

MOL-254N

Automatic 2-needle Belt-Loop Attaching Machine



PATENTED!!

The world's first dog ear prevention mechanism

SPECIFICATIONS

Model name	MOL-254N
Machine head	Computer-controlled, 2-needle, lockstitch bartacking machine
Max. sewing speed	2,500sti/min*
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)	DPx17 (#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	43~70mm (1-11/16"~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 EP-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-phase, 3-phase 200~240V/350VA
Compressed air and air consumption	0.5MPa (5kgf/cm ²), 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)

* sti/min is the abbreviation for "stitches per minute"

WHEN YOU PLACE ORDERS

Please note when placing orders, that the model name should be written as follows:

MOL-254N □ □ □ □ □

Power supply	Code	Options	Code
Single-/3-phase 200V-240V	D	No options	Z
		Loop detection sensor	B
		Air gun	C
		Needle cooler	D
		Needle thread breakage detector	E

<p>JUKI ECO PRODUCTS</p>	<p>The MOL-254N is an eco-friendly product which complies with JUKI ECO PRODUCTS standards for protecting the environment.</p> <ul style="list-style-type: none"> The sewing machine complies with the "Juki Group Green Procurement Guidelines" on the use of hazardous substances, which is stricter than other restrictions, such as those of the RoHS Directive. <p>For details of JUKI ECO PRODUCTS, refer to: https://www.juki.co.jp/en/company/eco</p> <p><small>*The RoHS Directive is an EU Directive limiting the use of 6 hazardous substances (lead, hexavalent chromium, mercury, cadmium, PBB and PBDE) in electrical and electronic equipment. The Juki Green Procurement Guideline is the voluntarily established criteria to eliminate not only the aforementioned six substances, but also other ones which also adversely affect the environment.</small></p>
--------------------------	---



Registered Organization: JUKI CORPORATION Head Office
The Scope of the Registration: The activities of research, development, design, sales, distribution, and maintenance services of industrial sewing machines, household sewing machines and industrial robots, etc., including sales and maintenance services of data entry systems.



JUKI CORPORATION
SEWING MACHINERY & SYSTEMS BUSINESS UNIT

2-11-1, TSURUMAKI, TAMA-SHI,
TOKYO 206-8551, JAPAN
PHONE: (81) 42-357-2370
FAX: (81) 42-357-2274
<https://www.juki.co.jp/en>

- * Specifications and appearance are subject to change without prior notice for improvement.
- * Read the instruction manual before putting the machine into service to ensure safety.
- * This catalogue prints with environment-friendly soyink on recycle paper.
- * Paper from responsible sources FSC™ C001712

MOL-254N

The MOL-254N feeds, cuts, and sews belt loops automatically at high speeds with high-quality output.



Productivity

With its machine head exclusively developed for sewing belt loops and its belt loop supply unit, the MOL-254N achieves the industry-leading production capacity.

Equipped with a direct drive system. High work efficiency is achieved with the improved start-up performance and sewing speed. The belt loop supply device has a halfway standby function for the next batch of belt loops. Automatic resupply after supply failure reduces downtime.

Top class in the industry!



Top class in the industry!

Features of the MOL-254N

Production Volume
200~250 garments/1h

- The machine time is 9 seconds per 5 belt-loop (with 28 stitches).
- Hours of work: 1 hours. Allowance rate: 20%

High quality

Beautiful finishes without dog ears and enhanced results with a stable fullness function

Operability

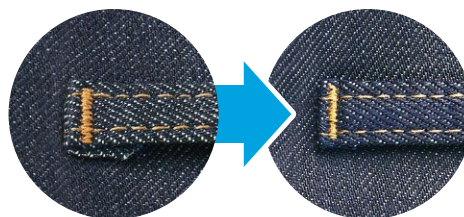
The number of needles, bartacking size, and cutting method can be easily changed by panel operation. No need to replace the feed plate when changing needle widths, for greatly reduced setup changeover times.

High quality

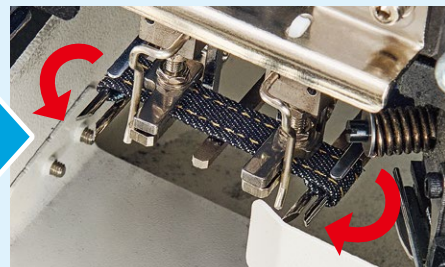
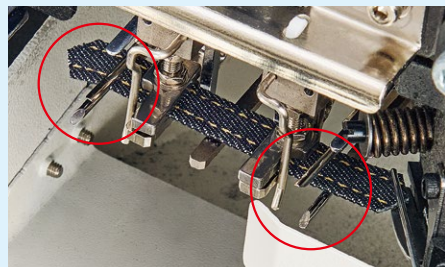
The folding fork and gate-shaped presser ensure the sewing of quality belt loops with no dog ears.

The folding fork pinches the fabric according to the thickness of the belt loop, eliminating fabric misalignment within the fork and ensuring secure loop bending. The newly adopted gate-shaped presser securely fastens and sews belt loops and helps to prevent dog ears and stitch skipping.

Prevents dog ears!

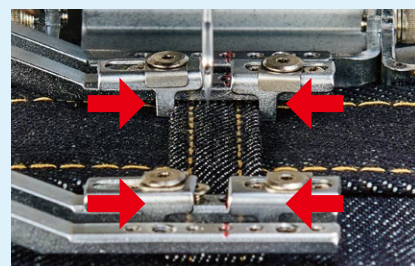


Folding fork NEW



Gate-shaped presser NEW

The gate-shaped presser surrounds belt loops to be sewn from all sides to stop the fabric from shifting during sewing.



New fullness mechanism provided as standard equipment NEW

The new fullness mechanism provided as standard firmly holds the belt loop and loosens it (fullness) in a swift and stable motion according to the selected quality specifications.



Operability

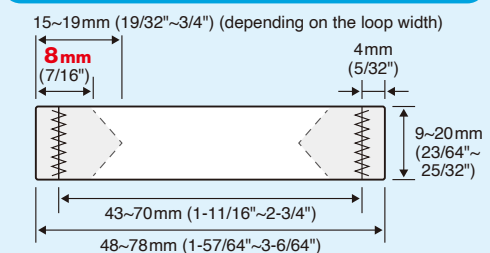
The computer-controlled X-Y linear feed system lets you program the number of stitches and bartacking size. You can also switch between cross cutting and straight cutting with a simple operation.

Change the bartacking size and stitch number for belt loop sewing with a few easy taps on the operation panel. You can switch between cross cut and straight cut, as well as switch the cut length. Since the cut length is shortened, cutting work in the next process can be omitted.

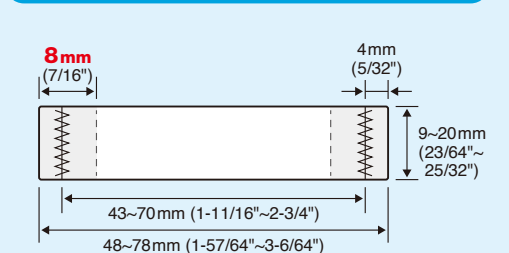
Finished Belt-loop Stitch Size

A seam allowance of 8mm is achieved!

Cross Cutting (Standard)



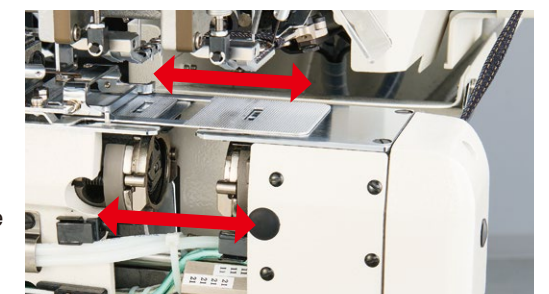
Straight Cutting



• The machine is factory-equipped with cross-cutting device at the time of delivery.

The motorized back-and-forth movement of the hook shaft during needle-width adjustment eliminates the need for feed plate replacement.

Move the hook shaft back and forth by motor when changing the needle width. Simply loosen a screw to adjust the feed plate. These simple features spare you the effort and cost of parts replacement.



OPTIONS

Loop detection sensor

The loop detection sensor detects clogging of belt loops while supplying them. If belt loops clog up and cannot be supplied, the sewing machine displays an error message and stops its operation.

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.

Needle cooler

The device cools the frictional heat generated by the needle during sewing.

Air gun assembly