation		Code
Knife width	11.5 ~ 25.4mm	2	Square-type bartacking	/	
	11.5 ~ 31.8mm	3	Round-type bartacking		
	12.7 ~ 38.1mm	4			

## LIST OF THE SUBCLASS MACHINES ACCORDING TO THEIR APPLICATIONS

Subclass models	Application		Buttonholing size (in mm)							
			A		B		C		D	
			6.4 ~ 19.1	6.4 ~ 25.4	6.4 ~ 31.8	12.7 ~ 38.1	2.5 ~ 4.0	2.5 ~ 5.0	2.5 ~ 5.0	2.5 ~ 5.0
		Stitch formation	C	Max. 22	C	Max. 33	C	Max. 40	C	Max. 47
Standard type	Men's shirts, blouses, working wear, ladies' wear		LBH-781U	LBH-782U	LBH-783U	LBH-784U				
K type: For Knits	Knitting fabric underwear, knit products including sweaters, cardigans and tights, medium-weight material including working wear.		LBH-781KU	LBH-782KU	LBH-783KU	LBH-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.			*1 LBH-782NV LBH-782NV1	*2 LBH-783NV LBH-783NV1	LBH-784NV LBH-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 LBH-783NB LBH-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

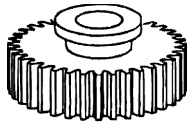
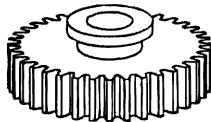
## OPTIONS

Model	Part No.	Description	Feature
Q060	MAQ-060000A0	Men's shirts 	Spacer for first buttonholes This is a ruler to be used to set the first buttonhole at a predetermined position in accordance with the shape of the collar.
Q061	MAQ-061000A0	Ladies' blouses 	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.
A017		Automatic single-pedal unit	






## EXCHANGING PARTS

### ● Table of changing gears

Small gear			Large gear	
				
Set	Stitch No.	Part No.	Stitch No.	Stitch No.
A	54	B2936-761-000	345	B2937-761-000
B	62	B2938-761-000	300	B2939-761-000
C	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
H	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
K	105	B2952-761-000	180	B2953-761-000
L	110	B2932-761-000	170	B2933-761-000
M	115	B2954-761-000	160	B2955-761-000
N	123	B2934-761-000	152	B2935-761-000
O	130	B2956-761-000	145	B2957-761-000

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

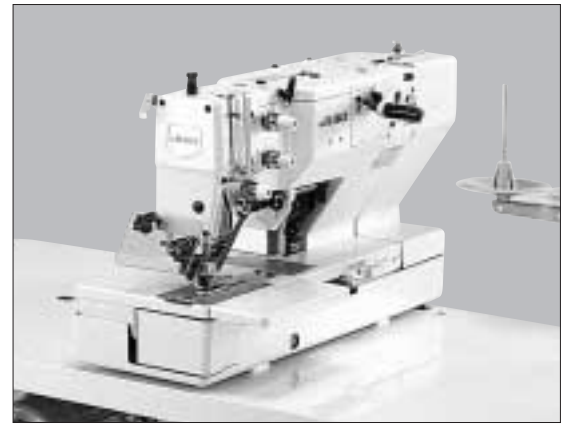
Knife			Work clamp check	Throat plate
A			B	C
				
No.	Size	Part No.	Part No.	Part No.
1	6.4mm (1/4")	B2702-047-F00	B1552-781-000-A	B2402-771-000
2	9.5mm (3/8")	B2702-047-K00		
3	12.7mm (1/2")	B2702-047-L00		
4	14.3mm (9/16")	B2702-047-V00		
5	15.9mm (5/8")	B2702-047-M00		
6	19.1mm (3/4")	B2702-047-N00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

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



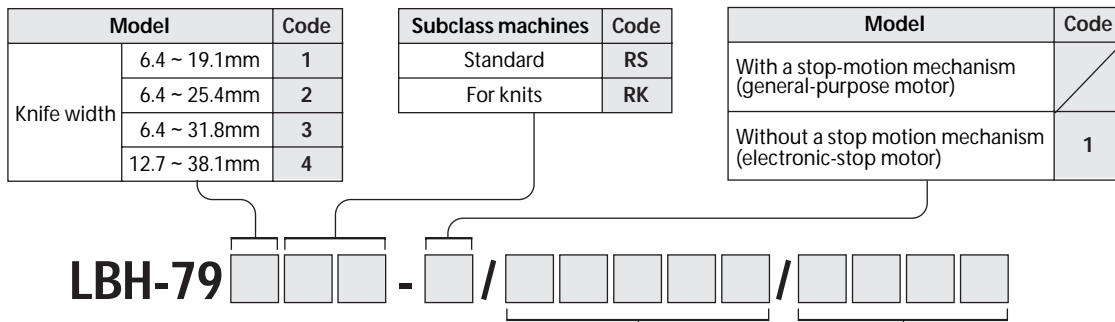
## SPECIFICATIONS

Model name	LBH-791R ~ LBH-794R	LBH-791R-1 ~ LBH-794R-1
Type	General-purpose motor type	Electronic-stop motor type
Sewing speed	Max. 4,000rpm (normal: 3,600rpm)	
Needle bar stroke	34.6mm	
Max. lift of the work clamp check	14mm	
Number of stitches	56 ~ 370 (by gear-change method)	
Buttonhole length	6.4 ~ 38.1mm (For the LBH-791 to 793 models, the buttonhole length can be changed by replacing the work clamp check. The LBH-794 is exclusively used for sewing large buttonholes.)	
Needle (at the time of delivery)	DP x 5 (#11J) #9 ~ #14	
Hook	DP type, Automatic-lubricating full-rotary hook	
Lubrication	Automatic	
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

Subclass models	Application		Buttonholing size (in mm)							
			A	6.4 ~ 19.1	A	6.4 ~ 25.4	A	6.4 ~ 31.8	A	12.7 ~ 38.1
RS type: Standard	Men's shirts, ladies' blouses, work uniforms and ladies' wear		B	2.0 ~ 4.0	B	2.0 ~ 5.0	B	2.0 ~ 5.0	B	2.0 ~ 5.0
			C	9.8 ~ 24.8	C	9.8 ~ 32.2	C	9.8 ~ 39.7	C	16.7 ~ 47.2
RS 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				
RK type: Knits	Knits including knitted underwear, sweaters, cardigans and tights and medium-weight garments including work uniforms.		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

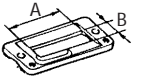
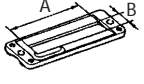
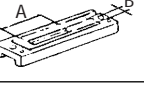
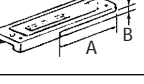
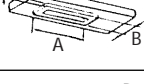





Motor				Control box (MC-50A)				Controller (MC-405)			
For General Export	Single-phase	100 ~ 115V	113	For General Export	Single-phase	100 ~ 115V	230	For General Export	Single-phase	100 ~ 115V	01
		200 ~ 240V	114			200 ~ 240V	229			200 ~ 240V	
	3-phase	200 ~ 240V	101		3-phase	200 ~ 240V	229		3-phase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


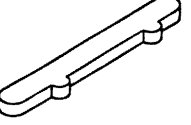
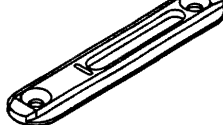
## OPTIONS

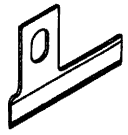
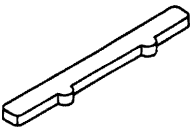
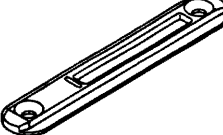
Model	Part No.	Description	Feature
Q082	MAQ-08200-0A0	For men's shirts	<b>• First buttonhole spacing gauge</b> A ruler to help sew the top buttonhole at an accurate distance from the collar.
Q083	MAQ-08300-0A0	For ladies' blouses	
—	137-71209	For vertical buttonholes	
—	137-82909	For vertical buttonholes: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

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

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


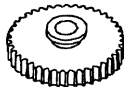
● **Table showing parts used in connection with knives (for plain knife)**

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


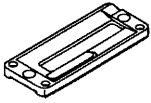

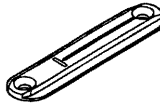
Large size plain knife		Knife guard	Throat plate
			
38.1mm (1-1/2")	B2745-771-F00	137-39602	137-39404

## TABLE OF EXCHANGING GAUGE

### ● Table of changing gears

Small gear			Larger gear	
				
Set	Stitch No.	Part No.	Stitch No.	Part No.
A	56	137-56200	370	137-56309
B	60	137-56408	347	137-56507
C	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
H	86	137-57604	242	137-57703
I	91	137-57802	228	137-57901
J	96	137-58008	216	137-58107
K	101	137-58206	204	137-58305
L	107	137-58404	194	137-58503
M	113	137-58602	183	137-58701
N	119	137-58800	174	137-58909
O	126	137-59006	164	137-59105
P	133	137-59204	156	137-59303
Q	140	137-59402	148	137-59501

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

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

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

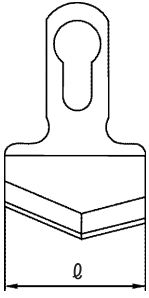
Model name	MBH-180	MBH-180S	MBH-180L
Application	Standard buttonholing process for shirts	Decorative buttonhole process for men's upper garments	Various label attaching processes
Max. sewing speed	3,300rpm		
Sewing size	6.4 ~ 34.9mm (1/4" ~ 1-3/8")	* 6.4 ~ 22.2mm (1/4" ~ 7/8")	6.4 x 38.1mm (1/4" ~ 1-1/2")
Overcasting width	1.6 ~ 2.4mm		
Max. stitch length	0.4 ~ 1mm		
Needle bar stroke	27mm		
Max. lift of the presser foot	7mm (normal: 5mm)		2mm (when the presser foot is in its most advanced position)
Needle (at the time of delivery)	DB x 1 (#14) #11 ~ #16 16 x 231 (Nm90) Nm75 ~ Nm100	DB x 1 (#14) #11 ~ #14 16 x 231 (Nm90) Nm75 ~ Nm90	DB x 1 (#14) #11 ~ #16 16 x 231 (Nm90) Nm75 ~ Nm100
Lubrication	By an oiler		
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)		
Dimensions	470mm (W) x 212mm (L) x 260mm (H)		

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

# EXCHANGING PARTS COMPONENTS

## ● Knife







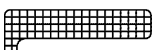

Size	Part No.	For knit **
6.4mm (1/4")	B2701-180-F00	B2701-180-FOA
9.5mm (3/8")	B2701-180-K00	B2701-180-KOA
12.7mm (1/2")	B2701-180-L00	B2701-180-LOA
14.4mm (9/16")	B2701-180-V00	B2701-180-VOA
15.9mm (5/8")	B2701-180-M00 *	B2701-180-MOA
19.1mm (3/4")	B2701-180-N00	B2701-180-NOA
22.2mm (7/8")	B2701-180-P00	B2701-180-POA
25.4mm (1")	B2701-180-Q00	B2701-180-QOA
28.6mm (1-1/8")	B2701-180-R00	B2701-180-ROA
31.8mm (1-1/4")	B2701-180-S00	B2701-180-SOA
34.9mm (1-3/8")	B2701-180-T00	B2701-180-TOA



\* Standard

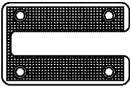
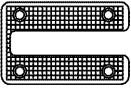
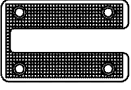
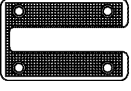
\*\* Special order parts

## ● Cloth clamp foot asm.

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

\* Standard

## ● 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 B1109-180-000
B1501-180-B00 * 	B1502-180-BA0 B1503-180-BA0 B1502-180-DA0 B1503-180-DA0	
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

**SPECIFICATIONS**

Model name	MEB-3200SS	MEB-3200RS	MEB-3200RD	MEB-3200JS	MEB-3200CS
Application	For men's and ladies' wear	For combined use for lateral and longitudinal buttonholing: for men's and ladies' wear		For jeans	For cotton pants and working wear
Thread trimming style	Longer remaining thread			Shorter remaining thread	
Table stand	Standard	Standard	Lateral-installation machine head	Standard	Standard
Stitch system	1-needle, double chainstitch (with 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 ( ) parentheses are in case of taper bar				
Stitch bite width (at the time of delivery)	2.0 ~ 3.2mm				
	(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	Intermittent feed by a stepping motor				
Method to drive the cloth-cutting knife	Vertically driven by stepping motor				
Needle (at the time of delivery)	D0 x 558 (Nm100) Nm90 ~ Nm110		D0 x 558 (Nm120) Nm120 ~ Nm130		D0 x 558 (Nm110) Nm110 ~ Nm120
Lubrication	Automatic (looper and spreader: by an oiler)				
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)				
Compressed air and air consumption	0.5MPa (5kgf/cm <sup>2</sup> ), 6Nℓ/min (8cycle/min)				
Power requirement and power consumption	Single-/3-phase, 550VA				
Dimensions	1,060mm (W) x 790mm (D) x 1,230mm (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



## WHEN YOU PLACE ORDERS (COMPLETE)

MEB-3200 

Application	Code
For men's and ladies' wear	S
For combined use for lateral and longitudinal buttonholing: for men's and ladies' wear	R
For jeans	J
For cotton pants and working wear	C

Table stand	Code
Standard	S
Lateral-installation machine head (with 2-pedal unit)	D









\* The lateral-installation machine head (classified into category D) can be selected for the seam specification category R.

Power supply		Code
Single-phase	220 ~ 240V	K
3-phase	220 ~ 240V	D
	220 ~ 415V	L
Single-/3-phase	220 ~ 415V (for CE)	M

Option	Code
Not provided	Z
Needle thread clamp device	A

## EYLET SHAPES AND STRAIGHT BUTTONHOLE SHAPES

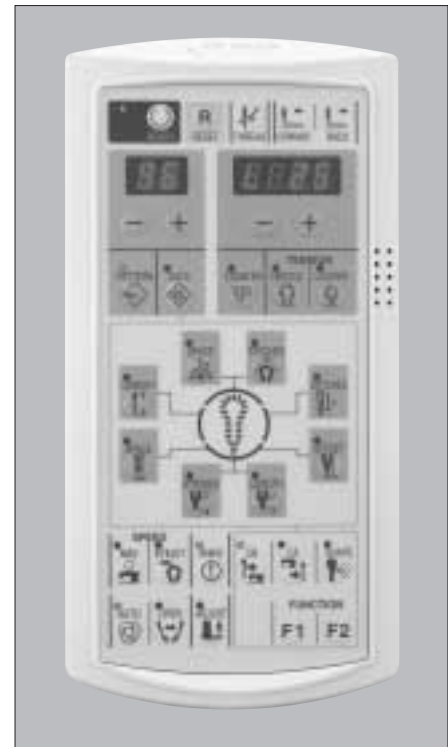
- The machine is provided as standard with 10 different stitching shape patterns. As many as 89 different patterns can be stored in memory and selected.

							
*	**	**	**	*	*	*	*
	Buttonhole with a taper bar	Buttonhole with a straight bartack	Buttonhole with a round bartack		Buttonhole with a taper bar	Buttonhole with a straight bartack	Buttonhole with a round bartack
Eyelet buttonhole				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

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

## ● Throat plate

Part name	Part No.	Application				Needle size
		S	R	J	C	
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			
		S	R	J	C
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			
		S	R	J	C
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			
		S	R	J	C
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

Part name	Part No.	Application			
		S	R	J	C
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				

## ● Cloth cutting knife

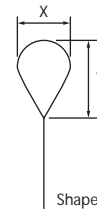
For eyelet buttonhole							
Part No.	Shape (mm)		Max. cutting length (mm)	Application			
	X	Y		S	R	J*	C*
140-41206	2.9	4.4	38			L	L
320-63604	2.9	4.4	24			S	
320-63703	2.9	4.4	32				M
320-63802	2.1	3.2	38				
320-63901	2.1	3.2	24				
320-64008	2.1	3.2	32				
320-64107	3.2	5.4	38				
320-64206	3.2	5.4	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 length (mm)	Application			
	X	Y		S	R	J*	C*
140-41404	0	0	38				
320-65302	0	0	24				
320-65401	0	0	32				



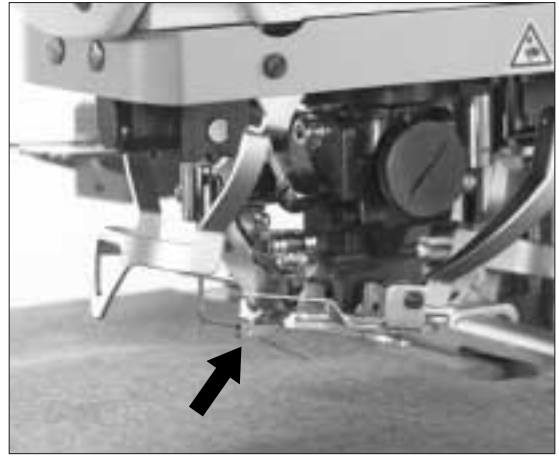
## ● Knife guard

For eyelet buttonhole					For straight buttonhole						
Size (mm)	Part No.	Application				Size (mm)	Part No.	Application			
		S	R	J*	C*			S	R	J*	C*
38	320-62101					40	140-42501				
36	320-62200					36	320-64404				
34	320-62309					34	320-64503				
32	320-62408					32	140-42600				
30	320-62507					30	320-64602				
28	320-62606					28	320-64701				
26	320-62705					26	140-42808				
24	320-62804					24	320-64800				
22	320-62903					22	140-42907				
20	320-63000					20	320-64909				
18	320-63109					18	320-65005				
16	320-63208					16	140-43103				
14	320-63307					14	320-65104				
12	320-63406					12	320-65203				
10	320-63505					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 form a beautiful seam without fail from the first stitch.
- \* Optional part: Part No.: 320-24465

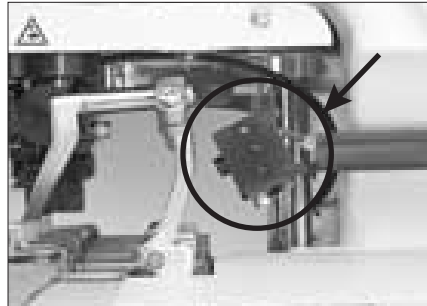


## OPTIONS

Part No.	Description	Feature
320-70054	Marking lamp, asm.	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. (The MEB-3200RD is provided as standard with the pedal switch, asm.)
M9014-620-0A0	Pedal switchcable, asm.	



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

## SPECIFICATIONS

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 x 178mm
Weight of the machine	29kg

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## 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

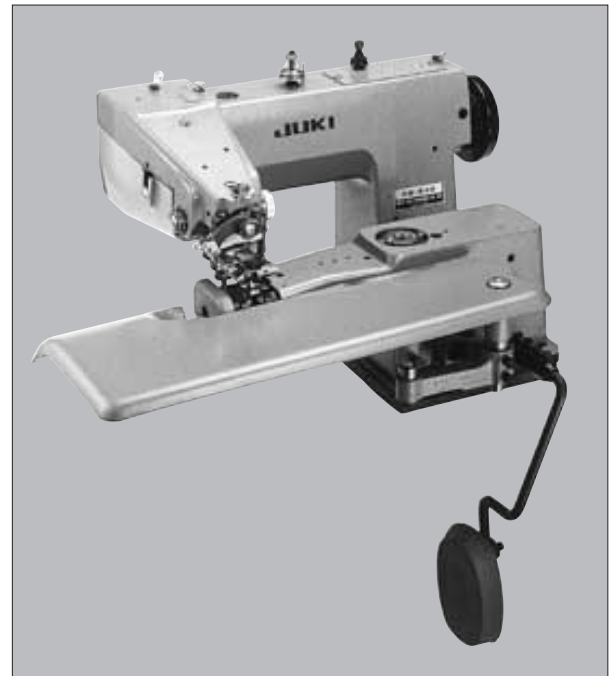
## CB-640

**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

### 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 garments, shirts, slacks cardigans etc.
CB-641	Universal throat plate enables a single machine to blindstitch various materials independent of weight.	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 circled-edge workpieces.

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### 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-feed				Differential top-feed
Differential-feed ratio					Max. 1:1.5 (main feed: sub feed)
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 x 6T (#14) #11, #16 43:45CC (Nm90) Nm75, Nm100				
Thread	#100 ~ #50, B33, Nm=120/3				
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				27kg

## OPTIONS

Model	Part No.	Description		Feature	Application				
					CB-638	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	Uncurling guide		Guides the workpiece steadily to the throat plate preventing light-weight or stretching materials from waving, curling or rising while being sewn.					
K060	B4366-640-0A0	30mm	Auto-open Hemmer (swing type)	Regulates the folding width for hemming (30, 35 or 40mm). Auto-open swing type hemmer permits prominent sections to pass smoothly and does not interrupt stitching. When the periphery of a skirt bottom has been completely hemmed, the front end of the hem 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.					
	B4367-640-0A0	35mm							
	B4368-640-0A0	40mm							
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 disc with round point	Velvet and boa and similar materials can be sewn smoothly and softly by using a ridge forming disc with round point (optional part).					
	B4842-640-000	2.5mm							
	B4843-640-000	3mm							

## WHEN YOU PLACE ORDERS

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

**CB-641/K060/S090/T003**

Model No. of machine

Auto-open hemmer

Thread controller

Manual thread cutter

## 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 minimum 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 (at the time of delivery)	Needle	SCHMETZ 29-C-150 (#90) #80 ~ #140
	Looper	SCHMETZ 29-C-151 (#100) #80 ~ #140
Distance from needle to machine arm		265mm
Lubrication		By an oiler
Lubricating oil		JUKI New Defrix Oil No.1 (equivalent to ISO VG7)

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## 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.

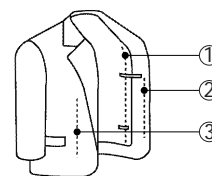
A single MP-200 supports these three needle width.

Needle width	Number of spacer gauges
1.2mm	0
1.6mm	1
2.0mm	2

## USES OF PINPOINT STITCHING

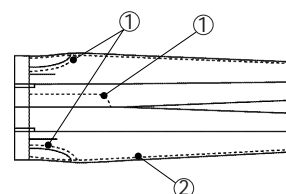
### ● Men's coats and jackets

- ① Topstitching on front facing
- ② Star-shape tacking at the far side of front facing, star-shape tacking on front body (for preventing uneven material feed)



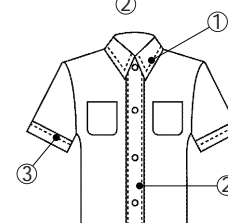
### ● Slacks

- 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.



LT-591

## 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 x 7 (#14)
Hook	Vertical-axis large hook (dia. of bobbin: 37mm, amount of bobbin thread 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 x 178mm
Weight of the machine head	53kg

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## KINDS OF HIGH WOODEN BUCK TABLE

A

B

C

D

**Usage-example**

**A:** Round A type  
Basting front interlining

**B:** Round B type  
Basting front  
Basting neckline  
Basting front facing  
Basting bottom

**C:** Flat A type  
Basting pad

**D:** Flat B type  
Basting sleeve cuff  
Basting sleeve lining, etc.



## 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-206C/PGM-5A

#### ● AMS-206CGL

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.

## SPECIFICATIONS

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 set to 3mm)				
Stitch length	0.2 ~ 6.2mm				
Needle bar stroke	41.2mm				
Lift of the feeding frame	Standard 12mm (max. 18mm)		Standard 17mm (max. 18mm)		
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	Large-capacity shuttle hook				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 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/cm <sup>2</sup> ), 1.8Nℓ/min
Sewing machine motor	400W, 4P electronic-stop motor				550W, 2P electronic-stop motor
Power consumption	Single-phase, 3-phase 1KVA				
Lubrication	Centralized oil wick lubrication				
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)				
Total weight	120kg		125kg		
Dimensions	675mm (L) × 1,200mm (W) × 1,130mm (H)		705mm (L) × 1,200mm (W) × 1,130mm (H)		

## WHEN YOU PLACE ORDERS

Application	Code	Work clamp type	Code
Standard	S	Standard	S
For medium-weight materials	H		

Application	Code	Work clamp type	Code
Standard	S	Standard	S
For medium-weight materials	H	Pneumatic double-step work clamp	L
Double-capacity shuttle hook type for heavy-weight materials	*G		

Work clamp foot	Code
Compatible with LK	0001 ~
For AMS	5000 (standard) 5001 ~

AMS-205C S [ ] [ ] [ ] [ ] Z

AMS-206C [ ] [ ] [ ] [ ] [ ] Z

\* The G type machine, equipped with a double-capacity shuttle hook for heavy-weight materials, can use only the pneumatic double-step work clamp (L).

## 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) x (L)	Description
1		42	16 x 2	Large bartacking
2		36	16 x 2	
3		28	16 x 2	
4		56	16 x 2	
5		36	8 x 2	Small bartacking
6		28	8 x 2	
7		21	8 x 2	Linear bartacking
8		28	14 x 0	
9		21	14 x 0	
10		36	16 x 0	Bartacking for knitted fabric
11		28	8 x 2	
12		21	8 x 2	

\* Sewing size shows the dimensions when the scale rate is 100%.

## 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	
B1601-210-000	Intermediate presser A	3.5 x 5.5 x 4 x 42.5
B1601-210-00B	Intermediate presser B	3.5 x 5.5 x 6 x 40.5
B1601-210-00C	Intermediate presser C	3.5 x 10 x 5 x 41.5
B1601-210-00D	Intermediate presser D	2.2 x 3.6 x 6 x 40.5
B1601-210-00E	Intermediate presser E	1.6 x 2.6 x 6 x 40.5
B1601-210-00G	Intermediate presser G	3 x 5 x 8 x 40.5
B1601-220-00G	Intermediate presser G	2.7 x 4.1 x 5 x 29.5
B2426-210-00B	Needle hole guide B ( A= 2.0)	
B2426-210-00C	Needle hole guide C ( A= 1.6)	
B2426-210-00D	Needle hole guide D ( A= 2.4)	
B2426-210-00F	Needle hole guide F ( A= 3.0)	
B2426-210-00G	Needle hole guide G ( A= 3.0)	
B2551-205-000	Right work clamp foot	
B2552-205-000	Left work clamp foot	
B2551-205-B00	Right work clamp foot for small bartacking	
B2552-205-B00	Left work clamp foot for small bartacking	
B2551-205-C00	Right work clamp foot for bartacking of knitted material	
B2552-205-C00	Left work clamp foot for bartacking of knitted material	
B2556-205-000	Feed plate	
B2556-205-B00	Feed plate for small bartacking	
B2556-205-C00	Feed plate for bartacking of knitted material	
B2556-206-0X0	Feed plate blank (without knurl)	
B2556-206-0Y0	Feed plate blank (with knurl)	

Part No.	Description	
B2553-206-0X0	Feeding frame assembly blank (without knurl)	
B2553-206-0Y0	Feeding frame assembly blank (with knurl)	
B2572-206-0X0	Feeding frame blank, right (without knurl)	
B2572-206-0Y0	Feeding frame blank, right (with knurl)	
B2573-206-0X0	Feeding frame blank, left (without knurl)	
B2573-206-0Y0	Feeding frame blank, left (with knurl)	
B2570-206-0A0	Right slide plate	
B2571-206-0A0	Left slide plate	
B2551-206-0A0	Slide plate assembly	
B2556-206-000	Feed plate	
B2557-206-0A0	Large plastic feeding frame (asm.)	
B2587-210-000	Feeding frame material (A)	
B2588-210-000	Feeding frame material (B)	
M1007-511-0A0	Foot switch fixed plate	
M8590-510-0A0	2 pedal	For both the AMS-205C and AMS-206C
M8560-511-0A0	Foot switch (asm.)	
M8151-206-0A0	Manual pedal (asm.)	Exclusive to the AMS-206C
B2564-210-0A0	Auxiliary feed plate (asm.)	Use with LK subclass feed plate

## 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.



AMS-210D

## 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 (P type)

## WHEN YOU PLACE ORDERS

### ● Machine head

### AMS-210D [ ] [ ] [ ] [ ] [ ] [ ] [ ] Z

Application	Code
Standard	S
For heavy-weight materials	H

Feeding frame type	Code
Magnet-driven feeding frame	S
Pneumatic separately-driven feeding frame	L

Subclass	Code
Standard	5000
Subclass	6001 ~

Stitch type	Code
Standard	S
Perfect stitch	P

### ● Table stand

### J-AM2000 [ ] [ ] [ ] B

Specification	Code
Magnet-driven feeding frame	S
Pneumatic separately-driven feeding frame	L

Power supply	Code	
Single-phase	100 ~ 120V	C
	200 ~ 240V	K
	220 ~ 415V	R
3-phase	200 ~ 240V	D
	220 ~ 415V	L
	220 ~ 415V (For CE)	M

Pedal switch	Code
2-pedal unit	A
3-pedal unit	B
PK 2-pedal unit	C
PK 3-pedal unit	D

Control panel	Code
English and pictograph	B

\* For using magnet-driven feeding frame type, please select A or C type. (Standard: C type)  
\* For using Pneumatic separately-driven feeding frame type, please select B or D type.

## SPECIFICATIONS

Model name	AMS-210D		AMS-210D P TYPE	
	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 ~ 12.7mm			
Needle bar stroke	41.2mm			
Lift of the feeding frame	Max. 25mm, Pneumatic: Max. 30mm			
Lift of the intermediate presser	Max. 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	#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	Double-capacity shuttle hook		DP double-capacity shuttle hook	
Input function	Provided as standard			
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% (by increasing/decreasing the stitch length or the number of stitches)			
Error detector function	Needle thread breakage detector, temporary stop (pause) switch, error code indicating function			
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)			
Total weight	120kg			
Dimensions	710mm (L) × 1,200mm (W) × 1,200mm (H)			

## PROGRAMMING FUNCTIONS

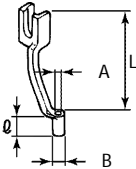
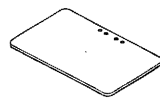
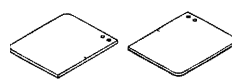

- With its large memory, the machine responds to many different sewing patterns. Sewing settings can be established and sewing patterns programmed entirely through the operation panel.
- Ample storage capacity: maximum of 360,000 stitches on a floppy disk, or 691 patterns on a 2DD disk or 999 ones on 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 peripheries need to be sewn such as labels and emblems.
FU01L		Inverted clamp device for separately driven pneumatic feeding frame	
	B5019-222-0B0 PJ-0320525-03 PJ-0205000-02 B4717-223-C00 BT040-025-1EB BT060-040-1EB B4712-215-0A0 SK-3312500-SE × 2 SS-6151812-TP WP-0641601-SD × 5	Thread tension controller No.3	The tension controller unit is used to partially change the needle thread tension during the sewing of a pattern.
	B2120-215-0A0 B4150-210-DA0	Needle thread clamp device Junction cord	This device prevents the thread from tangling at the start of 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 B2594-210-DA0	Cassette holder fixing base (asm.) Cassette holder (asm.)	The next material to be sewn can be placed between the top and bottom plates of the cassette holder while the machine is still engaged in the sewing of the currently set material.
	B2585-210-DB0 B2586-210-DB0	One-touch utility clamp for the magnet-driven feeding frame One-touch utility clamp for separately-driven pneumatic feeding frame	The feeding frame and the feed plate can be quickly 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.

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Part No.	Description	
B1601-210-D00A	Intermediate presser A 2.2 × 3.6 × 6 × 29.5	 <p>A × B × Ø × L</p>
B1601-210-D0BA	Intermediate presser B 2.7 × 4.1 × 6 × 29.5	
B1601-210-D0CA	Intermediate presser C 2.7 × 5.5 × 6 × 29.5	
B1601-210-D0E	Intermediate presser E 1.6 × 2.6 × 6 × 29.5	
B1601-210-D0FA	Intermediate presser F 2.2 × 3.6 × 9 × 29.5	
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)	

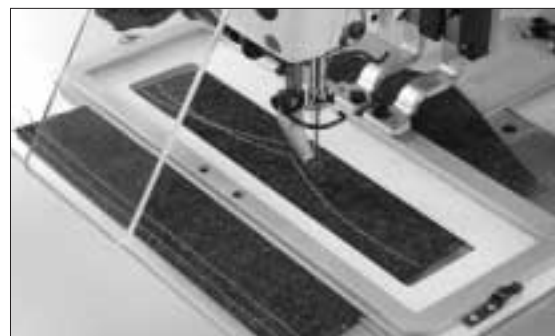
Computer-controlled Cycle Machine with an Input Function  
for Topstitching Jean Pockets

**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



**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 × 17 (#18), For JE: 135 × 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 ~ 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 <sup>2</sup> ), 1.8Nℓ/min
Total weight	120kg
Dimensions	710mm (L) × 1,200mm (W) × 1,200mm (H)

## WHEN YOU PLACE ORDERS

● Machine head

**AMS-210DHL6100SZ**

● Table stand

**J-AM2000L**  **B**

Power supply		Code
Single-phase	100 ~ 120V	C
	200 ~ 240V	K
	220 ~ 415V	R
3-phase	200 ~ 240V	D
	220 ~ 415V	L
	220 ~ 415V (For CE)	M

Pedal switch		Code
2-pedal unit		A
PK 2-pedal unit		C

Control panel		Code
English and pictograph		B

## 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.



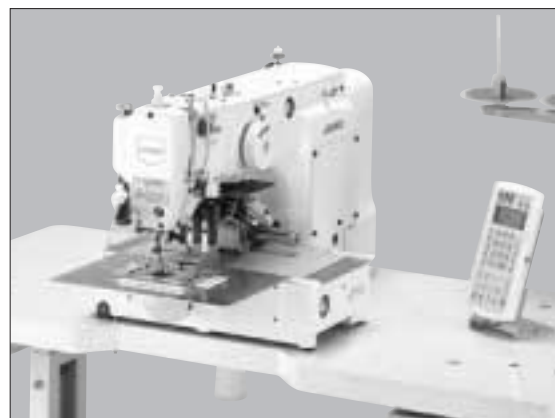
## OPTIONS

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	Thread tension controller No.3	The tension controller unit is used to partially change the needle thread tension during the sewing of a pattern.
	PJ-0320525-03		
	PJ-0205000-02		
	B4717-223-C00		
	BT040-025-1EB		
	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.
	B2585-210-DB0	One-touch utility clamp for the monolithic feeding frame	The feeding frame and the feed plate can be quickly changed without any tools.
	B2586-210-DB0	One-touch utility clamp for separately-driven pneumatic feeding frame	
	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



**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
Tread 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/cm <sup>2</sup> ), 1.8Nℓ/min
Total weight	120kg
Dimensions	710mm (L) × 1,200mm (W) × 1,200mm (H)



## WHEN YOU PLACE ORDERS

● Machine head

**AMS-210DHL6300SZ**

● Table stand

**J-AM2000L** 

Power supply		Code
Single-phase	100 ~ 120V	C
	200 ~ 240V	K
	220 ~ 415V	R
3-phase	200 ~ 240V	D
	220 ~ 415V	L

Pedal switch		Code
3-pedal unit		B
PK-47(3-pedal unit)		D

Control panel		Code
English and pictograph		B

## 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 BT060-040-1EB B4712-215-0A0 SK-3312500-SE × 2 SS-6151812-TP WP-0641601-SD × 5	Thread tension controller No.3	The tension controller unit is used to partially change the needle thread tension during the sewing of a pattern.
	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 B2594-210-DA0	Cassette holder fixing base (asm.) Cassette holder (asm.)	The next material to be sewn can be placed between the top and bottom plates of the cassette holder while the machine is still engaged in the sewing of the currently set material.
	B2585-210-DB0 B2586-210-DB0	One-touch utility clamp for the monolithic feeding frame One-touch utility clamp for separately-driven pneumatic feeding frame	The feeding frame and the feed plate can be quickly 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



AMS-221D

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

**AMS-215D P TYPE** Sewing area: 110mm(L) × 220mm(W)

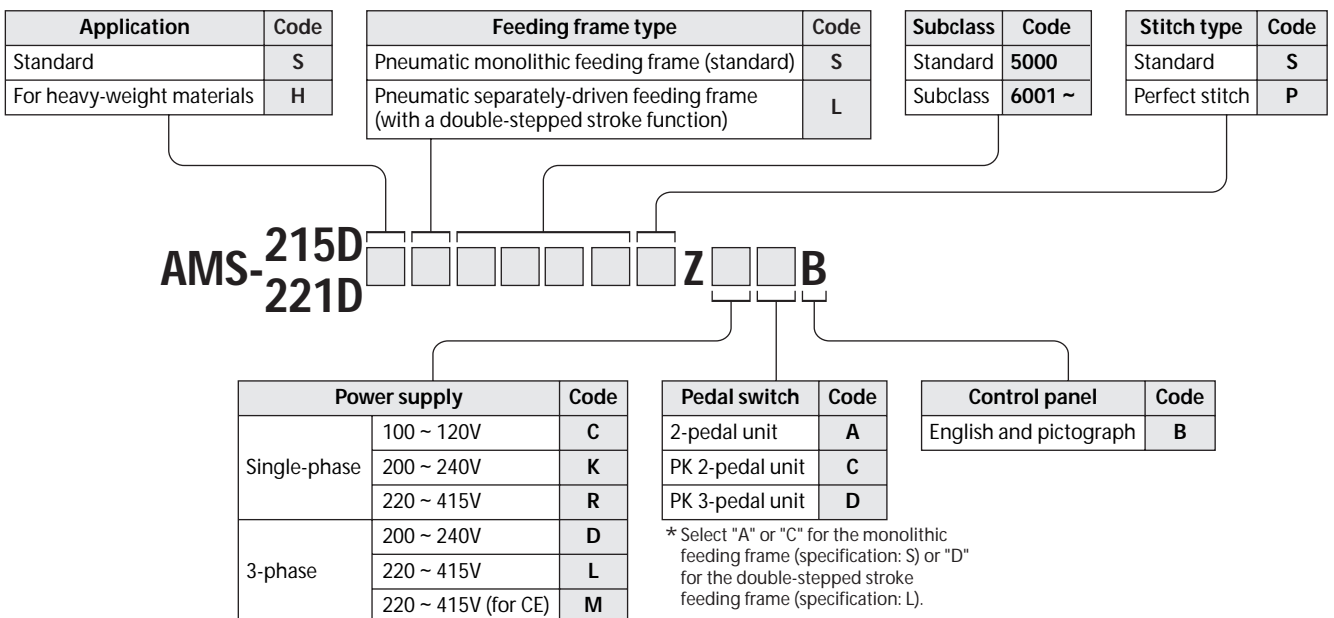
**AMS-221D P TYPE** Sewing area: 160mm(L) × 250mm(W)

- 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.



AMS-221DSS

**WHEN YOU PLACE ORDERS**



## SPECIFICATIONS

Model name	AMS-215D		AMS-215D P TYPE		AMS-221D		AMS-221D P TYPE	
	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 ~ 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 × 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	Double-capacity shuttle hook		DP double-capacity shuttle hook		Double-capacity shuttle hook		DP double-capacity shuttle hook	
Memory medium	2DD/2HD 3.5" micro-floppy disk							
Space under the arm	Sewing area + 253mm				Sewing area + 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. 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 system)							
Power consumption	Single-phase, 3-phase 600VA							
Compressed air and air consumption	0.5 ~ 0.55MPa (5 ~ 5.5kgf/cm <sup>2</sup> ), 1.8Nl/min							
Lubrication	Automatic							
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)							
Total weight	175kg							
Dimensions	960mm (L) × 1,200mm (W) × 1,200mm (H)				1,005mm (L) × 1,200mm (W) × 1,200mm (H)			

## PROGRAMMING FUNCTIONS

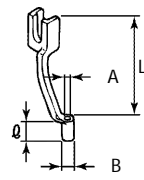
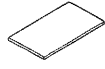
- With its large memory, the machine responds to many different sewing patterns. Sewing settings can be established and sewing patterns programmed entirely through the operation panel.
- Ample storage capacity: maximum of 360,000 stitches on a floppy disk, or 691 patterns on a 2DD disk or 999 ones on 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.
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 PX-500014000 SS-6152212SP WP-0612516SD x 2	Thread tension controller No.3	The tension controller unit is used to partially change the needle thread tension during the sewing of a pattern.
	B2120-215-0A0 B4150-210-DA0	Needle thread clamp device Junction cord	This device prevents the thread from tangling at the start of sewing.
	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 plate.
MU14		Milling unit (for AMS-221D)	
	B2581-221-DA0 B2582-221-0A0	Cassette holder fixing base (asm.) Cassette holder (asm.)	The next material to be sewn can be placed between the top and bottom plates of the cassette holder while the machine is still engaged in the sewing of the currently set material.
	B2640-215-0B0 B2641-215-0A0 x 2 SS-6150610SP x 4	One-touch utility clamp	The feeding frame and the feed plate can be quickly 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.

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Part No.	Description	
B1601-210-D00A	Intermediate presser A	2.2 x 3.6 x 6 x 29.5
B1601-210-D0BA	Intermediate presser B	2.7 x 4.1 x 6 x 29.5
B1601-210-D0CA	Intermediate presser C	2.7 x 5.5 x 6 x 29.5
B1601-210-D0E	Intermediate presser E	1.6 x 2.6 x 6 x 29.5
B1601-210-D0FA	Intermediate presser F	2.2 x 3.6 x 9 x 29.5
	A x B x 0 x L	
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)	AMS-215D
B2623-215-D00	Feeding frame blank, left (with knurl)	
B2626-215-D00	Feeding frame blank (with knurl)	
B2622-221-000	Feeding frame blank, right (with knurl)	AMS-221D
B2623-221-000	Feeding frame blank, left (with knurl)	
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)	
B2620-221-000	Feeding frame blank plate (with knurl)	AMS-221D
B2621-221-000	Feeding frame blank plate	
B2552-215-D0A	Lower plate blank (without knurl)	AMS-215D
B2552-215-D0B	Lower plate blank (with knurl)	
B2552-215-D0C	Lower plate blank (0.5mm)	
B2552-221-D0A	Lower plate blank (without knurl)	AMS-221D
B2552-221-D0B	Lower plate blank (with knurl)	
B2552-221-D0C	Lower plate blank (0.5mm)	



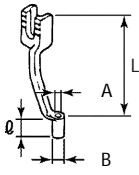
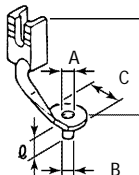
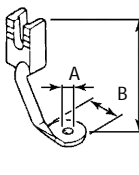




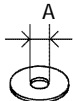
## SPECIFICATIONS

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	Standard 25mm (max. 30mm)				
Lift of the intermediate presser	20mm				
Stroke of intermediate presser	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 120/3 ~ 60/3	#50 ~ #8 B33 ~ B92 120/3 ~ 30/3	#8 ~ #2 B92 ~ B207 120/3 ~ 10/3	#60 ~ #30 B33 ~ B46 120/3 ~ 60/3	#50 ~ #8 B33 ~ B92 120/3 ~ 30/3
Input function	Provided as standard (can also be connected to the PGM-5A)				
Hook	Large-capacity shuttle hook		Double-capacity shuttle hook	DP large-capacity shuttle hook	
Memory medium	2DD/3.5" micro-floppy disk				
Free space under the arm	Sewing area + 290mm				
Number of stitches that can be stored in memory	Max. 176,000 stitches (max. 4,000 stitches/pattern)				
Number of patterns that can be input	Max. 691 patterns				
Enlarging/Reducing facility	0.1 ~ 400% (0.1% step), by increasing/decreasing the stitch length or the number of stitches				
Bobbin thread counter	Provided as standard				
Compressed air and air consumption	0.55MPa (5.5kgf/cm <sup>2</sup> ), 1.8N <sub>0</sub> /min				
Sewing machine motor	400W, 4P electronic-stop motor		550W, 2P electronic-stop motor	400W, 4P electronic-stop motor	
Power consumption	Single-phase, 3-phase 1KVA				
Lubrication	Automatic				
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)				
Weight	290kg				
Dimensions	1,190mm (L) × 1,230mm (W) × 1,285mm (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 materials
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				
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 (0.3 ~ 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 120/3 ~ 60/3	#50 ~ #8 B33 ~ B92 120/3 ~ 30/3	#8 ~ #2 B92 ~ B207 120/3 ~ 10/3	#60 ~ #30 B33 ~ B46 120/3 ~ 60/3	#50 ~ #8 B33 ~ B92 120/3 ~ 30/3
Input function	Provided as standard (can also be connected to the PGM-5A)				
Hook	Large-capacity shuttle hook		Double-capacity shuttle hook	DP large-capacity shuttle hook	
Memory medium	2DD/3.5" micro-floppy disk				
Free space under the arm	Sewing area + 240mm				
Number of stitches that can be stored in memory	Max. 176,000 stitches (max. 4,000 stitches/pattern)				
Number of patterns that can be input	Max. 691 patterns				
Enlarging/Reducing facility	0.1 ~ 400% (0.1% step), by increasing/decreasing the stitch length or the number of stitches				
Bobbin thread counter	Provided as standard				
Compressed air and air consumption	0.55MPa (5.5kgf/cm <sup>2</sup> ), 1.8N <sub>0</sub> /min				
Sewing machine motor	400W, 4P electronic-stop motor		550W, 2P electronic-stop motor	400W, 4P electronic-stop motor	
Power consumption	Single-phase, 3-phase 1KVA				
Lubrication	Automatic				
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)				
Weight	320kg				
Dimensions	1,220mm (L) × 1,230mm (W) × 1,285mm (H)				

# 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	Thread tension controller No.3	The tension controller unit is used to partially change the needle thread tension during the sewing of a pattern.
	PV-150209000		
	142-04754		
	PX-5000014000		
	SS-6152212SP		
	WP-0612516SD × 2		
	B2120-215-0A0	Needle thread clamp device	This device prevents the thread from tangling at the start of sewing.
	B4150-210-DA0	Junction cord	
	B4720-215-DB0	Needle cooler	The needle cooler blows air to the needle, thereby preventing thread breakage caused by hot needle.
MU08		Milling unit	The milling unit can be installed on the machine to allow the operator to easily machine a feeding frame or feed plate.
MU11		Milling unit	
	B2581-223-CA0	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 machine is still engaged in the sewing of the currently set material.
	B2582-223-CA0	Cassette holder (asm.)	
	B2581-224-CA0	Cassette holder fixing base (asm.)	
	B2582-224-CA0	Cassette holder (asm.)	
	B2640-215-0B0	One-touch utility clamp	The feeding frame and the feed plate can be quickly changed without any tools.
	B2641-215-0A0 × 2		
	SS-6150610SP × 4		

Part No.	Description		
B1601-220-000	Intermediate presser A 2.2 × 3.6 × 6 × 29.5	 $A \times B \times \varnothing \times L$	
B1601-220-00B	Intermediate presser B 3.5 × 5.5 × 6 × 29.5		
B1601-220-00C	Intermediate presser C 2.2 × 3.6 × 12 × 6 × 29.5		 $A \times B \times C \times \varnothing \times L$
B1601-220-00D	Intermediate presser D 2.2 × 12 × 34.5		
B1601-220-00E	Intermediate presser E 1.6 × 2.6 × 6 × 29.5		 $A \times B \times L$
B1601-220-00F	Intermediate presser F 2.2 × 3.6 × 9 × 29.5		
B1601-220-00G	Intermediate presser G 2.7 × 4.1 × 5 × 29.5		A, B, E, F and G type
B1601-220-0A0	Intermediate foot (asm) 2.2 × 10 × 6 × 29.5	C 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)		
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)		
B2623-223-C00	Feeding frame blank, left (with knurl)		
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)	AMS-223	
B2556-223-C0C	Lower plate blank (with knurl)		
B2556-223-C0D	Lower plate blank (0.5mm, without knurl)		
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)		
B2426-210-00C	Needle hole guide C ( A = 1.6)		
B2426-210-00D	Needle hole guide D ( A = 2.4)		
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.



AMS-223C/BK2

## 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

## WHEN YOU PLACE ORDERS

**BK-**

Applicable models	Code
AMS-223C AMS-224C	2
AMS-223P AMS-224P	5

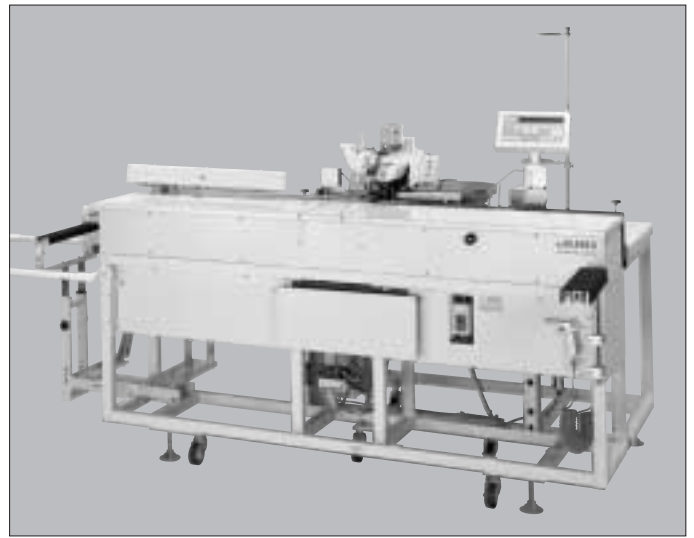
Application	Code
Standard	S
For medium-weight materials	H



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

# ACF-164-1800

- The machine is equipped with a computer-controlled single-thread 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 and 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	□, ▢, ×, ×, Z, □,  ,  , - ,   △, ▽, ◁, ▷ (Button carrier for 3-holed buttons is available by special order.)
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 <sup>2</sup> )
Air consumption	20Nℓ/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 supply			Code
For General Export	Single-phase	220V	D
	3-phase	200V, 220V, 240V	Q
For CE	3-phase	380V	L

Options	Code
Not provided	Z
Second work clamp	B
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) *
	B	Total feeding amount	Standard: 650mm (optional size: Max. 1,200mm)
	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 garment to be sewn	Width: 220 ~ 420mm
	F		Length: 400 ~ 880mm

\* Button intervals can be respectively 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
<b>Standard</b>				<b>Standard</b> (Packed together with accessories.)			
2.6	1.0	165-57902	A	3.2	1.2	165-58009	B
<b>Optional</b>							
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	T	2.4	1.2	165-87909	L
2.6	1.2	165-88709	U	2.6	1.0	165-87602	H
2.8	1.2	165-88808	V	2.6	1.2	165-88006	M
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	K
3.1	1.2	165-89004	X	3.0	1.2	165-88204	P
3.1	1.4	165-89202	Z	3.8	1.2	165-87107	C
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 buttons

\*\* For 3-holed buttons is available by special order.

## OPTIONS

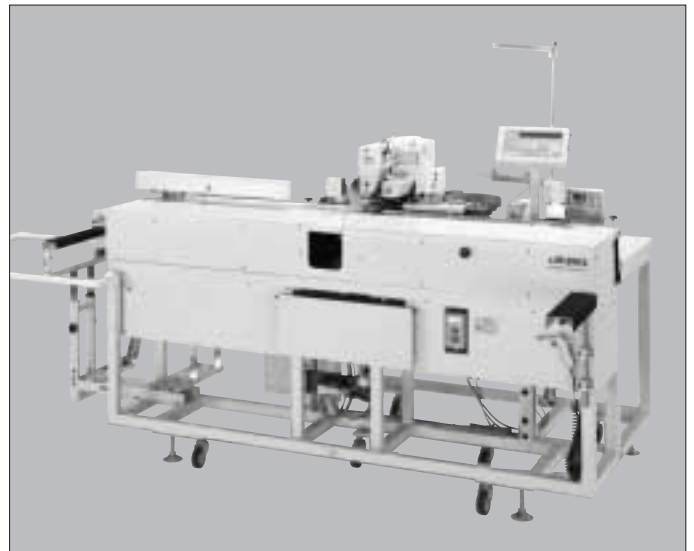
Model	Part No.	Description	Feature
	G5510-164-0A0	Auxiliary feed plate	This part feeds heavy sewing products such as finished garments with great reliability.
	G5508-164-0A0	Clamp for light-weight materials	This part clamps easy-to-slack materials such as light cottons and silks to ensure reliable feeding.
	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.

\* Specify at the time of order where necessary.

Computer-controlled, Lockstitch, Button Sewing Indexer

# ACF-164-1903

- 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

## SPECIFICATIONS

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 <sup>2</sup> )
Air consumption	20Nℓ/min
Dimensions	1,860mm (W) x 970mm (D) x 920mm (H)
Total weight	270kg

## WHEN YOU PLACE ORDERS

### ACF-164-1903

Power supply			Code
For General Export	Single-phase	220V	D
		240V	E
	3-phase	200V, 220V, 240V	Q
		380V, 415V, 440V	T
For North America	3-phase	220V	K
For CE		380V	L
		415V	M

Option	Code
Not provided	Z
Cloth suction device (MC16)*	E

\* Other options are separately available.

## APPLICATIONS SIZE OF CLOTH

	A	Feeding intervals	25 ~ 650mm (0.1mm steps) *
	B	Total feeding amount	Standard: 650mm (optional size: Max. 1,200mm)
	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 garment to be sewn	Width: 220 ~ 420mm
	F		Length: 400 ~ 880mm

\* Button intervals can be respectively 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
<b>Standard</b>				<b>Standard</b> (Packed together with accessories.)			
2.6	1.0	165-57902	A	3.2	1.2	165-58009	B
<b>Optional</b>							
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	T	2.4	1.2	165-87909	L
2.6	1.2	165-88709	U	2.6	1.0	165-87602	H
2.8	1.2	165-88808	V	2.6	1.2	165-88006	M
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	K
3.1	1.2	165-89004	X	3.0	1.2	165-88204	P
3.1	1.4	165-89202	Z	3.8	1.2	165-87107	C
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 buttons

## 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.

## 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

### ● 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.

## SPECIFICATIONS

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 x 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	Provided as standard (only when sewing garment bodies)	
Capability of sewing finished products	Impossible	Possible	
Garment body stacker	Provided as 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 <sup>2</sup> ), 240Nℓ/min	0.5MPa (5kgf/cm <sup>2</sup> ), 20Nℓ/min	
Dimensions	1,910mm (W) x 850mm (D)		
Total weight	320kg	350kg	320kg

## WHEN YOU PLACE ORDERS

# ACF-172-791



Application	Code
For sewing garment bodies (standard)	RS
For sewing finished products with a garment body stacker	RA
For sewing finished products without a garment body stacker	RB

Power supply		Code	
For General Export	Single-phase	220V	D
		240V	E
	3-phase	200V, 220V, 240V	Q
		380V, 415V, 440V	T
For North America	3-phase	220V	K
For CE		380V	L
		415V	M

Option	Code
Auxiliary garment clamp device	A
Adjusting range shifter	B
Not provided	Z

## APPLICATIONS SIZE OF CLOTH

A	Buttonhole interval	20 ~ 610mm (0.1mm steps) (Each interval between each two of buttonholes can be separately changed.)	
B	Total feeding amount	610mm	
C	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 body to be sewn	Width: 220 ~ 420mm	
F	Applicable size of the garment body to be sewn	Length: 400 ~ 880mm	

## OPTIONS

Part No.	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.	

\* 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 x 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 <sup>2</sup> )
Air consumption	10Nℓ/min

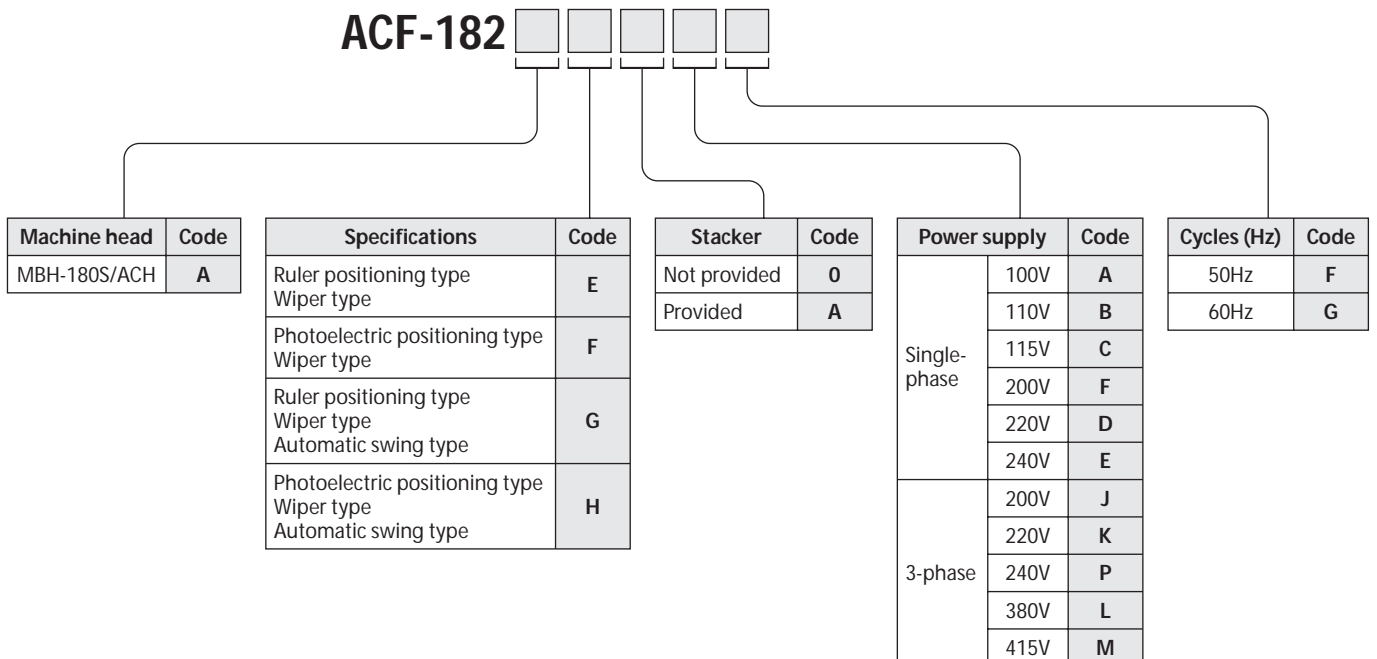


ACF-182



## WHEN YOU PLACE ORDERS

### ACF-182



## 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 two-holed 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.

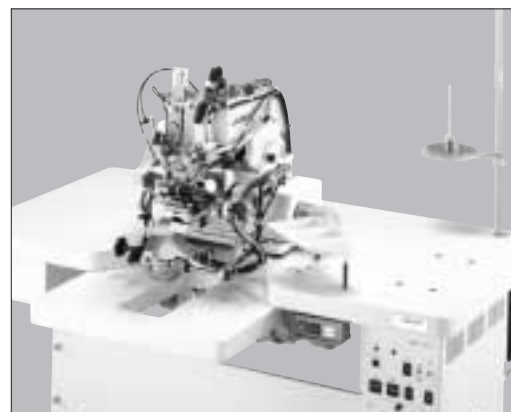
### **AMB-189N** (for flat button, shank button and marble button)

- 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)

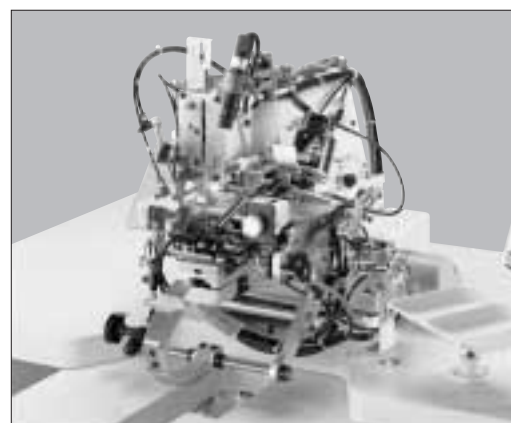
- The button loader allows the operator to set the next button to be sewn on the machine while the sewing machine is still engaged in the current button operation the material, thereby improving productivity. Furthermore, the operator can position a button on the loader without any possibility of error. 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



## SPECIFICATIONS

Model name	AMB-187N	AMB-189N			
Machine head	MB-376 (exclusive head)				
Max. sewing speed	850rpm				
Needle bar stroke	58.6mm				
Needle (at the time of delivery)	Button with neck wraps: SM × 332EXTLG (Nm90) Nm80, Nm100				
	Button without neck wraps: SM × 332EXTLG (#14BUT) #16, #18				
Thread	Cotton thread, supn thread: #60 ~ #30, B33 ~ B46, 120/3 ~ 60/3				
Type of sewing	Four-holed and two-holed flat button sewing with/without neck wraps Parallel stitching or cross stitching for four- holed flat buttons				
		Shank and marble button sewing with neck wrap			
Outside diameter of button	8 ~ 32mm	<table border="1"> <tr> <td>8 ~ 16mm: Button chuck, small</td> </tr> <tr> <td>14 ~ 25mm: Button chuck, medium</td> </tr> <tr> <td>21 ~ 32mm: Button chuck, large</td> </tr> </table>	8 ~ 16mm: Button chuck, small	14 ~ 25mm: Button chuck, medium	21 ~ 32mm: Button chuck, large
8 ~ 16mm: Button chuck, small					
14 ~ 25mm: Button chuck, medium					
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)				
		Shank and marble button sewing with neck wraps 0 ~ 3mm			
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 <sup>2</sup> ), 15Nℓ/min				
Dimensions	1,100mm (W) × 810mm (L) × 1,500mm (H)				
Adjustment of the height of table	Height of the top face of the table 750 ~ 1,030mm				
Total weight	120kg				

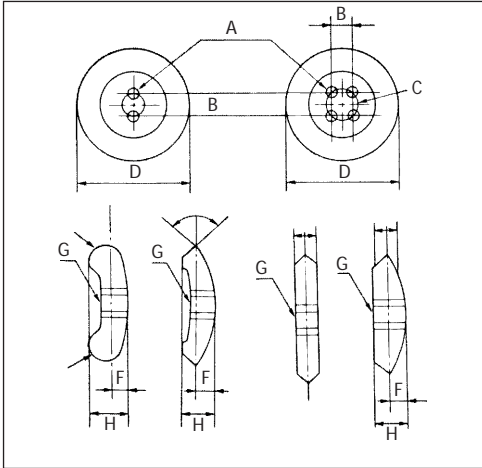
## WHEN YOU PLACE ORDERS

AMB-187N  
AMB-189N

Power supply		Code	Pedal switch		Code	Option		Code
Single-phase	100 ~ 130V	Q	Knee switch	A	Not provided			R
	115V (for North America)	C	2-pedal (PK62)	B	Button loader			
	190 ~ 250V	U						
3-phase	190 ~ 250V	W						
	220V (for North America)	K						
	380V (for JE)	L						
	380V (for General Export)	Y						
	415V	M						
	440V	N						

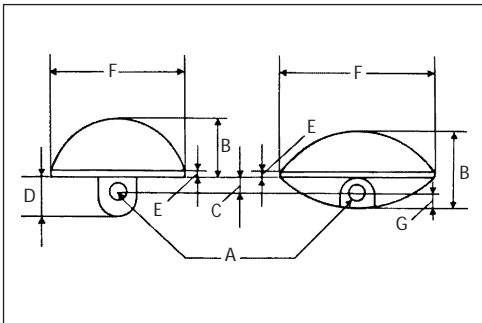
## APPLICABLE BUTTON REQUIREMENTS

### AMB-187N/AMB-187NR, AMB-189N/AMB-189NR



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
B	Distance between the button holes	2 ~ 5mm(± 0.15mm)
C	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
E <sub>1</sub>	Button with a round edge	The button must have a radius of 3mm or less
E <sub>2</sub>	Button with a V-shaped edge	Within 120 °
E <sub>3</sub>	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
H	Thickness	8mm or less

### AMB-189N/AMB-189NR

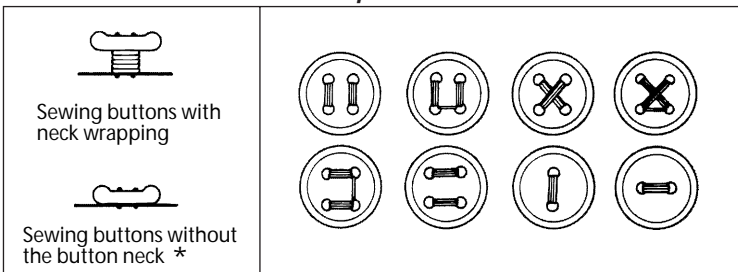


Specifications for shank and marble buttons		
A	Button hole diameter	1.5mm or more
B	Thickness	6.8mm or less
C	Distance between the bottom of button head to the center of hole of button	Shank button: 1mm ~ 6mm Marble button: 1.5mm or more
D	Button shank length	8mm or less
E	Straight section on the side 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.

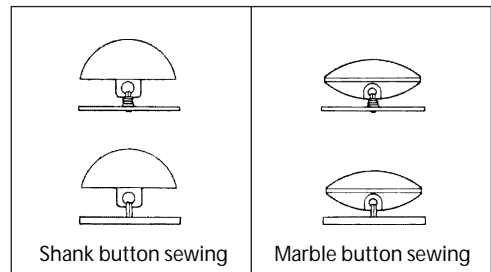
## KINDS OF BUTTON AND STITCH SHAPES

### AMB-187N/AMB-187NR, AMB-189N/AMB-189NR



\* Optional parts are necessary for sewing buttons without button neck.

### AMB-189N/AMB-189NR



13

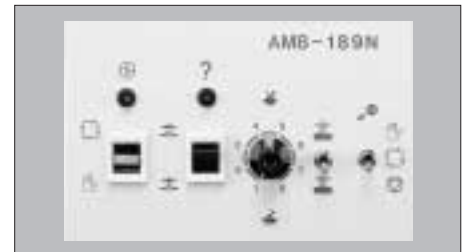
## OPERATION PANEL/OPERATION BOX

### 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								
Without neck wraps *								

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.



Operation panel



Operation box

## 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 × 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

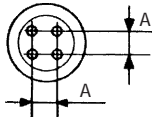
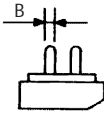
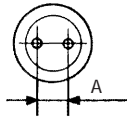
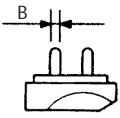
### AMB-187N/AMB-187NR, AMB-189N/AMB-189NR

Part No.	Description	Remarks
250-05208	Feed plate	For heavy-weight materials
250-09051	Button sewing unit for sewing buttons without button neck	For sewing buttons without the button neck
250-09101	Knife cover for sewing buttons without button neck	
178-28906	Feed plate for large buttons	
178-29102	Feed plate for small buttons	




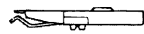
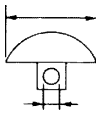

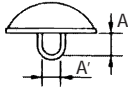
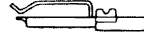
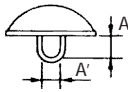


### AMB-189N/AMB-189NR

Part No.	Description	Remarks
179-66656	Tongue(asm.) Triangular(for 1.2mm)	 1.2mm
179-66458	Tongue(asm.) Triangular(for 2.4mm)	 2.4mm

## BUTTON CARRIERS FOR AMB-189NR, AMB-189NR

Button carrier configuration	For 4-holed button				For 2-holed button			
								
	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	Dimension B(mm) carrier pin diameter	Part No.	Symbol
Standard	2.8	1.4	178-57004	E	3.4	1.4	178-58606	T
	3.4	1.4	178-57400	H	4.2	1.4	178-58804	V
Optional	2.0	1.0	178-56600	A	2.0	1.0	178-58802	M
	2.4	1.2	178-56709	B	2.4	1.2	178-58101	N
	2.6	1.2	178-56808	C	2.6	1.2	178-58200	P
	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
	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	K	4.6	1.4	178-59000	X
	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)

Button set pin		Marble button	Shank button	Metallic button
Description	Part No.			
A for marble button 	179-74056	Use A	 20mm 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

\* 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 consistent-quality 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.

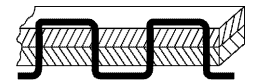


FLS-350NA

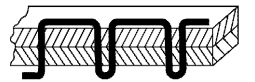
**SPECIFICATIONS**

Model name	FLS-350NA	FLS-350NB
	Standard	For thick thread
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	ORGAN DPN1032B1/49 SCHMETZ 1032B1/49
Thread (JUKI-specified threads)	●Handstitching thread: FUJIX's New Wax Silk (for light-weight materials) ●Synthetic thread: FUJIX's KING FIT #60	●Synthetic thread: ONUJI LIMITED. ACE CROWN (Tetoron) #8
	#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	7mm	
Lubrication	By an oiler	
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)	
Power consumption	700W	
Dimensions	1,200mm (W) × 800mm (D) × 870mm (H)	
Total weight	300kg	

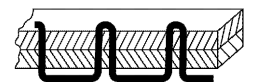
**TYPES OF STITCHES**



Saddle stitch



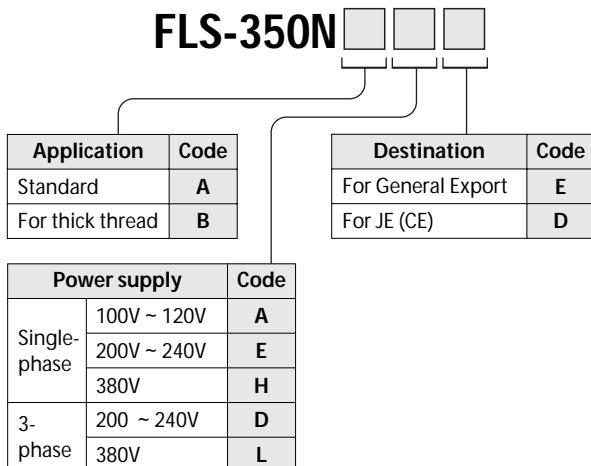
Long and short stitch



Short and long stitch

**WHEN YOU PLACE ORDERS**

**FLS-350N**



**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	

## Automatic Serging Machine

**ASN-395L** (standard air pressure type)

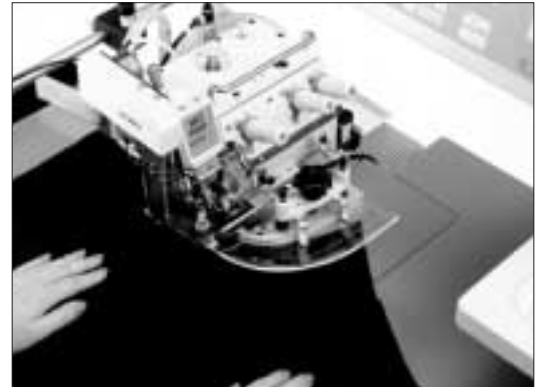
**ASN-395T** (standard airless type)

**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.



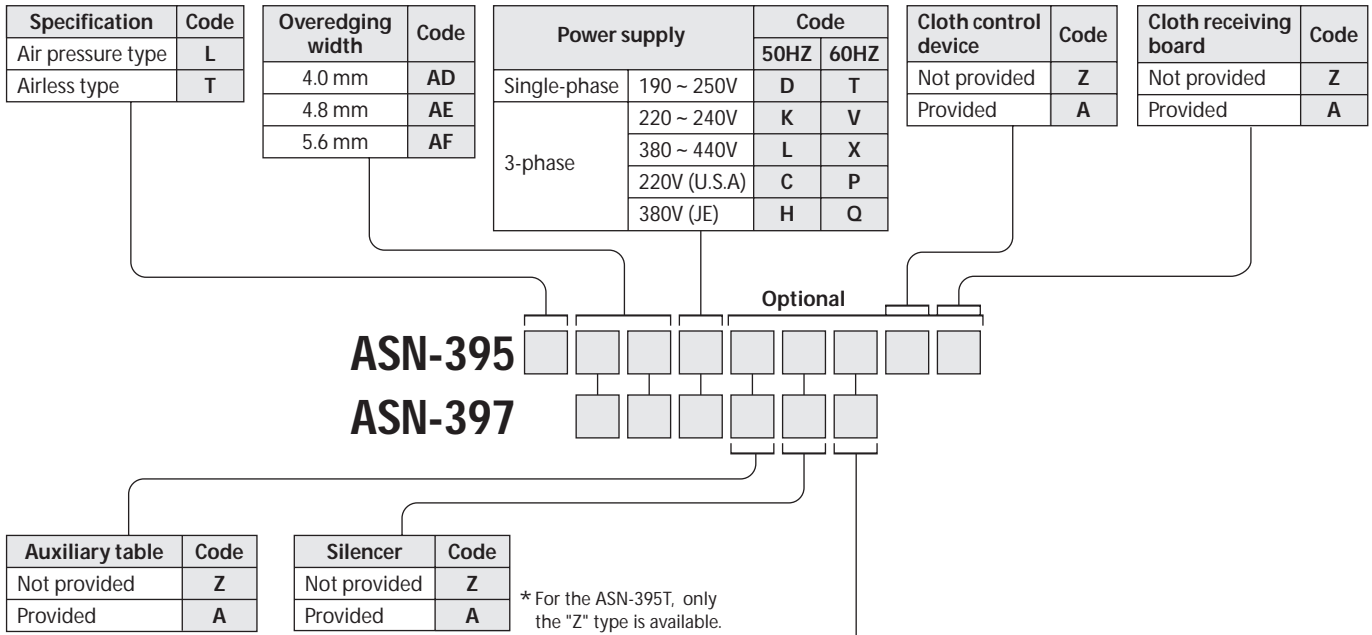
ASN-395L



## 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 x 27 (#11) #9 ~ #14		
Chain-off thread trimmer	T038 (suction type side cutter)		
Sewing specifications	Cutting curve : 200R or more (40R or more when cloth control device is used) Cloth size : Width 400mm or less Length 480mm or more (length for which stacking is possible) Number of cloth : Limited to 1.		
Class of work	Men's slacks, one-piece, skirt, pants, coat etc.		
Speed control function	Can be set at either "automatic" or "manual"	Manual	
Cloth control device (sharp curve sewing device)	Provided as standard	Option	
Cloth receiving board	Provided as standard	Option	
Curve detecting function	Both out-curve and in-curve are detected		
Curly 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	Option		
Lubrication	Automatic (machine head)		
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)		
Power requirement	Single-phase 190 ~ 250V, 3-phase 220 ~ 240V, 380 ~ 440V, 220V, 380V		
Power consumption	700W		50HZ: 835W, 60H: 905W
Compressed air and air consumption	0.5MPa (5kgf/cm <sup>2</sup> ), 220Nℓ/min (when the stacker is used: 250Nℓ/min)	0.5MPa (5kgf/cm <sup>2</sup> ), 170Nℓ/min (when the stacker is used: 220Nℓ/min)	
Dimensions (mm)			
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



For ASN-397

Optional device					Code
Stacker		2-pedal unit	Differential-feed pedal	Cloth feed device	
SS40	SS42				
					Z
					A
					B
					C
					D
					E
					K
					L
					M
					N

For ASN-395L, ASN-395T

Optional device						Code
Stacker		Differential-feed device	2-pedal unit	Air blower	Cloth feed device	
SS40	SS42					
						Z
						A
						B
						C
						D
						E
						F
						G
						H
						J
						K
						L
						M
						N
						P
						Q
						R
						S

\* For the ASN-395T, only the "Z" type is available.

## OPTIONS

S: Provided as standard

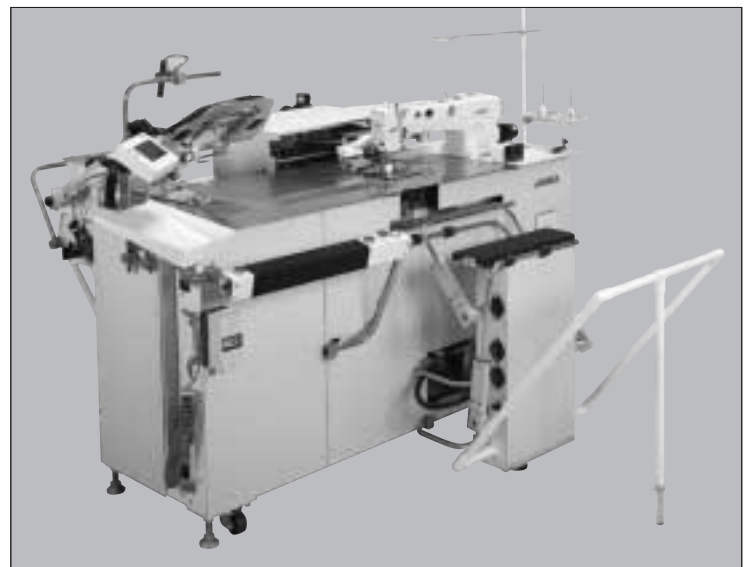
Model	Part No.	Description	Feature	397	395L	395T
SS40	GSS-40000B0	Single stacker	The max. number of garments that can be stacked is 70.			
SS42	GSS-420010B0	Double stacker	The max. number of pieces of garments that can be stacked is 140.			
	G5925-397-0A0	Cloth feed device				
	GMC-08042000	Silencer	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	Cloth control device	The ball-based control mechanism demonstrates its performance when sewing small parts or sharp curves.			
	G5051-395-0A0					
	G5050-397-0A0			S		
	G5060-397-0A0	Cloth receiving board		S		
	G5420-397-0A0	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.

## 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 <sup>2</sup> ), 120Nℓ/min
Total weight	640kg
Dimensions	1,850mm (W) × 1,830mm (D) × 1,200mm (H)

## WHEN YOU PLACE ORDERS

Specification	Code	Option	Code	Marking light	Code
Single-line stitching	W	Remaining bobbin thread detector	A	With one marking light	A
Double-line stitching		Not provided	Z	With two marking light	B
				Not provided	Z

AVP870W

Pattern			Thread tension controller No. 3	Code
Classification of pattern shapes	Code	Type	Provided	A
Single-line	Round	A	Not provided	Z
	Pointed	B		
	Rounded square shape	C		
	Bilge-shape	D		
	Square	E		
Double-line	Round	J		
Others		X		
Not provided with a replaceable pocket pattern jig				999

## OPTIONS

Model	Part No.	Description	Feature
PGM-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.

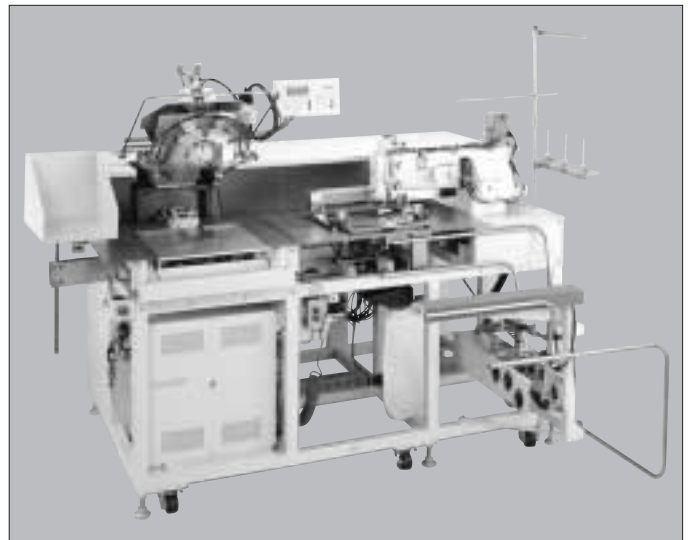
## Automatic Pocket Setter (for jeans)

# AVP-875S

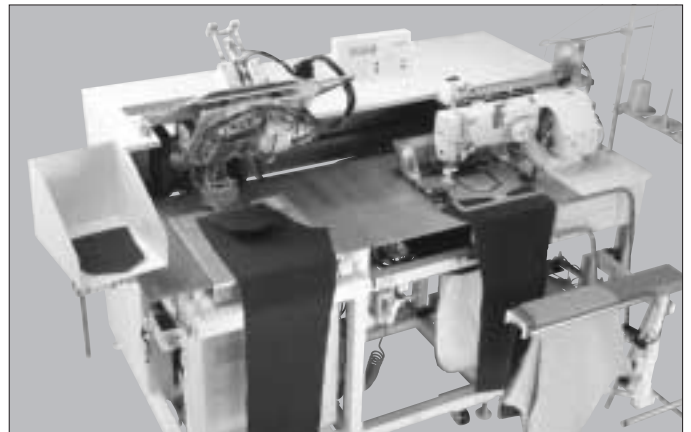
- The machine automates a series of pocket-setting processes, concurrently folding and sewing sequential pocket cloths in the production line, thereby resulting in substantial labor savings. With its newly developed large-hooked zigzag stitching lockstitch machine head, the machine runs at a maximum 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.

## AVP-875A (with an automatic bobbin thread winding and feeding device AW-2)

- 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.

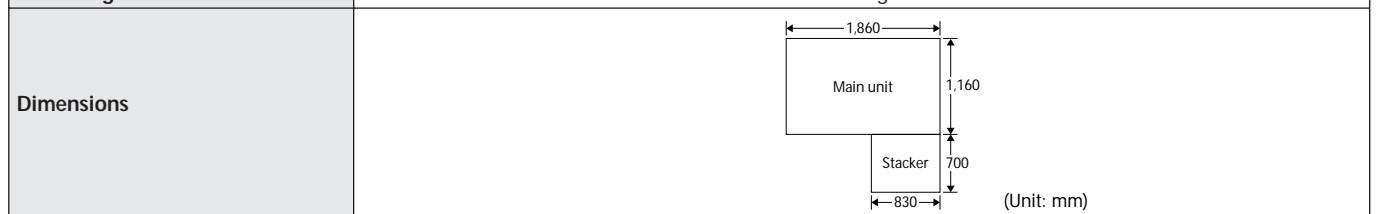


AVP-875A



## 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) x 240mm (W)	
Stitch length	0.1 ~ 6.0mm	
Needle bar stroke	35mm	
Needle (at the time of delivery)	SCHMETZ 134SES 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	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" micro-floppy disk	
Feeding method	AC servomotor, X-Y clamp drive	
Lubrication	Automatic (machine head)	
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	
Power requirement	Single-phase 200 ~ 240V, 3-phase 200V, 200 ~ 240V, 380 ~ 440V	
Power consumption	600VA	
Compressed air	0.5MPa (5.0kgf/cm <sup>2</sup> )	
Air consumption	120Nℓ/min	220Nℓ/min (max.)
Total weight	600kg	



\* The automatic bobbin thread winding and feeding device (AW-2) cannot be mounted on the AVP-875S after setup.



## WHEN YOU PLACE ORDERS

AVP-875         S

Type	Code
Standard	S
With AW-2	A

Power supply		Code
Single-phase	200 ~ 240V	E
3-phase	200 ~ 240V	P
	380 ~ 440V	N
	200V for CE	M

Pocket style jig				
Configuration	Code	Kind	Label-inserting device	Code
Not used	Z	999	Not provided	Z
Round-bottom type	A	001 ~ 998 for each configuration	Not provided : Z Provided : A	
Blade-shape bottom type	B			
Trapezoidal-bottom type	C			
Bilge-shaped-bottom type	D			
Square-bottom type	E			
Others	X			

Option		
Garment put base	Marking light	Code
Not provided	Not provided	Z
Provided	Not provided	A
Not provided	Provided	B
Provided	Provided	C

## TRIAL CALCULATION OF PRODUCTIVITY TRIAL CALCULATION 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	Part No.	Description	Feature
PGM-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.
	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)



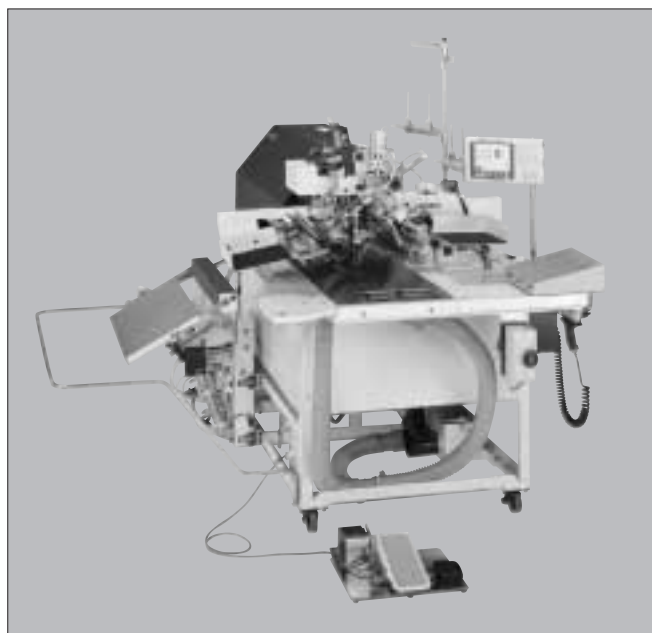
Clamp lower plate (machined)

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 after-process.
- 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		APW-297	APW-298
		For straight pocket with flap	For slanted pocket with flap
Max. sewing speed		3,000rpm (1,000 ~ 3,000rpm)	
Stitch length	Regular stitching	Standard: 2.5mm (2.0 ~ 3.4mm)	
	Fastening stitching	Standard: 1.0mm (0.5 ~ 1.5mm)	
	Safety 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, slant double welt, slant single welt, trapezoidal stitching (with/without flaps)
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 maximum)	
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 (#16) #16 ~ #18 SCHMETZ SY3355 Standard (Nm100) Nm100 ~ Nm110
Needle bar stroke		34.4mm	33.4mm
Thread		SPUN #50	
Hook		Vertical-axis 1.6 fold-capacity hook	
Machine head		2-needle, needle-feed, lockstitch machine with a center knife	2-needle, needle-feed, lockstitch machine with an organized split needle bar and a center knife
Machine head motor		Compact AC servomotor (direct-drive system)	
Thread take-up		Slide type	
Lubrication		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	
Automatic welting patch feeder		Provided as standard	
Bobbin thread remaining amount detecting device		Provided as standard	
Bobbin winder		By an external motor	
Power consumption		550W	
Compressed air and air consumption		0.5MPa (5.0kgf/cm <sup>2</sup> ), 40Nℓ/min	
Total weight		330kg	350kg
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

Automatic welting patch feeder		Code	Stacker		Code	Single-welt change-over function		Code	Power supply			Code
Standard: Automatic welting patch feeder (right)		R	Not provided		Z	Not provided		Z	Single-phase	220V	D	
SA102 Welting patch cutting device		A	SP44 Clamp bar stacker		N	SA111 Right		G	3-phase	220V	K	
			SP45 Roller stacker		P					380V	L	

**APW 297**  
**298**

Automatic flap feeder		Code	Pocket lip width (needle gauge: mm)		Code
Not provided		Z	10		B
SA103 Automatic flap feeder (left)		A	12		C
SA104 Automatic flap and pocket bag feeder (left)		B			

Option		Code
Not provided		ZZ
SA106 Dart stretcher/ SA107 Automatic pocket bag presser/ SA108 Suction device/ SA109 Automatic interlining feeder		J0
SA106		J1
SA106/SA108/SA109		J2
SA106/SA108		J3
SA106/SA107		J4
SA106/SA108/ SA91 Suction motor/SA109		J5
SA109		J6
SA106/SA107/SA108		J7
SA106/SA107/SA108/SA91		J8
SA106/SA108/SA91		J9
SA106/SA116 Vacuum table		K0
SA106/SA107/SA116		K1
SA106/SA108/ SA105 Automatic pocket bag feeder (right)		K2
SA106/SA108/SA105/SA109		K3
SA106/ SA115 Automatic interlining presser		K4

Welt patch and welt patch base plate							
Double-welt				Right single-welt			
Pocket lip width (needle gauge: mm)	Size of welt patch base plate		Code	Pocket lip width (needle gauge: mm)	Size of welt patch base plate		Code
	L-size	R-size			L-size	R-size	
10	3.8	3.8	B0	10	3.8	8.5	M4
12	4.8	4.8	B9	12	4.8	10.5	M5

The same optional parts are offered for the APW-297 and APW-298.

## NEWLY DEVELOPED DEVICES (OPTIONAL)

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 style="list-style-type: none"> <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 patches even when the binder is in the lower position. This further eliminates wasted time due to welting patch cutting.</li> </ul>
SA103	Automatic flap feeder	<ul style="list-style-type: none"> <li>The fulcrum at the center of the automatic flap feeder claw clamps flaps securely and automatically feeds them to the sewing position. This promises increased productivity.</li> </ul>
SA104	Automatic flap and pocket bag feeder	<ul style="list-style-type: none"> <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)	<ul style="list-style-type: none"> <li>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.</li> </ul>

## 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	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

### ● APW-196N

The machine is provided as standard with a turret-type 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

Model name		APW-194N	APW-195N	APW-196N
		For without pocket type	For flap sewing type	For slanted pocket sewing type
Sewing speed		Normal 2,500rpm (1,000 ~ 2,500rpm)		
Stitch length	Regular stitching	Standard: 2.0mm (2.0 ~ 3.4mm)		
	Fastening stitching	Standard: 1.0mm (0.5 ~ 1.5mm)		
	Safety 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 length (welt length)		Needle gauge 8 ~ 12mm: 35 ~ 180mm, Needle gauge 14mm or more: 50 ~ 180mm * By using the corresponding optional device, sewing length can be set to 18mm or more. However, for the sewing length of 21mm or less, neither the center knife nor the corner knife can be used.		
Number of patterns that can be stored in memory		10 patterns		
Cycle sewing		Possible (max. 5 different patterns can be combined)		
Needle gauge		8, 10, 12, 14, 16, 18, 20mm		
Needle (at the time of delivery)		ORGAN Mt x 190 (#16) #16 ~ #18 SCHMETZ 190R (Nm100) Nm100 ~ Nm110		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		
Machine head		2-needle, lockstitch machine with a center knife		2-needle, lockstitch machine with an organized split needle bar and a center knife
Thread take-up		Slide type		
Lubrication		By an oiler (machine head and hook)		
Lubricating oil		JUKI New Defrix Oil No.2 (equivalent to ISO VG32)		
Cloth feed system		By a servomotor drive		
Bobbin thread remaining amount detecting device		Provided as standard		
Power consumption		500W		
Compressed air and air consumption		0.5MPa (5.0kgf/cm <sup>2</sup> ), 40Nℓ/min		
Total weight		200kg		220kg
Dimensions (excluding the stacker)		735mm (W) x 1,250mm (D) x 1,200mm (H)		
Height of table		820mm		

# WHEN YOU PLACE ORDERS

Pocket lip width (needle gauge: mm)	Code
8	A
10	B
12	C
14	D
16	E
18	F
20	G

**Option**  
See the under of this sheet.

Main unit	Code
Standard main unit with a side cover	A
Shim-type main unit with a side cover	B
Main unit with a side cover for vacuum device	C

Power supply	Code	
Single-phase	220V	D
	230V	G
	240V	E
3-phase	220V	K
	230V	Q
	240V	P
	380V	L
	400 ~ 415V	M
	440V	N

**194N**  
**APW-195N**  
**196N**



Knife	Code
Right	1
* Left	2

\* For APW-194N, only "2" of "left-knife" is available.

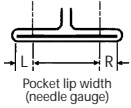
Stacker	194N	195N	196N	Code
Not provided				Z
SP41 (grasping stacker)				J
SP42 (bar stacker)				K
SP43 (roller stacker)				L
SP42+SP43 (roller bar stacker)				M

: Main stacker : Can be combined

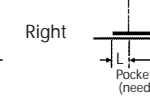
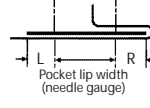
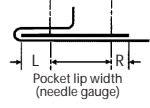
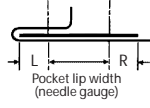
Single-welt change-over function	194N	195N*	196N	Code
Not provided				Z
SA97N left				D
SA97N right				E
SA97N both-side				F
SA98 left				L
SA98 right				R

\* For APW-195N, SA-98 of single-welt change-over function is delivered as standard.

Double-welting



Single-welting



## Welt patch and welt patch base plate

Double-welt				Single-welt								Variant double-welt			
Pocket lip width (needle gauge)	Size of welt Patch base plate		Code	Pocket lip width (needle gauge)	Size of welt Patch base plate		Code	Pocket lip width (needle gauge)	Size of welt Patch base plate		Code	Pocket lip width (needle gauge)	Size of welt Patch base plate		Code
	L-size	R-size			L-size	R-size			L-size	R-size			L-size	R-size	
8	3.3	3.3	A0	8	7.3	7.3	J0	8	7.3	3.3	L0	10	8.3	0.5	S1
10	4.3	4.3	A1	10	9.3	9.3	J1	8	3.3	7.3	L1				
12	5.3	5.3	A2	12	11.3	11.3	J2	10	9.3	4.3	L2				
14	6.3	6.3	A3	14	13.3	13.3	J3	10	4.3	9.3	L3				
16	7.3	7.3	A4	16	15.3	15.3	J4	12	11.3	5.3	L4				
18	8.3	8.3	A5	18	17.3	17.3	J5	12	5.3	11.3	L5				
20	9.3	9.3	A6	20	19.3	19.3	J6	14	13.3	6.3	L6				
10	3.8	3.8	B0					14	6.3	13.3	L7				
								16	15.3	7.3	L8				
								16	7.3	15.3	L9				
								18	17.3	8.3	M0				
								18	8.3	17.3	M1				
								20	19.3	9.3	M2				
								20	9.3	19.3	M3				

## Options

○: Can be attached to the machine S: Provided as standard (not included in options) with the machine


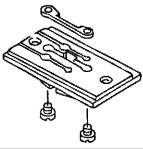
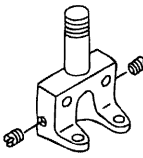



Code	Name of optional devices	APW-194N			APW-195N			APW-194N		
		Table type			Table type			Table type		
		Standard	Shim	Vacuum	Standard	Shim	Vacuum	Standard	Shim	Vacuum
ZZ	Not provided									
A2	SA84 Dart stretcher	○	○	○	○	○	○	○	○	○
A6	SA92 Pocket bag clamping device		S							
A7	SA88 Table stand for standing work	○	○	○	○	○	○	○	○	○
A8	SA89 Small welt sewing device									
B1	SA94 Center reference device	○	○	○	○	○	○	○	○	○
B8	SA84/SA92									
E9	SA101 Pocket bag clamping device	S		S	○	○	○	○	○	○
F1	SA84/SA101									
F3	SA84/SA89/SA90N/SA101						○			○
G0	SA86N Automatic interlining feeder									
G1	SA84/SA86N	○		○	○		○	○		○
G2	SA86N/SA89									
G3	SA90N Suction device			○			○			○
G4	SA90N/SA91									
G5	SA96N Flap presser device	○	○	○						
G6	SA84/SA96N									
G7	SA88/SA96N	○	○	○						
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.
SA85N	GSA-85000DA0B	Needle gauge: 8, 10, 12mm	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.
	GSA-85000EA0B	Needle gauge: 14, 16mm	
	GSA-85000FA0B	Needle gauge: 18, 20mm	
SA86N	GSA-86000DA0	Needle gauge: 8 ~ 16mm	Automatic interlining feeder To improve workability, the automatic interlining feeder automatically delivers rolled interlining cloth onto the table and cuts it.
	GSA-86000EA0	Needle gauge: 18, 20mm	
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.)
SA90N	GSA-90000GA0	Needle gauge: 8 ~ 12mm	Suction device (for sim type table) 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).
	GSA-90000HA0	Needle gauge: 14, 16mm	
	GSA-90000IA0	Needle gauge: 18, 20mm	
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 concurrently. * This device equipped as standard for APW-194N. (SA92 or SA101)
SA101		Automatic pocket bag presser (for standard table and vacuum type table)	
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 sewing welts with flaps.
	GSA-96000BA0B	Needle gauge: 16 ~ 20mm	
SA97N	GSA-97000GA0A	Needle gauge: 8 ~ 14mm (for left)	Single-welt and double-welt change-over device (for APW-195N, APW-196N) 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 easily changed over between double-welt type and single-welt type simply by 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 ones, and the double-side welt type designed to change over the welt type between the left and right single-welt types.
	GSA-97000HA0A	Needle gauge: 16 ~ 20mm (for left)	
	GSA-97000IA0A	Needle gauge: 8 ~ 14mm (for right)	
	GSA-97000JA0A	Needle gauge: 16 ~ 20mm (for right)	
	GSA-97000IA0A	Needle gauge: 8 ~ 14mm (for double)	
	GSA-97000JA0A	Needle gauge: 16 ~ 20mm (for double)	
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.

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## SEWING MACHINE COMPONENTS

Needle gauge	Throat plate asm.		Needle clamp asm.	Knife	Needle thread counter knife	Needle thread clamp plate
						
	For knife, left	For knife, right*				
	Part No.	Part No.				
8mm (5/16")	164-01150	164-02356	G1402-116-JA0	251-37100	164-09906	164-10201
10mm (25/64")	164-01259	164-02455	G1402-116-BA0			
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			
16mm (5/8")	164-01556	164-02752	G1402-116-EA0	164-10508	164-09906	164-10201
18mm (45/64")	164-01655	164-02851	G1402-116-FA0			
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



		Single-welt				
		WELT patch ruler	Clamp foot spacer		Clamp foot collar setscrew	Foot collar
Needle gauge	Size (mm)	Part No.	T	Part No.	Part No.	Part No.
8mm (5/16")	L 7.3	253-11713	7	169-15506	SM-6052002-TP	169-08709 (L=31)
	R 7.3		7	169-15506		
	L 7.3	253-12414	7	169-15506		
	R 3.3		3	169-15100		
	L 3.3	253-13115	3	169-15100		
	R 7.3		7	169-15506		
10mm (25/64")	L 9.3	253-11812	9	169-15605		
	R 9.3		9	169-15605		
	L 9.3	253-12513	9	169-15605		
	R 4.3		4	169-15209		
	L 4.3	253-13214	4	169-15209		
	R 9.3		9	169-15605		
12mm (13/32")	L 11.3	253-11911	11	169-15704	SM-6052502-TP	
	R 11.3		11	169-15704		
	L 11.3	253-12612	11	169-15704		
	R 5.3		5	169-15308		
	L 5.3	253-13313	5	169-15308		
	R 11.3		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	253-13412	6	169-15407		
	R 13.3		13	169-15803		
16mm (5/8")	L 15.3	253-12117	22	169-16009	SM-6053502-TP	
	R 15.3		22	169-16009		
	L 15.3	253-12810	22	169-16009		
	R 7.3		14	169-15902		
	L 7.3	253-13511	14	169-15902		
	R 15.3		22	169-16009		
18mm (45/64")	L 17.3	253-12216	24	169-19201	SM-6053002-TP	
	R 17.3		24	169-19201		
	L 17.3	253-12919	24	169-19201		
	R 8.3		15	169-19102		
	L 8.3	253-13610	15	169-19102		
	R 17.3		24	169-19201		
20mm (25/32")	L 19.3	253-12315	26	168-95609	SM-6053002-TP	
	R 19.3		26	168-95609		
	L 19.3	253-13016	26	168-95609		
	R 9.3		16	169-19300		
	L 9.3	253-13719	16	169-19300		
	R 19.3		26	168-95609		

		Double-welt				
		WELT patch ruler	Clamp foot spacer (right and left each one)		Clamp foot collar setscrew (right and left each one)	Foot collar (right and left each one)
Needle gauge	Size (mm)	Part No.	T	Part No.	Part No.	Part No.
8mm (5/16")	L 3.3	253-11010	3	169-15100	SM-6052002-TP	169-08709
	R 3.3					
10mm (25/64")	L 4.3	253-11119	4	169-15209		
	R 4.3					
12mm (13/32")	L 5.3	253-11218	5	169-15308		
	R 5.3					
14mm (35/64")	L 6.3	253-11317	6	169-15407		
	R 6.3					
16mm (5/8")	L 7.3	253-11416	14	169-15902		
	R 7.3					
18mm (45/64")	L 8.3	253-11515	15	169-19102	SM-6053002-TP	
	R 8.3					
20mm (25/32")	L 9.3	253-11614	16	169-19300		
	R 9.3					



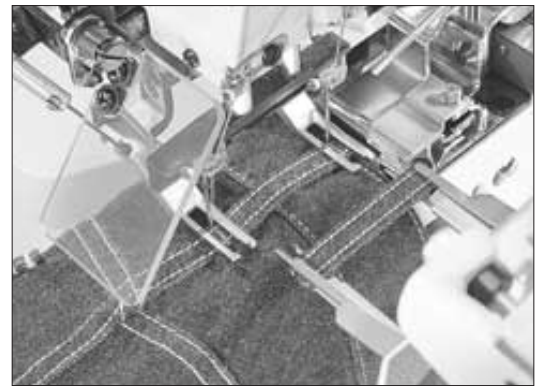
## Automatic 2-needle Belt-loop Attaching Machine

# 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



## 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 x 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 <sup>2</sup> ), 32Nℓ/min
Total weight	230kg
Dimensions	1,200mm (W) x 800mm (D) x 1,350mm (H: in its lowest end)
Height of the top surface of the throat plate as from the floor surface	920 ~ 1,250mm (provided with the adjustable stand capability)

## WHEN YOU PLACE ORDERS

MOL-254

Power supply		Code
Single-/3-phase	200 ~ 240V	D
	220 ~ 400V	L
	220 ~ 400V (For CE)	M

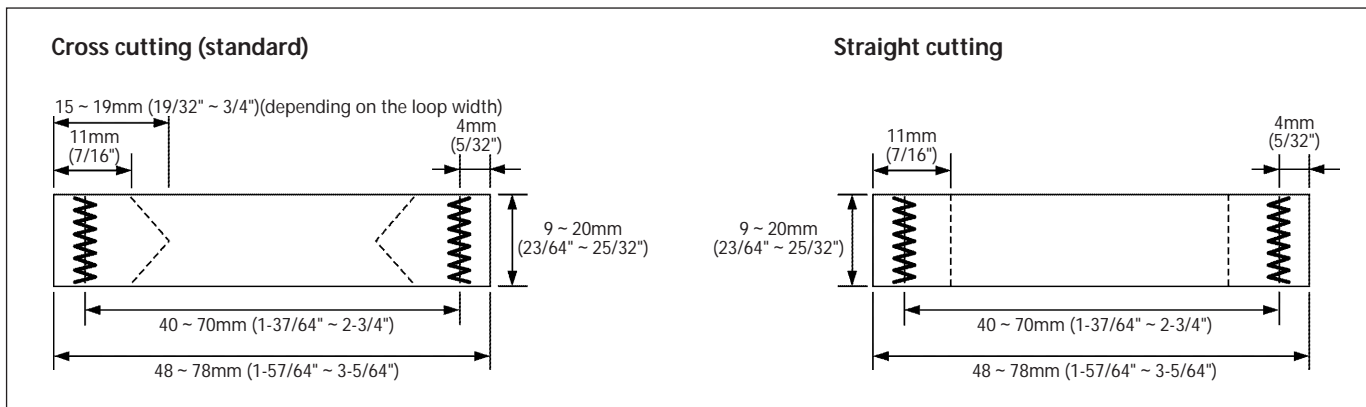
Option	Code
No options	Z
Belt-loop tension releasing device (fullness)	A
Belt-loop feeding device	B
Air gun	C
Needle cooler	D
Needle thread breakage detector	E

\* 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 optimally 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, smoothed 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.



DDL-8700L



### SPECIFICATIONS

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

### WHEN YOU PLACE ORDERS

#### DDL-8700L

Application	Code
For leather and heavy-weight materials	L

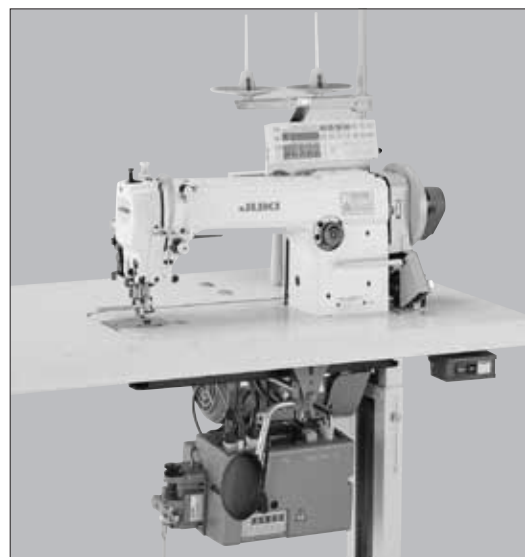
1-needle, Top & Bottom-feed, Lockstitch Machine

# DU-140

## DU-141NH (with a double-capacity hook)

## DU-141H-7 (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 reverse-feed 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
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	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	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)		
Distance from needle to machine arm	265mm	270mm	
Bed size	477mm x 178mm		
Weight of the machine head	32kg		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

- Without an automatic thread trimmer

## DU-140 DU-141NH

- With an automatic thread trimmer

## DU-141H-7-0B/□

Automatic reverse feed function	Code
provided	0B

Pneumatic auto-lifter (optional)	Code
Knee switch type (AK114C)	C
Pedal switch type (AK114B)	B
Not provided	

- PSC box/control panel for SC

## SC-380-□□-□□□□□□

PSC box		Code	
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

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

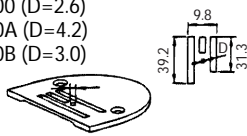

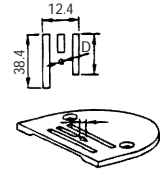
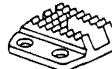
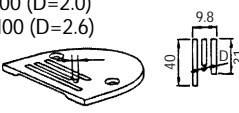


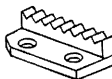
## M□□

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

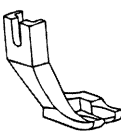




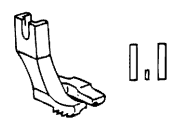

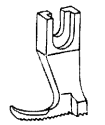
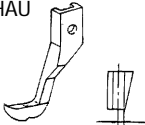
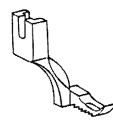
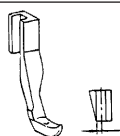
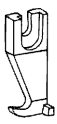



\* JUS: North America and Central and South America.

## 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
	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-H0T

### ● For DU-140, DU-141NH, DU-141H-7

Description	Walking foot	Presser foot	Notes
Standard	B1526-141-H0A 	B1525-141-HA0 	
For piping	B1527-141-H0 	B1527-141-HA0 	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 		
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 	B1526-141-HAB 	Stitch length: max. 6mm Exclusive parts Feed dog: 114-05701 Throat plate: 114-05800
For attaching zippers	B1527-141-H0X 	B1526-141-H0X 	Without hardening (blank)

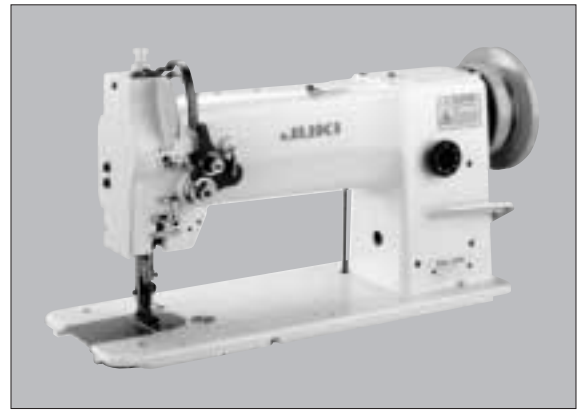
1-needle, Unison-feed, Lockstitch Machine with a Large Hook

## DNU-241H

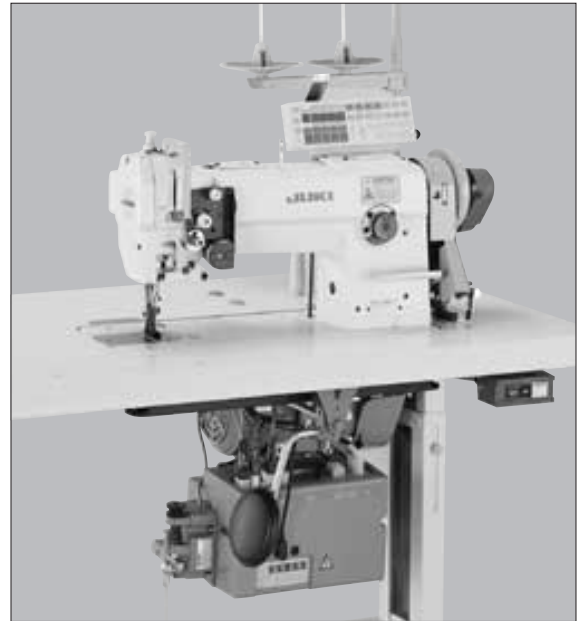
**DNU-241HS** (with a safety device for hook)

**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-OB/XC-E500

## SPECIFICATIONS

Model name	DNU-241H	DNU-241HS	DNU-241H-7
Max. sewing speed	2,000rpm		2,400rpm
Max. stitch length	8mm (normal/reverse feed)		
Needle bar stroke	33.4mm		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	Horizontal-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 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V		

## WHEN YOU PLACE ORDERS

### ● Without an automatic thread trimmer

DNU-241H

Safety device for hook	Code
Not provided	/
Provided	S

### ● With an automatic thread trimmer

DNU-241H-7-0B/

Automatic reverse feed function	Code
Provided	0B

Pneumatic auto-lifter (optional)	Code
Knee switch type (AK110C)	C
Pedal switch type (AK110B)	B
Not provided	/

\* Note that the auto-lifter cannot be installed on the machine after the set-up.

### ● PSC box/control panel for SC

SC-380-   -

PSC box			Code
For General Export	Single-phase	220 ~ 240V	07
	3-phase	220 ~ 220V	11
For JUS (LA)*	Single-phase	110 ~ 120V	37
	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

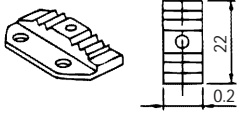
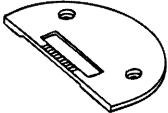
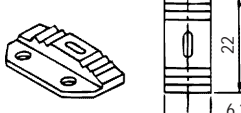

M

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


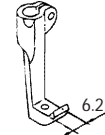

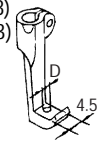

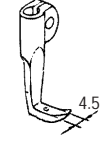

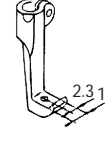
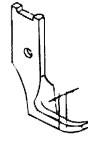
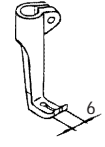

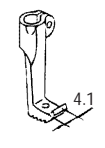
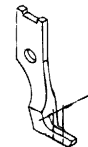
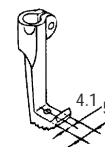

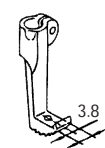
\* JUS: North America and Central and South America.

## EXCHANGEABLE GAUGE PARTS

### ● For DNU-241H(S), DNU-241H-7

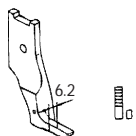
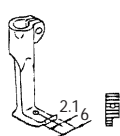

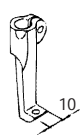

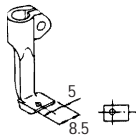
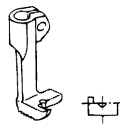
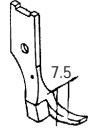
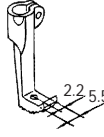
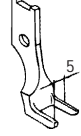
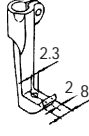
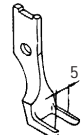
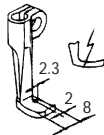




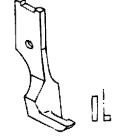
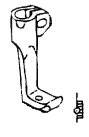
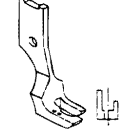

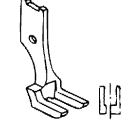



Description	Throat plate	Feed dog	Notes
Standard (without groove)	B1105-241-H00A	D1613-241-E00 	Needle hole: 4 × 2.5mm
For thin needles		D1613-241-E0A 	Needle hole: 2.6 × 2.2mm
With groove		D1613-241-E0B 	Needle hole: 4 × 2.5mm

### ● For DNU-241H(S), DNU-241H-7, DNU-261H

Description	Presser foot	Walking foot	Notes
Standard	B1525-241-HA0 	B1470-241-HA0 	For DNU Stitch length: max. 10mm
	B1525-053-0A0 	B1470-053-000 (D=2.8) B1470-053-C00 (D=2.3) 	For LU & LS Stitch length: max. 10mm
	B1525-562-BA0 	B1470-562-B00 	Stitch length: max. 10mm With teeth
	B1525-563-E00 	B1470-563-E00 	Stitch length: max. 10mm
Left-hand type	B1524-245-0A0 	B1470-245-000 	DSC-245(-7), 246(-7) standard Stitch length: max. 6mm
	B1529-245-0AD (special order) 	B1476-245-00D (special order) 	Stitch length: max. 8mm With teeth
	B1529-245-0AC (special order) 	B1476-245-00C (special order) 	Stitch length: max. 6mm With teeth
	B1529-245-0AB (special order) 	B1476-245-00B (special order) 	Stitch length: max. 8mm With teeth



● For DNU-241H(S), DNU-241H-S, DNU-261H

Description	Presser foot	Walking foot	Notes
Left-hand type	B1529-245-0AF (special order) 	B1476-245-00F (special order) 	Stitch length: max. 6mm With teeth
For binding	MAQ-092080A0 (with teeth) 	MAQ-09207000 	Stitch length: max. 10mm
	MAQ-093080A0 (with teeth) 	MAQ-09307000 	DSC-246V(-7) standard Stitch length: max. 10mm
MAN-10452000 		DSC-245V(-7) standard Stitch length: max. 10mm	
Right-hand type	B1529-245-00A 	B1476-245-00A 	Stitch length: max. 8mm With teeth
Wide type	103-25157 	103-25306 	Stitch length: max. 10mm Exclusive parts (for LU-1114) Throat plate: 103-25009 Feed dog: 103-25207
For leather (without teeth)	103-26304 	103-26205 	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) 	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 	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 	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, Unison-feed, Lockstitch Machine with a Vertical-axis Large Hook

# 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 thread trimmer)

● 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 reduce gathered stitches.

### Complete rectangular feed LU-1508H

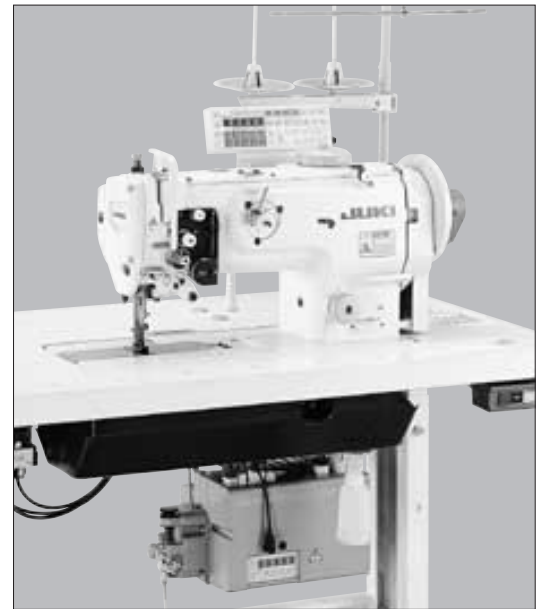
The locus of the "needle" and "feed" motions are nearly rectangular. This prevents stitch gathering and provides efficient feed on multi-layered portions of material.

● With the adoption of a new rectangular feed mechanism, an alternating vertical movement mechanism, and a unison-feed 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 heavy-weight materials while preventing stitch gathering.
- With its sufficient needle bar stroke of 38mm and long 190R needle, the machine supports the sewing of extra heavy-weight 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

### ● Without an automatic thread trimmer

LU-1508  LU-1510

Application	Code
Standard	
For extra heavy-weight materials	H

### ● With an automatic thread trimmer

LU-1510-7-0B

Pneumatic auto-lifter	Code
Knee switch type (AK119A)	A
Pedal switch type (AK119B)	B
Not provided	

### ● Motor for SC

M

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

### ● PSC box / control panel for SC

SC-380-   -

PSC box			Code
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

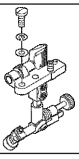
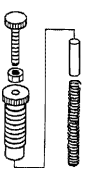
Control panel		Code
Not provided		00000
Control panel display language: English. Instruction manual comes in three different languages.		E500B
Control panel display language: English. Instruction manual comes in five different languages.		E500C

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


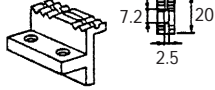
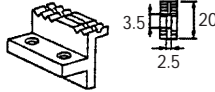

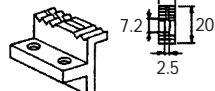
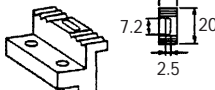
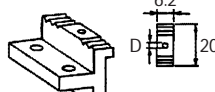



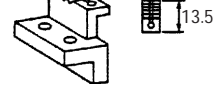
## SPECIFICATIONS

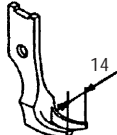



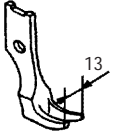


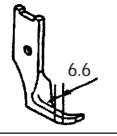

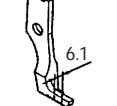

Model name	LU-1508	LU-1508H	LU-1510	LU-1510-7
Application	For heavy-weight materials	For extra heavy-weight materials	For heavy-weight materials	
Max. sewing speed	2,500rpm	2,000rpm	2,500rpm	3,000rpm
Max. stitch length	9mm (normal/reverse feed)	10mm (normal/reverse feed)	9mm (normal/reverse feed)	
Needle 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 double-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 × 17 (Nm160) Nm125 ~ Nm180 DP × 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, 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	By an oiler (hook: automatic)		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	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 <sup>2</sup> ), 0.3Nℓ/min
Power requirement				Single-phase 110 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V






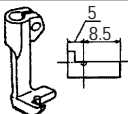
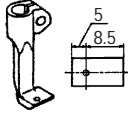




















## OPTIONS

Model	Part No.	Description	Feature
AK119A	GAK-A19010A0	Knee switch type	Applicable model: LU-1510-7
AK119B	GAK-A19010B0	Pedal switch type	
AK120A	GAK-A20010A0	Knee switch type	Applicable model: LU-1508, LU-1508H, LU-1510
AK120B	GAK-A20010B0	Pedal switch type	
	213-48552	Pneumatic one-touch type reverse feed stitching device (provided with an air 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
H152	MAH-152010A0	Suspended ruler	
	SS-7151610-SP × 2		
	WP-0621016-SD × 2		
	WP-0610002-KN × 2		
	MAY-BL6B10A0	Core dia. 6 ~ 10mm	Piping holder
	MAY-BL6B20A0	Core dia. 2 ~ 5mm	
PK75		3-pedal unit	Applicable model: LU-1510-7 Highly operable 3-pedal unit for standing work.
	210-06507	Additional spring for presser bar	
	NS-6110530-SP		
	210-06408		
	210-16101		
	210-06002 × 3		

# EXCHANGEABLE GAUGE PARTS

Description	Throat plate	Feed dog	Notes
Lower fittings standard (equipped on machine)	B1109-563-000 (area: 33.2 × 6.6) 	213-49303 (needle hole: 2.5 × 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)
		213-49204 (needle hole: 2.5 × 3.5) (groove in front and back) 	Equipped on LU-1510-7 Stitch length up to 9mm
Lower fittings standard	B1109-053-00A (area: 31.7 × 6.6) 	B1613-563-000 (needle hole: 2.5 × 7.2) (groove at back) 	Equipped on LU-563N Stitch length up to 9mm Not applicable to LU-1510-7
Lower fittings (no groove)		B1613-053-000 (needle hole: 2.5 × 7.2) (No groove) 	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
Upper fittings standard	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
		D1470-241-E0A (width: 6.2, needle hole: 2.8) (front-open) 	Stitch length up to 10mm
		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
Upper fittings left handed	B1524-245-0A0 (width: 9.6mm) 	B1470-245-000 (width: 6, needle hole: 2.2) (front-open) 	Stitch length up to 6mm
	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

Description	Presser foot	Walking foot	Notes
Upper fittings left handed	B1529-245-0AD (width 6.7mm) (with teeth) 	B1476-245-00D (width 4.1, needle hole: 2.6) (with teeth) 	Stitch length up to 8mm
	B1525-563-SAD (width 9.4mm) (with teeth) 	103-38309 (width 4.5, needle hole: 2.2) (with teeth at the toe) 	Stitch length up to 10mm
Upper fittings for binding	MAQ-093080AO (width 17mm) (with teeth) 	MAN-10452000 (width 13.5, needle hole: 2.5) (with teeth at the toe) 	Stitch length up to 10mm
		MAQ-09307000 (width 13.5, needle hole: 2.5) 	Stitch length up to 10mm
	MAQ-092080AO (width 13.5mm) (with teeth) 	MAQ-09207000 (width 10, needle hole: 2.5) 	Stitch length up to 10mm
Upper fittings right handed	B1529-245-00A (width 9.5mm) (with teeth) 	B1476-245-00A (width 5.5, needle hole: 2.6) (with teeth) 	Stitch length up to 8mm
Upper fittings wide	B1525-563-E00 	B1470-563-E00 (width 10, needle hole: 2.5 x 5) 	Stitch length up to 10mm
	103-25157 	103-25306 (width 8, needle hole: 2.3) 	Stitch length up to 10mm
	103-26304 	103-26205 (width 8, needle hole: 2.3) 	Stitch length up to 6mm
Upper fittings for piping	B1530-245-0A * : [D, F, H, K] 	B1478-245-000 (width 4.5, needle hole: 2.1) (universal, regardless of size) 	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")
	B1527-245-00 * : [C, D, F, H, K] 	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) 	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) 	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

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-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 one-touch utility lever.
- The machine produces neatly finished stitches at corner parts of the material.

**WHEN YOU PLACE ORDERS**

● Without an automatic thread trimmer

**LU-1560** □ □

Needle gauge*	Code
4.8mm (3/16")	D
6.4mm (1/4")	F
7.9mm (5/16")	H
9.5mm (3/8")	K
12.7mm (1/2")	L

**LU-1565** □ □

Needle gauge*	Code
4.8mm (3/16")	D
6.4mm (1/4")	F
7.9mm (5/16")	H

● With an automatic thread trimmer

**LU-1560** □ □ - **7-0B** □ □

Needle gauge*	Code
4.8mm (3/16")	D
6.4mm (1/4")	F
7.9mm (5/16")	H
9.5mm (3/8")	K
12.7mm (1/2")	L

Pneumatic auto-lifter	Code
Knee switch type (AK119A)	A
Pedal switch type (AK119B)	B
Not provided	

\* The needle gauge (attached with a circle ( )) in the table below are prepared as optional parts (separately available).

Model name	Needle gauge											
	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

**SC-380**- □ □ - □ □ □ □ □ □

PSC box			Code
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

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** □ □

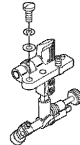
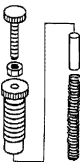
Motor			Code
For General Export	Single-phase	200 ~ 240V	60
	3-phase	200 ~ 240V	61
* For JUS (LA)	Single-phase	100 ~ 120V	61
	3-phase	200 ~ 240V	62
For CE	Single-phase	200 ~ 240V	63

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

## SPECIFICATIONS

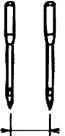
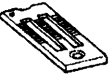
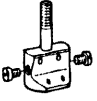
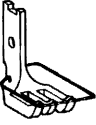

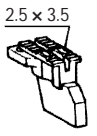


Model name	LU-1560	LU-1560-7	LU-1565
		With an automatic thread trimmer	With an organized split needle bar
Application	For heavy-weight materials		
Max. sewing speed	2,500rpm		2,000rpm
Max. stitch length	9mm (normal/reverse feed)		
Needle bar stroke	36mm		33.4mm
Lift of the presser foot	By hand: 9mm, By knee: 16mm (max.)		By hand: 9mm, By knee: 13mm (max.)
Needle gauge (mm)	4.8, 6.4, 7.9, 9.5, 12.7 (3/16", 1/4", 5/16", 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	Automatic		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/cm <sup>2</sup> ), 0.3Nℓ/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	Applicable model: LU-1560-7
AK119B	GAK-A19010B0	Pedal switch type	
AK120A	GAK-A20010A0	Knee switch type	Applicable model: LU-1560, LU-1565
AK120B	GAK-A20010B0	Pedal switch type	
	213-48552	Pneumatic one-touch type reverse feed stitching device (provided with an air regulator)	Applicable model: LU-1560, LU-1565 * To use an auto-lifter and reverse feed stitching device in combination, select AK119A or AK119B
H152	MAH-152010A0	Suspended ruler	
	SS-7151610-SP × 2		
	WP-0621016-SD × 2		
	WP-0610002-KN × 2		
	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	Additional spring for presser bar	
	NS-6110530-SP		
	210-06408		
	210-16101		
	210-06002 × 3		

# EXCHANGEABLE GAUGE PARTS

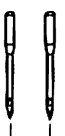
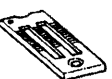
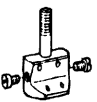


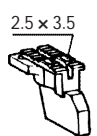


## LU-1560

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
								
	3.2mm (1/8")	213-68709	213-71554	213-70853	213-72255	213-69400	213-65606	213-65002
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		
H	7.9mm (5/16")	213-66307	213-68352	213-67859	213-72552	213-66802		
K	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	213-65705	213-65101
	15.9mm (5/8")	213-68808	213-71653	213-70952	213-72859	213-69509		
	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		
	31.8mm (1-1/4")	213-69301	213-72156	213-71455	213-73352	213-70002		

## LU-1560

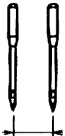
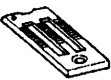



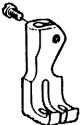

Code	Needle gauge size	Walking foot asm. Needle hole 2.6 × 7 slit
		 (option)
	3.2mm (1/8")	213-73451
D	4.8mm (3/16")	213-73550
F	6.4mm (1/4")	213-73659
H	7.9mm (5/16")	213-73758
K	9.5mm (3/8")	213-73857
L	12.7mm (1/2")	213-73956
	15.9mm (5/8")	213-74053
	19.1mm (3/4")	213-74152
	22.2mm (7/8")	213-74251
	25.4mm (1")	213-74350
	28.6mm (1-1/8")	213-74459
	31.8mm (1-1/4")	213-74558

## LU-1560-7

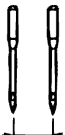





Code	Needle gauge size	Throat plate	Needle clamp asm.	Presser foot asm.	Walking foot asm. Needle hole 2.5	Feed dog Needle hole 2.5 × 3.5	Slide plate, left	Slide plate, right
								
	3.2mm (1/8")	213-68709	213-71554	213-70853	213-70150	213-69400	213-65606	213-65002
D	4.8mm (3/16")	213-66109	213-68154	213-67651	213-67156	213-66604		
F	6.4mm (1/4")	213-66208	213-68253	213-67750	213-67255	213-66703		
H	7.9mm (5/16")	213-66307	213-68352	213-67859	213-67354	213-66802		
K	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	213-65705	213-65101
	15.9mm (5/8")	213-68808	213-71653	213-70952	213-70259	213-69509		
	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		



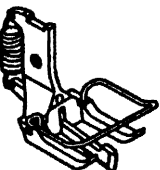

## LU-1565

Code	Needle gauge size	Throat plate	Needle clamp asm., left	Needle clamp asm., right	Presser foot asm.	Walking foot asm. Needle hole 2.6 x 7 with groove & teeth	Feed dog Needle hole 2.6 x 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
H	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 x 7 slit	Feed dog Needle hole 2.6 x 5	Feed dog Needle hole 2
				 (option)	 (option)	 (option)
D	4.8mm (3/16")	B1112-521-E00	213-77304	213-73550	B1613-521-D0A	B1613-521-D0B
F	6.4mm (1/4")			213-73659	B1613-521-F0A	B1613-521-F0B
H	7.9mm (5/16")			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

## LU-1560, LU-1560-7, LU-1565 (option)

Description	Presser foot	Walking foot	Notes
Upper fittings for french-seam (with center guide)		(a) 213-72552 (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")
		(b) 213-74756 (needle hole: 2.5) (with groove)	
(c) 213-74855 (needle hole: 2.5) (with groove)			
		(a) 213-67354 (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")
		(b) 213-67453 (needle hole: 2.5) (with groove)	
		(c) 213-67552 (needle hole: 2.5) (with groove)	

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)

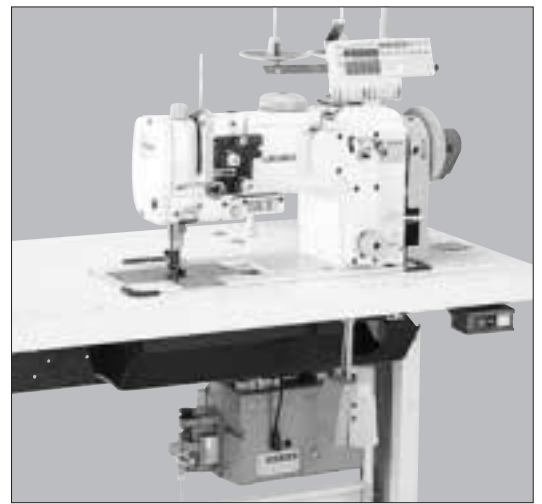
**LU-2210W-7** (double-capacity hook)

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 fold-capacity 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

## SPECIFICATIONS

Model name	LU-2210N-7	LU-2210W-7	LU-2260N-7	LU-2260W-7
	1-needle		2-needle	
Max. sewing speed	3,500rpm			
Max. stitch length	9mm (normal/reverse feed)		6mm (normal/reverse feed)	
Needle bar stroke	33.8mm			
Needle gauge (mm)			6, 8, 10 (standard), 12, 20*	
Lift of the presser foot	By hand: 9mm, By knee: 16mm (max)			
Auto lifter	Provided as standard (pneumatic 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	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 ~ B138, Nm=60/3 ~ 20/3		#20 ~ #5, B64 ~ B138, Nm=40/3 ~ 20/3	
Safety mechanism	Provided as standard			
Lubrication	Automatic			
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)			
Distance from needle to machine arm	264mm			
Bed size	517mm × 178mm			
Weight of the machine head	55kg		58kg	
Automatic reverse feed function	Provided as standard			
Compressed air and air consumption	0.5MPa (5kgf/cm <sup>2</sup> ), 0.3Nℓ/min			
Power requirement	Single-phase 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V			

\* 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	A
For thin thread (2.5mm x 1.6mm)	W

DL function	Code
Provided with DL function/push button type	A
Provided with DL function/knee switch type	B
Not provided with DL function	Z

LU-2210      -7-0B

Hook	Code
1.6 fold-capacity hook	N
Double-capacity hook	W

Walking foot	Code
Standard	A
For urethane	B
Right single-sided presser	C
Left single-sided presser	D
For piping 3mm	E
For piping 4mm	F
For piping 5mm	G
For piping 6mm	H
Adjustable type for piping 3mm	J
Adjustable type for piping 4mm	K
Adjustable type for piping 5mm	L
Adjustable type for piping 6mm	M

Presser foot	Code
Standard	A
For material with overlapped sections	B
For urethane	C
Right single-sided presser	D
Left single-sided presser	E
For piping 3mm	F
For piping 4mm	G
For piping 5mm	H
For piping 6mm	J
Pressing face is reduce	K

LU-2260  S  S  -7-0B

Hook	Code
1.6 fold-capacity hook	N
Double-capacity hook	W

Stitch length	Code
6mm	S

Needle gauge	Code
6mm	B
8mm	C
10mm (standard)	D
12mm	E
20mm	J

Walking foot/ Presser foot/feed dog	Code
Standard	S

DL function	Code
Provided with DL function/push button type	A
Provided with DL function/knee switch type	B
Not provided with DL function	Z

### ● PSC box/control panel for SC

SC-380-   -

PSC box			Code
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

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






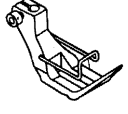
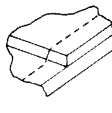







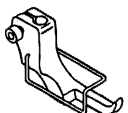
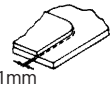

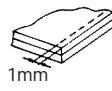
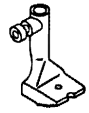
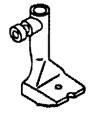
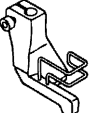
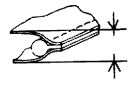
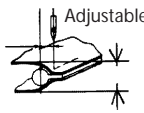


M

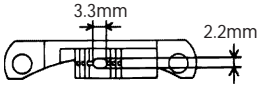
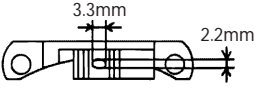
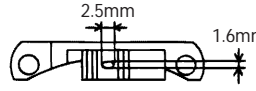
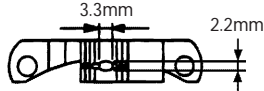
Motor			Code
For General Export	Single-phase	220 ~ 240V	60
	3-phase	220 ~ 240V	60
For JUS (LA)*	Single-phase	110 ~ 120V	61
	3-phase	220 ~ 240V	62
For CE	Single-phase	220 ~ 240V	63

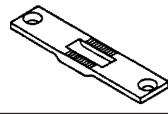
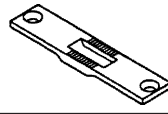
\* JUS: North America and Central and South America.

# INTERCHANGEABLE GAUGE PARTS



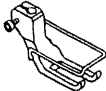


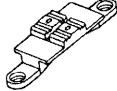


## LU-2210N-7, LU-2210W-7

Sewing conditions		Walking foot		Presser foot				
<b>Standard</b> 		A	Standard 107-11653	A	Standard 107-12552			
		K	Standard (pressing face is reduced) 107-58456					
		B	For material with overlapped section 107-12651					
		C	For urethane 107-12750					
<b>For material with overlapped section</b> Allows the smooth feed of multi-layered portions of the material 		B	For urethane 107-11752					
<b>For light-weight sponge</b> Used for resilient materials including sponge 			C	Right single-sided presser 107-11851				
<b>For heavy-weight sponge</b> Used for more resilient materials Thick 			D	Right single-sided presser 107-12859				
<b>Right single-sided presser</b> Used for sewing material edges 			D	Right single-sided presser 107-11950			E	Left single-sided presser 107-12958
<b>Left single-sided presser</b> Used for sewing material edges 		E ~ H	For piping 3 107-45354 4 107-45453 5 107-45552 6 107-45651		F ~ J	For piping		
<b>For piping</b> Used for the general piping process 			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
<b>For piping</b> The position of the needle can be adjusted according to the pipe to be sewn Adjustable			(special order) 107-12057		(special order) 107-13055			
<b>Wide type</b> To be used when a sewing product cannot be smoothly fed 								

Feed dog			
			
107-17106	107-17205	107-17304	107-39001
S	A	B	
Standard	Without a groove Used when the needle thread does not interlace consisting with the bobbin thread at the start of sewing.	For thin thread	Wide type (special order)

Throat plate	
	
107-01704	107-02009
Standard	Wide type (special order)

## LU-2260N-7, LU-2260W-7

Needle gauge	Typical* part No.	Needle clamp	Presser foot	Walking foot	Needle plate	Feed dog	Slide plate	
							Left	Right
								
4mm (special order)	107-84551	107-77555	107-81557	107-83058	107-84502	107-80005	107-86309	107-01803
6mm	107-84650	107-77654	107-81656	107-83157	107-84601	107-80104		
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	107-86408	107-86002
12mm	107-84957	107-77951	107-80401	107-83454	107-84908	107-80401		
14mm (special order)	107-85053	107-78058	107-82050	107-83553	107-85004	107-80500		
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	107-86507	107-86101
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		
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.



Push-button type

## ATTACHMENT

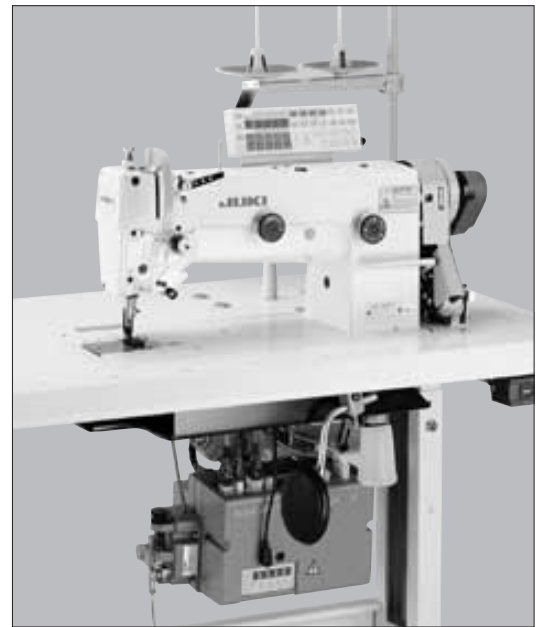
Part name	Part No.
H152 (suspended ruler)	MAH-152010A0

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 (adjustable to 10mm)	
Zigzag width adjustment method	By dial	
Needle bar stroke	35mm	
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	295mm	
Bed size	477mm x 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/

Pneumatic auto-lifter	Code
Not provided	
Knee switch type (AK112C)	<b>C</b>
Pedal switch type (AK112B)	<b>B</b>

- Motor for SC

### M

Motor			Code
For General Export	Single-phase 3-phase	220 ~ 240V	<b>60</b>
For JUS (LA) *	Single-phase	110 ~ 120V	<b>61</b>
	3-phase	220 ~ 240V	<b>62</b>
For CE	Single-phase	220 ~ 240V	<b>63</b>

- PSC box/control panel for SC

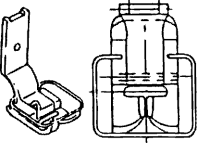
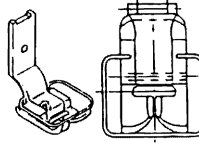
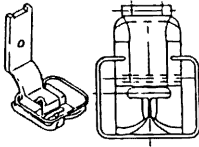
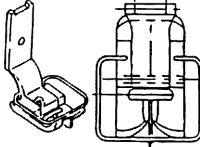
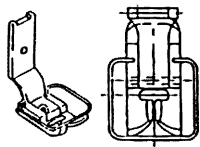
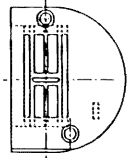
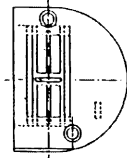
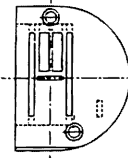
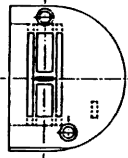
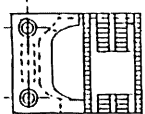
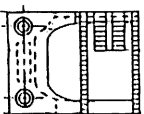
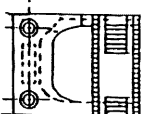
### SC-380-

PSC box			Code
For General Export	Single-phase	220 ~ 240V	<b>07</b>
	3-phase	200 ~ 220V	<b>11</b>
For JUS (LA) *	Single-phase	110 ~ 120V	<b>37</b>
	3-phase	220 ~ 240V	<b>38</b>
For CE	Single-phase	220 ~ 240V	<b>34</b>

Control panel		Code
Not provided		<b>00000</b>
Control panel display language: English. Instruction manual comes in three different languages.		<b>E500B</b>
Control panel display language: English. Instruction manual comes in five different languages.		<b>E500C</b>

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

## GAUGE

Type	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) 	100-85751 	100-98051 	100-85850 
Throat plate	100-93300 		100-75505 	100-93318 	100-75711 
Feed dog	100-83301 			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

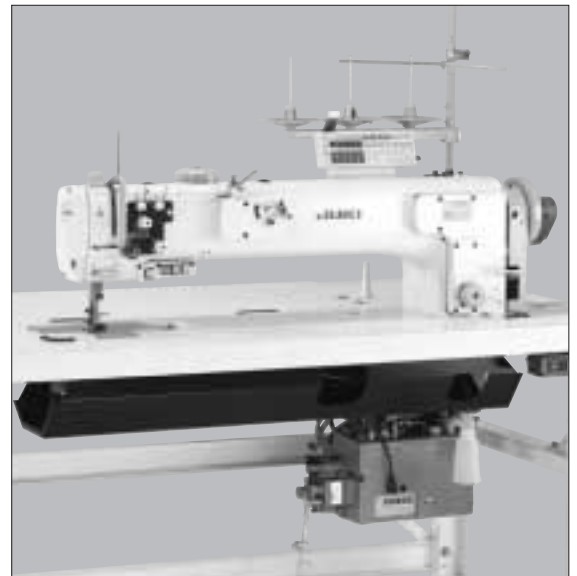
\* Gauges other than the standard one are optionally available.

**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
	1-needle	2-needle
Max. sewing speed	3,000rpm	
Max. stitch length	9mm (normal/reverse feed)	6mm (normal/reverse feed)
Needle bar stroke	36mm	
Needle gauge	10mm (standard)	
Lift of the presser foot	By hand: 9mm, Auto: 16mm	
Auto lifter	Provide as standard (pneumatic 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 × 35 (Nm140) Nm100 ~ Nm180	134 × 35 (Nm140) Nm100 ~ Nm160
Thread	#30 ~ #4, B46 ~ B138, Nm=60/3 ~ 20/3	#20 ~ #5, B69 ~ B138, Nm=40/3 ~ 20/3
Safety mechanism	Provided as standard	
Lubrication	Automatic	
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	
Distance from needle to machine arm	650mm	
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 <sup>2</sup> ), 0.3Nℓ/min.	
Power requirement	Single-phase 110 ~ 120V, 220 ~ 240V, 3-phase 200 ~ 220V, 220 ~ 240V	



## WHEN YOU PLACE ORDERS

### LU-2216NAASB-7-0B

Walking foot	Code	Presser foot	Code	Feed dog	Code
Standard*	A	Standard*	A	Standard*	S

\* Any gauge other than the standard is available on a part order. (See the table of replaceable gauges.)

### LU-2266NSDSB-7-0B

Needle gauge	Code	Walking foot Presser foot Feed dog	Code
10mm (standard)*	D	Standard*	S

#### ● PSC box/control panel for SC

SC-380-□□-□□□□□□

PSC box			Code
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

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

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

#### ● Motor for SC

M□□

Motor			Code
For General Export	Single-phase	220 ~ 240V	60
	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

## GAUGE PARTS

#### ● Some gauge used in the LU-2210N/-2260N Series

The gauge (hook, bobbin case, 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.

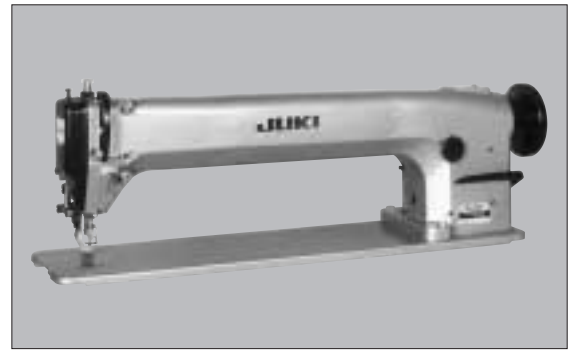
## ATTACHMENT

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 heavy-weight 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 long-sized 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.
- Since the machine is equipped with a double-capacity hook, the frequency of bobbin replacement is reduced, thereby leading to higher efficiency.



DU-580

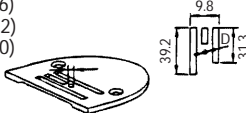
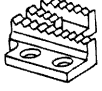
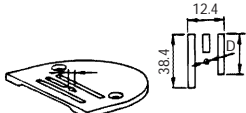

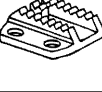
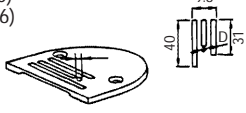
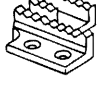
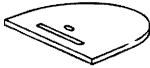
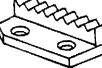
## SPECIFICATIONS

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 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	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)
Distance from needle to machine arm	500mm
Bed size	715mm x 178mm
Weight of the machine head	49kg

## WHEN YOU PLACE ORDERS

# DU-580

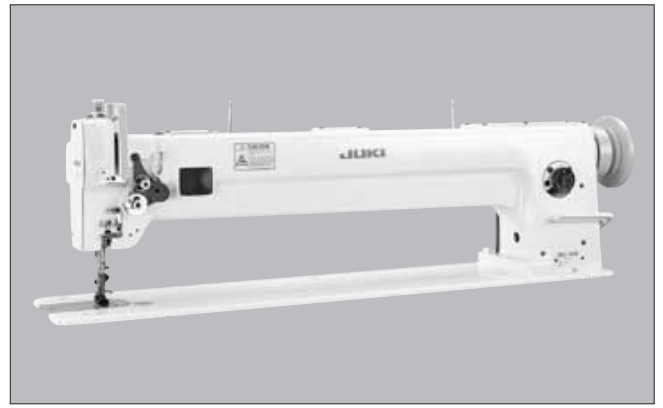
## EXCHANGEABLE GAUGE PARTS

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	
Single-lined feed dog for sewing gloves and shoes	B1105-141-000 (D=2.0) B1105-141-H00 (D=2.6) 	B1613-141-H00A 	Stitch length: max. 9mm
	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

1-needle, Unison-feed, Long 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 x 178mm
Weight of the machine head	59kg

## WHEN YOU PLACE ORDERS

DNU-261H-□□ / □

Automatic reverse feed function	Code
Not provided	00
Provided	0B

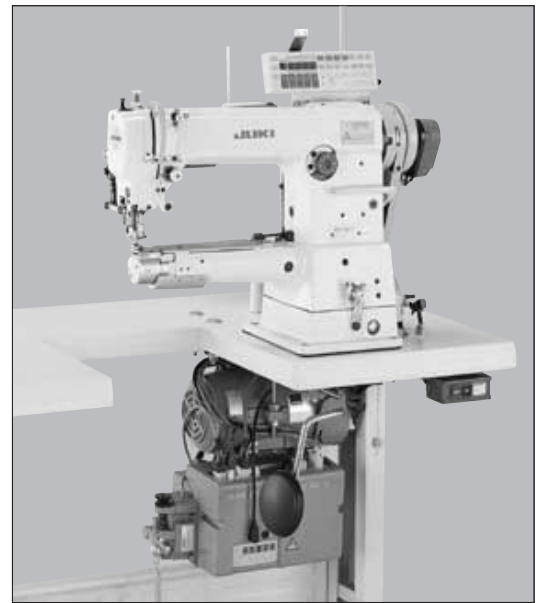
Pneumatic auto-lifter (optional)	Code
Knee switch type (AK70A)	A
Pedal switch type (AK70B)	B
Not provided	

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

### SPECIFICATIONS

Model name	DSU-145	DSU-145-7
Max. sewing speed	2,000rpm	
Max. stitch length	6mm (normal/reverse feed)	
Needle bar stroke	37mm	
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 ~ 5mm	
Hook	Horizontal-axis full-rotary double-capacity hook	
Needle (at the time of delivery)	DP x 17 (#21) #14 ~ #21, For JE: 135 x 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)	C
Pedal switch type (AK114B)	B
Not provided	

- Motor for SC

M

Motor			Code
For General Export	Single-phase	220 ~ 240V	60
	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

- PSC box/control panel for SC

SC-380-



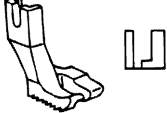





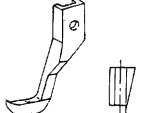

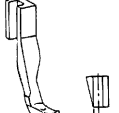
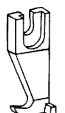
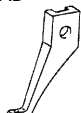

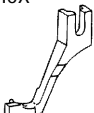
PSC box			Code
For General Export	Single-phase	220 ~ 240V	07
	3-phase	200 ~ 220V	11
For JUS (LA)*	Single-phase	110 ~ 120V	37
	3-phase	220 ~ 240V	38
For CE	Single-phase	220 ~ 240V	34

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

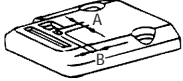
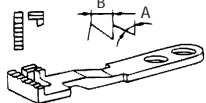

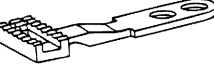

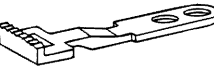
\* JUS: North America and Central and South America.

## EXCHANGEABLE GAUGE PARTS

### ● For DSU-145 (-7)

Description	Walking foot	Presser foot	Notes
Standard	B1526-141-H0A 	B1525-141-HA0 	
For piping	B1527-141-H0 	B1527-141-HA0 	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 		
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 	B1526-141-HAB 	Stitch length: max. 6mm Exclusive parts Feed dog: 114-05701 Throat plate: 114-05800
For attaching zippers	B1527-141-H0X 	B1526-141-H0X 	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) 	
Three-lined feed dog	D1105-145-E0B 	D1613-145-E0B 	
Single-lined feed dog for sewing gloves	D1105-145-E0T 	D1613-145-E0T 	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)

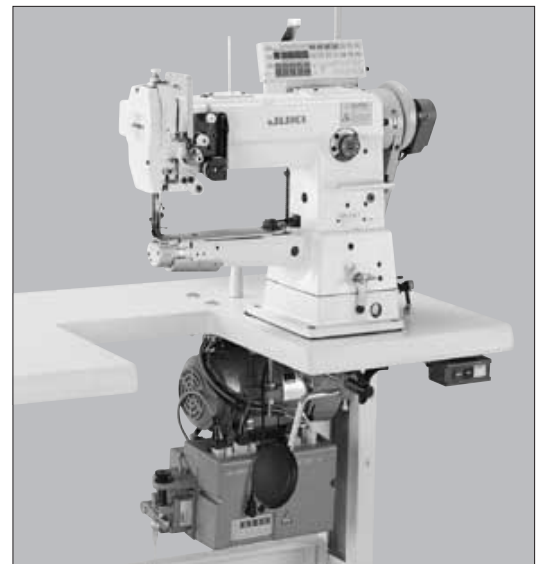
**DSC-245** (with standard hook, an automatically lubricated for hook)

**DSC-245-7** (with standard hook, an automatically lubricated for hook and an automatic thread trimmer)

**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 hook-lubricating system that automatically lubricates the hook. With this feature, a maintenance-free hook has finally materialized.



DSC-245-7-OB/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.

**SPECIFICATIONS**

Model name	DSC-244	DSC-245	DSC-246
Max. sewing speed	2,200rpm		
Max. stitch length	6mm (normal/reverse feed)		
Needle bar stroke	36mm		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	Horizontal-axis full-rotary hook		Horizontal-axis full-rotary double-capacity hook
Needle (at the time of delivery)	DP x 17 (#18) #14 ~ #21 For JE: 135 x 17 (Nm110)		DP x 17 (#21) #14 ~ #23 For JE: 135 x 17 (Nm130)
Thread	#50 ~ #20, B33 ~ B69, 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
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	36mm		38mm
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 x 17 (#18) #14 ~ #21 For JE: 135 x 17 (Nm110)		DP x 17 (#21) #14 ~ #23 For JE: 135 x 17 (Nm130)
Thread	#50 ~ #20, B33 ~ B69, 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
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		

## WHEN YOU PLACE ORDERS

### ● Without an automatic thread trimmer

DSC-244/245/246  -

Feed system	Code
Elliptical feed	/
Horizontal feed	V

Automatic reverse feed function	Code
Not provided	/
Provided	0B

### ● With an automatic thread trimmer

DSC-244/245/246  -7-0B/

Feed system	Code
Elliptical feed	/
Horizontal feed	V

Pneumatic auto-lifter (optional)	Code
Knee switch type (AK110C)	C
Pedal switch type (AK110B)	B
Not provided	/

### ● PSC box/control panel for SC

SC-380-   -

PSC box			Code
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

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

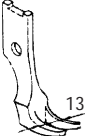



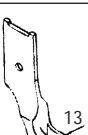

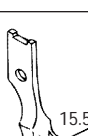

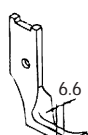



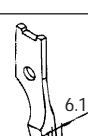

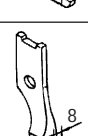
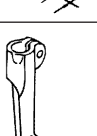

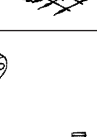


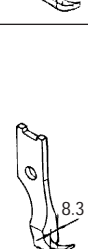
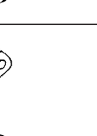

M

Motor			Code
For General Export	Single-phase	220 ~ 240V	60
	3-phase		
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.

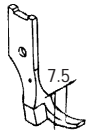
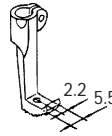
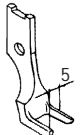
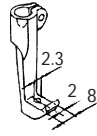
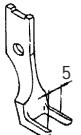
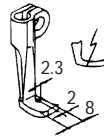


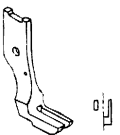
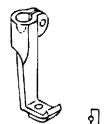
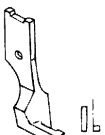

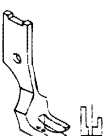

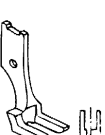

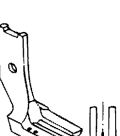

# EXCHANGEABLE GAUGE PARTS

● For DSC-244 (-7), 245 (-7), 246 (-7)


Description	Presser foot	Walking foot	Notes
Standard	B1525-241-HA0 	B1470-241-HA0 	For DNU Stitch length: max. 10mm
	B1525-053-0A0 	B1470-053-000 (D=2.8) B1470-053-C00 (D=2.3) 	For LU & LS Stitch length: max. 10mm
	B1525-562-BA0 	B1470-562-B00 	Stitch length: max. 10mm With teeth
	B1525-563-E00 	B1470-563-E00 	Stitch length: max. 10mm
Left-hand type	B1524-245-0A0 	B1470-245-000 	DSC-245(-7), 246(-7) standard Stitch length: max. 6mm
	B1529-245-0AD (special order) 	B1476-245-00D (special order) 	Stitch length: max. 8mm With teeth
	B1529-245-0AC (special order) 	B1476-245-00C (special order) 	Stitch length: max. 6mm With teeth
	B1529-245-0AB (special order) 	B1476-245-00B (special order) 	Stitch length: max. 8mm With teeth
	B1529-245-0AF (special order) 	B1476-245-00F (special order) 	Stitch length: max. 6mm With teeth
For binding	MAQ-092080A0 (with teeth) 	MAQ-09207000 	Stitch length: max. 10mm
	MAQ-093080A0 (with teeth) 	MAQ-09307000 	DSC-246V(-7) standard Stitch length: max. 10mm
		MAN-10452000 	DSC-245V(-7) standard Stitch length: max. 10mm



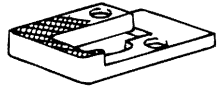

● For DSC-244(-7), 245(-7), 246(-7)

Description	Presser foot	Walking foot	Notes
Right-hand type	B1529-245-00A 	B1476-245-00A 	Stitch length: max. 8mm With teeth
Wide type	103-25157 	103-25306 	Stitch length: max. 10mm Exclusive parts (for LU-1114) Throat plate: 103-25009 Feed dog: 103-25207
For leather (without teeth)	103-26304 	103-26205 	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) 	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 	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 	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")

● 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	
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	

● 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)	
Narrow type (width: 14mm)	DSC-245V-7: MAQ-09401000 DSC-246V-7: 211-41106	DSC-245V-7: 213-05107 DSC-246V-7: 211-43409 (without groove)	Exclusive parts Walking foot: MAQ-09307000 Presser foot: MAQ-093080A0
		DSC-245V: MAQ-09209000 DSC-245V-7: MAQ-09409000 DSC-246V: 211-42104 (with groove)	
		DSC-245V-7: 213-05008 DSC-246V-7: 211-43102 (without groove)	

**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 reduced, 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 kinds of heavy-weight materials.

**LS-341N-7** (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	Unison-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 (at the time of delivery)	DP x 5 (#14) #14 ~ #16 For JE: 135 x 5 (Nm90)	DP x 17 (#23) #14 ~ #24 For JE: 135 x 17 (Nm160)	DP x 17 (#23) #16 ~ #24 For JE: 135 x 17 (Nm160)
			D Type: 135 x 17 (Nm110) Nm100 ~ Nm130 or DP x 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 VG7)		
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		

## WHEN YOU PLACE ORDERS

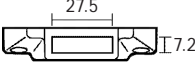

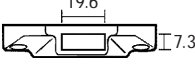
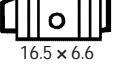
### ● Without an automatic thread trimmer

**LS-321**  
**LS-341N**

### ● With an automatic thread trimmer

**LS-341N**  **-7-0B**

Gauge	Code	Pneumatic auto-lifter (optional)	Code
Standard		Not provided	
Gauge for small articles	<b>D</b>	Knee switch type (AK117A)	<b>A</b>
		Pedal switch type (AK117B)	<b>B</b>

	Throat plate	Feed dog
<b>Standard type</b>	231-00803 	231-01702 
<b>For small articles</b>	231-00902 	231-01801 

\* Standard presser foot is used for both types.

### ● PSC box/control panel for SC

**SC-380-**   -

PSC box				Code	Control panel		Code
For General Export	Single-phase	220 ~ 240V		<b>07</b>	Not provided		<b>00000</b>
	3-phase	200 ~ 220V		<b>11</b>	Control panel display language: English. Instruction manual comes in three different languages.		<b>E500B</b>
For JUS (LA)*	Single-phase	110 ~ 120V		<b>37</b>	Control panel display language: English. Instruction manual comes in five different languages.		<b>E500C</b>
	3-phase	220 ~ 240V		<b>38</b>			
For CE	Single-phase	220 ~ 240V		<b>34</b>			

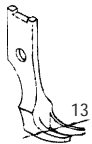
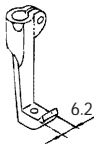
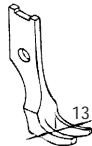
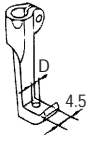
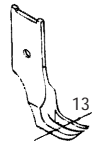


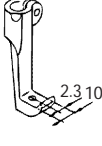
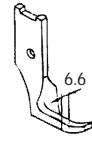
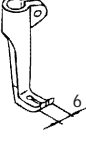

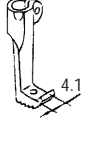
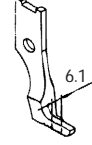
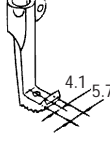
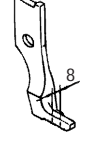
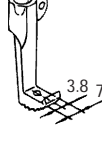
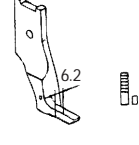
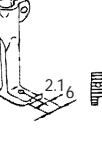
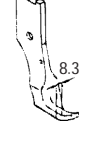
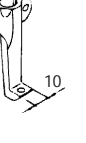
### ● Motor for SC


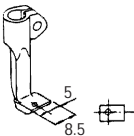
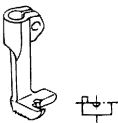
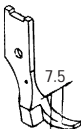
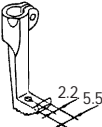
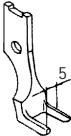
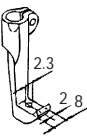

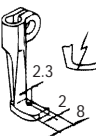


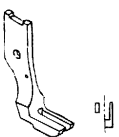
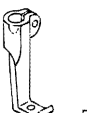
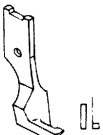
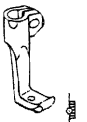
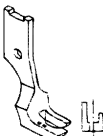

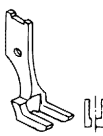



**M**

Motor			Code
For General Export	Single-phase	220 ~ 240V	<b>60</b>
	3-phase		
For JUS (LA)*	Single-phase	110 ~ 120V	<b>61</b>
	3-phase	220 ~ 240V	<b>62</b>
For CE	Single-phase	220 ~ 240V	<b>63</b>

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

# EXCHANGEABLE GAUGE PARTS

Description	Presser foot	Walking foot	Notes
Standard	B1525-241-HA0 	B1470-241-HA0 	For DNU Stitch length: max. 10mm
	B1525-053-0A0 	B1470-053-000 (D=2.8) B1470-053-C00 (D=2.3) 	For LU & LS Stitch length: max. 10mm
	B1525-562-BA0 	B1470-562-B00 	Stitch length: max. 10mm With teeth
	B1525-563-E00 	B1470-563-E00 	Stitch length: max. 10mm
Left-hand type	B1524-245-0A0 	B1470-245-000 	DSC-245(-7), 246(-7) standard Stitch length: max. 6mm
	B1529-245-0AD (special order) 	B1476-245-00D (special order) 	Stitch length: max. 8mm With teeth
	B1529-245-0AC (special order) 	B1476-245-00C (special order) 	Stitch length: max. 6mm With teeth
	B1529-245-0AB (special order) 	B1476-245-00B (special order) 	Stitch length: max. 8mm With teeth
	B1529-245-0AF (special order) 	B1476-245-00F (special order) 	Stitch length: max. 6mm With teeth
For binding	MAQ-092080A0 (with teeth) 	MAQ-09207000 	Stitch length: max. 10mm

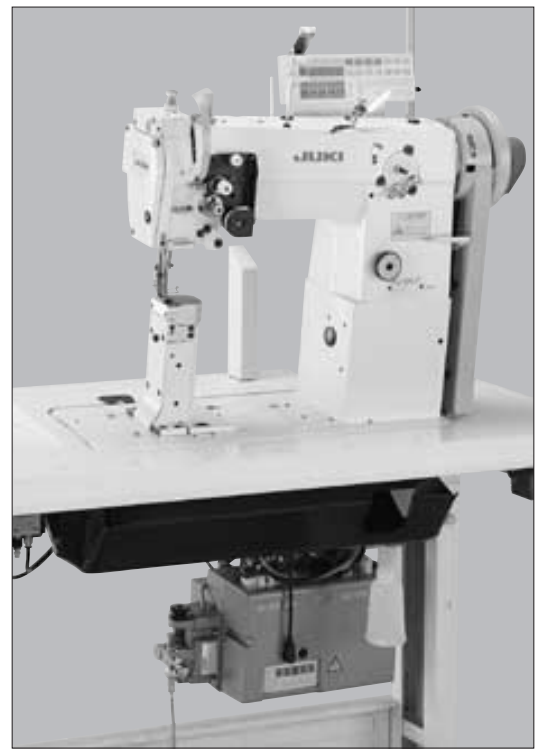
Description	Presser foot	Walking foot	Notes
For binding	MAQ-093080A0 (with teeth) 	MAQ-09307000 	DSC-246V(-7) standard Stitch length: max. 10mm
		MAN-10452000 	DSC-245V(-7) standard Stitch length: max. 10mm
Right-hand type	B1529-245-00A 	B1476-245-00A 	Stitch length: max. 8mm With teeth
Wide type	103-25157 	103-25306 	Stitch length: max. 10mm Exclusive parts (for LU-1114) Throat plate: 103-25009 Feed dog: 103-25207
For leather (without teeth)	103-26304 	103-26205 	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) 	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 	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 	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	33.4mm	
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 × 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 <sup>2</sup> ), 0.3Nℓ/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	50kg
Automatic reverse feed function	Provided as standard	
Power requirement	Single-phase 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V	

## PLC-1610SSSA

Specifications	Code	Throat plate	Code	Presser foot	Code	Feed dog	Code	Pneumatic auto-lifter	Code
Standard	S	Standard	S	Standard	S	Round hole ( 2.4)	A	Knee switch type (AK116A)	A
								Pedal switch type (AK116B)	B

\* If pedal-switch type B is specified use a servomotor or electronic-stop motor (DC 24 V is required.)

## PLC-1610SSA-7-0B

Throat plate	Code	Presser foot	Code	Feed dog	Code	Pneumatic auto-lifter	Code
Standard	S	Standard	S	Round hole ( 2.4)	A	Knee switch type (AK116A)	A
						Pedal switch type (AK116B)	B

● PSC box/control panel for SC

## SC-380- [ ] [ ] - [ ] [ ] [ ] [ ] [ ]

PSC box				Code	Control panel		Code
For General Export	Single-phase	220 ~ 240V		07	Not provided		00000
	3-phase	200 ~ 220V		11	Control panel display language: English. Instruction manual comes in three different languages.		E500B
For JUS (LA)*	Single-phase	110 ~ 120V		37	Control panel display language: English. Instruction manual comes in five different languages.		E500C
	3-phase	220 ~ 240V		38			
For CE	Single-phase	220 ~ 240V		34			

● Motor for SC

## M [ ] [ ]

Motor				Code
For General Export	Single-phase	220 ~ 240V		60
	3-phase			
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)

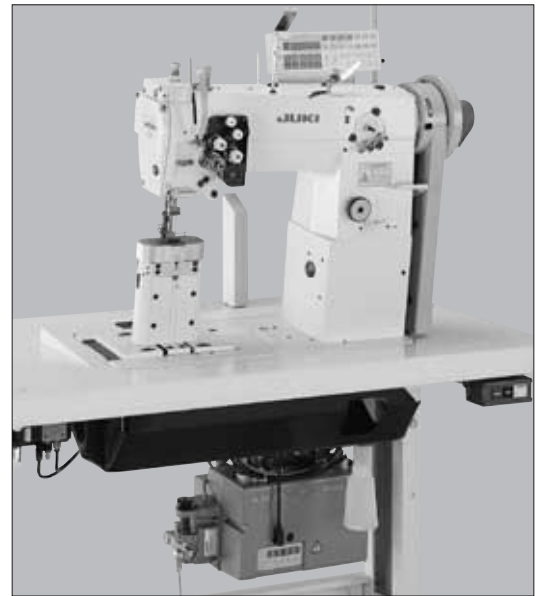
- With its large-sized thread take-up lever and wide-diameter pulley, the machine can handle threads as thick as #1 (B207, Nm=8/3) and the stitch length can be set to 10mm at the maximum.

### PLC-1665 (with organized split needle bars)

- With its organized split needle bars, the machine produces well-balanced beautiful topstitch-seams at the corners of materials.

### PLC-1660-7 (with an automatic thread trimmer)

- The machine 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 3-dimensional sewing product is sewn, the button can be shifted upward to prevent interruption.



PLC-1660-7-0B/XC-E500



PLC-1660L



PLC-1665



## SPECIFICATIONS

Model name	PLC-1660	PLC-1660L
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/cm <sup>2</sup> ), 0.3Nℓ/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
		With organized split needle bars
Max. sewing speed	1,800rpm	2,000rpm
Max. stitch length	6mm (normal/reverse feed)	
Needle bar stroke	33.4mm	
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 × 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 <sup>2</sup> ), 0.3Nℓ/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

Specification	Code
Standard	S
Thick-thread long-pitch	L

\* For thick-thread long-pitch type L, the needle gauge code is "D" and the presser foot code is "S" only.

Presser foot	Code
Standard	S
Provide with a center guide (needle gauge: 8mm)	A

Feed dog	Code
Round hole( 2.4)	A
Slot (2.4mm × 3.8mm) for S type (standard)	B
Slot (3.5mm × 4.5mm) for L type (standard)	C

**PLC-1660**

Needle gauge	Code
8mm	C
10mm	D

Throat plate	Code
Standard	S
For under-tape attachment (needle gauge: 8mm, tape width: 12mm)	C
For under-tape attachment (needle gauge: 10mm, tape width: 14mm)	D

\* If the throat plate for under-tape attachment is selected, specify needle gauge C for the C-type throat plate and needle gauge D for the D-type.

Pneumatic auto-lifter	Code
Knee switch type (AK116A)	A
Pedal switch type (AK116B)	B

\* If pedal-switch type B is specified use a servomotor or electronic-stop motor (DC 24 V is required).

Presser foot	Code
Standard	S

**PLC-1665**

Needle gauge	Code
8mm	C
10mm	D

Throat plate	Code
Standard	S
For under-tape attachment (needle gauge: 8mm, tape width: 12mm)	C
For under-tape attachment (needle gauge: 10mm, tape width: 14mm)	D

\* If the throat plate for under-tape attachment is selected, specify needle gauge C for the C-type throat plate and needle gauge D for the D-type.

Feed dog	Code
Round hole( 2.4)	A
Slot (2.4mm × 3.8mm) Standard	B
Slot (3.5mm × 4.5mm)	C

Pneumatic auto-lifter	Code
Knee switch type (AK116A)	A
Pedal switch type (AK116B)	B

\* If pedal-switch type B is specified use a servomotor or electronic-stop motor (DC 24 V is required).

Feed dog	Code
Round hole( 2.4)	A

**PLC-1660**

**A-7-0B**

Needle gauge	Code
6mm	B
8mm	C
10mm	D

Throat plate	Code
Standard	S
For under-tape attachment (needle gauge: 8mm, tape width: 12mm)	C
For under-tape attachment (needle gauge: 10mm, tape width: 14mm)	D

\* If the throat plate for under-tape attachment is selected, specify needle gauge C for the C-type throat plate and needle gauge D for the D-type.

Pneumatic auto-lifter	Code
Knee switch type (AK116A)	A
Pedal switch type (AK116B)	B

Presser foot	Code
Standard	S
Provide with a center guide (needle gauge: 8mm)	A

## ● PSC box/control panel for SC

**SC-380-** [ ] [ ] - [ ] [ ] [ ] [ ] [ ]

PSC box		Code	
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

\* JUS: North America and Central and South 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

**M** [ ] [ ]

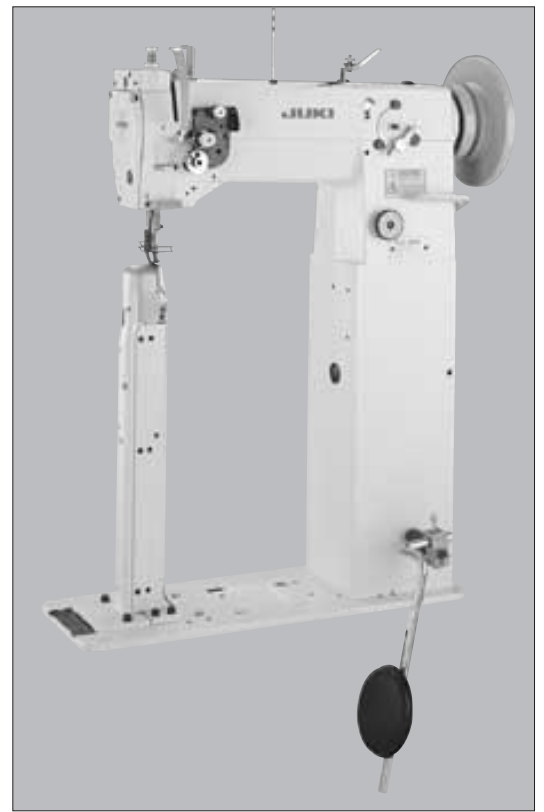
Motor		Code	
For General Export	Single-phase	220 ~ 240V	60
	3-phase	220 ~ 240V	60
* For JUS (LA)	Single-phase	110 ~ 120V	61
	3-phase	220 ~ 240V	62
For CE	Single-phase	220 ~ 240V	63

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 compact-finished 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 machines. \* PLC-1690S: 15mm PLC-1690A, PLC-1691: 10.5mm
- 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**

Model name	PLC-1690S	PLC-1690A	PLC-1691
		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 hook
Needle (at the time of delivery)	134 x 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 x 178mm		
Weight of the machine head	57kg		

**WHEN YOU PLACE ORDERS**

PLC-1690

PLC-1691

Throat plate	Code
Flat-surface type (Standard)	S
Curved-surface type	A

Pneumatic auto-lifter	Code
Not provided	/
Knee switch type (AK116A)	A
Pedal switch type (AK116B)	B

\* 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.



PLH-981

Post-bed, Needle-feed Lockstitch Machine

**PLN-985** (1-needle)

**PLN-986** (2-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.



PLN-986



PLH-981



PLN-986

**SPECIFICATIONS**

Model name	PLH-981	PLH-982	PLN-985	PLN-986
	1-needle	2-needle	1-needle	2-needle
Feed system	Bottom-feed		Needle-feed	
Max. sewing speed	2,500rpm			
Max. stitch length	4mm (normal/reverse feed)			
Needle bar stroke	36mm		33.4mm	
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	
Thread take-up	Slide type			
Hook	Vertical-axis hook			
Needle (at the time of delivery)	DP x 5 (#18) #16 ~ #21		DP x 5 (#16) #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	
Bed size	517mm x 178mm			
Weight of the machine head	36kg		40kg	

## WHEN YOU PLACE ORDERS

- 1-needle, Bottom-feed

### PLH-981

- 1-needle, Needle-feed

### PLN-985

- 2-needle, Bottom-feed

### PLH-982B


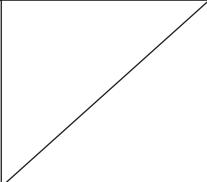





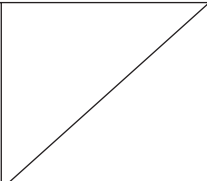




Needle gauge	Code
1.2mm	12
1.6mm	16
2.0mm	20
2.4mm (standard)	24

- 2-needle, Needle-feed

### PLN-986B

Needle gauge	Code
1.6mm	16
2.4mm (standard)	24

## GAUGE TABLE (2-NEEDLE TYPE)

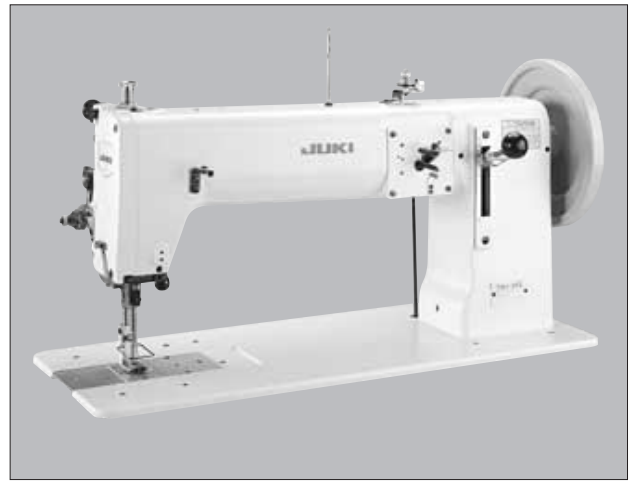
Model name	Needle gauge	Gauge set	Needle clamp	Needle guide	Throat plate	Feed dog
PLH-982						
	1.2mm	210-16357	210-17405	210-18908	210-16308	210-21100
	1.6mm	210-16159			210-16100	
	2.0mm	210-16258	210-17504	210-18809	210-16209	210-21209
2.4mm (standard)	210-16050	210-16019			210-21308	
PLN-986						
	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

**TU-273** (top & bottom-feed)

**TNU-243** (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.
- 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 x 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 x 253mm	
Weight of the machine head	65kg	

**WHEN YOU PLACE ORDERS**



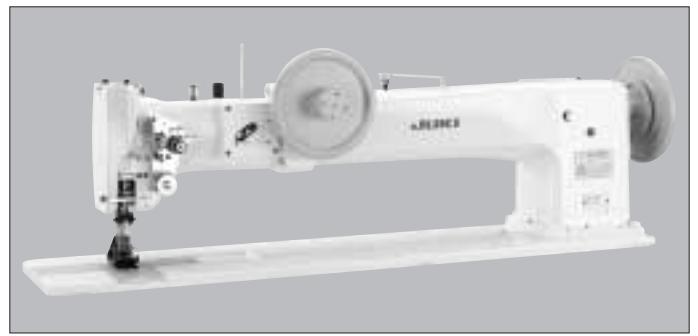
Auto-lifter	Code
Not provided	
Knee switch type (AK72A)	<b>A</b>
Pedal switch type (AK72B)	<b>B</b>

**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.



LG-158



**SPECIFICATIONS**



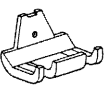



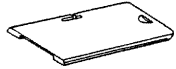
Model name	LG-158	LG-158-1
	2-needle	1-needle
Max. sewing speed	1,500rpm	
Max. stitch length	10mm (normal/reverse feed)	
Needle bar stroke	46.9mm	
Needle gauge	Standard 19.1mm (3/4")	
Lift of the presser foot	By pedal: 21.5mm	
Thread take-up	Side type	
Alternating vertical movement	6 ~ 19mm	
Hook	Vertical-axis 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	
Lubrication	By an oiler	
Lubricating oil	JUKI New Oil No.1 (equivalent to ISO VG7)	
Distance from needle to machine arm	750mm	
Bed size	1,088mm x 230mm	
Weight of the machine head	108kg	

**WHEN YOU PLACE ORDERS**

**LG-158**  **LG-158-1**

Needle gauge (mm)	Code
6.4 (1/4")	F
7.9 (5/16")	H
9.5 (3/8")	K
12.7 (1/2")	L
15.9 (5/8")	M
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

**EXCHANGEABLE GAUGE PARTS**

Needle gauge (mm)	Needle clamp asm.	Presser foot	Walking foot	Throat plate	Feed dog	Slide plate Left	Slide plate Right
							
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



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

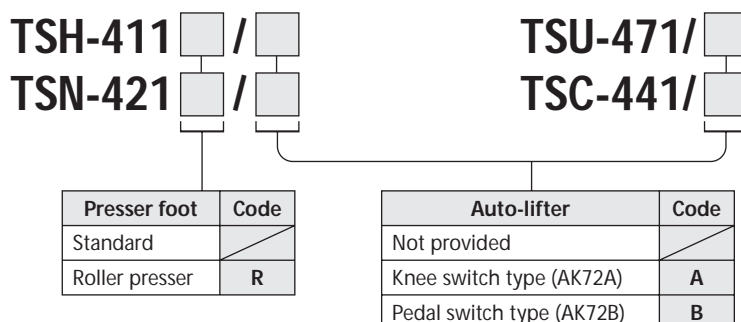
## FEATURES

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	800rpm			
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	56kg			

## 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%.
- **Applications**  
Carrying bags, transportation equipment, sporting goods.



TSC-461

## 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

TSC-461/



Auto-lifter	Code
Not provided	
Pedal switch type (AK78) *	<b>B</b>

**\* 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

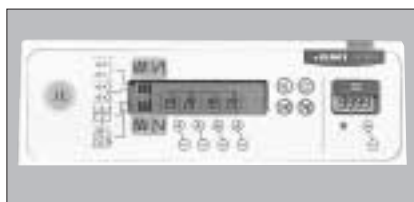
## CONTROL PANEL

- 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.

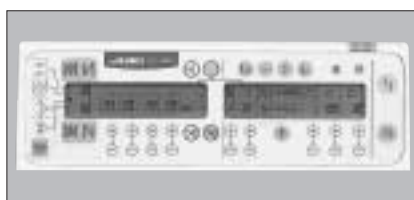
1-needle, lockstitch machine	LH-series	LZ-series
CP-60	CP-60B	CP-60B
CP-160	CP-160B	CP-160B
CP-360	CP-360B	



CP-60, CP-60B



CP-160, CP-160B



CP-360, CP-360B

## CONTROL PANEL SPECIFICATIONS

No.	Function	Pictograph	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				
14	Double back tack switch				
15	Key lock				
16	Constant-dimension stitching pattern				
17	Programmable seam length				
18	Production counter				
19	Programmed stitching pattern				
20	Combined stitching pattern switch				
21	Re-sewing switch				
22	Teaching switch				
23	Presser foot lifting time setting switch				

● 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).

# PSC BOX/CONTROL PANEL/MOTOR FOR SC

● 1-needle, lockstitch machine

SC800-□□□ D - □□□ A

Control box	Code
Standard	S
Optional unit A (for the ED-2 and the AE-4)	A

Pulley belt	Code
Lockstitch for general fabric Pulley: 75, Belt: 38 inches	D

Control panel	Code
CP-60	060
CP-160	160
CP-360	360

● LH-3100 series

SC800-□□□ H - □□□ B

Control box	Code
Standard	S

Pulley belt	Code
For LH Pulley: 75, Belt: 39 inches	H

Control panel	Code
CP-60	060
CP-160	160
CP-360	360

● LZ-2280N series

SC800-□□□ SZ - □□□ B

Control box	Code
Standard	S

Pulley belt	Code
For zigzag stitching machine Pulley: 75, Belt: 40 inches	Z

Control panel	Code
CP-60	060
CP-160	160

● DLU-5494N-7

SC801-□□□ AD-560

Control box	Code
Optional unit A	A

Pulley belt	Code
Lockstitch for general fabric Pulley: 75, Belt: 38 inches	D

Control panel	Code
CP-560	560

● LH-3162-7, LH-3182-7

SC804-□□□ SH-660B

Control box	Code
Standard	S

Pulley belt	Code
For LH Pulley: 75, Belt: 39 inches	H

Control panel	Code
CP-660	660

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

## AC SERVOMOTOR/CONTROLLER SC-380

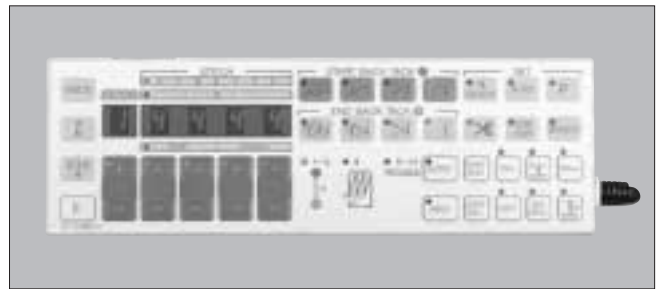
- The SC-380 is provided with many different standard functions, including speed-control, soft-start, automatic reverse stitching with the specified number of stitches, constant-dimension stitching, and overlapped (multi-layered) stitching. These functions ensure sewing performance optimally suited to 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

SC-380-□□-□□□□□□

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

- MO-3000 series

SC-380-□□-00000

Applicable models		Code
MF-7000	Pulley: 85, Belt: 33 inches	F1
MFC-7000	Top mount type Pulley: 85, Belt: 33 inches	F2
	Semi-sunken type Pulley: 85, Belt: 33 inches	F3

- MF-7000, MFC-7000

SC-380-□□-00000-□□

- Motor for SC

M□□

PSC box			Code
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

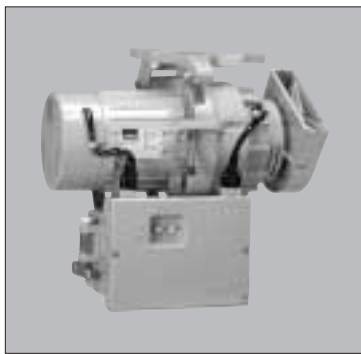
Control panel	Code
Not provided	00000

Motor			Code
For General Export	Single-phase	220 ~ 240V	60
	3-phase	220 ~ 240V	62
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.

## ELECTRONIC-STOP MOTOR/ CONTROL BOX EC-10B

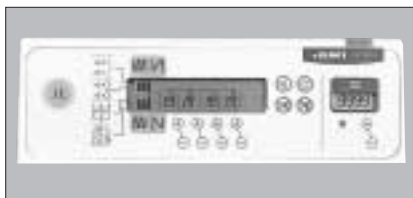
- The EC-10B enables the sewing machine to perform thread trimming, stop with its needle up/down, perform automatic reverse feed stitching at sewing start and sewing end, and perform one-touch reverse feed stitching with a switch. Needless to say, the number of reverse feed stitches can be specified.
- 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 multi-layer 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-10B	EC10B/CP-160 (optional)
1	Automatic thread trimmer		
2	Automatic back tack function		
3	Wiper		
4	Soft-start		
5	Auto-lifter		*
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		
11	Automatic stitching at sewing end		
12	Back tack pattern switch	(0 ~ 15 stitches)	(0 ~ 19 stitches)
13	Max speed limitation variable resistor		
14	Thread trimming prohibition switch		
15	Needle up/down compensating switch		
16	Double back tack switch for start		
17	Double back tack switch for end		
18	Overlapped stitching pattern switch		
19	Constant-dimension stitching pattern		
20	Programmable seam length		
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)

EC10B-

Power supply			Code
For General Export	220V	PFL	F
For North America	110V	PFL	H
	220V	PFL	K
For CE	230V	PFL	N

Control panel		Code
Not provided		/
Provided	1-needle, lockstitch machine	AA
	LH-3100, LZ-2280N series	AB

- Motor for EC-10B
- 1-needle, lockstitch machine

M

Power supply	Code	
Single-phase	110V	B
	220V	D
	230V	G
	240V	E
3-phase	220V	K
	230V	Q
	240V	P
	380V	L
	400V	T
	415V	M

Frequency	Code
50Hz	5
60Hz	6

Pulley belt		
Motor pulley O.D. (mm)	Pulley belt length (Inch)	Code
65	40"	F
75		H
80		J
85	41"	K
90		L
95		M
100		N
105	42"	P
110		Q
115		R
120	43"	S
125		T

Motor mounting base	Code
Standard	/
For Europe	E
For CE	C

\* 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

M

Power supply	Code	
Single-phase	110V	B
	220V	D
	230V	G
	240V	E
3-phase	220V	K
	230V	Q
	240V	P
	380V	L
	400V	T
	415V	M

Frequency	Code
50Hz	5
60Hz	6

Motor pulley	
Motor pulley O.D. (mm)	Code
65	F
70	G
75	H
80	J
85	K
90	L
95	M
100	N
105	P
110	Q

Motor mounting base	Code
Standard	/
For Europe	E
For CE	C

Pulley belt	
Pulley belt length (Inch)	Code
41"	5
42"	6
43"	7
44"	8

## 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

SC350

Controller		Code	Sewing speed	Destination	Code
Single-phase	220 ~ 240V	E	3,300rpm	For the whole world	33
	220 ~ 240V *	V			
3-phase	220 ~ 240V	P	4,000rpm	For U.S.A and European nations and excluded	40
			4,500rpm	For Europe	45
			4,800rpm	For U.S.A	48

\* Note that the motor base for European market has to be used.

### Remark

Power supply		Sewing speed
Single-phase	220 ~ 240V	3,300rpm
		4,000rpm
		4,500rpm
		4,800rpm
3-phase	220 ~ 240V	3,300rpm
		4,000rpm
		4,800rpm
Single-phase	220 ~ 240V	3,300rpm
		4,500rpm

## 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

Applicable model	PSC box		
	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	
	SC-801	SC-804
DLU-5494N-7		
LH-3162-7		
LH-3182-7		

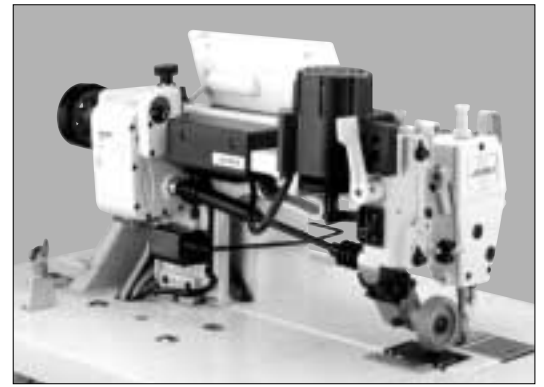
Applicable model	PSC box
	SC-380
DU-141H7	
DNU-241H-7	
DSC-244-7	
DSC-245-7	
DSC-246-7	
DSU-145-7	
LU-2210N-W-7	
LU-2260N-W-7	
LU-1510-7	
LU-1560-7	
LU-2216N-7	
LU-2266N-7	
LS-341N-7	
LZH-1290-7	
PLC-1610-7	
PLC-1660-7	
MO-3600	
MO-3700	
MO-3900	
MOR-3900	
MOC-3900	
MOF-3900	
MO·MOR/LB-1·LB-2	
MF-7000	
MFC-7000	
MH-1410	



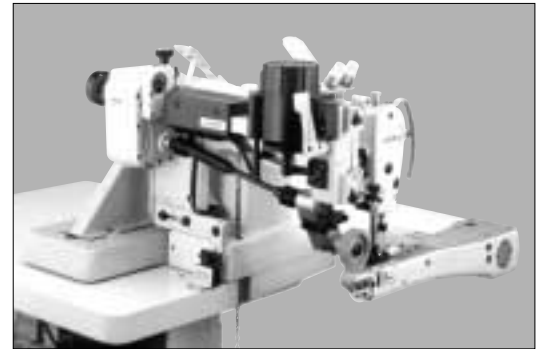
## Cloth Puller

# 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.



DDL-5550N-7/V052A



MS-1190/V054A

## SPECIFICATIONS

<b>Feed method</b>	<ul style="list-style-type: none"> <li>• Lockstitch machine..... Intermittent feed that is almost same as the continuous feed</li> <li>• Chainstitch machine..... Intermittent feed</li> </ul>			
<b>Feed mechanism</b>	One-way system interlocked with the feed mechanism of the sewing machine			
<b>Feed amount of roller</b>	0 ~ 6 mm *			
<b>Lift of the roller</b>		Proximity type	Large roller type	Top and bottom roller type
	Manual	10mm	14mm	12mm
	Auto	4mm	12mm	5.5mm
<b>Weight</b>	Approx. 13kg			
<b>Power supply</b>	Single-/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 double-stepped 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

### 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 newly-developed materials.
- Strong pulling force ensures an upgraded efficiency for the sewing of large materials and long materials.



V053

## FOR 1-NEEDLE, LOCKSTITCH MACHINES

Type	Model	Applicable model	Feature
Proximity type	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 extremely short 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-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, from light-weight materials for ladies' dresses, blouses and men's shirts, to medium-weight materials for blazers and coats.
	V051B	DLN	
Proximity type (provided with an auto-lifter)	V051C *	DDL **, DLD	
	V051D *	DLN	
Cloth puller with a large roller	V052A	DDL **, DLD DLN, DLU	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 fatigue and enables even low-skilled operators to successfully perform sewing operation.
Cloth puller with a large roller (provided with an auto-lifter)	V052B *		
Cloth puller with top and bottom rollers	V056A	DDL **, DLD DLN, DLU	The puller securely 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

V050		V052		V056A		Voltage	
Applicable model	Code	Applicable model	Code	Applicable model	Code		Code
DDL **, DLD models	A	DDL **, DLD models	A	DDL **, DLD, DLN, DLU models	A	100V ~ 240V	A
DLN model	B	DDL **, DLD, DLN, DLU/ provided with an auto-lifter	B			380V ~ 440V	S
DDL **, DLD/ provided with an auto-lifter	C						
DLN/provided with an auto-lifter	D						

\*\* Except DDL-9000

## FOR LH SERIES (2-NEEDLE, LOCKSTITCH MACHINES)

Type	Model	Applicable model	Feature
Cloth puller with a large roller	V053A	LH series	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 fatigue and enables even low-skilled operators to successfully perform sewing operation.
Cloth puller with a large roller (for provided with a back tucking solenoid type)	V053C *		
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 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.
Cloth puller with top and bottom rollers (for provided with a back tucking solenoid type)	V053D *		

\* For the puller provided with a back tucking solenoid a back tucking solenoid shifting device asm. (part No.: MAV-053020A0) and junction cable (part No.: MAV-053-030A0) is required.

## WHEN YOU PLACE ORDERS

V053		Voltage	
Applicable model	Code		Code
LH series (with a large roller)	A	100V ~ 240V	A
LH-3100 series (with top and bottom roller)	B	380V ~ 440V	S
LH series (with a large roller/for solenoid shifting type)	C		
LH-3100 series (with top and bottom roller/for solenoid shifting type)	D		

## FOR MS SERIES (2-NEEDLE, FEED-OFF-THE-ARM, DOUBLE-CHAINSTITCH MACHINES)

Type	Model	Applicable model	Feature
Cloth puller with a large roller	V054A	MS-1190 MS-2260	This type of cloth puller is suited for joining the sides of skirts and 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.

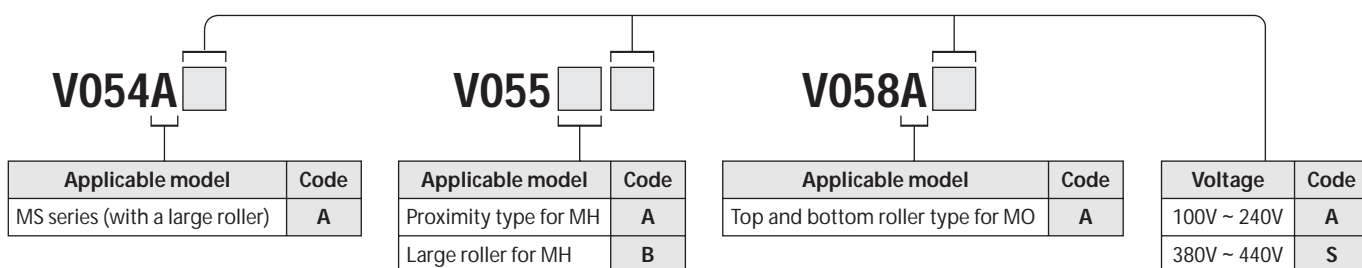
## FOR MH SERIES (DOUBLE-CHAINSTITCH MACHINES)

Type	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 shirts 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)

Type	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

Model Name	For 1-needle, lockstitch machine						
	Proximity type				Large roller type		Top and bottom roller type
	V051A	V051B	With a side plate and an AK device type		V052A	V052B	V056A
V051C			V051D				
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	


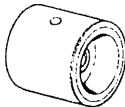
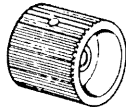
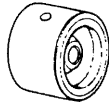
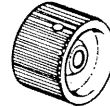


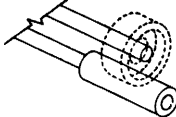
Model Name	For LH series				For MS series	For MH series		For MO series
	Large roller type	Top and bottom roller type	With a back tacing solenoid type		Large roller type	Proximity type	Large roller type	Top and bottom roller type
			Large roller type	Top and bottom roller type				
V053A	V053B	V053C	V053D	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
Top roller	V051A V051B V055A	Selection code	PA25 × 8	
		Diameter 25mm × width 8mm		
Top roller	V052 V053A V053B V054 V055B V056 V058	Selection code	PA55 × 50	SA55 × 50
		Diameter 55mm × width 50mm		
		Selection code	PA55 × 35	SA55 × 35
		Diameter 55mm × width 35mm		
		Selection code	PA55 × 15	SA55 × 15
		Diameter 55mm × width 15mm		
Bottom roller	V053B V056 V058	Selection code	PA25 × 80	
		Diameter 25mm × width 80mm		

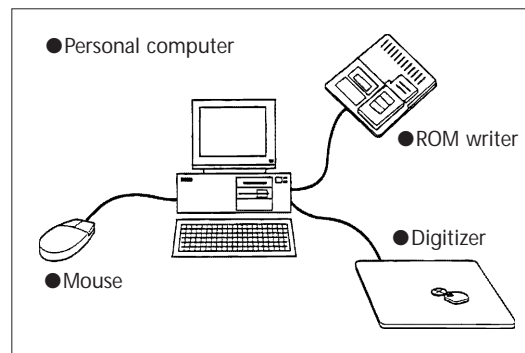
(Note) Standard roller for V052A, V052B, V053A and V055B is 55mm in diameter and 15mm in width.

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.

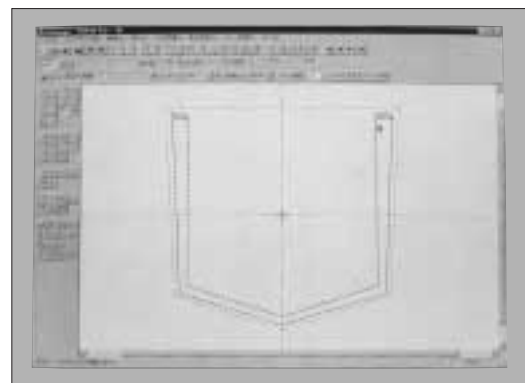
## Programming Software for Computer-controlled Sewing Machines

### PGM-20

- The PGM-20 programming software for computer-controlled sewing machines is especially designed for creating pattern data for JUKI's AMS-series 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 stitch 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.



System configuration



AVP-875

### 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, polygons, splines, dotted lines, and configuration points.	Edit: cut, paste, copy, enlargement/reduction/rotation/parallel move, and mirror inversion.
Entry of sewing attributes: point stitching, normal stitching, zigzag stitching, satin stitching, basting stitching, reverse sewing, jump and multi-sewing.	Edit of needle entries: addition/movement/deletion of needle entry points, joining of point sewing data, and change of point sewing speed.
	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	
Personal computer supporting PGM-20 software	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.
	Memory	16MB or more
	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	
Digitizer	To be used with RS-232C interface (any port from COM1 to COM4)	
	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	Data input/output data for the AMS-205/-206 or LK-1900 is required. For remote-control operation of the ROM writer, a PKW-1100 NAME OF MACHINE TYPE (AVAL DATA Co.) has to be connected to the RS-232C interface (any port from COM1 to COM4 ). If any ROM writer other than PKW-1100 is used, input/output HEX file.	

\* For a detailed explanation of communication-related matters, please contact us.

# inch mm CONVERSION TABLE

1" = 25.4mm

inch	0	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
1/64	015625	0.3969	25.7969	51.1969	76.5969	101.9969	127.3969	152.7969	178.1969	203.5969
1/32	03125	0.7938	26.1938	51.5938	76.9938	102.3938	127.7938	153.1938	178.5938	203.9938
3/64	046875	1.1906	26.5906	51.9906	77.3906	102.7906	128.1906	153.5906	178.9906	204.3906
<b>1/16</b>	0625	1.5875	26.9875	52.3875	77.7875	103.1875	128.5875	153.9875	179.3875	204.7875
5/64	078125	1.9844	27.3844	52.7844	78.1844	103.5844	128.9844	154.3844	179.7844	205.1844
3/32	09375	2.3812	27.7812	53.1812	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
<b>1/8</b>	125	3.175	28.575	53.975	79.375	104.775	130.175	155.575	180.975	206.375
9/64	140625	3.5719	28.9719	54.3719	79.7719	105.1719	130.5719	155.9719	181.3719	206.7719
5/32	15625	3.9688	29.3688	54.7688	80.1688	105.5688	130.9688	156.3688	181.7688	207.1688
11/64	171875	4.3656	29.7656	55.1656	80.5656	105.9656	131.3656	156.7656	182.1656	207.5656
<b>3/16</b>	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	21875	5.5562	30.9562	56.3562	81.7562	107.1562	132.5562	157.9562	183.3562	208.7562
15/64	234375	5.9531	31.3531	56.7531	82.1531	107.5531	132.9531	158.3531	183.7531	209.1531
<b>1/4</b>	25	6.35	31.75	57.15	82.55	107.95	133.35	158.75	184.15	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
19/64	296875	7.5406	32.9406	58.3406	83.7406	109.1406	134.5406	159.9406	185.3406	210.7406
<b>5/16</b>	3125	7.9375	33.3375	58.7375	84.1375	109.5375	134.9375	160.3375	185.7375	211.1375
21/64	328125	8.3344	33.7344	59.1344	84.5344	109.9344	135.3344	160.7344	186.1344	211.5344
11/32	34375	8.7312	34.1312	59.5312	84.9312	110.3312	135.7312	161.1312	186.5312	211.9312
23/64	359375	9.1281	34.5281	59.9281	85.3281	110.7281	136.1281	161.5281	186.9281	212.3281
<b>3/8</b>	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	40625	10.3188	35.7188	61.1188	86.5188	111.9188	137.3188	162.7188	188.1188	213.5188
27/64	421875	10.7156	36.1156	61.5156	86.9156	112.3156	137.7156	163.1156	188.5156	213.9156
<b>7/16</b>	4375	11.1125	36.5125	61.9125	87.3125	112.7125	138.1125	163.5125	188.9125	214.3125
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
31/64	484375	12.3031	37.7031	63.1031	88.5031	113.9031	139.3031	164.7031	190.1031	215.5031
<b>1/2</b>	5	12.7	38.1	63.5	88.9	114.3	139.7	165.1	190.5	215.9
33/64	515625	13.0969	38.4649	63.8969	89.2969	114.6969	140.0969	165.4969	190.8969	216.2969
17/32	53125	13.4938	38.8938	64.2938	89.6938	115.0938	140.4938	165.8938	191.2938	216.6938
35/64	546875	13.8906	39.2906	64.6906	90.0906	115.4906	140.8906	166.2906	191.6906	217.0906
<b>9/16</b>	5625	14.2875	39.6875	65.0875	90.4875	115.8875	141.2875	166.6875	192.0875	217.4875
37/64	578125	14.6844	40.0844	65.4844	90.8844	116.2844	141.6844	167.0844	192.4844	217.8844
19/32	59375	15.0812	40.4812	65.8812	91.2812	116.6812	142.0812	167.4812	192.8812	218.2812
39/64	609375	15.4781	40.8781	66.2781	91.6781	117.0781	142.4781	167.8781	193.2781	218.6781
<b>5/8</b>	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	65625	16.6688	42.0688	67.4688	92.8688	118.2688	143.6688	169.0688	194.4688	219.8688
43/64	671875	17.0656	42.4656	67.8656	93.2656	118.6656	144.0656	169.4656	194.8656	220.2656
<b>11/16</b>	6875	17.4625	42.8625	68.2625	93.6625	119.0625	144.4625	169.8625	195.2625	220.6625
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
47/64	734375	18.6531	44.0531	69.4531	94.8531	120.2531	145.6531	171.0531	196.4531	221.8531
<b>3/4</b>	75	19.05	44.45	69.85	95.25	120.65	146.05	171.45	196.85	222.25
49/64	765625	19.4469	44.8469	70.2469	95.6469	121.0469	146.4469	171.8469	197.2469	222.6469
25/32	78125	19.8438	45.2438	70.6438	96.0438	121.4438	146.8438	172.2438	197.6438	223.0438
51/64	796875	20.2406	45.6406	71.0406	96.4406	121.8406	147.2406	172.6406	198.0406	223.4406
<b>13/16</b>	8125	20.6375	46.0375	71.4375	96.8375	122.2375	147.6375	173.0375	198.4375	223.8375
53/64	728125	21.0344	46.4344	71.8344	97.2344	122.6344	148.0344	173.4344	198.8344	224.2344
27/32	84375	21.4312	46.8312	72.2312	97.6312	123.0312	148.4312	173.8312	199.2312	224.6312
55/64	859375	21.8281	47.2281	72.6281	98.0281	123.4281	148.8281	174.2281	199.6281	225.0281
<b>7/8</b>	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	90625	23.0188	48.4188	73.8188	99.2188	124.6188	150.0188	175.4188	200.8188	226.2188
59/64	921875	23.4156	48.8156	74.2156	99.6156	125.0156	150.4156	175.8156	201.2156	226.6156
<b>15/16</b>	9375	23.8125	49.2125	74.6125	100.0125	125.4125	150.8125	176.2125	201.6125	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.) =3 miles
- 1 mile (m. mi.) =8 furlongs
- 1 furlong (fur.) =40 rods
- 1 rod (rd.) =5-1/2 yards
- 1 yard (yd.) =3 feet
- 1 foot (ft.) =12 inches (in.)

## 2. NAUTICAL MEASURE

- 1 nautical mile =10 cables lengths
- 1 cable's length =100 fathoms
- 1 fathom (f., fm.) =6 feet
- (Ref.)
- 1 nautical mile =1.150779 miles
- 3 nautical miles =1 (marine ) league

## 3. SQUARE MEASURE

- 1 acre (a.) =160 square rods
- 1 square rod (sq. rd.) =30-1/4 square yards
- 1 square yard (sq. yd.) =9 square feet
- 1 square foot (sq. ft.) =144 square inches (sq. in.)

## 4. DRY MEASURE

- 1 bushel (bu.) =4 pecks
- 1 peck (pk.) =8 quarts
- 1 quart (qt.) =2 pints (pt.)
- (Caution) 1 dry quart (USA) =0.969 quarts (E)

## 5. LIQUID MEASURE

- 1 gallon (gal.) =4 quarts
- 1 quart (qt.) =2 pints
- 1 pint (pt.) =4 gills (gi.)
- (Caution) 1 quart (USA) =0.833 quarts (E)

## 6. AVOIRDUPOIS WEIGHT

- 1 ton (tn., t.) =20 hundred weights
- 1 long ton (E) =2,240 pound
- 1 short ton (USA) =2,000 pound
- 1 hundred weight (cwt.) =100 [(E) 112] pounds
- 1 stone (st.) (E) =14 pounds
- 1 pound (lb.) =16 ounces
- 1 ounce (oz.) =16 drams (dr.)

## 7. TROY WEIGHT

- 1 pound (lb. t.) 12 ounces
- 1 ounce (oz. t.) =20 penny weights
- 1 penny weight (dwt.) =24 grains (gr.)
- 1 carat (car.) =3.086 grains

## 8. APOTHECARIES' WEIGHT

- 1 pound (lb. ap.) =12 ounces
- 1 ounce (oz. ap.) =8 drams
- 1 dram (dr. ap.) =3 scruples
- 1 scruple (scr. ap.) =20 grains (gr.)

Centi-meters		Inches		Meters		Feet		Meters		Yards		Kilo-meters		Miles	
2.540	1	0.394		0.305	1	3.281		0.914	1	1.094		1.609	1	0.621	
5.080	2	0.787		0.610	2	6.562		1.829	2	2.187		3.219	2	1.243	
7.620	3	1.181		0.914	3	9.843		2.743	3	3.281		4.828	3	1.864	
10.160	4	1.575		1.219	4	13.123		3.658	4	4.374		6.437	4	2.485	
12.700	5	1.969		1.524	5	16.404		4.572	5	5.468		8.047	5	3.107	
15.240	6	2.362		1.829	6	19.685		5.486	6	6.562		9.656	6	3.728	
17.780	7	2.756		2.134	7	22.966		6.401	7	7.655		11.265	7	4.350	
20.320	8	3.150		2.438	8	26.247		7.315	8	8.749		12.875	8	4.971	
22.860	9	3.543		2.743	9	29.528		8.230	9	9.843		14.484	9	5.592	
Cubic Meters		Cubic Yards		Liters		U.S. Pints		Liters		British Pints		Liters		U.S. Gallons	
0.765	1	1.308		0.473	1	2.113		0.568	1	1.760		3.785	1	0.264	
1.529	2	2.616		0.946	2	4.227		1.136	2	3.520		7.571	2	0.528	
2.294	3	3.924		1.420	3	6.340		1.705	3	5.279		11.356	3	0.793	
3.058	4	5.232		1.893	4	8.454		2.273	4	7.039		15.142	4	1.057	
3.823	5	6.540		2.366	5	10.567		2.841	5	8.799		18.927	5	1.321	
4.587	6	7.848		2.839	6	12.680		3.409	6	10.559		22.712	6	1.585	
5.352	7	9.156		3.312	7	14.794		3.978	7	12.319		26.498	7	1.849	
6.116	8	10.464		3.785	8	16.907		4.546	8	14.078		30.283	8	2.113	
6.881	9	11.772		4.259	9	19.030		5.114	9	15.838		34.069	9	2.378	
Hecto-grams		Ounces		Long Tons		Short Tons		Metric Tons		Long Tons		Metric Tons		Short Tons	
0.283	1	3.527		0.893	1	1.120		1.016	1	0.984		0.907	1	1.102	
2.567	2	7.055		1.786	2	2.240		2.032	2	1.968		1.814	2	2.205	
0.850	3	10.582		2.679	3	3.360		3.048	3	2.953		2.722	3	3.307	
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	
1.701	6	21.164		5.357	6	6.720		6.096	6	5.905		5.443	6	6.614	
1.984	7	24.692		6.250	7	7.840		7.112	7	6.889		6.350	7	7.716	
2.268	8	28.219		7.143	8	8.960		7.128	8	7.874		7.257	8	8.818	
2.551	9	31.747		8.036	9	10.080		9.144	9	8.858		8.165	9	9.921	
Square Centi-meters		Square Inches		Square Meters		Square Yards		Square Kilo-meters		Square Miles		Cubic Centi-meters		Cubic Inches	
6.452	1	0.155		0.836	1	1.196		2.590	1	0.386		16.387	1	0.061	
12.903	2	0.310		1.672	2	2.392		5.180	2	0.772		32.774	2	0.122	
19.355	3	0.465		2.508	3	3.588		7.770	3	1.158		49.161	3	0.183	
25.806	4	0.620		3.345	4	4.784		10.360	4	1.544		65.548	4	0.244	
32.258	5	0.775		4.181	5	5.980		12.950	5	1.931		81.936	5	0.305	
38.710	6	0.930		5.017	6	7.176		15.540	6	2.317		98.323	6	0.366	
45.161	7	1.085		5.853	7	8.372		18.130	7	2.703		114.710	7	0.427	
51.613	8	1.240		6.689	8	9.568		20.720	8	3.089		131.097	8	0.488	
58.064	9	1.395		7.525	9	10.764		23.310	9	3.475		147.484	9	0.549	
Liters		British Gallons		Hecto-liters		U.S. Bushels		Hecto-liters		British Bushels		Hecto-grams		Troy Ounces	
4.546	1	0.220		0.352	1	2.838		0.364	1	2.750		0.311	1	3.215	
9.092	2	0.440		0.705	2	5.676		0.727	2	5.409		0.622	2	6.430	
13.638	3	0.660		1.057	3	8.513		1.091	3	8.249		0.933	3	9.645	
18.184	4	0.880		1.410	4	11.351		1.455	4	10.999		1.244	4	12.860	
22.730	5	1.100		1.762	5	14.189		1.818	5	13.748		1.555	5	16.075	
27.276	6	1.320		2.114	6	17.027		2.182	6	16.498		1.866	6	19.290	
31.822	7	1.540		2.467	7	19.864		2.546	7	19.248		2.177	7	22.506	
36.368	8	1.760		2.819	8	22.702		2.909	8	21.998		2.488	8	25.721	
40.914	9	1.980		3.172	9	25.540		3.273	9	24.747		2.799	9	28.936	
U.S. Gallons (Liquid)		British Gallons (Liquid)		Kilo-grams		Av. Pounds		U.S. Bushels		British Bushels		Hectares		Acres	
1.201	1	0.833		0.454	1	2.205		1.032	1	0.969		0.405	1	2.471	
2.402	2	1.665		0.907	2	4.409		2.064	2	1.938		0.809	2	4.942	
3.603	3	2.498		1.361	3	6.614		3.093	3	2.907		1.214	3	7.413	
4.804	4	3.331		1.814	4	8.818		4.128	4	3.876		1.619	4	9.884	
6.005	5	4.163		2.268	5	11.023		5.160	5	4.845		2.023	5	12.355	
7.206	6	4.996		2.722	6	13.228		6.192	6	5.814		2.428	6	14.826	
8.407	7	5.829		3.175	7	15.432		7.224	7	6.783		2.833	7	17.297	
9.608	8	6.661		3.629	8	17.637		8.256	8	7.752		3.237	8	19.769	
10.808	9	7.494		4.082	9	19.842		9.228	9	8.721		3.642	9	22.240	

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