

# JUKI®

## INDUSTRIAL SEWING MACHINES

# HAND BOOK



## JUKI CORPORATION

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**DDL-5530N****DDL-5550N****DDL-5550N-7** (with 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-160A

**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 × 1 (#14) For JE: 134 (Nm75)	DA × 1 (#9) For JE: 134 (Nm65)	DB × 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 × 1 (#14) For JE: 134 (Nm75)	DA × 1 (#9) For JE: 134 (Nm65)	DB × 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 × 1 (#14) For JE: 134 (Nm75)	DA × 1 (#9) For JE: 134 (Nm65)	DB × 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	650VA		
Total weight	81kg		

## WHEN YOU PLACE ORDERS

DDL5530N

DDL5550N

DDL5550N  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

SC910

PSC box				Code
For JUS(LA)*	Single-phase	100 ~ 120V	PFL	S
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

Control box	Code
Standard	S
Provided with a built-in I/O board	A

● Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-4).

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

### ● Motor for SC

M91S

Pulley belt	Code
Standard	S

### ● Operation panel

Operation panel	Code
IP-100C	IP100C
CP-160A	CP160A

## 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 faceplate. It is very convenient for frequent use.

\* To retrofit the AE-4 to your existing machine, I/O board A (part number: 400-06080), which is separately available, is required.



Remaining bobbin thread detector (AE-4)



Material edge sensor (ED-2)

1-needle, Lockstitch Machine

## DDL-8700

### DDL-8700-7 (with 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-160A

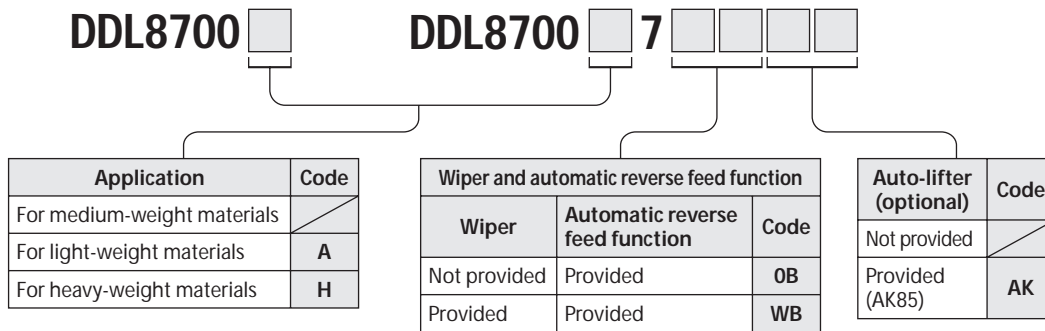


## SPECIFICATIONS

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 Machine Oil No.7 (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 Machine Oil No.7 (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	650VA		
Total weight	81kg		

## WHEN YOU PLACE ORDERS



### ● PSC box

SC910

PSC box				Code
For JUS(LA)*	Single-phase	100 ~ 120V	PFL	S
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

Control box	Code
Standard	S
Provided with a built-in I/O board	A

- Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-4).

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

### ● Motor for SC

M91S

Pulley belt	Code
Standard	S

### ● Operation panel

Operation panel	Code
IP-100C	IP100C
CP-160A	CP160A

## 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 faceplate. It is very convenient for frequent use.

\* To retrofit the AE-4 to your existing machine, I/O board A (part number: 400-06080), which is separately available, is required.



Remaining bobbin thread detector (AE-4)



Material edge sensor (ED-2)

Direct-drive, High-speed, 1-needle, Lockstitch Machine with 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	Dry head type		Minute-quantity lubrication type	
	DDL-9000DS	DDL-9000DF	DDL-9000SS	DDL-9000SH
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			35mm
Lift of the presser foot	By hand : 5.5mm, By knee : 15mm, auto : 10mm			
Lubrication	No lubrication		Minute-quantity lubrication to needle bar and hook	
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)			
Hook	Exclusive no-lubricating hook (plastic hook with special-purpose race surface)		Automatic lubricating hook	
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) Nm65 ~ Nm75	DB x 1 (#14) #9 ~ #18 For JE:134 (Nm75) Nm65 ~ Nm110	DB x 1 (#21) #19 ~ #23 For JE:134 (Nm130) Nm120 ~ Nm160
Free space for sewing	300mm			
Size of bed	517mm x 178mm			
Bobbin thread winder	Built-in the machine head			
Machine head drive	Compact AC servomotor that is directly connected to the main shaft (direct-drive system)			
Automatic reverse feed function	Provided as standard			
Power requirement Power consumption	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V/650VA			
Total weight	84.5Kg			

## WHEN YOU PLACE ORDERS

DDL9000    B

Machine head type	Code	Application	Code	Wiper	Code	Device and attachment	Code
Dry head	D	For light- to medium-weight materials	S	Not provided	0	Not provided	
Minute-quantity lubrication	S	For heavy-weight materials	H*	Provided	W	Auto-lifter (pedal-driven)	AK118
		For extra light-weight materials and foundation	F*				

\* 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

SC910

PSC box				Code
For JUS(LA)*	Single-phase	100 ~ 120V	PFL	S
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

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

### ● Operation panel

Operation panel	Code
IP-100B	IP100B
CP-160D	CP160D

Control box	Code
Standard	S
Provided with a built-in I/O board	A

● Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-8).

## 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 retrofit the AE-8 to your existing machine, I/O board A (part number: 400-06080), which is separately available, is required.

### Newly developed control box.

## SC-910

- SC-910 model control box is resistant to voltage fluctuations. It comes with a compact and energy-saving type switching power supply system that does not use a transformer. This contributes to improved reliability.
- The number of revolutions can be selected from among three different types (standard, slow and fast) according to the preference of the operator. In addition to this feature, the control box incorporates many different functions for upgraded workability.



### The operation panel can be selected according to the process.

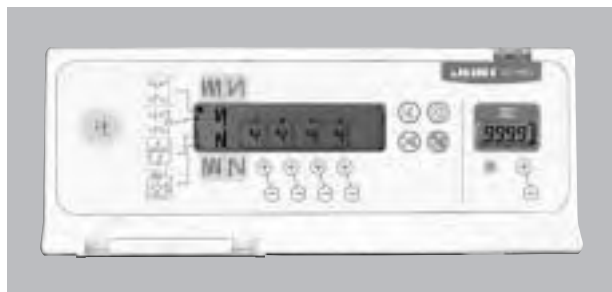
## IP-100B

- The operation panel has been provided with a large user-friendly LCD. A pictograph and set values are shown on the same screen, which promises improved operability of the panel.
- The operation panel has been provided with a variety of communication and maintenance control features and is able to store data on a SmartMedia or personal computer.
- The features of the operation panel can be updated without the need for changing the PWB/ROM.



## CP-160D

- Four different kinds of pattern sewing are possible: automatic reverse stitching, constant-dimension sewing, rectangle-shape sewing, and multi-layer stitching. The maximum number of stitches that can be set for automatic reverse stitching (single or double) is 19.





**DLN-5410N****DLN-5410N-7** (with 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-160A

**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	650VA		
Total weight	83kg		

## WHEN YOU PLACE ORDERS

DLN5410N

DLN5410N  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

SC910

PSC box				Code
For JUS(LA)*	Single-phase	100 ~ 120V	PFL	S
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

Control box	Code
Standard	S
Provided with a built-in I/O board	A

● Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-4 or AE-5).

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

### ● Motor for SC

M91S

Pulley belt	Code
Standard	S

### ● Operation panel

Operation panel	Code
IP-100C	IP100C
CP-160A	CP160A

## 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.)

\* To retrofit the AE-4 or AE-5 to your existing machine, I/O board A (part number: 400-06080), which is separately available, is required.



Remaining bobbin thread detector (AE-4)



Material edge sensor (ED-2)

High-speed, Cylinder-bed, 1-needle, Needle-feed Lockstitch Machine with Large Hook

# DLN-6390

## DLN-6390-7 (with automatic thread trimmer)

- The needle bar stroke is as high as 35mm. This offers increased penetration of the needle into the material to improve adaptability to heavy-weight materials.
- The machine demonstrates excellent sewing capabilities, when sewing heavy-weight denim or multi-layered portions, that free it of sewing troubles such as stitch gathering, stitch skipping and needle breakage.
- The machine is able to sew material with a low presser foot pressure while preventing the material from flapping. As a result, the material can be sewn free of puckering.
- The top- and bottom-roller style feed mechanism forms seams with increased consistency to achieve improved hemming quality while reducing uneven hems.



DLN-6390-7



### SPECIFICATIONS

Model name	DLN-6390	DLN-6390-7
Application	Bottom-folding and hemming (lockstitch type)	
Max. sewing speed	5,000rpm	
Stitch length	Standard gears: 3.2mm (2.8mm) / Supplied gears: 2.3mm, 3.6mm / Optional gears: 2.1mm, 2.5mm, 4.2mm (utilized by changing pitch conversion gears)	
Needle	SCHMETS UY180GVS Nm140 range of use: Nm90 ~ Nm150 (equivalent to #14 ~ #22.5)	
Needle bar stroke	35mm	
Hook	Automatic-lubrication type exclusive full-rotary 1.7-fold hook	
Lift of the presser foot	Max. 14mm	
Feed system	Top- and bottom-roller style	
Binder open/close type	Manual type	Driven by air cylinder
Compressed air and air consumption	0.5MPa (0.5kgf/cm <sup>2</sup> ), 10Nℓ /min	
Lubrication	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	
Motor	400 W clutch motor or higher class motor is applicable	SC380(JUKI exclusive motor)
Cylinder-bed diameter	180mm	
Weight of the machine head	34.5kg	36.5kg

### WHEN YOU PLACE ORDERS

● Without automatic thread trimmer

DLN6390

Application	Code
Standard	S

● With automatic thread trimmer

DLN6390  7W0

Application	Code
Standard	S

Wiper and automatic reverse feed function		
Wiper	Automatic reverse feed function	Code
Provided	Not provided	W0

Option	Code
Not provided	Z
With needle cooler	A

● PSC Box

SC380   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

PSC box			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

## DEVICE CONFIGURATIONS BY MODEL

	DLN-6390	DLN-6390-7
Thread trimmer	-	Provided as standard
Manual binder (coupled to the presser lifter)	Provided as standard	-
Pneumatic AK device (auto-lifter)	-	Provided as standard
Pneumatic binder (coupled to the AK device)	-	Provided as standard
Edge guide	Accessory	Accessory
Mechanical wiper	-	Provided as standard
Thread trimmer air blower	-	Provided as standard
Needle cooler	Option	Option

## OPTIONS

### Needle cooler

The needle cooler helps reduce the occurrence of thread breakage caused by needle heat when sewing is performed at a speed of 4,000rpm or more.

The components differ with the type of machine head, i.e. with or without the thread trimmer. Selections should be made by referring to the following table.

Machine head	Type	Part No.
For DLN-6390	Mechanical valve type, provided with regulator	400-04071
For DLN-6390-7	Solenoid valve type, not provided with regulator	400-04070

## DEVICE CONFIGURATIONS BY MODEL

Feed rollers, pressers, feed adjusting gears and binders from the UNION SPECIAL 63900 model machine can be attached to the DLN-6390/-6390-7 with no additional machining or adjustments.

### Parts provided as standard

#### Presser foot

1/2" Part No.: 300-31108

#### Binder

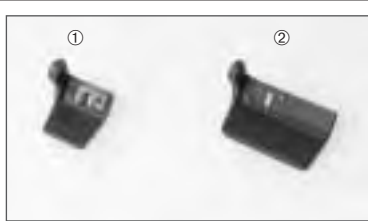
1/2" Part No.: 300-15309

#### Feed roller

1/2" Part No.: 276-38006 (Top roller)

1/2" Part No.: 276-35705 (Bottom roller)

### Options

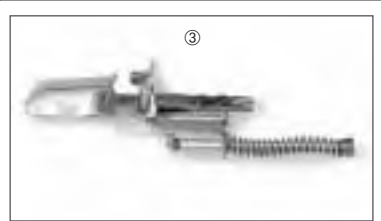


Hem width 3/8"

①Part No.: 300-31009

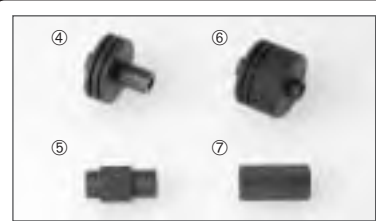
Hem width 1"

②Part No.: 277-94601



Hem width 1" (asm.)

③Part No.: 400-10327



1/2" roller (knurled type)

④Part No.: 300-20705 (Top roller)

⑤Part No.: 300-32106 (Bottom roller)

1" roller (knurled type)

⑥Part No.: 277-94403 (Top roller)

⑦Part No.: 277-94502 (Bottom roller)

### Table of feed amount adjustment/conversion gears

The shaded portion indicates the factory-attached gear present at the time of delivery. It can be interchanged with other gears supplied with the machine to support four different feed amounts.



Feed pitch	Top gear		Bottom gear		Remarks
	JUKI part No.	Engraved marker	JUKI part No.	Engraved marker	
4.2mm (6 stitch/inch)	300-37600	63949-47	300-37501	63949-33	Option
3.6mm (7 stitch/inch)	300-37303	63949-44	300-37402	63949-36	Supported by the gear supplied with the machine.
3.2mm (8 stitch/inch)	300-33302	63949-41	300-33203	63949-39	Standard factory-attached gear present at the time of delivery
2.8mm (9 stitch/inch)	300-33203	63949-39	300-33302	63949-41	Supported by changing over the factory-attached top and bottom gears.
2.5mm (10 stitch/inch)	300-33104	63949-37	300-33401	63949-43	Option
2.3mm (11 stitch/inch)	300-37402	63949-36	300-37303	63949-44	Supported by the gear supplied with the machine.
2.1mm (12 stitch/inch)	300-37501	63949-33	300-37600	63949-47	Option

Direct-drive, High-speed, Needle-feed, Lockstitch Machine with Automatic Thread Trimmer

# DLN-9010

- Thanks to the needle-feed mechanism which offers excellent efficiency of feed, the machine ensures accurate stitch pitches (stitch length) as well as preventing slippage of the upper cloth. The bottom feed's locus has been improved to match the needle feed motion, thus the machine produces beautiful seams without stitch gathering, even when it is used for sewing slippery and difficult-to-feed material or for handling a difficult process.
- The needle feed mechanism is a so-called "dry type", which does not require oiling. With this mechanism, a highly reliable machine structure, free from oil leakage troubles, has been achieved. The frame, which requires only a minute quantity of lubricating oil, is structured to eliminate oil leakage.



DLN-9010SS-WB/CP-160D

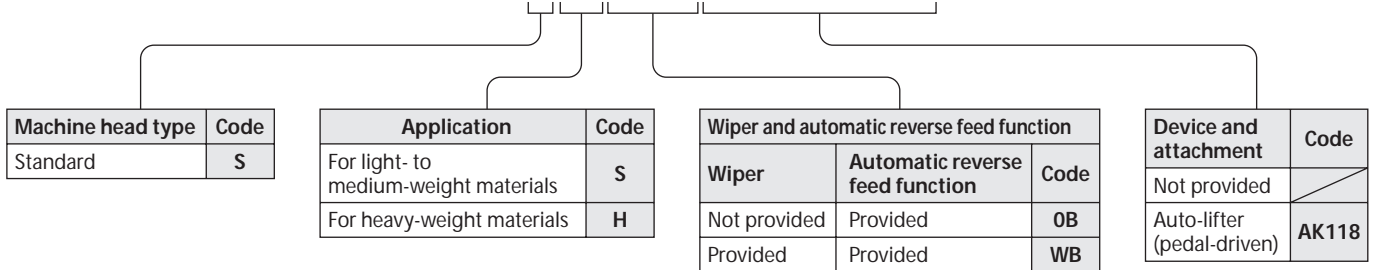
## SPECIFICATIONS

Model name	DLN-9010SS	DLN-9010SH
Application	For light- to medium-weight materials	For heavy weight materials
Max. sewing speed	5,000rpm	4,000rpm
Max. stitch length	4.5mm *	
Needle bar stroke	33mm	
Lift of the presser foot	By hand: 5.5mm, By knee: 15mm(max.), Auto: 10mm	
Needle (at the time of delivery)	DB x 1 (#11) #9 ~ #18 For JE:134 (Nm90) Nm65 ~ Nm110	DB x 1 (#21) #20 ~ #23 For JE:134 (Nm130) Nm120 ~ Nm160
Hook	Automatic-lubricating full-rotary hook	
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 that is directly connected to the main shaft (direct-drive system)	
Automatic reverse feed function	Provided as standard (built-in solenoid type)	
Power requirement/Power consumption	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V / 650VA	
Total weight	87kg	

\* The maximum sewing speed is 4,000 rpm or less in cases where the maximum stitch length is 3.5 mm or more.

## WHEN YOU PLACE ORDERS

### DLN9010S



### ● PSC box

### SC910

PSC box				Code
For JUS(LA)*	Single-phase	100 ~ 120V	PFL	S
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

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

### ● Operation panel

Operation panel	Code
IP-100B	IP100B
CP-160D	CP160D

Control box	Code
Standard	S
Provided with a built-in I/O board	A

● Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-8).

## OPTIONS

Model	Part No.	Description	Feature
AK118		Auto-lifter	
	400-00380	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 retrofit the AE-8 to your existing machine, I/O board A (part number: 400-06080), which is separately available, is required.

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

# DLU-5490N

## DLU-5490N-7 (with 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-160A

### 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 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		650VA
Weight	Machine head: 30kg	Total weight: 83kg

### 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-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 faceplate. It is very convenient for frequent use.

\* To retrofit the AE-4 to your existing machine, I/O board A (part number: 400-06080), which is separately available, is required.



Remaining bobbin thread detector (AE-4)



Material edge sensor (ED-2)

## WHEN YOU PLACE ORDERS

DLU5490N

DLU5490N   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

SC910

PSC box				Code
For JUS(LA)*	Single-phase	100 ~ 120V	PFL	S
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

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

Control box	Code
Standard	S
Provided with a built-in I/O board	A

● Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-4).

### ● Motor for SC

M91S

Pulley belt	Code
Standard	S

### ● Operation panel

Operation panel	Code
IP-100C	IP100C
CP-160A	CP160A



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



DLU-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

DLU5494N   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   AD560

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.

**DLD-5430N****DLD-5430N-7** (with 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. Thanks to these improvements, partial shirring can be performed with minimum tension applied to the material, thus leading to greater flexibility in responding to different types of material.



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

**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 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	650VA	
Weight	Machine head: 29kg	Total weight: 82kg

\* This ratio applies provided that the stitch length does not exceed 2.5mm.

**OPTIONS**

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

\* To retrofit the AE-4 to your existing machine, I/O board A (part number: 400-06080), which is separately available, is required.



Remaining bobbin thread detector (AE-4)



Material edge sensor (ED-2)



Gathering attachment (Q036)

DLD5430N7

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

● PSC box

SC910

PSC box				Code
For JUS(LA)*	Single-phase	100 ~ 120V	PFL	<b>S</b>
For JUS*, General Export	3-phase	200 ~ 240V	PFL	<b>D</b>
For General Export	Single-phase	200 ~ 240V	PFL	<b>K</b>
For CE	Single-phase	200 ~ 240V	PFL	<b>N</b>

Control box		Code
Standard		<b>S</b>
Provided with a built-in I/O board		<b>A</b>

● Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-4).

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

● Motor for SC

M91S

Pulley belt	Code
Standard	<b>S</b>

● Operation panel

Operation panel	Code
IP-100C	<b>IP100C</b>
CP-160A	<b>CP160A</b>

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

DLM5200N

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









DLM5210N/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	B1115-530-0AD	B1190-522-X00	113-46905	113-46400	B1524-522-NB0A	B1613-522-N00A	B4121-522-000
D	3.2mm (1/8")	113-46004	B1115-530-0AD	B1190-522-S00	113-46905	113-46400	B1524-522-NB0A	B1613-522-N00A	B4121-522-000
E	4.0mm (5/32")	113-46004	B1115-530-0AF	B1190-522-Y00	113-46905	113-46400	B1524-522-NB0A	B1613-522-N00A	B4121-522-000
F	4.8mm (3/16")	113-46004	B1115-530-0AF	B1190-522-T00	113-46905	113-46400	B1524-522-NB0A	B1613-522-N00A	B4121-522-000
H	6.4mm (1/4")	113-46004	B1115-530-0AF	B1190-522-U00	113-47101	113-46509	B1524-012-0BA	B1613-522-W00A	B4121-522-000
M	9.5mm (3/8")	113-46103	B1115-530-0AM	B1190-522-V00	113-47309	113-46509	B1524-012-0BA	B1613-522-W00A	B4121-522-000

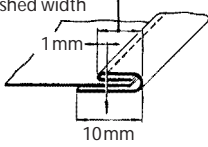
■ This is made to order as an auxiliary part only

CA	2.0mm (5/64")	113-46004	B1115-530-0AD	B1190-522-Y0A	113-46905	113-46400	B1524-522-NB0A	B1613-522-N00A	B4121-522-000
HA	6.4mm (1/4")	113-46004	B1115-530-0AF	B1190-522-U0A	113-47101	113-46509	B1524-012-0BA	B1613-522-A0A	B4121-522-000
K	7.9mm (5/16")	113-46103	B1115-530-0AM	B1190-522-Y0B	113-47101	113-46509	B1524-012-0BA	B1613-522-W00A	B4121-522-000

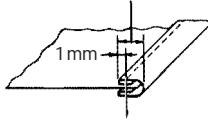
# DLM-5210N/ N011, N015

## ATTACHMENTS

● N011

Rolled hem 	N011 Semi-fold Binder (cut-before knife, rolled hem)			Exclusive sub-gauge		
	Finished width	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 Vertical Edge Trimmer and automatic thread trimmer

## DLM-5400N-7

1-needle, Needle-feed, Lockstitch Machine  
with Vertical Edge Trimmer and 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 plated 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 toward you from the center of the needle.



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

## 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 x 1 (#14) #9 ~ #18, For JE: 134 (Nm90)	
Hook	Automatic-lubricating full-rotary hook	
Max. thickness of the material to be cut	4mm	
Lubrication	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	650VA	
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 retrofit the AE-4 to your existing machine, I/O board A (part number: 400-06080), which is separately available, is required.

DLM5400N  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

DMN5420N   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

SC910

PSC box				Code
For JUS(LA)*	Single-phase	100 ~ 120V	PFL	S
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

Control box		Code
Standard		S
Provided with a built-in I/O board		A

● Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-4).

● Motor for SC

M91S









Pulley belt	Code
Standard	S

● Operation panel

Operation panel	Code
IP-100C	IP100C
CP-160A	CP160A



**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

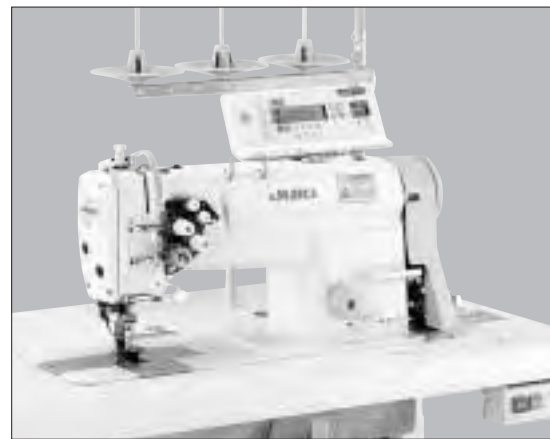
\* Be sure to use this gauge with the stitch length set to 2mm or less.  
 \*\* Be sure to use this gauge with the stitch length set to 2.5mm or less.  
 Wiper cannot be attached to the CA and DA type of sub-gauges.

2-needle, Needle-feed, Lockstitch Machine

## LH-3128

### LH-3128-7 (with 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.



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

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

## LH-3168

### LH-3168-7 (with 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 Large Hooks

## LH-3178

### LH-3178-7 (with automatic thread trimmer)

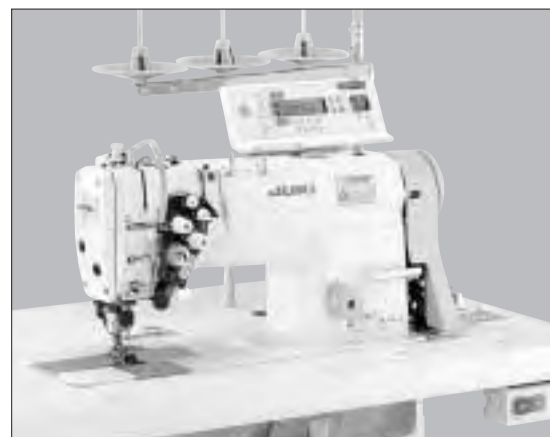
- Our investigation of the thread take-up stroke and other mechanisms results in the reduction of irregular stitches. Even at high speed, the machine performs sewing as consistently as the standard hook machine. The machine can make the most out of the advantageous features of the large hook, upgrading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

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

## LH-3188

### LH-3188-7 (with 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.

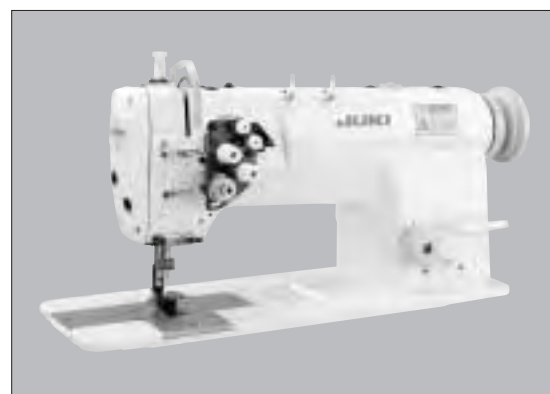


LH-3188-7-WB/CP-160B

2-needle, Bottom-feed, Lockstitch Machine

## LH-3120

- 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-3120

# SPECIFICATIONS

## ● Without 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 plunger pump			
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)			
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 plunger pump					
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)					
Distance from needle to machine arm	245mm					
Bed size	517mm x 178mm					
Weight of the machine head	38kg					

## ● With automatic thread trimmer

Model name	LH-3128A-7	LH-3128S-7	LH-3128G-7
Feed system	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	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 (#14) #11 ~ #18	DP x 5 (#21) #18 ~ #22
Organized split needle bar mechanism	Not provided		
Lubrication	Fully automatic lubrication system by means of plunger pump		
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)		
Distance from needle to machine arm	245mm		
Bed size	517mm x 178mm		
Weight of the machine head	43kg		
Power requirement Power consumption	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V/650VA		

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 plunger pump					
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)					
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 Power consumption	Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V/650VA					

# WHEN YOU PLACE ORDERS

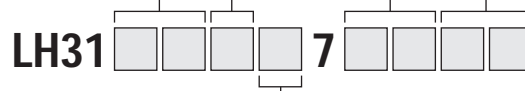
● With automatic thread trimmer

Type	Code
Needle-feed	28
Needle-feed with organized split needle bar	68
Needle-feed with large hooks	78
Needle-feed with 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



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-3128-7	A																	
	S																	
	G																	
LH-3168-7	A																	
	S																	
	G																	
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 box	Code
Standard	S

PSC box				Code
For JUS (LA)*	Single-phase	100 ~ 120V	PFL	S
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

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

● Motor for SC



Pulley belt	Code
Standard	S

● Operation panel

Operation panel	Code
IP-100B	IP100B
CP-160B	CP160B

● Without automatic thread trimmer

Type	Code
Bottom-feed	20
Needle-feed	28
Needle-feed with organized split needle bar	68
Needle-feed with large hooks	78
Needle-feed with 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

LH31 

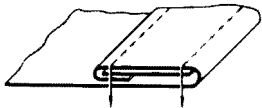
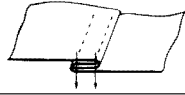
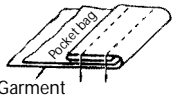
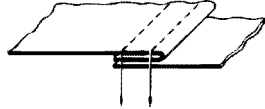
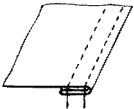
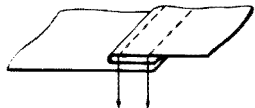
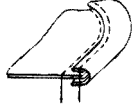
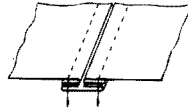
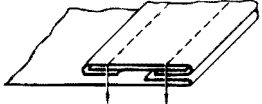

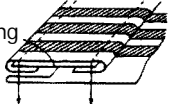
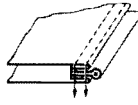
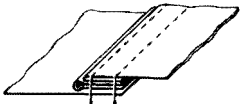
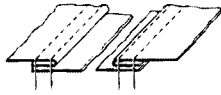
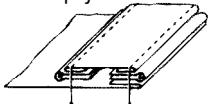
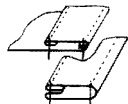
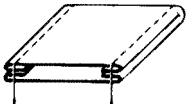
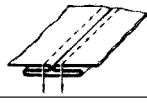
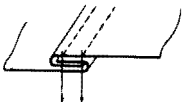
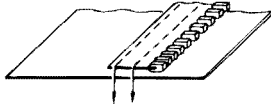
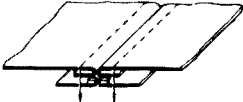
Code		A	B	C	D	E	F	G	H	K	W	L	M	N	P	Q	R	S	T	U	
Model name	Needle gauge	mm	2.4	3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	11.1	12.7	15.9	19.1	22.2	25.4	28.6	31.8	34.9	38.1
	Spec.	inch	3/32	1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4	1-3/8	1-1/2
LH-3120	A																				
LH-3128	A																				
	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.)
	232-09059	Micro-lifter	This device can be installed on the back of the face plate. It is very convenient for frequent use.

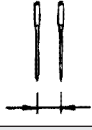




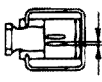
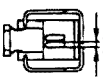
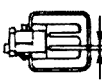
# ATTACHMENTS

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 hemmer 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, etc. 	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

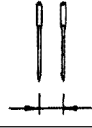



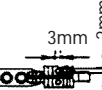
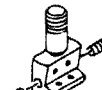
\* The part numbers are designated according to needle gauge and specification.  
Be sure to confirm the part number of the attachment you need when placing your order with us.

# TABLE OF EXCHANGE PARTS FOR LH3100 SERIES

## LH-3128




Needle gauge size		Throat plate	Feed dog			Presser foot asm.		
Code								(tipdivided) 
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							


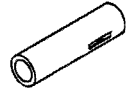
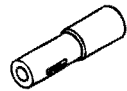
## LH-3128-7

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






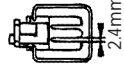
Needle gauge size		Throat plate with thread trimmer	Feed dog (with thread trimmer)			Needle clamp asm. Left	Needle clamp asm. Right	
Code								
B	3.2mm (1/8")	226-60203	226-65103			B1402-528-BA0A	B1402-528-BA0A	Standard spec.
C	4.0mm (5/32")	226-60302	226-65202	102-37907		B1402-528-CA0A	B1402-528-CA0A	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		

## LH-3168/LH-3168-7





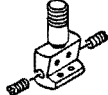

Needle gauge size	Bed slide asm. (with thread trimmer)		
	Bed slide asm. (left)	Bed slide asm. (right)	
Code			
B	3.2mm (1/8")	226-50857	226-50352
K	9.5mm (3/8")		
L	12.7mm (1/2")	226-50956	226-50451
N	19.1mm (3/4")		
Q	25.4mm (1")	226-51053	226-50550

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					


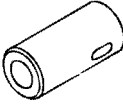
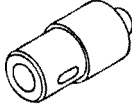
# LH-3178-7

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					



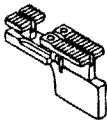

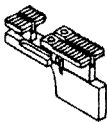
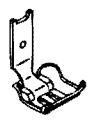

Standard spec.

## LH-3178/3178-7





Needle gauge size		Bed slide asm. (with thread trimmer)	
Code		Bed slide asm. (left) 	Bed slide asm. (right) 
A   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






### ● 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	
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-3188


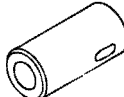
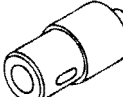
Needle gauge size		Throat plate	Feed dog	Presser foot asm.
Code				(tipdivided) 
B	3.2mm (1/8")			
C	4.0mm (5/32")			
D	4.8mm (3/16")	226-25305	228-15401	228-16557
E	5.6mm (7/32")	226-25404	228-15500	228-16656
F	6.4mm (1/4")	226-25503	228-15609	228-16755
G	7.1mm (9/32")	226-25602	228-15708	228-16854
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



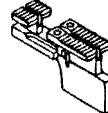

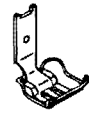

Needle gauge size		Throat plate with thread trimmer	Feed dog (with thread trimmer)	Needle clamp asm. Left	Needle clamp asm. Right
Code					
B	3.2mm (1/8")				
C	4.0mm (5/32")				
D	4.8mm (3/16")	226-60401	228-21201	B1402-528-DALA	B1402-528-DARA
E	5.6mm (7/32")	226-60500	228-21300	B1402-528-EAL	B1402-528-EAR
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


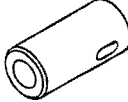
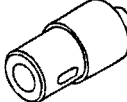
Needle gauge size	Throat plate (without thread trimmer)	Feed dog (without thread trimmer)	Throat plate (with thread trimmer)	Feed dog (with thread trimmer)	Presser foot asm.	Feed dog screw
Code						
D	4.8mm (3/16")	228-35003	228-35557	228-35201	B1524-512-DBH	SS6580710TP × 2
F	6.4mm (1/4")	228-35102	228-35656	228-35300	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

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")	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	B1803-515-0A0
Q	25.4mm (1")		
U	38.1mm (1-1/2")	B1802-512-0AB	101-12357

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

# LH-3126F

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



LH-3126F

## SPECIFICATIONS

Model name	LH-3126F
Max. sewing speed	3,000rpm
Max. stitch length	4mm (normal/reverse feed)
Thread take-up	Slide type
Needle bar stroke	33.4mm
Lift of the presser foot	By hand: 5.5mm, By knee: 12mm
Hook (selectable)	Vertical-axis hook (regular fold), specific latch hook or specific hook with 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 plunger pump
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)
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 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						

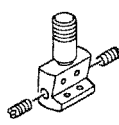


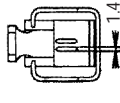
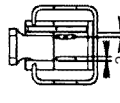
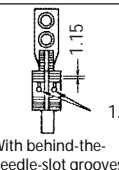
LH3126F

Attachment	Code	Auto-lifter	Code	Motor *	Code
Standard throat plate, standard slide plate, standard presser foot	1	Not provided	Z	Compatible with clutch motor (without synchronizer and resistor pack)	0
Throat plate for tape-attachment, slide plate for tape-attachment, presser foot for tape-attachment	4*	Pedal switch type (AK89) *	P	Compatible with SC-800 and EC-10B (with built-in synchronizer and resistor pack)	1
* For the above category 4, select the feed category A (needle-feed).		* For the AK89, select the motor compatibility category 1 (SC-800, SC-910 or EC-10B).		* Refer to the combination availability table.	

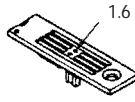
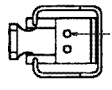
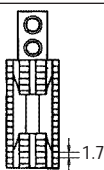
Automatic reverse feed function	Motor	Clutch motor	SC-800	EC-10B
0 (not provided)	Where "0" is selected		x	x
	Where "1" is selected	x		
B (provided)	Where "0" is selected	x	x	x
	Where "1" is selected	x		

●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-DOB
F	6.4mm (1/4")	101-48054	226-25503	B1109-512-FOB	226-27558	226-47358	B1613-512-FOB
G	7.1mm (9/32")	101-48153	226-25602	B1109-512-GOB	226-27657	226-47457	B1613-512-GOB
H	7.9mm (5/16")	101-48252	226-25701	B1109-512-HOB	226-27756	226-47556	B1613-512-HOB

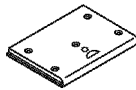
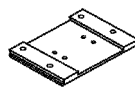







Gauge size		Bottom-feed gauges		
Code		Throat plate	Presser foot	Feed dog
		B	3.2mm (1/8")	228-45200
D	4.8mm (3/16")	228-45408	103-92058	232-05305
F	6.4mm (1/4")	228-45606	103-92256	232-05503

Needle slot  
2.0 (B gauge)  
2.2 (D and F gauges)

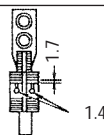

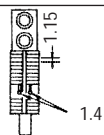
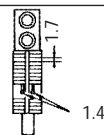
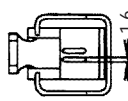
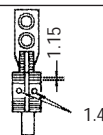
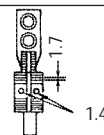
Common gauges for needle-feed and bottom-feed	
Slide plate (front)	
Standard type	For tape attachment
B1110-051-0A0	232-06709

Bed with flat top surface


●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

With behind-the-needle-slot grooves

Gauge size		Needle-feed gauges
Code		Throat plate
		For tape attachment
B	3.2mm (1/8")	226-28002
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



With tape inserting recess

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



All-thin type

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 Automatic Organized Split Needle Bar Incorporating Corner  
Programming Device and 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 plunger pump			
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)			
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	
	227-98458	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).
	227-97252		
	227-98508		
	EA-9500B0100		
	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

LH31     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 compensation stitching switch (reverse feed control lever mounting type)	A
With 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   SH660B

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 (PK-70/-71 can be used for this feature)	S

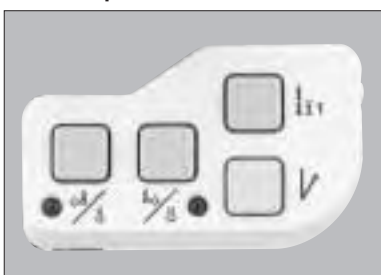
Control panel	Code
CP-660B	660

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

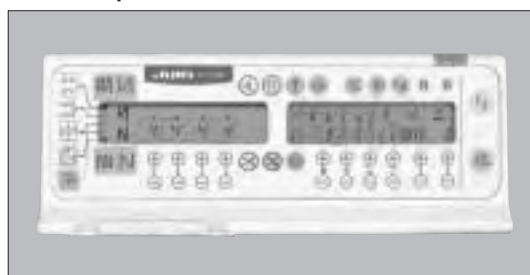
\* If an auto-lifter is installed on the machine, the presser foot will be lifted/lowered by the foot pedal.

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

### ● Corner stitching hand-operated switches



### ● Control panel CP-660B



### ● Servomotor/Controller SC-804



# MO-6100D Series

- The needle bar, feed and looper mechanisms require no oiling. This means they do not splash oil, thereby leaving no oil stains on the sewing material, and thus contributing to upgraded quality.
- The driving section of the machine, except for the needle bar, feed and looper mechanisms is installed in a forced oiling block. This block is completely sealed to prevent the leakage of oil.
- Stain-removing work or re-sewing work resulting from oil stains is eliminated.
- The machine does not need periodical oiling or used-oil disposal, which markedly improves maintainability.
- **Anti-material-slip type**

MO-6114D- -30P, MO-6116D- -30P

The sewing machine is fully equipped with adjusting devices and provisions to effectively prevent puckering of difficult-to-sew materials or new-generation materials. The operator is able to produce beautifully finished high-quality seams without conducting difficult adjustments.



MO-6114D

## SPECIFICATIONS

Model name	MO-6104D	MO-6114D	MO-6116D
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)	-	2.0, 2.4	2.0, 3.2, 4.8
Overedging width (mm)	3.2, 4.0, 4.8	2.0, 3.2, 4.0, 4.8	3.2, 4.0, 4.8
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 (Anti-material-slip type), 25.5mm (Upper looper extra high throw type)		
Inclination angle of the needle	20°		
Needle mechanism	Needle bar method and upper/lower bushing		
Needle	DC × 27 (excluding some subclass model)		
Max. lift of the presser foot	7mm (excluding some subclass model)		
Max. presser foot pressure	63.7N (6.5kg)		
Stitch adjusting method	By push-button		
Differential-feed adjusting method	By lever (with micro-adjustment)		
Weight of the machine head	28kg		
Lubrication	No lubrication		
Needle cooler	Option		
Needle thread heat remover	Option		
Micro-lifter	Provided as standard		

## SUBCLASS MACHINE LIST

Seams	Model No.	Materials	Number of needles	Number of threads	Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	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

	MO-6104D-0D4-40H	M ~ H	1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	Upper looper extra high throw type
	MO-6104D-0E4-40H		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	
	MO-6104D-0D6-40H		1	3	-	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	
	MO-6104D-0E6-40H		1	3	-	4.0	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	
	MO-6104D-0F4-40H		1	3	-	4.8	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	
	MO-6104D-0F6-40H		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	6,000	

														Remarks
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■ 2-needle overlock

● For runstitching in general fabric

	MO-6114D-BD4-40H	M ~ H	2	4	2.0	3.2	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	Upper looper extra high throw type
	MO-6114D-BD6-40H		2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	
	MO-6114D-BE4-40H		2	4	2.0	4.0	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	
	MO-6114D-BE6-40H		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	
	MO-6114D-BB6-30P	L ~ M	2	4	2.0	2.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	Anti-material-slip
	MO-6114D-BD6-30P		2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	
	MO-6114D-BE6-30P		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	
MO-6114D-CF6-40H	M ~ H	2	4	2.4	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	6,000	Upper looper extra high throw type	

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

	MO-6114D-BE6-44H/ G39/Q141	M ~ H	2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #14	6,000	Upper looper extra high throw type
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■ Safety stitching

● For runstitching in general fabric

	MO-6116D-DE4-40H	M ~ H	2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	Upper looper extra high throw type
	MO-6116D-DE6-40H		2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-DF4-40H		2	5	3.2	4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-DF6-40H		2	5	3.2	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-FF6-40H		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-BE4-30P	L ~ M	2	5	2.0	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	Anti-material-slip
	MO-6116D-BF4-30P		2	5	2.0	4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-DD4-30P		2	5	3.2	3.2	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-DE4-30P		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
	MO-6116D-DF4-30P		2	5	3.2	4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000	
MO-6116D-FF4-30P	2	5	4.8	4.8	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	6,000			

WHEN YOU PLACE ORDERS

Stitch type	U.S.A	Code
1-needle overlock	504	04
2-needle overlock	514	14
2-needle safety stitch	516	16

Type	Code
Dry-head	D

Device and attachment	Code
Tape attaching presser foot (for sewing sharp curves) / Tape guide	G39/Q141

MO61   D       /

Needle gauge (mm)	Overedging width (mm)	Feed dog	Code
	3.2	2-row	0D4
	3.2	3-row	0D6
	4.0	2-row	0E4
	4.0	3-row	0E6
	4.8	2-row	0F4
	4.8	3-row	0F6
2.0	2.0	3-row	BB6
2.0	3.2	2-row	BD4
2.0	3.2	3-row	BD6
2.0	4.0	2-row	BE4
2.0	4.0	3-row	BE6
2.4	4.8	3-row	CF6
3.2	3.2	2-row	DD4
3.2	4.0	2-row	DE4
3.2	4.0	3-row	DE6
3.2	4.8	2-row	DF4
3.2	4.8	3-row	DF6
4.8	4.8	2-row	FF4
4.8	4.8	3-row	FF6

Material		Application	Special machine classification	Code
Medium- to heavy-weight	Specific to knits such as sweaters	Runstitching	Upper looper extra high throw	40H
		Tape attaching	Upper looper extra high throw	44H
Light- to medium-weight	For general fabrics	Runstitching	Anti-material-slip type	30P

# DEVICES AND ATTACHMENTS

Model	Part No.	Description
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## ● 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 + chain-off thread trimming device (number-off-stitch control and electro-magnetic 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	

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

MC-7A	Blower-type chain-off thread suction device + cloth chips
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## ● Pneumatic chain-off thread suction device

MC-4	Specific to chain-off thread, pedal-operated
MC-5	Specific to chain-off thread
MC-8	Pneumatic chain-off thread + cloth chips
MC-9	Function of MC-8 + auto-lifter
MC-24	Pneumatic chain-off thread + cloth chips

\* The aforementioned devices are not equipped with 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 (knee-operated)
AK49	GAK-490000A0	Pneumatic type (pedal-operated)
AK52	GAK-520000A0	Pneumatic type (with chain-off thread suction device)
AK65	GAK-650000A0	Electromagnetic type
AK101	GAK-A01000A0	Pneumatic type (for servomotor)

Model	Part No.	Description	Feature
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## ● Gathering device

S159	MAS-159000A0	Swing-type gathering device (interlocked with pedal / for safety stitch machine)	The attachment opens with the presser foot pedal. This facilitates material setting on the machine. Furthermore, 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 / for overlock machine)	
S161	MAS-161000A0	Swing-type gathering device (manual-lever operated / for 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 (manual-lever operated / for overlock machine)	

## ● 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	For flat upper knife For 110, 115 ,220, 240V
	MAL-122002A0		For 220, 380, 415, 440V
	MAL-122001AA		For 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 gathering	The attachment makes gathers on the lower fabric while making decorative piping.

## ● Guide, Ruler

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.
	131-62557	Needle cooler unit asm.	Needle cooler By silicon oil lubricating unit for the needle thread.
	SS-7110840SP	Screw	
	131-63159	Needle cooler unit asm.	For safety stitch machine
	SS-7110840SP	Screw	
	131-63902	Presser	Needle thread heat remover By silicon oil lubricating unit for the needle thread.
	131-63456	Silicon tank asm.	
	131-63803	Felt	
	TA-0950806R0	Rubber plug	
	SM-4040855SP	Screw	

## [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	Auto-lifter	
T039	+	MC-7A	AK65 (Electronic-stop motor or AC servomotor) AK101 (JUKI servomotor)
		MC-8	AK65 (Electronic-stop motor or AC servomotor) AK101 (JUKI servomotor)
	+	MC-9	(MC-9 is equipped with auto-lifter.)

T040	+	MC-7A	AK32 (any motor will do) AK65 (Electronic-stop motor or AC servomotor)
		MC-5	AK32 (any motor will do)
	+	MC-24	AK32 (any motor will do)

T041 or T042	+	MC-7A	AK49 (Motors other than JUKI servomotors are applicable.) AK65 (Electronic-stop motor or AC servomotor) AK101 (JUKI servomotor)
		*	AK52 (any motor will do) * AK52 is equipped with chain-off thread suction device.
		MC-4	AK65 (Electronic-stop motor or AC servomotor)
	+	MC-8	AK65 (Electronic-stop motor or AC servomotor) AK101 (JUKI servomotor)
		MC-9	(MC-9 is equipped with auto-lifter.)

# MO-6700S Series

- Since the machine comes with a needle-thread take-up mechanism as well as a looper thread take-up mechanism, to offer upgraded responsiveness from light- to heavy-weight materials with a lower applied tension, it achieves well-tensed soft-feeling seams that flexibly correspond to the elasticity of the material at the maximum sewing speed of 7,000rpm.
- The machine incorporates various mechanisms as standard, such as a differential-feed micro-adjustment mechanism and an external adjustment mechanism for adjusting the feed dog inclination as well as increasing the differential feed ratio, which can be easily adjusted to finish seams that perfectly match the material to be used.



MO-6714S

## SPECIFICATIONS

Model name	MO-6704S	MO-6714S	MO-6716S
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		1.5 ~ 4mm
Needle gauge (mm)	-	2.0, 2.4, 3.2	2.0, 3.2, 4.0, 4.8, 4.8+2.0
Overedging width (mm)	1.6, 3.2, 4.0, 4.8	3.2, 4.0, 4.8	3.2, 4.0, 4.8, 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 mechanism	Needle bar method and upper/lower bushing		
Needle	DC × 27 (excluding some subclass model)		
Max. lift of the presser foot	7mm (excluding some subclass model)		
Max. presser foot pressure	63.7N (6.5kg)		
Stitch 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 Machine Oil 18 (equivalent to ISO VG18)		
Needle cooler	Option		
Needle thread heat remover	Option		
Micro-lifter	Provided as standard		

## SUBCLASS MACHINE LIST

Seams	Model No.	Materials	Number of needles	Number of threads	Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	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

	MO-6704S-0D4-300	L ~ M	1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	For soft-chains
	MO-6704S-0E4-300		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-6704S-0F4-300		1	3	-	4.8	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-6704S-0D6-300		1	3	-	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-6704S-0F6-300		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-6704S-0D4-3F0		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-6704S-0E4-3F0		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-6704S-0D6-3F0		1	3	-	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	
	MO-6704S-0D4-3F6		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	7,000	

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	MO-6704S-0E4-4FH	M ~ H	1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	For soft-chains Upper looper extra high throw type
	MO-6704S-0E4-40H		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	Upper looper extra high throw type
	MO-6704S-0F4-40H		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6704S-0E6-40H		1	3	-	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6704S-0F6-500		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #14	7,000	
	MO-6704S-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

● For blind hemming L121: Blind stitch hemming attachment

	MO-6705S-0D4-210/ L121	L ~ M	1	3	-	3.2	2	4	1:0.7 ~ 1:2	5.5	DC x 27 #9	7,000	
	MO-6705S-0E4-41H/ L121	M ~ H	1	3	-	4.0	2	4	1:0.7 ~ 1:2	5.5	DC x 27 #9	7,000	Upper looper extra high throw type

● For rolled hemming (folded downward)

	MO-6704S-0A4-150	EL ~ L	1	3	-	1.6	2	4	1:0.7 ~ 1:2	5	DC x 1 #8	7,000	
	MO-6704S-0A5-150		1	3	-	1.6	1	4	1:0.7 ~ 1:2	5	DC x 1 #8	7,000	

■ 2-needle overlock

● For runstitching in general fabric

	MO-6714S-BD4-307	L ~ M	2	4	2.0	3.2	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6714S-BE4-307		2	4	2.0	4.0	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6714S-BD6-307		2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6714S-BE6-307		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6714S-BE6-20H		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	Upper looper extra high throw type
	MO-6714S-BE4-40H	M ~ H	2	4	2.0	4.0	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6714S-BE6-40H		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6712S-CE4-40H		2	4	2.4	4.0	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	
	MO-6712S-DF6-507		2	4	3.2	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #14	7,000	For imitation safety-stitching
	MO-6712S-DF6-50F	2	4	3.2	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #14	7,000		

● For gathering S162: Swing-type gathering device (manual-lever operated)

	MO-6714S-BE6-327/ S162	L ~ M	2	4	2.0	4.0	3	3.2	1:0.9 ~ 1:2.6	6	DC x 27 #11	7,000	
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● For tape attaching G02, G39: Tape attaching presser foot Q141: Tape guide

	MO-6714S-BE6-44H/ 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-6714S-BE7-44H/ G02/Q141		2	4	2.0	4.0	4	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,000	

■ Safety stitching

● For runstitching in general fabric

	MO-6716S-DD6-300	L ~ M	2	5	3.2	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-DD6-3F0		2	5	3.2	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	For soft-chains
	MO-6716S-DE4-300		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-DE6-300		2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-FF6-300		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-BE4-40H	M ~ H	2	5	2.0	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	Upper looper extra high throw type
	MO-6716S-DE4-40H		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-DE6-40H		2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-FF6-40H		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,000	
	MO-6716S-DD6-500		2	5	3.2	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	7,000	
	MO-6716S-FF6-500		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	7,000	
	MO-6716S-FF6-50H		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #16	7,000	Upper looper extra high throw type
	MO-6716S-FH6-50H		2	5	4.8	6.4	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #16	7,000	
	MO-6716S-FF6-60H	H	2	5	4.8	4.8	3	4.5	1:0.9 ~ 1:1.7	5	DC x 27 #21	7,000	For jeans Upper looper extra high throw type
	MO-6716S-FH6-60H		2	5	4.8	6.4	3	4.5	1:0.9 ~ 1:1.7	5	DC x 27 #21	7,000	

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

	MO-6716S-FF6-42H/ S159	M ~ H	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-6716S-DE4-42H/ S161		2	5	3.2	4.0	2	3.2	1:0.9 ~ 1:2.6	6	DC x 27 #11	7,000	

● **For rolling-in tape** N077: Clean finish top and bottom

	MO-6745S-ED4-360/ N077	L ~ M	2	4	4.0	3.2	2	4	1:0.7 ~ 1:2	5	DC x 27 #14	7,000	2-needle type for double-chainstitch on pocket bags
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■ **3-needle safety stitching**

	MO-6743S-1D6-40H	M ~ H	3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	Upper looper extra high throw type
	MO-6743S-2D6-40H		3	6	3.2 +2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,000	

**WHEN YOU PLACE ORDERS**

Stitch type	U.S.A	Code
1-needle overlock	504	04
1-needle overlock for blind hemming	505	05
2-needle imitation safety stitch	512	12
2-needle overlock	514	14
2-needle safety stitch	516	16
3-needle safety stitch		43
2-needle double chain stitch		45

Type	Code
Standard	S

Device and attachment	Code
Tape attaching presser foot / Tape guide	G02/Q141
Tape attaching presser foot (for sewing sharp curves)/ Tape guide	G39/Q141
Blind stitch hemming attachment	L121
Swing-type gathering device (interlocked with pedal / for safety stitch machine)	S159
Swing-type gathering device (manual-lever operated / for safety stitch machine)	S161
Swing-type gathering device (manual-lever operated / for overlock machine)	S162
Clean finish top and bottom	N077

MO67   S       /

Needle gauge (mm)	Overedging width (mm)	Feed dog	Code
	1.6	2-row	0A4
	1.6	1-row	0A5
	3.2	2-row	0D4
	3.2	3-row	0D6
	4.0	2-row	0E4
	4.0	3-row	0E6
	4.8	2-row	0F4
	4.8	3-row	0F6
2.0	3.2	2-row	BD4
2.0	3.2	3-row	BD6
2.0	4.0	2-row	BE4
2.0	4.0	3-row	BE6
2.0	4.0	4-row	BE7
2.4	4.0	2-row	CE4
3.2	3.2	3-row	DD6
3.2	4.0	2-row	DE4
3.2	4.0	3-row	DE6
3.2	4.8	3-row	DF6
4.0	3.2	2-row	ED4
4.8	4.8	3-row	FF6
4.8	6.4	3-row	FH6
4.8+2.0	3.2	3-row	1D6
3.8+2.0	3.2	3-row	2D6

Material		Application	Special machine classification	Code
Extra light- to light-weight	Light-weight materials such as men's shirts	Rolled hemming	Standard	150
Light- to medium-weight	Specific to knits	Runstitching	Upper looper extra high throw	20H
		Blind hemming	Standard	210
Light- to medium-weight	For general fabrics	Runstitching	Standard	300
		Runstitching	Upper looper high throw	307
		Gathering	Upper looper high throw	327
		Rolling-in tape	Standard	360
		Soft-chain	Standard	3F0
		Soft-chain	Throat plate and feed dog both provided with a lip	3F6
Medium- to heavy-weight	Specific to knits such as sweaters	Runstitching	Upper looper extra high throw	40H
		Blind hemming	Upper looper extra high throw	41H
		Gathering	Upper looper extra high throw	42H
		Tape attaching	Upper looper extra high throw	44H
		Soft-chain	Upper looper extra high throw	4FH
	Medium- to heavy-weight materials such as denim	Runstitching	Standard	500
		Runstitching	Upper looper high throw	507
		Runstitching	Swim suits	50F
		Runstitching	Upper looper extra high throw	50H
		For heavy-weight materials	Runstitching	Upper looper extra high throw

# DEVICES AND ATTACHMENTS

Model	Part No.	Description		
<b>● Chain-off thread trimming device</b>				
T039	MAT-039001A0	One-touch type tape cutter and chain-off thread trimming device (electromagnetic type)		
	MAT-039002A0			
T040	MAT-040001A0	Automatic tape cutter + 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		

<b>● Blower-type chain-off thread suction device</b>		
MC-7A		Blower-type chain-off thread suction device + cloth chips

<b>● Pneumatic chain-off thread suction device</b>		
MC-4		Specific to chain-off thread, pedal-operated
MC-5		Specific to chain-off thread
MC-8		Pneumatic chain-off thread + cloth chips
MC-9		Function of MC-8 + auto-lifter
MC-24		Pneumatic chain-off thread + cloth chips

\* The aforementioned devices are not equipped with 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

<b>● Auto-lifter</b>		
AK25	GAK-250000A0	Electromagnetic type
AK32	GAK-320000A0	Pneumatic type (knee-operated)
AK49	GAK-490000A0	Pneumatic type (pedal-operated)
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	Auto-lifter
T039	MC-7A	AK65 (Electronic-stop motor or AC servomotor)
		AK101 (JUKI servomotor)
	MC-8	AK65 (Electronic-stop motor or AC servomotor)
	MC-9	AK101 (JUKI servomotor) (MC-9 is equipped with auto-lifter.)

T040	MC-7A	AK32 (any motor will do)
		AK65 (Electronic-stop motor or AC servomotor)
	MC-5	AK32 (any motor will do)
	MC-24	AK32 (any motor will do)

T041 or T042	MC-7A	AK49 (Motors other than JUKI servomotors are applicable.)
		AK65 (Electronic-stop motor or AC servomotor)
		AK101 (JUKI servomotor)
	*	AK52 (any motor will do) * AK52 is equipped with chain-off thread suction device.
	MC-4	AK65 (Electronic-stop motor or AC servomotor)
	MC-8	AK65 (Electronic-stop motor or AC servomotor)
	MC-9	AK101 (JUKI servomotor) (MC-9 is equipped with auto-lifter.)

Model	Part No.	Description	Feature
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<b>● Gathering device</b>			
S159	MAS-159000A0	Swing-type gathering device (interlocked with pedal / for safety stitch machine)	The attachment opens with the presser foot pedal. This facilitates material setting on the machine. Furthermore, 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 / for overlock machine)	
S161	MAS-161000A0	Swing-type gathering device (manual-lever operated / for safety stitch machine)	The attachment is used to perform two different processes, joining fabric process and gathering process, at a time.
S162	MAS-162000A0	Swing-type gathering device (manual-lever operated / for overlock machine)	The attachment can be opened/closed by using the lever (manually operated). The differential-feed ratio is controlled with the knee lever.

<b>● Blind hemming device</b>				
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	For flat upper knife	For 110, 115, 220, 240V
	MAL-122002A0		For 220, 380, 415, 440V	
	MAL-122001AA		For 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.	

<b>● Piping folder</b>			
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 gathering	The attachment makes gathers on the lower fabric while making decorative piping.

<b>● Guide, Ruler</b>			
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.

<b>● Feller, Binder</b>			
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 runs stitches a pocket bag and binding its periphery with tape simultaneously.

<b>● Miscellaneous</b>				
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.	
	131-62557	Needle cooler unit asm.	For overlock machine	Needle cooler By silicon oil lubricating unit for the needle thread.
	SS-4091015SP	Screw		
	WP-0371026SD	Washer		
	SS-7110840SP	Screw		
	131-63159	Needle cooler unit asm.	For safety stitich machine	
	SS-4091015SP	Screw		
	WP-0371026SD	Washer		
	131-63902	Presser		
131-63456	Silicon tank asm.	Needle thread heat remover By silicon oil lubricating unit for the needle thread.		
131-63803	Felt			
TA-0950806R0	Rubber plug			
	SM-4040855SP	Screw		



# MO-6900S Series

● Since the machine comes with a needle-thread take-up mechanism as well as a looper thread take-up mechanism, to offer upgraded responsiveness from light- to heavy-weight materials with a lower applied tension, it achieves well-tensed soft-feeling seams that flexibly correspond to the elasticity of the material at the maximum sewing speed of 8,000 to 8,500rpm. To offer improved sewing capabilities as well as to prevent stitching misshapes, the machine is equipped as standard with the needle thread heat remover and needle cooler.



MO-6914S

## SPECIFICATIONS

Model name	MO-6904S	MO-6914S	MO-6916S
Stitch type	1-needle overlock	2-needle overlock	Safety stitching
Stitch style in the U.S.A.	504	514	516
Max. sewing speed	8,500rpm	8,000rpm	8,000rpm
Stitch length	0.8 ~ 4mm		1.5 ~ 4mm
Needle gauge (mm)	-	2.0, 2.4, 3.2	2.0, 3.2, 4.0, 4.8, 4.8+2.0
Overedging width (mm)	1.6, 3.2, 4.0, 4.8	3.2, 4.0, 4.8	3.2, 4.0, 4.8, 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 bar bushing	Upper/lower bushing method		
Needle	DC × 27(excluding some subclass model)		
Max. lift of the presser foot	7mm(excluding some subclass model)		
Max. presser foot pressure	63.7N (6.5kg)		
Stitch 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 Machine Oil 18 (equivalent to ISO VG18)		
Needle cooler	Provided as standard (excluding MO-6945S)		
Needle thread heat remover	Provided as standard (excluding MO-6945S)		
Micro-lifter	Provided as standard		

## SUBCLASS MACHINE LIST

Seams	Model No.	Materials	Number of needles	Number of threads	Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	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

	MO-6904S-0D4-300	L ~ M	1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,500	For soft-chains
	MO-6904S-0E4-300		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,500	
	MO-6904S-0F4-300		1	3	-	4.8	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-6904S-0D6-300		1	3	-	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,500	
	MO-6904S-0E6-300		1	3	-	4.0	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,500	
	MO-6904S-0F6-300		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,000	
	MO-6904S-0D4-3F0		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,500	
	MO-6904S-0E4-3F0		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,500	
	MO-6904S-0D6-3F0		1	3	-	3.2	3	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,500	
	MO-6904S-0D4-3F6		1	3	-	3.2	2	4	1:0.7 ~ 1:2	7	DC × 27 #11	8,500	

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	MO-6904S-0E4-4FH	M ~ H	1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,500	For soft-chains Upper looper extra high throw type
	MO-6904S-0E4-40H		1	3	-	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,500	Upper looper extra high throw type
	MO-6904S-0E6-40H		1	3	-	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,500	Upper looper extra high throw type
	MO-6904S-0F6-500		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #14	8,000	
	MO-6904S-0F6-50H		1	3	-	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #14	7,500	Upper looper extra high throw type

● For blind hemming L121: Blind stitch hemming attachment

	MO-6905S-0D4-210/ L121	M ~ H	1	3	-	3.2	2	4	1:0.7 ~ 1:2	5.5	DC x 27 #9	7,500	Upper looper extra high throw type
	MO-6905S-0E4-41H/ L121		1	3	-	4.0	2	4	1:0.7 ~ 1:2	5.5	DC x 27 #9	7,500	

● For rolled hemming (folded downward)

	MO-6904S-0A4-150	EL ~ L	1	3	-	1.6	2	4	1:0.7 ~ 1:2	5	DC x 1 #8	8,500	
	MO-6904S-0A5-150		1	3	-	1.6	1	4	1:0.7 ~ 1:2	5	DC x 1 #8	8,500	

■ 2-needle overlock

● For runstitching in general fabric

	MO-6914S-BD4-307	L ~ M	2	4	2.0	3.2	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	8,000	
	MO-6914S-BE4-307		2	4	2.0	4.0	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	8,000	
	MO-6914S-BD6-307		2	4	2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	8,000	
	MO-6914S-BE6-307		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	8,000	
	MO-6914S-BE6-20H		2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,500	Upper looper extra high throw type
	MO-6914S-BE4-40H	2	4	2.0	4.0	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,500		
	MO-6914S-BE6-40H	2	4	2.0	4.0	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,500		
	MO-6912S-CE4-40H	2	4	2.4	4.0	2	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,500		
	MO-6912S-DF6-507	2	4	3.2	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #14	7,500	For imitation safety-stitching	
	MO-6912S-DF6-50F	2	4	3.2	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #14	7,500		

● For gathering S162: Swing-type gathering device (manual-lever operated)

	MO-6914S-BE6-327/ S162	L ~ M	2	4	2.0	4.0	3	3.2	1:0.9 ~ 1:2.6	6	DC x 27 #11	7,000	
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● For tape attaching G02, G39: Tape attaching presser foot Q141: Tape guide

	MO-6914S-BE6-44H/ 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-6914S-BE7-44H/ G02/Q141		2	4	2.0	4.0	4	3.2	1:0.9 ~ 1:2.6	7	DC x 27 #14	7,000	

■ Safety stitching

● For runstitching in general fabric

	MO-6916S-DD6-300	L ~ M	2	5	3.2	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	
	MO-6916S-DD6-3F0		2	5	3.2	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	For soft-chains
	MO-6916S-DE4-300		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	
	MO-6916S-DE6-300		2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	
	MO-6916S-FF6-300		2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	8,000	
	MO-6916S-BE4-40H	2	5	2.0	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,500	Upper looper extra high throw type	
	MO-6916S-DE4-40H	2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,500		
	MO-6916S-DE6-40H	2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,500		
	MO-6916S-FF6-40H	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #11	7,500		
	MO-6916S-DD6-500	2	5	3.2	3.2	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	8,000		
	MO-6916S-FF6-500	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	7	DC x 27 #16	8,000		
	MO-6916S-DF6-50H	2	5	3.2	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #16	7,500	Upper looper extra high throw type	
	MO-6916S-FF6-50H	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #16	7,500		
	MO-6916S-FH6-50H	2	5	4.8	6.4	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #16	7,500		
	MO-6916S-FF6-60H	2	5	4.8	4.8	3	4.5	1:0.9 ~ 1:1.7	5	DC x 27 #21	7,000	For jeans	
	MO-6916S-FH6-60H	2	5	4.8	6.4	3	4.5	1:0.9 ~ 1:1.7	5	DC x 27 #21	7,000	Upper looper extra high throw type	

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

	MO-6916S-FF6-42H/S159	M ~ H	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-6916S-DE4-42H/S161		2	5	3.2	4.0	2	3.2	1:0.9 ~ 1:2.6	6	DC x 27 #11	7,000	

● For rolling-in tape N077: Clean finish top and bottom

	MO-6945S-ED4-360/N077	L ~ M	2	4	4.0	3.2	2	4	1:0.7 ~ 1:2	5	DC x 27 #14	7,000	2-needle type for double-chainstitch on pocket bags
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■ 3-needle safety stitching

	MO-6943S-1D6-40H	M ~ H	3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,500	Upper looper extra high throw type
	MO-6943S-1D6-50H		3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	6.5	DC x 27 #11	7,500	

## WHEN YOU PLACE ORDERS

Stitch type	U.S.A	Code
1-needle overlock	504	04
1-needle overlock for blind hemming	505	05
2-needle imitation safety stitch	512	12
2-needle overlock	514	14
2-needle safety stitch	516	16
3-needle safety stitch		43
2-needle double chain stitch		45

Type	Code
Standard	S

Device and attachment	Code
Tape attaching presser foot / Tape guide	G02/Q141
Tape attaching presser foot (for sewing sharp curves)/ Tape guide	G39/Q141
Blind stitch hemming attachment	L121
Swing-type gathering device (interlocked with pedal / for safety stitch machine)	S159
Swing-type gathering device (manual-lever operated / for safety stitch machine)	S161
Swing-type gathering device (manual-lever operated / for overlock machine)	S162
Clean finish top and bottom	N077

MO69    S      /

Needle gauge (mm)	Overedging width (mm)	Feed dog	Code
	1.6	2-row	0A4
	1.6	1-row	0A5
	3.2	2-row	0D4
	3.2	3-row	0D6
	4.0	2-row	0E4
	4.0	3-row	0E6
	4.8	2-row	0F4
	4.8	3-row	0F6
2.0	3.2	2-row	BD4
2.0	3.2	3-row	BD6
2.0	4.0	2-row	BE4
2.0	4.0	3-row	BE6
2.0	4.0	4-row	BE7
2.4	4.0	2-row	CE4
3.2	3.2	3-row	DD6
3.2	4.0	2-row	DE4
3.2	4.0	3-row	DE6
3.2	4.8	3-row	DF6
4.0	3.2	2-row	ED4
4.8	4.8	3-row	FF6
4.8	6.4	3-row	FH6
4.8+2.0	3.2	3-row	1D6

Material		Application	Special machine classification	Code	
Extra light- to light-weight	Light-weight materials such as men's shirts	Rolled hemming	Standard	150	
Light- to medium-weight	Specific to knits	Runstitching	Upper looper extra high throw	20H	
Light- to medium-weight	For general fabrics	Runstitching	Standard	300	
		Runstitching	Upper looper high throw	307	
		Gathering	Upper looper high throw	327	
		Rolling-in tape	Standard	360	
		Soft-chain	Standard	3F0	
		Soft-chain	Throat plate and feed dog both provided with a lip	3F6	
Medium- to heavy-weight	Specific to knits such as sweaters	Runstitching	Upper looper extra high throw	40H	
		Blind hemming	Upper looper extra high throw	41H	
		Gathering	Upper looper extra high throw	42H	
		Tape attaching	Upper looper extra high throw	44H	
		Soft-chain	Upper looper extra high throw	4FH	
		Runstitching	Standard	500	
	Medium- to heavy-weight materials such as denim	Runstitching	Upper looper high throw	507	
		Runstitching	Swim suits	50F	
		Runstitching	Upper looper extra high throw	50H	
		Runstitching	Upper looper extra high throw	60H	
		For heavy-weight materials	Runstitching	Upper looper extra high throw	60H

● AC SERVOMOTOR (SC-380)/Machine head

MO69   S      /AK101/SY35

Pneumatic auto-lifter	Code
Standard type	AK101
For the machine provided with T040	AK32

\* Only the pneumatic auto-lifter is prepared for the MO-6900S series.

Built-in synchronizer		Code
Set speed *		
MO-6904S	8,000rpm	SY35
MO-6914S, 6916S	7,500rpm	

\* Select a sewing speed that is lower than the machine head's maximum sewing speed by 500rpm.

# DEVICES AND ATTACHMENTS

Model	Part No.	Description
<b>● Chain-off thread trimming device</b>		
T039	MAT-039001A0	One-touch type tape cutter and chain-off thread trimming device (electromagnetic type)
	MAT-039002A0	
T040	MAT-040001A0	Automatic tape cutter + chain-off thread trimming device (number-off-stitch control and electromagnetic type)
	MAT-040002A0	
	MAT-040001AA	For semi-sunken type
	MAT-040002AA	For fully-sunken type
T041	MAT-041000A0A	Pneumatic flat cutter
T042	MAT-042000A0	Pneumatic side cutter

<b>● Blower-type chain-off thread suction device</b>		
MC-7A		Blower-type chain-off thread suction device + cloth chips

<b>● Pneumatic chain-off thread suction device</b>		
MC-4		Specific to chain-off thread, pedal-operated
MC-5		Specific to chain-off thread
MC-8		Pneumatic chain-off thread + cloth chips
MC-9		Function of MC-8 + auto-lifter
MC-24		Pneumatic chain-off thread + cloth chips

\* The aforementioned devices are not equipped with 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

<b>● Auto-lifter</b>		
AK25	GAK-250000A0	Electromagnetic type
AK32	GAK-320000A0	Pneumatic type (knee-operated)
AK49	GAK-490000A0	Pneumatic type (pedal-operated)
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	Auto-lifter	
T039	+	MC-7A	AK65 (Electronic-stop motor or AC servomotor) AK101 (JUKI servomotor)
		MC-8	AK65 (Electronic-stop motor or AC servomotor) AK101 (JUKI servomotor)
			MC-9

T040	+	MC-7A	AK32 (any motor will do) AK65 (Electronic-stop motor or AC servomotor)
		MC-5	AK32 (any motor will do)
		MC-24	AK32 (any motor will do)

T041 or T042	+	MC-7A	AK49 (Motors other than JUKI servomotors are applicable.) AK65 (Electronic-stop motor or AC servomotor) AK101 (JUKI servomotor)	
			*	AK52 (any motor will do) * AK52 is equipped with chain-off thread suction device.
			MC-4	AK65 (Electronic-stop motor or AC servomotor)
		MC-8	AK65 (Electronic-stop motor or AC servomotor) AK101 (JUKI servomotor)	
			MC-9	(MC-9 is equipped with auto-lifter.)

Model	Part No.	Description	Feature
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<b>● Gathering device</b>			
S159	MAS-159000A0	Swing-type gathering device (interlocked with pedal / for safety stitch machine)	The attachment opens with the presser foot pedal. This facilitates material setting on the machine. Furthermore, 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 / for overlock machine)	
S161	MAS-161000A0	Swing-type gathering device (manual-lever operated / for 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 (manual-lever operated / for overlock machine)	

<b>● Blind hemming device</b>				
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.	
	MAL-122002A0			For flat upper knife
	MAL-122001AA			For square upper knife
	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.	

<b>● Piping folder</b>			
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 gathering	The attachment makes gathers on the lower fabric while making decorative piping.

<b>● Guide, Ruler</b>			
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.

<b>● Feller, Binder</b>			
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.

<b>● Miscellaneous</b>			
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.

# MO-6900R Series

- The MO-6900R Series comes with a newly-developed feed mechanism that moves the top and bottom feeds separately. With the combination of the feed's increased differential feed ratio and improved feeding capacity, the machine is able not only to prevent uneven material feed, but also to easily finish difficult processes, such as sewing different types of materials together, ruffling and piping.
- The locus of the top feed dog increases the surfaces of the top feed dog that horizontally synchronize with the bottom feed dog, to reliably feed the materials without damaging them. The feed mechanism smoothly feeds light-weight materials softly or feeds heavy-weight materials with an increased cloth-biting force.
- The fulcrum of the top feed locus can be set at the best-suited position according to the material or process.



MO-6914R

## SPECIFICATIONS

Model name	MO-6904R	MO-6914R	MO-6916R
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 (Longitudinal stroke of top feed dog is 6mm or less) 6,000rpm (Longitudinal stroke of top feed dog is 6 ~ 8.5mm)		
Stitch length	0.8 ~ 4mm		1.5 ~ 4mm
Needle gauge (mm)	-	2.0	3.2, 4.8, 4.8+2.0
Overedging width (mm)	3.2, 4.0, 4.8, 6.4	3.2, 4.0	3.2, 4.0, 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 mechanism	Needle bar method and upper/lower bushing		
Needle	DC x 27 (excluding some subclass model)		
Vertical stroke of top feed dog	3.5 ~ 8.5mm (It differs with the machine's specifications.)		
Longitudinal stroke of top feed dog	1 ~ 7.5mm (It differs with the machine's specifications.)		
Max. lift of the presser foot	7mm (excluding some subclass model)		
Max. presser foot pressure	63.7N (6.5kg)		
Stitch adjusting method	By push-button		
Bottom differential feed adjusting method	By lever (with micro-adjustment)		
Top differential feed adjusting method	By lever (with micro-adjustment)		
Weight of the machine head	29kg		
Lubrication	Automatic		
Lubricating oil	JUKI Machine Oil 18 (equivalent to ISO VG18)		
Needle cooler	Provided as standard		
Needle thread heat remover	Provided as standard		
Micro-lifter	Provided as standard		

## SUBCLASS MACHINE LIST

Seams	Model No.	Materials	Number of needles	Number of threads	Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	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 in general fabric

	MO-6904R-0D4-3F6	L ~ M	1	3	-	3.2	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #11	7,000	For soft-chains
	MO-6904R-0E4-300		1	3	-	4.0	2	4	1:0.7 ~ 1:2	1 ~ 7.5	7	DC x 27 #11	7,000	
	MO-6904R-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	
	MO-6904R-0H4-50M		1	3	-	6.4	2	4	1:0.7 ~ 1:2	1 ~ 7.5	4.5	DC x 27 #16	7,000	For zipper attaching

															Remarks
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■ 2-needle overlock  
● For runstitching in general fabric

	MO-6914R-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	
	MO-6914R-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	
	MO-6914R-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	
	MO-6914R-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
	MO-6914R-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	

■ Safety stitching  
● For runstitching in general fabric

	MO-6916R-DD6-300	L ~ M	2	5	3.2	3.2	3	4	1:0.7 ~ 1:2	1 ~ 7.5	5.5	DC x 27 #11	7,000	
	MO-6916R-DE4-300		2	5	3.2	4.0	2	4	1:0.7 ~ 1:2	1 ~ 7.5	5.5	DC x 27 #11	7,000	
	MO-6916R-DE6-300		2	5	3.2	4.0	3	4	1:0.7 ~ 1:2	1 ~ 7.5	5.5	DC x 27 #11	7,000	
	MO-6916R-FF6-300	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	1 ~ 7.5	5.5	DC x 27 #11	7,000		
	MO-6916R-FF6-50H	M ~ H	2	5	4.8	4.8	3	4	1:0.7 ~ 1:2	1 ~ 7	5	DC x 27 #16	7,000	Upper looper extra high throw type
	MO-6916R-FH6-60H		2	5	4.8	6.4	3	4.5	1:0.9 ~ 1:1.7	1 ~ 7	5	DC x 27 #21	7,000	For jeans Upper looper extra high throw type

■ 3-needle safety stitching  
● Multi-purpose runstitching

	MO-6943R-1D6-307	L ~ M	3	6	4.8 +2.0	3.2	3	4	1:0.7 ~ 1:2	1 ~ 7.5	6.5	DC x 27 #11	7,000	
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## WHEN YOU PLACE ORDERS

Stitch type	U.S.A	Code
1-needle overlock	504	04
2-needle overlock	514	14
2-needle safety stitch	516	16
3-needle safety stitch		43

Type	Code
Variable top-feed	R

MO69   R

Needle gauge (mm)	Overedging width (mm)	Feed dog	Code
	3.2	2-row	0D4
	4.0	2-row	0E4
	4.8	3-row	0F6
	6.4	2-row	0H4
2.0	3.2	2-row	BD4
2.0	3.2	3-row	BD6
2.0	4.0	3-row	BE6
3.2	3.2	3-row	DD6
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	1D6

Material		Application	Special machine classification	Code
Light- to medium-weight	For general fabrics	Runstitching	Standard	300
		Runstitching	Upper looper high throw	307
		Soft-chain	Throat plate and feed dog both provided with a lip	3F6
Medium- to heavy-weight	Specific to knits such as sweaters	Runstitching	Upper looper extra high throw	40H
		Runstitching	Standard	500
	Medium- to heavy-weight materials such as denim	Runstitching	Upper looper extra high throw	50H
		Runstitching	For zipper attaching	50M
	For heavy-weight materials	Runstitching	Upper looper extra high throw	60H

● AC SERVOMOTOR (SC-380)/Machine head

MO69   R         /AK101/SY35

Pneumatic auto-lifter	Code
Standard type	AK101
For the machine provided with T040	AK32

Built-in synchronizer	
Set speed*	Code
6,500rpm	SY35

\* Only the pneumatic auto-lifter is prepared for the MO-6900R series.

\* Select a sewing speed that is lower than the machine head's maximum sewing speed by 500rpm.

# DEVICES AND ATTACHMENTS

Model	Part No.	Description
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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 + chain-off thread trimming device	For semi-sunken type
	MAT-040006A0		For 220, 380, 415, 440V
	MAT-040005AA	(number-off-stitch control and electro-magnetic type)	For fully-sunken type
	MAT-040006AA		For 110, 115, 220, 240V
T041	MAT-041000AB	Pneumatic flat cutter	For 220, 380, 415, 440V
T045	MAT-045000A0	Pneumatic side cutter	

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

MC-7A		Blower-type chain-off thread suction device + cloth chips
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### ● Pneumatic chain-off thread suction device

MC-4		Specific to chain-off thread, pedal-operated
MC-5		Specific to chain-off thread
MC-8		Pneumatic chain-off thread + cloth chips
MC-9		Function of MC-8 + auto-lifter
MC-24		Pneumatic chain-off thread + cloth chips

\* The aforementioned devices are not equipped with 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 x 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 (knee-operated)
AK49	GAK-490000A0	Pneumatic type (pedal-operated)
AK52	GAK-520000A0	Pneumatic type (with chain-off thread suction device)
AK65	GAK-650000A0	Electromagnetic type
AK101	GAK-A01000A0	Pneumatic type (for servomotor)

Model	Part No.	Description	Feature
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### ● Gathering device

S167	MAS-167000A0	Swing-type upper-cloth gathering device (interlocked with pedal)	The attachment opens with the presser foot pedal. This facilitates material setting on the machine. Furthermore, 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.
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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	For flat upper knife
	MAL-122002A0		For 110, 115, 220, 240V
	MAL-122001AA		For square upper knife
	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 gathering	The attachment makes gathers on the lower fabric while making decorative piping.
M222	MAM-2220M0A0	Piping folder upper-cloth gathering (finished width 12mm, tape width 26mm)	This folder is to be used together with upper-cloth gathering device S167. Gimp size that can be used is 2 to 2.5mm.
	MAM-2220J0A0	Piping folder upper-cloth gathering (finished width 9mm, tape width 20mm)	
M224	MAM-2240N0A0	Ready-made piping folder for upper-cloth gathering	This folder is to be used together with upper-cloth gathering device S167. Tape, of which width is 8 to 18mm, can be used.

### ● Guide, Ruler

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.

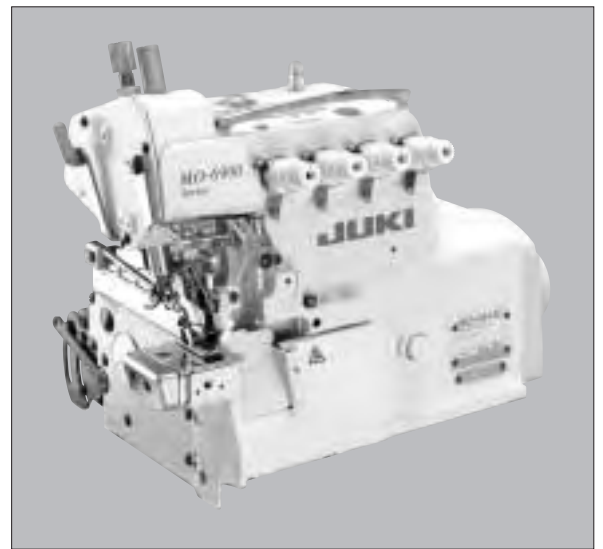
### [Reference]

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	Auto-lifter
T039	MC-7A	AK65 (Electronic-stop motor or AC servomotor)
		AK101 (JUKI servomotor)
	MC-8	AK65 (Electronic-stop motor or AC servomotor)
AK101 (JUKI servomotor)		
	MC-9	(MC-9 is equipped with auto-lifter.)
T040	MC-7A	AK32 (any motor will do)
		AK65 (Electronic-stop motor or AC servomotor)
	MC-5	AK32 (any motor will do)
MC-24		AK32 (any motor will do)
T041 or T045	MC-7A	AK65 (Electronic-stop motor or AC servomotor)
		AK101 (JUKI servomotor)
	*	AK52 (any motor will do) * AK52 is equipped with chain-off thread suction device.
	MC-8	AK65 (Electronic-stop motor or AC servomotor)
		AK101 (JUKI servomotor)
MC-9	(MC-9 is equipped with auto-lifter.)	

# MO-6900C Series

- The cylinder-bed is bestsuited to the runstitching and blind hemming of tubular materials.
- Since the machine comes with a needle-thread take-up mechanism as well as a looper thread take-up mechanism, to enable sewing with a lower tension applied to the material, it achieves soft-feeling high-quality seams.
- Since the machine is provided as standard with the bottom feed dog inclination-adjusting mechanism and the external differential feed-increasing mechanism, it can be easily adjusted to ideally match the material being sewn. In addition, the machine is provided as standard with a micro lifter feature that offers improved responsiveness to materials, and provides the operator with upgraded operability. The stitch length can be easily adjusted with the push-button mounted on the front surface of the sewing machine.



MO-6914C

## SPECIFICATIONS

Model name	MO-6904C	MO-6914C
Stitch type	1-needle overlock	2-needle overlock
Stitch style in the U.S.A.	504	514
Max. sewing speed	8,000rpm	
Stitch length	0.8 ~ 3.5mm	
Needle gauge (mm)	-	2.0
Overedging width (mm)	3.2, 4.0, 4.8	3.2, 4.0
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 mechanism	Needle bar method and upper/lower bushing	
Needle	DC x 27	
Max. lift of the presser foot	7mm (excluding some subclass model)	
Max. presser foot pressure	63.7N (6.5kg)	
Stitch adjusting method	By push-button	
Differential-feed adjusting method	By lever	
Weight of the machine head	24kg	
Lubrication	Automatic	
Lubricating oil	JUKI Machine Oil 18 (equivalent to ISO VG18)	
Needle cooler	Provided as standard	
Needle thread heat remover	Provided as standard	
Micro-lifter	Provided as standard	

## SUBCLASS MACHINE LIST

Seams	Model No.	Materials	Number of needles	Number of threads	Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	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

	MO-6904C-0D6-307	L ~ M	1	3	-	3.2	3	3.5	1:0.8 ~ 1:2.3	7	DC x 27 #11	8,000	Upper looper extra high throw type
	MO-6904C-0E6-307		1	3	-	4.0	3	3.5	1:0.8 ~ 1:2.3	7	DC x 27 #11	8,000	
	MO-6904C-0F4-307		1	3	-	4.8	2	3.5	1:0.8 ~ 1:2.3	7	DC x 27 #14	8,000	

### ■ 2-needle overlock

	MO-6914C-BD4-307	L ~ M	2	4	2.0	3.2	2	3.5	1:0.8 ~ 1:2.3	6.5	DC x 27 #11	8,000	Upper looper extra high throw type
	MO-6914C-BD6-307		2	4	2.0	3.2	3	3.5	1:0.8 ~ 1:2.3	6.5	DC x 27 #11	8,000	
	MO-6914C-BE6-307		2	4	2.0	4.0	3	3.5	1:0.8 ~ 1:2.3	6.5	DC x 27 #11	8,000	



## DEVICES AND ATTACHMENTS

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

T043	MAT-043000A0	Pneumatic side cutter
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### ● Blower-type chain-off thread suction device

MC-7B		Blower-type chain-off thread suction device + cloth chips
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### ● Pneumatic chain-off thread suction device

MC-38		Pneumatic chain-off thread + cloth chips
MC-39		Function of MC-8 + auto-lifter

\* The aforementioned devices are not equipped with 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 (knee-operated)
AK94	GAK-940000A0	Pneumatic type (with chain-off thread suction device)
AK102	GAK-A02000A0	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	Auto-lifter
T043	MC-7B	AK102 (JUKI servomotor)
	*	AK94 (any motor will do) * AK94 is equipped with chain-off thread suction device.
	MC-38	AK102 (JUKI servomotor)
	MC-39	(MC-39 is equipped with auto-lifter.)

Model	Part No.	Description	Feature
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### ● Blind hemming device

L124	MAL-124000A0	Blind stitch hemming attachment	A ruler used for blind hemming in knits	
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.	
	MAL-125002A0			For flat upper knife For 110, 115, 220, 240V
	MAL-125001AA			For square upper knife For 110, 115, 220, 240V
	MAL-125002AA			For square upper knife For 220, 380, 415, 440V

### ● Cloth tensioner

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

### ● Ruler, Miscellaneous

H153	MAH-153000A0	Cloth edge guide ruler	A swing type edge guide.
	122-26155	Cloth plate	Wider material can be sewn by attaching the cloth plate.

## WHEN YOU PLACE ORDERS

Material	Application	Special machine classification	Code
Light- to medium-weight	For general fabrics	Runstitching	Upper looper high throw

MO69   C

Stitch type	U.S.A	Code
1-needle overlock	504	04
2-needle overlock	514	14

Type	Code
Cylinder-bed	C

Needle gauge (mm)	Overedging width (mm)	Feed dog	Code
	3.2	3-row	OD6
	4.0	3-row	OE6
	4.8	2-row	OF4
2.0	3.2	2-row	BD4
2.0	3.2	3-row	BD6
2.0	4.0	3-row	BE6

### ● AC SERVOMOTOR (SC-380)/Machine head

MO69   C         /AK102/SY35

Pneumatic auto-lifter	Code
Standard type	AK102

Built-in synchronizer	Code
Set speed	Code
7,500rpm	SY35

Bottom-feed, Overlock / Safety Stitch Machine  
for Extra heavy-weight materials

## MO-6900G Series

- The machine incorporates a mechanism and parts that are optimum for the sewing of extra heavy-weight materials, such as an extra high-lift type upper looper, tractor foot and coarse type feed dog. It demonstrates an excellent performance ability in the sewing of various kinds of heavy-weight materials such as jeans, raised fabric materials, mats and carpets.
- The machine securely clamps the material at the beginning of sewing as well as smoothly sewing multi-layered parts of the material to facilitate the sewing of extra heavy-weight materials.



MO-6916G

### SPECIFICATIONS

Model name	MO-6904G	MO-6914G	MO-6916G
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	2.5 ~ 5mm	2.5 ~ 4mm	2.5 ~ 5mm
Needle gauge (mm)	-	2.6	4.8
Overedging width (mm)	4.8, 10.0, 18.0	6.4	4.8, 6.4
Differential feed ratio	For gathering 1:1.75 (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 1:1.75 (Max. 1:3.8) For stretching 1:0.6
Needle bar stroke	28.8mm		
Inclination angle of the needle	20°		
Needle bar bushing	Upper/lower bushing method		
Needle	DO × 5 (excluding some subclass model)		
Max. lift of the presser foot	8mm (excluding some subclass model)		
Max. presser foot pressure	63.7N (6.5kg)		
Stitch 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 Machine Oil 18 (equivalent to ISO VG18)		
Needle cooler	Provided as standard (excluding some subclass model)		
Needle thread heat remover	Provided as standard		
Micro-lifter	Provided as standard		

### SUBCLASS MACHINE LIST

Model No.	Materials	Number of needles	Number of threads	Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	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
MO-6903G-0N6-3D1	L ~ M	1	2	-	18.0	3	5	1:0.6 ~ 1:1.75	-	5	DO × 5 #16	5,500	For splicing fabrics
MO-6904G-0F6-700	EH	1	3	-	4.8	3	5	1:0.6 ~ 1:1.75	-	8	DO × 5 #21	6,000	For runstitching extra heavy-weight materials such as denim
MO-6905G-0M6-700		1	3	-	10.0	3	5	1:0.6 ~ 1:1.75	-	7	DC × 1 #24	4,000	For overedging carpets, mats for entrance halls, etc.
MO-6905G-0M6-7E0		1	3	-	10.0	3	5	1:0.6 ~ 1:1.75	-	7	DC × 1 #24	4,000	For overedging car mats
MO-6914G-CH6-700		2	4	2.6	6.4	3	4	1:0.7 ~ 1:2	-	8	DO × 5 #18	6,000	For overedging jersey, etc.
MO-6916G-FF6-700		2	5	4.8	4.8	3	5	1:0.6 ~ 1:1.75	-	8	DO × 5 #21	6,000	For safety stitching extra heavy-weight materials such as denim
MO-6916G-FH6-700		2	5	4.8	6.4	3	5	1:0.6 ~ 1:1.75	-	8	DO × 5 #21	6,000	

**MO69**   **G**

Stitch type	U.S.A	Code
For splicing fabrics	503	03
1-needle overlock	504	04
For overedging carpets	505	05
2-needle overlock	514	14
2-needle safety stitch	516	16

Type	Code
Extra heavy-weight materials	G

Needle gauge (mm)	Overedging width (mm)	Feed dog	Code
-	18.0	3-row	<b>ON6</b>
-	4.8	3-row	<b>OF6</b>
-	10.0	3-row	<b>OM6</b>
2.6	6.4	3-row	<b>CH6</b>
4.8	4.8	3-row	<b>FF6</b>
4.8	6.4	3-row	<b>FH6</b>

Remarks	Code
For splicing fabrics	<b>3D1</b>
For extra heavy-weight materials (jeans, car mats etc.)	<b>700</b>
For car mats	<b>7E0</b>

Variable Top-feed, Overlock / Safety Stitch Machine  
for Extra heavy-weight materials

## MO-6900J Series

- The machine incorporates a mechanism and parts that are optimum for the sewing of extra heavy-weight materials, such as an extra high-lift type upper looper, tractor foot and coarse type feed dog. It demonstrates an excellent performance ability in the sewing of various kinds of heavy-weight materials such as jeans, raised fabric materials, mats and carpets.
- The MO-6900J Series comes with a newly-developed feed mechanism that moves the top and bottom feeds separately. With its improved feeding capacity and stronger cloth-biting force, the feed mechanism prevents uneven material feed when sewing extra heavy-weight materials.



MO-6916J

### SPECIFICATIONS

Model name	MO-6904J	MO-6914J	MO-6916J
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	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 1:1.75 (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 1:1.75 (Max. 1:3.8) For stretching 1:0.6
Needle bar stroke	28.8mm		
Inclination angle of the needle	20°		
Needle bar bushing	Upper/lower bushing method		
Needle	DO × 5 (excluding some subclass model)		
Vertical stroke of top feed dog	8.5mm		
Longitudinal stroke of top feed dog	2.7 ~ 7mm (It differs with the machine's specifications.)		
Max. lift of the presser foot	8mm (excluding some subclass model)		
Max. presser foot pressure	63.7N (6.5kg)		
Stitch adjusting method	By push-button		
Bottom differential feed adjusting method	By lever (with micro-adjustment)		
Top differential feed adjusting method	By lever (with micro-adjustment)		
Weight of the machine head	29kg		
Lubrication	Automatic		
Lubricating oil	JUKI Machine Oil 18 (equivalent to ISO VG18)		
Needle cooler	Provided as standard		
Needle thread heat remover	Provided as standard		
Micro-lifter	Provided as standard		

### SUBCLASS MACHINE LIST

Model No.	Materials	Number of needles	Number of threads	Needle gauge (mm)	Overedging width (mm)	Number of feed dog rows	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
MO-6904J-0F6-700	EH	1	3	-	4.8	3	5	1:0.6 ~ 1:1.75	2.7 ~ 7	8	DO × 5 #21	6,000	For runstitching extra heavy-weight materials such as denim
MO-6914J-CH6-700		2	4	2.6	6.4	3	4	1:0.7 ~ 1:2	2.7 ~ 7	8	DO × 5 #18	6,000	For overedging jersey, etc.
MO-6916J-FF6-700		2	5	4.8	4.8	3	5	1:0.6 ~ 1:1.75	2.7 ~ 7	8	DO × 5 #21	6,000	For safety stitching extra heavy-weight materials such as denim
MO-6916J-FH6-700		2	5	4.8	6.4	3	5	1:0.6 ~ 1:1.75	2.7 ~ 7	8	DO × 5 #21	6,000	For safety stitching extra heavy-weight materials such as denim
MO-6916J-FF6-70Q		2	5	4.8	4.8	3	5	1:0.7 ~ 1:1.75	2.7 ~ 7	8	DC × 27 #16	6,000	For safety stitching bathrobe, etc.

## DEVICES AND ATTACHMENTS

Model	Part No.	Description	MO-6900G	MO-6900J		
<b>● Chain-off thread trimming device</b>						
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 + 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		
T048	MAT-048010A0	Pneumatic flat cutter (for overlock stitch machine)		○	-	
	MAT-048010B0			-	○	
T050	MAT-050010A0	Pneumatic side cutter (for safety stitch machine)		○	-	
	MAT-050010B0			-	○	

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

MC-7A	-	Blower-type chain-off thread suction device + cloth chips	○	○
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### ● Pneumatic chain-off thread suction device

MC-4	-	Specific to chain-off thread, pedal-operated	○	○
MC-5	-	Specific to chain-off thread	○	○
MC-8	-	Pneumatic chain-off thread + cloth chips	○	○
MC-9	-	Function of MC-8 + auto-lifter	○	○
MC-24	-	Pneumatic chain-off thread + cloth chips	○	○

\* The aforementioned devices are not equipped with 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 (knee-operated)	○	○
AK49	GAK-490000A0	Pneumatic type (pedal-operated)	○	○
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	Auto-lifter
T039	MC-7A	AK101 (JUKI servomotor)
	MC-8	AK101 (JUKI servomotor)
	MC-9	- (MC-9 is equipped with auto-lifter.)

T040	MC-7A	AK32 (any motor will do)
	MC-5	AK32 (any motor will do)
	MC-24	AK32 (any motor will do)

T048 or T050	MC-7A	AK101 (JUKI servomotor)
	MC-8	AK101 (JUKI servomotor)
	* -	AK52 (any motor will do) * AK52 is equipped with chain-off thread suction device.
	MC-9	- (MC-9 is equipped with auto-lifter.)

## WHEN YOU PLACE ORDERS

MO69   J

Stitch type	U.S.A	Code
1-needle overlock	504	04
2-needle overlock	514	14
2-needle safety stitch	516	16

Type	Code
Variable top-feed for extra heavy-weight materials	G

Needle gauge (mm)	Overedging width (mm)	Feed dog	Code
-	4.8	3-row	OF6
2.6	6.4	3-row	CH6
4.8	4.8	3-row	FF6
4.8	6.4	3-row	FH6

Remarks	Code
For extra heavy-weight materials (jeans, car mats etc.)	700
For extra heavy-weight materials (bathrobe etc.)	70Q

**Overlock Machine with Semi-automatic Backlatch Device**  
[1-needle]

**MO-6 04S-0E6-300/LB-3**

[2-needle]

**MO-6 14S-BE4-307/LB-4**

**Variable Top-feed Overlock Machine**  
with Semi-automatic Backlatch Device

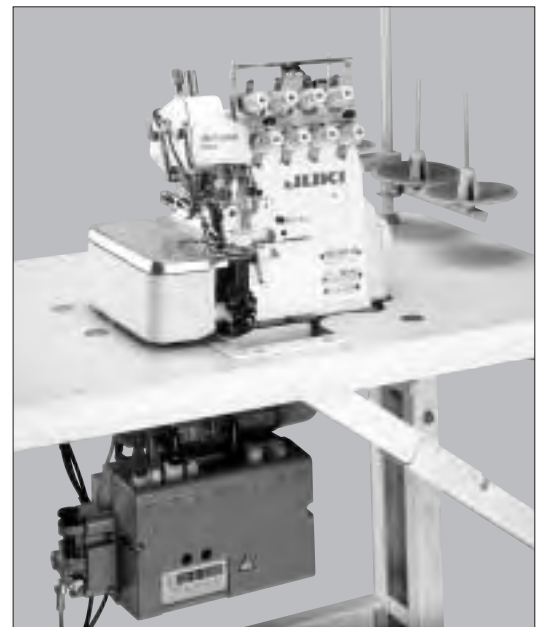
[1-needle]

**MO-6904R-0E6-300/LB-3**

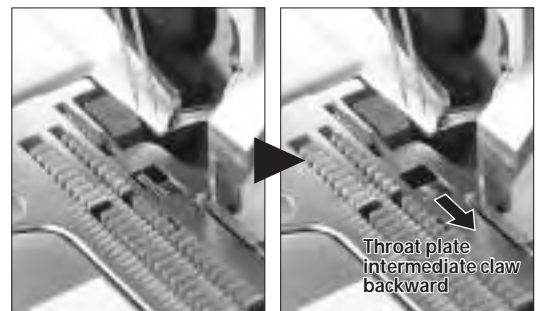
[2-needle]

**MO-6914R-BE4-307/LB-4**

- 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-6914S-BE4-307/LB-4



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

**SPECIFICATIONS**

Auto-lifter	Provided as standard
Compressed air	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) **MO6**  **04S0E6300/LB3**

Model	Code
MO-6704S	7
MO-6904S	9

(2-needle) **MO6**  **14SBE4307/LB4**

Model	Code
MO-6714S	7
MO-6914S	9

● **Variable Top-feed Overlock Machine**

(1-needle) **MO6904R0E6300/LB3**

(2-needle) **MO6914RBE4307/LB4**

● **PSC box**

**SC380**   **00000**

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>

● **Motor for SC**

**M**

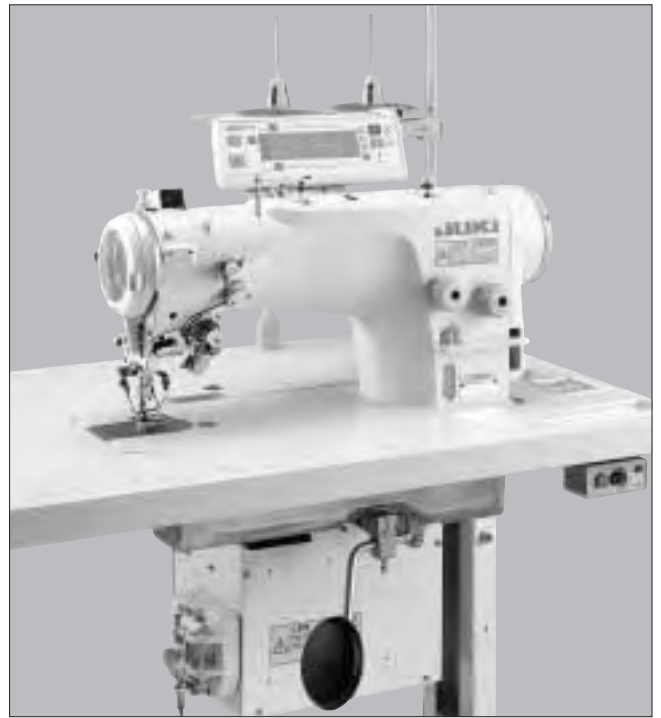
PSC box		Code
For General Export	Single-phase	220 ~ 240V <b>60</b>
	3-phase	200 ~ 240V <b>61</b>
For JUS (LA) *	Single-phase	100 ~ 120V <b>61</b>
	3-phase	200 ~ 240V <b>62</b>
For CE	Single-phase	200 ~ 240V <b>63</b>

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

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

## LZ-2290A Series

- It comes in two different models, one with standard specifications and the other with an anti-material slip capability. For both models, there are two subclass models, i.e., the "minute-quantity lubrication type" and the "dry-head type", which eliminates oil stains on sewing products. You may select the best-suited model from the diversified subclasses according to your applications. The machine is also provided with a newly-developed operation panel, the IP-100. With this operation panel, you can easily establish settings for stitch shapes and stitches, as well as conduct setup changing, thereby achieving further increased availability.
- 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 (IP-100) of the machine body. The zigzag width, needle throw position and number of blind stitches can also be easily adjusted on the operation panel.



LZ-2290A-SS-7-WB

### SPECIFICATIONS

Machine head type		Dry-head type		Minute-quantity lubrication type	
Model name	Without automatic thread trimmer	LZ-2290A-DS	LZ-2290A-DU	LZ-2290A-SS	LZ-2290A-SU
	With automatic thread trimmer	LZ-2290A-DS-7	LZ-2290A-DU-7	LZ-2290A-SS-7	LZ-2290A-SU-7
Type		Standard	Anti-material-slip capability type	Standard	Anti-material-slip capability type
Max. sewing speed		4,000rpm		5,000rpm	4,500rpm
		(for standard zigzag stitching, the zigzag width has to be set to 5mm or less.)		(for standard zigzag stitching, the zigzag width has to be set to 4mm or less.)	
Max. zigzag width		10mm (in increments of 0.1mm)			
Needle throw mechanism		Computer-controlled			
Max. feeding amount		5.0mm	2.5mm	5.0mm	2.5mm
		Stepless fine adjustment			
Lift of the presser foot		By hand: 5.5mm/By knee: 10mm			
Hook		Exclusive no-lubricating hook (plastic hook with special-purpose race surface)		DP hook (with titanium-treated inner hook)	
Thread take-up		Rotary type			
Needle (at the time of delivery)		SCHMETZ438(#75), ORGAN DP × 5(#10)			
Number of patterns for standard stitching		8 types/14 patterns			
Custom pattern memory capacity	Internal memory	Max. 20 patterns			
	Extended memory	Max. 999 patterns			
Max. number of stitches		500 stitches/pattern			
Continuous stitching pattern		Max. 10 patterns, 20 step, 500 stitches/step			
Input function of the main unit		Provided as standard (operation panel)			
Bobbin thread winder		Built-in machine head			
Machine head drive		Compact AC servomotor (direct-drive system)			
Lubrication		No lubrication		Minute-quantity lubrication to needlebar and hook (no oil pan system)	
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/Power consumption		Single-phase 100 ~ 120V, 200 ~ 240V, 3-phase 200 ~ 240V/Power rating 600VA			
Total weight		98kg (for the model without automatic thread trimmer) 100kg (for the model with automatic thread trimmer)			

## WHEN YOU PLACE ORDERS

### ● Without automatic thread trimmer

Machine head type	Code	Type	Code
Standard	S	Standard	S
Dry-head	D	Anti-material-slip type	U

LZ2290A

Push-button-type reverse feed switch	Code
Provided	OB
Not provided	

For LZ-2290A-SU (anti-material-slip capability), select "Not provided."

### ● With automatic thread trimmer

Machine head type	Code	Type	Code
Standard	S	Standard	S
Dry-head	D	Anti-material-slip type	U

LZ2290A

Wiper/Push-button-type reverse feed switch		Device/Attachment	Code
Wiper	Push-button-type reverse feed switch		
Provided	Provided	Auto-lifter (pedal-driven)	AK121
		Not provided	

### ● PSC box/Operation panel for SC

SC915 SIP100A

PSC box				Code
For JUS*	Single-phase	100 ~ 120V	PFL	C
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

Control box	Code
Standard	S

Operation panel	Code
IP-100A	IP100A

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

## SEWING PATTERN

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	1	2	4	6	24				12				2 + α		Max. 500

## OPTIONS

Model	Part No.	Description	Features
-	400-10795	Automatic reverse feed kit	When this device is installed, the LZ-2290A- (without automatic thread trimmer) can perform reverse feed operation. (The mirroring switch for scallop stitching is used as the push-button-type reverse feed switch.)
-	400-03640	Optional switch kit	This handy switch is used to control various functions*. It is most effective when operating the machine in a standing position. (* Needle up/down correction, 1-stitch correction, reverse-stitch correction, auto lifter and thread trimmer, etc.)
AK121	GAK-A21000B0	Auto-lifter (pedal-driven)	-
-	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	
-	B1551-586-000	Presser foot connecting foot	
-	SS-7090910-SP	Screw	
-	225-26560	Hard-point hook	The blade point of this hook prevents abrasion.
-	235-23152	Hook	Hook with non-rotational bobbin
-	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	Pneumatic type	Elastic tape tensing device
S189B	MAS-189000AB	Solenoid type	
			Applies tension to desired portions of the tape fed from tension-free tape puller. The device is started/stopped by operating the knee switch. This increases operator productivity without interrupting the sewing work.



# LIST OF THE MAJOR GAUGES

Max. zigzag width / Max. feed pitch	Throat plate	Feed dog	Presser foot (with finger guard)	Remarks
	<b>10041010</b> 	<b>10047017</b> 	With a recess on the reverse side of the presser foot <b>22580369</b> 	
	<b>10041101</b> 	<b>22580104</b> 	<b>22580260</b> Light-in-weight type 	
	<b>22580005</b> 	<b>22580500</b> 	Light-in-weight type with the front fulcrum <b>22580765</b> 	
	<b>22582100</b> 	<b>22582209</b> 		
	<b>22582704</b> 	<b>22582803</b> 	<b>23503154</b> Light-in-weight type 	
	(at the time of delivery) <b>22582407</b> 	<b>22581508</b> (at the time of delivery) 	<b>23503204</b> Front fulcrum type 	
	<b>22582506</b> 	<b>23558208</b> (at the time of delivery: dry-head type) 	<b>22580864</b> 	<ul style="list-style-type: none"> <li>• Light-in-weight presser foot prevents jumping at the time of high-speed sewing.</li> </ul>
	<b>22548804</b> 	<b>22548804</b> 	<b>22584965</b> Light-in-weight type (at the time of delivery) 	
	<b>22540009</b> 	<b>22540009</b> 	<b>MAB10900B0</b> 	
	<b>22545008</b> 	<b>22545107</b> 	<b>22545362</b> Light-in-weight type 	
	<b>22545511</b> 	<b>22545610</b> 	Light-in-weight type with the front fulcrum <b>22545867</b> 	

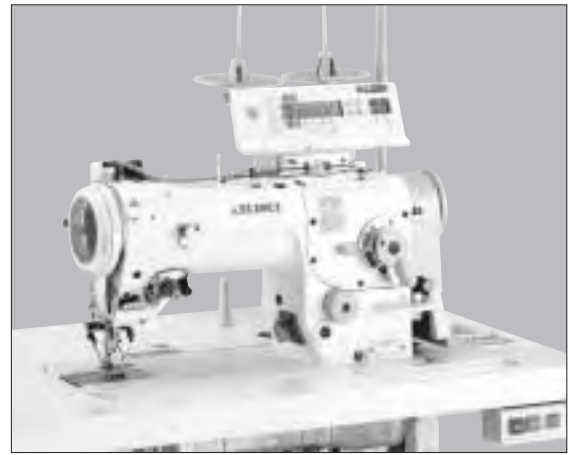
Max. zigzag width / Max. feed pitch	Throat plate	Feed dog	Presser foot (with finger guard)	Remarks
	22548705 	22548804  Max. feed amount: 1.3mm	22548960 Light-in-weight type 	
	22548507 	22548408  Max. feed amount: 2.5mm	22547962 Light-in-weight type 	• For standard zigzag stitching
	22548010 	22548119 22541601  Max. feed amount: 2.5mm Max. feed amount: 5mm		
	22549000 	22549109 22541809  Max. feed amount: 2.5mm Max. feed amount: 5mm		
	22549208 	22549307 22541700  Max. feed amount: 2.5mm Max. feed amount: 5mm		
	22546519 	22546717 22546618 	22546964 Light-in-weight type 	
	22546212 	22546410 22546311 	Light-in-weight type with the front fulcrum 22547269 	
	MAD04060000 	MAD04070000 	MAD040500A0 	• For attaching tape to brassieres, etc.
	22549604 	22549703 	22549869 Light-in-weight type 	

• Max. feed is 5 mm for the LZ-2290A-SS(-7). Since the max. feed is 2.5 mm for the LZ-2290A-SU(-7), 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.

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

**LZ-2280N SERIES**

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



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

**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 lower knife)  
**LZ-2282N-7** (standard zigzag/with lower knife and 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 standard/3-step zigzag stitching pattern changeover function)  
**LZ-2284N-7** (with standard/3-step zigzag stitching pattern changeover function and automatic thread trimmer)




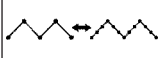


- The operator can easily switch the needle-throwing pattern between the standard and 3-step zigzag stitching patterns using the lever located in the free space under the arm. (Time required: Approx. 15 sec)  
 When changing the sewing product or design, there's no need to adjust the sewing machine head or machine layout.

High-speed, 1-needle, Lockstitch, Zigzag Stitching Machine with anti-material-slip capability

**LZ-2280NU** (standard zigzag)  
**LZ-2284NU** (with standard/3-step zigzag stitching pattern changeover function)  
**LZ-2284NU-7** (with standard/3-step zigzag stitching pattern changeover function and automatic thread trimmer)


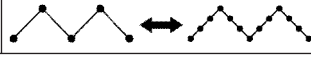
- With its newly developed feed mechanism, the machine prevents "uneven feed of the upper and lower cloths" when sewing girdles and body suits made of slippery, elastic materials.
- Drop-feed sewing machines have been widely said to feed in the lower cloth more quickly than the upper cloth. However, 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 automatic thread trimmer	LZ-2280N	LZ-2281N	LZ-2282N	LZ-2284N	LZ-2286N	LZ-2288N	LZ-2285N
	With automatic thread trimmer			LZ-2282N-7	LZ-2284N-7			
Stitch system		Standard zigzag	Standard wider zigzag	Standard zigzag (with 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 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 438SUK (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 automatic thread trimmer	LZ-2280NU	LZ-2284NU
	With automatic thread trimmer		LZ-2284NU-7
Stitch system			
Max. sewing speed		4,500rpm	

## WHEN YOU PLACE ORDERS

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

LZ228

Type	Code
Standard zigzag	0N
Standard zigzag/with 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 lower knife	2N
With standard/3-step zigzag stitching pattern changeover function	4N
With standard/3-step zigzag stitching pattern changeover function and anti-material-slip capability	4NU
With standard/3-step zigzag stitching pattern changeover function and with tape attaching foot capability	4NT
3-step zigzag	6N
3-step zigzag/with 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.

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

LZ228    7

Type	Code
Standard zigzag (anti-material-slip type)	2N
Standard/3-step zigzag	4N
Standard/3-step zigzag (anti-material-slip type)	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

SC910  S

PSC box				Code
For JUS (LA)*	Single-phase	100 ~ 120V	PFL	S
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

Control box	Code
Standard	S

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

### ● Motor for SC

M91S

Pulley belt	Code
Standard	S





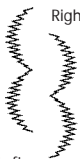

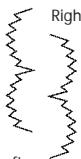
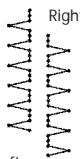
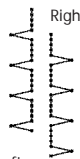
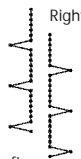
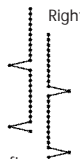
### ● Operation panel

Operation panel	Code
IP-100B	IP100B
CP-160B	CP160B

## OPTIONS

Model	Part No.	Description	Feature
	225-61559	Automatic reverse feed kit	This device allows a machine without 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 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											

\* 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 	With a recess on the reverse side of the presser foot 225-80369 		
	100-41101 	225-80104 	225-80260 Light-in-weight type 		
	225-80005 	225-80500 	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 	235-03154 Light-in-weight type 		
	225-82704 	225-82803 	235-03204 Front fulcrum type 		
	225-82407 	225-81508 	225-80864 		
		225-48804 	225-48804 		225-84965 Light-in-weight type 
	225-82506 	225-40009 	MAB-109000B0 		
	225-45008 	225-45107 	225-45362 Light-in-weight type 		
	225-45511 	225-45610 	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 	<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		225-48663 Light-in-weight type 225-48671 (finger guard: small) 
	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 		

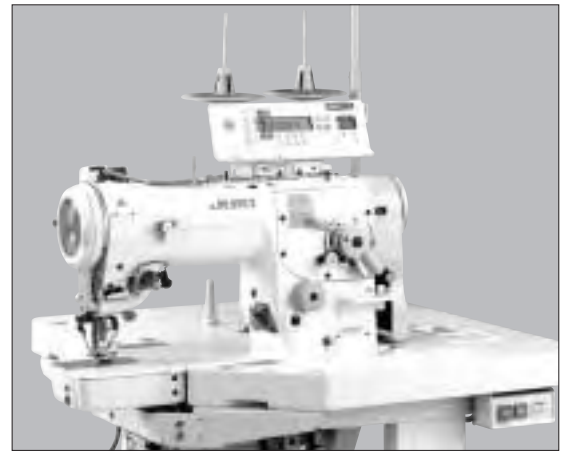
• In addition to the above-listed ones, many different gauges and attachments for zigzag stitching are available. Please contact us for details.



High-speed, Cylinder-bed, 1-needle, Lockstitch, Zigzag Stitching Machine with Automatic Thread Trimmer  
(with standard/3-step zigzag stitching pattern changeover function)

## LZ-2284C-7

- The cylinder-bed more than adequately facilitates the handling of tubular sewing products in circular sewing processes, thereby contributing to increased productivity and upgraded seam quality. This zigzag stitching machine is best suited to the attaching or counter stitching of elastic tape. The machine demonstrates features of the LZ-2284N-7 that offer outstanding productivity and a higher facility operation ratio, which is supported by a maximum sewing speed of 5,000rpm and a one-touch utility changeover between standard and 3-step zigzag stitching patterns.
- In elastic tape attaching or counter stitching processes for girdles, shorts or swimwear, the machine promises easy handling of the material. The material is placed over the cylinder-bed and can be sewn at once without stopping the sewing machine during sewing. This dramatically increases productivity.



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

### SPECIFICATIONS

Model name	LZ-2284C-7
Stitch system	Standard/3-step zigzag
Stitch pattern	
Max. sewing speed	5,000rpm Standard zigzag stitching: zigzag width of 5mm or less    3-step zigzag: zigzag width set to 8mm or less
Max. zigzag width	Standard zigzag: 8mm/3-step zigzag: 10mm
Max. feeding amount	Standard zigzag: 2.5mm/3-step zigzag: 2.0mm
Lift of the presser foot	By hand: 5.5mm/By knee: 10mm
Hook	DP hook (with titanium-treated inner hook)
Thread take-up	Rotary type
Needle (at the time of delivery)	SCHMETZ 134SUK, 438(#75)#65 ~ #90    ORGAN DP x 5 #9 ~ #14
Needle position changing mechanism	Provided as standard
Reverse feed stitching mechanism	Provided as standard
Bobbin thread winder	Built-in the machine head
Needle throw pattern cam	Grooved cam
Cylinder diameter	322mm
Lubrication	Automatic
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)
Power requirement/Power consumption	Single-, 3-phase/650VA
Total weight	86.5kg

### WHEN YOU PLACE ORDERS

LZ2284C7

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

Auto-lifter	Code
Not provided	ZZ
AK83 (pedal-driven)	AK

● PSC box

SC910  S

Control box	Code
Standard	S

PSC box					Code
For JUS(LA)*	Single-phase	100 ~ 120V	PFL		S
For JUS*, General Export	3-phase	200 ~ 240V	PFL		D
For General Export	Single-phase	200 ~ 240V	PFL		K
For CE	Single-phase	200 ~ 240V	PFL		N

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

● Motor for SC

M91S

Pulley belt	Code
Standard	S

● Operation panel

Operation panel	Code
IP-100B	IP100B
CP-160B	CP160B

## 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

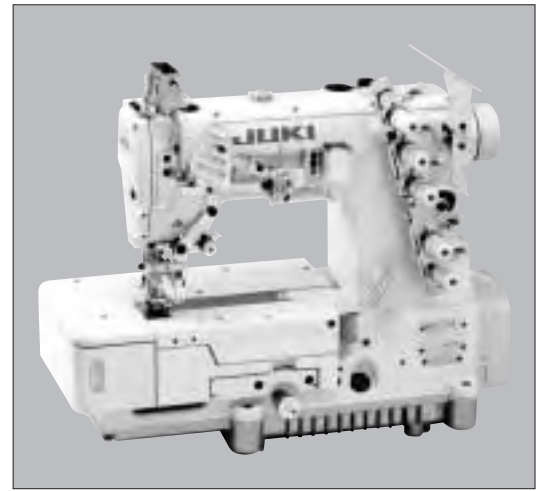
Part No.	Description	Apprication
B3352-271-0A0	Compass (asm.)	LZ-271, LZ-391N
B1502-391-BA0	Presser bar joint rod B (asm.)	
B5001-271-0A0	Scallop (asm.)	

## High-speed, Flat-bed, Top and Bottom Covering Stitch Machine

### MF-7722 (2-needle, Top and Bottom Covering Stitch Machine)

### MF-7723 (3-needle, Top and Bottom Covering Stitch Machine)

- Since the seam tension may be easily increased or decreased, the machine can be used for a broader range of applications. Seams can be adjusted depending on the application or material by changing the thread path or adjusting the thread tension controller, to produce soft and low-tensed seams for inner wear or to produce high-grade well-tensed seams for outer wear.
- Optimization of the thread take-up mechanism and top covering thread path route. The optimized thread take-up mechanism and top covering thread path route contribute to an increased stability of top covering stitches. In addition, the machine is capable of performing sewing with a low tension applied to the thread to offer improved responsiveness to the sewing thread.
- The machine comes with a variety of features to increase applicable types of sewing products. The machine is provided as standard with a great diversity of features, such as a differential feed adjustment mechanism with a micro-adjustment mechanism, a feed dog inclination adjustment mechanism, a micro-lifter and a needle bar stroke conversion mechanism. The machine can therefore be quickly adjusted to respond to various materials and processes, thus increasing the applicable types of sewing products.



MF-7723U10B56



MF-7723U10B56



MF-7723CC10B56

## SPECIFICATIONS

Model name	MF-7722	MF-7723
Stitch type	2-needle top and bottom covering stitch	3-needle top and bottom covering stitch
Max. sewing speed	6,500rpm	
Stitch length	1.2 ~ 3.6mm (stitch length can be adjusted to 4.4 mm)	
Differential-feed ratio	1:0.7 ~ 1:2	
Needle gauge	4.0mm	4.8, 5.6, 6.4mm
Needle	UY128GAS #9S ~ #14S (standard #10S)	
Lift of the presser foot	5mm (with top & bottom covering stitch), 8mm (with bottom covering stitch)	
Stitch pitch adjustment	By dial	
Differential feed adjustment	By micro-adjustment mechanism	
Lubrication	Automatic	
Lubricating oil	JUKI Machine Oil 18 (equivalent to ISO VG18)	
Feed dog inclination adjustment	Provided as standard	
Micro-lifter	Provided as standard	
Needle bar stroke converting function	Provided as standard	
Silicon oil tank for needle tip and needle thread	Provided as standard	
Cartridge oil filter	Provided as standard	
Weight of the machine head	46kg	

## WHEN YOU PLACE ORDERS

MF77       B

Stitch type	Code
2-needle, Top and Bottom Covering Stitch	22
3-needle, Top and Bottom Covering Stitch	23

Application	Code
For universal	U10
For collarete	C10

Needle pawl shape	Code
B type (standard)	B

Needle gauge	Code
4.0mm	40
4.8mm	48
5.6mm	56
6.4mm	64

For model category (23) (3-needle), needle gauge category 40 cannot be selected. For application category "collarete (C10)," needle gauge category 48 cannot be selected.

## SUBCLASS MACHINE LIST

Subclass machine	Seams	Model No.	Number of needles	Number of threads	Needle gauge (mm)	Stitch length (mm)	Differential-feed ratio	Presser lifting amount* (mm)	Max. sewing speed (rpm)
Basic stitch (universal type)		MF-7723-U10-B48	3	5	4.8	1.2 ~ 4.4	1:0.7 ~ 1:2	5(8)	6.500
		MF-7723-U10-B56	3	5	5.6	1.2 ~ 4.4	1:0.7 ~ 1:2	5(8)	6.500
		MF-7723-U10-B64	3	5	6.4	1.2 ~ 4.4	1:0.7 ~ 1:2	5(8)	6.500
Collarette attaching		MF-7722-C10-B40	2	4	4.0	1.2 ~ 4.4	1:0.6 ~ 1:1.1	5(8)	6.500
		MF-7722-C10-B56	3	5	5.6	1.2 ~ 4.4	1:0.6 ~ 1:1.1	5(8)	6.500
		MF-7722-C10-B64	3	5	6.4	1.2 ~ 4.4	1:0.6 ~ 1:1.1	5(8)	6.500

\* The presser foot lift is 5 mm for collarette with top and bottom covering or 8 mm for collarette with bottom covering.

### U10 (universal type)

This basic model can be used in a broad range of processes including sleeve-/bottom-hemming for T-shirts and coverings for sportswear and knitwear.



### C10 (for collarette attaching)

This model is best suited for attaching collarettes on underwear, briefs and knitwear.



Specifications changing between the U10 and C10 can easily be carried out by replacing gauge components.

#### U10 → C10 Interchangeable parts

Cover related parts			
*1 Cover related assembly parts number 40018349			
Gauge components			
Parts name	Gauge component parts No.		
	4.0mm	5.6mm	6.4mm
Presser foot asm.	13376157	13376256	13376256
Throat plate	13351408	13351606	13351705
Main feed dog	13353800	13353909	13353909
Differential-feed dog	13357702	13357801	13357801

\* 1 The coverseam related assembly parts number does not include any attachment.

#### C10 → U10 Interchangeable parts

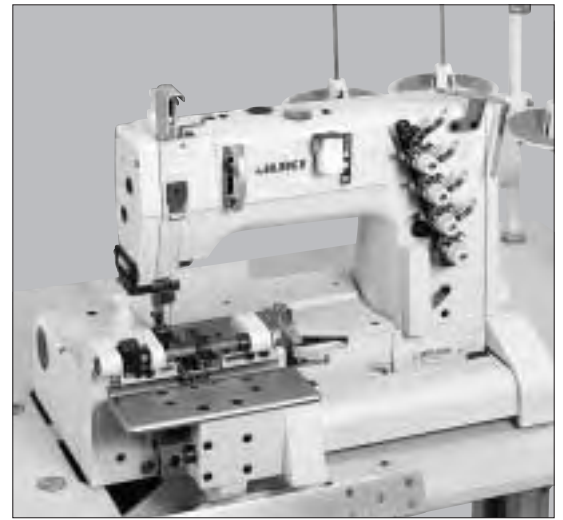
Cover related parts			
Cover related assembly parts number 13303458			
Gauge components			
Parts name	Gauge component parts No.		
	4.0mm	5.6mm	6.4mm
Presser foot asm.	13376058	13375050	13375050
Throat plate	13354709	13354808	13351200
Main feed dog	13354204	13354204	13353701
Differential-feed dog	13358304	13358304	13357603
Looper *2	13339007		

\* 2 For the gauge size of 4.8 mm, the looper (13339007) is also required.

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)

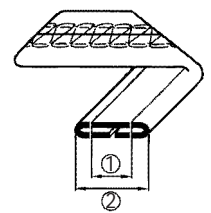
## WHEN YOU PLACE ORDERS

### MFB2600

Needle gauge	Code
4.8mm	F
5.6mm	G
6.4mm	H
8.0mm	K

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

MH380  U

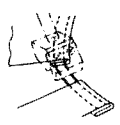
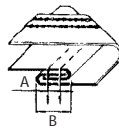
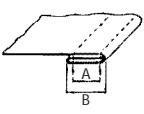
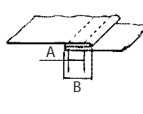
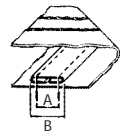
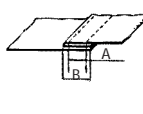
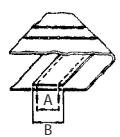
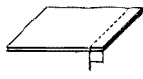
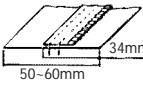
MH382U

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>

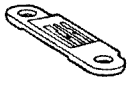




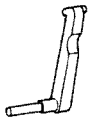
# DEVICES AND ATTACHMENTS

<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-080000AC</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-080000AC	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>● Decorative tape attaching foot</p> <p><b>B050</b></p>  <p>A: Needle gauge B: Finished width</p>	<p><b>Applicable machines:</b> MH-380  <b>Class of work:</b> Sportswear, Training wear, Swimsuits, Uniforms, Boxer pants, Rompers  <b>Applications:</b> Stitch accent line attach tapes  <b>Materials:</b> Cotton bias tape, or plain woven tape for some limited process.</p> <table border="1"> <thead> <tr> <th>Finished width (mm)</th> <th>Needle gauge mm (in)</th> <th>Tape width (mm)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>17</td> <td>12.7 (1/2)</td> <td>34</td> <td>MAB-0500SLA0</td> </tr> <tr> <td>15</td> <td>9.5 (3/8)</td> <td>30</td> <td>MAB-0500CKA0</td> </tr> <tr> <td>12</td> <td>7.9 (5/16)</td> <td>24</td> <td>MAB-0500MHA0</td> </tr> <tr> <td>10</td> <td>6.4 (1/4)</td> <td>20</td> <td>MAB-0500KFA0</td> </tr> <tr> <td>8</td> <td>4.8 (3/16)</td> <td>16</td> <td>MAB-0500HDA0</td> </tr> <tr> <td>6</td> <td>4.0 (5/32)</td> <td>14</td> <td>MAB-0500GCA0</td> </tr> </tbody> </table>	Finished width (mm)	Needle gauge mm (in)	Tape width (mm)	Part No.	17	12.7 (1/2)	34	MAB-0500SLA0	15	9.5 (3/8)	30	MAB-0500CKA0	12	7.9 (5/16)	24	MAB-0500MHA0	10	6.4 (1/4)	20	MAB-0500KFA0	8	4.8 (3/16)	16	MAB-0500HDA0	6	4.0 (5/32)	14	MAB-0500GCA0	<p>● Right feed top stitch folder</p> <p><b>M055</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-0550S0A0</td> </tr> <tr> <td>14</td> <td>9.5 (3/8)</td> <td>MAM-0550P0A0</td> </tr> <tr> <td>12</td> <td>7.9 (5/16)</td> <td>MAM-0550M0A0</td> </tr> <tr> <td>10</td> <td>6.4 (1/4)</td> <td>MAM-0550K0A0</td> </tr> <tr> <td>10</td> <td>5.6 (7/32)</td> <td>MAM-0550K0A0</td> </tr> <tr> <td>9</td> <td>4.8 (3/16)</td> <td>MAM-0550J0A0</td> </tr> <tr> <td>8</td> <td>4.0 (5/32)</td> <td>MAM-0550H0A0</td> </tr> </tbody> </table>	Finished width (mm)	Needle gauge mm (in)	Part No.	17	12.7 (1/2)	MAM-0550S0A0	14	9.5 (3/8)	MAM-0550P0A0	12	7.9 (5/16)	MAM-0550M0A0	10	6.4 (1/4)	MAM-0550K0A0	10	5.6 (7/32)	MAM-0550K0A0	9	4.8 (3/16)	MAM-0550J0A0	8	4.0 (5/32)	MAM-0550H0A0
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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 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





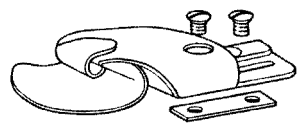
## MH-380

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	B1613-380-K00			
9.5mm (3/8")	B1103-380-K00	B1406-038-KA0	B1509-038-KB0	B1613-380-L00			
12.7mm (1/2")	B1103-380-L00	B1406-038-LA0	B1509-038-LBB	B1613-380-L00	B2311-380-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 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.



MH-481-5

1-needle, Double Chainstitch Differential-feed Machine

# MH-484

## MH-484-5(4) (with 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.

1-needle, Double Chainstitch, Bottom & Variable Top-feed Machine with 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
Reverse 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 dog	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 material 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-compensating foot for side pockets)			B3026-487-M00	B1524-486-MAA
S	For sharp turning stitch (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

6



## 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 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 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

MH1410  /      /

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.



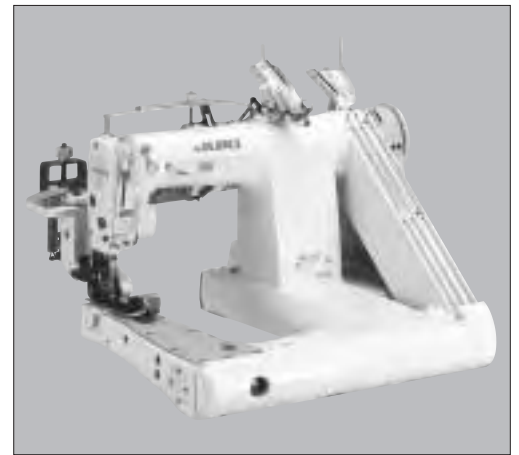
MS-1190

## 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.

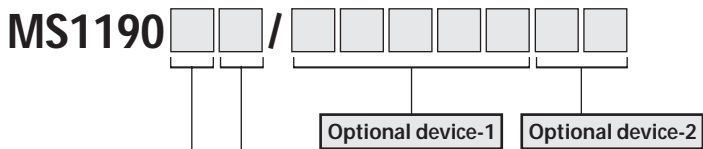


MS-1261/045

## 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 push-button (with locking mechanism)				
Lubrication	Semi-automatic lubrication				
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)				

## WHEN YOU PLACE ORDERS

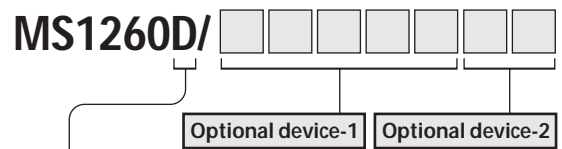


Application	Code
For light-weight materials (standard)	M
For medium-weight materials	

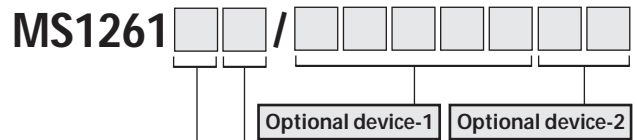
Needle gauge	Code
3.2mm (1/8")	B
4.0mm (5/32")	C
4.8mm (3/16")	D
5.6mm (7/32")	E
6.4mm (1/4")	F

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>



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



Application	Code
For extra heavy-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 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

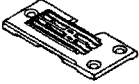

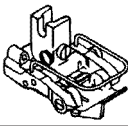
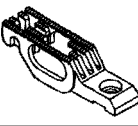


	129-45168	For MS-1190 series	Silicon oil lubricating unit is an auxiliary device to reduce the frequency of thread breakage caused by a hot needle.
	129-76254	For MS-1260 series	

### ●Pneumatic auto-lifter

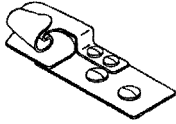
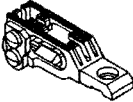

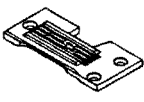
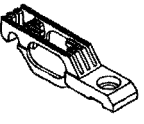
AK81	GAK-81000AA0	Pedal switch type	The pneumatic auto-lifter helps reduce the operator's fatigue and enables the operator to operate the sewing machine rhythmically.
	GAK-81000AA0	Knee switch type	

# TABLE OF EXCHANGING GAUGE PARTS

## MS-1190

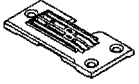
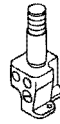
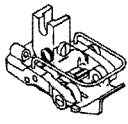
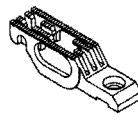


		1	2	3	4	5	6	7
Description		Gauge set (with finger guard)	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog	Looper asm. (L)	Looper asm. (R)
Needle gauge size		/						
Code	Size							
B	3.2mm (1/8")							
C	4.0mm (5/32")	129-23561	129-23504	129-26051	129-27869	129-32307	129-41555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

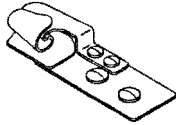
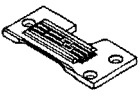
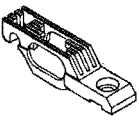
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		8	9	10	11	12	13	14
Description		Lap seam folder asm.			Feed dog asm. (with removing needle holder)	Looper needle guide (for removing needle holder)	Throat plate (for chain-off thread)	Feed (for chain-off thread)
		M295	M296	M297				
Needle gauge 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.

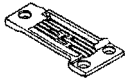
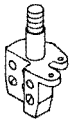

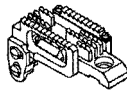
## MS-1190M

		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")							
C	4.0mm (5/32")	129-80561	129-80504	129-26051	129-82666	129-83508	129-41555	129-40656
D	4.8mm (3/16")	129-80660	129-80603	129-26150	129-82765	129-83508	129-41654	129-40755
E	5.6mm (7/32")	129-80462	129-80405	129-25954	129-82567	129-83508	129-41456	129-40557
F	6.4mm (1/4")	129-80769	129-80702	129-26259	129-82864	129-83508	129-41753	129-40854
		129-80868	129-80801	129-26358	129-82963	129-83607	129-41852	129-40953



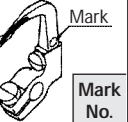
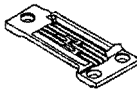
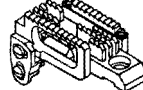
		8	9	10	11
Description		Lap seam folder asm.		Throat plate (for chain-off thread)	Feed (for chain-off thread)
		M296	M297		
Needle gauge size					
Code	Size				
B	3.2mm (1/8")	MAM-2960AAAA	MAM-2970AAAA	129-80900	129-83706
C	4.0mm (5/32")	MAM-2960BBAA	MAM-2970BBAA	/	/
D	4.8mm (3/16")	MAM-2960CCAA	MAM-2970CCAA		
E	5.6mm (7/32")	MAM-2960DDAA	MAM-2970DDAA		
F	6.4mm (1/4")	MAM-2960EEAA	MAM-2970EEAA		



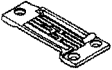
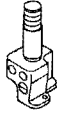




## MS-1261/V045 (for extra heavy-weight materials)



		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					Needle gauge size							
Code	Size	Mark No.	Mark No.	Mark No.	Code	Size						
	E	5.6mm (7/32")	129-68558	1			129-68855	1	129-69150	1	E	5.6mm (7/32")
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											
Code	Size						Mark No.	Mark No.			
MS-1260/V045	D	4.8mm (3/16")	129-77963	129-77906	129-25954	129-78268	129-78755	129-79258	3	129-79357	2
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")	↑

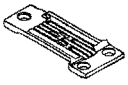
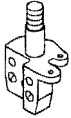

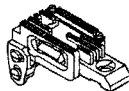
10. Spacer for presser				Screw for spacer	
No.	Thickness	Part No.	Description	Part No.	Qty
①	0.3	129-72509	Adjusting plate B	SS-5060310SP	2
②	0.5	129-73608	Adjusting plate C	↑	2
③	0.8	129-73707	Adjusting plate D	SS-5060410SP	2
④	1.0	129-62106	Adjusting plate A	↑	2
⑤	1.2	129-73806	Adjusting plate E	↑	2

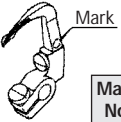

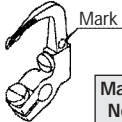
The spacer and installing screws are not included in gauge set.

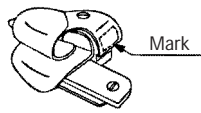
11. Spacer for presser			
No.	Thickness	Part No.	Description
①	0.3	129-75702	Adjusting plate B
②	0.5	129-64102	Adjusting plate A
③	0.8	129-75801	Adjusting plate C
④	1.0	129-75900	Adjusting plate D

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")	129-72972	129-72907	129-56355	129-60183	129-75058
F	6.4mm (1/4")	129-72873	129-72808	129-56256	129-60084	129-74952
G	7.2mm (9/32")	129-73079	129-73004	129-56454	129-60282	129-75157
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

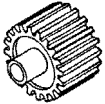
The folder is not included in gauge set.

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 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 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 wiper unit)

## WHEN YOU PLACE ORDERS

### ● Machine head, Circuit board



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

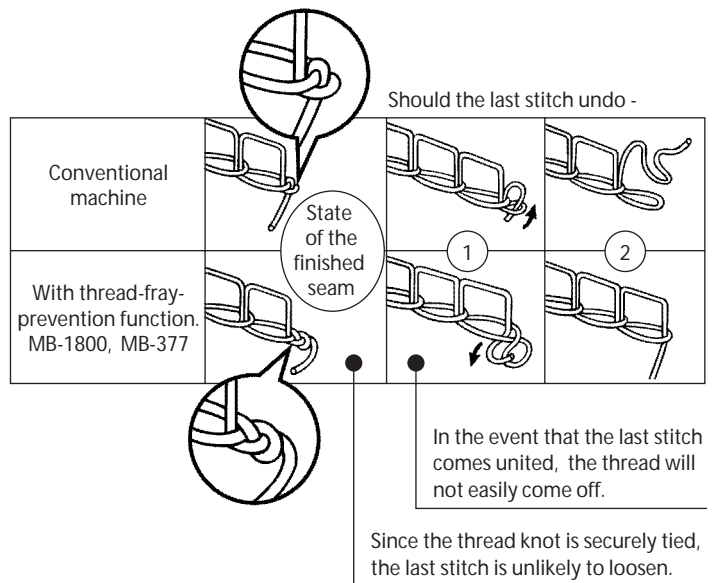
## OPTIONS

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			
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



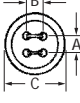
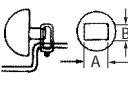






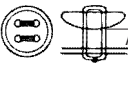




● Attaching flat button (small)



● Space pin (accessory)

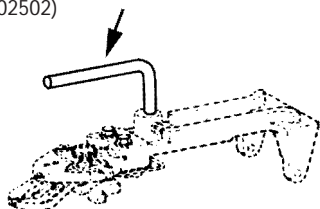
\* For all stitch shapes, three different pieces of data can be established by selecting the number of stitches and stitch pitch within the respective data setting ranges.

# 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).

## WHEN YOU PLACE ORDERS

● Machine head, Circuit board: with button feeder

**MB1800A**  / **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
Standard							
2.6	1.0	165-57902	A	3.2	1.2	165-58009	B
Optional							
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



Single-thread, Chainstitch, Button Sewing Machine

# MB-373NS Series

- The 4-holed button sewing mode can be easily switched over to the 2-holed button sewing mode in accordance with changing sewing specifications. Furthermore, the button hole interval can be easily changed by operating the lever.
- The number of stitches can be quickly selected from among 8, 16 and 32 stitches corresponding to the change in sewing specifications.
- The machine ensures consistent sewing performance even when it runs at 1,500rpm. The unique speed-decreasing device reduces vibration when the sewing machine stops, thereby enabling the sewing machine to beautifully finish buttons with accuracy.



MB-373NS





## SPECIFICATIONS

Model name	MB-373NS
Thread trimming mechanism	Interlocked with the presser lifter Cut with the fixed knife and moving knife
Sewing speed	Max 1,500rpm, Normal 1,300rpm
Number of stitches	8, 16 and 32 stitches (6, 12 and 24 stitches are also available by changing the cam)
Feed length	Crosswise feed 2.5 ~ 6.5mm, Lengthwise feed 0 ~ 6.5mm
Stitching shape	□, Z, X
Applicable button	Round-shaped flat button (2-holed, 4-holed)
	Shank button, Wrapped-around button, Snap, Label, Metal button, Stay button (exclusive attachments have to be used)
Button size	10 ~ 28mm
Thickness of button	Max. 5mm
Needle bar stroke	48.6mm
Needle (at the time of delivery)	TQ x 7 (#16) #14 ~ #20
Button clamp lifting system	Automatic system (pedal type possible)
Sewing system	Single thread chainstitch
Stop-motion mechanism	Automatic stop-motion mechanism (equipped with the speed-decreasing device and the reverse rotation preventing device)
Lubrication	By an oiler
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)
Power requirement/motor used	Single- or 3-phase/200W (1/4 HP), general-purpose motor

## WHEN YOU PLACE ORDERS

- Machine head

MB373NS   /

Subclass models	Code
8, 16 and 32 stitches 	
8, 16 and 32 stitches 	10
8, 16 and 32 stitches 	11

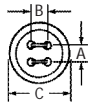
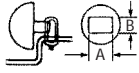


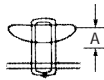
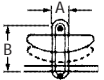
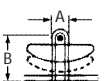


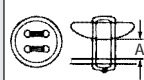




Button clamp unit	Code
For flat button (small)	S
For flat button (medium)	M



For sewing flat buttons

# ATTACHMENT TABLE

● Existing attachments are applicable.

Application			Sketch		Attachment		
					Symbol	Part No.	Finger guard
For flat buttons	Small- to large-buttons thickness 5.0mm	Left		Button size A: 0 ~ 6.5mm B: 2.5 ~ 6.5mm C: 10 ~ 28mm		D2556-372-CAA	B3130-372-000B
		Right			D2558-372-CAA		
	Large-buttons thickness 3.1mm			Button size A: 0 ~ 6.5mm B: 2.5 ~ 6.5mm C: 20 ~ 28mm	Z031	MAZ-031000AA	
	Medium-buttons thickness 2.8mm			Button size A: 0 ~ 4.5mm B: 2.5 ~ 4.5mm C: 12 ~ 20mm	Z032	D2529-373-B00A	
Small-buttons thickness 2.8mm		Button size A: 0 ~ 3.5mm B: 2.5 ~ 3.5mm C: 10 ~ 12mm			B2529-373-000		
For shank buttons				Button diameter: 16mm or less Shank size A: 5 ~ 6mm B: 2.5 ~ 3mm	Z033	B2401-373-0BA	
				Button diameter: 16mm or less Responds to slight variations in the button shank.	Z040	MAZ-040000AA	
				Buttons with round shanks A: 5mm Cloth-to-button distance is small.	Z040B	MAZ-040000AA	
For wrapped-around buttons		1st process		Button-to-material distance A: 5.5mm	Z004	B2447-372-0A0	B3130-372-000B
				Button-to-material distance is adjustable. A: 3mm or more B: 9 ~ 18mm	Z041	MAZ-041010A0	
				Button-to-material distance is adjustable. The machine is capable of sewing flat buttons without neck wraps. A: 3mm or more B: 9 ~ 12mm	Z099	141-34050	
		2nd process			Z035	B2440-373-0A0	
				The machine wraps the button neck while moving the attachment back and forth.	Z046	MAZ-046010A0	
For flat buttons and wrapped-around buttons (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.	Z172	MAZ-172000A0	B3130-372-000B
For snaps				Size A: 8mm	Z037	B2552-373-BAA	B3130-372-000B
For metal buttons					Z038	B2420-373-0AA	
For stay buttons				To be used in combination with the B2447-372-0A0(Z044)  To be used in combination with the MAZ-041010A0(Z041) or 141-34050. A: 3.5mm or more	Z039	MAZ-039010A0	B3130-372-000B
For label attaching				Zigzag width: 3 ~ 6.5mm	Z044	MAT-64401ZBA	B3130-372-000B



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


## MB-377NS Series

- 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 knots, they 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.
- The 4-holed button sewing mode can be easily switched over to the 2-holed button sewing mode in accordance with changing sewing specifications. Furthermore, the button hole interval can be easily changed by operating the lever.
- The number of stitches can be quickly selected from among 8, 16 and 32 stitches corresponding to the change in sewing specifications.



MB-377NS




### SPECIFICATIONS

Model name	MB-377NS
Thread trimming mechanism	Interlocked with the presser lifter Cut with the fixed knife and moving knife
Sewing speed	Max 1,500rpm, Normal 1,300rpm
Number of stitches	8, 16 and 32 stitches
Feed length	Crosswise feed 2.5 ~ 6.5mm, Lengthwise feed 0 ~ 6.5mm
Stitching shape	
Applicable button	Round-shaped flat button (2-holed, 4-holed)
Button size	10 ~ 28mm
Thickness of button	Max. 3.1mm
Needle bar stroke	48.6mm
Needle (at the time of delivery)	TQ x 1 (#16) #14 ~ #18 or TQ x 7 (#16) #14 ~ #20
Button clamp lifting system	Automatic system (pedal type possible)
Sewing system	Single thread chainstitch
Stop-motion mechanism	Automatic stop-motion mechanism (equipped with the speed-decreasing device and the reverse rotation preventing device)
Lubrication	By an oiler
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)
Power requirement/motor used	Single- or 3-phase/200W (1/4 HP), general-purpose motor

### WHEN YOU PLACE ORDERS

- Machine head

MB377NS   /

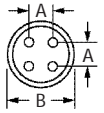
Subclass models	Code
8, 16 and 32 stitches 	
8, 16 and 32 stitches 	10
8, 16 and 32 stitches 	11

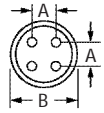
Button clamp unit	Code
For flat button (small)	S
For flat button (medium)	M



For sewing flat buttons

### 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

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

### LK-1903A

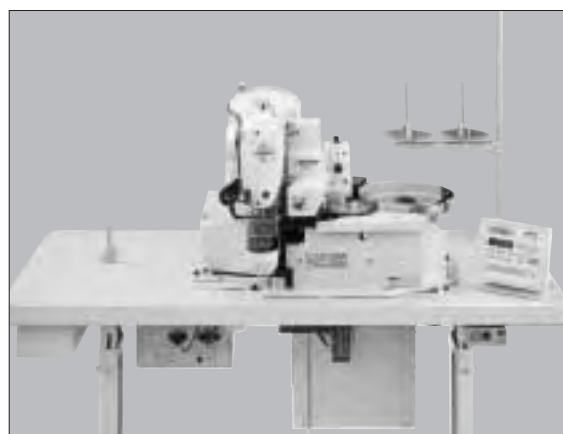
- The machine achieves sewing speed of 2,700rpm. The machine's starting, stopping, thread-trimming and automatic presser lifting speeds have been increased to significantly shorten total cycle time.
- The machine is provided as standard with 50 different sewing patterns. The machine permits easy changeover of sewing patterns for effortless execution of an inexhaustible range of sewing specifications.
- The machine is provided as standard with the active tension (electronic thread tension control mechanism). Since the machine is provided with an active tension mechanism, it is able to set a needle thread tension that matches various sewing conditions (such as thread, material and sewing speed) on the operation panel, store the data in memory and reproduce it.

### LK-1903A/BR35 (with button feeder)

- It provides better productivity as it achieves the maximum speed of 2,700rpm (2,500rpm in normal use) and is equipped with the high speed trimmer.
- With our original horizontal forced feed mechanism, the button carrier sets a button in position so that the operation is simplified. Furthermore, operator fatigue is reduced since what operator needs to do is only setting material and pressing a pedal.



LK-1903A-SS-301

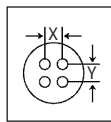


LK-1903A/BR35

## SPECIFICATIONS

Model name	LK-1903A	LK-1903A/BR35
Max. sewing speed	2,700rpm (normal 2,500rpm)	
Button size	Type: Round-shaped, flat button Size: 8 ~ 32mm (standard 8 ~ 20mm)	Type: Round-shaped, flat button (2-holed, 4-holed) Size: 9 ~ 20mm For small button: 10 ~ 15mm For medium-sized button: 12 ~ 18mm (Those that are smaller than 10mm or larger than 18mm must be specially ordered.) Thickness: 1.8 ~ 3.5mm
Stitch length	0.1 ~ 10mm (0.1mm step)	
Needle bar stroke	45.7mm	
Lift of the work clamp foot	Max. 13mm	Max. 11mm
Auto-lifter	Provided as standard (stepping motor type)	
Needle thread tension	Active tension (electronic thread tension control system)	
Needle (at the time of delivery)	DP x 17(#14)	
Hook	Standard shuttle hook	
Number of stitches that can be stored in memory	Max. 20,000 stitches	
Number of standard patterns	50 patterns	
Number of data that can be input	200 patterns ( For up to 150 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	
Memory medium	EEP-ROM/EP-ROM	
Bobbin thread counter	Provided as standard (Up/Down method)	
Supplying and sorting of button		Vibration system
Button feed		Horizontal forced button-feed mechanism
Button feed mode		Automatic feed mode, non-feed mode, and small-lot sewing mode
Lubrication	Hook: minute-quantity lubrication	
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)	
Sewing machine motor	450W compact AC servomotor (direct-drive system)	
Power consumption	320W	350W
Weight	Machine head (include motor) 42kg, Control box 16.5kg	115kg (include machine head, table and BR35)

TABLE OF THE SEWING PATTERNS



Pattern No.	Stitch shape	Sewing thread (pcs.)	Standard length X (mm)	Standard length Y (mm)	Pattern No.	Stitch shape	Sewing thread (pcs.)	Standard length X (mm)	Standard length Y (mm)
1 · 34		6-6	3.4	3.4	18 · 44		6	3.4	0
2 · 35		8-8			19 · 45		8		
3		10-10			20		10		
4		12-12			21		12		
5 · 36		6-6			22		16		
6 · 37		8-8			23 · 46		6	0	3.4
7		10-10			24		10		
8		12-12			25		12		
9 · 38		6-6			26 · 47		6-6	3.4	3.4
10 · 39		8-8			27		10-10		
11		10-10			28 · 48		6-6		
12 · 40		6-6			29		10-10		
13 · 41		8-8			30 · 49		5-5-5	3.0	2.5
14		10-10			31		8-8-8		
15 · 42		6-6			32 · 50		5-5-5		
16 · 43		8-8			33		8-8-8		
17		10-10							

\* (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.

MODELS CLASSIFIED BY BUTTON SIZES

Model name		LK-1903A-301				LK-1903A-302		Option		
Button size		For extra-small button		For small button (accessory)		For medium-size button		For large button		
Outside diameter that can be adjusted (mm)		8 ~ 9	9 ~ 10	10 ~ 15	10 ~ 20	10 ~ 20		15 ~ 32		
Sewing size (mm)	Length (Y)	0 ~ 2.5	0 ~ 3.0	0 ~ 3.5	0 ~ 3.5	0 ~ 4.5		0 ~ 6.5		
	Width (X)	0 ~ 2.5	0 ~ 3.0	0 ~ 3.5	0 ~ 3.5	0 ~ 4.5		0 ~ 6.5		
Button clamp jaw lever (combination)	Thickness (mm)	1.7 (2.2)		1.7 (2.2) (2.7) (0.9)		2.0 (2.2) (2.7)		2.7 (3.2)		
		*		*		*		*		
	Part No.	Right	MAZ158070BB	G	14148852	K	14149058	L	MAZ157070BB	D
			(MAZ158070BA)	F	(MAZ155070B0)	B	(MAZ155070B0)	B	(MAZ157070BA)	E
		Left	-	-	(MAZ156070B0)	C	(MAZ156070B0)	C	-	-
			-	-	(B25553720A0)	-	-	-	-	-
Needle hole guide (mm)	A	1.6 (1.8)		(1.6) (1.8) (1.1)		1.6		1.4		
	B	2.8		( 3.5)		3.5		3.5		
Part No.	C	1.6		( 1.6)		2.0		2.0		
	MAZ15801000	(14149900)		(MAZ15501000) (14149603)		MAZ15601000		MAZ15701000		
Feed plate	MAZ15502000( 8.5)		(D2426284Y00)		MAZ15602000( 10)		MAZ15702000( 12.5)			

● Parts shown in parentheses ( ) are optional. \* Engraved marker

Model name	Option			
Button type	For shank button			
Max. sewing speed	1,500rpm			
Button configuration	Outside diameter	8 ~ 20		
	Diameter of hole in button	1.5 or more		
Configuration of shank	Position of hole in button			
		1.5mm or more		
Pattern No.		B (mm)		
		A (mm)		
		Min	Max	
		1	4	9
		3	3	8
		5	-	7

Optional part for shank button	
Part No.	Name of part
14146054	Pick-up device complete
D1401M1YC0A	Needle bar (for TQ-1)
MAZ160170A0	Wiper (asm.)
40015434	Moving plate link A
14148209	Bushing
SL6030892TN (2 pcs.)	Screw
MAZ16015000	Button support link
SD0640321TP	Hinge screw
40010103	Connecting link
SL6040892TN (2 pcs.)	Screw
MAZ16021000	Needle hole guide
MTQ300B1400	Needle TQ x 3 #14

**MODELS CLASSIFIED BY BUTTON SIZES**

Model name		LK-1903A-311/BR35	LK-1903A-312/BR35			
Button size		For small button		For medium-size button		
Outside diameter that can be adjusted (mm)		10 ~ 15		12 ~ 18		
Sewing size (mm)	Length (Y)	0 ~ 3.5		0 ~ 4.5		
	Width (X)	0 ~ 3.5		0 ~ 4.5		
Button clamp jaw lever (combination)	Thickness (mm)	1.7 (2.2)		2.7		
			*		*	
	Part No.	Right	14190458	P	MAZ166070B0	J
			(MAZ165080B0)	H	-	-
		Left	14190557	P	MAZ166080B0	J
			(MAZ165080B0)	H	-	-
Needle hole guide (mm)		A		1.6 (1.8)		
		B		3.5		
		C		2.0		
		Part No.		MAZ15501000 (14149603)	MAZ15601000	
Feed plate		MAZ15502000( 8.5)		MAZ15602000( 10)		

● Parts shown in parentheses ( ) are optional.  
\* Engraved marker

**BUTTON CARRIER**

Configuration of button carrier							
For 4-holed button				For 2-holed button			
Distance A(mm): Distance B(mm): Distance between holes in button	Distance B(mm): Diameter of set pin	Part No.	Code	Distance A(mm): Distance B(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				

7

**SHAPE OF BUTTON**

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

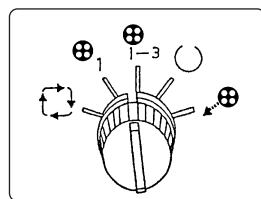
●For thick buttons

Suitable model: LK-1903A/BR35

Thickness of button should be 2.5mm ~ 5.0mm

\* Please contact our branch and sales offices.

**OPERATION PANEL**



**Automatic supply mode**

The machine and button feeder are connected and run together. It starts sewing a button by pressing a pedal, thread trimmer is activated after sewing a button, and button feeder sets the next button in position automatically. The machine repeats these operations with this mode.



**Mode for individual**

This mode is for the machine only. As button feeder will not be activated, this can be used as a standard button sewing machine.



**Mode for small lots**

Same as the automatic mode, but parts feeder will not be activated. It discharges the required amount of buttons in the index and sews buttons automatically. This is suitable for smaller lots.

## WHEN YOU PLACE ORDERS

### ● Machine head

### ● Control box

LK1903ASS

MC596

Application	Code
Standard	S

Button clamp jaw lever	Code
For extra-small, small button	301
For medium-size button	302

Work clamp foot	Code
Standard	S

Power supply	Code
3-phase	200 ~ 240V E
Single-phase	200 ~ 240V K
	CE 200 ~ 240V (not provided with power switch) N

Operation panel	Code
Standard panel	SS
IP-200B	PB

### ● Machine head

LK1903ASS / BR35 S

Application	Code
Standard	S

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

Work clamp foot	Code
Standard	S

Feed plate	Code
For small button (standard: 16mm)	S
For medium-size button (22mm)	M

Power supply	Code
Single-phase	115V C
	220V D
	240V E
	CE 230V (not provided with power switch) G
3-phase	220V K

Operation panel	Code
Standard panel	S

\* IP-200B cannot be installed.

## OPERATION PANEL (You can choose operation panel.)

### STANDARD PANEL

- Functional settings, such as pattern numbers and needle thread tensions can be established through the operation panel with ease. Distance between holes in a button can be easily changed by means of pattern enlargement/reduction feature.
- Standard sewing patterns can be assigned to pattern keys P1 to P50. Any of the sewing patterns assigned to the P1 to P25 pattern keys can be activated with a touch of the corresponding key. This means that workability is improved by assigning 25 sewing patterns that are most frequently used to those pattern keys.
- As many as 20 different cycle sewing patterns, each of which combines a maximum of 30 different sewing patterns, can be stored in the memory.
- The operation panel has been installed at an angle and can be placed at the top, bottom, right or left part of the table according to the operator's preference.



### IP-200B

- A large color LCD touch panel has been adopted for the display. It gives clear displays that allow the operator to understand operating procedures.
- The IP-200B panel can be connected to a personal computer and can store data on SmartMedia. This allows data to be exchanged or shared among sewing machines installed in a factory or among remote factories.
- The IP-200B panel has been provided with a process improvement supporting feature through the indication of the operational state of the sewing machine, and a maintenance and management feature for indicating the needle changing timing and cleaning timing.



LK-1903A-SS/Installation of the IP-200B



## Computer-controlled, High-speed, Bartacking Machine

### LK-1900A

- The machine achieves the world's highest sewing speed of 3,000rpm. In addition to the high-speed sewing performance, the machine's starting, stopping, thread-trimming and automatic presser lifting speeds have been increased to significantly shorten total cycle time (reduced approximately 30% compared to our predecessor model: For 42-stitch large bartacks).
- The machine comes with a newly developed needle thread grasping mechanism. The mechanism prevents thread from slipping off from the needle eyelet at the beginning of sewing, from tangling on the wrong side of the material and also being stained during sewing. The thread trimming mechanism has been further improved to shorten the length of thread remaining on the wrong side of the material after thread trimming.
- With its 30mm (length) by 40mm (width) sewing area, the machine can sew many different shapes of bartacks. The machine is provided as standard with as many as 50 different types of sewing patterns including semilunar bartacking, round bartacking, radial tacking as well as conventional bartacks.
- The machine is provided as standard with the active tension (electronic thread tension control mechanism). Since the machine is provided with an active tension mechanism, it is able to set a needle thread tension that matches various sewing conditions (such as thread, material and sewing speed) on the operation panel, store the data in memory and reproduce it.
- The machine is provided as standard with an auto-lifter that uses a new stepping-motor system. This helps reduce operator fatigue.



LK-1900A-SS



LK-1900A-FS

## Computer-controlled, High-speed Bartacking Machine for Eyelet Buttonholes

### LK-1901A

- 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 buttonholes.
- Three different sewing patterns (21-, 36- and 48-stitch bartacking) are prepared to enable easy switchover of sewing sizes. If the sewing patterns are assigned to the pattern 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.



LK-1901A-SS

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

### LK-1902A

- 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 patterns 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-1902A-SS

## SPECIFICATIONS

Model name	LK-1900A-SS	LK-1900A-HS	LK-1900A-FS	LK-1900A-MS	LK-1900A-WS
Application	Standard	For heavy-weight materials	For foundation	For knits and knitted materials	With large hook for heavy-weight materials
Max. sewing speed	3,000rpm				2,700rpm
Sewing area	30mm (L) × 40mm (W)				
Stitch length	0.1 ~ 10mm (0.1mm step)				
Needle bar stroke	41.2mm				
Lift of the work clamp foot	Standard 14mm (17mm when the reverse-rotation needle-up function)				
Auto-lifter	Provided as standard (stepping motor type)				
Needle thread tension	Active tension (electronic thread tension control system)				
Needle (at the time of delivery)	DP × 5 (#14)	DP × 17 (#21)	DP × 5 (#11)	DP × 5 (#11)	DP × 17 (#21)
Hook	Standard shuttle hook				Large shuttle hook
Number of stitches that can be stored in memory	Max. 20,000 stitches				
Number of standard patterns	50 patterns				
Number of data that can be input	200 patterns (For up to 150 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				
Memory medium	EEP-ROM, EP-ROM				
Bobbin thread counter	Provided as standard (Up/Down method)				
Lubrication	Hook: minute-quantity lubrication				
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)				
Sewing machine motor	450W compact AC servomotor (direct-drive system)				
Power consumption	320W				
Weight	Machine head (include motor) 42kg, Control box 16.5kg				

Model name	Eyelet buttonhole bartacking machine	Belt-loop attaching machine	
	LK-1901A-SS	LK-1902A-SS	LK-1902A-HS
Application	Standard	Standard	For heavy-weight materials
Max. sewing speed	3,000rpm		
Sewing area	30mm (L) × 40mm (W)		
Stitch length	0.1 ~ 10mm		
Needle bar stroke	41.2mm		
Lift of the work clamp foot	Standard 14mm (by using the reverse-rotation needle-up function 17mm)		
Auto-lifter	Provided as standard (stepping motor type)		
Needle thread tension	Active tension (electronic thread tension control mechanism)		
Needle (at the time of delivery)	DP × 5 (#16)	DP × 5 (#16)	DP × 17 (#21)
Hook	Standard shuttle hook		
Number of stitches that can be stored in memory	Max. 20,000 stitches		
Applicable pattern number	11, 12, 13	17, 18 (19, 20, 21, 22*) *This device has been factory-set to "invoking prohibited" status at the time of delivery.	
Number of data that can be input	200 patterns (For up to 150 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		
Memory medium	EEP-ROM, EP-ROM		
Material drawing amount	Max. 3mm	-	
Bobbin thread counter	Provided as standard (Up/Down method)		
Lubrication	Hook: minute-quantity lubrication		
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)		
Sewing machine motor	450W compact AC servomotor (direct-drive system)		
Power consumption	320W		
Weight	Machine head (include motor) 42kg, Control box 16.5kg		

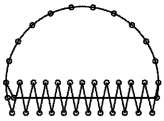

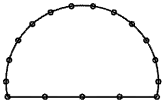

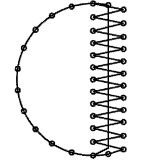

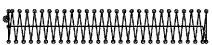

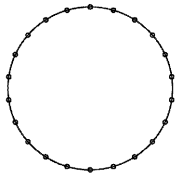

# TABLE OF THE STANDARD PATTERNS




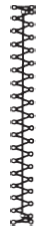


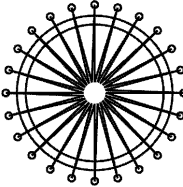
	No.	Stitch diagram	Number of stitches	Sewing size (mm)		(Note 2) No. of work clamp foot	
				Length-wise	Cross-wise		
Large bartacking	1		42	2.0	16	1	
						2	
						3	
		2		28	2.0	10	1
			2				
			3				
		* 3		36	2.5	16	1
			4				
		* 4		56	3.0	24	6
			7				
	5		64	2.0	10	1	
		2					
		3					
	* 6		28	2.5	16	1	
		4					
	7		36	2.0	10	1	
		2					
		3					
	* 8		56	2.5	16	1	
		4					
	* 9		64	3.0	24	6	
		7					
	* 10		64	3.0	24	6	
		7					
Small bartacking	11		21	2.5	6	8	
	12		28	2.5	6		
	13		36	2.5	6		
Large bartacking	14		14	2.0	8	5	
	15		21	2.0	8		
	16		28	2.0	8		

	No.	Stitch diagram	Number of stitches	Sewing size (mm)		(Note 2) No. of work clamp foot	
				Length-wise	Cross-wise		
Linear bartacking	17		28	21	0	10	1
							2
							3
		18		36	0	25	1
			2				
			3				
		19		41	0	25	6
			7				
		20		44	0	25	6
			7				
	21		44	0	35	6	
		7					
	22		44	0	35	(Note 3)	
Lengthwise bartacking	23	(Top)  (Bottom)	9, 10	28	20	4.0	1
	24	(Top)  (Bottom)					2
	25	(Top)  (Bottom)					3
	26	(Top)  (Bottom)					4
Lengthwise linear bartacking	27	(Top)  (Bottom)	11	18	20	0	1
	28	(Top)  (Bottom)					2
	29	(Top)  (Bottom)					3
	30	(Top)  (Bottom)					4

- (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.  
 5. Presser foot attached with a sign is available by special order.



	No.	Stitch diagram	Number of stitches	Sewing size (mm)		(Note 2) No. of work clamp foot
				Length-wise	Cross-wise	
Semilunar bartacking	31		52	7	10	
	32		63	7	12	
	33		24	6	10	
	34		31	6	12	
	35		48	10	7	
	36		48	10	7	
Large size bartacking	37		90	3	24	6
						7
Knit goods bartacking	38		28	2	8	5
Round bartacking	39		28	12		
	40		48			

	No.	Stitch diagram	Number of stitches	Sewing size (mm)		(Note 2) No. of work clamp foot	
				Length-wise	Cross-wise		
Lengthwise bartacking	41		29	20	2.5		
	42		39	25	2.5		
	43		45	25	2.5		
	44		58	30	2.5		
	45		75	30	2.5		
	46		42	30	2.5		
	Radial tacking	47		91	8		
		48		99			
		49		148			
		50		164			

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**TABLE OF THE WORK CLAMP FOOT**

No. of work clamp foot	1	2	3	4	5
Work clamp foot	13518659 (asm.)			13548557 (asm.)	13542964 (asm.)
Feed plate	14116107	14116404 (without knurl)	14116800 (without knurl)	14116305	14116206
Application code	S	F	F	H	M
Finger guard*	13533104				
Remarks	Standard accessory for S (standard) type machine head.	Option (3)	Standard accessory for F (foundation) type machine head. (1)	Option	Standard accessory for M (knit and knitting fabric) type machine head.

No. of work clamp foot	6	7	8	9	10	11	12
Work clamp foot	13548151 (asm.)		13542451 (asm.)	13571955 (asm.)		13561360 (asm.)	14137509 (Light) 14137608 (Left)
Feed plate	13548003	13554803	14116602	14116503 (without knurl)	14116909 (without knurl)	14116701 (without knurl)	14137707 (without knurl)
Application code	S	H	S	F	F	F	F
Finger guard*	13548300		13533104	14135305			
Remarks	Option	Standard accessory for H (heavy-weight material) type machine head.	Option	Option (2)	For lengthwise bartacking (packed together with accessories supplied with F-type machine head) (1)	Option	Option

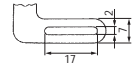
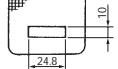
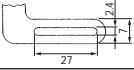
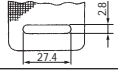
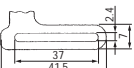
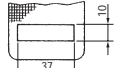
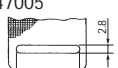
For JE: (1) Option

(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.

## WORK CLAMP FOOT AND FEED PLATE FOR LK-1902A (for belt-loop attaching)

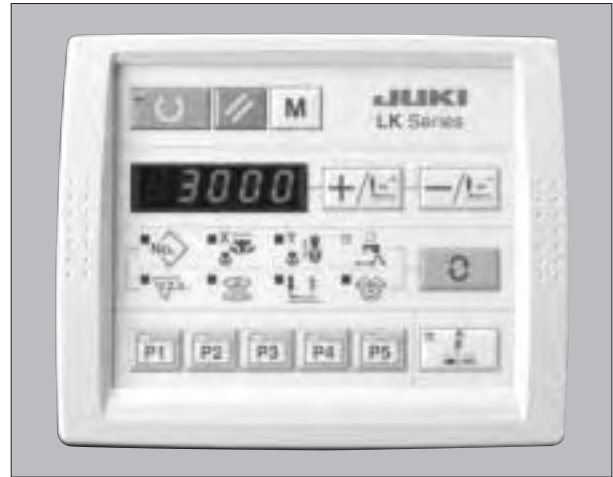
	Work clamp foot	Feed plate	Number of pattern
Provided as standard LK-1902A-SS LK-1902A-HS	13544465 	14143002 	17 18
Option For large size	13545660 	13545504 	19 20 21
Option For extra large size	13547161 	13545801 	22
		13547005 	22

\* A finger guard is included in the presser foot.

## OPERATION PANEL (You can choose operation panel.)

### STANDARD PANEL

- Functional settings, such as pattern numbers, enlargement/reduction scales, swing speeds and needle thread tensions can be established through the operation panel with ease.
- Standard sewing patterns can be assigned to pattern keys P1 to P50. Any of the sewing patterns assigned to the P1 to P25 pattern keys can be activated with a touch of the corresponding key. This means that workability is improved by assigning 25 sewing patterns that are most frequently used to those pattern keys.
- As many as 20 different cycle sewing patterns, each of which combines a maximum of 30 different sewing patterns, can be stored in the memory.
- The operation panel has been installed at an angle and can be placed at the top, bottom, right or left part of the table according to the operator's preference.



### IP-200B

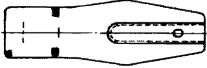
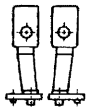

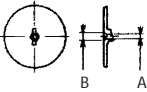
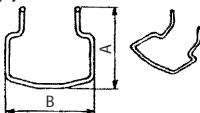
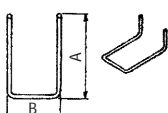
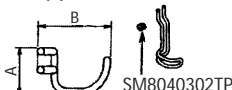
- A large color LCD touch panel has been adopted for the display. It gives clear displays that allow the operator to understand operating procedures.
- The IP-200B panel can be connected to a personal computer and can store data on SmartMedia. This allows data to be exchanged or shared among sewing machines installed in a factory or among remote factories.
- The IP-200B panel has been provided with a process improvement supporting feature through the indication of the operational state of the sewing machine, and a maintenance and management feature for indicating the needle changing timing and cleaning timing.



LK-1900A-SS/Installation of the IP-200B



## TABLE OF THE OPTIONAL PARTS

Name of parts	Type	Part No.
<b>Feed plate blank</b>  t=1.2	Without knurl	14120109
	With knurl	14120307
	Without knurl/stainless steel t=0.8	14120505
<b>Work clamp foot face plate (asm.)</b> 	Face plate for presser blank	14121263
<b>Presser blank</b>  t=3.2	With knurl/Processed (right)	14121701
	With knurl/Processed (left)	14121800
<b>Needle hole guide</b> 	A=1.6 B=2.6 With relief slit Standard type	B2426280000
	A=1.6 B=2.0 Without relief slit F and M types	D2426282C00
	A=2.3 B=4.0 Without relief slit for heavy-weight material	14109607
	A=2.7 B=3.7 Without relief slit for extra heavy-weight material	D2426MMCK00
<b>Finger guard (1)</b> 	A=56.5 B=64	13533104
	A=59 B=74 For extra-large bartacking	13548300
<b>Finger guard (2)</b> 	A=66.5 B=43 For lengthwise bartacking	13573407
<b>Finger guard (3)</b> 	A=21.5 B=35.5 For specially ordered work clamp	14120000

### ● Foot pedal for standing work (optional)



### ● 2-pedal unit for standing work\* [Part No. M85205800A0]

### ● Pedal switch conversion cable asm. [Part No. M90125900A0]



### ● PK-57\* [Part No. GPK570010B0]

### ● Pedal switch conversion cable asm. [Part No. M90135900A0]

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

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## WHEN YOU PLACE ORDERS

### ● Machine head

(Bartacking)

LK1900A  S000

Application	Code	Work clamp foot	Code	Attachment	Code
Standard	S	Standard	S	Not provided	000
For heavy-weight materials	H				
For foundation	F				
For knits and knitted materials	M				
With large hook for heavy-weight materials	W				

(Eyelet buttonhole bartacking)

LK1901A  SS000

Application	Code	Work clamp foot	Code	Attachment	Code
Standard	S	Standard	S	Not provided	000

(Belt-loop attaching)

LK1902A  S000

Application	Code	Work clamp foot	Code	Attachment	Code
Standard	S	Standard	S	Not provided	000
For heavy-weight materials	H				

### ● Control box

Operation panel	Code
Standard panel	SS
IP-200B	PB

MC596

Power supply		Code
3-phase	200 ~ 240V	E
	200 ~ 240V	K
Single-phase	CE 200 ~ 240V (not provided with power switch)	N

## 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

LK185      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

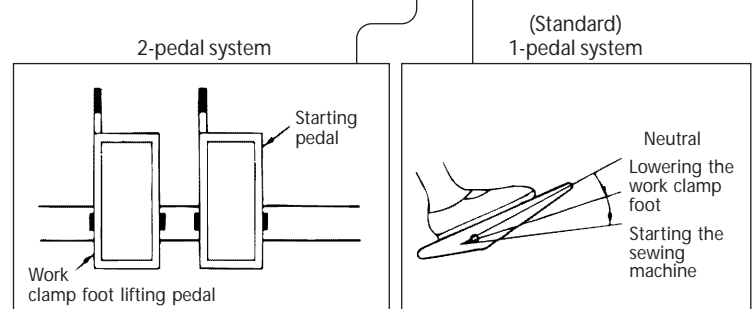
Subclass number
Refer to the subclass machines list

### \*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:

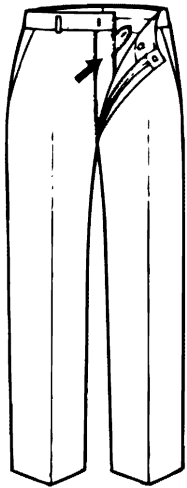
The work clamp foot is raised or lowered by the lever system in accordance with the amount of pedal depression. This feature is very advantageous for a process that requires accurate positioning of the material.



## 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	

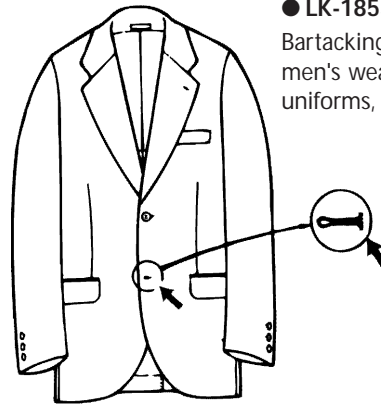
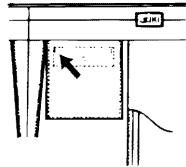


- LK-1850
- LK-1852-5
- LK-1853-15
- LK-1854-24

Large bartacking for men's wear, ladies' wear, children's wear, work wear, jeans, etc. Various types of extra large bartacking

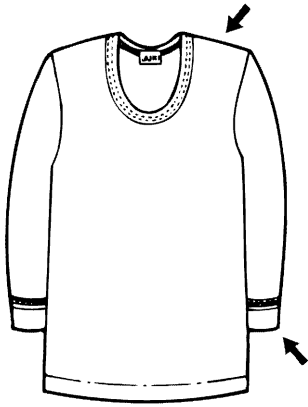
- LK-1852-2
- LK-1854-11

Small size bartacking for men's wear, coats, etc.



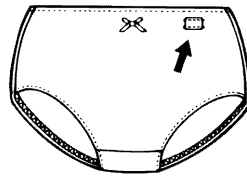
- LK-1852-1
- LK-1854-4
- LK-1853-16

Bartacking eyelet buttonholes for men's wear, ladies' wear, school uniforms, coats, etc.



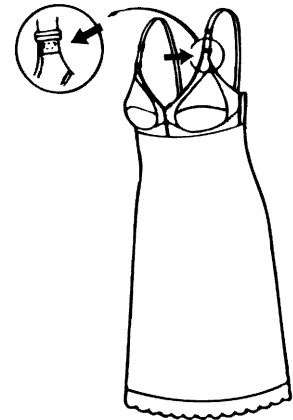
- LK-1852-3
- LK-1854-6
- LK-1852-22

Bartacking for light-weight materials, including knit underwear.



- LK-1854-8

Attaching various kinds of labels.

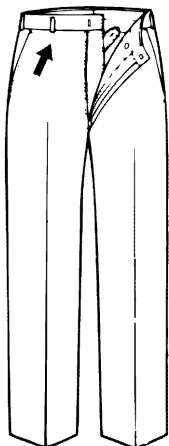


- LK-1854-12

Attaching straps to ladies' under gaments and semicircular bartacking on them.

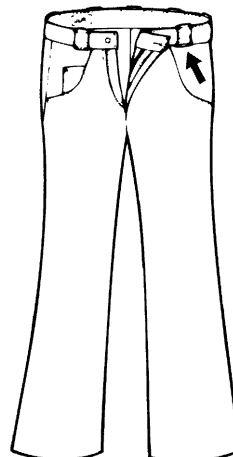
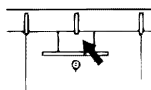
- LK-1854-24

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

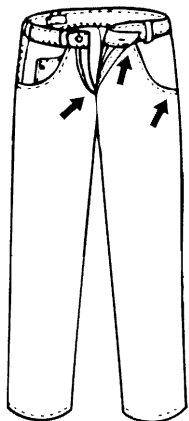
Attaching wide belt-loops to jeans, etc.

## 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

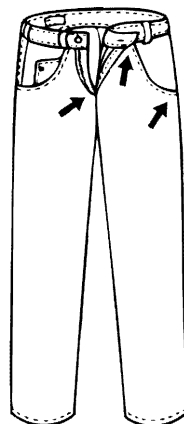
## APPLICATIONS



- 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 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 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

LK19         Z

Model		Code
Intermediate presser	Input function	
Not provided	Not provided	10
Provided	Not provided	20
Provided	Provided	30

Application	Code
Standard	S
For heavy-weight materials	H

Feeding frame	Code
Magnet-driven feeding frame	S
Pneumatic separately driven feeding frame	A

Subclass	Code
Standard	5000
Subclass	5001 ~

### ● Control box

MC59

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 power switch)	M

### ● Table stand: optional

JTK

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.

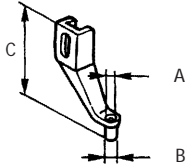



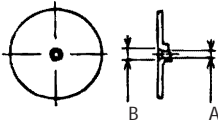
## FEEDING FRAME INTERCHANGEABILITY

: 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	
	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		

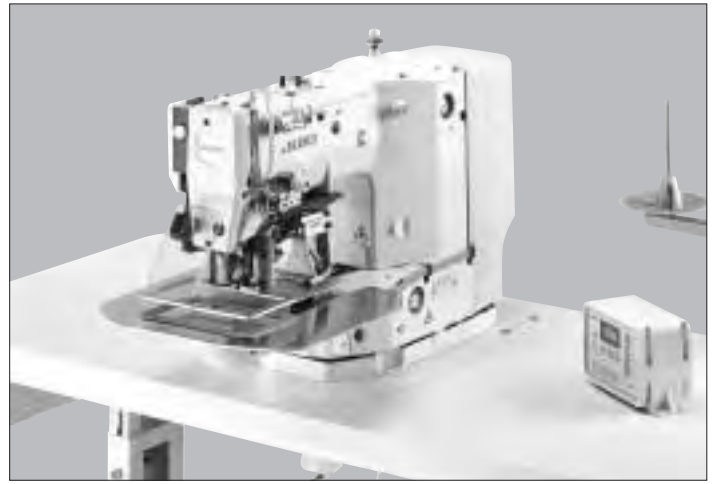
**Computer-controlled Shape-tacking Machine  
with Full-rotary 3 fold-Capacity Hook**  
Sewing area: 60mm (L) × 100mm (W)

**LK-1941ZA** (for extra heavy-weight materials  
with heat cutter)

**LK-1942HA** (for heavy-weight materials  
with intermediate presser)

**LK-1942GA** (for extra heavy-weight materials  
with intermediate presser)

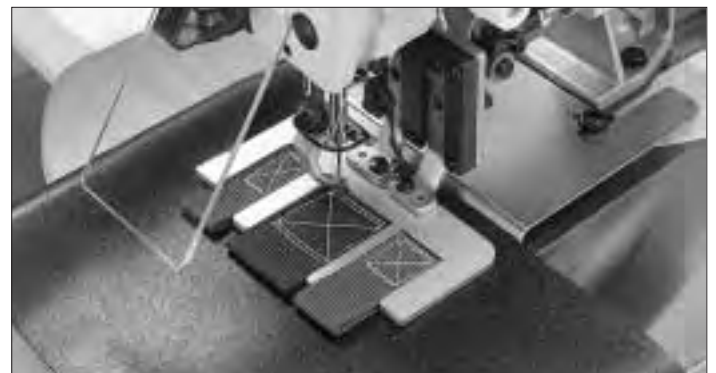
- With its new electronic feed system, the operator can select and use the sewing pattern entered. When changing a sewing pattern, the conventional mechanical bartacking machine requires the replacement of a feed cam. Since the new electronic machine no longer uses a feed cam, this operation is no longer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



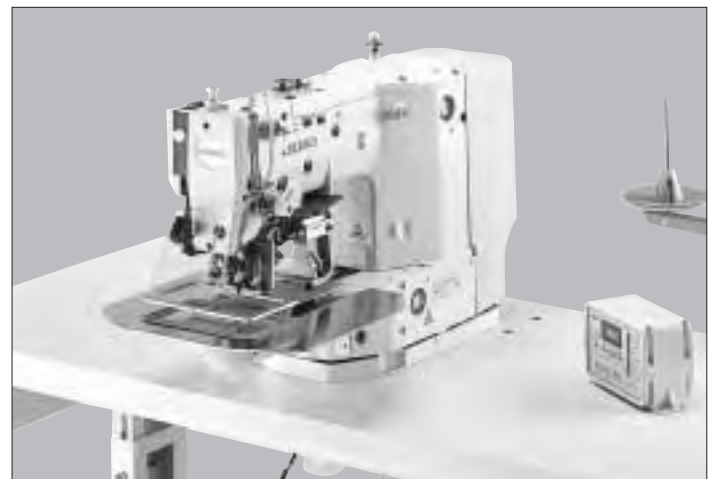
LK-1941ZA



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 heat cutter, without intermediate presser)

LK1941ZA □ □ □ □ Z

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

Subclass	Code
Standard	5000
Subclass	5001 ~

(without heat cutter, with intermediate presser)

LK1942 □ A □ □ □ □ Z

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

Subclass	Code
Standard	5000
Subclass	5001 ~

### ● Control box

MC594 □ □ F

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

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










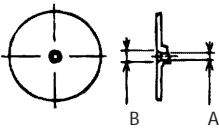
### ● Table stand: optional

JTK35

\* The table stand is not equipped with casters.

Pedal switch	Code
1-pedal unit	F

## 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, High-speed, Lockstitch Buttonholing Machine LBH-1790

- The hollowed type frame promises efficient sewing of vertical buttonholes. The machine can be operated with its head positioned horizontally.
- 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).
- Thanks to our advanced dry-head technology, no lubrication is required except for the hook section. This eliminates oil stains on the sewing product.



LBH-1790S

### SPECIFICATIONS

Sewing speed	Max.: 4,200rpm, Normal: 3,600rpm
	When the non-lubricated hook (optional) is used: 3,300rpm
Needle bar stroke	34.6mm
Size of cloth cutting knife	6.4 ~ 31.8mm (1/4" ~ 1-1/4")
Bartacking width	Max. 5.0mm (with special-specification part: Max. 10mm*)
Buttonhole length	Max. 41mm (optional: 70mm, 120mm)
Precision of needle throwing mechanism	0.05mm
Needle thread tension	Active tension (electronic thread tension control system)
Number of stitches	Automatically computed from the size of the buttonhole and stitch pitch
Needle (at the time of delivery)	DP × 5 (#11J) #11J ~ #14J
Hook	DP type, full-rotary hook
	Non-lubricated hook (optional)
Lift of the work clamp	14mm (17mm when the reverse-rotation needle-up function is used)
Auto-lifter	Provided as standard (stepping motor type)
Needle throwing drive system	Driven by stepping motor
Cloth feeding knife drive system	Intermittent feed by stepping motor
Cloth cutting knife drive system	By double-acting solenoid
Number of standard patterns	30 patterns
Number of patterns that can be input	Max. 99 patterns
Bobbin thread winder	Built-in the machine head
Machine head drive system	Compact AC servomotor (direct-drive system)
Power requirement / Power consumption	Single-phase 220V, 230V, 240V · 3-phase 200 ~ 240V/600VA
Lubrication	Only the hook section needs a minute-quantity lubrication. * No lubrication is required when the non-lubricated hook (optional) is used.
Lubricating oil	Hook: JUKI New Defrix Oil NO.1 (equivalent to ISO VG7)
Total weight	112kg

\* The special-specification part is available on a special order. Contact our branch or office in your area.

### WHEN YOU PLACE ORDERS

[Machine head]

[Control box]

**LBH1790S**

Model		Type	Code
Knife width	Code	Standard	S
6.4 ~ 31.8mm	0		

**MC601**

Power supply		Code	Operation panel		Code
Single-phase	220 ~ 240V	K	Standard panel	SS	
3-phase	200 ~ 220V	E	IP-200A	PA	
For CE Single-phase (Not provided with power switch)		230V	N		

● The machine is provided as standard with as many as 30 stitch patterns for buttonholing.

① Square	② Round	③ Radial square	④ Radial	⑤ Radial straight bartacking	⑥ Radial taper bartacking	⑦ Eyelet square	⑧ Eyelet radial	⑨ Eyelet straight bartacking	⑩ Eyelet taper bartacking
⑪ Semilunar	⑫ Round square	⑬ Semilunar square	⑭ Semilunar straight bartacking	⑮ Semilunar taper bartacking	⑯ Eyelet semilunar	⑰ Eyelet round	⑱ Square radial	⑲ Square semilunar	⑳ Square round
㉑ Square straight bartacking	㉒ Square taper bartacking	㉓ Radial semilunar	㉔ Radial round	㉕ Semilunar radial	㉖ Semilunar round	㉗ Bartacking	㉘ Bartacking, right cut	㉙ Bartacking, left cut	㉚ Bartacking, center cut

**OPERATION PANEL (You can choose operation panel.)**

**STANDARD PANEL**

- All kinds of data can be entered on or selected from the operation panel.
- Various data, such as pattern numbers and stitch shapes are indicated on the LCD section with easy-to-understand pictographs.



**IP-200A**

- A large color LCD touch panel has been adopted for the display. It gives clear displays that allow the operator to understand operating procedures.
- The IP-200A panel can be connected to a personal computer and can store data on SmartMedia. This allows data to be exchanged or shared among sewing machines installed in a factory or among remote factories.
- The IP-200A panel has been provided with a process improvement supporting feature through the indication of the operational state of the sewing machine, and a maintenance and management feature for indicating the needle changing timing and cleaning timing.



Communication screen



SmartMedia card

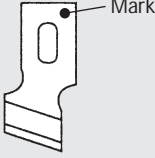
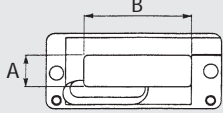


Connected to a personal computer



## OPTIONS

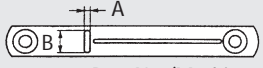
### ● Cloth cutting knife, Work clamp

Knife size	Cloth cutting knife			Work clamp		Work clamp foot	
							
	Part No.			Part No.	Part No.		Part No. <Type>
	Mark			(Length of cloth cutting knife) <Type> ( A × B )	(Length of cloth cutting knife) <Type> ( A × B )		
Mark			(Length of cloth cutting knife) <Type> ( A × B )	(Length of cloth cutting knife) <Type> ( A × B )			
6.4mm (1/4")	B2702-047-F00		F	B1552-781-000-A (6.4 ~ 19.1mm) <1> (4×25mm)	145-24409 (6.4 ~ 31.8mm) <3> (6×41mm)	D1511-771-KA0 <1>	
9.5mm (3/8")	B2702-047-K00-A		K				
11.1mm (7/16")	B2702-047-I00		I				
12.7mm (1/2")	B2702-047-L00-A		L				
14.3mm (9/16")	B2702-047-V00		V				
15.9mm (5/8")	B2702-047-M00-A		M				
17.5mm (11/16")	B2702-047-A00		A				
19.1mm (3/4")	B2702-047-N00		N				
22.2mm (7/8")	B2702-047-P00		P	B1552-782-000 (6.4 ~ 25.4mm) <2> (5×35mm)		D1511-772-KA0 <2>	
25.4mm (1")	B2702-047-Q00-A		Q				
31.8mm (1-1/4")	B2702-047-S00-A		S	B1552-783-000 (6.4 ~ 31.8mm) <3> (5×41mm)		D1511-773-KA0 <3> SS-6060210-SP (2 pcs.)	

Factory installed on machine

Supplied as an accessory (For LBH-1790S)

### ● Throat plate

For needle throwing width		Part No. (Marking: A×B)
5mm		400-04350 (S5: 1.4×6.2mm)
6mm		400-04351 (S6: 1.4×7.4mm)

Factory installed on machine

Designation	Part No.	Name of part	Features	
Non-lubricated hook	400-06345	RP hook (asm.)	By the installation of non-lubricated hook, the machine is changed to be a fully dry-head machine. (In this case, the maximum sewing speed will be 3,300rpm.)	
	400-06349	RP bobbin case		
	137-29603	Hook sleeve (asm.)		
	SS-8660612-TP	Screws		
Work clamp (For sewing length of 70 mm, 120mm)	400-06340	Work clamp arm spacer	Exclusive to 70mm	
	SM-6040450-TP (3 pcs.)	Screws		
	145-23252	Work clamp foot 70 (asm.)		Selectable
	145-23401	Work clamp 70		
	145-23708	Urethane work clamp 70		
	145-24102	Flat work clamp 70	Exclusive to	
	400-08646	Work clamp foot 120 (asm.)		
	400-08658	Work clamp 120		
	400-06335	Work clamp arm 120		Common to 70 mm and 120 mm
	400-06339	Cloth feeding plate 120		
	400-06341	Close cam 120		
	400-06342	Lifting plate 120		
	SM-6050800-SP (2 pcs.)	Screws		
SS-6060210-SP (2 pcs.)	Screws			
Electric bobbin winder	G5001-198-0A0-A	Electric bobbin winder (asm.)	It is a device for winding bobbin separately.	
	400-05405	Power cord (asm.)		
	B3221-771-0A0	Tension controller (asm.)		
	SK-3452000-SC (4 pcs.)	Wood screws		
2-pedal unit for standing work	GPK-510010B0	Pedal switch (asm.)	-	
	400-03493	Junction cable (asm.)		

#### Non-lubricated hook



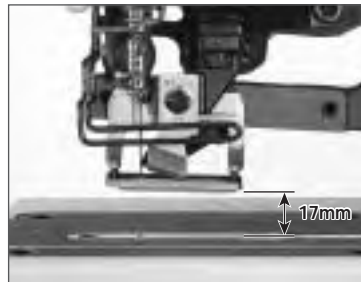
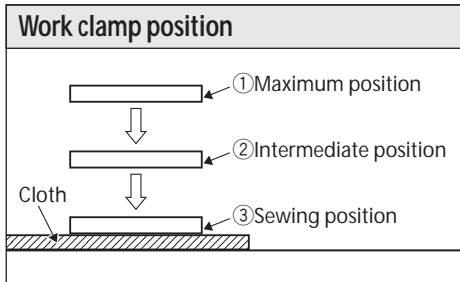
Bobbin case

Hook (asm.)

Hook sleeve

● Explanation of pedal motion

Pedal motion	Pedal type		
	2-pedal	1-pedal (without intermediate position)	1-pedal (with intermediate position)
Initial position	②Intermediate position	①Maximum position	①Maximum position
Setting of sewing product	Presser goes up as high as the pedal toe down amount of the left side pedal. Presser comes down when the left side pedal is depressed. ③Sewing position	The first step of the right side pedal ③Sewing position	The first step of the right side pedal ②Intermediate position The second step of the right side pedal ③Sewing position
Start of sewing	The right side pedal is depressed.	The second step of the right side pedal	The third step of the right side pedal
End of sewing	②Presser automatically goes up to intermediate position.	①Presser automatically goes up to maximum position.	①Presser automatically goes up to maximum position.



## 1-needle, Lockstitch Buttonholing Machine

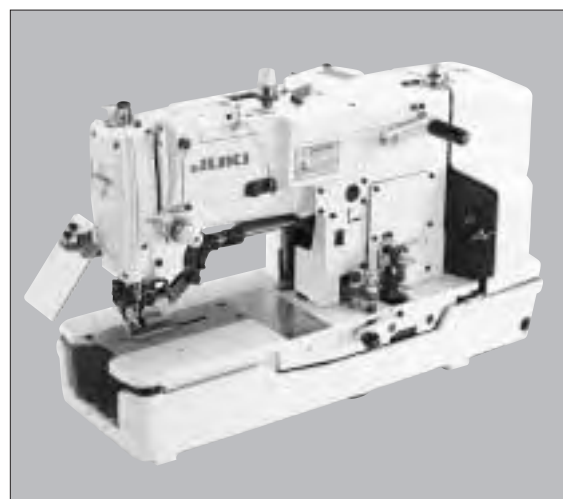
### LBH-780 SERIES

- 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 x 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

LBH78   U

	Model	Code
Knife width	6.4 ~ 19.1mm	1
	6.4 ~ 25.4mm	2
	6.4 ~ 31.8mm	3
	12.7 ~ 38.1mm	4

Subclass machines	Code
Standard	/
For knits	K

### ● NV Type

LBH78  NV

	Model	Code
Knife width	9.5 ~ 25.4mm	2
	9.5 ~ 31.8mm	3
	12.7 ~ 38.1mm	4

Stitch formation	Code
Square-type bartacking	/
Round-type bartacking	1

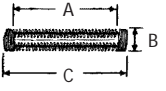




### ● NB Type

LBH78  NB

	Model	Code
Knife width	11.5 ~ 25.4mm	2
	11.5 ~ 31.8mm	3
	12.7 ~ 38.1mm	4

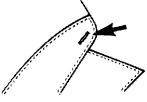
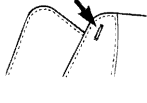
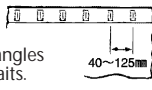
Stitch formation	Code
Square-type bartacking	/
Round-type bartacking	1

## LIST OF THE 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
			B	2.5 ~ 4.0	B	2.5 ~ 5.0	B	2.5 ~ 5.0	B	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	

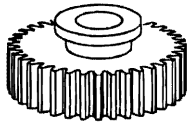
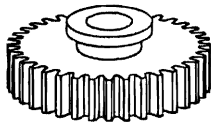
\* 1...Dimension A: 9.5 ~ 25.4mm \* 2...Dimension A: 9.5 ~ 31.8mm \* 3...Dimension A: 11.5 ~ 25.4mm \* 4...Dimension A: 11.5 ~ 31.8mm

## OPTIONS


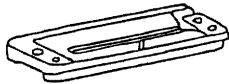

Model	Part No.	Description	Feature
Q060	MAQ-060000A0	Men's shirts 	Spacer for first buttonholes This is a ruler to be used to set the first buttonhole at a predetermined position in accordance with the shape of the collar.
Q061	MAQ-061000A0	Ladies' blouses 	Adjustable regardless of the dimensions and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

### ● 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.

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**

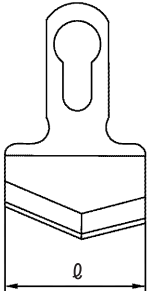
Model name	MBH-180	MBH-180S	MBH-180L
Application	Standard buttonholing process for shirts	Decorative buttonhole process for men's upper garments	Various label attaching processes
Max. sewing speed	3,300rpm		
Sewing size	6.4 ~ 34.9mm (1/4" ~ 1-3/8")	* 6.4 ~ 22.2mm (1/4" ~ 7/8")	6.4 x 38.1mm (1/4" ~ 1-1/2")
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



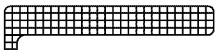
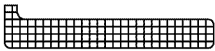


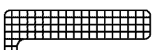

Size	Part No.	For knit **
6.4mm (1/4")	B2701-180-F00	B2701-180-FOA
9.5mm (3/8")	B2701-180-K00	B2701-180-KOA
12.7mm (1/2")	B2701-180-L00	B2701-180-LOA
14.4mm (9/16")	B2701-180-V00	B2701-180-VOA
15.9mm (5/8")	B2701-180-M00 *	B2701-180-MOA
19.1mm (3/4")	B2701-180-N00	B2701-180-NOA
22.2mm (7/8")	B2701-180-P00	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

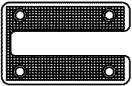
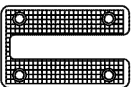
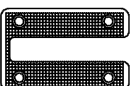
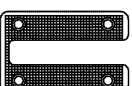
\*\* Special order parts

## ● 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 Trimmer for Needle and Looper Thread with Gimp

**MEB-3200SS** (for men's and ladies' wear)

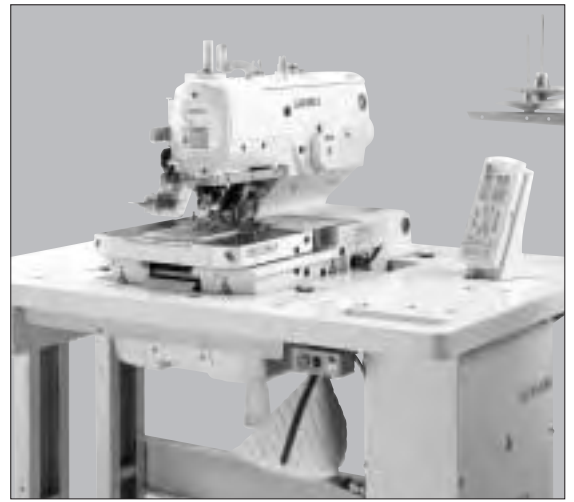
**MEB-3200RS** (for combined use for lateral and longitudinal buttonholing:  
for men's and ladies' wear)

**MEB-3200JS** (for jeans)

**MEB-3200CS** (for cotton pants and working wear)

**MEB-3200TS** (for trousers)

- 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-3200JS



MEB-3200SS

## SPECIFICATIONS

Model name	MEB-3200SS	MEB-3200RS	MEB-3200JS	MEB-3200CS	MEB-3200TS
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	For trousers
Thread trimming style	Longer remaining thread		Shorter remaining thread		Shorter thread cutting without gimp
Stitch system	1-needle, double chainstitch (with gimp)				1-needle, double chainstitch (without 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	10 ~ 34mm Compensating work clamp S, 24mm for eyelet buttonholes: standard
Needle throwing width (at the time of delivery)	2.0 ~ 3.2mm*		2.6 ~ 4.0mm*	2.0 ~ 3.2mm*	2.0 ~ 3.2mm
	(2.3mm)		(2.5mm)	(2.5mm)	(2.3mm)
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 stepping motor				
Cloth cutting knife drive system	Vertically driven by stepping motor				
Needle (at the time of delivery)	DO x 558 (Nm100) Nm90 ~ Nm110		DO x 558 (Nm120) Nm110 ~ Nm120	DO x 558 (Nm110) Nm110 ~ Nm120	DO x 558 (Nm100) Nm100 ~ Nm110
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 (TS model is excluded)



## WHEN YOU PLACE ORDERS (COMPLETE)

MEB3200   S    

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
For trousers*	T

\* When the sewing specification category T (trousers) is selected, A is the only option category available for selection (needle thread clamp device).

Table stand	Code
Standard	S




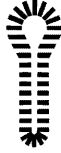




Power supply		Code
Single-phase	220 ~ 240V	K
3-phase	220 ~ 240V	D
	220 ~ 415V	L
Single-/3-phase	220 ~ 415V (for CE)	M

Option	Code
Not provided	Z
Needle thread clamp device	A
Multi-cutting device Needle thread clamp device*	M

\* When option category M (multi-cutting device, needle thread clamp device) is selected, S is the only sewing specification category available for selection (men's and ladies' wear).

## EYLET SHAPES AND STRAIGHT BUTTONHOLE SHAPES

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

							
*	**	**	**	*	*	*	*
	Buttonhole with a 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
<b>Eyelet buttonhole</b>				<b>Straight buttonhole</b>			

\* 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	T	
Throat plate A (standard)	320-42715			-	-	-	Nm90 ~ Nm110
Throat plate B (for semi-wide stitch bite)	320-42913			-	-	-	Nm90 ~ Nm110
Throat plate C (for wide stitch bite)	320-43010			-	-	-	Nm90 ~ Nm110
Throat plate D (for narrow stitch bite)	320-43218			-	-	-	Nm90 ~ Nm110
Throat plate JA (standard)	320-43424	-	-				Nm120 ~ Nm130
Throat plate JB (for semi-wide stitch bite)	320-42830	-	-				Nm90 ~ Nm110
Throat plate JC (for wide stitch bite)	320-43135	-	-				Nm90 ~ Nm110
Throat plate JD (standard)	320-43622	-	-				Nm90 ~ Nm100
Throat plate JE (standard)	320-43523	-	-				Nm110 ~ Nm120
Throat plate JF (standard)	320-43325	-	-				Nm90 ~ Nm100
Throat plate TE	320-43713	-	-	-	-	-	Nm100 ~ Nm110

## ● Work clamp, complete

Part name	Part No.	Application				
		S	R	J	C	T
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	T
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	T
For eyelet buttonhole 40mm	140-10003					
For eyelet buttonhole 32mm	140-59505					
For eyelet buttonhole 22mm	140-59703					
For straight buttonhole 40mm	140-13909			-	-	
Compensating work clamp H, 40mm for eyelet buttonholes	140-58804					
Compensating work clamp M, 32mm for eyelet buttonholes	320-28607					
Compensating work clamp S, 24mm for eyelet buttonholes	320-28201					

## ● Presser support plate

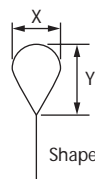
Presser support plate (left)						
Part name	Part No.	Application				
		S	R	J	C	T
Presser support plate for eyelet buttonholes	320-27104			-	-	-
Presser support plate J, M for eyelet buttonholes	320-28904	-	-			-
Presser support plate C, S for eyelet buttonholes	320-28508	-	-			-
Presser support plate L for eyelet buttonholes	320-29100	-	-			-
Presser support plate for straight buttonholes	320-29506			-	-	-
Presser support plate for eyelet buttonholes	140-11506	-	-	-	-	-
Presser support plate for straight buttonholes	140-13700	-	-	-	-	-

Presser support plate (right)						
Part name	Part No.	Application				
		S	R	J	C	T
Presser support plate for eyelet buttonholes	320-27005			-	-	-
Presser support plate J, M for eyelet buttonholes	320-28805	-	-			-
Presser support plate C, S for eyelet buttonholes	320-28409	-	-			-
Presser support plate L for eyelet buttonholes	320-29001	-	-			-
Presser support plate for straight buttonholes	320-29407			-	-	-
Presser support plate for eyelet buttonholes	140-11407	-	-	-	-	-
Presser support plate for straight buttonholes	140-13601	-	-	-	-	-

## ● Cloth cutting knife

For eyelet buttonhole								
Part No.	Shape (mm)		Max. cutting length (mm)	Application				
	X	Y		S	R	J*	C*	T*
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					
320-66904	2.7	5.1	38					-

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*	T*
140-41404	0	0	38					-
320-65302	0	0	24					
320-65401	0	0	32					

## ● Knife guard

For eyelet buttonhole (standard)★						
Size (mm)	Part No.	Application				
		S	R	J*	C*	T*
38	320-67209					-
36	320-67308					-
34	320-67407					-
32	320-67506					
30	320-67605					
28	320-67704					
26	320-67803					
24	320-67902					
22	320-68009					
20	320-68108					
18	320-68207					
16	320-68306					
14	320-68405					
12	320-68504					
10	320-68603					

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

Standard type Hardness of the knife guard is high (heat-treated)

Hardness of the knife guard is low (not heat-treated)

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

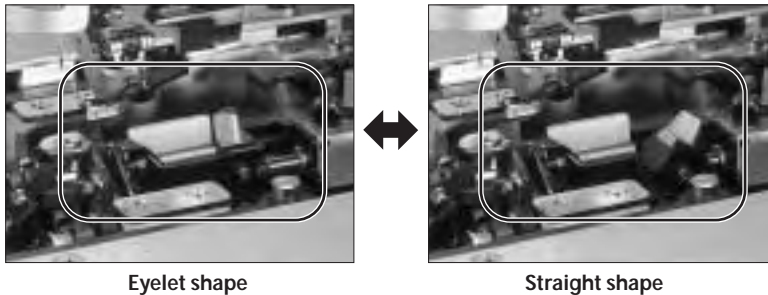
\* For the J, C, T type, use cloth-cutting knife and knife guard that are equal in length to the maximum sewing length or shorter. (Maximum sewing length S: 24mm, M: 32mm, L: 40mm)

## ● Left looper, left spreader

Applicable zigzag width (mm)	Left looper	Left spreader	Application				
	Part No.	Part No.	S	R	J	C	T
2.0 ~ 3.2	320-40800	320-40917					
2.6 ~ 4.0	140-30902	140-31116					-

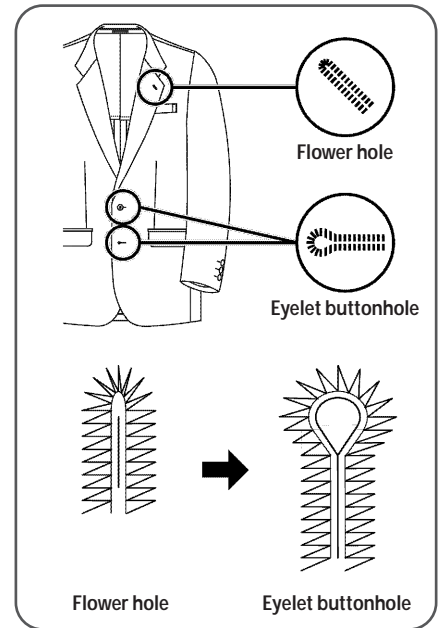
## MULTI-CUTTING DEVICE

- The multi-cutting device incorporates a separate cloth cutting knife with two sections of blade --- one intended for the eyelet sections of buttonholes and one intended for straight sections. When sewing men's wear, the machine can sew eyelet buttonholes on a front body and straight buttonholes on a lapel without changing the knife. Conventionally, two different types of buttonholing machines are required for these processes. By performing two different kinds of buttonholing, the MEB-3200SS M halves the time required for the setup procedure, including color thread changing. The end result is increased productivity.
- By dropping the knife two or more times per cycle, the machine can sew buttonholes of various sizes without changing the knife guard (18mm to 38mm for eyelet buttonholes and 10mm to 38mm for straight buttonholes). The machine is best suited for small-lot production of ladies' wear subject to frequent design changes.



Eyelet shape

Straight shape

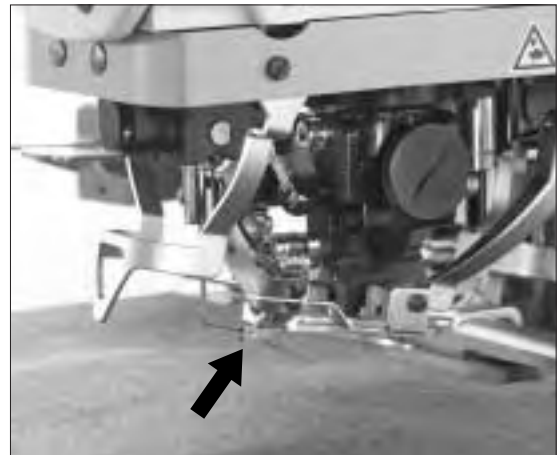


Flower hole

Eyelet buttonhole

## NEEDLE THREAD CLAMP DEVICE

- MEB-3200 S A, provided with a needle thread clamp device.
- The needle thread clamp device eliminates the thread securing procedure by tucking the needle thread in the finished seams.
- The needle thread clamp device retains the needle thread to ensure neat seam formation from the very first stitch.  
\* The needle thread clamp device can be retrofitted to the machine. Optional part: Part No.: 320-24465

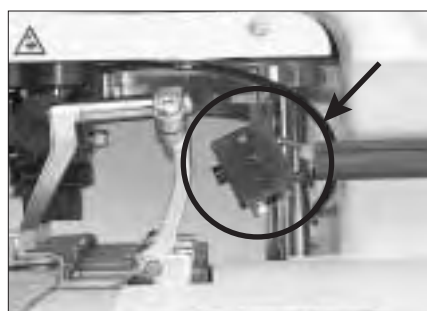


## OPTIONS

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-OAA	Pedal switch, asm.	The work clamp can be lifted/lowered and the machine can be stand using the pedal switch.
M9014-620-OA0	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-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

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### SPECIFICATIONS

Model name	CB-638	CB-640	CB-641
Stitch type	Single-thread chainstitch/Blindstitch (stitch type 103)		
Max. sewing speed	2,500rpm		
Stitch length	3 ~ 8mm		
Feed system	Top-feed		
Differential-feed ratio			
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	3mm (fixed)		
Penetration depth	Max. 0.8mm		
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
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:

**CB641/K060/S090/T003**

Model No. of machine	Auto-open hemmer	Thread controller	Manual thread cutter

## Pinpoint Saddle Stitching Machine

# MP-200N

- In addition to balloon-stitching (to produce seams with a hand-stitched touch), smooth sewing of chain-off stitches, and having other outstanding seam quality features of the highly regarded Columbia 100, the MP-200N achieves more improved sewing capabilities and a wider adjustment range.
- The machine comes with a box type feed that permits a split adjustment in both horizontal and vertical directions, thereby responding to the sewing of various types of materials. Additionally, the inclination of the feed dog is also adjustable in accordance to the material.
- Needle gauges support, using replacement parts, stitch widths from as narrow as 1.2mm to as wide as 5.0mm.
- The applicable range of yarn counts has been widened from #60 to #8 (B33, Nm = 120/3) for both Tetron and spun thread. This allows the machine to be used for topstitching a wider range of items.



MP-200NL

## SPECIFICATIONS

Model name		MP-200NS	MP-200NL
Max. sewing speed		2,000rpm (feed pitch 6mm or less) 1,500rpm (feed pitch 6 ~ 8mm) 1,200rpm (feed pitch 8 ~ 10mm)	1,500rpm (feed pitch 6 ~ 8mm) 1,200rpm (feed pitch 8 ~ 10mm)
Pinpoint stitch width (needle gauge)		1.6mm (2.0 mm: Spacer is required to be changed with the one supplied with the machine)	5.0mm
Length of thread that appears on the right side of sewing product (reference)		1.1mm	4.5mm
Feed pitch		3.5 ~ 10mm	10mm (For the needle gauge of 5 mm)
Recommended feed pitch		3.5 ~ 10mm (feed pitch that is larger than double of needle gauge is recommended)	
Applicable range of gauges		1.2 ~ 2.5mm (for 1.2 and 2.5mm, optional parts are required)	3.0 ~ 5.0mm (for 3 and 4mm, optional parts are required)
Needle (at the time of delivery)	Needle	SCHMETZ 29C150 (Nm90) Nm80 ~ Nm140	ORGAN CP x 1J (#22U) #18U ~ #22U
	Hook-needle	SCHMETZ 29C151 (Nm100) Nm80 ~ Nm140	ORGAN CP x 12J (#23) #19 ~ #30
	Recommended thread	Tetron · Spun	Tetron · Spun
	Recommended yarn count	#60 ~ #30, B33 ~ B46, Nm=120/3 ~ 60/3	#30 ~ #8, B46 ~ B92, Nm=60/3 ~ 30/3
Recommended material/process		Wool, lining/facing-topstitching process	Flannel/topstitching peripheries of collars and pockets
Lift of the presser foot		By hand: 5.5mm/By knee: 10.5mm	
Split adjustment of feed (vertical/horizontal direction)		Possible	
Lubrication		By an oiler	
Lubricating oil		JUKI New Defrix Oil No.2 (equivalent to ISO VG32)	

## WHEN YOU PLACE ORDERS

MP200N

Needle gauge	Code
1.6mm	S
5.0mm	L

## WIDER RANGE OF APPLICABLE NEEDLE GAUGES AND YARN COUNTS

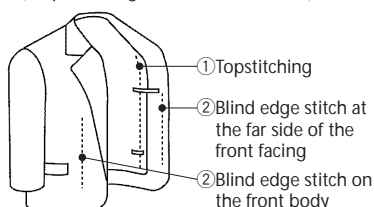
Model name	Needle gauge	Gauge *	Applicable yarn count
MP-200NS (Needle gauge 1.6mm)	1.2mm	Option	Tetron, Spun #60~#30, B33~B46, Nm=120/3~60/3
	1.6mm	Provided as standard	
	2.0mm	To be replaced with the needle clamp spacer supplied with the machine	
	2.5mm	Option	
MP-200NL (Needle gauge 5.0mm)	3.0mm	Option	Tetron, Spun #30~#8, B46~B92, Nm=60/3~30/3
	4.0mm	Option	
	5.0mm	Provided as standard	

\* Refer to "Replaceable parts of gauges" for a correspondence between gauges and needle gauges.

## USES OF PINPOINT STITCHING

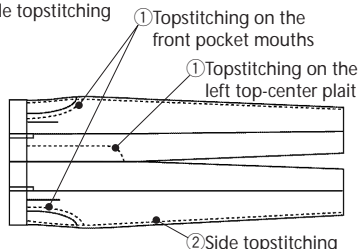
### ●Men's coats and jackets

- ① Topstitching on the front facing
- ② Blind edge stitch at the far side of the front facing, and blind edge stitch on the front body (for preventing uneven material feed)



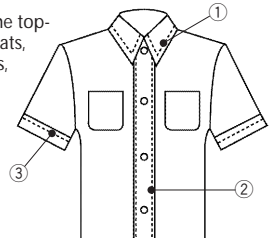
### ●Trousers

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



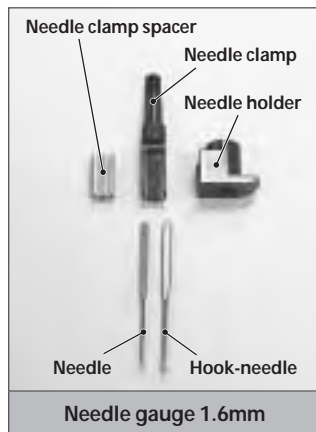
### ●Miscellaneous

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

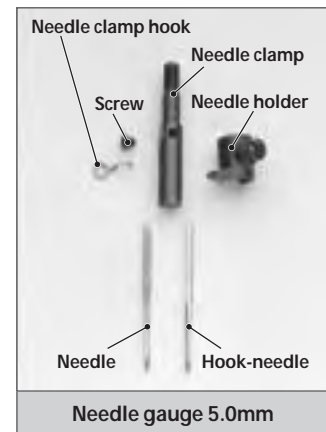


## REPLACEABLE PARTS OF GAUGES

Replaceable parts			S type (1.6mm, standard)				L type (5.0mm, standard)			Remarks
			1.2 mm	1.6 mm	2.0 mm	2.5 mm	3.0 mm	4.0 mm	5.0 mm	
Part No.	Description	Quantity								
231-24100	Needle clamp S	1							S type, common	
231-24308	Needle clamp spacer (1.2mm)	1							S type, exclusive to 1.2mm	
231-24407	Needle clamp spacer (1.6mm)	1							S type, exclusive to 1.6mm	
231-24506	Needle clamp spacer (2.0mm)	1							S type, exclusive to 2.0mm	
231-24605	Needle clamp spacer (2.5mm)	1							S type, exclusive to 2.5mm	
231-24803	Needle clamp (3mm)	1							L type, exclusive to 3.0mm	
231-24902	Needle clamp (4mm)	1							L type, exclusive to 4.0mm	
231-25008	Needle clamp (5mm)	1							L type, exclusive to 5.0mm	
231-24209	Needle holder S	1							S type, common	
SS-8090540-SP	Screw	1							S type, common	
231-25107	Needle holder (3mm)	1							L type, exclusive to 3.0mm	
231-25206	Needle holder (4mm)	1							L type, exclusive to 4.0mm	
231-25305	Needle holder (5mm)	1							L type, exclusive to 5.0mm	
SS-7090530-SP	Needle clamp screw	1							L type, common	
231-25404	Needle clamp hook	1							L type, common	
SS-5060310-SP	Screw	1							L type, common	
231-22658	Presser S (asm.)	1							S type, common	
231-22757	Presser L (asm.)	1							L type, common	
231-23003	Throat plate (1.4 × 3.0)	1							S type, exclusive to 1.2mm	
231-23102	Throat plate (1.6 × 4.2)	1							S type, common to 1.6~2.0mm	
231-23201	Throat plate (1.6 × 4.7)	1							S type, exclusive to 2.5mm	
231-23300	Throat plate (2.2 × 5.6)	1							L type, exclusive to 3.0mm	
231-23409	Throat plate (2.2 × 6.6)	1							L type, exclusive to 4.0mm	
231-23508	Throat plate (2.2 × 7.6)	1							L type, exclusive to 5.0mm	
231-25750	Spreader fitting base (asm.)	1							S type, common/L type 3.0mm	
231-38209	Spreader (JC1023)	1							S type, common	
SM-4020301-SC	Screw	1							S type, common/L type 3.0mm	
231-25800	Spreader (3mm)	1							L type, exclusive to 3.0mm	
231-25909	Spreader (4mm)	1							L type, exclusive to 4.0mm	
231-26006	Spreader (5mm)	1							L type, exclusive to 5.0mm	
231-36104	Looper clank	1							S type, common	
231-21502	Looper clank B	1							L type, common	
SM-8060612-TP	Screw	2							Common to types and sizes	



Part number of gauge set	Description	Standard specifications
231-24357	Needle gauge size 1.2mm S set	Standard specifications
Not prepared	Needle clamp spacer (accessory parts)	Standard specifications
231-24654	Needle gauge size 2.5mm S set	Standard specifications
231-24861	Needle gauge size 3.0mm L set	Standard specifications
231-24960	Needle gauge size 4.0mm L set	Standard specifications
Not prepared		Standard specifications



Standard parts for S and L types (gauge set is not prepared)
Accessory parts for S type (gauge set is not prepared)
Parts to be purchased (included in a gauge set) at the time of changing sizes
Parts not to be purchased (not included in a gauge set) at the time of changing sizes since they are included in S or L type machine as accessories.

## OPTIONS

### Needle bar crank

\*In order to be applicable to a wider range of materials, various types of needle bar cranks with different thread take-up timings have been prepared.

Part No.	Thread take-up timing	Type	Remarks
231-21106	Standard	Standard timing (provided as standard)	
231-21205	Standard - 10 °	Type timing, of which is earlier than that of the standard needle bar crank by 10°	Thread is applied with a higher tension as compared with the standard needle bar crank
231-21304	Standard + 10 °	Type timing, of which is later than that of the standard needle bar crank by 10°	Thread is applied with a lower tension as compared with the standard needle bar crank
231-21403	Stepless setting	A Needle bar crank which has a flat shaft to permit the stepless setting of thread take-up timing. Note, however, that the needle bar stroke changes according to the thread take-up timing.	



# 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.

Computer-controlled Cycle Machine with Input Function

# AMS-210D

Sewing area: 60mm(L) x 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 Input Function for Wider-area Perfect Stitching

# AMS-210D P TYPE

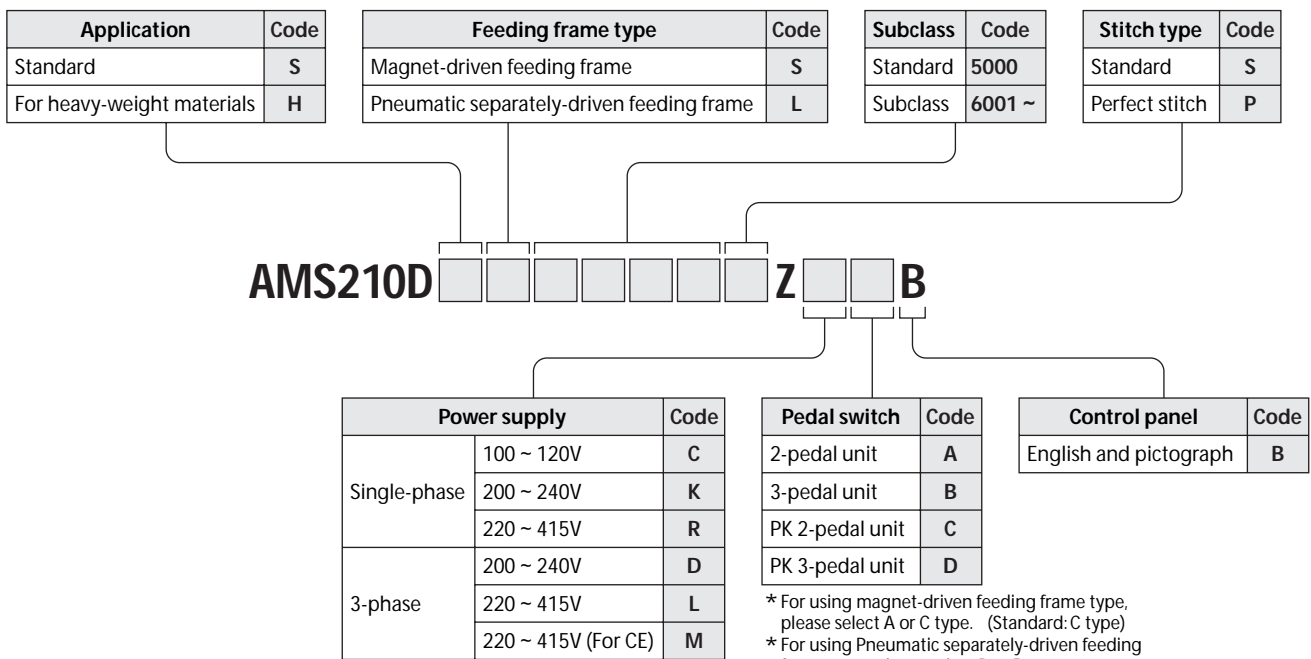
Sewing area: 60mm(L) x 130mm(W)

- 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



## 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
PM-1		Programming software for computer-controlled sewing machines	This software is to input and edit sewing data of JUKI's latest sewing machines. Its versatile input functions allow to input sewing data of each electronic sewing machine model easily, accurately, and quickly. It supports high quality production with high added value by utilizing and creating original data for specific designs and applications.
PGM-20		Programming software for computer-controlled sewing machines	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.

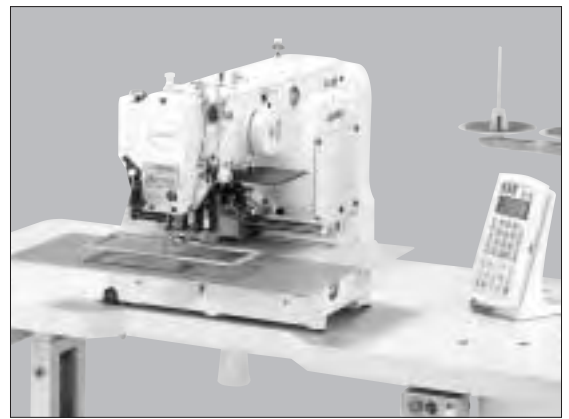
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Part No.	Description	
B1601-210-D00A	Intermediate presser A 2.2 × 3.6 × 6 × 29.5	<p>A × B × l × L</p>
B1601-210-D0BA	Intermediate presser B 2.7 × 4.1 × 6 × 29.5	
B1601-210-D0CA	Intermediate presser C 2.7 × 5.5 × 6 × 29.5	
B1601-210-D0E	Intermediate 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)	

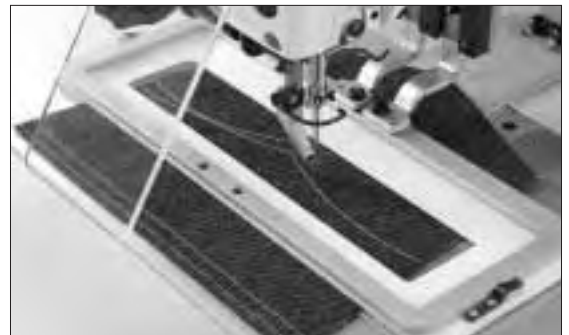
Computer-controlled Cycle Machine with Input Function  
for Topstitching Jean Pockets

**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.



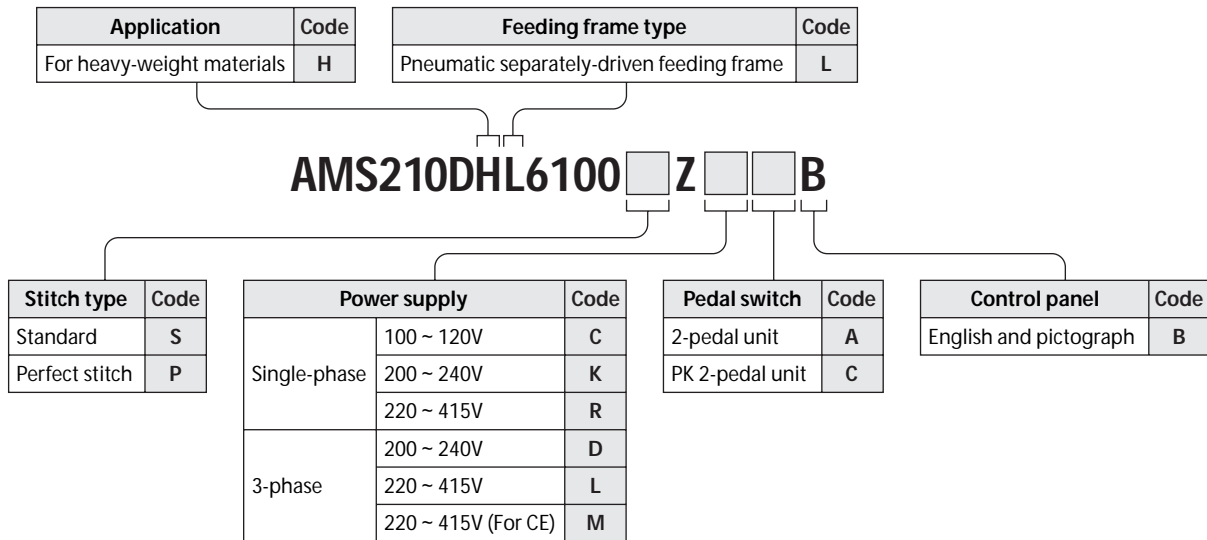
AMS-210DHL6100SZ



**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



## 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
PM-1		Programming software for computer-controlled sewing machines	This software is to input and edit sewing data of JUKI's latest sewing machines. Its versatile input functions allow to input sewing data of each electronic sewing machine model easily, accurately, and quickly. It supports high quality production with high added value by utilizing and creating original data for specific designs and applications.
PGM-20		Programming software for computer-controlled sewing machines	The PGM-20 is provided with many different input functions to permit interactive data creation, free from difficulties, using a general-purpose personal computer or digitizer.
	B5019-222-0B0 PJ-0320525-03 PJ-0205000-02 B4717-223-C00 BT040-025-1EB BT060-040-1EB B4712-215-OA0 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.
	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 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

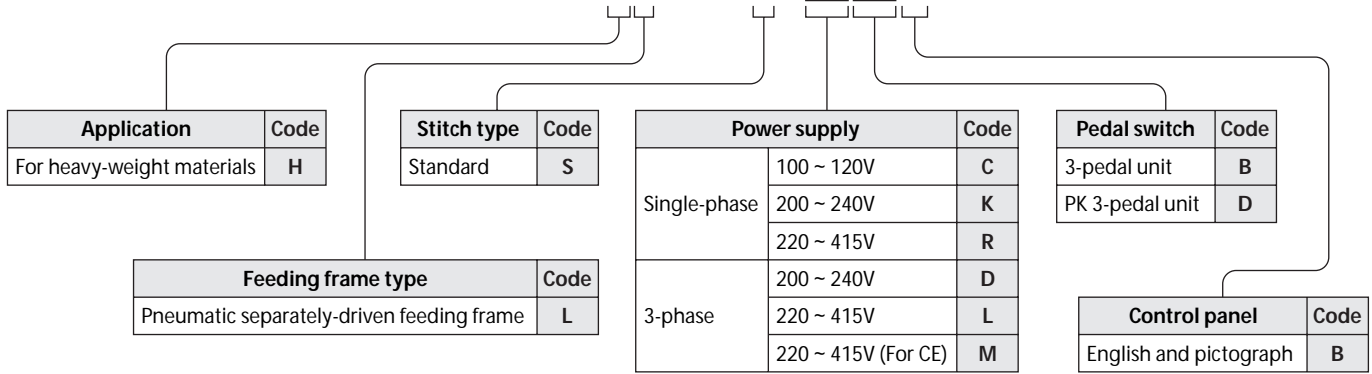


**SPECIFICATIONS**

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

# AMS210DHL6300SZ 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
PM-1		Programming software for computer-controlled sewing machines	This software is to input and edit sewing data of JUKI's latest sewing machines. Its versatile input functions allow to input sewing data of each electronic sewing machine model easily, accurately, and quickly. It supports high quality production with high added value by utilizing and creating original data for specific designs and applications.
PGM-20		Programming software for computer-controlled sewing machines	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 x 2 SS-6151812-TP WP-0641601-SD x 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	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.
	B2594-210-DA0	Cassette holder (asm.)	
	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.



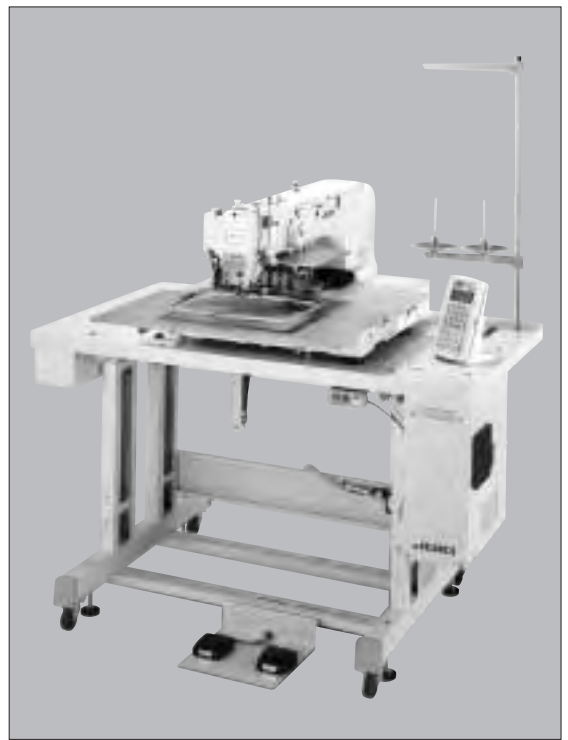
Computer-controlled Cycle Machine with Input Function

**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 Input Function for Wider-area Perfect Stitching

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

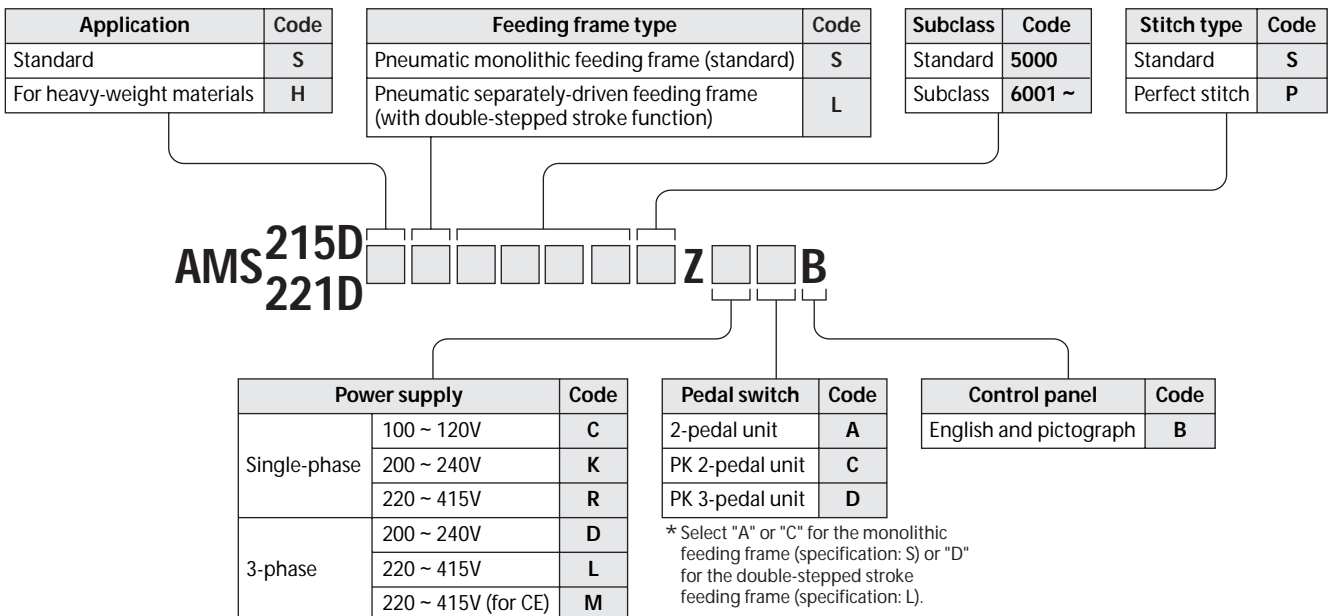
**AMS-221D P TYPE** Sewing area: 160mm(L) × 250mm(W)

- 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)			

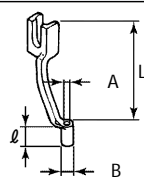
## PROGRAMMING FUNCTIONS

- 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
PM-1		Programming software for computer-controlled sewing machines	This software is to input and edit sewing data of JUKI's latest sewing machines. Its versatile input functions allow to input sewing data of each electronic sewing machine model easily, accurately, and quickly. It supports high quality production with high added value by utilizing and creating original data for specific designs and applications.
PGM-20		Programming software for computer-controlled sewing machines	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 × 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 B4720-221-DB0	Needle thread clamp device Junction cord Needle cooler	This device prevents the thread from tangling at the start of sewing.
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 × 2 SS-6150610SP × 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.

Part No.	Description	
B1601-210-D00A	Intermediate presser A	2.2 × 3.6 × 6 × 29.5
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
B2587-220-000	Work clamp paper material (A)	 A × B × l × L
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)	



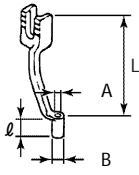
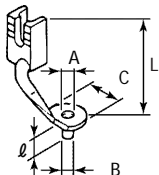
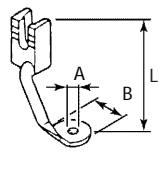

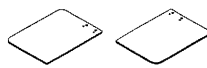
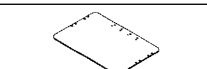


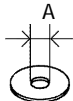
## SPECIFICATIONS

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	 $A \times B \times l \times L$	
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		 $A \times B \times C \times l \times L$
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)		
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-223	
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)		
			AMS-224

## 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.

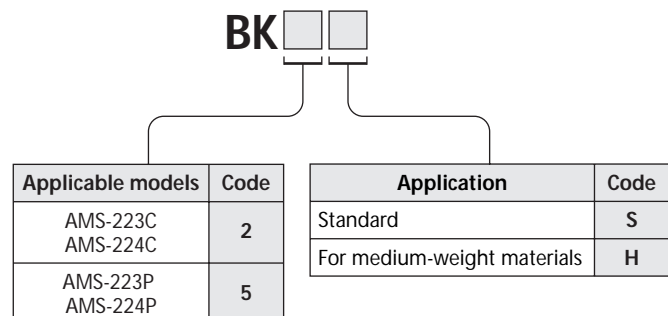


AMS-223C/BK2

## 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

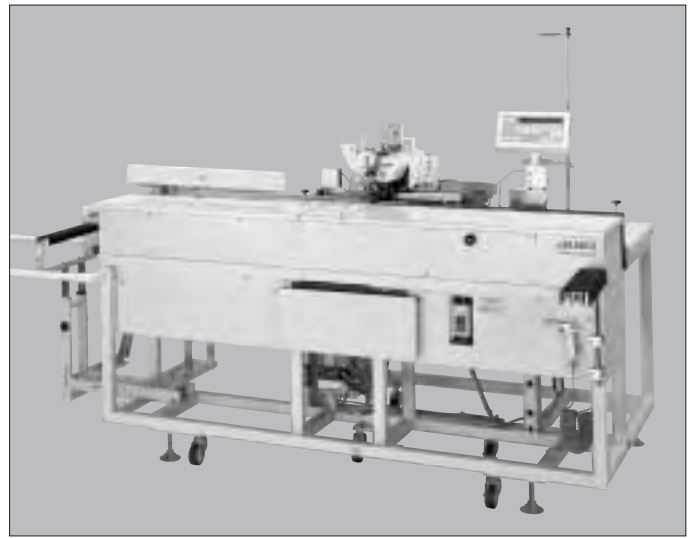
## WHEN YOU PLACE ORDERS



**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

ACF1641800

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

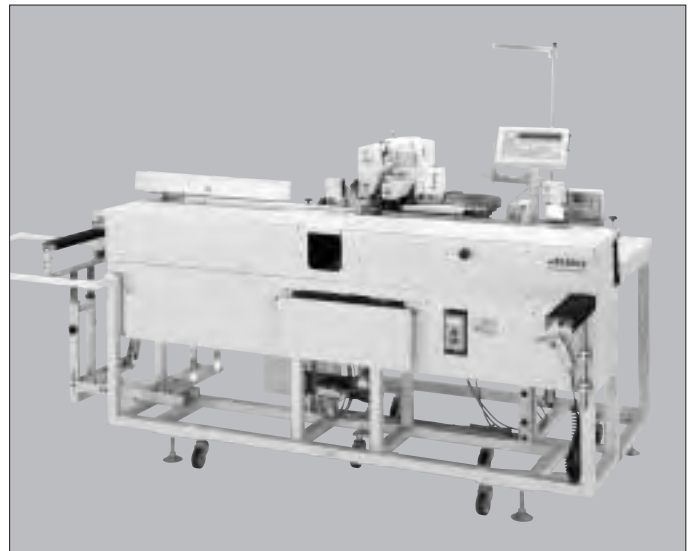
Model	Part No.	Description	Feature
	G5510-164-0A0	Auxiliary feed plate	This part feeds heavy sewing products such as finished garments with great reliability.
	G5508-164-0A0	Clamp for light-weight materials	This part clamps easy-to-slack materials such as light cottons and silks to ensure reliable feeding.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

### ACF1641903

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.

## 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

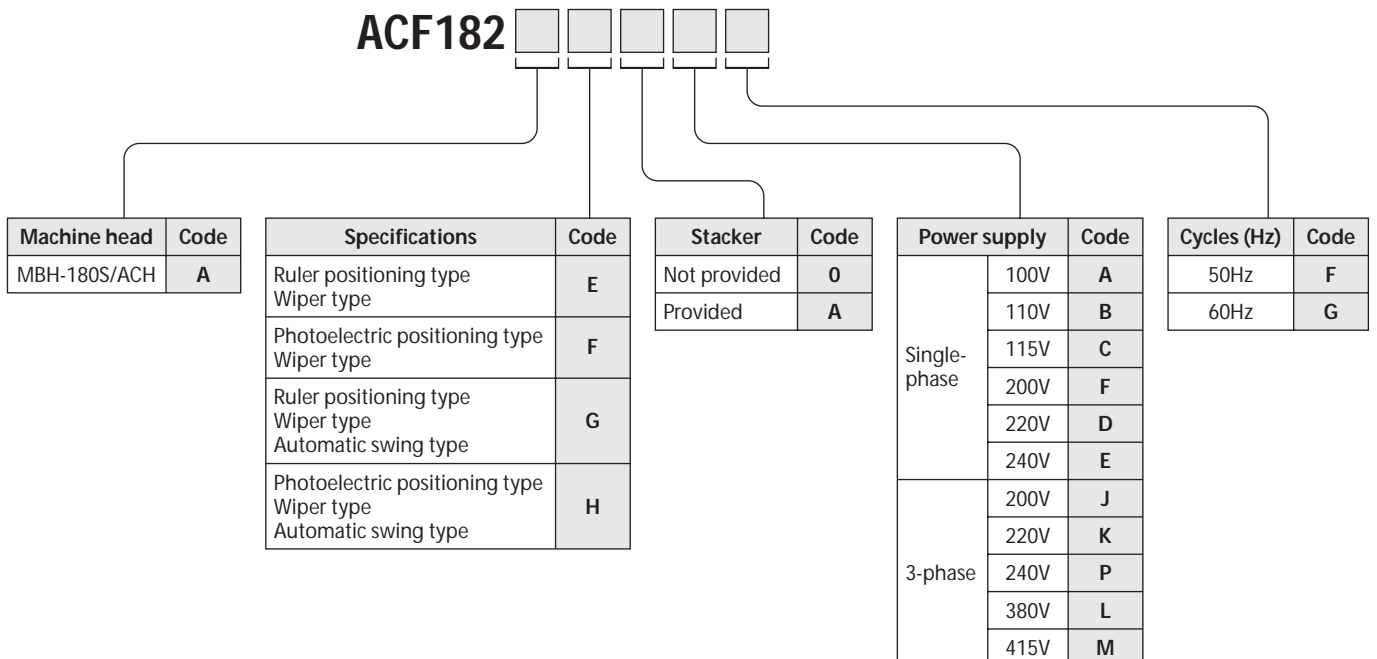


ACF-182



## WHEN YOU PLACE ORDERS

### ACF182



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.

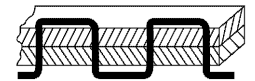


FLS-350NA

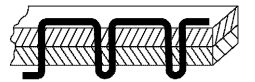
**SPECIFICATIONS**

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)	<ul style="list-style-type: none"> <li>● Handstitching thread: FUJIX's New Wax Silk (for light-weight materials)</li> <li>● Synthetic thread: FUJIX's KING FIT #60</li> </ul>	<ul style="list-style-type: none"> <li>● Synthetic thread: ONUKI LIMITED. ACE CROWN (Tetoron) #8</li> </ul>
	#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	

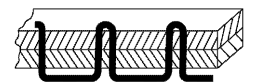
**TYPES OF STITCHES**



Saddle stitch

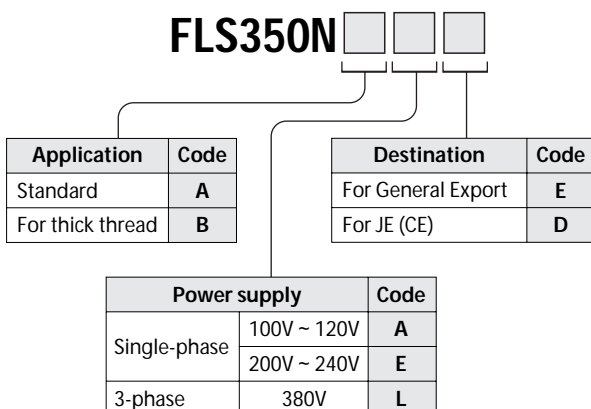


Long and short stitch



Short and long stitch

**WHEN YOU PLACE ORDERS**



**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	

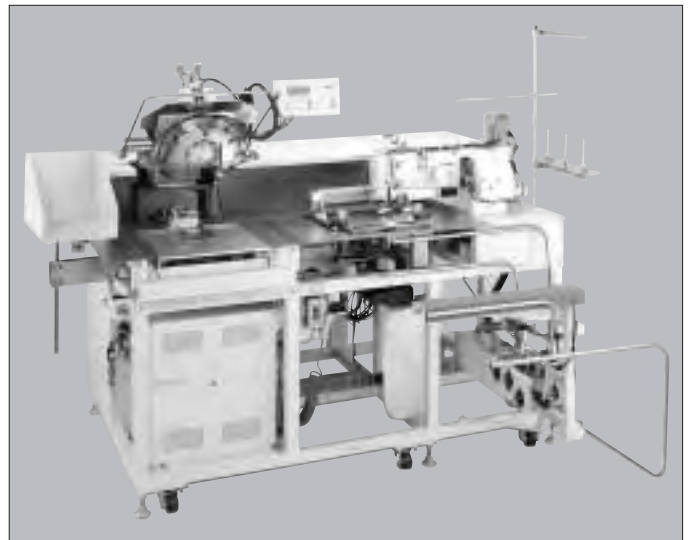
## Automatic Pocket Setter (for jeans)

# AVP-875S

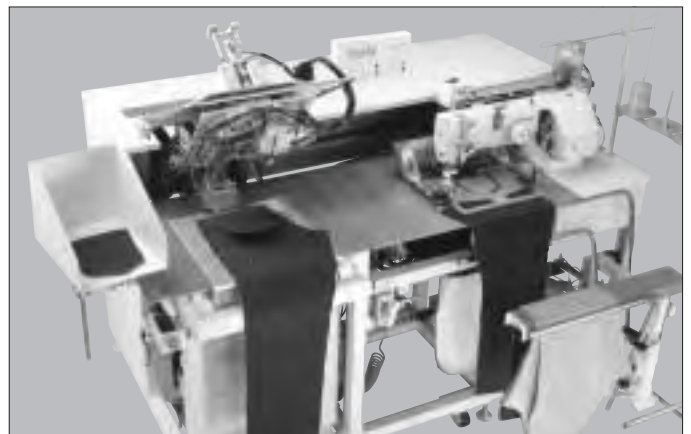
- The machine automates a series of pocket-setting processes, concurrently folding and sewing sequential pocket cloths in the production line, thereby resulting in substantial labor savings. With its newly developed large-hooked zigzag stitching lockstitch machine head, the machine runs at a maximum 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/removal. 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 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	
Dimensions	<p>(Unit: mm)</p>	

\* The automatic bobbin thread winding and feeding device (AW-2) cannot be mounted on the AVP-875S after setup.

## WHEN YOU PLACE ORDERS

AVP875         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 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)

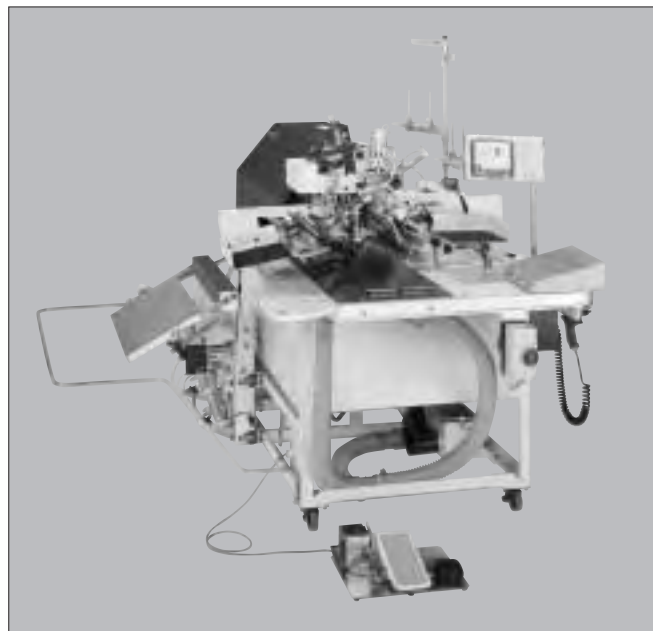
**Automatic Pocket Welting Machine  
with Automatic Welting Patch Feeder**

**APW-297** (for straight pocket with flap)

**APW-297B** (for sewing bottoms)

**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-297B	APW-298
		For straight pocket with flap	For sewing bottoms	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 center knife	2-needle, needle-feed, lockstitch machine with an organized split needle bar and 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 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
Standard: Automatic welting patch feeder (right)	R
SA102 Welting patch cutting device	A

Stacker	Code
Not provided	Z
SP44 Clamp bar stacker	N
SP45 Roller stacker	P

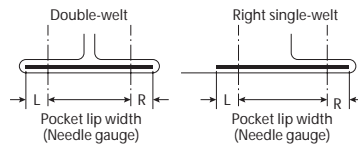
Single-welt change-over function	Code
Not provided	Z
SA111 (right)	G

Power supply		Code
Single-phase	220V	D
3-phase	220V	K
	380V	L

**APW 297  
298**

Automatic flap feeder	Code
Not provided	Z
SA103 Automatic flap feeder (left)	A
SA104 Automatic flap and pocket bag feeder (left)	B

Pocket lip width (needle gauge: mm)	Code
10	B
12	C



Option	
Name of optional device	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
SA106/SA107/SA108/SA91/SA105	K5
SA108/SA91/SA109	K6
SA105/SA106/SA109	K7
SA112 Shim device	K8
SA106/SA107/SA108/SA91/SA73	K9

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.

APW-297B (for sewing bottoms)

Automatic welting patch feeder	Code
Standard: Automatic welting patch feeder (left)	L
SA102 Welting patch cutting device (left)	B

Stacker	Code
Not provided	Z
SP44 Clamp bar stacker	N
SP45 Roller stacker	P

Single-welt change-over function	Code
Not provided	Z
SA111 (left)	H

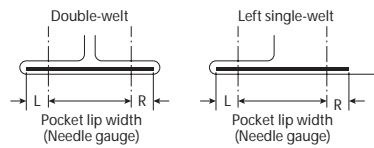
Power supply		Code
Single-phase	220V	D
3-phase	220V	K
	380V	L

APW297

Automatic flap feeder	Code
Not provided	Z
SA103 Automatic flap feeder (right)	C

Pocket lip width (needle gauge: mm)	Code
10	B
12	C

Option	
Name of optional device	Code
Not provided	ZZ
SA106 Darts stretcher	J1
SA106/SA108 Suction device	J3
SA106/SA107 Automatic pocket bag presser	J4
SA106/SA107/SA108	J7
SA106/SA107/SA108/SA91 Suction motor	J8
SA106/SA108/SA91	J9
SA106/SA116 Vacuum table	K0
SA106/SA107/SA116	K1



Welt patch and welt patch base plate							
Double-welt			Left 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	8.5	3.8	M6
12	4.8	4.8	B9	12	10.5	4.8	M7

## 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.

## Automatic Pocket Welting Machine

**APW-194N** (for without flap 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 flap 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 center knife		2-needle, lockstitch machine with organized split needle bar and 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

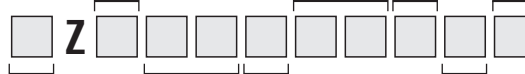
Pocket lip width (needle gauge: mm)	Code
8	A
10	B
12	C
14	D
16	E
18	F
20	G

**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.

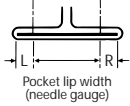
Stacker	194N	195N	196N	Code
Not provided				Z
SP41 (grasping stacker)				J
SP42 (bar stacker)				K
SP43 (roller stacker)				L
SP42+SP43 (roller bar stacker)				M

: Main stacker : Can be combined

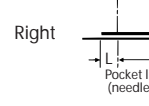
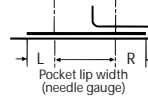
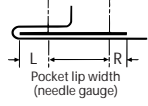
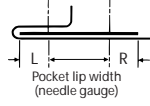
Single-welt change-over function	194N	195N*	196N	Code
Not provided				Z
SA97N left				D
SA97N right				E
SA97N both-side				F
SA98 left				L
SA98 right				R

\* 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


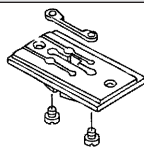
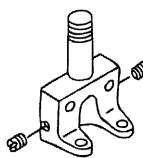



Code	Name of optional devices	APW-194N			APW-195N			APW-196N		
		Table type			Table type			Table type		
		Standard	Shim	Vacuum	Standard	Shim	Vacuum	Standard	Shim	Vacuum
ZZ	Not provided									
A2	SA84 Dart stretcher	•			•			•		
A6	SA92 Pocket bag clamping device		S							
A7	SA88 Table stand for standing work	•	•	•	•	•	•	•	•	•
A8	SA89 Small welt sewing device									
B1	SA94 Center reference device	•	•	•	•	•	•	•	•	•
B5	SA74/SA84/SA86N									
B8	SA84/SA92				•			•		
C2	SA74 Pattern-matching marking device									
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									
H2	SA88/SA89				•	•	•	•	•	•

## 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 start up 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

MOL254

Power supply		Code
Single-/3-phase	200 ~ 240V	D
	220 ~ 400V	L
	220 ~ 400V (For CE)	M

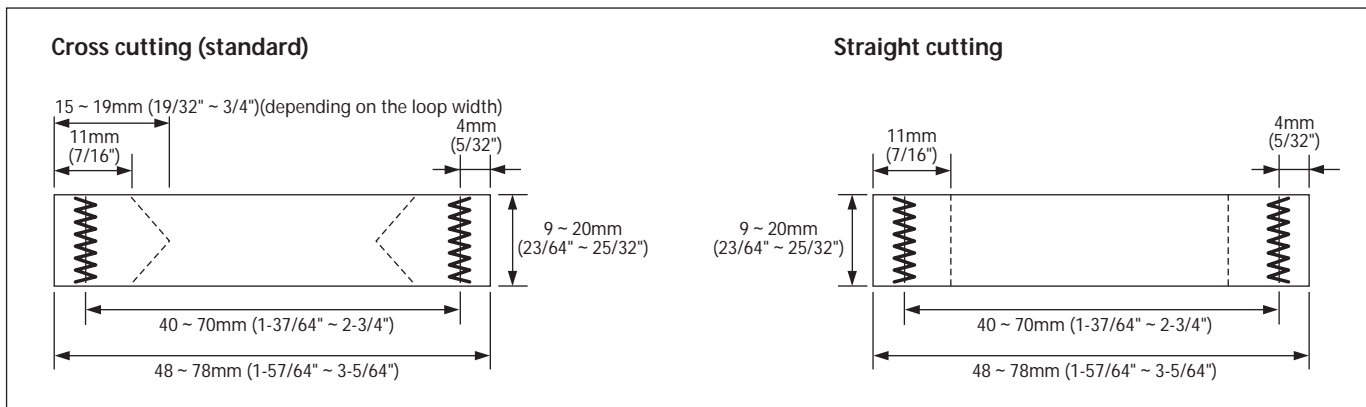
Option	Code
No options	Z
Belt-loop tension releasing device (fullness)	A
Belt-loop feeding device	B
Air gun	C
Needle cooler	D
Needle thread breakage detector	E

\* 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 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



## SPECIFICATIONS

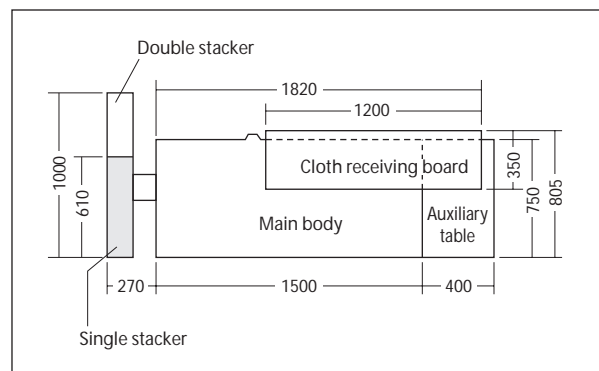
Model name	ASN-697	ASN-695
Machine head	Exclusive for MO-6904S*	
Max. sewing speed	8,000rpm	
Stitch length	0.8 ~ 4.0mm	
Lift of the presser foot	Max. 7mm	
Overedging width (mm)	4.0, 4.8, 5.6	
Needle (at the time of delivery)	DC x 27 #11 (#9 ~ #14)	
Chain-off thread trimmer	T038 (suction type side cutter)	
Sewing specifications	Cutting curve: 200R or more (40R 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.	
Power supply	Single-phase / 3-phase	
Power consumption	700W	
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: 200Nℓ /min.)
Lubrication	Automatic	
Lubricating oil	JUKI Machine Oil 18 (equivalent to ISO VG18)	
Total weight	190kg (when all the optional devices are installed: 215kg)	180kg (when all the optional devices are installed: 210kg)

\* 2-needle overlock type model is available for order. Please contact JUKI distributors or agents in your area for more information.

## FUNCTION COMPARISON TABLE

Function, device	ASN-697	ASN-695
Specifies a sewing speed	Touch panel (provided as standard)	Touch panel (provided as standard)
Speed control function	Can be set at either "automatic" or "manual"	Manual
Cloth control device	Provided as standard	Optional
Cloth feeding device	Optional	Optional
Table air blower	Provided as standard	Optional
Cloth receiving board	Provided as standard	Optional
Partial shirring function	Provided as standard	Optional
Curve detecting function (both out-curve and in-curve are detected)	Provided as standard	Not provided
Curl blower	Provided as standard	Not provided
Table lifting device	Provided as standard	Not provided
Stacker	Optional	Optional

## DIMENSIONS (mm)



## OPTIONS

Description	Part No.	Model name		Feature
		ASN-697	ASN-695	
Single stacker/SS40		Optional	Optional	The max. number of garments that can be stacked is 40 (without pedal)
Double stacker/SS42		Optional	Optional	The max. number of garments that can be stacked is 140 (without pedal)
Silencer for chain-off thread suction device	GMC08042000	Optional	Optional	For reducing the air suction noise of the chain-off thread suction unit
Table air blower	G55403950A0	Provided as standard	Optional	Air blower blows air to help facilitate the smooth feed of the material during sewing.
Cloth receiving board	40013687	Provided as standard	Optional	The table for retaining materials before they are sewn. (1200mm (L) x 350mm (W))
Cloth control device	40013694	Provided as standard	Optional	With this optional device, the machine is able to sew, at a minimum, curved sections with R40mm.
Cloth feeding device	G59253970A0	Optional	Optional	The device feeds short materials to a position where they can be stacked.
Differential feed device	40013697	Provided as standard	Optional	With this device, the machine automatically shirr desired sections of the material by programming data.
Auxiliary table	G54203970A0	Optional	Optional	The part facilitates handling of long-size materials such as slacks and white overalls.
Differential feed pedal (for ASN-697)	G54273970A0	Optional		With this part, the operator is able to manually shirr desired sections of the material.
Stacker pedal	G54253970A0	Optional	Optional	The part is used to start/stop the machine and open/close the cloth retaining bar.
2-pedal unit (for ASN-697)	G54223970A0	Optional		Stacker pedal + Differential feed pedal

\* Please refer to FUNCTION COMPARISON TABLE.

# AC SERVOMOTOR/ELECTRONIC-STOP MOTOR SERIES

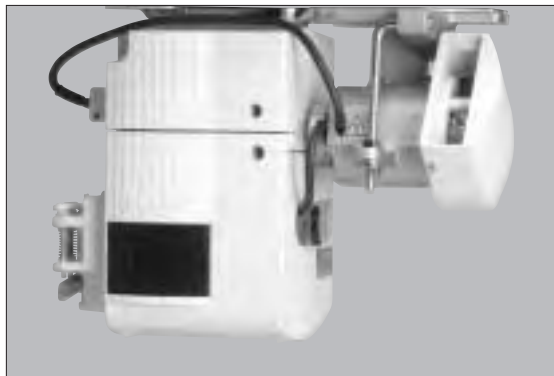
## SC-910 CONTROL BOX

### SC-910/M91 CONTROL BOX/COMPACT MOTOR UNIT

- SC-910 model control box is resistant to voltage fluctuations. It comes with a compact and energy-saving type switching power supply system that does not use a transformer. This contributes to improved reliability.
- The M91 model compact motor unit featuring low vibration and low noise capabilities is installed on the control box.
- The number of revolutions can be selected from among three different types (standard, slow and fast) according to the preference of the operator. In addition to this feature, the control box incorporates many different functions for upgraded workability.



SC-910

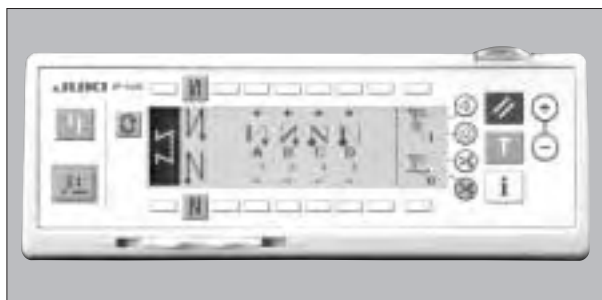


SC-910/M91

**OPERATION PANEL** The operation panel can be selected according to the process.

## IP-100

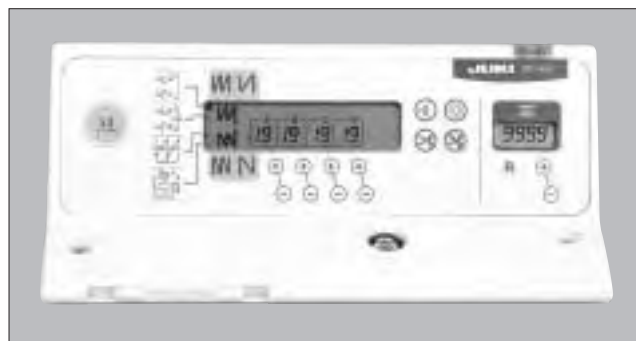
- The operation panel has been provided with a large user-friendly LCD. A pictograph and set values are shown on the same screen, which promises improved operability of the panel.
- The operation panel has been provided with a variety of communication and maintenance control features and is able to store data on a SmartMedia or personal computer.
- The features of the operation panel can be updated without the need for changing the PWB/ROM.



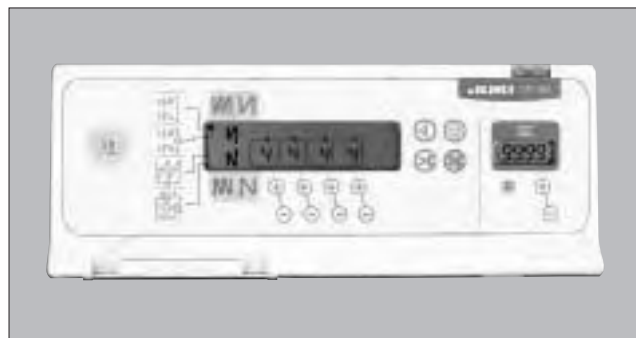
IP-100B, IP-100C

## CP-160

- Pattern sewing can be performed by the number of stitch control feature.
- Four different kinds of pattern sewing are possible: automatic reverse stitching, constant-dimension sewing, rectangle-shape sewing, and multi-layer stitching. The maximum number of stitches that can be set for automatic reverse stitching (single or double) is 19.








CP-160A



CP-160B, CP-160D

# PSC BOX/CONTROL PANEL/MOTOR FOR SC

Model name	PSC box	Motor for SC	Operation panel																
DDL-9000 DLN-9010	<p><b>SC910</b> </p> <table border="1"> <thead> <tr> <th>Control box</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>Standard</td> <td>S</td> </tr> <tr> <td>Provided with a built-in I/O board</td> <td>A</td> </tr> </tbody> </table> <p>● Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-8).</p>	Control box	Code	Standard	S	Provided with a built-in I/O board	A		<table border="1"> <thead> <tr> <th>Operation panel</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>IP-100B</td> <td>IP100B</td> </tr> <tr> <td>CP-160D</td> <td>CP160D</td> </tr> </tbody> </table>	Operation panel	Code	IP-100B	IP100B	CP-160D	CP160D				
Control box	Code																		
Standard	S																		
Provided with a built-in I/O board	A																		
Operation panel	Code																		
IP-100B	IP100B																		
CP-160D	CP160D																		
DDL-5550N-7 DDL-8700-7 DLN-5410N-7 DLU-5490N-7 DLD-5430N-7 DLM-5400N-7 DMN-5420N-7	<p><b>SC910</b> </p> <table border="1"> <thead> <tr> <th>Control box</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>Standard</td> <td>S</td> </tr> <tr> <td>Provided with a built-in I/O board</td> <td>A</td> </tr> </tbody> </table> <p>● Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-4).</p>	Control box	Code	Standard	S	Provided with a built-in I/O board	A	<p><b>M91S</b> </p> <table border="1"> <thead> <tr> <th>Pulley belt</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>Standard</td> <td>S</td> </tr> </tbody> </table>	Pulley belt	Code	Standard	S	<table border="1"> <thead> <tr> <th>Operation panel</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>IP-100C</td> <td>IP100C</td> </tr> <tr> <td>CP-160A</td> <td>CP160A</td> </tr> </tbody> </table>	Operation panel	Code	IP-100C	IP100C	CP-160A	CP160A
Control box	Code																		
Standard	S																		
Provided with a built-in I/O board	A																		
Pulley belt	Code																		
Standard	S																		
Operation panel	Code																		
IP-100C	IP100C																		
CP-160A	CP160A																		
DDL-5600N-7 DLN-5410NJ-7	<p><b>SC910</b> </p> <table border="1"> <thead> <tr> <th>Control box</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>Standard</td> <td>S</td> </tr> <tr> <td>Provided with a built-in I/O board</td> <td>A</td> </tr> </tbody> </table> <p>● Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-5).</p>	Control box	Code	Standard	S	Provided with a built-in I/O board	A		<table border="1"> <thead> <tr> <th>Operation panel</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>IP-100C</td> <td>IP100C</td> </tr> <tr> <td>CP-160A</td> <td>CP160A</td> </tr> </tbody> </table>	Operation panel	Code	IP-100C	IP100C	CP-160A	CP160A				
Control box	Code																		
Standard	S																		
Provided with a built-in I/O board	A																		
Operation panel	Code																		
IP-100C	IP100C																		
CP-160A	CP160A																		
LZ-2282N-7 LZ-2284N-7 LZ-2284NU-7 LZ-2284C-7 LH-31 -7* * Except LH-3162-7, LH-3182-7	<p><b>SC910</b> </p> <table border="1"> <thead> <tr> <th>Control box</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>Standard</td> <td>S</td> </tr> </tbody> </table>	Control box	Code	Standard	S		<table border="1"> <thead> <tr> <th>Operation panel</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>IP-100B</td> <td>IP100B</td> </tr> <tr> <td>CP-160B</td> <td>CP160B</td> </tr> </tbody> </table>	Operation panel	Code	IP-100B	IP100B	CP-160B	CP160B						
Control box	Code																		
Standard	S																		
Operation panel	Code																		
IP-100B	IP100B																		
CP-160B	CP160B																		

PSC box				Code
For JUS(LA)*	Single-phase	100 ~ 120V	PFL	S
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

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

## OPTIONS

Part No.	Description	Feature
400-06080	I/O board A	To retrofit the AE-4, AE-5 or AE-8 to your existing machine, an I/O board A which is separately available, is required.

### ● Remaining bobbin thread detector

Model	Part No.	Application
AE-4	GAE-040000A0	DDL-5550N-7, DDL-8700-7, DLN-5410N-7, DLU-5490N-7, DLD-5430N-7, DLM-5400N-7, DMN-5420N-7
AE-5	GAE-050000A0	DDL-5600N-7, DLN-5410NJ-7
AE-8	GAE-080000A0	DDL-9000, DLN-9010



## AC SERVOMOTOR/CONTROLLER SC-380

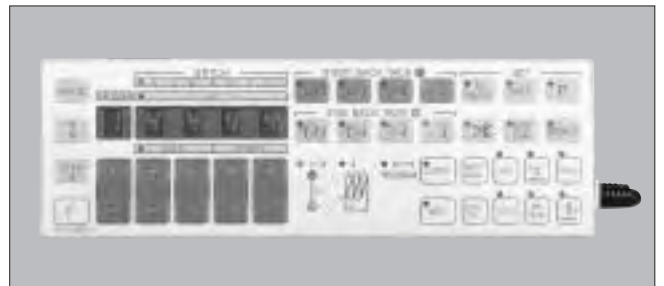
- The SC-380 is provided with many different standard functions, including speed-control, soft-start, automatic reverse stitching with the specified number of stitches, constant-dimension stitching, and overlapped (multi-layered) stitching. These functions ensure sewing performance optimally suited to 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

## OPERATION 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 operation panel.
- Data programmed in the operation panel can be transferred to another sewing machine unit.



XC-E500

## PSC BOX/OPERATION PANEL/MOTOR FOR SC

- Machine for leather and heavy weight materials

SC380

Operation panel	Code
Not provided	00000
Operation panel display language: English. Instruction manual comes in three different languages.	E500B
Operation panel display language: English. Instruction manual comes in five different languages.	E500C

- MO-6000 series

SC380   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

SC380   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

Operation panel	Code
Not provided	00000

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.

## ELECTRONIC-STOP MOTOR/ CONTROL BOX EC-10B

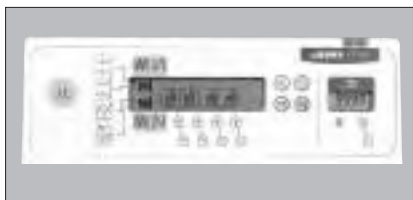
- The EC-10B enables the sewing machine to perform thread trimming, stop with its needle up/down, perform automatic reverse feed stitching at sewing start and sewing end, and perform one-touch reverse feed stitching with a switch. Needless to say, the number of reverse feed stitches can be specified.
- 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

## OPERATION PANEL CP-160 (OPTION)

- Along with its standard functions, the operation 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 operation panel facilitates function selection and easy input of sewing data such as the number of stitches.
- 1-needle, lockstitch machine: CP-160A
- LH-3100 series, LZ-2280N series: CP-160B



CP-160A, CP-160B

- The optional ED-2 material edge sensor can be attached to the operation panel.  
(for 1-needle, lockstitch machine)

## OPERATION PANEL SPECIFICATIONS

No.	Function	EC-10B	EC-10B/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 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

Operation 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
	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
	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

Pulley belt	
Pulley belt length (Inch)	Code
41"	5
42"	6
43"	7
44"	8

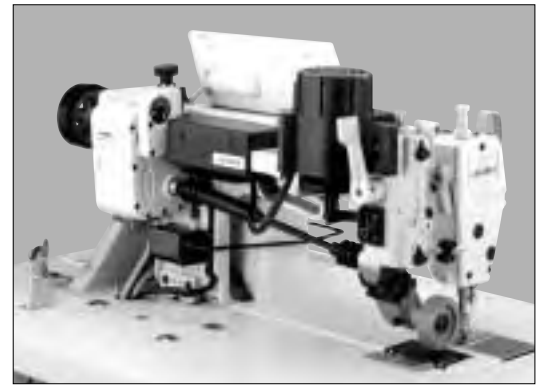
Motor mounting base	Code
Standard	
For Europe	E
For CE	C



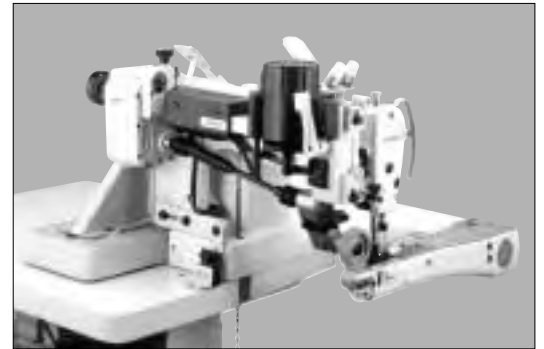
Cloth Puller

# 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 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 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 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

V051		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 auto-lifter	B			380V ~ 440V	S
DDL **, DLD/ provided with auto-lifter	C						
DLN/provided with 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.

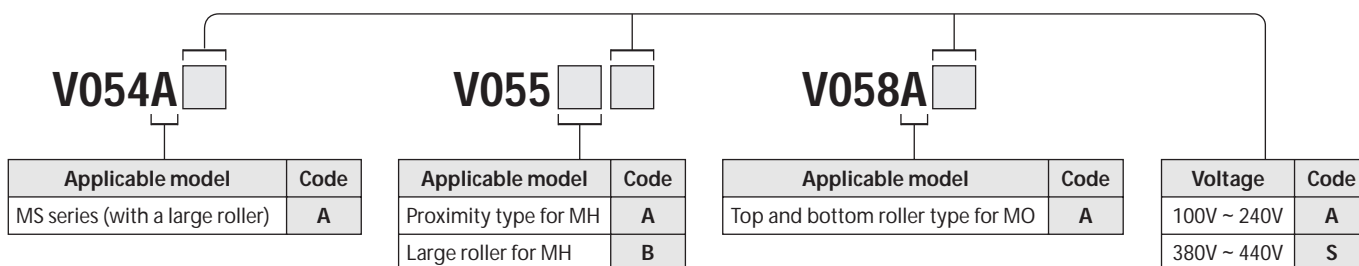
## FOR MO SERIES (OVERLOCK/SAFETY STITCH MACHINES)

Type	Model	Applicable model	Feature
Cloth puller with top and bottom rollers	V058A	MO 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.

### ● V058A (TOP AND BOTTOM ROLLER TYPE)

Roller	Size (mm)		Provided as standard	Options
			Roller material: Polyurethane	Roller material: Steel
	Diameter	Width	Roller surface: Plane	Roller surface: Tooth
Top roller	55	15	Part No. MAUAPA5515K	Part No. MAUASA5515K
	55	35	Part No. MAUAPA5535K	Part No. MAUASA5535K
	55	50	Part No. MAUAPA5550K	Part No. MAUASA5550K
Bottom roller	25	80	Part No. MAUAPA2580K	Part No. MAUASA2580K
	25	60	Part No. MAUAPA2560K	Part No. MAUASA2560K

## 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	
DLN-5430N, -7	28		28		52	52	
DLU-5490N, -7	56		56		52	52	
DLN-5410N, -7		28		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	Model name	Size (mm)		Provided as standard		Options	
				Roller material: Polyurethane		Roller material: Steel	
		Roller surface: Plane		Roller surface: 60 tooth			
		Diameter	Width	Part No.	Shape	Part No.	Shape
Top roller	V051A, B, C, D	25	10	MAUA0PA2510			
	V055A	25	15	MAUA0PA2515			
	V052A, B	55	15	MAUA0PA5515		MAUA0SA5515	
	V054A *						
	V053A, C	55	35	MAUA0PA5535		MAUA0SA5535	
	V056A *						
	V053B, D *	55	50	MAUA0PA5550		MAUA0SA5550	
V055B							
Bottom roller	V053B, D *	25	80	MAUA0PA2580			
	V054A *	30	20	MAUA0PA3022			
	V056A *	55	50	MAUA0PA5550			

\* Top and bottom roller type

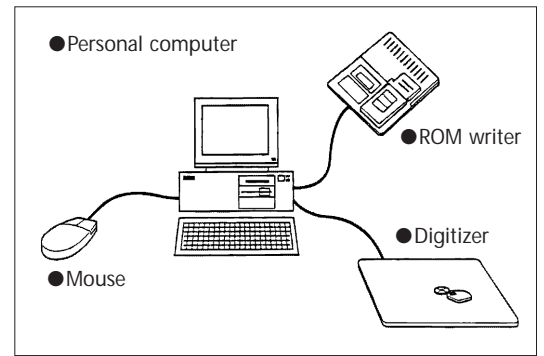
(Note) Standard roller for V052A, V052B, V053A and V055B is 55mm in diameter and 15mm in width.

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 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.

# PM-1

- This software is to input and edit sewing data of JUKI's latest sewing machines.
  - Its versatile input functions allow to input sewing data of each electronic sewing machine model easily, accurately, and quickly.
  - It supports high quality production with high added value by utilizing and creating original data for specific designs and applications.
- **Models suited for PM-1**  
AMS series (B type, C type, and D type),  
LK-1900 series, LK-1900A series,  
LK-1910, LK-1920, LK-1930 series,  
LZ-2290A (-7), LBH-1790, MB-1800, AVP-875

Create sewing data in an interactive manner during viewing screen displays.

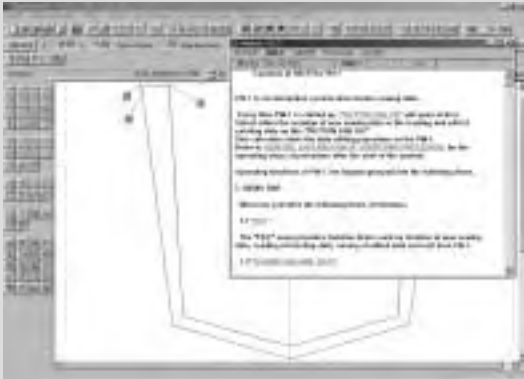
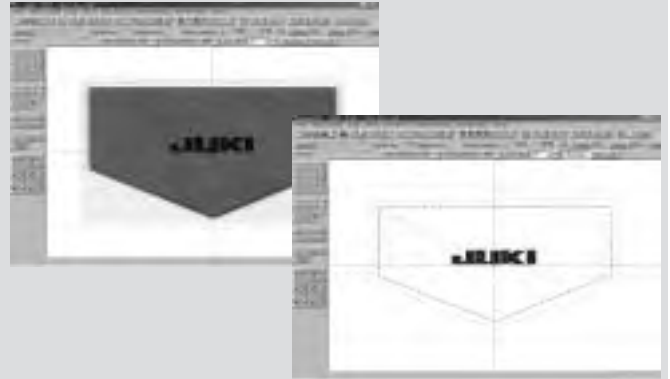
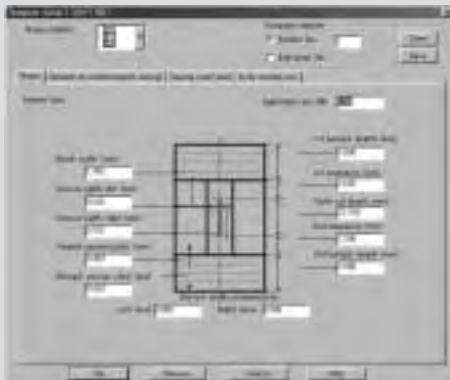


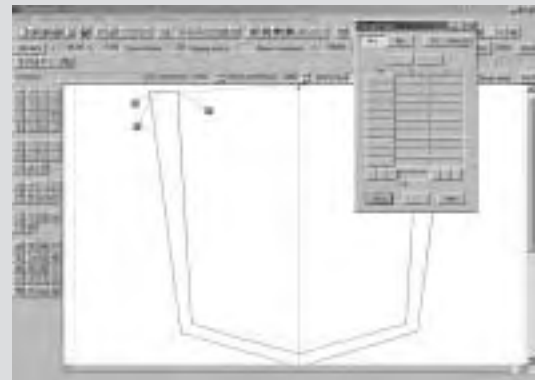
Image (BMP file) copied by a scanner can be traced by a mouse to input data.



Equipped with template functions that allow to create sewing data easily by input each parameter (For LBH-1790).



Coordinates entered can be corrected and re-edited by keyboard input.



Equipped with a data preview function that displays data configuration before reading sewing data.

Sewing sequences can be checked easily by a function of coloring needle drop points.

## Operating environment for Personal Computer

Item	Specifications	
Type of PC	IBM PC/AT compatible personal computer	
	CPU	PentiumII300MHz or higher is recommended
	Memory	32MB or higher is recommended (Do not overload OS)
	Hard disk	At least 100MB is required. Locate under "C:" as a device name
	CRT resolution	Recommend 1024 x 768 dots in at least 256 different colors
	Mouse/Keyboard	Equipped with a mouse and a keyboard
Operating System	English version PM-1	English version Windows 98 or Windows 2000
Other	To be used with digitizer, ROM writer, or PC connection, RS-232 C channel is required respectively	
	To be used with Smart Media, an adaptor is required. Locate under any device name from "A:" to "Z:"	
	To be used with a floppy disk, at least 1 drive of needed 3.5 inch 2DD (720K bites) / 2HD(1.44M bite) is required. Locate under any device name from "A:" to "Z:"	
	ROM Writer is required to input/output ROM on LK-1900 series	

By connecting with a personal computer line, sewing machine equipped with the latest operation panel IP series can perform sew-off and data can be checked and edited on the spot.

### IP-100

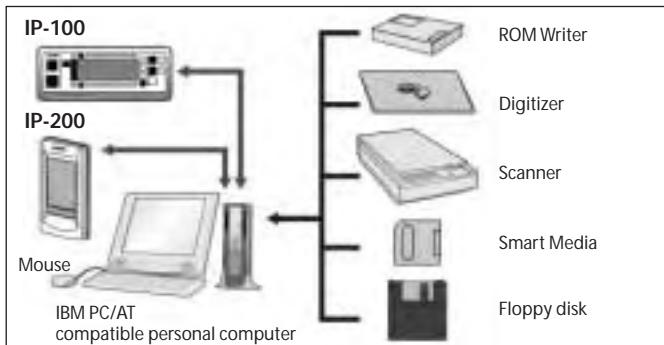


Smart Media card



Connected to a personal computer

## System Formation



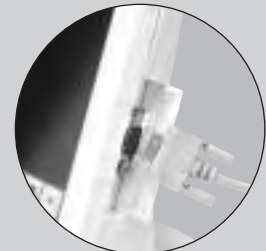
IP-100 For LZ-2290 Operation panel	Through a PC on-line connection, sew-off can be performed and entering and correcting data is possible on the spot.
IP-200 For LBH-1790, LK-1900A Operation panel	
ROM Writer	Required to enter pattern data in ROM for LK1900 series and AMS-205/206.
Digitizer	Use to input from the original print.
Smart Media Reader/Writer	Required to enter pattern data into Smart Media of LZ-2290A, LBH-1790, and LK-1900A.
Floppy disk Driver	Required to input data into disks of AMS series and AVP, excluding AMS-205 and 206.
Scanner	Able to trace images from the original and input data (Use BMP file).

\* It cannot be connected with standard panels of LBH-1790 and LK-1900A.

### IP-200



Smart Media card



Connected to a personal computer

## Digitizer

The following is specifications of digitizer for PM-1.

Item	Specifications	
Digitizer	Connect with RS-232C (any port from COM1 to COM) to input digitizer.	
	Input data format	Format prepared by Graphtech Co., Ltd., conforming to the digitizer input format Binary-1 and Binary-2.
	Mode	Use Stream Mode, 20 pps
	Resolution	0.1mm
	Baud rate	9600bps

## ROM Writer

ROM writer is required to read and write ROM data with PM-1.

	Specifications	
To be used with PM-1 data file input/output functions	ROM Writer has to be able to read and write ROM of sewing machines as well as to input/output Intel HEX file through PC connection.	

1-needle, Lockstitch Machine with Double-capacity Hook

# DDL-5600N

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

- The machine is equipped with a link mechanism which is highly evaluated for its straightness, consistency and durability. Thanks to this mechanism, the machine is capable of making well-tensed, beautifully finished seams, regardless of the type of heavy materials. The maximum stitch length is as long as 8mm (with the L-type machine for the sewing heavy materials with long stitch length), thereby making the machine widely applicable to the sewing of heavy 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. Thanks to this feature, greater efficiency is assured.



DDL-5600N-7-OB/CP-160A

### SPECIFICATIONS

Model name	DDL-5600NJ	DDL-5600NL	DDL-5600NR
Application	For jeans	For heavy 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)		
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 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)		
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	650VA		
Total weight	81kg		



## WHEN YOU PLACE ORDERS

DDL5600N

DDL5600N 7

Application	Code
For jeans	J
For heavy 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	OB
Provided (for DDL-5600NJ-7)	Provided	FB

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

### ● PSC box

SC910

PSC box				Code
For JUS(LA)*	Single-phase	100 ~ 120V	PFL	S
For JUS*, General Export	3-phase	200 ~ 240V	PFL	D
For General Export	Single-phase	200 ~ 240V	PFL	K
For CE	Single-phase	200 ~ 240V	PFL	N

Control box	Code
Standard	S
Provided with a built-in I/O board	A

● Control box provided with a built in I/O board (Code A) should be selected for the machine head equipped with the remaining bobbin thread detector (AE-5).

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

### ● Motor for SC

M91S

Pulley belt	Code
Standard	S

### ● Operation panel

Operation panel	Code
IP-100C	IP100C
CP-160A	CP160A

## 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.
	112-43763	Micro-lifter (asm.)	This device can be installed on the back of the faceplate. It is very convenient for frequent use.

\* To retrofit the AE-5 to your existing machine, I/O board A (part number: 400-06080), which is separately available, is required.



Remaining bobbin thread detector (AE-5)



Material edge sensor (ED-2)

## 1-needle, Lockstitch Machine for Leather and Heavy 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 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 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 materials, the machine smoothly feeds heavy 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 Machine Oil No.7 (equivalent to ISO VG7)
Weight of the machine head	28kg

## WHEN YOU PLACE ORDERS

### DDL-8700L

Application	Code
For leather and heavy materials	L

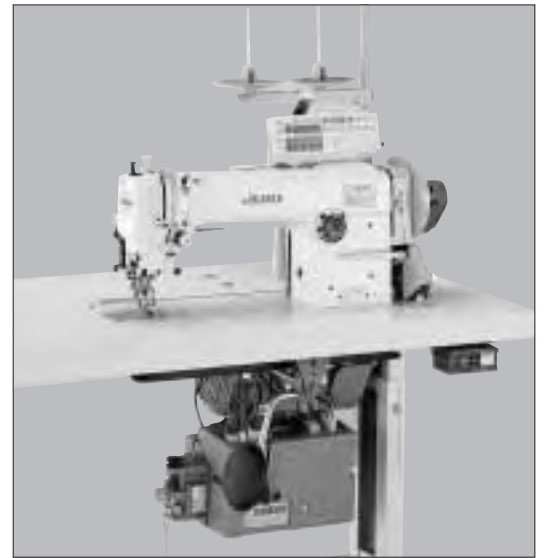
1-needle, Top & Bottom-feed, Lockstitch Machine

# DU-140

## DU-141NH (with double-capacity hook)

## DU-141H-7 (with double-capacity hook and 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 automatic thread trimmer

**DU140**  
**DU141NH**

- With automatic thread trimmer

**DU141H70B/**

Automatic reverse feed function	Code
provided	<b>0B</b>

Pneumatic auto-lifter (optional)	Code
Knee switch type (AK114C)	<b>C</b>
Pedal switch type (AK114B)	<b>B</b>
Not provided	

- PSC box/operation panel for SC

**SC380**

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>

Operation panel		Code
Not provided		<b>00000</b>
Operation panel display language: English. Instruction manual comes in three different languages.		<b>E500B</b>
Operation panel display language: English. Instruction manual comes in five different languages.		<b>E500C</b>

- Motor for SC

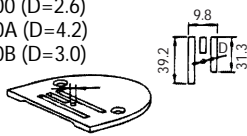

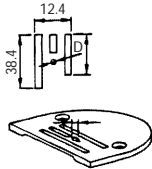

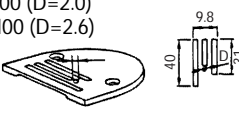

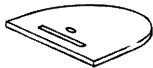
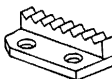
**M**

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

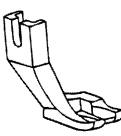




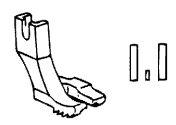


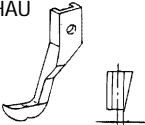
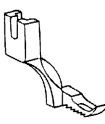
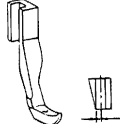
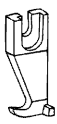



\* JUS: North America and Central and South America.

## 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)

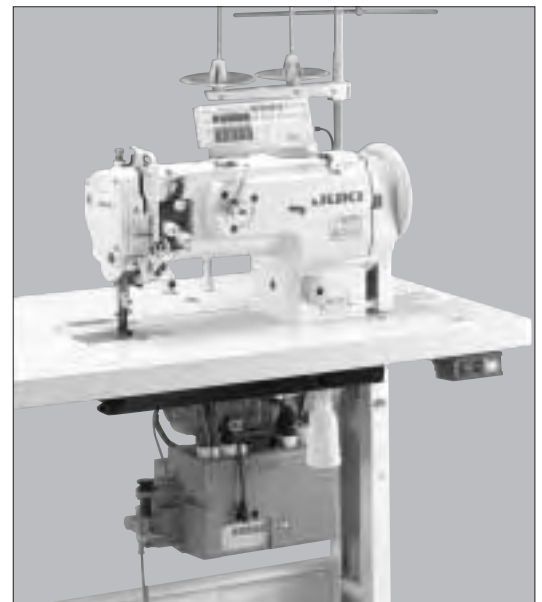
1-needle, Unison-feed, Lockstitch Machine with Large Hook

**DNU-1541**

**DNU-1541S** (with safety mechanism)

**DNU-1541-7** (with automatic thread trimmer)

- With its larger needlebar stroke, higher presser foot lift, and newly adopted double-tension mechanism, the machine offers excellent sewing capabilities and responsiveness.
- The alternating vertical movements of the walking foot and presser foot are as large as 6.5mm. In addition, the ratio between alternating vertical movements of the walking foot and presser foot remains unchanged even when the material thickness changes. Thanks to this feature and the adoption of a new method of rectangular feed that prevents needle from fraying, the machine sews multi-layered parts of a material with consistent stitching pitch while preventing stitch gathering.
- The stitch length can be easily selected by the stitch dial. The machine's enhanced operability features include a clear view of the area around the needle, placement of the bobbin thread winder on the front face of the machine arm, and a large handwheel (ø160mm).



DNU-1541-7-0B/XC-E500

- **DNU-1541S**  
When the thread is caught in the hook or any other sewing trouble occurs, the safety mechanism will automatically operate to prevent the machine from being damaged.
- **DNU-1541-7**  
The vertical stroke of the presser foot and walking foot (amount of alternating vertical movement) can be easily changed with the large dial mounted on the top of the machine head. The sewing speed is automatically regulated based on the vertical stroke setting. This ensures ideal sewing conditions at all times.

**WHEN YOU PLACE ORDERS**

● Without automatic thread trimmer

DNU1541

Safety mechanism	Code
Not provided	/
Provided	S

● With automatic thread trimmer

DNU154170B

Pneumatic auto-lifter	Code
Knee switch type (AK123A)	A
Pedal switch type (AK123B)	B
Not provided	/

DL device	Code
Not provided	/
Provided *	A

\* Select the auto-lifter code B (AK123B).

● Motor for SC

M

Motor			Code
For General Export	Single-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/operation panel for SC

SC380

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

Operation panel	Code
Not provided	00000
Operation panel display language: English. Instruction manual comes in three different languages.	E500B
Operation panel display language: English. Instruction manual comes in five different languages.	E500C

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

## SPECIFICATIONS

Model name	DNU-1541	DNU-1541S	DNU-1541-7
Max. sewing speed **	2,500rpm		3,000rpm
Max. stitch length	9mm (Normal/Reverse feed)		
Needle bar stroke	36mm		
Lift of the presser foot	By hand: 9mm, By knee: 16mm		
Thread take-up	Slide type		
Amount of alternating vertical movement	2.5 ~ 6.5mm		1 ~ 6.5mm
Dial for adjustment of alternating vertical movement			Provided as standard
Bottom-feed adjusting mechanism			Provided as standard
Hook	Horizontal-axis full-rotary double-capacity hook		
Needle (at the time of delivery)	135 x 17 ( Nm160) Nm125 ~ Nm180		
Thread	#30 ~ #5, B46 ~ B138, Nm=60/3 ~ 15/3		
Pitch changing method	By dial		
Bobbin winder	Provided as standard		
Knee-lifter mechanism	Provided as standard		
Safety mechanism			Provided as standard
Lubrication	Centralized oil wick lubrication (hook: automatic)		
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)		
Distance from needle to machine arm	264mm		
Bed size	477mm x 178mm		
Weight of the machine head	36.5kg		42.5kg
Automatic 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 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V

\* Compressed air is indispensable

### \*\* SEWING SPEED TABLE

The maximum sewing speed has been specified in accordance with sewing conditions as shown in table below.

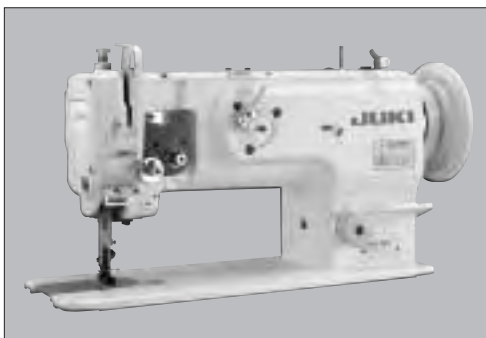
Set the maximum sewing speed appropriately in accordance with the sewing conditions given taking care not to exceed the corresponding specified value.

#### ● DNU-1541, DNU-1541S

Amount of alternate vertical movement of the walking foot and presser foot	Stitch length: 6mm or less	Stitch length: More than 6mm and 9mm or less
Less than 3mm	2,500rpm	2,000rpm
3mm to less than 4mm	2,000rpm	2,000rpm
4mm to less than 6.5mm	1,600rpm	1,600rpm

#### ● DNU-1541-7

Amount of alternate vertical movement of the walking foot and presser foot	Stitch length: 6mm or less	Stitch length: More than 6mm and 9mm or less
Less than 2.5mm	3,000rpm	2,000rpm
2.5mm to less than 4mm	2,400rpm	2,000rpm
4mm to less than 4.75mm	2,000rpm	2,000rpm
4.75mm to less than 6.5mm	1,800rpm	1,800rpm



DNU-1541



DNU-1541-7

## ● Pneumatic auto-lifter

Model name	Type	Part No.	Switch type		Air regulator	
			Knee switch type	Pedal switch type	Not provided	Provided
DNU-1541	AK119A	GAK-A19010A0				
DNU-1541S	AK119B	GAK-A19010B0				
	AK120A	GAK-A20010A0				
	AK120B	GAK-A20010B0				
DNU-1541-7	AK123A	GAK-A2300AA0				
	AK123B	GAK-A2300BA0				

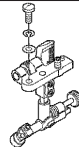
## ● Automatic reverse feed function

Model name	Part No.	Remarks
DNU-1541 DNU-1541S	213-48552	Provided with air regulator

\* To use a pneumatic auto-lifter and reverse feed function in combination with a machine that is without automatic thread trimmer, select AK119A or AK119B.

## ● Combination of optional devices

Model name	Combination	Pneumatic auto-lifter	Automatic reverse feed function	DL device
DNU-1541 DNU-1541S	Automatic reverse feed function			
	Pneumatic auto-lifter	AK120A AK120B		
	Pneumatic auto-lifter+ Automatic reverse feed function	AK119A AK119B		
DNU-1541-7	Pneumatic auto-lifter+ Automatic reverse feed function	AK123A AK123B	Provided as standard	
	Pneumatic auto-lifter+ Automatic reverse feed function+ DL device	AK123B		DL21(D kit)

Model	Part No.	Description	Feature
	GDL-21000DA0	DL device [DL21 (D kit)] for installed after the setup of the machine Applicable model: DNU-1541-7	<ul style="list-style-type: none"> <li>For sewing processes that handle heavy materials or multi-layered parts of material, the alternating vertical movements of the walking foot and presser foot can be quickly set to maximum by pressing the DL switch. The result is beautiful seams free from gathered stitches.</li> <li>The machine is provided with both a hand switch and knee switch.</li> </ul> <p>* The DL device cannot be used alone. It is designed for use in combination with the auto-lifter (AK123B).</p>
H152	MAH-152010A0	Ruler	Suspended ruler 
	SS-7151610SP x 2	Screw	
	WP-0621016SD x 2	Washer	
	WS-0610002KN x 2	Spring washer	
PK75	GPK-750000A0	3-pedal unit	Applicable model: DNU-1541-7 Highly operable 3-pedal unit for standing work.



DL device



PK75

1-needle, Unison-feed, Lockstitch Machine with Vertical-axis Large Hook  
[Gauge for standard]

**LU-1508NS**

**LU-1508NH** (for extra heavy materials)

**LU-1510N** (with automatic lubricating mechanism)

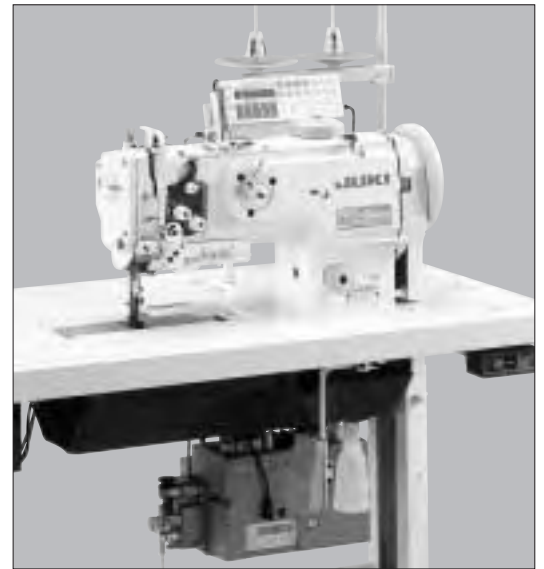
**LU-1510N-7** (with automatic lubricating mechanism and automatic thread trimmer)

[Gauge for LU-2200]

**LU-1509NS**

**LU-1509NH** (for extra heavy materials)

**LU-1511N-7** (with automatic lubricating mechanism and automatic thread trimmer)



LU-1510N-7-0BBAA/XC-E500

- 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-1508NS, LU-1510N, LU-1510N-7, LU-1509NS, LU-1511N-7**

Compared with the elliptical feed, the rectangular feed helps reduce gathered stitches.

**Complete rectangular feed LU-1508NH, LU-1509NH**

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 materials powerfully and smoothly. Well tensed seams are consistently produced without pitch errors.
- Even when a heavy 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-1508NH, LU-1509NH**
  - The maximum stitch length is 10mm. The complete rectangular feed locus enables accurate feed of extra heavy 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 materials.
- The machine comes with an extra large steel handwheel with a diameter as large as 175.

● **LU-1510N, LU-1510N-7, LU-1511N-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-1510N-7, LU-1511N-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**

Gauge for standard

[Without automatic thread trimmer]

**LU1508N**

Application	Code
For heavy materials	S
For extra heavy materials	H

**LU1510N**

[With automatic thread trimmer]

**LU1510N70BB**

Pneumatic auto-lifter	Code
Pedal switch type (AK123B)	B

DL device	Code
Not provided	Z
Provided	A

Option	Code
Not provided	Z
AE-10 (Bobbin thread remaining amount detecting device)	A

Gauge for LU-2200

[Without automatic thread trimmer]

**LU1509N**

Application	Code
For heavy materials	S
For extra heavy materials	H

[With automatic thread trimmer]

**LU1511N70BB**

Pneumatic auto-lifter	Code
Pedal switch type (AK123B)	B

DL device	Code
Not provided	Z
Provided	A

Option	Code
Not provided	Z
AE-10 (Bobbin thread remaining amount detecting device)	A

● PSC box/operation panel for SC

**SC380**

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

Operation panel		Code
Not provided		0000
Operation panel display language: English.		E500B
Instruction manual comes in three different languages.		E500C
Operation panel display language: English.		E500C
Instruction manual comes in five different languages.		E500C

● Motor for SC

**M**

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

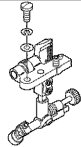
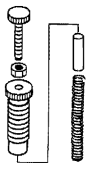
\* JUS: North America and Central and South America.




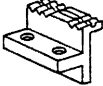
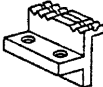

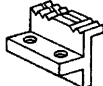
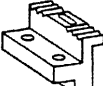
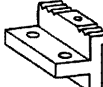

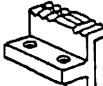

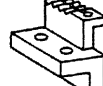
## SPECIFICATIONS

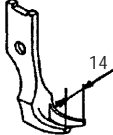



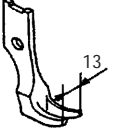




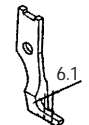

Model name	LU-1508NS, LU-1509NS	LU-1508NH, LU-1509NH	LU-1510N	LU-1510N-7, LU-1511N-7
	-	-	-	With automatic thread trimmer
Application	For heavy materials	For extra heavy materials	For heavy materials	
Max. sewing speed	2,500rpm	2,000rpm	2,500rpm	3,000rpm
Max. stitch length	9mm (Normal/Reverse feed)	10mm (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.)			By hand: 9mm, Auto: 16mm
Auto-lifter	Option			Provided as standard (Pneumatic auto-lifter: AK123B)
Alternating vertical movement	2.5 ~ 6.5mm			1 ~ 6.5mm
Dial for adjustment of alternating vertical movement	-			Provided as standard
Thread take-up	Slide type			
Hook	Vertical-axis double-capacity hook			
Needle (at the time of delivery)	135 × 17 (Nm160) Nm125 ~ Nm180	Standard 190R or 135 × 17 (Nm160) Nm125 ~ Nm200	135 × 17 (Nm160) Nm125 ~ Nm180	
Thread	#30 ~ #5, B46 ~ B138, Nm=60/3 ~ 20/3	#20 ~ #1, B69 ~ B207, Nm=40/3 ~ 8/3	#30 ~ #5, B46 ~ B138, Nm=60/3 ~ 20/3	
Locus of feed	Rectangular feed	Complete rectangular feed	Rectangular feed	
Needle thread tension box	Dual-tension method			
Bottom-feed micro-adjustment mechanism	-			Provided as standard
Pitch changing method	By dial			
Bobbin thread winder	Built on the machine head			
Knee-lifter mechanism	Built on the machine head			-
Safety mechanism	Provided as standard (Reset with the push of a button)			
Lubrication	Centralized oil wick lubrication (hook: automatic)		Automatic	
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)			
Distance from needle to machine arm	255mm			
Bed size	517mm × 178mm			
Weight of the machine head	42.5kg	44.5kg	43kg	48kg
Automatic reverse feed function	Option			Provided as standard
Compressed air and air consumption	-			0.5MPa (5kg/cm <sup>2</sup> ) • 0.3Nℓ /min
Power requirement	-			Single-phase 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V
Power consumption	-			550VA

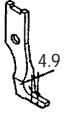

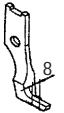


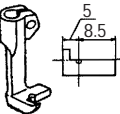
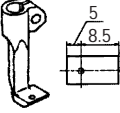










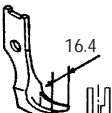

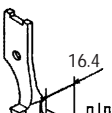

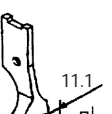

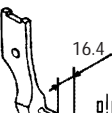



## OPTIONS

Model	Part No.	Description	Feature
DL21 (G kit)	GDL-21000GA0	For installed after the setup of the machine	Applicable model: LU-1510N-7, LU-1511N-7 For sewing processes that handle heavy materials or multi-layered parts of material, the alternating vertical movements of the walking foot and presser foot can be quickly set to maximum by pressing the DL switch. The result is beautiful seams free from gathered stitches. The machine is provided with both hand switch and knee switch.
AE-10 (Kit A)	GAE-10000AA0	For installed after the setup of the machine	The bobbin thread remaining-amount detecting device warns the operator with a buzzing sound and lamp indication of the time for bobbin thread replacement. This allows the operator to concentrate on sewing work without concern for the remaining amount of bobbin thread. Since the device directly detects the bobbin thread amount remaining, cumbersome setting is no longer required regardless of the material, thread and process.
AK119A	GAK-A19010A0	Knee switch type	Applicable model: LU-1508N, LU-1508HN, LU-1510N, 1509N, 1509NH
AK119B	GAK-A19010B0	Pedal switch type	
AK120A	GAK-A20010A0	Knee switch type	
AK120B	GAK-A20010B0	Pedal switch type	
	213-48552	Pneumatic one-touch type reverse feed stitching device (provided with air regulator)	Applicable model: LU-1508N, LU-1508HN, LU-1510N, 1509N, 1509NH * To use 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-1510N-7, LU-1511N-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)  6.2 7.2 2.5 20	Equipped on LU-1508N, LU-1508NH, LU-1510N Stitch length up to 9mm (10mm in case of LU-1508NH)
		213-49204 (needle hole: 2.5 × 3.5) (groove in front and back)  6.2 3.5 2.5 20	Equipped on LU-1510N-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)  6.2 7.2 2.5 20	Equipped on LU-563N Stitch length up to 9mm Not applicable to LU-1510N-7
Lower fittings (no groove)		B1613-053-000 (needle hole: 2.5 × 7.2) (No groove)  6.2 7.2 2.5 20	Stitch length up to 9mm Not applicable to LU-1510N-7
Lower fittings for thin needle		B1613-563-B00 (needle hole: 2.4) B1613-053-B00 (needle hole: 1.9)  6.2 D 20	Stitch length up to 9mm Not applicable to LU-1510N-7
Fitting for piping	B1109-562-A00 (area: 31.7 × 8.8) 	B1613-562-A00 (needle hole: 2.5 × 8)  8.5 2.5 20	Stitch length up to 9mm Not applicable to LU-1510N-7
Lower fittings for tape binding	B1109-563-C00 (area: 30.2 × 6.8) 	B1613-563-C00 (needle hole: 2.5)  6.4 13.5	Stitch length up to 7mm Not applicable to LU-1510N-7

Description	Presser foot	Walking foot	Notes
Upper fittings standard	B1525-241-HA0  14	B1470-241-H00 (width: 6.2, needle hole: 2.8) 	Equipped on LU-1508N, LU-1508NH, LU-1510N, LU-1510N-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  13	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)  6.6	B1470-245-000 (width: 6, needle hole: 2.2) (front-open) 	Stitch length up to 6mm
	B1529-245-0AC (width: 7.7mm) (with groove)  6.1	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-093080A0 (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-092080A0 (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  
[Gauge for standard]

**LU-1560N** (with automatic lubricating mechanism)

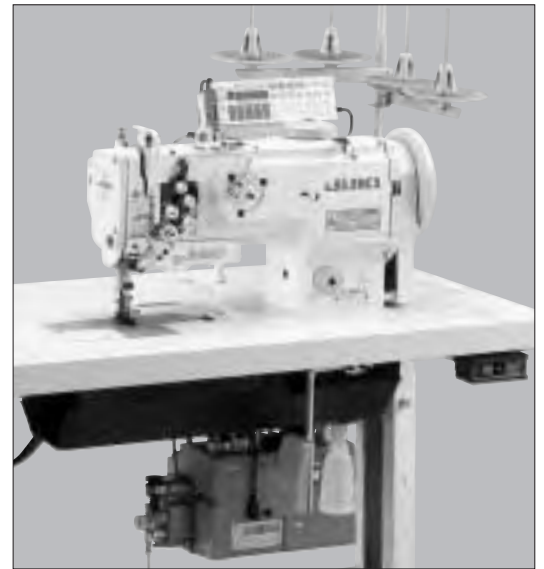
**LU-1560N-7** (with automatic lubricating mechanism and automatic thread trimmer)

**LU-1565N** (with organized split needle bar)

[Gauge for LU-2200]

**LU-1561N**

**LU-1561N-7** (with automatic lubricating mechanism and automatic thread trimmer)



LU-1560N-7-0BBAA/XC-E500

- 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**

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 materials powerfully and smoothly. Well tensed seams are consistently produced without pitch errors.
- **LU-1560N, LU-1561N, LU-1560N-7, LU-1561N-7**
  - Automatic lubricating mechanism improves maintainability. The sub oil pan and double filter prevent dust from entering the oil.

● **LU-1560N-7, LU-1561N-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.

● **LU-1565N**

- 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.

**SPECIFICATIONS**

Model name	LU-1560N	LU-1561N	LU-1560N-7	LU-1561N-7	LU-1565N
	-		With automatic thread trimmer		With organized split needle bar
Application	For heavy 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, Auto: 16mm		By hand: 9mm, By knee: 13mm (max.)
Auto-lifter	Option		Provided as standard (Pneumatic auto-lifter: AK123B)		Option
Needle gauge	4.8mm, 6.4mm, 7.9mm, 9.5mm, 12.7mm (3/16, 1/4, 5/16, 3/8, 1/2)	6mm, 8mm, 10mm, 12mm	4.8mm, 6.4mm, 7.9mm, 9.5mm, 12.7mm (3/16, 1/4, 5/16, 3/8, 1/2)	6mm, 8mm, 10mm, 12mm	4.8mm, 6.4mm, 7.9mm (3/16, 1/4, 5/16)
Organized split needle bar	-				Provided as standard
Alternating vertical movement	2.5 ~ 6.5mm		1 ~ 6.5mm		2.5 ~ 6.5mm
Dial for adjustment of alternating vertical movement	-		Provided as standard		-
Thread take-up	Slide type				
Hook	Vertical-axis double-capacity hook				
Needle (at the time of delivery)	135 x 17 (Nm160) Nm125 ~ Nm180				
Thread	#30 ~ #5, B46 ~ B138, Nm=60/3 ~ 20/3				
Locus of feed	Rectangular feed				
Needle thread tension box	Single-tension method				
Pitch changing method	By dial				
Bobbin thread winder	Built on the machine head				
Knee-lifter mechanism	Built on the machine head		-		Built on the machine head
Safety mechanism	Provided as standard (Reset with the push of a button)				
Lubrication	Automatic				By an oiler (hook: automatic)
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)				
Distance from needle to machine arm	255mm				
Bed size	517mm x 178mm				
Weight of the machine head	45kg		51kg		45kg
Automatic reverse feed function	Option		Provided as standard		-
Compressed air and air consumption	-		0.5MPa (5kg/cm <sup>2</sup> ) • 0.3Nℓ/min		-
Power requirement	-		Single-phase 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V		-
Power consumption	-		550VA		-

# WHEN YOU PLACE ORDERS

## Gauge for standard

[Without automatic thread trimmer]

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

Needle gauge	Code
4.8mm (3/16")	D
6.4mm (1/4")	F
7.9mm (5/16")	H

**LU1560N**

Presser foot	Code
Standard	S
Center guide	A*

**LU1565N**

\* For the gauge groups H, K and L only, the presser foot group A (equipped with center guide) can be selected.

[With automatic thread trimmer]

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
Pedal switch type (AK123B)	B

**LU1560N**  **70BB**

DL device	Code
Not provided	Z
Provided	A

Option	Code
Not provided	Z
AE-10 (Bobbin thread remaining amount detecting device)	A

### — Needle gauge correspondence table —

- (1) The needle gauges marked with a circle (○) in the table below are prepared as optional parts (separately available).  
 (2) The needle gauges marked with a circle (◐) are selectable at the time the order is placed.

#### ● LU-1560N Series

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")
	Code	-	D	F	H	K	L	-	-	-	-	-	-
LU-1560N		○	◐	◐	◐	◐	◐	○	○	○	○	○	○
LU-1560N-7		○	◐	◐	◐	◐	◐	○	○	○	○	○	-
LU-1565N		-	◐	◐	◐	◐	◐	-	-	-	-	-	-

## Gauge for LU-2200

[Without automatic thread trimmer]

**LU1561N**

Needle gauge	Code
6mm	B
8mm	C
10mm	D
12mm	E

[With automatic thread trimmer]

Pneumatic auto-lifter	Code
Pedal switch type (AK123B)	B

DL device	Code
Not provided	Z
Provided	A

**LU1561N**  **70BB**

Needle gauge	Code
6mm	B
8mm	C
10mm	D
12mm	E

Option	Code
Not provided	Z
AE-10 (Bobbin thread remaining amount detecting device)	A

### — Needle gauge correspondence table —

- (1) The needle gauges marked with a circle (○) in the table below are prepared as optional parts (separately available).  
 (2) The needle gauges marked with a circle (◐) are selectable at the time the order is placed.

#### ● LU-1561N Series

Model name	Needle gauge	4mm	6mm	8mm	10mm	12mm	14mm	16mm	18mm	20mm	22mm	24mm	26mm	30mm
	Code	-	B	C	D	E	-	-	-	-	-	-	-	-
LU-1561N		○	◐	◐	◐	◐	○	○	○	○	○	○	○	○
LU-1561N-7		○	◐	◐	◐	◐	○	○	○	○	○	○	○	○

#### ● PSC box/operation panel for SC

**SC380**

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

Operation panel		Code
Not provided		00000
Operation panel display language: English. Instruction manual comes in three different languages.		E500B
Operation panel display language: English. Instruction manual comes in five different languages.		E500C

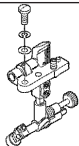
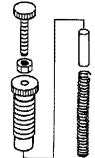
#### ● Motor for SC

**M**

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

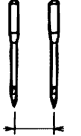







\* JUS: North America and Central and South America.

## OPTIONS

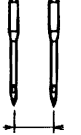

Model	Part No.	Description	Feature
DL21 (G kit)	GDL-21000GA0	For installed after the setup of the machine	Applicable model: LU-1560N-7, LU-1561N-7 For sewing processes that handle heavy materials or multi-layered parts of material, the alternating vertical movements of the walking foot and presser foot can be quickly set to maximum by pressing the DL switch. The result is beautiful seams free from gathered stitches. The machine is provided with both hand switch and knee switch.
AE-10 (Kit B)	GAE-10000BA0	For installed after the setup of the machine	The bobbin thread remaining-amount detecting device warns the operator with a buzzing sound and lamp indication of the time for bobbin thread replacement. This allows the operator to concentrate on sewing work without concern for the remaining amount of bobbin thread. Since the device directly detects the bobbin thread amount remaining, cumbersome setting is no longer required regardless of the material, thread and process.
AK119A	GAK-A19010A0	Knee switch type	Applicable model: LU-1560N, LU-1561N, LU-1565N
AK119B	GAK-A19010B0	Pedal switch type	
AK120A	GAK-A20010A0	Knee switch type	
AK120B	GAK-A20010B0	Pedal switch type	
	213-48552	Pneumatic one-touch type reverse feed stitching device (provided with air regulator)	Applicable model: LU-1560N, LU-1561N, LU-1565N * To use 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		
PK75		3-pedal unit	Applicable model: LU-1560N-7, LU-1561N-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

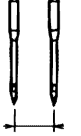







## LU-1560N

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 x 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		

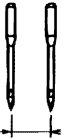


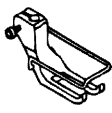

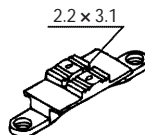


## LU-1560N

Code	Needle gauge size	Walking foot asm. Needle hole 2.6 x 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

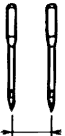




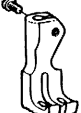

## LU-1560N-7

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 x 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		

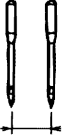



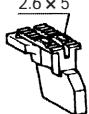

## LU-1561N, LU-1561N-7

Code	Needle gauge size	Throat plate	Needle clamp asm.	Presser foot asm.	Walking foot asm.	Feed dog Needle hole 2.2 x 3.1	Slide plate, left	Slide plate, right
								
	4mm	214-52800	107-77555	107-81557	107-83058	107-80005	107-86309	107-01803
B	6mm	214-52909	107-77654	107-81656	107-83157	107-80104		
C	8mm	214-53006	107-77753	107-81755	107-83256	107-80203		
D	10mm	214-53105	107-77852	107-81854	107-83355	107-80302	107-86408	107-86002
E	12mm	214-53204	107-77951	107-81953	107-83454	107-80401		
	14mm	214-53303	107-78058	107-82050	107-83553	107-80500		
	16mm	241-53402	107-78157	107-82159	107-83652	107-80609		
	18mm	214-53501	107-78256	107-82258	107-83751	107-80708		
	20mm	241-53600	107-78355	107-82357	107-83850	107-80807		
	22mm	241-53709	107-78454	107-82456	107-83959	107-80906	107-86507	107-86101
	24mm	241-53808	107-78553	107-82555	107-84056	107-81003		
	26mm	214-53907	107-78900	107-82951	107-84452	107-81409		
	30mm	214-54004	107-78603	107-82654	107-84155	107-81102		

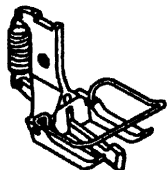
## LU-1565N

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-1565N

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-1560N, LU-1560N-7, LU-1565N (option)

Description	Presser foot asm.	Walking foot asm.	Notes
Upper fittings for french-seam (with center guide)	(a) 213-74657 (width: 21.4mm) (b) 213-74756 (width: 23.0mm) (c) 213-74855 (width: 26.0mm)	(a) 213-72552 (needle hole: 2.5) (with groove) (b) 213-72651 (needle hole: 2.5) (with groove) (c) 213-72750 (needle hole: 2.5) (with groove)	For LU-1560N and LU-1565N.  Needle distance: (a) ..... 7.9mm (5/16") (b) ..... 9.5mm (3/8") (c) ... 12.7mm (1/2")
		(a) 213-67354 (needle hole: 2.5) (b) 213-67453 (needle hole: 2.5) (c) 213-67552 (needle hole: 2.5)	For LU-1560N-7.  Needle distance: (a) ..... 7.9mm (5/16") (b) ..... 9.5mm (3/8") (c) ... 12.7mm (1/2")



1-needle, Unison-feed, Lockstitch Machine  
with Vertical-axis Large Hook and Automatic Thread Trimmer  
(needle thread roll-in and short tail type)

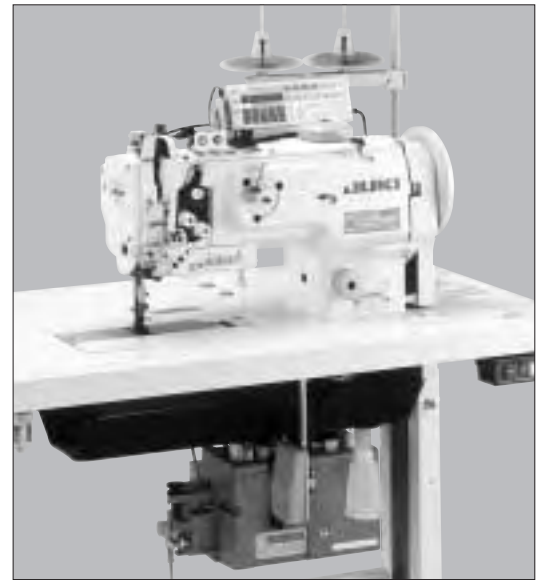
[Gauge for standard]

**LU-1520N-7**

[Gauge for LU-2200]

**LU-1521N-7**

- The remaining length of thread at the end of sewing is substantially shortened to approximately 5mm. The machine cuts thread as thick as #5 without fail.
- Even if the needle thread is clamped under the presser foot or walking foot, the machine draws the needle thread onto the underside of the material without fail, leaving no exposed thread on the right side. The needle thread drawn onto the underside of the material can be sewn under the seam.
- The end-of-sewing thread is kept in the seam allowance both at the beginning and end of sewing and does not jut out from the material edge. This function eliminates the need for thread snipping. The operator is able to concentrate on sewing work without having to perform thread snipping work, thereby dramatically increasing productivity. The frequency of scissor use by the operator is significantly reduced, thereby preventing accidents in which the scissors damage the material.



LU-1520N-7-0BBAA/XC-E500



## WHEN YOU PLACE ORDERS

LU152  N70BB

Specification	Code	Pneumatic auto-lifter	Code	DL device	Code	Option	Code
Gauge for Standard	0	Pedal switch type (AK124B)	B	Not provided	Z	Not provided	Z
Gauge for LU-2200	1			Provided	A	AE-10 (Bobbin thread remaining amount detecting device)	A

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[PSC box/operation panel for SC]

SC380

PSC box			Code	Operation panel		Code
For General Export	Single-phase	220 ~ 240V	07	Not provided	00000	
	3-phase	200 ~ 220V	11	Operation panel display language: English. Instruction manual comes in three different languages.	E500B	
For JUS(LA)*	Single-phase	110 ~ 120V	37	Operation panel display language: English. Instruction manual comes in five different languages.	E500C	
	3-phase	220 ~ 240V	38			
For CE	Single-phase	220 ~ 240V	34			

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

[Motor for SC]

M

Motor				Code
For General Export	Single-phase	200 ~ 240V		60
	3-phase	200 ~ 240V		
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-1520N-7 LU-1521N-7
Max. sewing speed	3,000rpm
Max. stitch length	9mm (Normal/Reverse feed)
Needle bar stroke	36mm
Lift of the presser foot	By hand: 9mm / Auto: 16mm
Auto-lifter	Provided as standard (Pneumatic auto-lifter: AK124B)
Thread take-up	Slide type
Alternating vertical movement	1 ~ 6.5mm
Dial for adjustment of alternating vertical movement	Provided as standard
Amount of thread remaining	5mm* * It varies depending on the sewing conditions.
Needle thread roll-in device	Provided as standard
Bottom-feed micro-adjustment mechanism	Provided as standard
Hook	Vertical-axis double-capacity hook
Needle (at the time of delivery)	135 × 17 (Nm160) Nm125 ~ Nm180 or DP × 17(#23) #16 ~ #24
Thread	#30 ~ #5, B46 ~ B138, Nm=60/3 ~ 20/3
Needle thread tension box	Dual-tension method
Pitch changing method	By dial
Bobbin thread winder	Built on the machine head
Safety mechanism	Provided as standard
Automatic reverse feed function	Provided as standard
Lubrication	Automatic
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)
Distance from needle to machine arm	255mm
Bed size	517mm × 178mm
Weight of the machine head	49.5kg
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

## OPTIONS

Model	Part No.	Feature
DL21 (F kit)	GDL-21000FA0	The DL device can be used to instantaneously maximize the alternate vertical movement amount. This device is useful, in particular, in processes for sewing products with many multi-layered parts. The machine is provided with both hand switch and knee switch.
AE-10 (Kit A)	GAE-10000AA0	The bobbin thread remaining-amount detecting device warns the operator with a buzzing sound and lamp indication of the time for bobbin thread replacement. This allows the operator to concentrate on sewing work without concern for the remaining amount of bobbin thread. Since the device directly detects the bobbin thread amount remaining, cumbersome setting is no longer required regardless of the material, thread and process.

## GAUGE

Application	Part name	Part No.	Remarks
Gauge for light-weight materials	Feed dog	213-99209	Width 4.5mm, Needle hole 2.2
	Throat plate	213-99605	With no knurl on the top face, groove width 5.0mm
Toothed gauge	Walking foot	B1470-562-BA0	Width 13mm
	Presser foot	B1525-562-BA0	Width 4.5mm, Needle hole 2.2 (with groove)

High-speed, 1-needle, Unison-feed, Lockstitch Machine with Large Hook and Automatic Thread Trimmer

**LU-2210N-7** (1.6 fold-capacity hook)

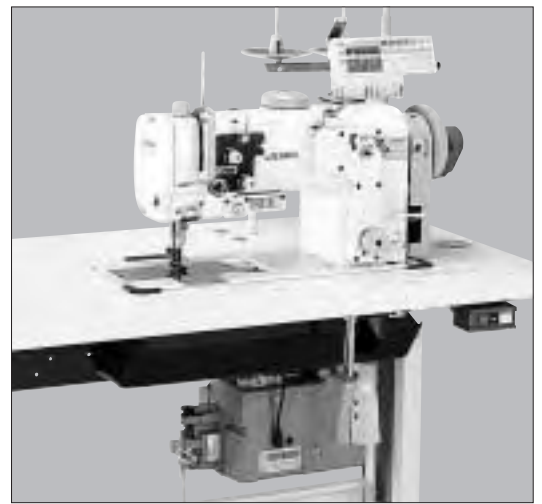
**LU-2210W-7** (double-capacity hook)

High-speed, 2-needle, Unison-feed, Lockstitch Machine with Large Hooks and Automatic Thread Trimmer

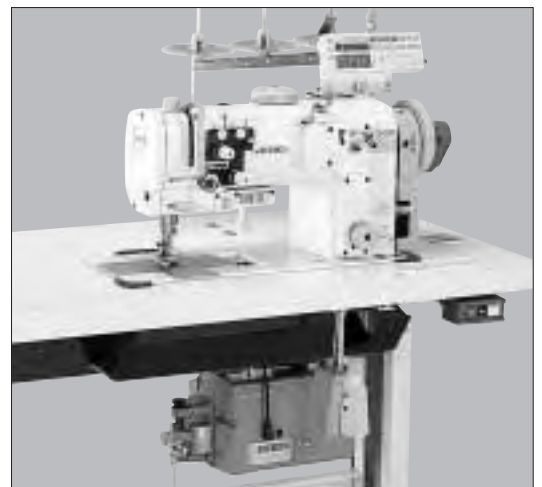
**LU-2260N-7** (1.6 fold-capacity hook)

**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

Hook	Code
1.6 fold-capacity hook	N
Double-capacity hook	W

Feed dog	Code
Standard (with groove)	S
Without groove	A
For thin thread (2.5mm x 1.6mm)	B

DL function	Code
Provided with DL function/ knee switch type	B

LU2210      **B70B**

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

Option	Code
Not provided	Z
AE-9 (Bobbin thread remaining amount detecting device)	A*

\* For the hook group N (1.6 fold-capacity hook) only, the option group A (equipped with AE-9) can be selected.

LU2260     **S**    **SB70B**

Hook	Code
1.6 fold-capacity hook	N
Double-capacity hook	W

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/ knee switch type	B

Option	Code
Not provided	Z
AE-9 (Bobbin thread remaining amount detecting device)	A*

\* For the hook group N (1.6 fold-capacity hook) only, the option group A (equipped with AE-9) can be selected.

### ● PSC box/operation panel for SC

SC380

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

Operation panel		Code
Not provided		00000
Operation panel display language: English. Instruction manual comes in three different languages.		E500B
Operation panel display language: English. Instruction manual comes in five different languages.		E500C

### ● Motor for SC







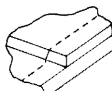




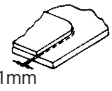


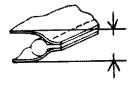
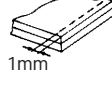
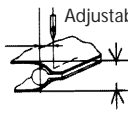




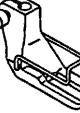

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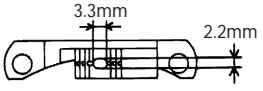
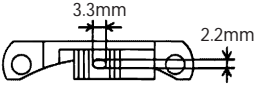
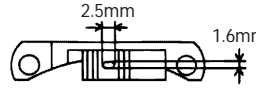
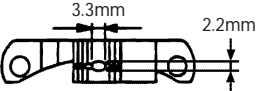
Motor			Code
For General Export	Single-phase	200 ~ 240V	60
	3-phase	200 ~ 240V	60
For JUS (LA)*	Single-phase	100 ~ 120V	61
	3-phase	200 ~ 240V	62
For CE	Single-phase	200 ~ 240V	63

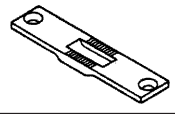
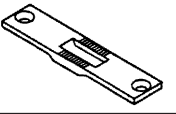
\* JUS: North America and Central and South America.

# INTERCHANGEABLE GAUGE PARTS



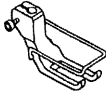


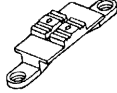


## LU-2210N-7, LU-2210W-7

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 heavy sponge</b> Used for more resilient materials Thick 	B	For urethane 107-11752				
<b>For light-weight sponge</b> Used for resilient materials including sponge 		<b>Right single-sided presser</b> Used for sewing material edges  1mm	C	Right single-sided presser 107-11851			<b>D</b> Right single-sided presser 107-12859 
<b>For piping</b> Used for the general piping process 			<b>Left single-sided presser</b> Used for sewing material edges  1mm	D		Left single-sided presser 107-11950	
<b>For piping</b> The position of the needle can be adjusted according to the pipe to be sewn  Adjustable		E ~ H		For piping 3 107-45354 4 107-45453 5 107-45552 6 107-45651			<b>F ~ J</b> For piping 3 107-47350 4 107-47459 5 107-47558 6 107-47657 
<b>Wide type</b> To be used when a sewing product cannot be smoothly fed 	J ~ M	Adjustable presser for piping 3 107-46352 4 107-46451 5 107-46550 6 107-46659		(special order) 107-13055 			
		(special order) 107-12057					

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	107-86507	107-86101
18mm (special order)	107-85251	107-78256	107-82258	107-83751	107-85202	107-80708		
20mm	107-85350	107-78355	107-82357	107-83850	107-85301	107-80807		
22mm (special order)	107-85459	107-78454	107-82456	107-83959	107-85400	107-80906	107-86606	107-86200
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		

\* The right and left slide plates are not included in the parts represented by the typical part numbers.

## OPTIONS

Model	Part No.	Description	Feature
AE-9 (kit C)	GAE09000CA0	for LU-2210N-7	The bobbin thread remaining-amount detecting device warns the operator with a buzzing sound and lamp indication of the time for bobbin thread replacement. This allows the operator to concentrate on sewing work without concern for the remaining amount of bobbin thread. Since the device directly detects the bobbin thread amount remaining, cumbersome setting is no longer required regardless of the material, thread and process.
AE-9 (kit D)	GAE09000DA0	for LU-2260N-7	

## ATTACHMENT

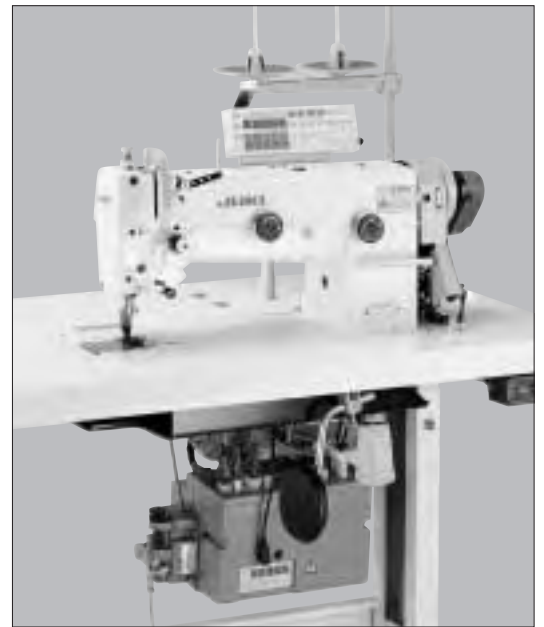
Part name	Part No.
H152 (suspended ruler)	MAH-152010A0

1-needle, Lockstitch, Zigzag Stitching Machine with Large Hook

# LZH-1290

## LZH-1290-7 (with 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 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 automatic thread trimmer

# LZH1290

● With automatic thread trimmer

# LZH129070B/

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	200 ~ 240V	<b>60</b>
For JUS (LA) *	Single-phase	100 ~ 120V	<b>61</b>
	3-phase	200 ~ 240V	<b>62</b>
For CE	Single-phase	200 ~ 240V	<b>63</b>

● PSC box/operation panel for SC

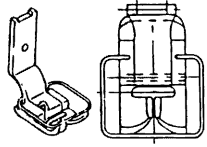
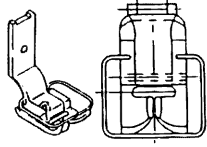
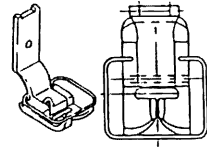
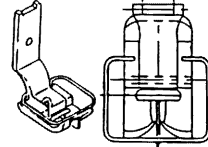
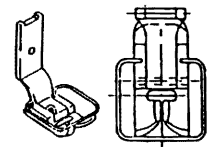
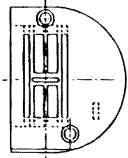
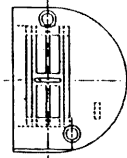
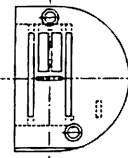
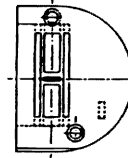
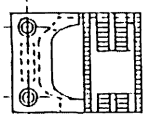
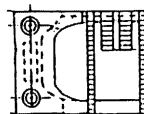
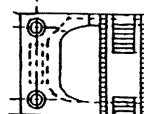
# SC380

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>

Operation panel		Code
Not provided		<b>00000</b>
Operation panel display language: English. Instruction manual comes in three different languages.		<b>E500B</b>
Operation 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.

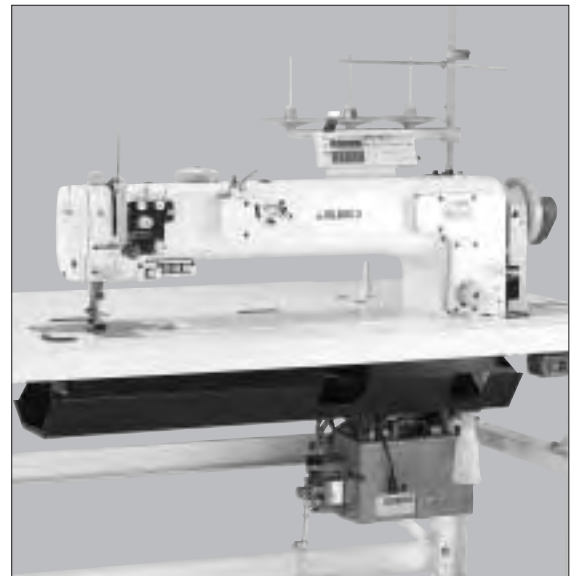


**Long-arm, Unison-feed, Lockstitch Machine  
with Vertical-axis Large Hook and Automatic Thread Trimmer**

**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 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

### LU2216NAASB70B

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.)

### LU2266NSDSB70B

Needle gauge	Code	Walking foot Presser foot Feed dog	Code
10mm (standard)*	D	Standard*	S

#### ● PSC box/operation panel for SC

SC380

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

Operation panel	Code
Not provided	00000
Operation panel display language: English. Instruction manual comes in three different languages.	E500B
Operation 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	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

## 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.

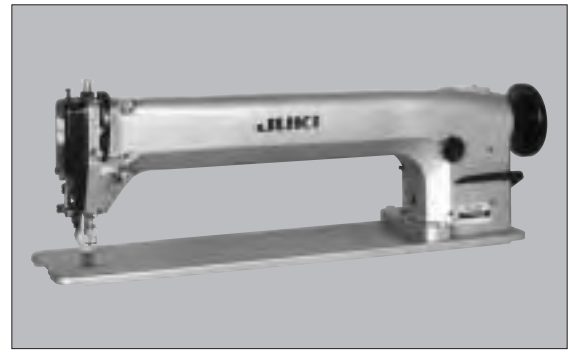
## ATTACHMENT

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 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

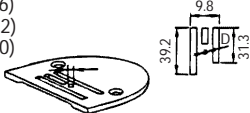
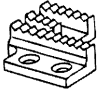
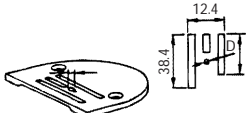


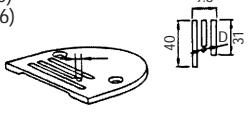
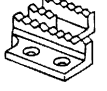

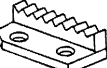
## SPECIFICATIONS

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

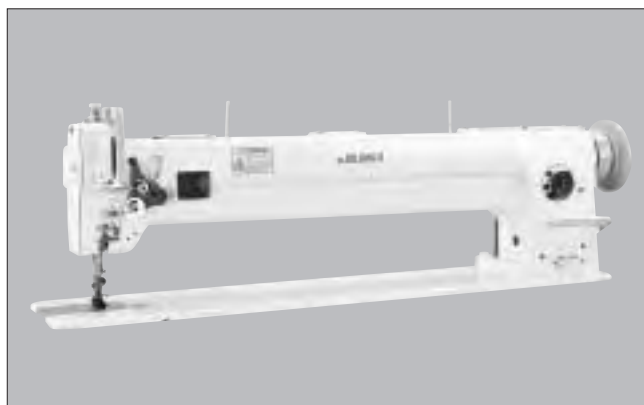
## EXCHANGEABLE GAUGE PARTS

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 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 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 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

DNU261H   /

Automatic reverse feed function	Code
Not provided	00
Provided	0B

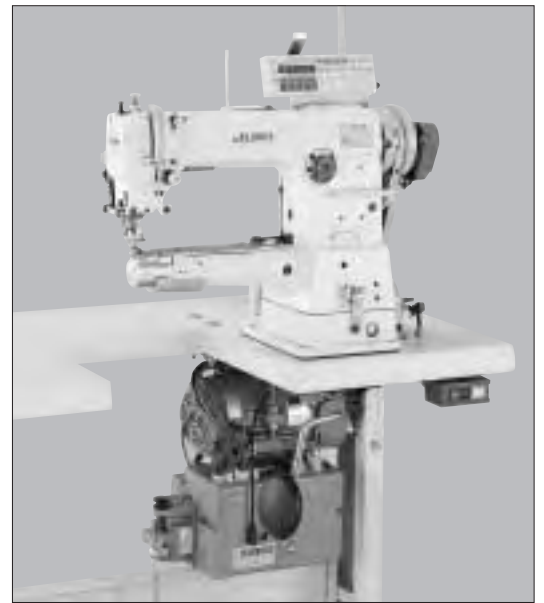
Pneumatic auto-lifter (optional)	Code
Knee switch type (AK70A)	A
Pedal switch type (AK70B)	B
Not provided	

Cylinder-bed, 1-needle, Top & Bottom-feed, Lockstitch Machine

# DSU-145

## DSU-145-7 (with automatic thread trimmer)

- The top & bottom-feed mechanism provides upgraded feed efficiency, feeding heavy 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 automatic thread trimmer

## DSU145

- With automatic thread trimmer

## DSU14570B/

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	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

- PSC box/operation panel for SC

## SC380



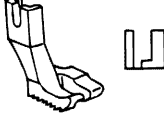


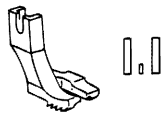


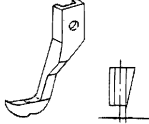
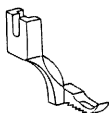
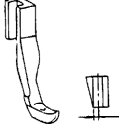
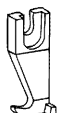



PSC box			Code
For General Export	Single-phase	220 ~ 240V	07
	3-phase	200 ~ 220V	11
For JUS (LA)*	Single-phase	110 ~ 120V	37
	3-phase	220 ~ 240V	38
For CE	Single-phase	220 ~ 240V	34

Operation panel		Code
Not provided		00000
Operation panel display language: English. Instruction manual comes in three different languages.		E500B
Operation panel display language: English. Instruction manual comes in five different languages.		E500C

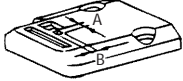
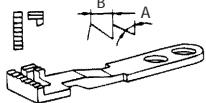

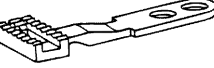

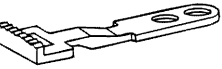
\* JUS: North America and Central and South America.

## 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 automatic thread trimmer)

**DSC-245** (with standard hook, automatically lubricated for hook)

**DSC-245-7** (with standard hook, automatically lubricated for hook and automatic thread trimmer)

**DSC-246** (with double-capacity hook)

**DSC-246-7** (with double-capacity hook and automatic thread trimmer)

- The unison-feed provides the optimal feed efficiency by feeding heavy 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-245-7-0B/XC-E500

- **DSC-246**  
The hook accommodates thread twice as long as that for a standard hook. It also reduces the frequency of bobbin thread replacement, thereby enabling the operator to smoothly conduct sewing with a higher degree of efficiency.
- **DSC-244-7, DSC-245-7, DSC-246-7**  
With its horizontal-cutting mechanism, the automatic thread trimmer cuts various kinds high-to low-count threads.

**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 automatic thread trimmer

DSC244/245/246

Feed system	Code
Elliptical feed	/
Horizontal feed	V

Automatic reverse feed function	Code
Not provided	/
Provided	0B

### ● With automatic thread trimmer

DSC244/245/246  70B/

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/operation panel for SC

SC380

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

Operation panel	Code
Not provided	00000
Operation panel display language: English. Instruction manual comes in three different languages.	E500B
Operation panel display language: English. Instruction manual comes in five different languages.	E500C

### ● Motor for SC

M

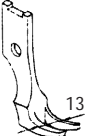



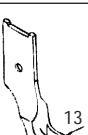


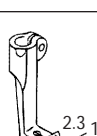
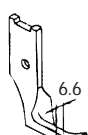



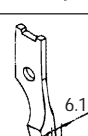

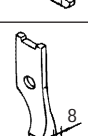
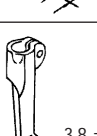
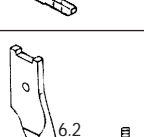
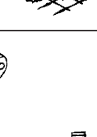


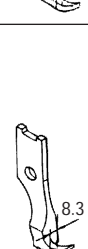
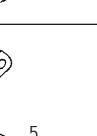
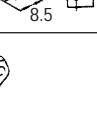
Motor			Code
For General Export	Single-phase	200 ~ 240V	60
	3-phase	200 ~ 240V	60
For JUS (LA)*	Single-phase	100 ~ 120V	61
	3-phase	200 ~ 240V	62
For CE	Single-phase	200 ~ 240V	63

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

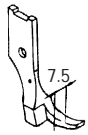
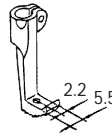

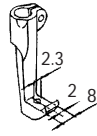

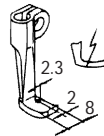


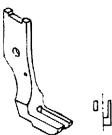

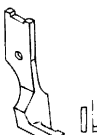

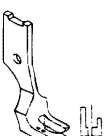

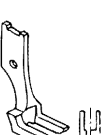

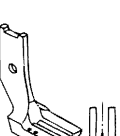



# EXCHANGEABLE GAUGE PARTS


● For 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

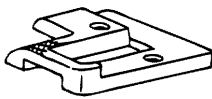
● For DSC-244(-7), 245(-7), 246(-7)

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-7: MAQ-09401000 DSC-246V-7: 211-41106	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: 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, Unison-feed, Lockstitch Machine with Vertical-axis Hook

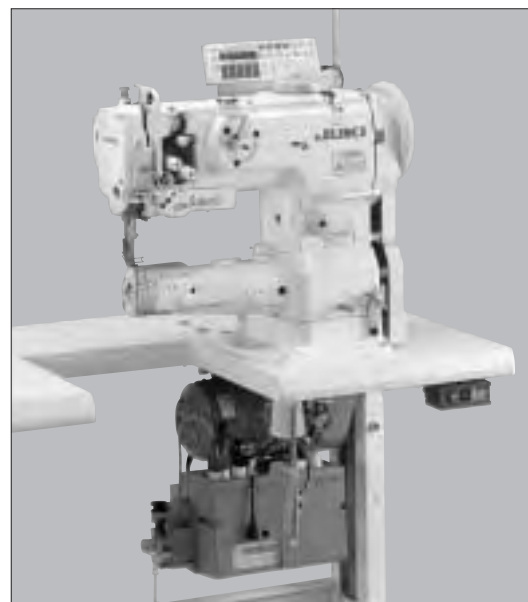
**LS-1340**

**LS-1341** (with large vertical-axis hook)

**LS-1342** (with large vertical-axis hook and gauge for small articles)

**LS-1342-7** (with large vertical-axis hook, gauge for small articles, and automatic thread trimmer)

- With its larger needlebar stroke, larger lift of the presser foot, and newly adopted double-tension mechanism, the machine sews beautifully with thick threads (low count thread) and at higher thread tensions. This allows the machine to sew a broad range of heavy materials.  
\* The LS-1340 is provided with a single-tension mechanism.
- The newly developed mode of highly rigid rectangular feed guarantees outstanding feed performance. In addition, the ratio between the alternating vertical movements of the walking foot and presser foot remains unchanged even when the material thickness changes. With this feature, the machine sews multi-layered parts of the material consistently and without stitch gathering.
- The machine is equipped as standard with a mechanism to correct uneven material feed by making-micro adjustments to the bottom-feed.
- The slimmed-down throat plate easily responds to the sewing of small tubular articles with diameters as small as 40mm.  
This enhances the machine's ability to smoothly sew not only bags and shoes, but also small articles such as wallets.



LS-1342-7-0BB/XC-E500

- **LS-1342, LS-1342-7**  
The vertical stroke of the presser foot and walking foot (amount of alternating vertical movement) can be easily changed with the large dial mounted on the top of the machine head. The sewing speed is automatically regulated based on the vertical stroke setting. This ensures ideal sewing conditions at all times.
- **LS-1342-7**  
The machine is provided as standard with an instantaneous change-over device for the alternate vertical movement amount (DL device).  
For sewing processes that handle heavy materials or multi-layered parts of material, the alternating vertical movements of the walking foot and presser foot can be quickly set to maximum by pressing the DL switch. The result is beautiful seams free from gathered stitches.

**WHEN YOU PLACE ORDERS**

● Without automatic thread trimmer

LS134

Specification	Code
Vertical-axis standard hook	1340
Vertical-axis 1.6 fold-capacity hook	1341
Vertical-axis 1.6 fold-capacity hook/ Gauge for small articles*	1342

\* For the LS-1342, a servomotor or motor with an electronic stop mechanism should be used. (Speed control is required.)

● With automatic thread trimmer

LS134270B

Specification	Code
Vertical-axis 1.6 fold-capacity hook/ Gauge for small articles	1342

Pneumatic auto-lifter	Code
Not provided	
Pedal switch type (AK123C)	B

● 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/operation panel for SC

SC380

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

Operation panel		Code
Not provided		00000
Operation panel display language: English. Instruction manual comes in three different languages.		E500B
Operation panel display language: English. Instruction manual comes in five different languages.		E500C

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

## SPECIFICATIONS

Model name	LS-1340	LS-1341	LS-1342	LS-1342-7
Gauge type	Standard		For small articles	
Max. sewing speed **	2,000rpm		2,500rpm	
Max. stitch length	6mm (Normal/Reverse feed)			
Needle bar stroke	36mm			
Lift of the presser foot	By hand: 9mm, By knee: 16mm			
Thread take-up	Slide type			
Amount of alternating vertical movement	2.5 ~ 6.5mm		1 ~ 6.5mm	
Hook	Vertical-axis standard hook	Vertical-axis 1.6 fold-capacity hook		
Needle (at the time of delivery)	135 x 17 (Nm140) Nm100~Nm180		135 x 17 (Nm160) Nm100~Nm180	
Thread	#50 ~ #8, B33 ~ B92, Nm=120/3 ~ 30/3	#40 ~ #5, B33 ~ B138, Nm=90/3 ~ 20/3		#30 ~ #5, B46 ~ B138, Nm=60/3 ~ 20/3
Safety mechanism	Provided as standard			
Lubrication	Centralized oil wick lubrication (hook: by an oiler)			
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)			
Distance from needle to machine arm	255mm			
Cylinder-bed diameter	72mm			
Weight of the machine head	37.5kg		40kg	
Automatic 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 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V	

\* Compressed air is indispensable

### \*\* SEWING SPEED TABLE

The maximum sewing speed has been specified in accordance with sewing conditions as shown in table below.

Set the maximum sewing speed appropriately in accordance with the sewing conditions given taking care not to exceed the corresponding specified value.

#### ● LS-1340, LS-1341

Amount of alternate vertical movement of the walking foot and presser foot	Stitch length: 6mm or less
2.5mm	2,500rpm
2.5mm to less than 3mm	2,200rpm
3mm to less than 4mm	2,000rpm
4mm to less than 6.5mm	1,600rpm

#### ● LS-1342, LS-1342-7

Amount of alternate vertical movement of the walking foot and presser foot	Stitch length: 6mm or less
Less than 2.5mm	2,500rpm
2.5mm to less than 4mm	2,200rpm
4mm to less than 4.75mm	1,800rpm
4.75mm to less than 6.5mm	1,600rpm



LS-1341



LS-1342



LS-1342-7

## OPTIONS

### ● Pneumatic auto-lifter

Model name	Type	Part No.	Switch type		Air regulator	
			Knee switch type	Pedal switch type	Not provided	Provided
LS-1340	AK119A	GAK-A19010A0				
LS-1341	AK119B	GAK-A19010B0				
LS-1342	AK120A	GAK-A20010A0				
LS-1342-7	AK120B	GAK-A20010B0				
LS-1342-7	AK123C	GAK-A2302EB0				

### ● Automatic reverse feed function

Model name	Part No.	Remarks
LS-1340, 1341, 1342	213-48552	Provided with air regulator

\* To use pneumatic auto-lifter and reverse feed function in combination with a machine that is without automatic thread trimmer, select AK119A or AK119B.

### ● Instantaneous change-over device for the alternate vertical movement amount (DL device). \*

Model name	Part No.	Remarks
LS-1342	GDL-21000AB0	Accessories set containing [DL21 + Automatic reverse feed function + AK123B]
	GDL-21000EA0	[DL21 (E kit)] for installed after the setup of the machine

\* The DL device cannot be used alone. It must be used in a set together with the automatic reverse feed function and AK123B.

\* To mount the DL device to a machine with auto lifter and automatic reverse feed function, the DL21 (E kit) should be purchased separately.

### ● Combination of optional devices

Model name	Combination	Pneumatic auto-lifter	Automatic reverse feed function	DL device
LS-1340	Automatic reverse feed function			
	Pneumatic auto-lifter	AK120A		
LS-1341		AK120B		
LS-1342	Pneumatic auto-lifter+	AK119A		
	Automatic reverse feed function	AK119B		
LS-1342	Pneumatic auto-lifter+	AK119B		DL21(E kit)
	Automatic reverse feed function+	Accessories set containing [AK123B+ Automatic reverse feed function+DL21]		
LS-1342-7	Pneumatic auto-lifter+	AK123C	Provided as standard	Provided as standard
	Automatic reverse feed function+			
	DL device			

Model	Part No.	Description	Feature		
	214-34758	LS-1340	V type kit		
	214-34857	LS-1341			
	214-34956	LS-1342			
V type binder N074		Tape width (mm)	LS-1340		
	MAN-0740M0AB	26		LS-1341	
	MAN-0740K0AB	22			LS-1342
	MAN-0740H0AB	18			
	MAN-0740F0AC	13 ~ 14			
MAN-0740E0AC	11 ~ 12	5			
	B9101-340-0A0		Edge guide		
	B9104-340-000	Binder set plate	For binder		
H152	MAH-152010A0	Ruler	Suspended ruler		
	SS-7151610SP × 2	Screw			
	WP-0621016SD × 2	Washer			
	WS-0610002KN × 2	Spring washer			
	214-33404	Presser lifter arm	Pedal type lifter		
	SM-6051602TP	Screw			
	214-33503	Presser lifter plate			
	SM-6051552TP × 2	Screw			
	B8133-019-000 × 2	S shaped hook			
	B8131-019-000	Chain			
PK75	GPK-750000A0	3-pedal unit	Applicable model: LS-1342-7 Highly operable 3-pedal unit for standing work.		



V type kit



Edge guide



Pedal type lifter

1-needle, Post-bed, Unison-feed, Lockstitch Machine

## PLC-1610

### PLC-1610-7 (with 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 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	

PLC1610SSSA

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 servomotor or electronic-stop motor (DC 24 V is required.)

PLC1610SSA70B

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/operation panel for SC

SC380

PSC box				Code	Operation panel		Code
For General Export	Single-phase	220 ~ 240V		07	Not provided		00000
	3-phase	200 ~ 220V		11	Operation panel display language: English. Instruction manual comes in three different languages.		E500B
For JUS (LA)*	Single-phase	110 ~ 120V		37	Operation 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	200 ~ 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.



## 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 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 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 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

**PLC1660** [ ] [ ] [ ] [ ] [ ] [ ]

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 servomotor or electronic-stop motor (DC 24 V is required).

Presser foot	Code
Standard	S

Feed dog	Code
Round hole( 2.4)	A
Slot (2.4mm × 3.8mm) Standard	B
Slot (3.5mm × 4.5mm)	C

**PLC1665** [ ] [ ] **S** [ ] [ ]

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 servomotor or electronic-stop motor (DC 24 V is required).

Feed dog	Code
Round hole( 2.4)	A

Pneumatic auto-lifter	Code
Knee switch type (AK116A)	A
Pedal switch type (AK116B)	B

**PLC1660** [ ] [ ] [ ] **A 70B** [ ]

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.

Presser foot	Code
Standard	S
Provide with center guide (needle gauge: 8mm)	A

## ● PSC box/operation panel for SC

**SC380** [ ] [ ] [ ] [ ] [ ] [ ] [ ]

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.

Operation panel	Code
Not provided	00000
Operation panel display language: English. Instruction manual comes in three different languages.	E500B
Operation panel display language: English. Instruction manual comes in five different languages.	E500C

## ● Motor for SC

**M** [ ] [ ]

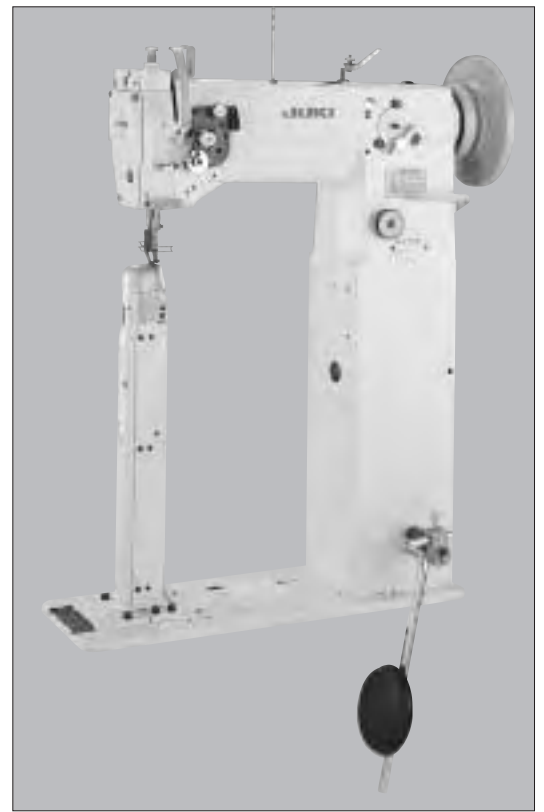
Motor		Code
For General Export	Single-phase 200 ~ 240V	60
	3-phase	
* For JUS (LA)	Single-phase 100 ~ 120V	61
	3-phase 200 ~ 240V	62
For CE	Single-phase 200 ~ 240V	63

1-needle, High Post-bed, Unison-feed, Lockstitch Machine

**PLC-1690** (with vertical-axis 1.6 fold-capacity hook)

**PLC-1691** (with 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 (φ175) can be easily turned by the operator when performing one-stitch sewing.



PLC-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 × 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 winder	Built on the machine arm		
Post height	420mm	424.5mm	
Post position	Left		
Bed size	517mm × 178mm		
Weight of the machine head	57kg		

**WHEN YOU PLACE ORDERS**



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 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

### PLH981

- 1-needle, Needle-feed

### PLN985

- 2-needle, Bottom-feed

### PLH982B


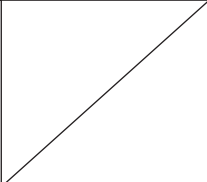





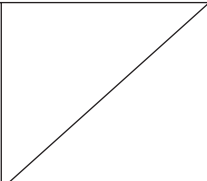




Needle gauge	Code
1.2mm	12
1.6mm	16
2.0mm	20
2.4mm (standard)	24

- 2-needle, Needle-feed

### PLN986B

Needle gauge	Code
1.6mm	16
2.4mm (standard)	24

## GAUGE TABLE (2-NEEDLE TYPE)

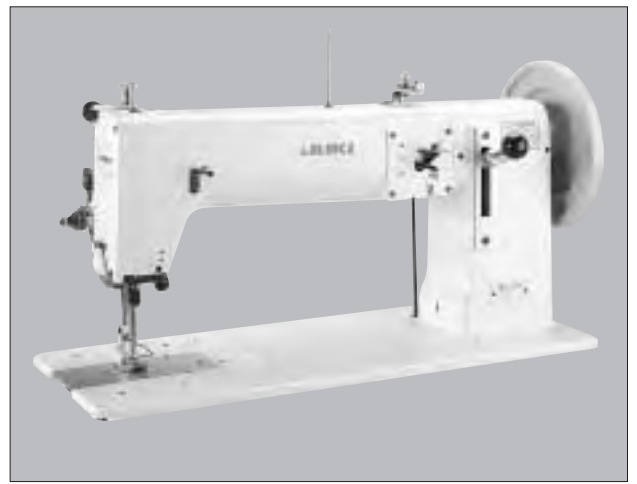
Model name	Needle gauge	Gauge set	Needle clamp	Needle guide	Throat plate	Feed dog
PLH-982						
	1.2mm	210-16357	210-17405	210-18908	210-16308	210-21100
	1.6mm	210-16159			210-16100	
	2.0mm	210-16258	210-17504	210-18809	210-16209	210-21209
2.4mm (standard)	210-16050	210-16019			210-21308	
PLN-986						
	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 Large Shuttle-hook for Extra Heavy 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 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 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 winder	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**



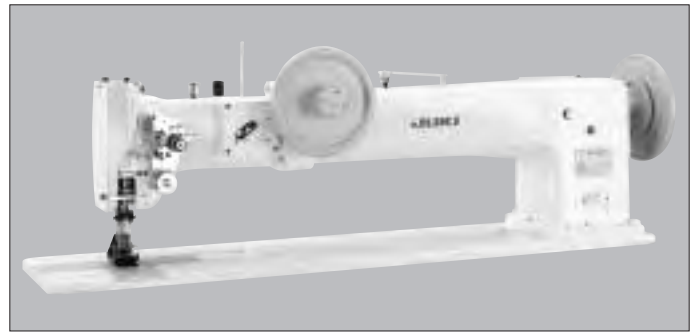
Auto-lifter	Code
Not provided	
Knee switch type (AK72A)	<b>A</b>
Pedal switch type (AK72B)	<b>B</b>

**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 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 materials.



LG-158



**SPECIFICATIONS**



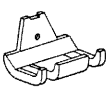



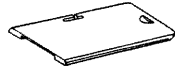
Model name	LG-158	LG-158-1
	2-needle	1-needle
Max. sewing speed	1,500rpm	
Max. stitch length	10mm (normal/reverse feed)	
Needle bar stroke	46.9mm	
Needle gauge	Standard 19.1mm (3/4")	
Lift of the presser foot	By pedal: 21.5mm	
Thread take-up	Side type	
Alternating vertical movement	6 ~ 19mm	
Hook	Vertical-axis 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**

**LG158**  **LG1581**

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 Large Shuttle-hook for Extra Heavy 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 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 materials sewn with lower-count threads.



TSC-441

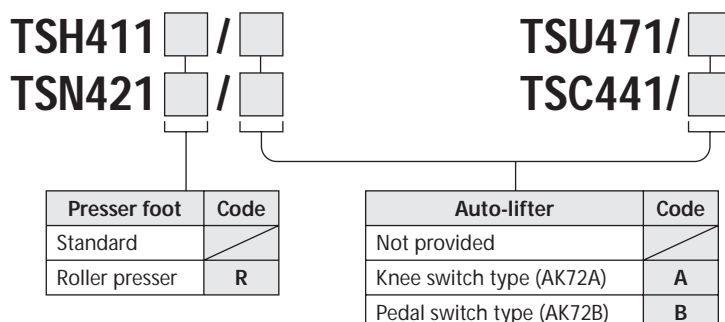
## FEATURES

Model name	Feature	Application
TSH-411	The TSH-411 can be modified to sew sharp curves by replacing the presser foot with 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 Large Shuttle-hook for Extra Heavy 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 materials.
- The machine comes with a large shuttle hook and large bobbin which have been exclusively designed for sewing extra heavy materials: these reduce the frequency of bobbin replacement, thereby leading to higher efficiency in sewing extra heavy 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

TSC461/



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.

# 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	5.614	
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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