

# **JUKI**®

INDUSTRIAL SEWING MACHINE  
Attachment

MODEL

## **MP-G25-MF**

TECHNICAL MANUAL


Manual Foot Pedal



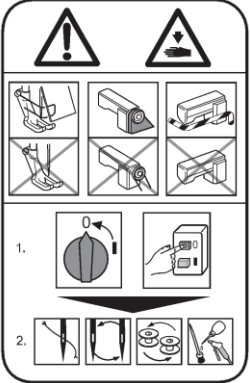


# FOR SAFE USE

Before the installation, operation, and inspection for this product, read the “FOR SAFE USE” and the technical manuals carefully. Also read the other technical manuals, “Sewing Machine Head”, “Control Unit” and “Operation Panel” describing some instructions, which are not in this manual, and use the sewing machine properly.

## SAFETY INDICATIONS

	<p><b>CAUTION</b></p> <p>Indicates that incorrect handling may cause hazardous conditions, resulting in medium or slight personal injury or physical damage. Note that CAUTION level may lead to a serious consequence according to the circumstances. Always follow the instructions of both levels because they are important to personal safety.</p>
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## CAUTION INDICATIONS

No.	Caution indication	Description
1		<p><u>Precaution for sewing machine operation:</u></p> <p>Indicates that removing the safety and operating the sewing machine for some other purposes with power-on are prohibited.</p> <ul style="list-style-type: none"> <li>● Please do not operate the sewing machine without protective equipment such as a needle guard, an eye guard, a belt cover or the others.</li> <li>● Please turn off the power switch when threading, changing a needle and a bobbin, cleaning, and lubricating.</li> </ul>
2		<p><u>Caution for fingers injury:</u></p> <p>Indicates a possibility of fingers (hands) injury in a certain condition.</p>
3		<p><u>Caution for squeezing fingers:</u></p> <p>Indicates a possibility of squeezing fingers in a certain condition.</p>

# 1. Setup procedures

## 1-1. Pedal mechanism

- 1) Tighten the screws (102) halfway in A and B of the table back side.
- 2) Hang the long hole point A and B of the link unit (101).
- 3) Adjust the position of the link unit (101). Tighten the remaining screws (102) and tighten the screw of temporary tightening.
- 4) Attach the pedal unit (103) and the holder (104) by the screws (105).
- 5) Put projection part of the holders (104) in the long hole of the support stand. Temporarily fixed the holder (104) by the nuts (106) and the bolts (107).
- 6) Fix the link unit (101) and the rod link (108) by the bolts (109) and the nuts (110).
- 7) Fix the rod link (108) and the pedal (111) by the bolt (112) and the nut (110).
- 8) The pedal unit (103) is sideways moved to the position in which the rod link (108) does not fall to right and left. Fix with the bolts (107).
- 9) Loosen the D bolts. The pedal is moved back and forth at the position that steps easily. Tighten the D bolts.
- 10) Tighten the C bolts of the rod link (108).
- 11) Hang the hook (113) on the E hole. (after assembling the manual mechanism)

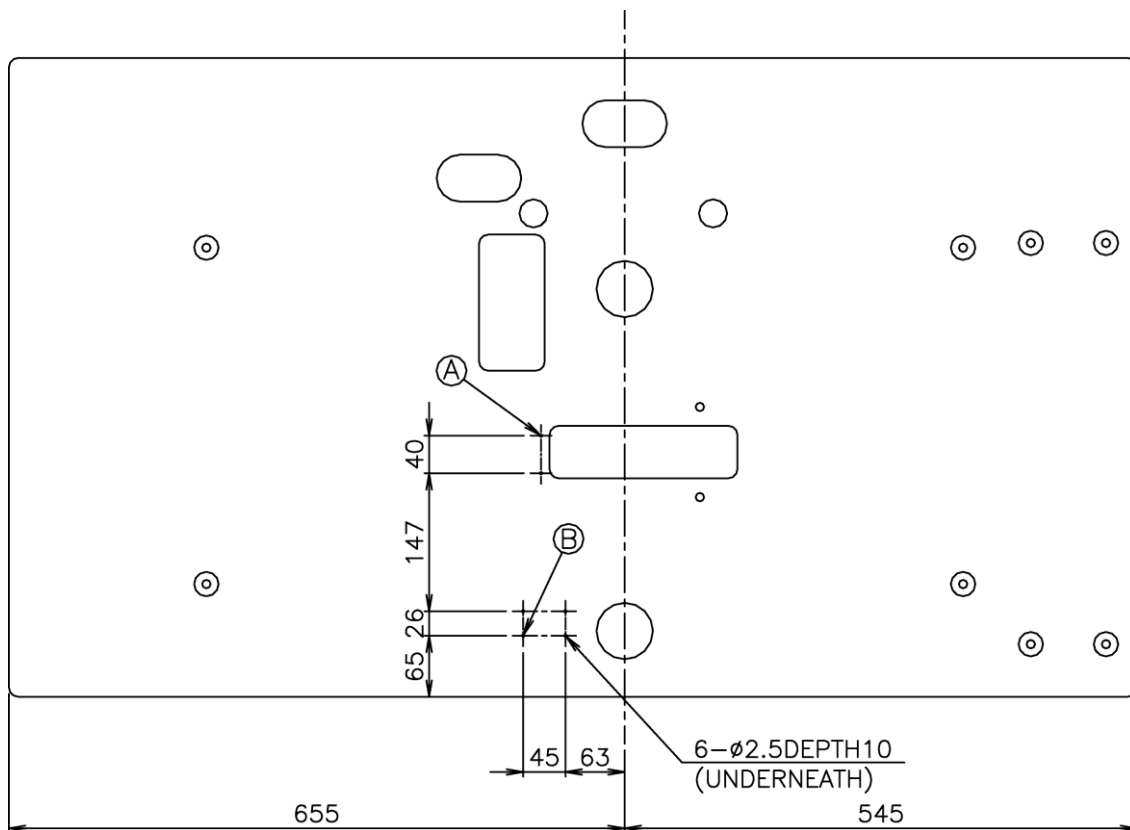


Fig.1 An installation position to the table (the back side)

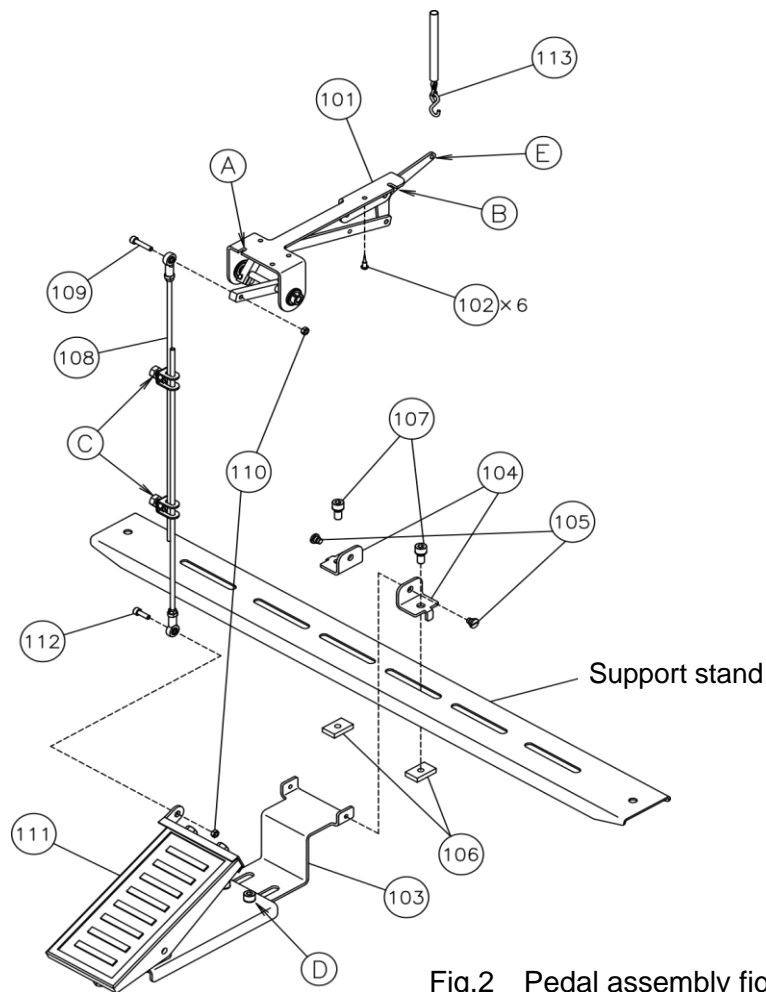


Fig.2 Pedal assembly figure

1-1. Pedal assembly (Parts list)

Fig	部品コード	品名	Description	数量
No.	Parts No.			Amt.
				Req.
101	MH25M0748	ペダルリンクコウクミタテ	Pedal link assy	1
102	M90409041	マルモクネジ 4.5×20	Wood screw D=4.5 L=20	6
103	MH20M0601	ペダルトリツケイタ	Pedal adaptor	1
104	MH20M1780	ホルダ	Holder	2
105	M91690015	ヒラネジダツキ	Screw 1/4(40)X4	2
106	M98606047	シクナット	Square Nut	2
107	M98003017	セフティソケット M8X16	Safety socket bolt M8X16	2
108	MH20M0955	レンケツホウクミタテ	Pitman rod assy	1
109	M95011021	ロッカクアナツキボルト M5X25	Socket bolt M5X25	1
110	M91382045	ロッカクナット M5	Nut M5	2
111	MH20M1748	ペダルクミタテ	Pedal assy	1
112	M95001021	ロッカクアナツキボルト M5X16	Socket bolt M5X16	1
113	MH20M0376	クサリセット	Chain set	1

## 1-2. Manual mechanism

- 1) Remove the top cover (251).
- 2) Remove the cover (252).
- 3) Remove the three bolts (253). Move the motor (254) so that the two cables (255 and 256) is not damaged.
- 4) Remove the J bolts and K bolts, and remove the clamp bracket.
- 5) Fix the guide pin (201) in the screw hole (401).
- 6) Remove the existing cover (402). Fix the slide bushing (202) by the bolts (203).
- 7) Pass the shaft (204) through the hole (403) in the left side, and put the pushing lever (206) in between two collars (205) in the inside of the arm.
- 8) Adjust the shaft (204) to the arm edge side, and fix the set side of the shaft with the screw (207).
- 9) Fix the bolt (208), the nut (209), and the washer (210) in screw hole (404). Fix the nut (209) so that the protrusive bolt (208) 30mm from arm edge side.
- 10) Attach the spring (211) on the lever (212), and pass the shaft of the lever (212) through the hole (405). Put the pushing lever (206) on the protrusive shaft of the arm inside, and fix the set sides of the pushing lever (206) by the F screw.
- 11) Pass the pressure plate (213) through the hole (402) from the under side, and the guide pin (201) enter the projection part of pressure plate (213).
- 12) Fix the pushing lever (206) to the pressure plate (213) by the screw (214).
- 13) Pass the shaft of pressure plate (213) through the holder (215). Temporarily fix the holder (215) with the bolts (216). Fix the holder (215) at the place that the pressure plate (213) moves smoothly.
- 14) Confirm whether the lever (212) and the pressure plate (213) move smoothly, and fix the pushing lever (206) in between two collars (205).
- 15) Fix the nut (218) so that the protrusive bolt (217) 10mm from the arm upper side of screw hole (406).
- 16) Hang the spring (219) to the bolt (217). Hang the other side on the G hole.
- 17) Pass the shaft of lever (212) through the lever (220), and fix it.
- 18) Temporarily fix the switch (221) to the hole (407) using the screw (222).
- 19) Fix at the place that the switch does ON of with the lever. (Becomes cause to break when the power to push the switch is strong at this time.)
- 20) Pass the switch cable (221) through from the below of the arm inside, and lead the cable to the solenoid PCB from the hole of the bed. Fix the cable to the place that doesn't come in contact with another.
- 21) Insert the switch cable (221) connector to the solenoid PCB.
- 22) Put the hook (113) in the cushion (223).
- 23) Hang the hook (113) on the H hole of lever (212).

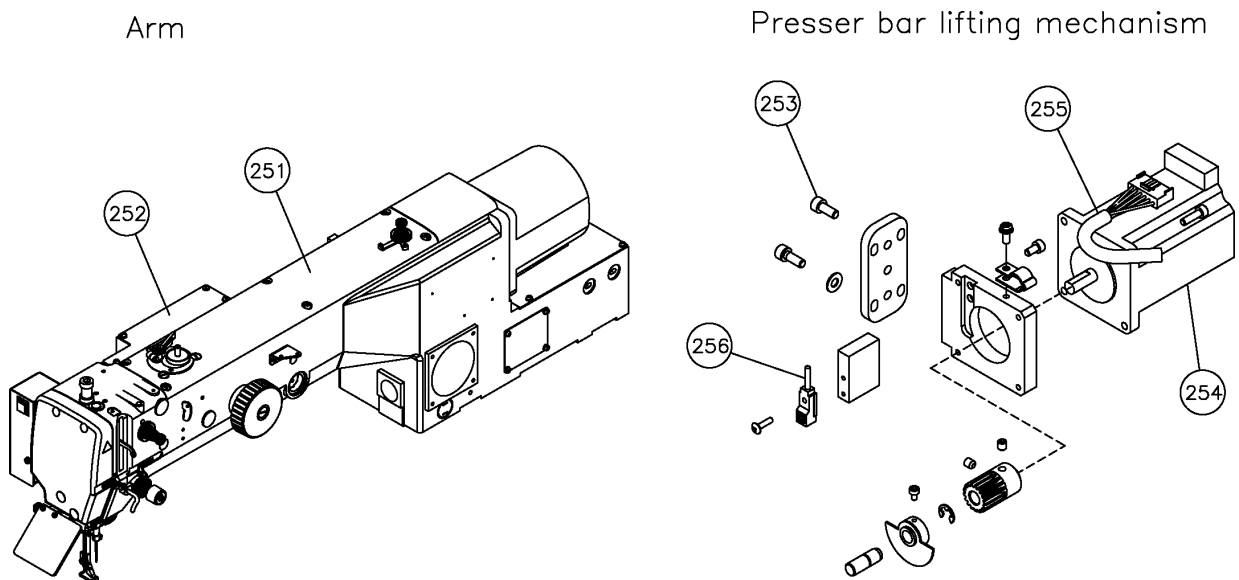


Fig.3 Disassembly figure

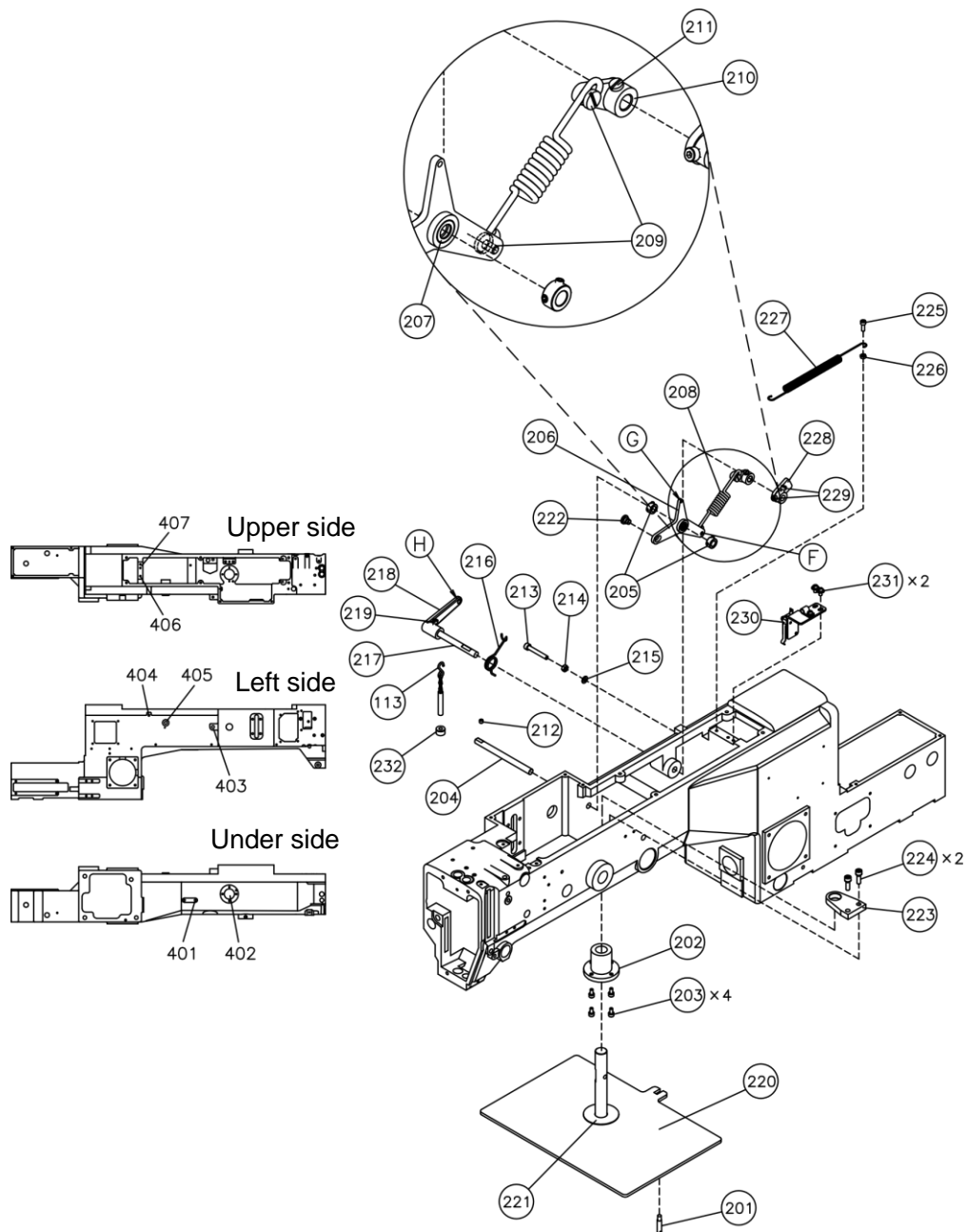


Fig.4 Manual mechanism assembly figure

1-2. Manual mechanism (Parts list)

Fig	部品コード	品名	Description	数量
No.	Parts No.			Amt.
				Req.
201	ME10A0802	マワリ止め	Stopper	1
202	MH20M0750	スライドブッシュ	Slide bushing	1
203	M95018021	ロツカクアナツキボルト M4X8	Socket bolt M4X8	4
204	MH25M0454	マニュアルオサエシク	MF shaft	1
205	MH20M0352	カラークミタテ	Collar assy	2
206	MH25M0266	マニュアルオサエレバー	MF lever	1
207	MH20M0456	シエルガタハリジョウコソジクウケ	Bearing	1
208	MH25M0700	ハネ	Spring	1
209	M91127015	ヒラネジダツキ	Screw 11/64(40)X5	2
210	MA10A1950	レバー	Lever	1
211	M91109002	ヒラネジ	Screw 11/64(40)X7	1
212	M95004021	ロツカクアナツキトメネジ M5X5	Screw M5X5	1
213	M95008021	ロツカクアナツキボルト M5X35	Socket bolt M5X35	1
214	M91382045	ロツカクナット M5	Nut M5	1
215	M90512050	コサガネ 5	Washer 5	1
216	MA10A0729	ヒネリハネ	Spring	1
217	MH25M1454	マニュアルオサエシク B	MF shaft B	1
218	MH10A0950	レバー	Lever	1
219	M95018021	ロツカクアナツキボルト M4X8	Socket bolt M4X8	1
220	MH25M0257	オサエイタクミタテ	Presser plate assy	1
221	MH20M0416	カンショウイタ	Rubber cushion	1
222	M91690015	ヒラネジダツキ	Screw 1/4(40)X4	1
223	MH25M0780	シャフトホルダー	Shaft holder	1
224	M95004017	セフティソケット M5X16	Safety socket bolt M5X16	2
225	M94003021	ロツカクアナツキボルト M4X12	Socket bolt M4X12	1
226	M91007045	ロツカクナット M4	Nut M4	1
227	MH25M1700	オサエイタモシハネ	Spring	1
228	MH20M1950	ケンシュツレバー	Detector lever	1
229	M95018021	ロツカクアナツキボルト M4X8	Socket bolt M4X8	2
230	MH20M0485	スイッチトリツケイタクミタテ	Switch adaptor assy	1
231	M91071004	SW-MW ツキ プラマイナベネジ	Screw M4X8	2
232	MH20M0397	クッション	Cushion	1
251	MH27A0600	トップカバー	Top cover	1
252	MH27A0339	アームジョウブカバー	Cover	1
253	M95003021	ロツカクアナツキボルト M5X12	Socket bolt M5X12	3
254	MH10A1848	ステッピングモータ	Stepping motor	1
255	MH27A0508	ケーブル (PF モータ)	Cable (PF motor)	1
256	MH27E0484	キンセツスイッチ	Detector	1

Note: Fig No.251 to No.256 are not included in this package. Please use existing parts which have standard PLK-G2516 or PLK-G2516R.



### 1-3. Clamp mechanism

The left side is similarly assembled with the explanation of the right side.

- 1) Confirm whether there is the screw hole in the rear of the clamp bracket which removed in step 1-2.4). When there is not the screw hole, please process the screw hole at the position of figure 5.
- 2) The shaft (301) is fixed to the even position of clamp bracket by the two screws (302).
- 3) Pass the right lever (303) through the shaft (301), and fixes by the collar (304).
- 4) Fix the right lever (303) and the cylinder lever (305) by the screw (306) and the nut (307).
- 5) Fix the clamp bracket with the reverse procedure of step 1-2. 4).
- 6) Put the shaft (308) between the right lever (303) and the left lever (311), and fix it by the washer (309) and the bolt (310).

The shaft (308) is the horizontal. The shaft (308) and the pressure plate (213) have a little space usually.

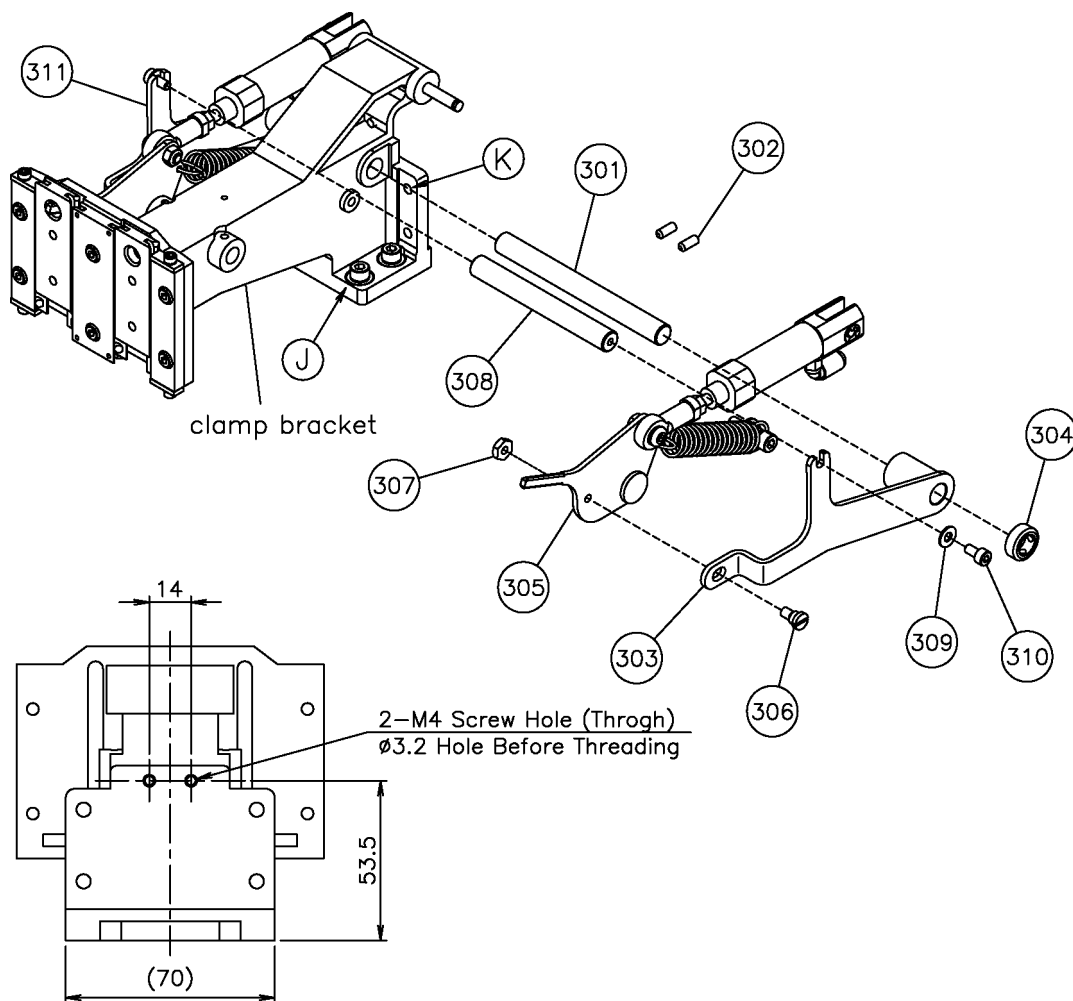


Fig.5 Clamp mechanism assembly figure

### 1-3. Clamp mechanism (Parts list)

Fig	部品コード	品名	Description	数量
No.	Parts No.			Amt.
				Req.
301	MH25M2454	ジク	Shaft	1
302	M91058020	ロツカクアナツキトメネジ M4X10	Screw M4X10	2
303	MH25M1266	マニュアルオサエレバー B ミキ	MF lever B right	1
304	MH27A0352	セットカラー	Set collar	2
305	MH20A0266	オサエレバー	Pushing lever	2
306	M91111015	ヒラネジダツツキ	Screw 11/64(40)X6.2	2
307	M91104045	ナツト	Nut 11/64(40)	2
308	MH25M3454	レンケツジク	Connecting shaft	1
309	M90421050	ミガキザガネ 4	Washer 4	2
310	M95018021	ロツカクアナツキボルト M4X8	Socket bolt M4X8	2
311	MH25M2266	マニュアルオサエレバー B ヒタリ	MF lever B left	1

Note: Fig No.305 is not included in this package. Please use existing parts which have standard PLK-G2516 or PLK-G2516R.

## 2. Operation

- (1) The holder plate (213) comes down when the pedal (111) is stepped on, and the clamp frame comes down.
- (2) If the position of sewing thing is decided, the work clamp is turned ON when the pedal (111) is stepped more. Quantity of stepping forward changes by adjusting lever (220).
- (3) Press the [Black] side on the foot switch to comes up the clamp frame.
- (4) Press the [Gray] side on the foot switch to rotate the sewing machine and start stitching.
- (5) When stitching is completed, the sewing machine will automatically return to home, and the clamp frame will comes up.



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