



**Pocket Facing Sewing Automat**

**JTR-DDL9000B/PFA Series**

# **INSTRUCTION MANUAL**



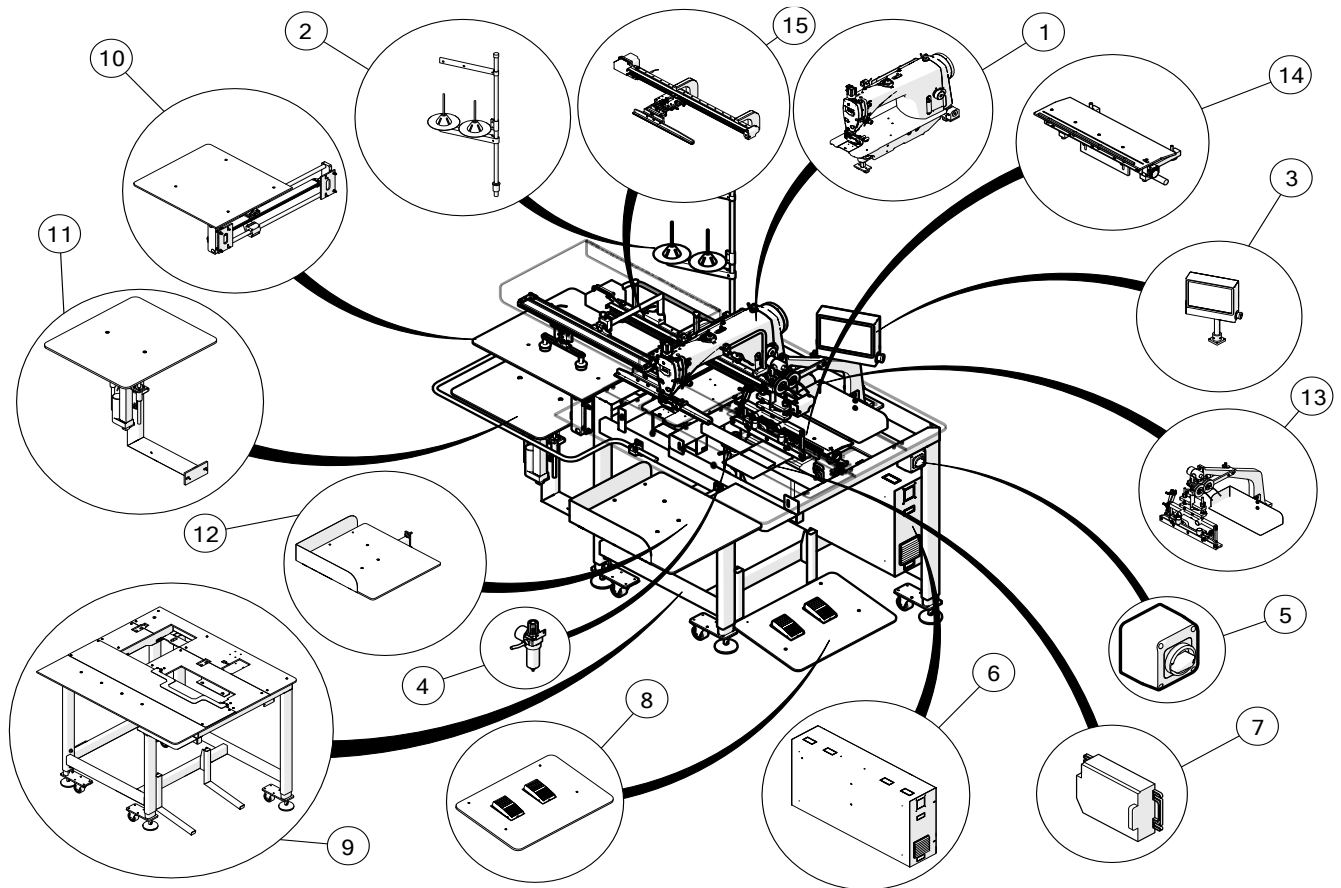
**No.JTR002**

**DDL9000BPFA-TM**

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- 7) LIST OF PATTERN DATA**
- 8) CAUSES AND COUNTERMEASURES**
- 9) DISPOSAL OF BATTERIES**

## 1) CONFIGURATION OF THE MACHINE



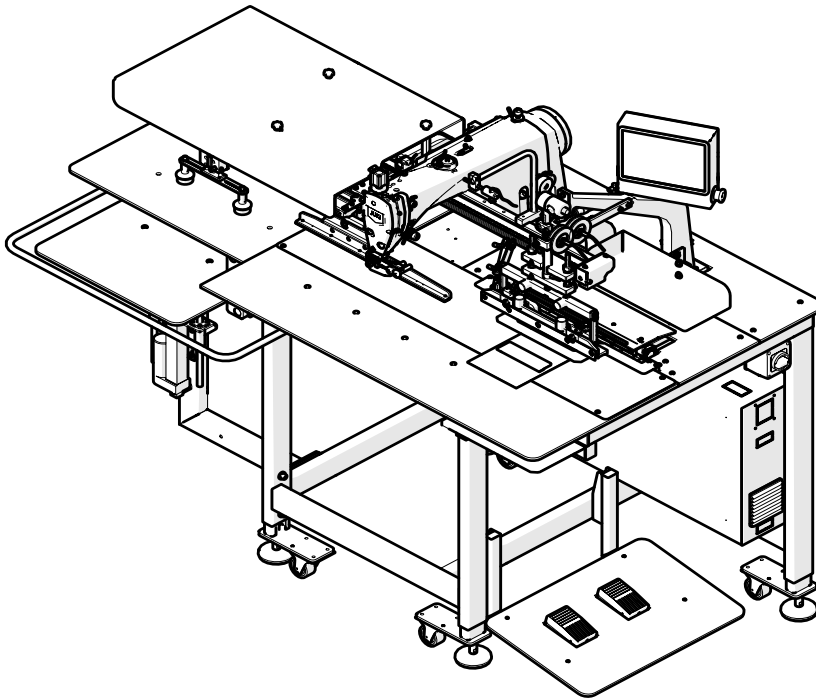
<b>1</b>	MACHINE HEAD	<b>9</b>	CHASIS GROUP
<b>2</b>	THREAD STAND	<b>10</b>	STACKING GROUP-1
<b>3</b>	PLC PANEL	<b>11</b>	STACKING GROUP-2
<b>4</b>	AIR REGULATOR	<b>12</b>	CLOTH STAND
<b>5</b>	MAIN SWITCH	<b>13</b>	CARRIER GROUP
<b>6</b>	JTRON CONTROL BOX	<b>14</b>	FOLDER GROUP
<b>7</b>	JUKI CONTROL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

## 2) SPECIFICATION

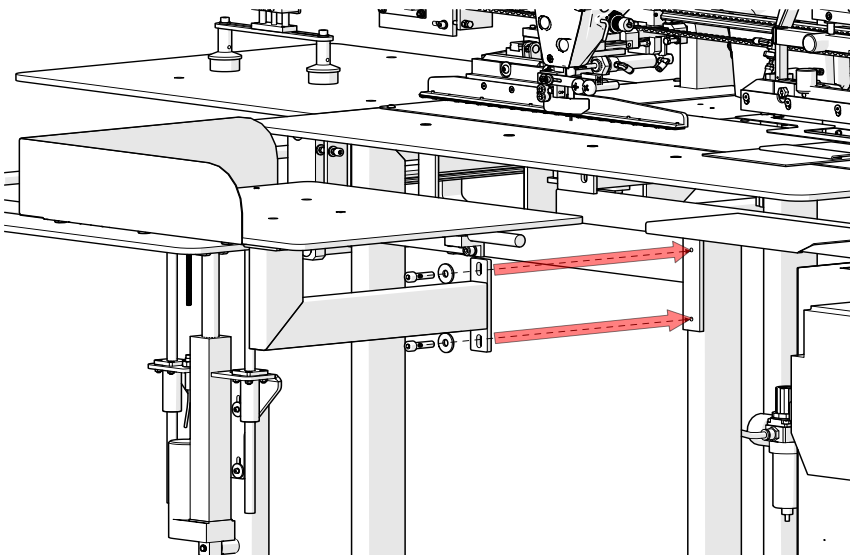
No.	Category	Description
1	MACHINE HEAD	DDL-9000BSS-WB
2	MODEL NAME	JTR-DDL9000B/PFA
3	MAIN MOTOR	JUKI AC SERVO MOTOR IPW550
4	MAIN MOTOR DRIVE	JUKI SC920
5	MAXIMUM SEWING SPEED	4000 sti/min, at the delivery: 4000 sti/min
6	STITCH LENGTH	Min : 2 mm / Max: 4.5 mm - At the delivery: 2.2 mm
7	NEEDLE TYPE	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 CLASSSSIFICATION	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

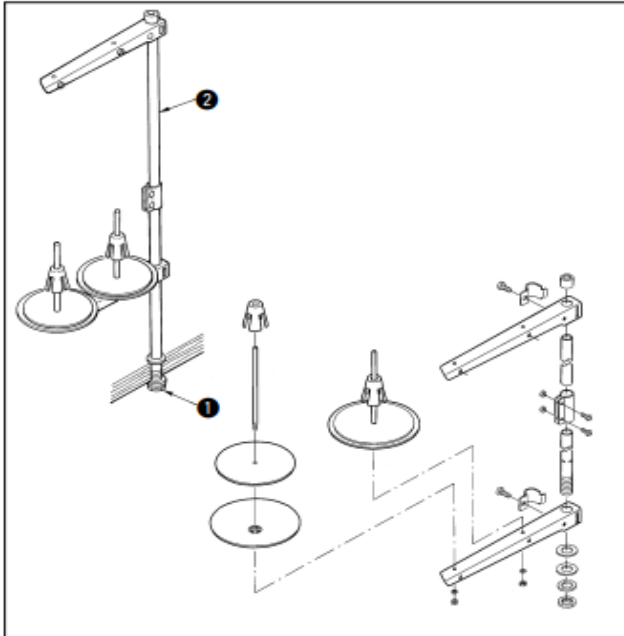
3.1) The machine is delivered as below.



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 ① 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 ② 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 ① to fix the thread stand.
- 3) For ceiling wiring, pass the power cord through spool rest rod ②.

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

- 1) Assembler le porte-bobines et l'introduire dans l'orifice de la table de la machine.
- 2) Serrer le contre-écrou ① 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 ②.

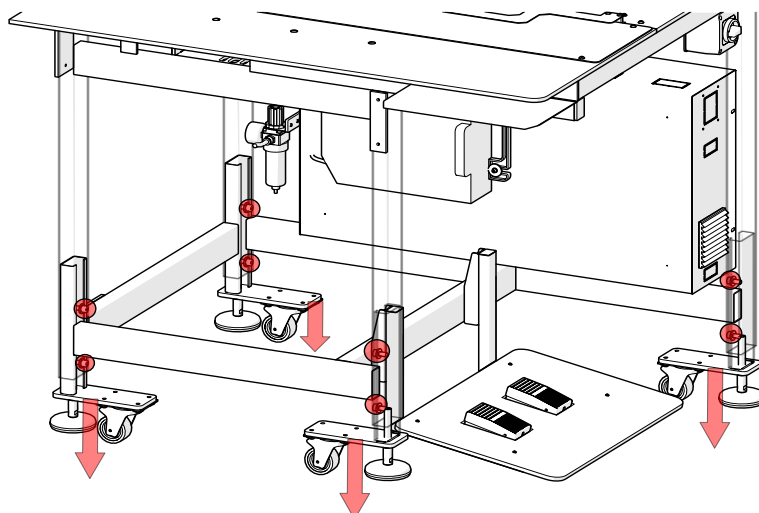
### 3.4) How to adjust the table height?

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

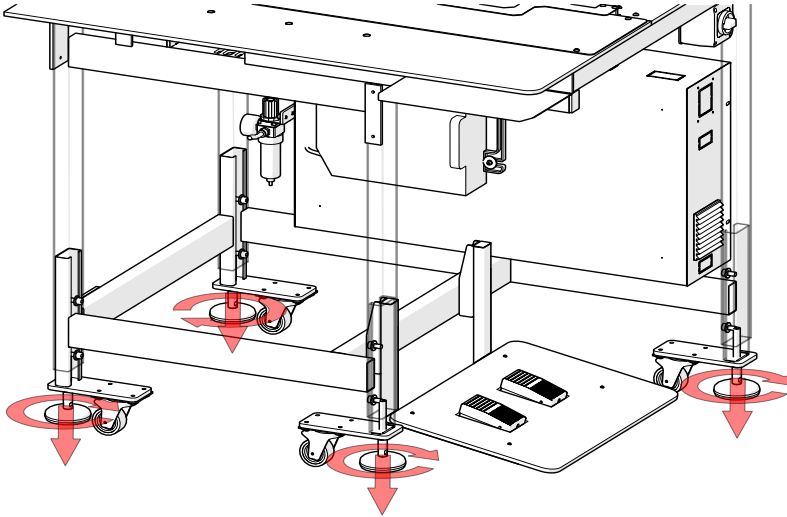
Loosen the screws(8 pieces).

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

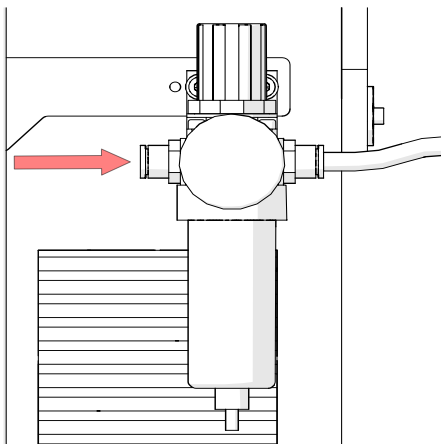
Tighten the screws(8 pieces) when the desired height is reached.



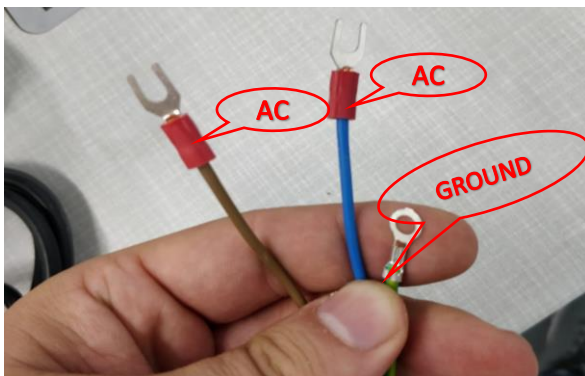
**3.5)** Adjust the rubber by turning them to ensure parallelism with the ground.



**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 necessary for you to select a plug that matches the receptacle available under a given operating environment and attach it to the power cable.



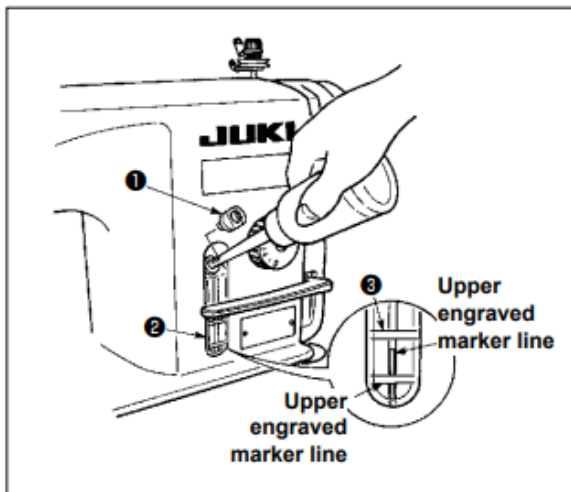
3.8) Remove the cable tie before starting the operation.



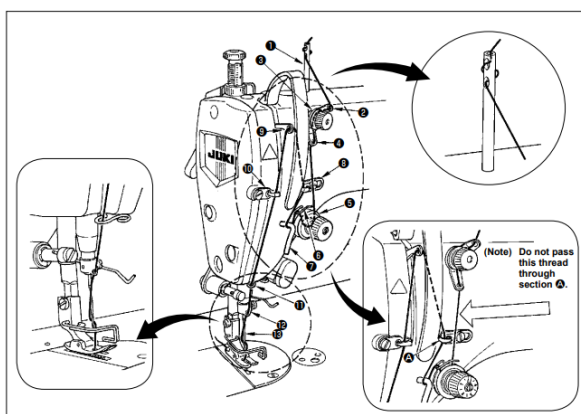
The components are fixed with cable ties to prevent damage during transportation.

## 4) PREPARATION FOR OPERATION

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

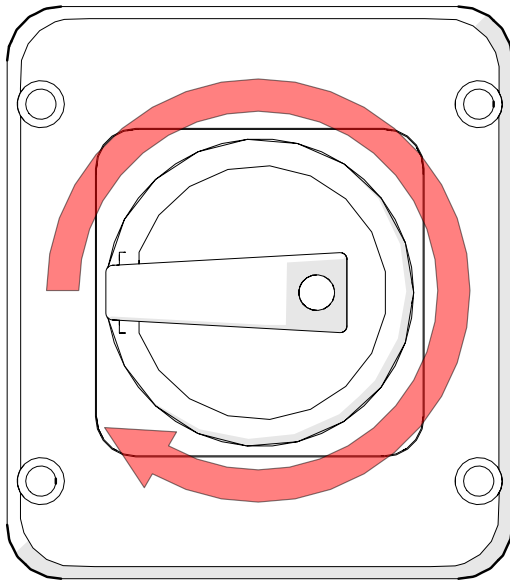


4.2) Threading the machine. (Please refer to machine head instructions – DDL-9000B Series)





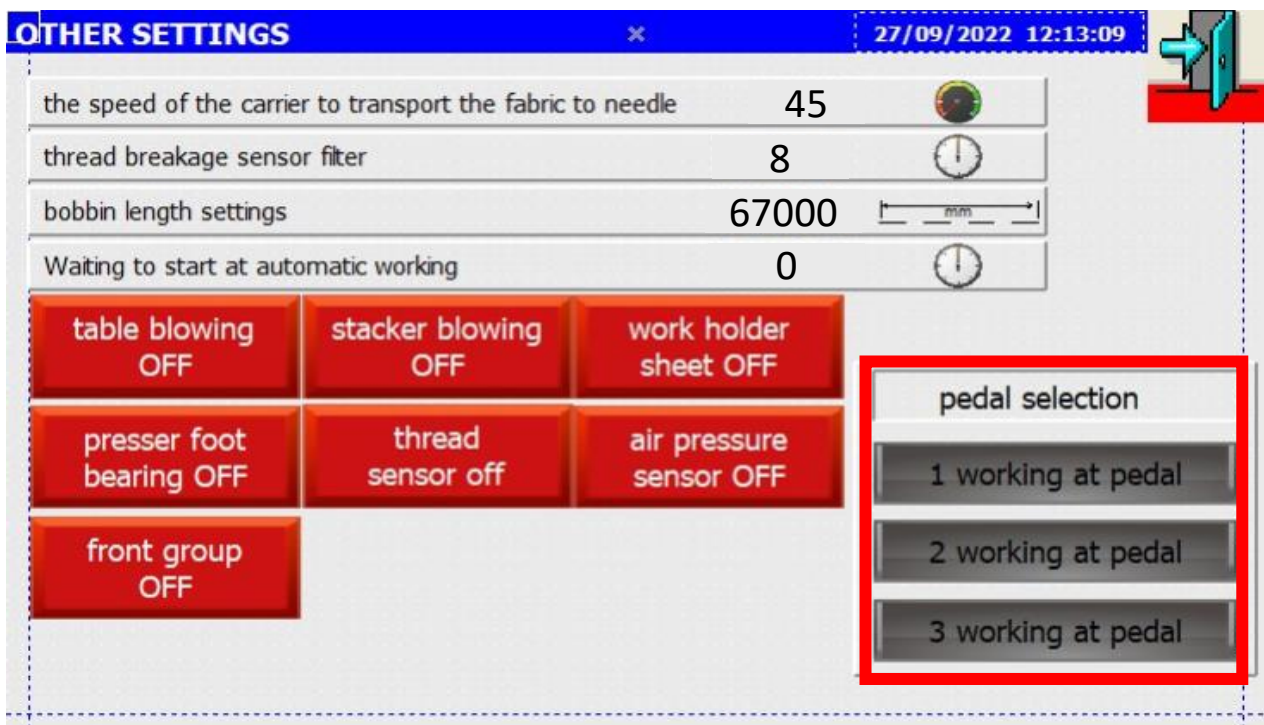
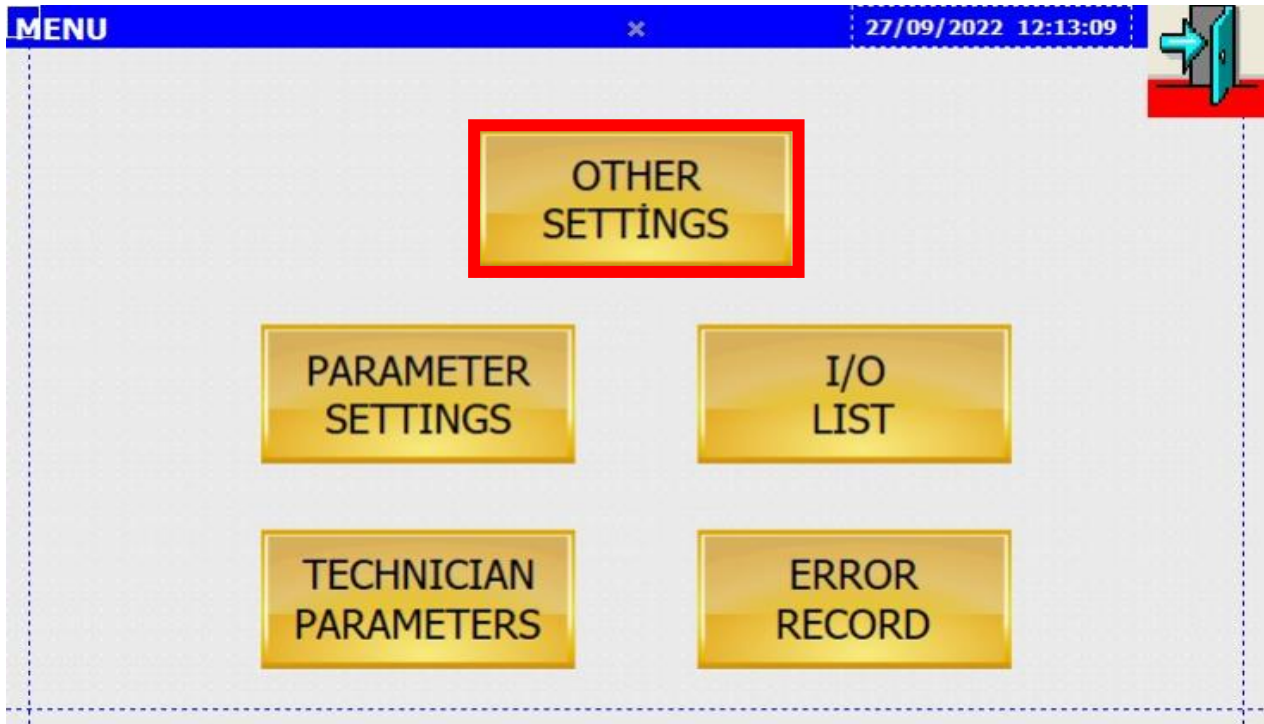
4.3) Switch on the machine.



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



#### 4.5) Selection of right pedal options.

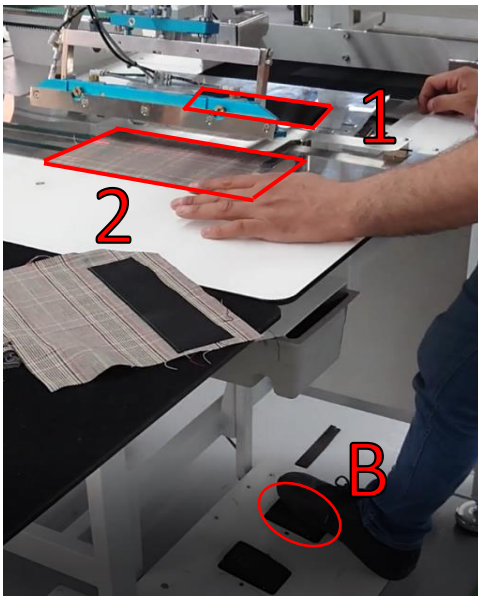


**1 working at pedal:** the whole operation is completed by pressing the right pedal only once.

**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).

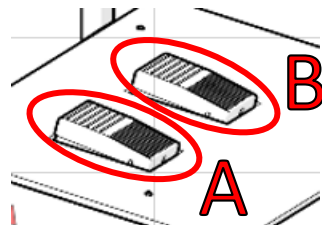
**1 working at pedal:** the whole operation is completed by pressing the right pedal only once.



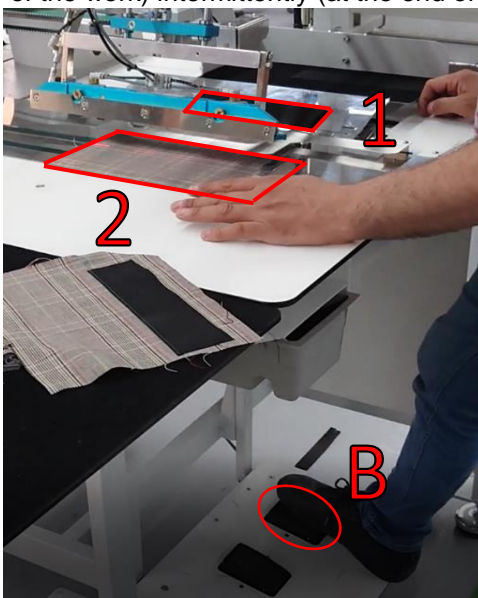
1 - Put the pocket-facing fabric(1).

2 - Put the pocket fabric(2).

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



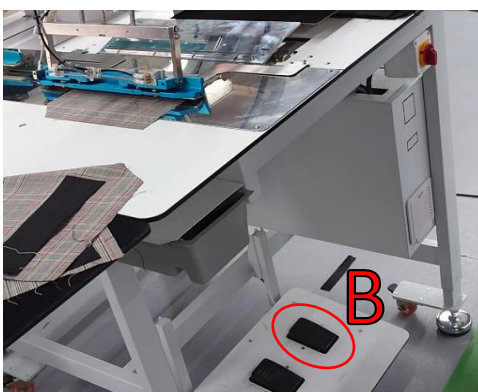
**2 working at pedal:** the whole operation is completed in 2 steps. The pedal is pressed once for each step (a part of the work) intermittently (at the end of each part).



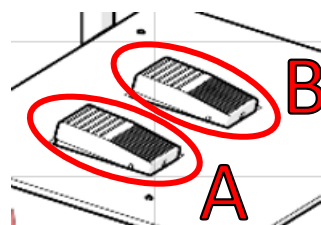
1 - Put the pocket-facing fabric(1).

2 - Put the pocket fabric(2).

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

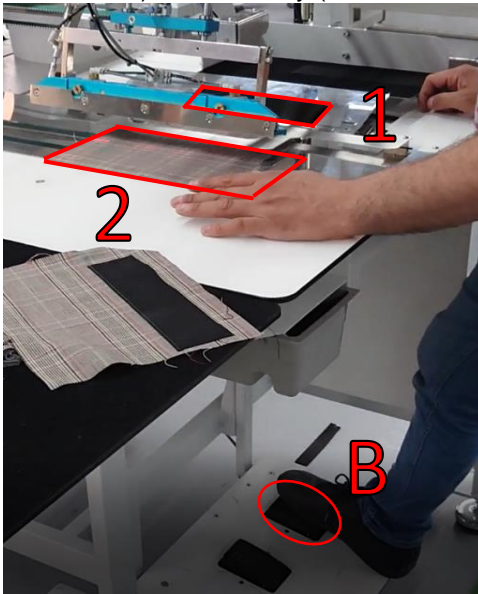


4 - Press the right pedal (B) again(2nd time) and complete the operation.





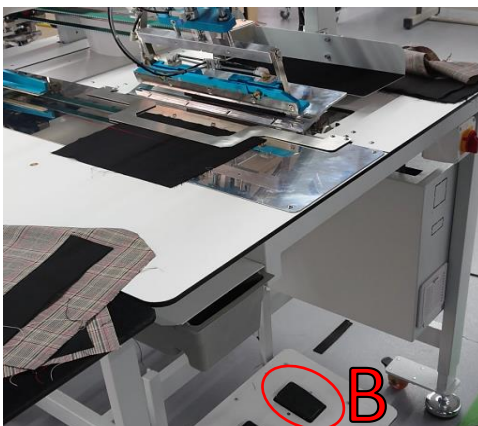
**3 working at pedal:** the whole operation is completed in 3 steps. The pedal is pressed once for each step (a part of the work) intermittently (at the end of each part).



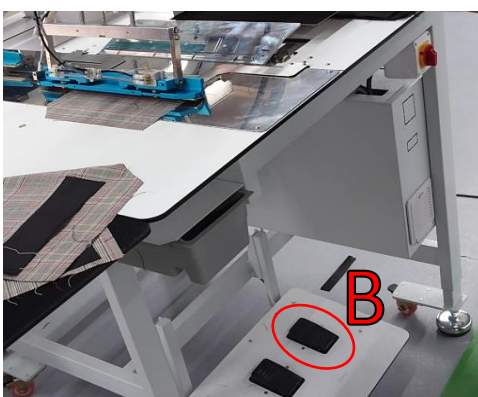
1 - Put the pocket-facing fabric(1).

2 - Put the pocket fabric(2).

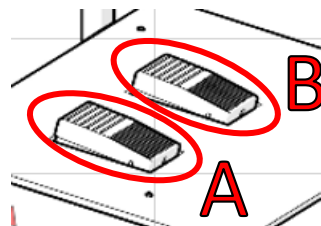
3 - Press the right pedal (B) (1st time).



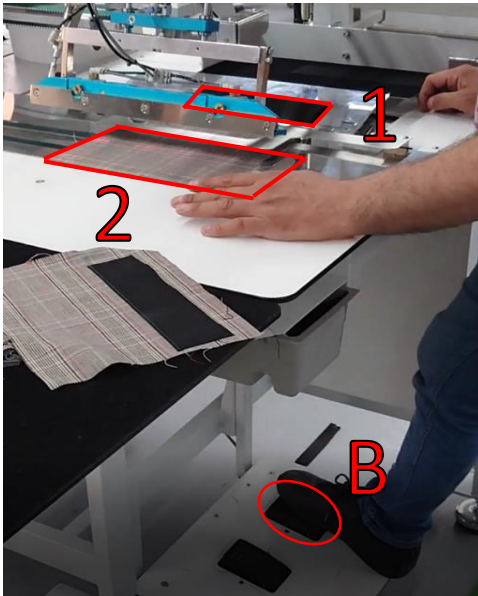
4 - Press the right pedal (B) again(2nd time).



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



#### 4.6) Sewing the sample.



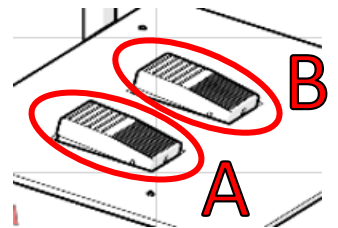
1 - Put the pocket-facing fabric(1).

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.



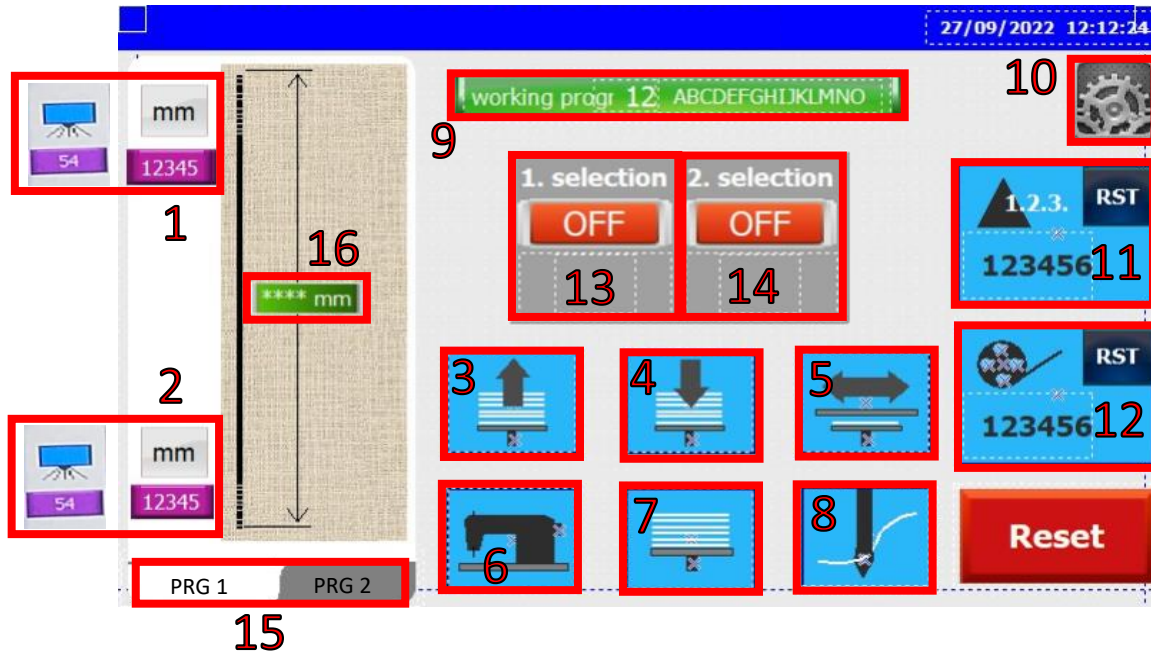
## 5) PANEL

### 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

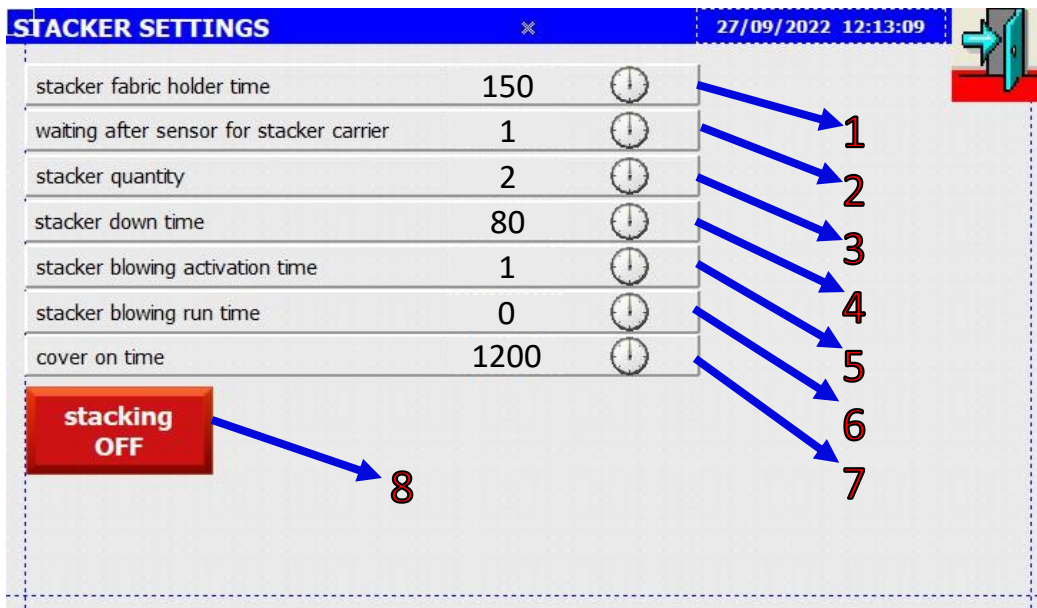
13- Operation Mode 1(PRG 1) : Stitching cycle is completed in a single operation in case of only this mode activated.

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



Setting	Value	Icon	Label
stacker fabric holder time	150	Clock	1
waiting after sensor for stacker carrier	1	Clock	2
stacker quantity	2	Clock	3
stacker down time	80	Clock	4
stacker blowing activation time	1	Clock	5
stacker blowing run time	0	Clock	6
cover on time	1200	Clock	7
stacking OFF			8

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



The screenshot shows the 'PROGRAM PAGE' interface. At the top, there is a blue header bar with the title 'PROGRAM PAGE', a close button (X), and the date/time '27/09/2022 12:13:09'. Below the header is a table with 30 rows, each containing a number (1-30) and the text 'ABCDEFGHIJKLMNO'. The table is divided into three columns of 10 rows each. To the right of the table are three buttons: 'PROGRAM SELECTION' (with a green arrow icon), 'SAVE' (with a floppy disk icon), and a return button (with a right arrow icon). At the bottom of the table, there is a green bar labeled 'working program' followed by the text '12 ABCDEFGHIJKLMNO'. Numbered callouts are placed around the interface: 1 points to the 'SAVE' button, 2 points to the 'PROGRAM SELECTION' button, 3 points to the return button, and 4 points to the first row of the table.





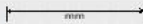
1- Save : It is used to save the settings of the recently created or existing program to a selected number on the program list.

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

SEWING SETTINGS		27/09/2022 12:13:09
normal sewing pitch (mm)	2.2	
normal sewing speed (head)	95	
front condense stitch pitch (mm)	1.0	
front condense stitch head speed (%)	50	
front condense stitch distance (mm)	8	
front condense stitch repetition number	1	
end condense stitch pitch (mm)	1.0	
end condense stitch speed (%)	50	
end condense stitch distance (mm)	8	
end condense stitch repetition number	1	

front condense stitch off

front zigzag off

end condense stitch off

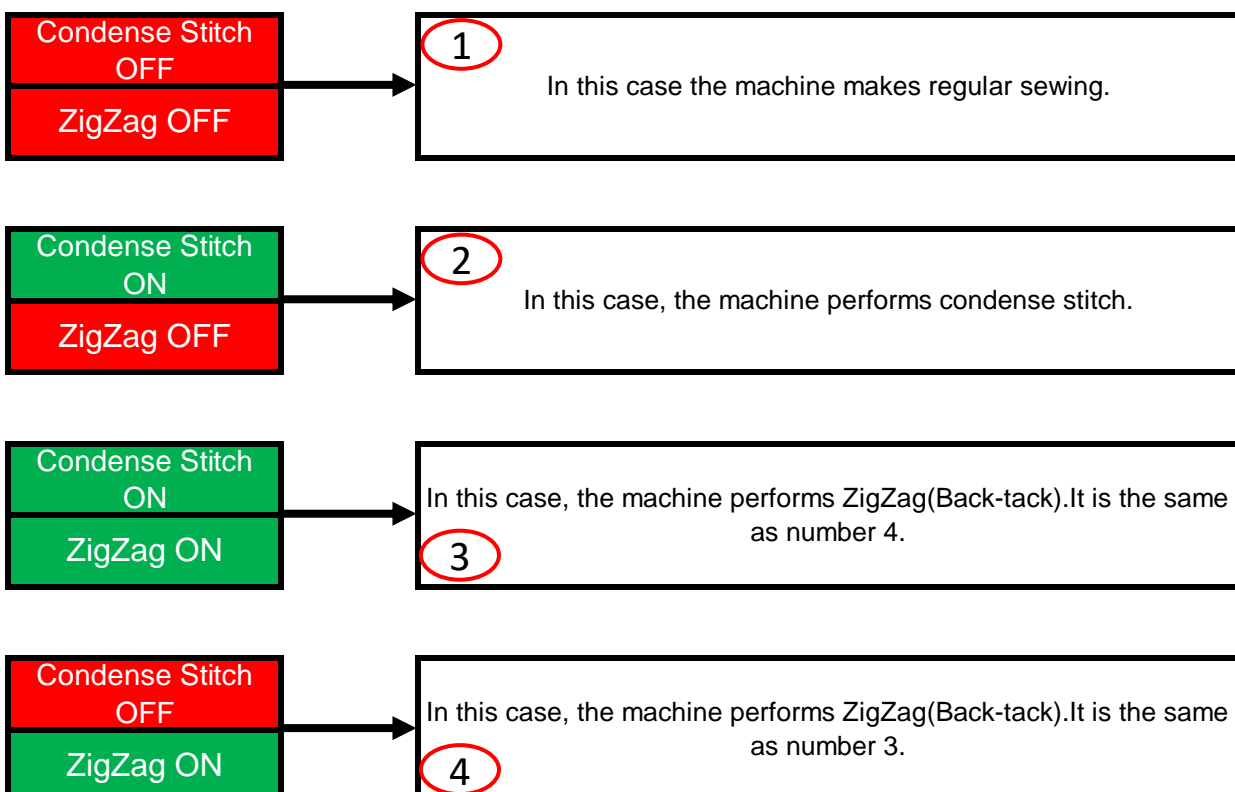
end zigzag off

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

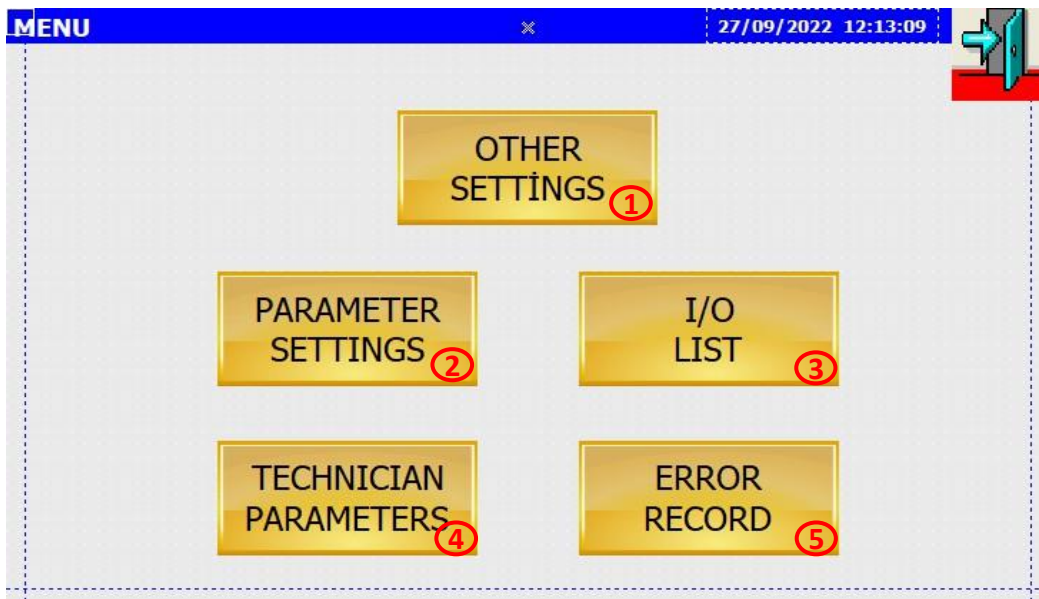
**Front ZigZag(Back-tack) ON/OFF:** It provides to make the front ZigZag(Back-tack) ON or OFF.

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

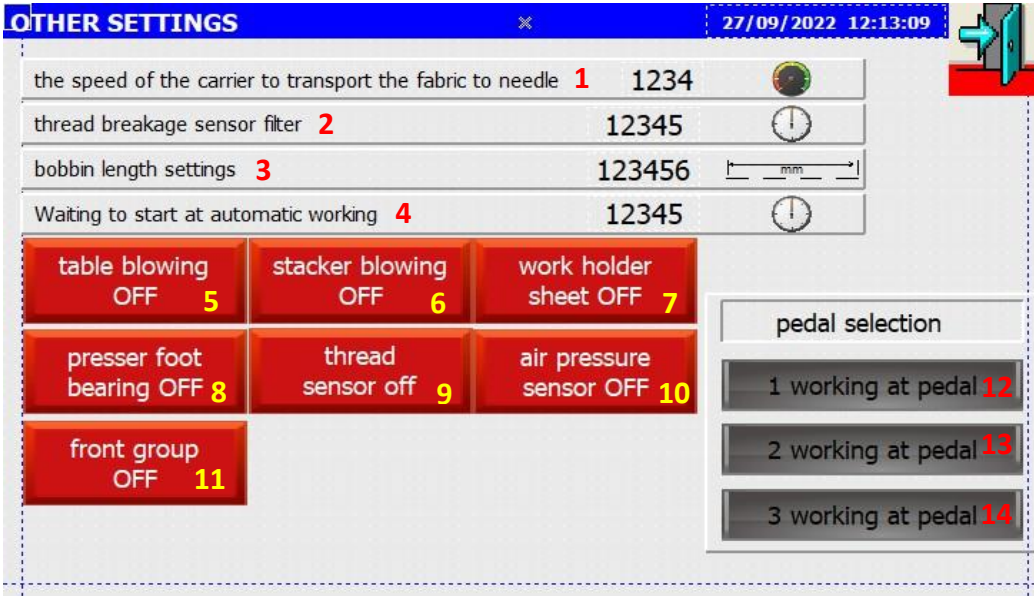
**End ZigZag(Back-tack) ON/OFF:** It provides to make the end ZigZag(Back-tack) ON or OFF.



#### 5.2.4) Menu



#### 5.2.4.1) Other Settings



**OTHER SETTINGS** 27/09/2022 12:13:09

the speed of the carrier to transport the fabric to needle **1** 1234

thread breakage sensor filter **2** 12345

bobbin length settings **3** 123456

Waiting to start at automatic working **4** 12345

table blowing OFF **5**

stacker blowing OFF **6**

work holder sheet OFF **7**

presser foot bearing OFF **8**

thread sensor off **9**

air pressure sensor OFF **10**

front group OFF **11**

pedal selection

1 working at pedal **12**

2 working at pedal **13**

3 working at pedal **14**

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

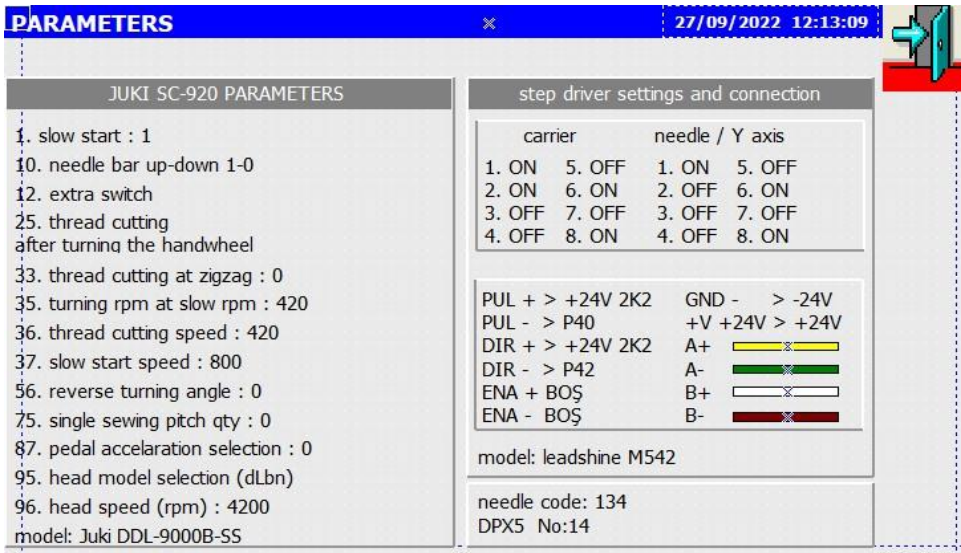
11- Front group OFF : ON/OFF

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

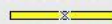


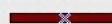
13- 2 working at pedal : the whole operation is completed by pressing the right pedal twice.

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

### 5.2.4.2) Parameter Settings



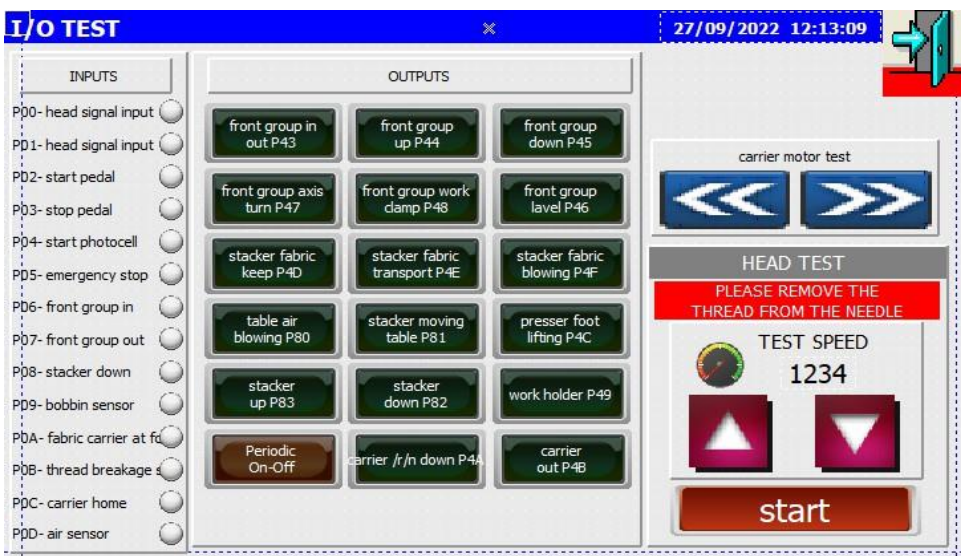
**PARAMETERS** 27/09/2022 12:13:09

JUKI SC-920 PARAMETERS	step driver settings and connection																				
1. slow start : 1 10. needle bar up-down 1-0 12. extra switch 25. thread cutting after turning the handwheel 33. thread cutting at zigzag : 0 35. turning rpm at slow rpm : 420 36. thread cutting speed : 420 37. slow start speed : 800 56. reverse turning angle : 0 75. single sewing pitch qty : 0 87. pedal acceleration selection : 0 95. head model selection (dLbn) 96. head speed (rpm) : 4200 model: Juki DDL-9000B-SS	<table border="1"> <thead> <tr> <th colspan="2">carrier</th> <th colspan="2">needle / Y axis</th> </tr> </thead> <tbody> <tr> <td>1. ON</td> <td>5. OFF</td> <td>1. ON</td> <td>5. OFF</td> </tr> <tr> <td>2. ON</td> <td>6. ON</td> <td>2. OFF</td> <td>6. ON</td> </tr> <tr> <td>3. OFF</td> <td>7. OFF</td> <td>3. OFF</td> <td>7. OFF</td> </tr> <tr> <td>4. OFF</td> <td>8. ON</td> <td>4. OFF</td> <td>8. ON</td> </tr> </tbody> </table> PUL + > +24V 2K2    GND - > -24V PUL - > P40    +V +24V > +24V DIR + > +24V 2K2    A+  DIR - > P42    A-  ENA + BOŞ    B+  ENA - BOŞ    B-   model: leadshine M542  needle code: 134 DPX5 No:14	carrier		needle / Y axis		1. ON	5. OFF	1. ON	5. OFF	2. ON	6. ON	2. OFF	6. ON	3. OFF	7. OFF	3. OFF	7. OFF	4. OFF	8. ON	4. OFF	8. ON
carrier		needle / Y axis																			
1. ON	5. OFF	1. ON	5. OFF																		
2. ON	6. ON	2. OFF	6. ON																		
3. OFF	7. OFF	3. OFF	7. OFF																		
4. OFF	8. ON	4. OFF	8. ON																		





This screen shows the default factory parameters.

**Note!** These parameters' values should not be changed.

### 5.2.4.3) I/O List (Testing Page)



**I/O TEST** 27/09/2022 12:13:09

INPUTS	OUTPUTS			HEAD TEST
P00-head signal input	front group in out P43	front group up P44	front group down P45	carrier motor test   PLEASE REMOVE THE THREAD FROM THE NEEDLE TEST SPEED 1234   start
P01-head signal input	front group axis turn P47	front group work clamp P48	front group level P46	
P02-start pedal	stacker fabric keep P4D	stacker fabric transport P4E	stacker fabric blowing P4F	
P03-stop pedal	table air blowing P80	stacker moving table P81	presser foot lifting P4C	
P04-start photocell	stacker up P83	stacker down P82	work holder P49	
P05-emergency stop	Periodic On-Off	carrier /r/n down P4A	carrier out P4B	
P06-front group in				
P07-front group out				
P08-stacker down				
P09-bobbin sensor				
P0A-fabric carrier at f				
P0B-thread breakage				
P0C-carrier home				
P0D-air sensor				

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

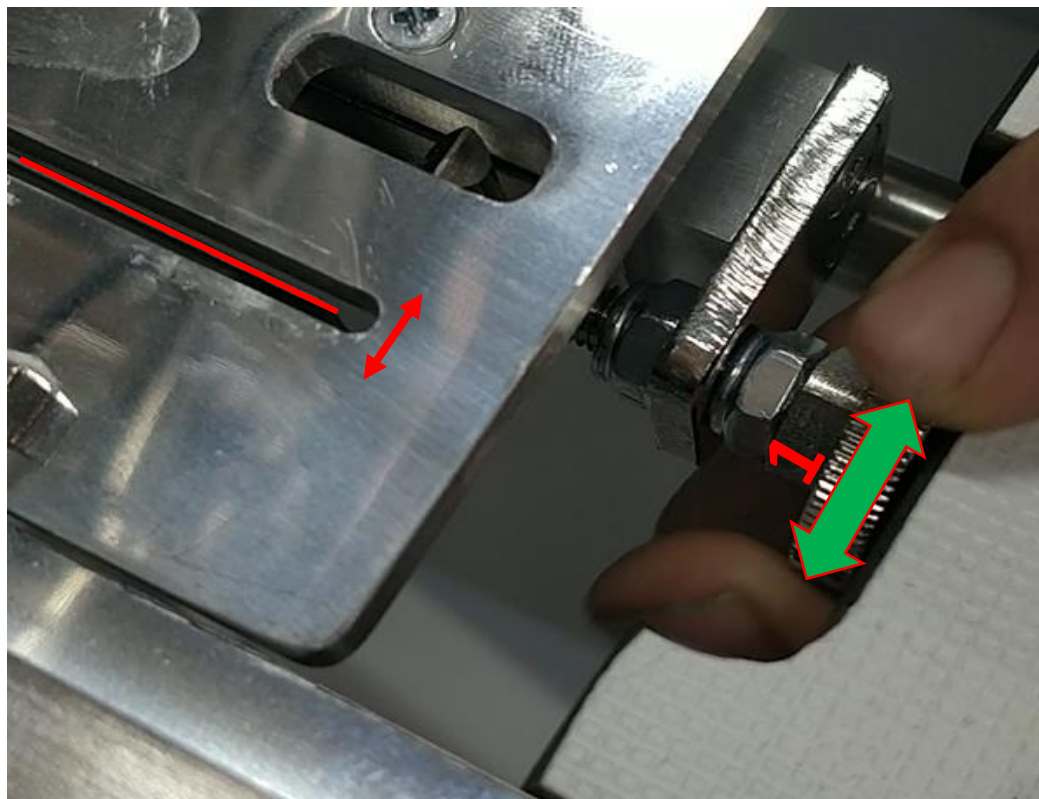
ERROR RECORD		27/09/2022 12:13:09	
Tarih	Alarm		
27/09/22 12:13	Emergency stop button is pressed.		
27/09/22 12:13	Thread breakage.		
27/09/22 12:13	Panel reset button is pressed.		
27/09/22 12:13	Photocell does not detect at the starting .		
27/09/22 12:13	Out of sewing area.		
27/09/22 12:13	Bobbing thread is consumed.		
27/09/22 12:13	Please send the machine to the reference point.		
27/09/22 12:13	No air pressure! please check the air.		
27/09/22 12:13			
27/09/22 12:13			
27/09/22 12:13			
27/09/22 12:13			
27/09/22 12:13			
27/09/22 12:13			
27/09/22 12:13			
27/09/22 12:13			

Error records cannot be deleted.

Error records are kept for examination by the technical service.

## 6) ADJUSTMENT

### 6.1) Adjusting Edgestitch



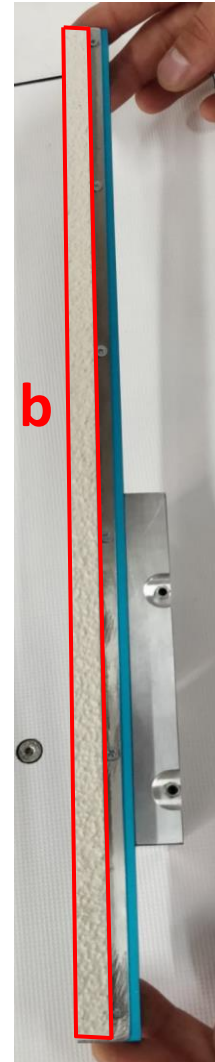
If you turn screw(1) clockwise, the width of edgestitch(a) decreases.

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



## 6.2) Replace the carrier presser arm rubber

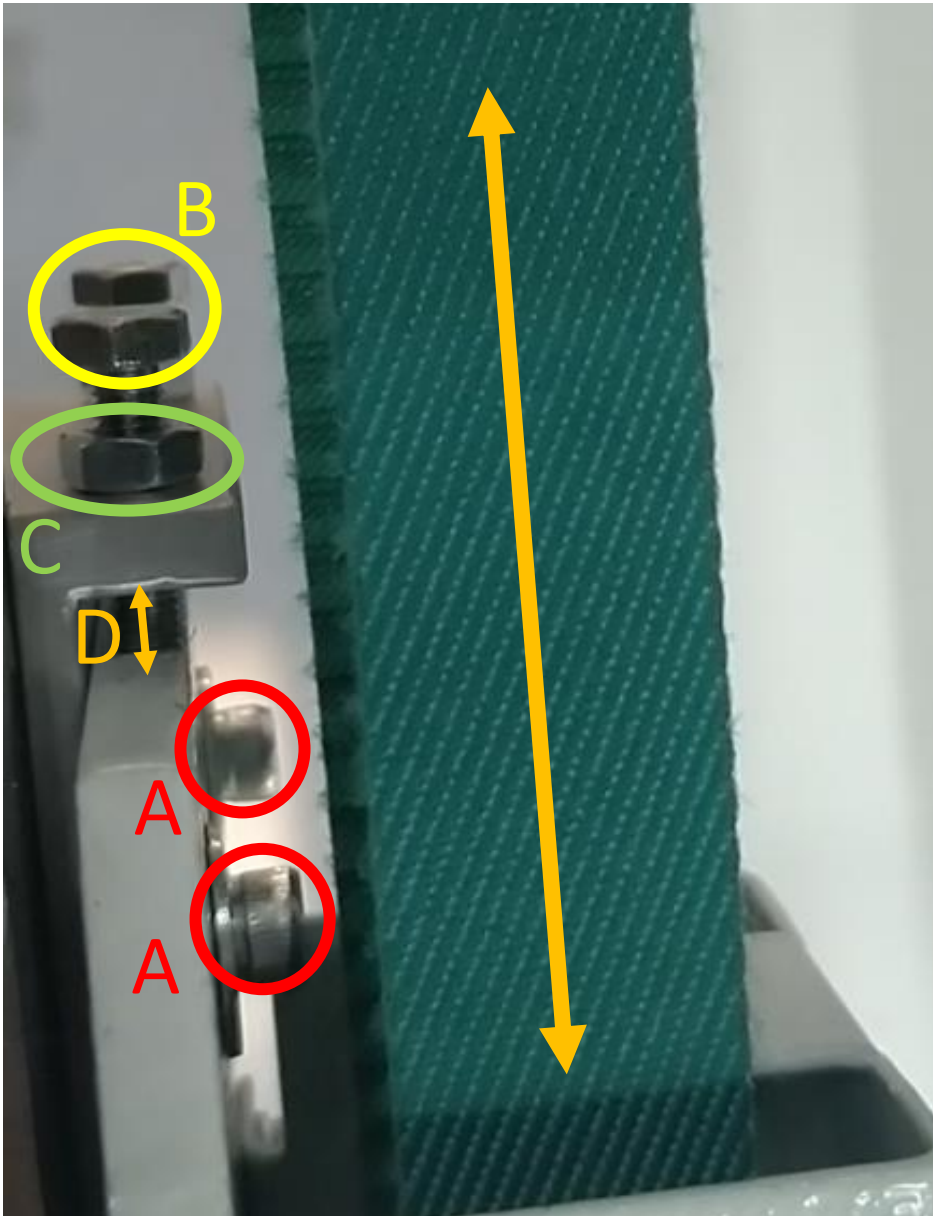
Remove the screw(a) and washer.



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).

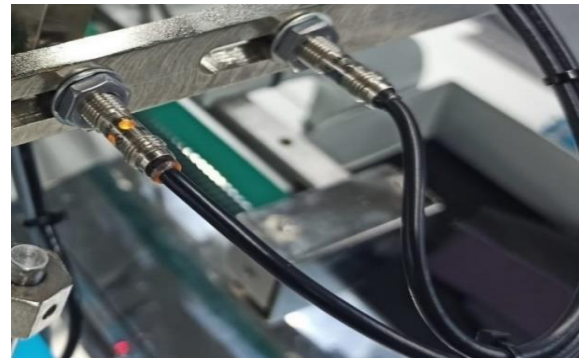
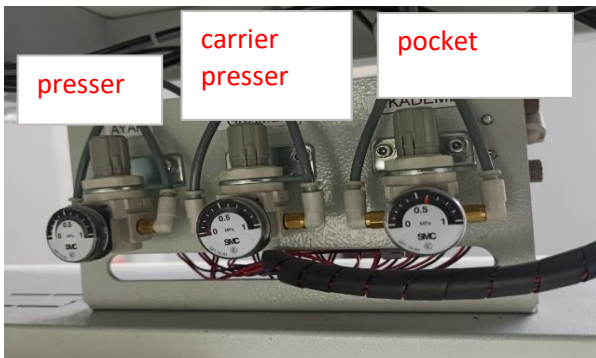
Secondly loosen the nuts(C).

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

SEWING SETTINGS		27/09/2022 12:13:09	
normal sewing pitch (mm)	123.4		
normal sewing speed (head)	1234		
front condense stitch pitch (mm)	12.3		
front condense stitch head speed (%)	12345		
front condense stitch distance (mm)	12345		
front condense stitch repetition number	12345		
end condense stitch pitch (mm)	12.3		
end condense stitch speed (%)	12345		
end condense stitch distance (mm)	12345		
end condense stitch repetition number	12345		

front condense stitch off

front zigzag off

end condense stitch off

end zigzag off

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)

**STACKER SETTINGS** 14/11/2022 13:29:46

stacker fabric holder time	150	
waiting after sensor for stacker carrier	1	
stacker quantity	2	
stacker down time	80	
stacker blowing activation time	1	
stacker blowing run time	0	
cover on time	1200	

**stacking ON**

**SEWING SETTINGS** 14/11/2022 13:29:56

normal sewing pitch (mm)	2.2		
normal sewing speed (head)	95		
front condense stitch pitch (mm)	1.0		<b>front condense stitch on</b>
front condense stitch head speed (%)	50		<b>front zigzag off</b>
front condense stitch distance (mm)	8		
front condense stitch repetition number	1		
end condense stitch pitch (mm)	1.0		<b>end condense stitch on</b>
end condense stitch speed (%)	50		<b>end zigzag off</b>
end condense stitch distance (mm)	8		
end condense stitch repetition number	1		

**OTHER SETTINGS** 14/11/2022 13:29:20

the speed of the carrier to transport the fabric to needle	45	
thread breakage sensor filter	8	
bobbin length settings	67000	
Waiting to start at automatic working	0	

**table blowing ON**

**stacker blowing OFF**

**work holder sheet ON**

**presser foot bearing ON**

**thread sensor on**

**air pressure sensor OFF**

**front group ON**

pedal selection

1 working at pedal

2 working at pedal

3 working at pedal

## 8) CAUSES AND COUNTERMEASURES

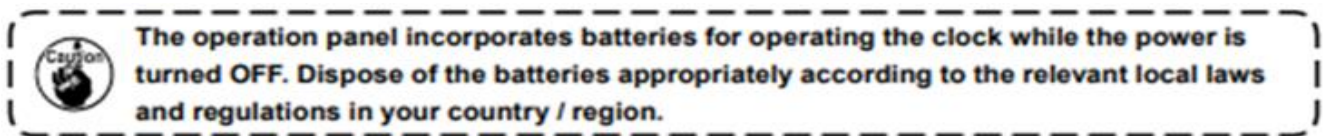
**Q.1)** Stitch skipping.

**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





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