



INDUSTRIAL SEWING MACHINE
Attachment

MODEL

MP-J60-GJ

TECHNICAL MANUAL

JIG EJECT DEVICE

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



CAUTION

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.

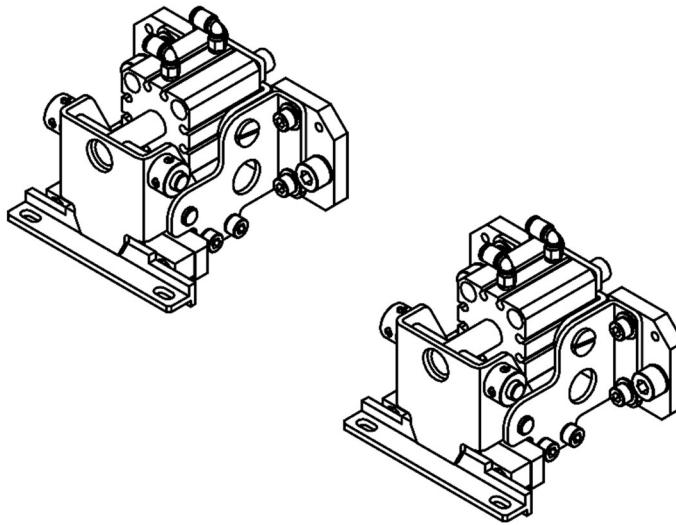
CAUTION INDICATIONS

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">● Please do not operate the sewing machine without protective equipment such as a needle guard, an eye guard, a belt cover or the others.● Please turn off the power switch when threading, changing a needle and a bobbin, cleaning, and lubricating.
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. Features

This device is a holding device for the work clamp. The same holding fixture (guide block) as the standard jig eject device of the PLK-G series can be used.

Notice Before using this device, be sure to fully understand the contents described in this technical document and confirm that your work clamp conforms to the specifications of this device. Refer to [5. The positional relationship between the sewing area and the jig eject device] in this technical document to confirm the work clamp fabrication and the sewing area.



2. Specifications

Name		: MP-J60-GJ (Jig eject device)
Applicable model		: PLK-J6040/J6040R/J6040R3/J6040RH
Sewing area		: 600 (X) x 400 (Y) mm
Drive source air pressure	Primary side	: 0.5 MPa (5 kg/cm ²)
	Secondary side	: 0.4 MPa (4 kg/cm ²)

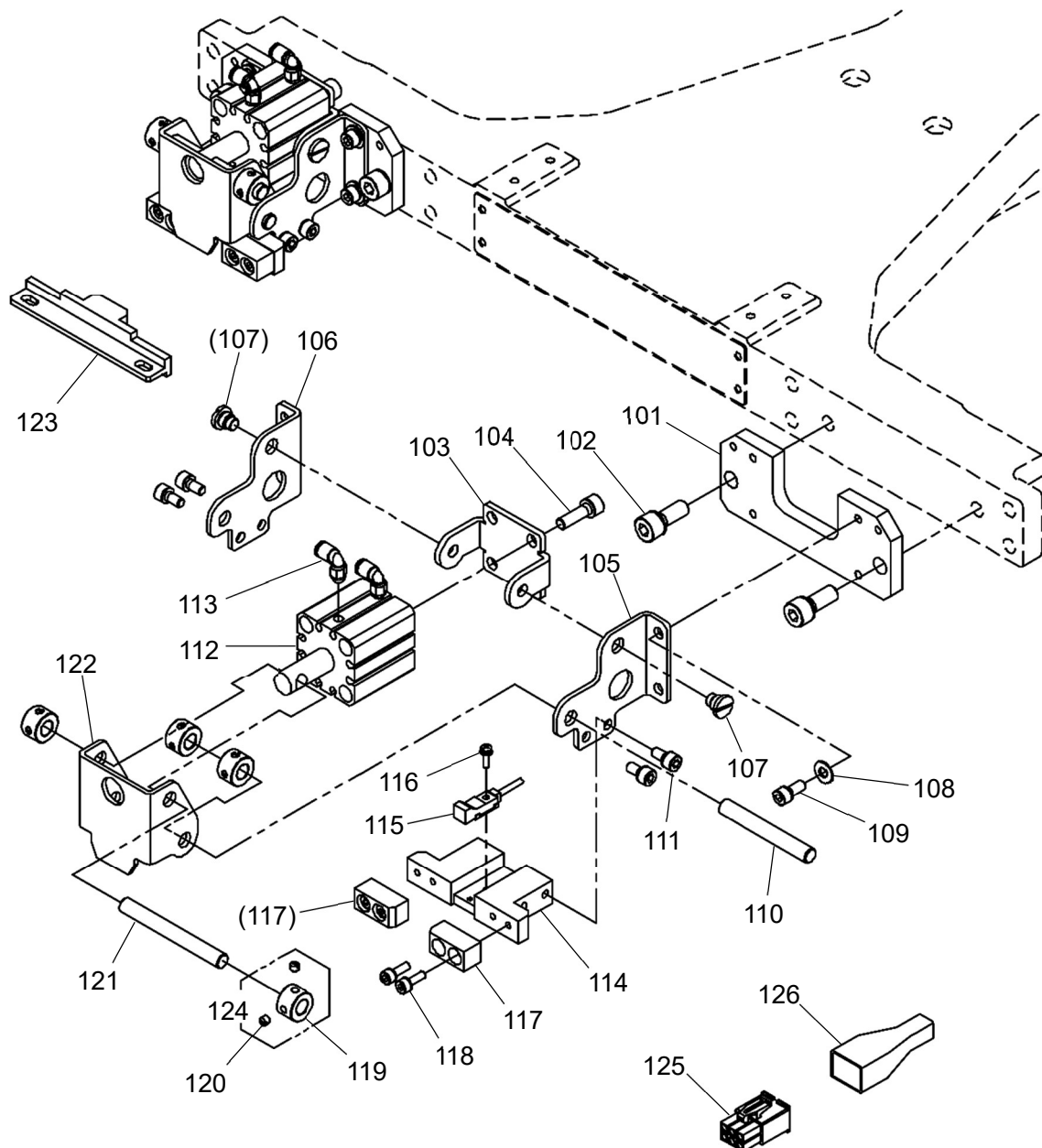


CAUTION

Trouble such as operation errors could occur if the secondary pressure is set too high. Use within the range of 0.4 MPa (4 kg/cm²).

3. Configuration

3.1 Jig eject device



3.1 Jig eject device (Parts list)

Fig No.	部品コード Parts No.	品 名	Description	数量 Amt. Req.
101	MJ6GJ0770	ジグベース	Jig base	2
102	M98010017	セフティソケット M8X20	Safety socket bolt M8X20	4
103	MH50C0601	シリンダトリツケイタ	Cylinder bracket	2
104	M96018017	セフティソケット M6X20	Safety socket bolt M6X20	8
105	MJ6GJ1154	アンナイタ R	Guide plate (right)	2
106	MJ6GJ0154	アンナイタ L	Guide plate (left)	2
107	M91690015	ヒラネジダんツキ 1/4(40)X4	Screw 1/4(40)X4	4
108	M90518050	ミカキザガネ 5	Large washer 5	8
109	M95019017	セフティソケット M5X12	Safety socket bolt M5X12	8
110	ME50C1454	ジグ	Shaft	2
111	M95018017	セフティソケット M5X10	Safety socket bolt M5X10	8
112	MH50C0434	ウスガタシリンダ	Air cylinder	2
113	MB61A1571	エルボユニオン	Connector	4
114	MJ6GJ0476	スペーサ	Spacer	2
115	MJ6GJ0484	キンセツスイッチ	Detector	2
116	M90971004	SW-PW プラマイナベネジ M3X10	SW-PW pan screw M3X10	2
117	MH50C0155	カセットアンナイ	Cassette guide	4
118	M94033017	セフティソケット M4X12	Safety socket bolt M4X12	8
119	MG23C2352	カラー	Collar	8
120	M91106001	トメネジ 11/64(40)X3.75	Set screw 11/64(40)X3.75	16
121	ME50C2454	ジグ	Shaft	2
122	MJ6GJ0391	クドウイタ	Lever	2
123	ME50C0154	アンナイガネ	Guide block	2
124	MF01E0352	カラーミタテ	Collar assy	8
125	MH50C0422	コネクタ	Connector	1
126	MJ6GJ0366	キャップ	Cap	1

4. Setup procedures



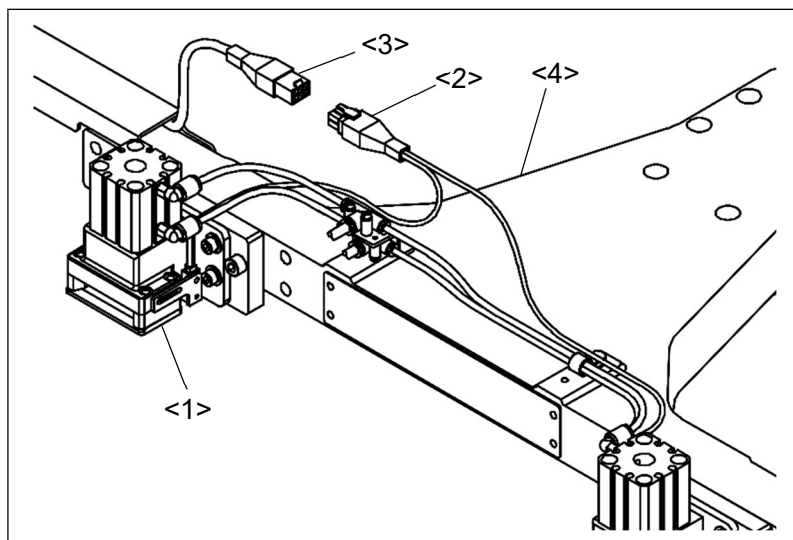
CAUTION

Always make sure that the power is OFF before starting setting work.

4.1 Removal of the existing jig eject device

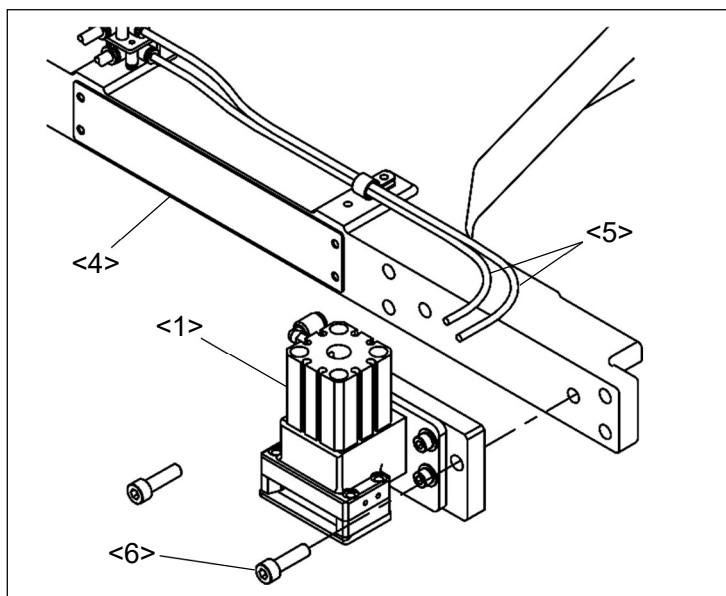
- (1) Disconnect the existing jig eject device side sensor cable <2> from the sewing machine side sensor cable <3>, and remove the sensor cable <2> from the clamp frame <4>.

MEMO The sensor cable is fixed to the clamp frame <4> with nylon clips or cable ties. Please remove these fixings before starting operation.



- <1>: Existing jig eject device
- <2>: Existing jig eject device side sensor cable
- <3>: Sewing machine side sensor cable
- <4>: Clamp frame

- (2) Remove the air tube <5> from the existing jig eject device <1>. Do not remove the air tube <5> from the clamp frame <4>, as it will be used in the next operation.
- (3) Remove the existing jig eject device <1> by removing the two screws <6>.
- (4) On the other side, remove the existing jig eject device in the same manner.

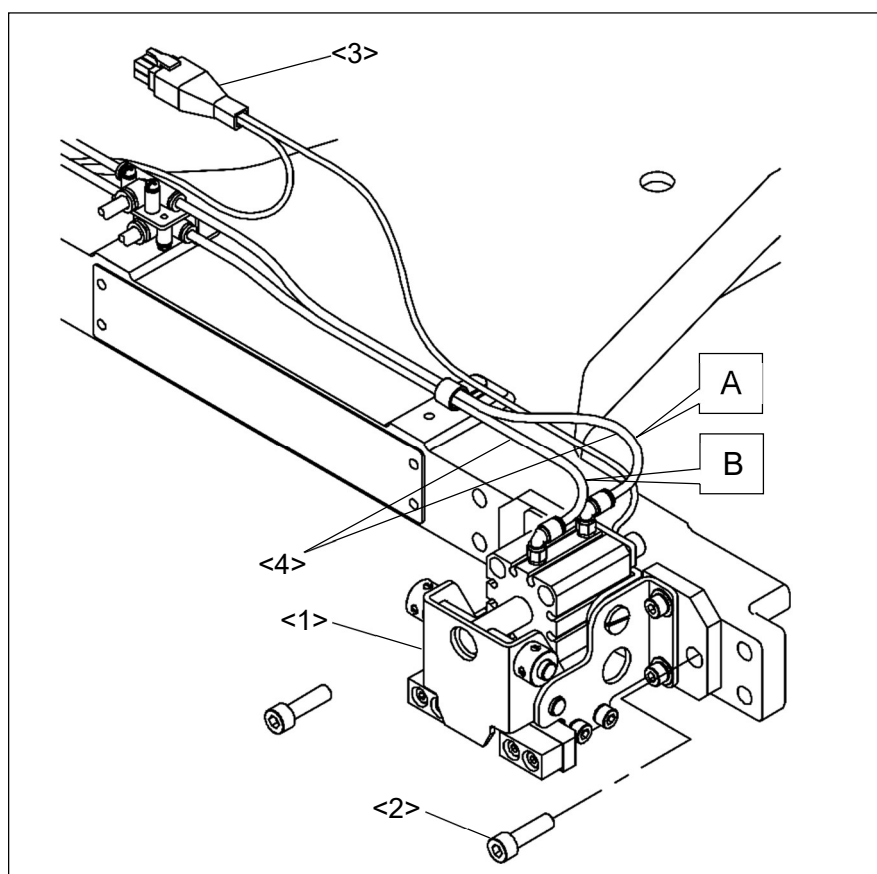


- <1>: Existing jig eject device
- <4>: Clamp frame
- <5>: Air tube
- <6>: Screw

4.2 Installation of jig eject device

- (1) Install the jig eject device (MP-J60-GJ) <1>. Use the two supplied screws <2> (safety socket bolt M8X20) to install the jig eject device in the screw holes where the existing jig eject device was installed.
- (2) Install the other side in the same manner.
- (3) Refer to the previous section 4.1(1) and connect the sensor cable <3> to the sensor cable on the sewing machine side.
- (4) Connect the air tube <4> to the air inlet of the jig eject device. Connect the air tube marked with B to the air inlet on the front side and the air tube marked with A to the air inlet on the opposite side.

MEMO The terminals of the jig eject sensor are connected to the connector as shown in the figure below.

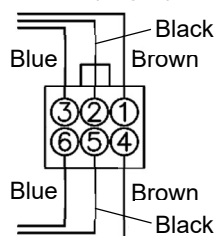


- <1>: jig eject device
- <2>: Screw (safety socket bolt M8X20)
- <3>: Sensor cable
- <4>: Air tube

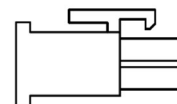
Connector / Pin diagram

Sensor	Wire color	Connector Pin no.	Signal
Sensor Right	Brown	1	+12V
	Black	2	I6
	Blue	3	GND
Sensor Left	Brown	4	+12V
	Black	5	I7
	Blue	6	GND

Sensor (Right)



Sensor (Left)



4.3 Configuration Change

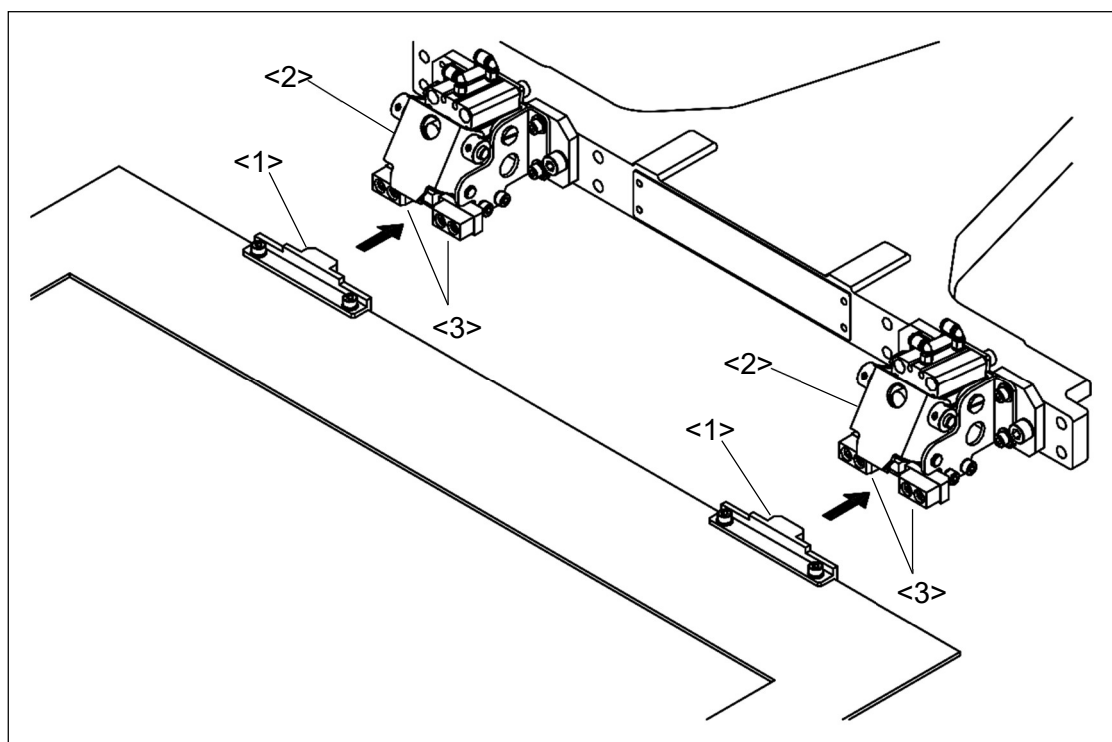
The jig eject device (MP-J60-GJ) operates with standard factory settings, so no configuration changes are required.

4.4 Operation check

- (1) Prepare the work clamp to hold the sewing material. Attach two pieces of the guide block <1> included in the accessories box to the work clamp.

MEMO Refer to the next section for the positional relationship between the guide block and the work clamp.

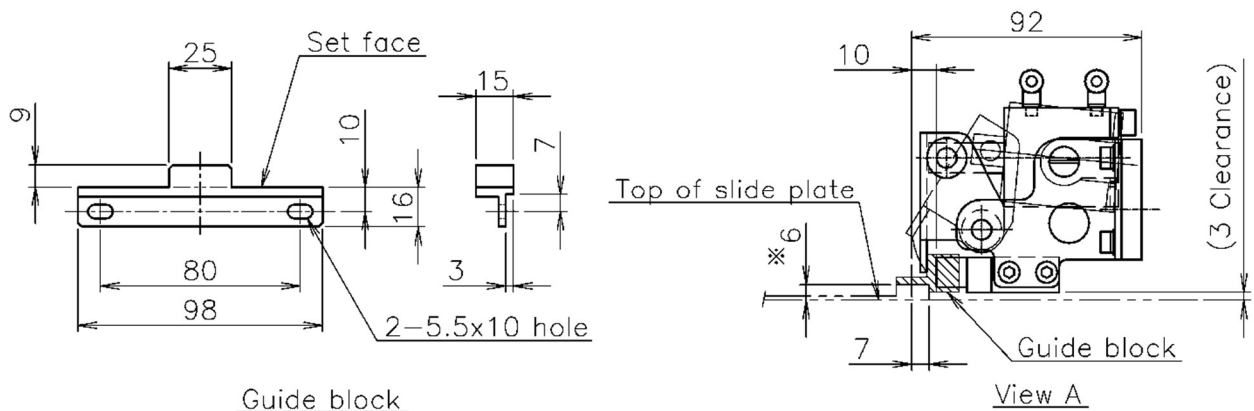
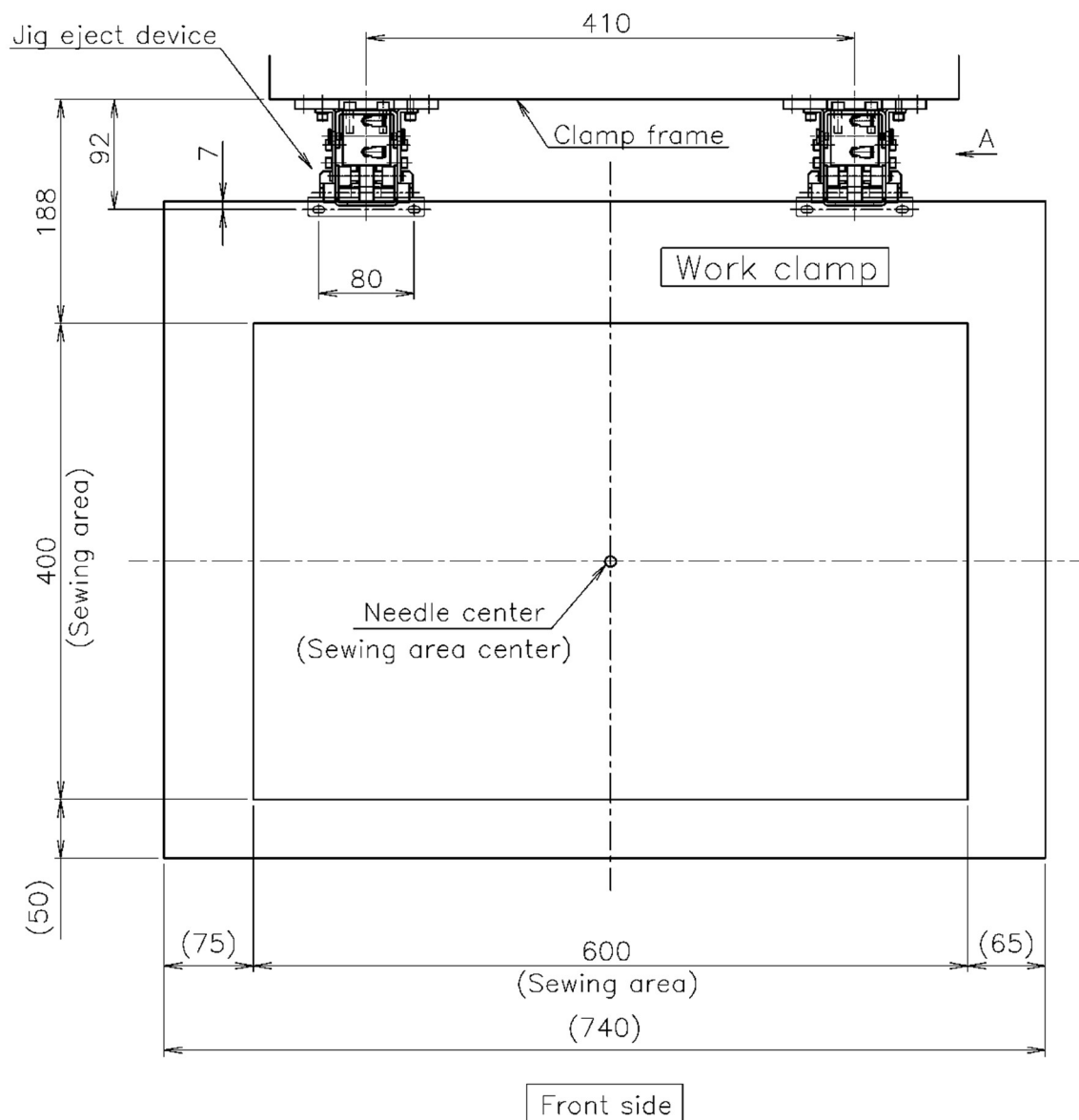
- (2) Insert the convex part of the guide block <1> into the cassette guide <3> of the jig eject device <2>. At this time, make sure that there is no gap between the guide block <1> and the cassette guide <3>.



<1>: Guide block <2>: Jig eject device <3>: Cassette guide

- (3) Please step on the pedal on the black side of the foot switch. The lever of jig eject device is lowered and the work clamp is locked. If the foot switch is pressed while the guide block <1> is not fully inserted, the work clamp may not be locked. After stepping on the foot switch, be sure to check that the work clamp is locked.

5. The positional relationship between the sewing area and the jig eject device



* Reference height of the guide block mounting face

MEMO

JUKI CORPORATION

Printed in Japan