Pocket Facing Sewing Automat

JTR-DDL9000B/PFA Series

INSTRUCTION MANUAL

No.JTR002

DDL9000BPFA-TM

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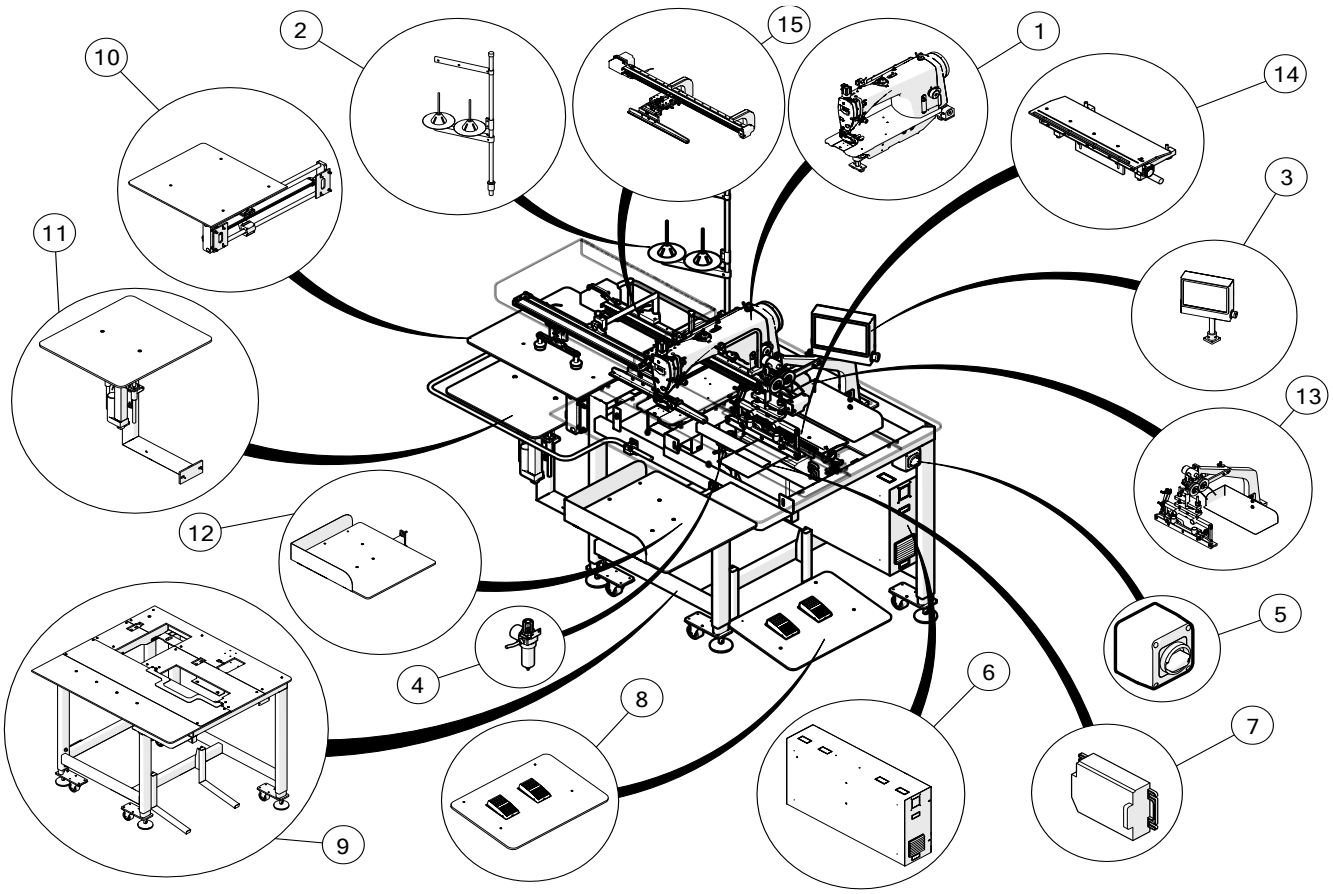
9) DISPOSAL OF BATTERIES

1) CONFIGURATION OF THE MACHINE



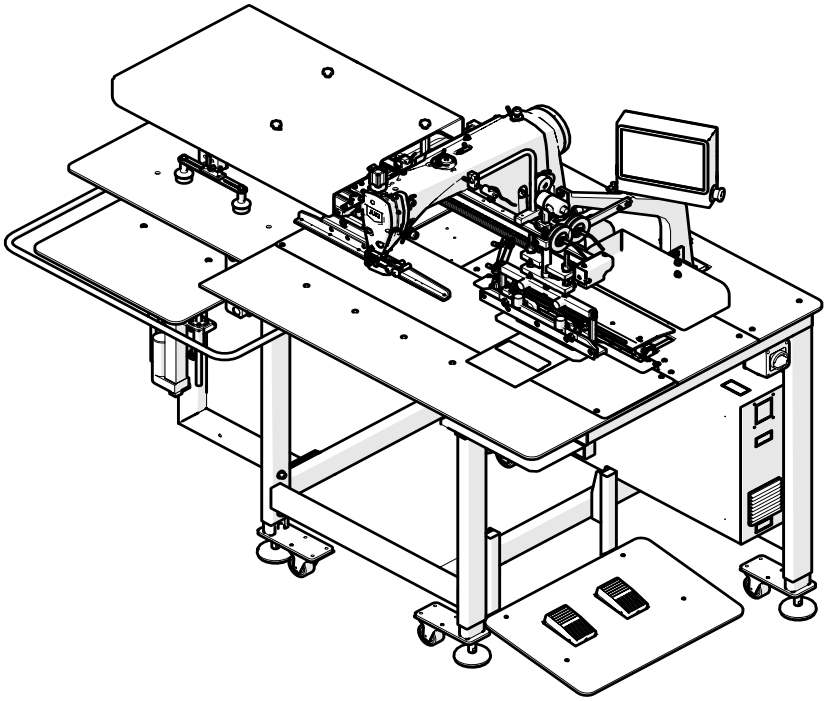
1	MACHINE HEAD	9	CHASIS GROUP
2	THREAD STAND	10	STACKING GROUP-1
3	PLC PANEL	11	STACKING GROUP-2
4	AIR REGULATOR	12	CLOTH STAND
5	MAIN SWITCH	13	CARRIER GROUP
6	JTRON CONTROL BOX	14	FOLDER GROUP
7	JUKI CONTROL BOX	15	RAIL GROUP
8	PEDAL		

2) SPECIFICATION

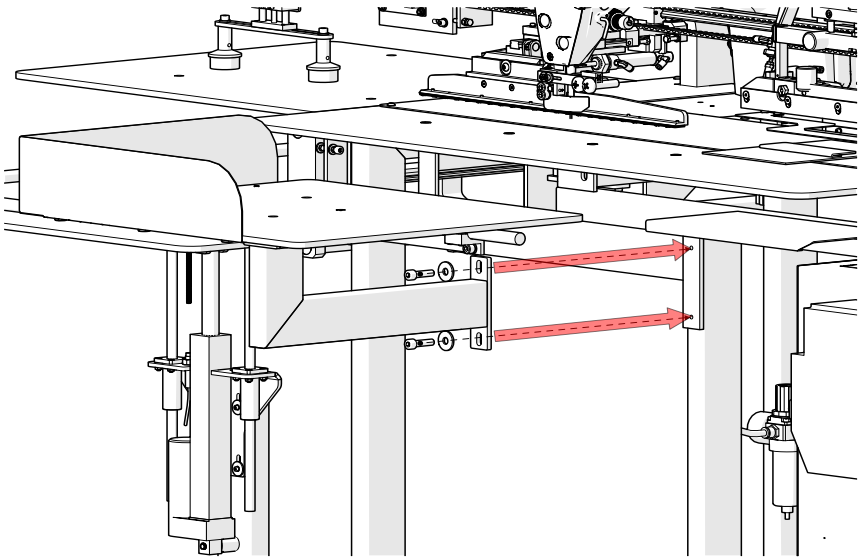
No.	Category	Description
1	MACHINE HEAD	DDL-9000BSS-WB
2	MODEL NAME	JTR-DDL9000B/PFA
3	MAIN MOTOR	JUKI AC SERVO MOTOR IPW550
4	MAIN MOTOR DRIVE	JUKI SC920
5	MAXIMUM SEWING SPEED	4000 sti/min, at the delivery: 4000 sti/min
6	STITCH LENGTH	Min : 2 mm / Max: 4.5 mm - At the delivery: 2.2 mm
7	NEEDLE TYPE	GB / DPX5 / #12
8	GAUGE	Jtron original
9	SEWING LENGHT	340 mm
10	SEAM ALLOWENCE	1 mm - 5 mm
11	SEWING SPECIFICATIONS	THIN TO MEDIUM THICKNESS
12	TARGET PROCESS	POCKET FACING
13	AIR PRESSURE	Min: 0.5 MPa Max: 0.7 MPa Delivery: 0.6 MPa
14	AIR CONSUMPTION	5 L/min
15	VOLTAGE CLASSSIFICATION	Single-phase 220-240V/50Hz
16	CAPACITY	4300 pcs / 9hours (the length of fabric:200mm)
17	DAILY PIECE COUNTER	YES
18	POWER CONSUMPTION	660 VA

3) INSTALLATION

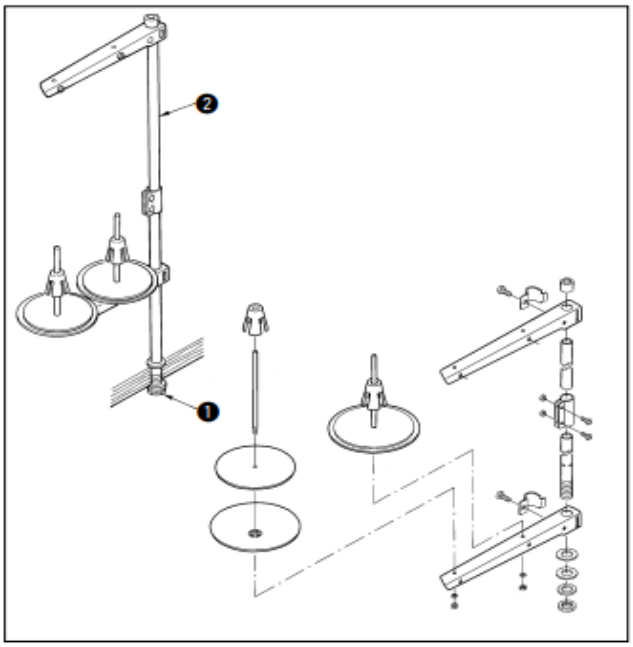
3.1) The machine is delivered as below.



3.2) Install the cloth stand.



3.3) Installing the thread stand.



1） 糸立装置を図のように組み付け、テーブルの穴に取り付けてください。
2） 糸立装置が動かない程度に、止めナット ❶ を締めてください。
3） 天井配線を行う場合は、電源コードを糸立棒 ❷ の中に通してください。

1) Assemble the thread stand unit, and insert it in the hole in the machine table.
2) Tighten locknut ❶ to fix the thread stand.
3) For ceiling wiring, pass the power cord through spool rest rod ❷.

1) Den Garnständer zusammenmontieren und in die Bohrung der Tischplatte einsetzen.
2) Die Sicherungsmutter ❶ zur Befestigung des Garnständers anziehen.
3) Wenn Deckenverkabelung vorhanden ist, kann das Netzkabel durch die Spulenstütze ❷ geführt werden.

1) Assembler le porte-bobines et l'introduire dans l'orifice de la table de la machine.
2) Serrer le contre-écrou ❶ pour fixer le porte-bobines.
3) Dans le cas où la machine est alimentée depuis le plafond, faire passer le câble d'alimentation à travers la tige du porte-bobines ❷.

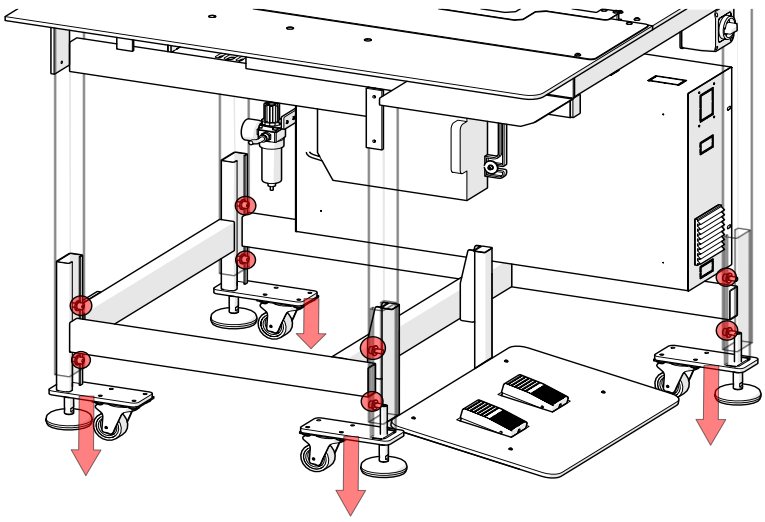
3.4) How to adjust the table height?

The position of the machine should be higher off the ground (Pallet truck assistance is recommended).

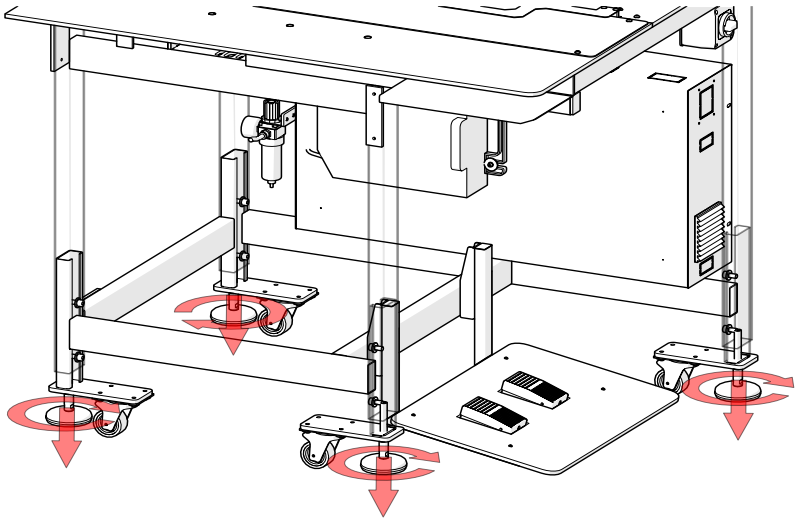
Loosen the screws(8 pieces).

Adjust the height of the table by moving the table in the desired direction.

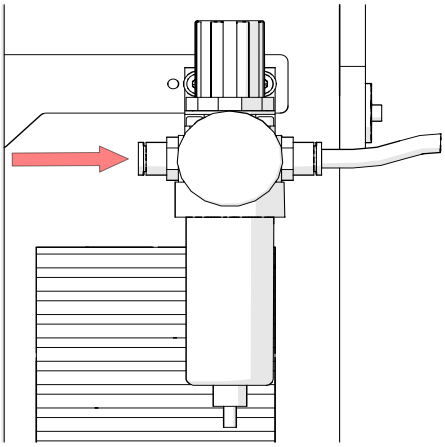
Tighten the screws(8 pieces) when the desired height is reached.



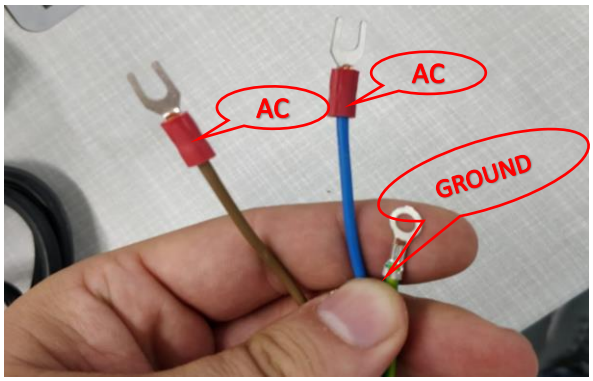
3.5) Adjust the rubber by turning them to ensure parallelism with the ground.



3.6) Connect the air tube to the air regulator.

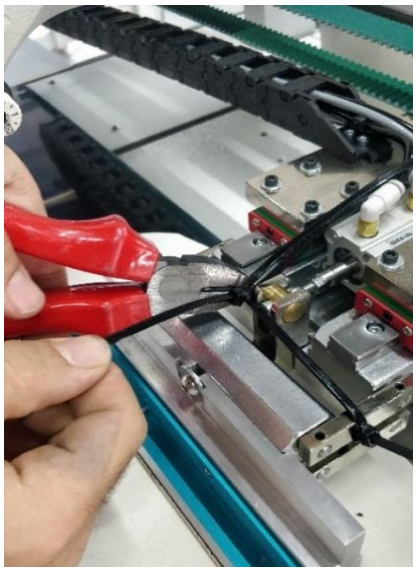


3.7) Connecting the power supply



The machine is not supplied with a power plug. It is therefore necessarry for you to select to plug that maches the receptacle availabe under a given operating environment and attach it to the power cable.

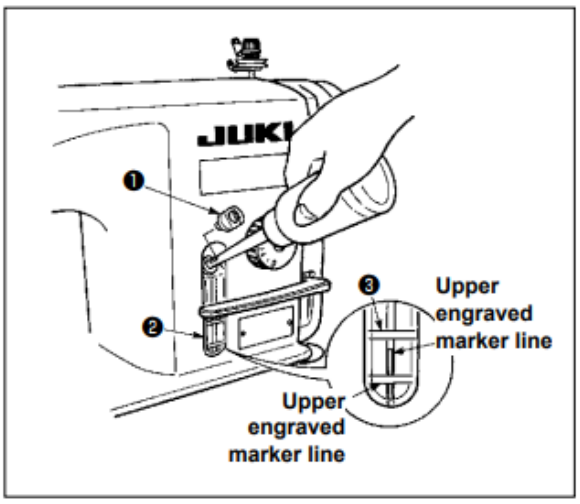
3.8) Remove the cable tie before starting the operation.



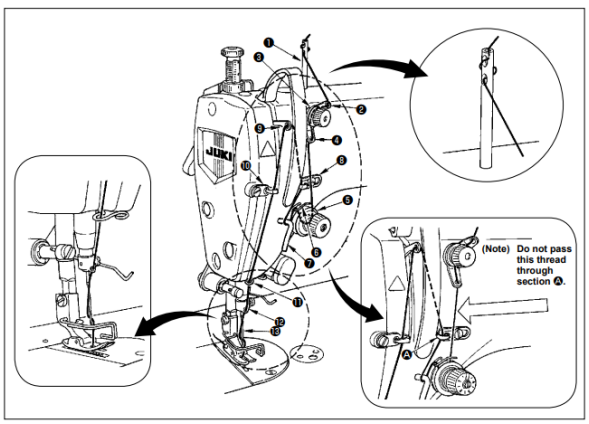
The components are fixed with cable ties to prevent damage during transportation.

4) PREPARATION FOR OPERATION

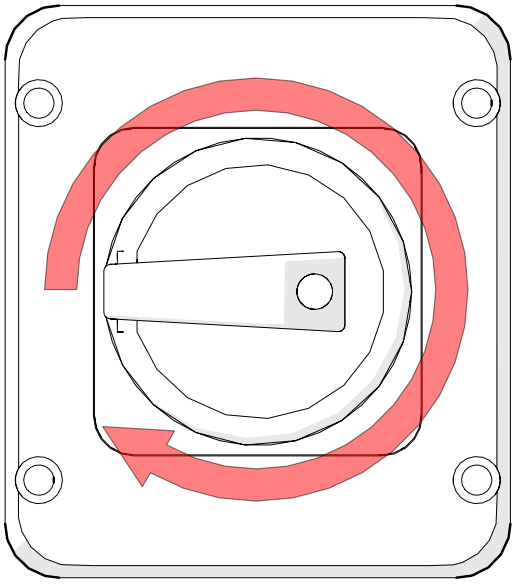
4.1) Please put the JUKI genuine oil 7. (Please refer to machine head instructions DDL-9000B Series)



4.2) Threading the machine. (Please refer to machine head instructions – DDL-9000B Series)

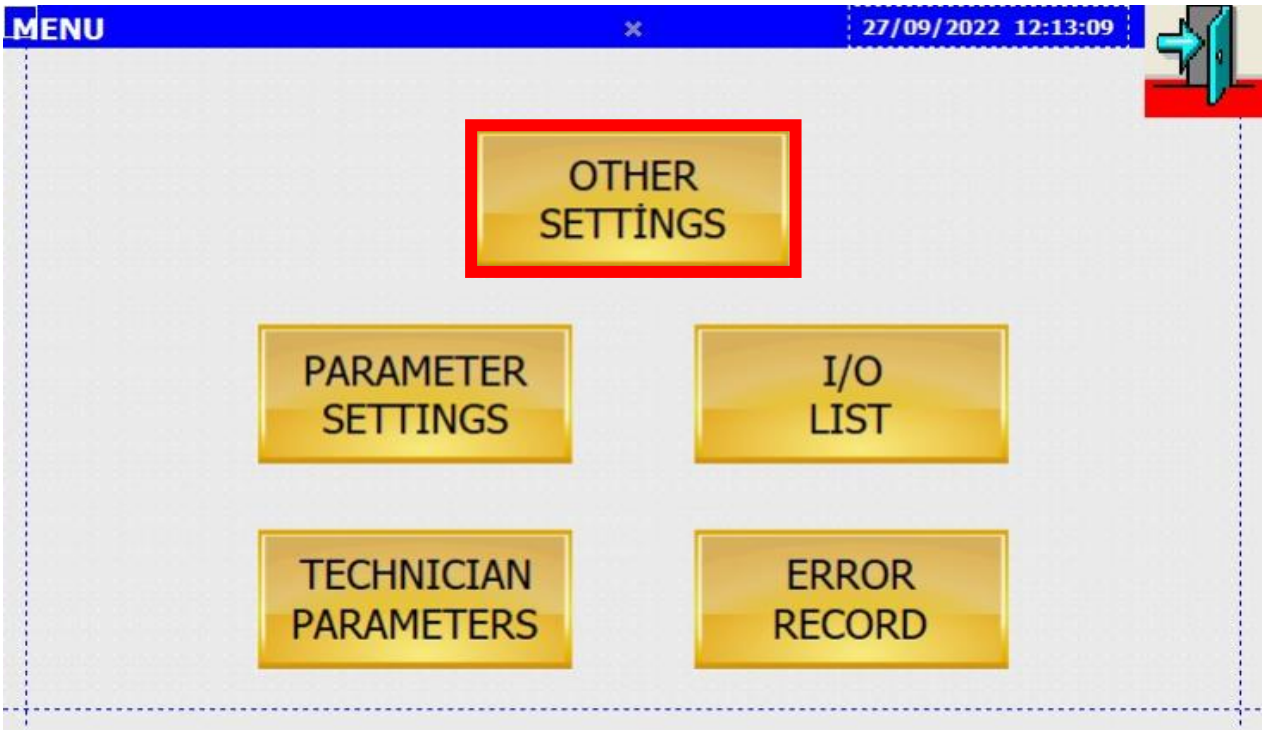


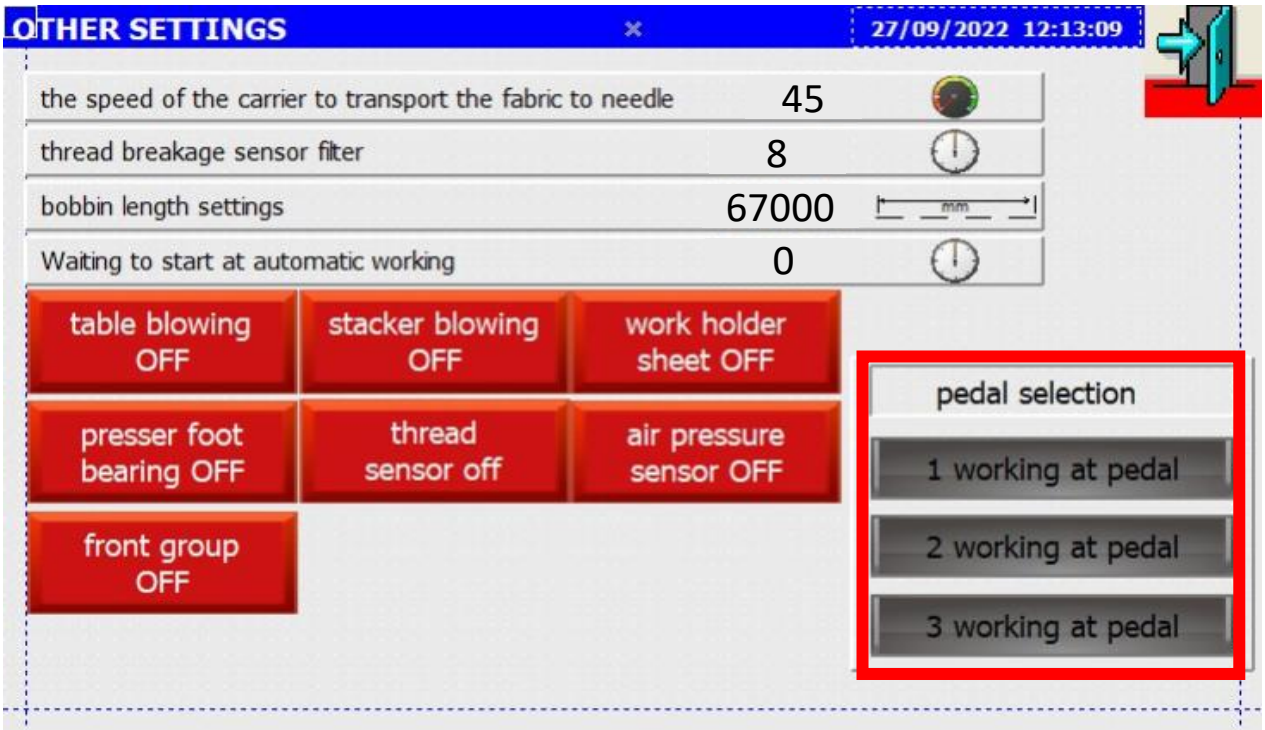
4.3) Switch on the machine.



4.4) Reset the components to the origin by pressing the reset button before starting the operation.

4.5) Selection of right pedal options.



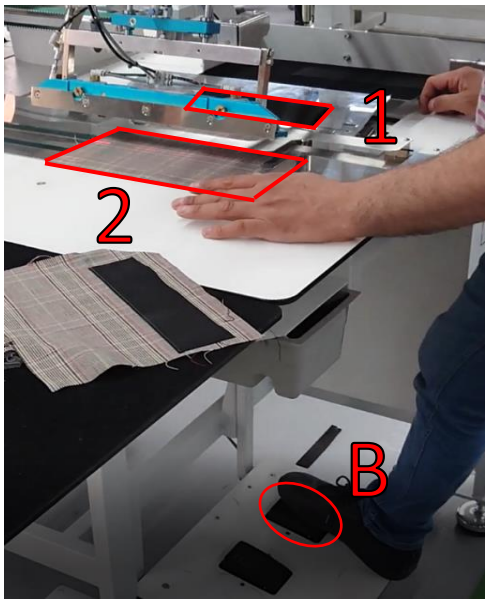


1 working at pedal: the whole operation is completed by pressing the right pedal only once.

2 working at pedal: the whole operation is completed in 2 steps. The pedal is pressed once for each step (a part of the work) intermittently (at the end of each part).

3 working at pedal: the whole operation is completed in 3 steps. The pedal is pressed once for each step (a part of the work) intermittently (at the end of each part).

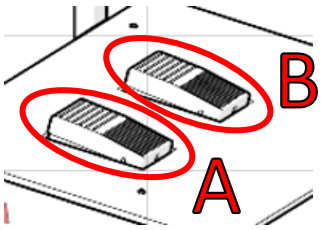
1 working at pedal: the whole operation is completed by pressing the right pedal only once.



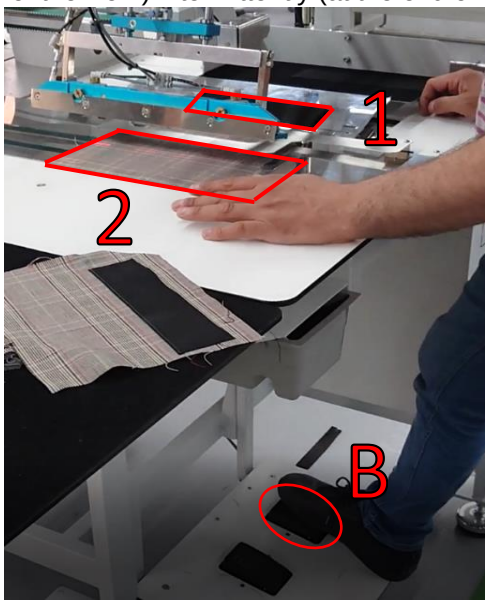
1 - Put the pocket-facing fabric(1).

2 - Put the pocket fabric(2).

3 - Press the right pedal (B) (1st time) and complete the operation.



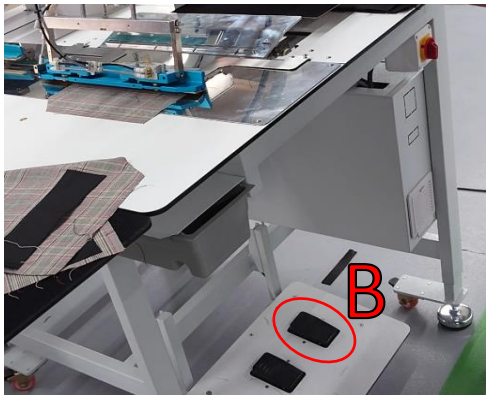
2 working at pedal: the whole operation is completed in 2 steps. The pedal is pressed once for each step (a part of the work) intermittently (at the end of each part).



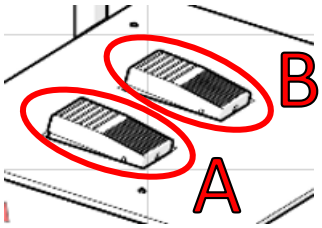
1 - Put the pocket-facing fabric(1).

2 - Put the pocket fabric(2).

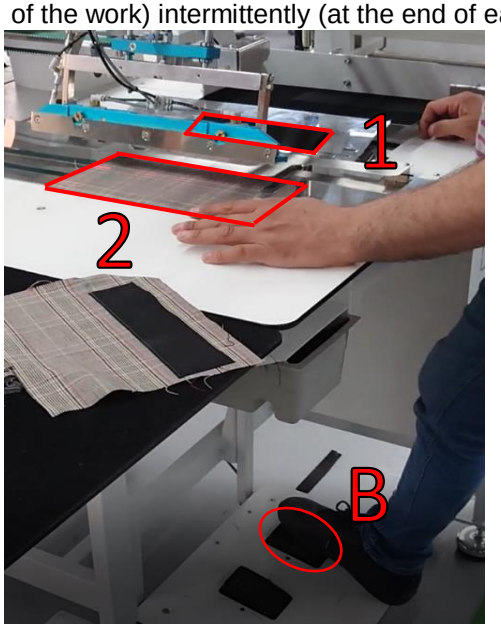
3 - Press the right pedal (B) (1st time).



4 - Press the right pedal (B) again(2nd time) and complete the operation.



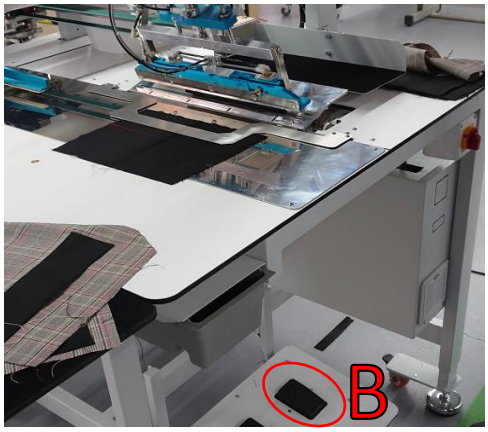
3 working at pedal: the whole operation is completed in 3 steps. The pedal is pressed once for each step (a part of the work) intermittently (at the end of each part).



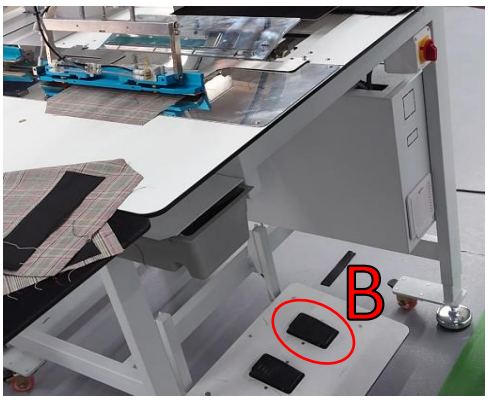
1 - Put the pocket-facing fabric(1).

2 - Put the pocket fabric(2).

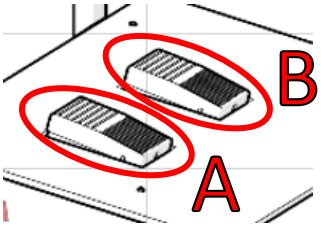
3 - Press the right pedal (B) (1st time).



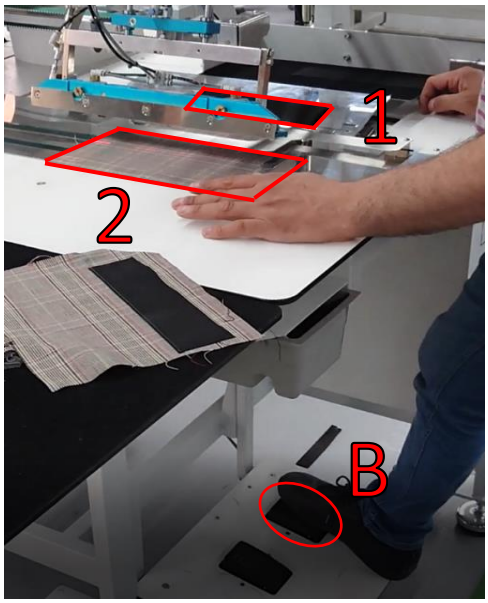
4 - Press the right pedal (B) again(2nd time).



5 - Press the right pedal (B) again(3rd time) and complete the operation.



4.6) Sewing the sample.



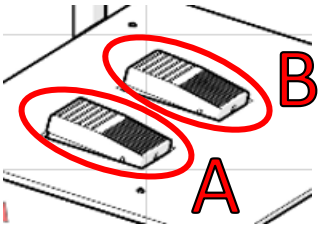
1 - Put the pocket-facing fabric(1).

2 - Put the pocket fabric(2).

3 - Press the right pedal(B) each time when the motion ceases until the operation is completed. According to the selected option[ref:4.5)] there is going to be a need to press the pedal once, twice or three times.

The pedal(A) could be only used for taking the operation one step back.

The pedal(B) could be only used for starting the operation.

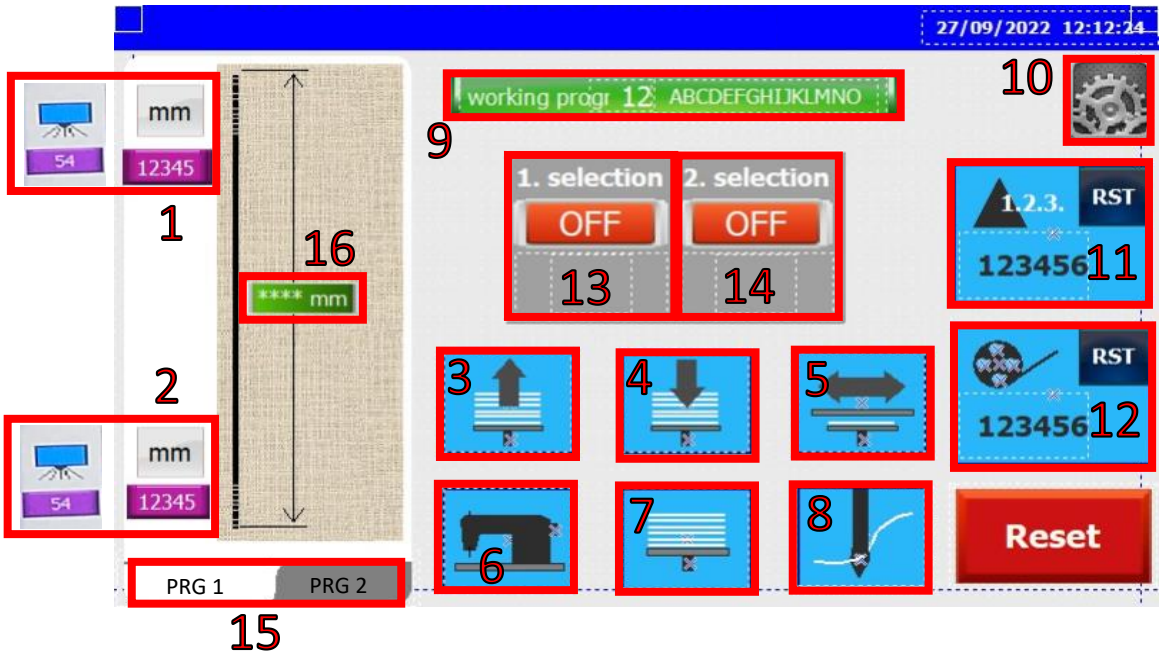


5) PANEL

5.1) Home Page

Touch start screen to enter Settings Page

5.2) Settings Page - 1



1- Delay distance[to start sewing once the sensor detects the fabric(mm).] [to start sewing once place the fabric(mm).]

2- Delay distance[to continue sewing once the fabric passes under the sensor(mm).]

3- Stacker Up : Stacker goes up when the button pressed.

4- Stacker Down : Stacker goes down when the button pressed.

5- Stacker Table Movement : Stacker table moves forward/backward once the button pressed.

6- Sewing Settings : Sewing Settings Parameters

7- Stacker Settings : Stacker Settings Parameters

8- Threading : It uses attaching the thread for the safety threading.If the button activates, machine does not work.

9- Program Selection: Program Page

10- Menu : Menu Page [Ref 5.2.4)]

11- Piece Counter : Daily Piece Counter

12- Bobbin Counter : Daily Bobbin Counter

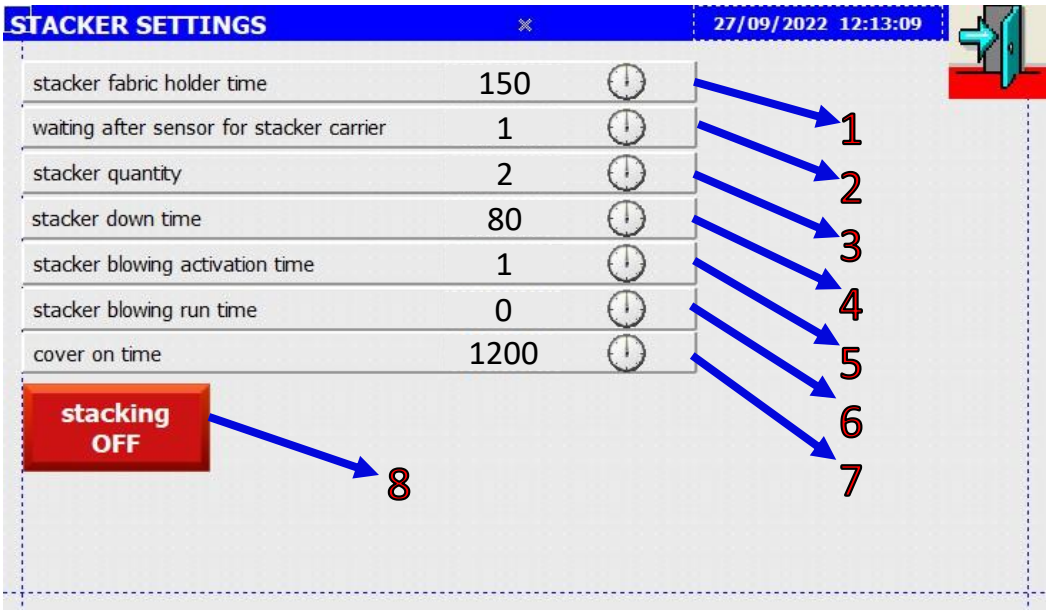
13- Operation Mode 1(PRG 1) : Stitching cycle is completed in a single operation in case of only this mode activated.

14- Operation Mode 2 (PRG 2) : If both operation mode 1 and 2 is activated at the same time, the different 2 operations completes in one cycle.

15 - Programs of Cycle : "13- Operation Mode 1(PRG 1)" and "14- Operation Mode 2 (PRG 2)"

16 - Length between the first sensor "1-Delay distance" detecting the feeding fabric and stopping to feed it without second sensor "2-Delay distance".

5.2.1) Stacker Settings



1- Stacker fabric holder time (ms) : Stacker fabric collecting time

2- Waiting after sensor for stacker carrier (s) : Delay time after stacking sensor detects.

3- Stacker quantity (quantity) : Quantity of stacked product

4- Stacker down time (ms) : Period of stacking down time.

5- Stacker blowing activation time : Activation time of the stacker blowing(This value should not be changed).

6- Stacker blowing run time : Run time of stacker blowing(This value should not be changed).

7- Cover on time : Delay time of stacking table when it is at forward position.

8- Stacking OFF : Stacking ON/OFF

5.2.2) Program Selection

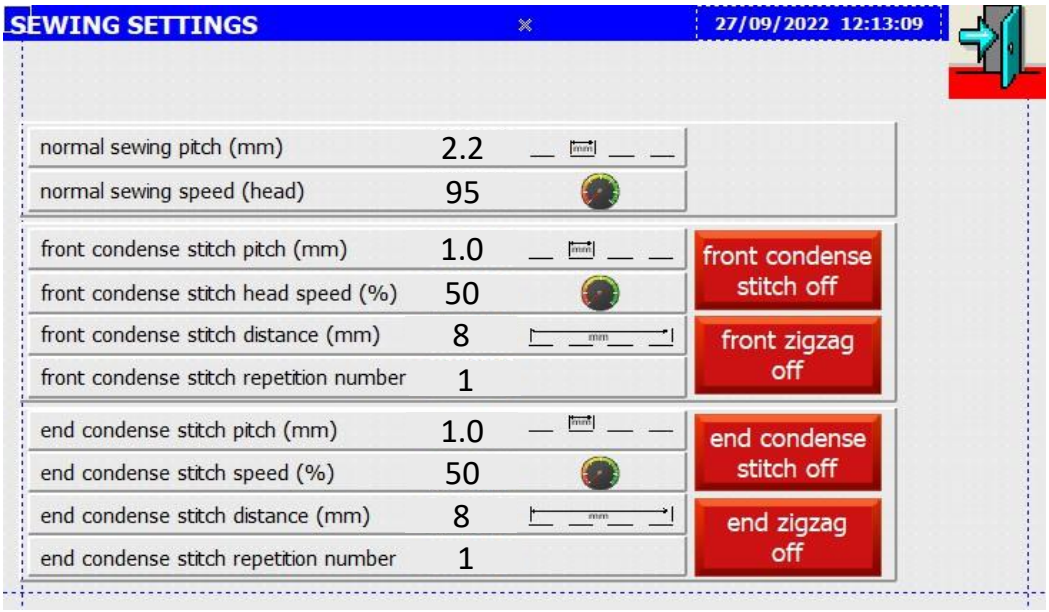
1- Save : It is used to save the settings of the recently created or existing program to a selected number on the program list.

2- Program Selection : It is used to activate(working program) the selected program in the program list.

3- Return to Home Page : It is the home page return button

4- Program List : It is the section where the records of the programmes are listed.

5.2.3) Sewing Settings



Front Condense Stitch ON/OFF: It provides to make the front condense stitch ON or OFF.

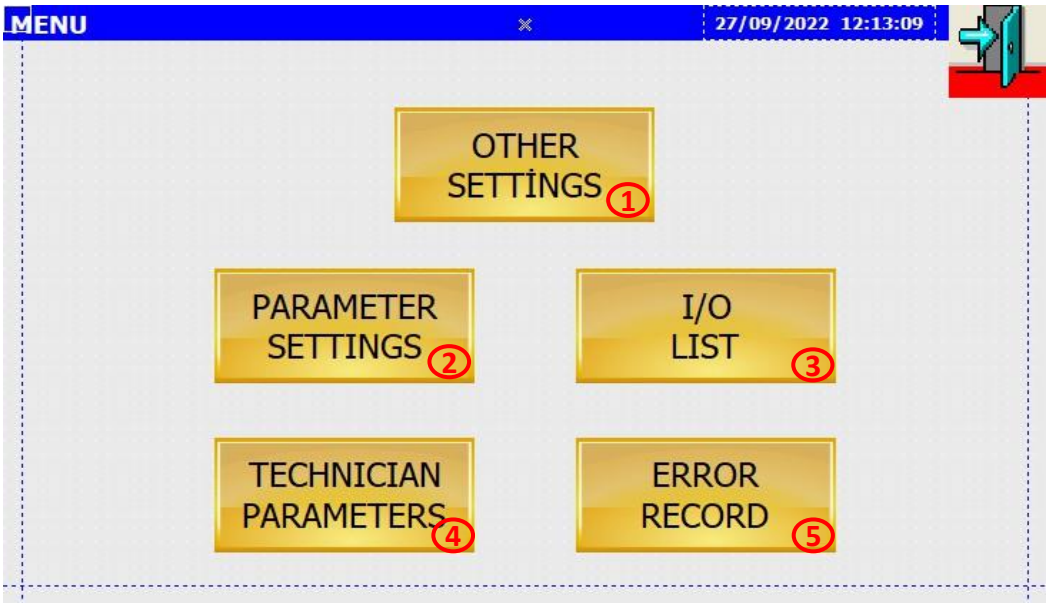
Front ZigZag(Back-tack) ON/OFF: It provides to make the front ZigZag(Back-tack) ON or OFF.

End Condense Stitch ON/OFF: It provides to make the end condense stitch ON or OFF.

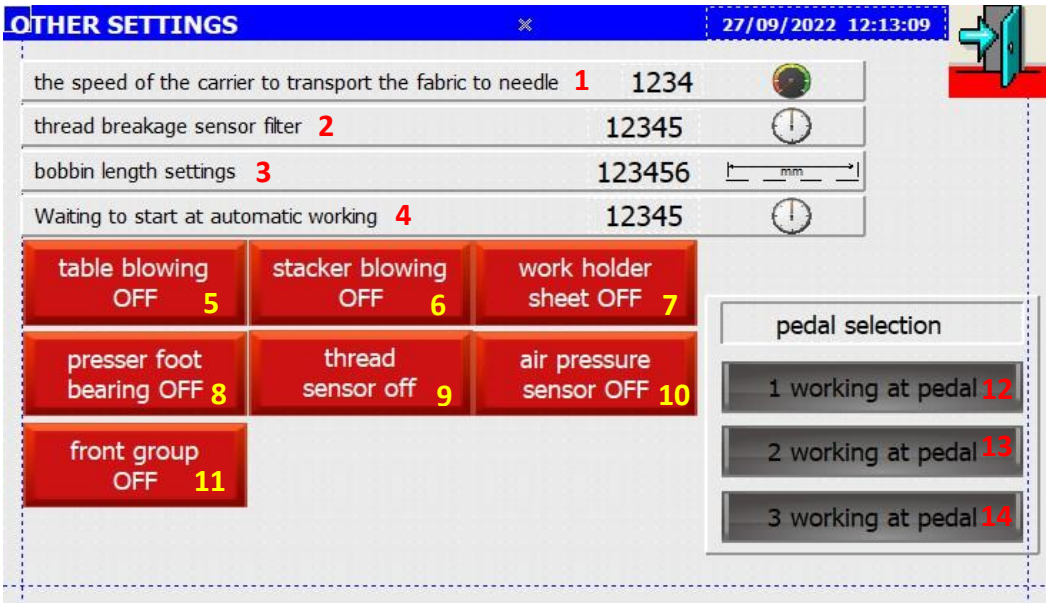
End ZigZag(Back-tack) ON/OFF: It provides to make the end ZigZag(Back-tack) ON or OFF.

Condense Stitch OFF ZigZag OFF	1 In this case the machine makes regular sewing.
Condense Stitch ON ZigZag OFF	2 In this case, the machine performs condense stitch.
Condense Stitch ON ZigZag ON	In this case, the machine performs ZigZag(Back-tack).It is the same as number 4. 3
Condense Stitch OFF ZigZag ON	In this case, the machine performs ZigZag(Back-tack).It is the same as number 3. 4

5.2.4) Menu


MENU
27/09/2022 12:13:09
OTHER SETTİNGS
1
PARAMETER SETTINGS
2
I/O LIST
3
TECHNICIAN PARAMETERS
4
ERROR RECORD
5

5.2.4.1) Other Settings



1- The speed of the carrier to transport the fabric to needle (%)

2- Thread breakage sensor filter (ms)

3- Bobbin length settings (mm)

4- Waiting to start at automatic working

5- Table blowing OFF : ON/OFF

6- Stacker blowing OFF : ON/OFF

7- Work holder sheet OFF : ON/OFF

8- Presser foot bearing OFF : ON/OFF

9- Thread sensor OFF : ON/OFF

10- Air pressure sensor OFF : ON/OFF

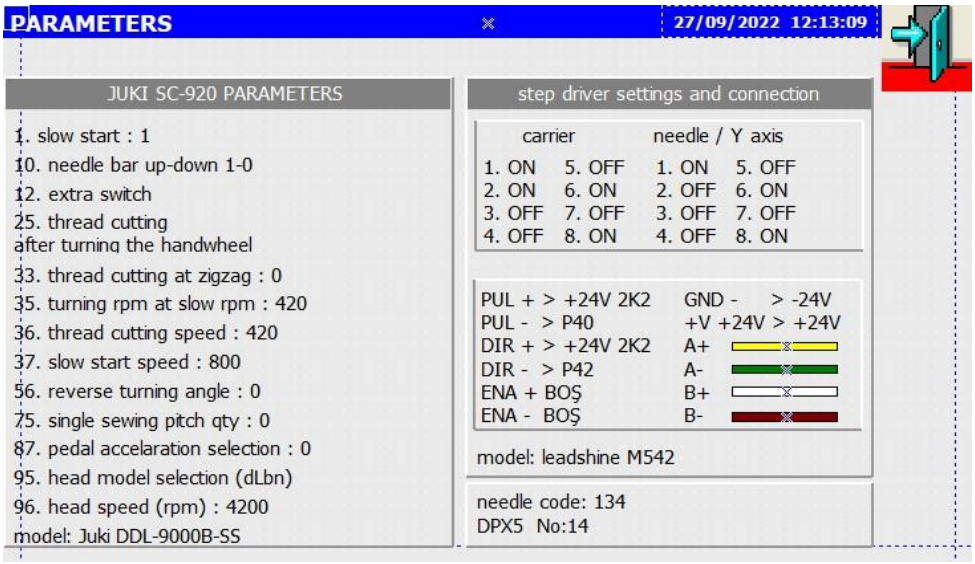
11- Front group OFF : ON/OFF

12- 1 working at pedal : the whole operation is completed by pressing the right pedal only once.

13- 2 working at pedal : the whole operation is completed by pressing the right pedal twice.

14- 3 working at pedal **:** the whole operation is completed by pressing the right pedal three times.

5.2.4.2) Parameter Settings



This screen shows the default factory parameters.

Note! These parameters' values should not be changed.

5.2.4.3) I/O List (Testing Page)

INPUTS : Sensor signals can be displayed.

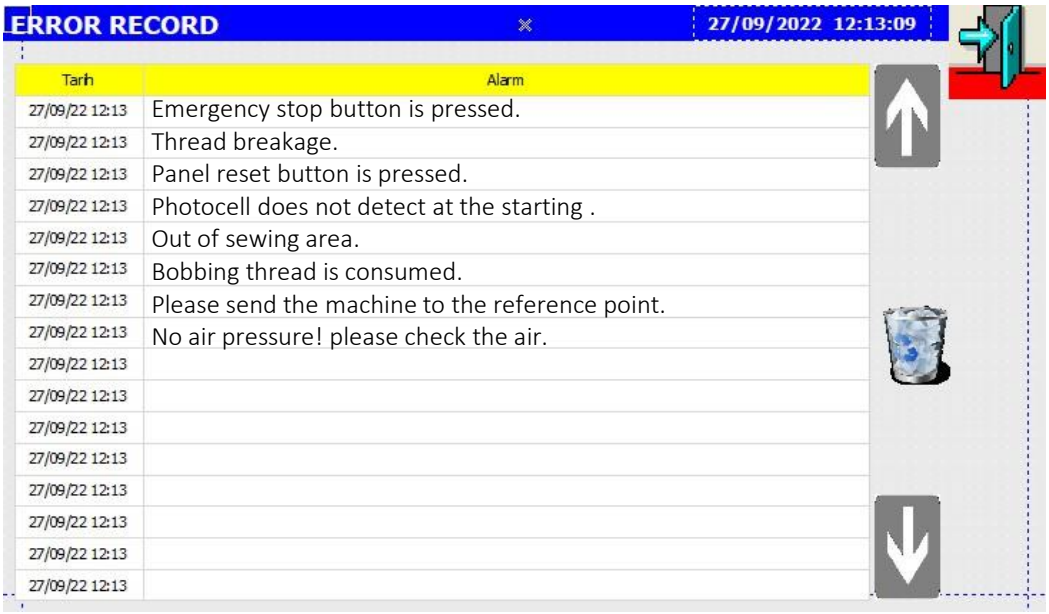
OUTPUTS : Press the key to check the operation of each part.

Periodic ON-OFF : It switches the selected command on and off at 1 second intervals.

Carrier Motor Test : It is used to test the carriage mechanism forwards and backwards.

HEAD TEST : These buttons start and test the head motor at the specified speed.

5.2.4.4) Error Record

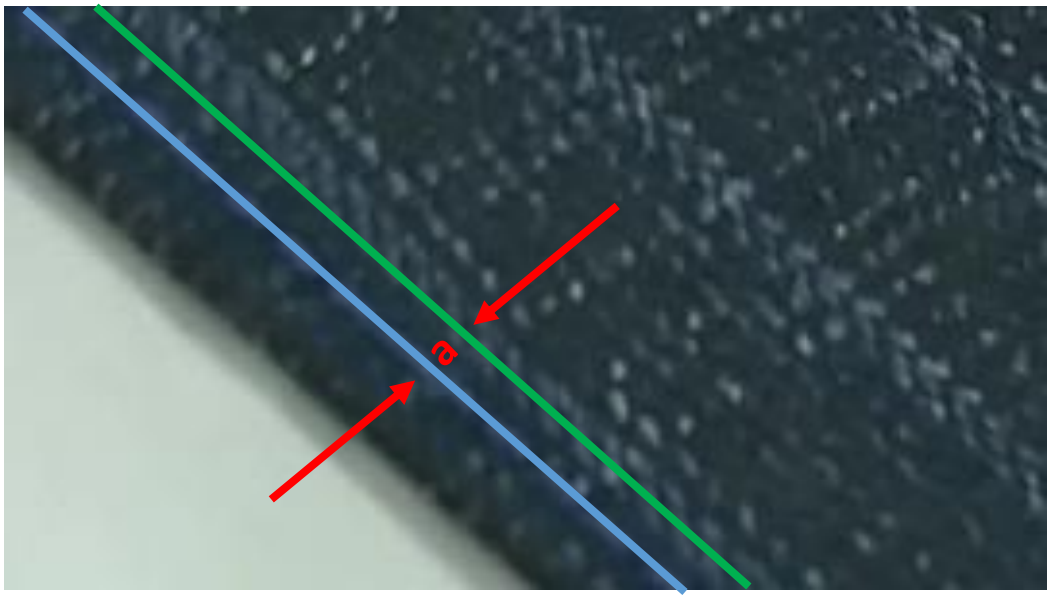


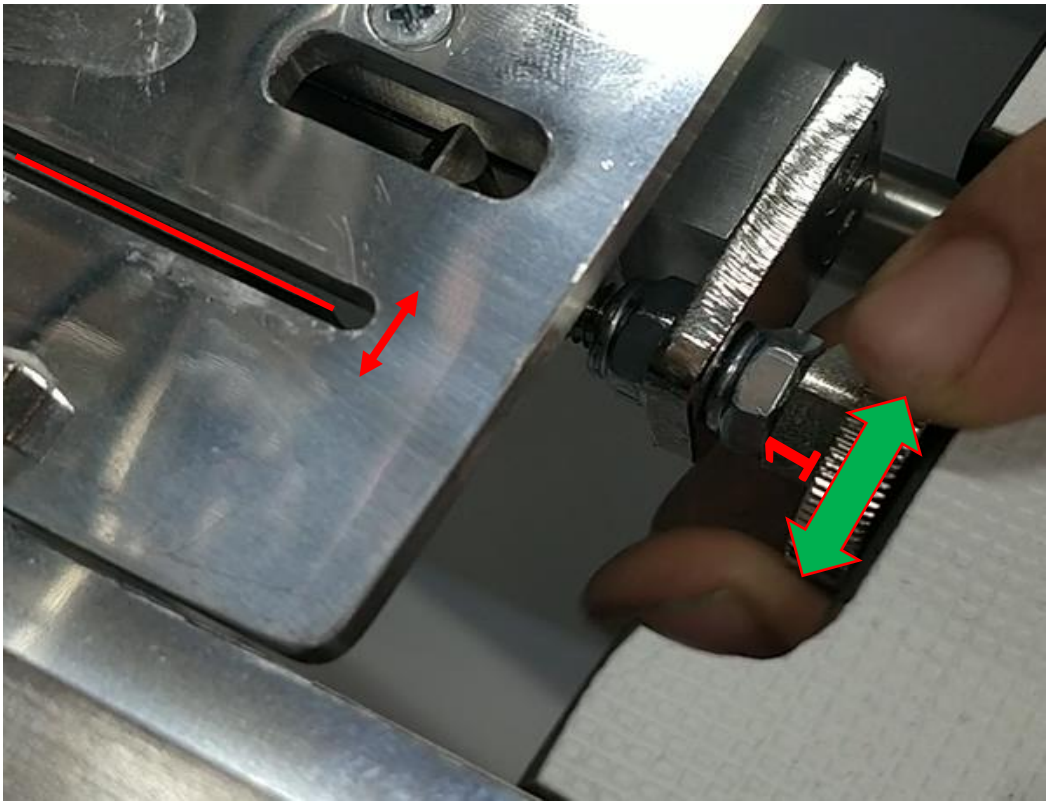
Error records cannot be deleted.

Error records are kept for examination by the technical service.

6) ADJUSTMENT

6.1) Adjusting Edgestitch



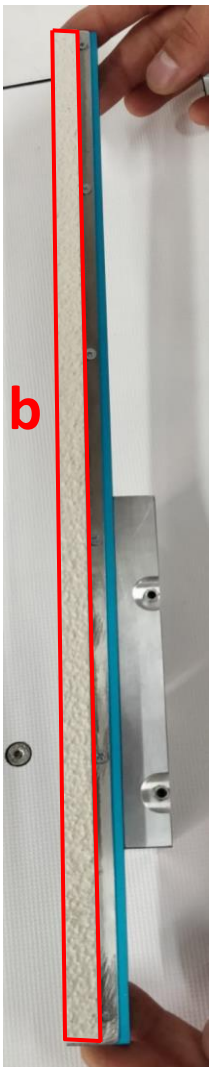


If you turn screw(1) clockwise, the width of edgestitch(a) decreases.

If you turn screw(1) counterclockwise, the width of edgestitch (a) increases.

6.2) Replace the carrier presser arm rubber

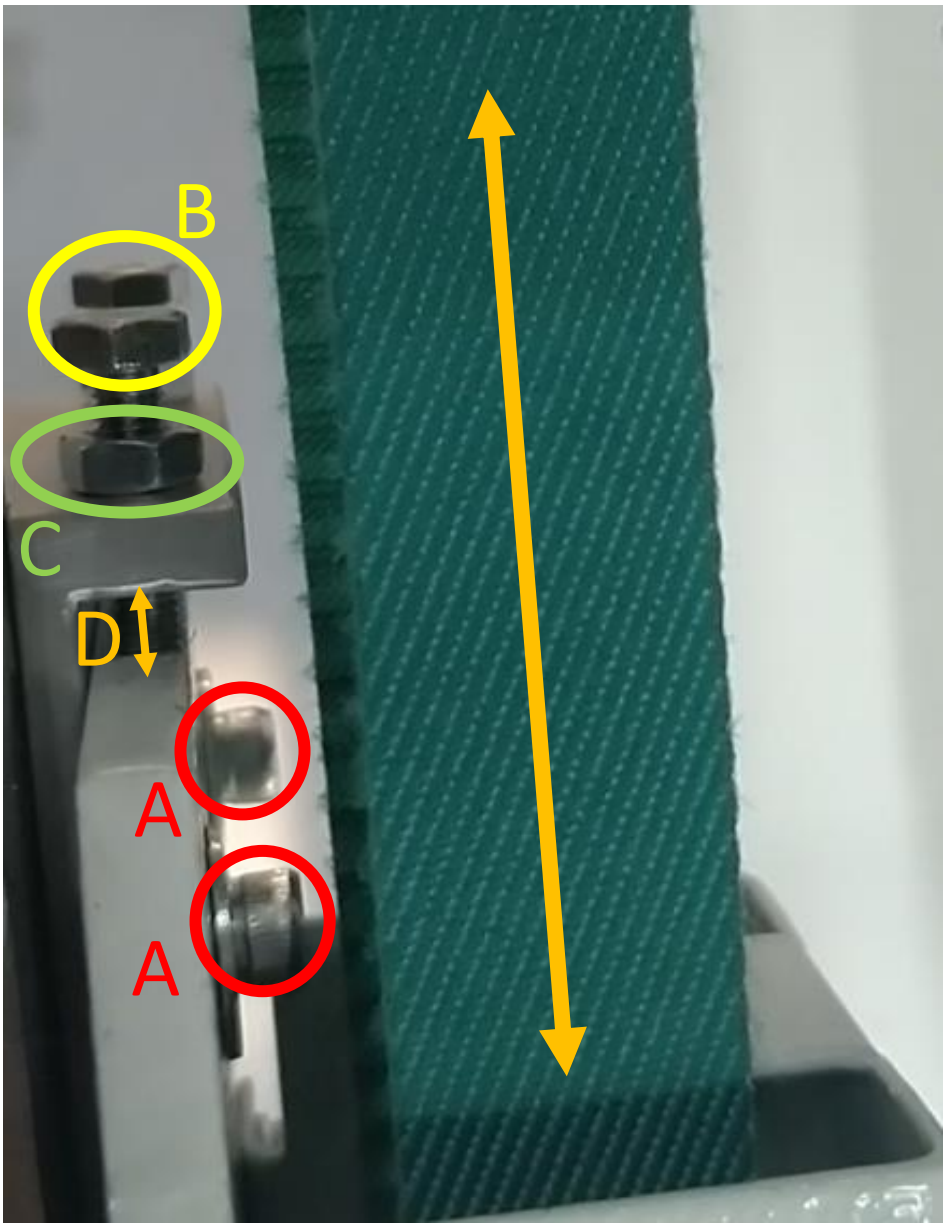
Remove the screw(a) and washer.



Remove the old rubber(b) with the help of heat. Then place the new rubber(b) by gluing it with bally.

Tighten the screw(a).

6.3) Adjusting of Belt Tension



Firstly loosen the screws(A).

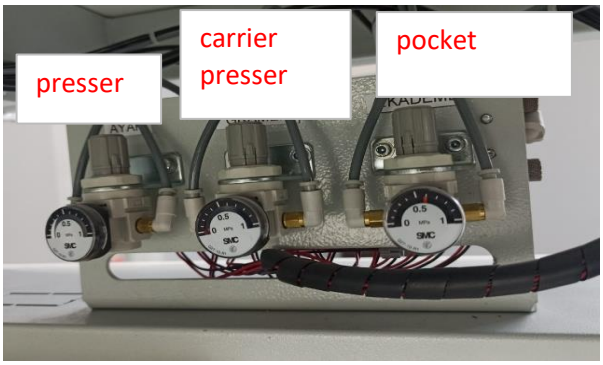
Secondly loosen the nuts(C).

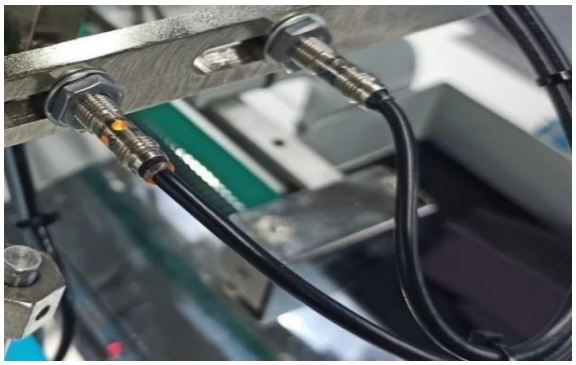
Finally you can adjust tension of the belt by turning the screws(B).

If you turn the screw clockwise, the distance(D) and the tension of belt increase.

If you turn the screw counter-clockwise, the distance(D) and the tension of belt decrease.

After above the process complete, tighten the nuts(C) and the screws(A).



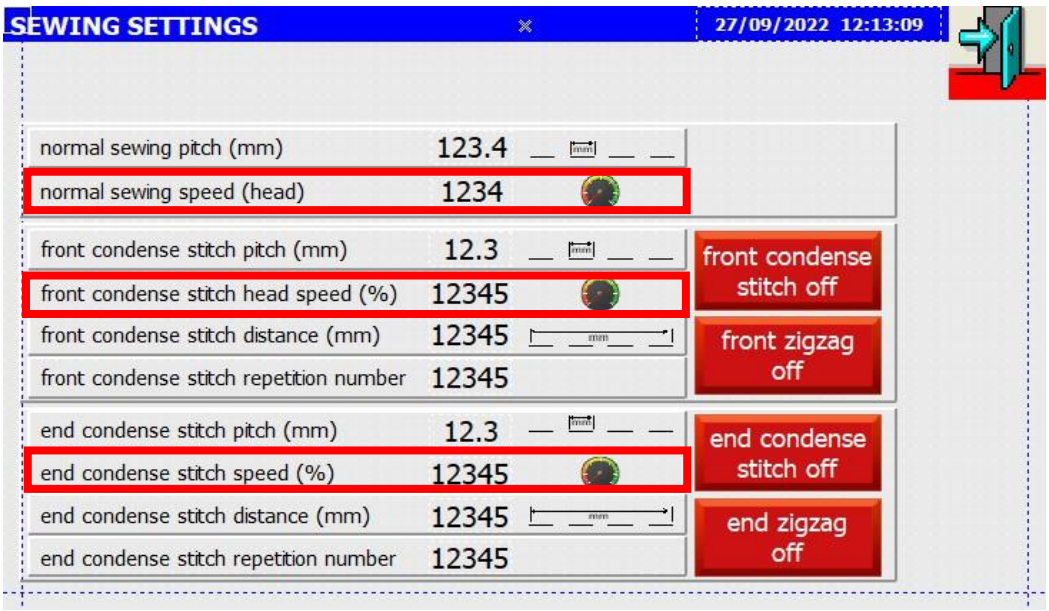


Warning : What not to do

These regulators are adjusted for each machine before shipment, so never change the setting values. These sensors (pocket facing clamp carrier forward and backward sensor) are also adjusted for each machine before shipment, so never change the position.

If these settings are changed, the machine will not operate properly.

6.4) Sewing Settings



If you want to adjust speed, you should calculate the speed as percental value.

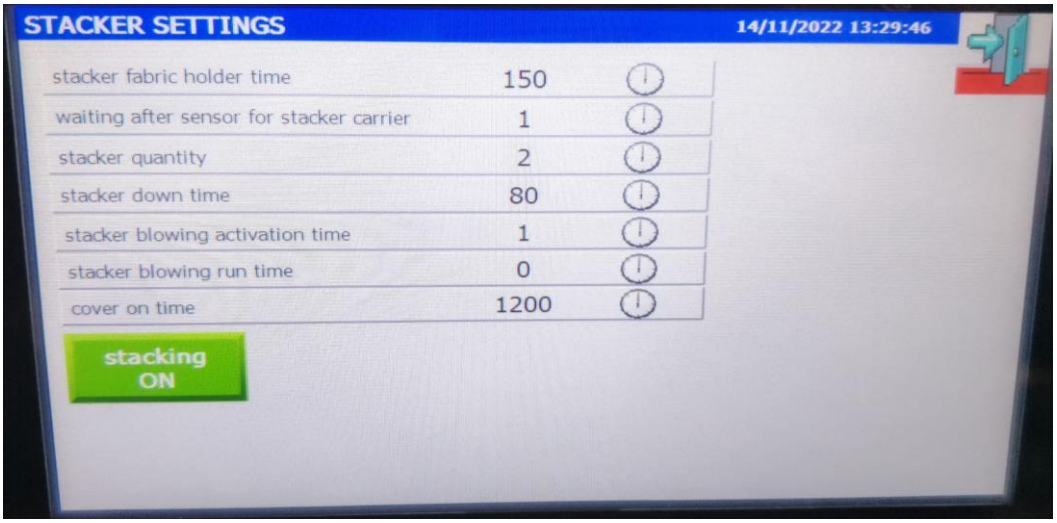
For example :

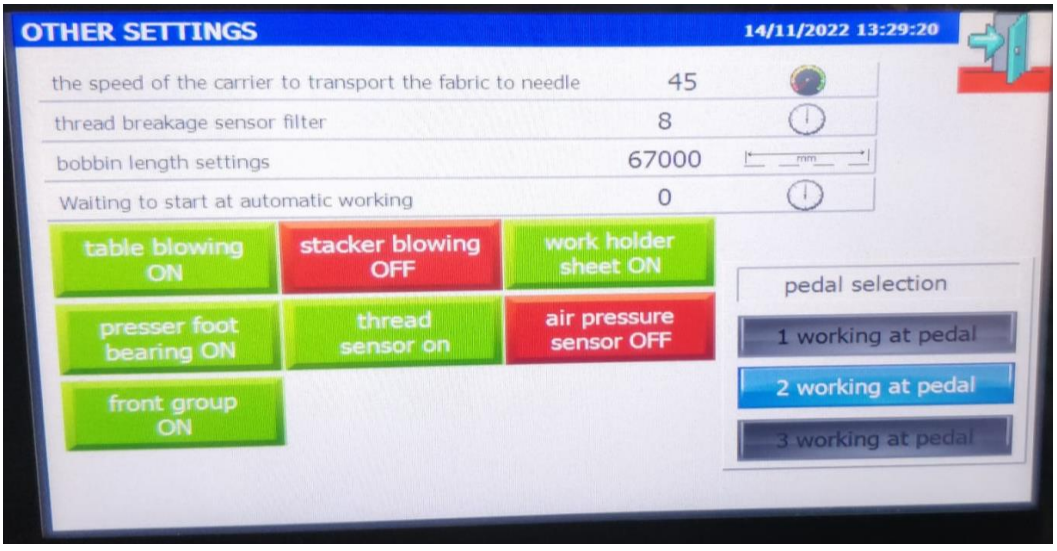
If you want to adjust speed 3000 rpm, Follow the below steps.

$$\frac{3000\ \text{rpm}}{4000\ \text{rpm (Max)}} = \frac{x\ (\text{percent})}{100}$$

$$x = \frac{3000 \times 100}{4000} = 75\%$$

7) LIST OF PATTERN DATA(SHIPPING VALUES)





8) CAUSES AND COUNTERMEASURES

Q.1) Stitch skipping.

A1) Check the tension of the needle thread and speed of machine head.

Q.2) Needle thread breakage.

A2) Check the tension of the needle thread and the thread path.

9) DISPOSAL OF BATTERIES

The operation panel incorporates batteries for operating the clock while the power is turned OFF. Dispose of the batteries appropriately according to the relevant local laws and regulations in your country / region.

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