

Polo Placket Automat

JTR-DDL9000B / PPA

INSTRUCTION MANUAL



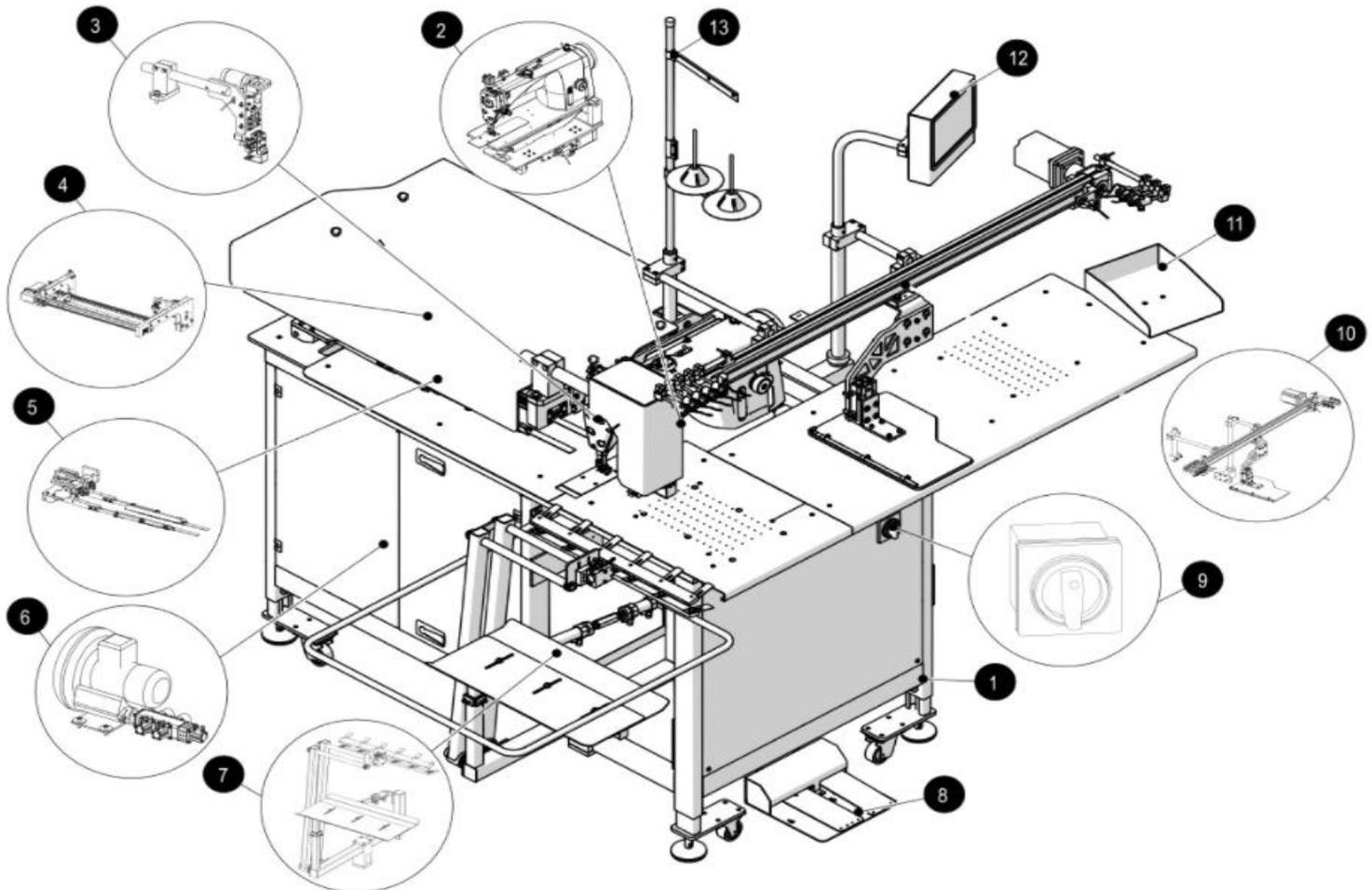
No.JTR001

DDL9000BPPA-TM

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1) CONFIGURATION OF THE MACHINE



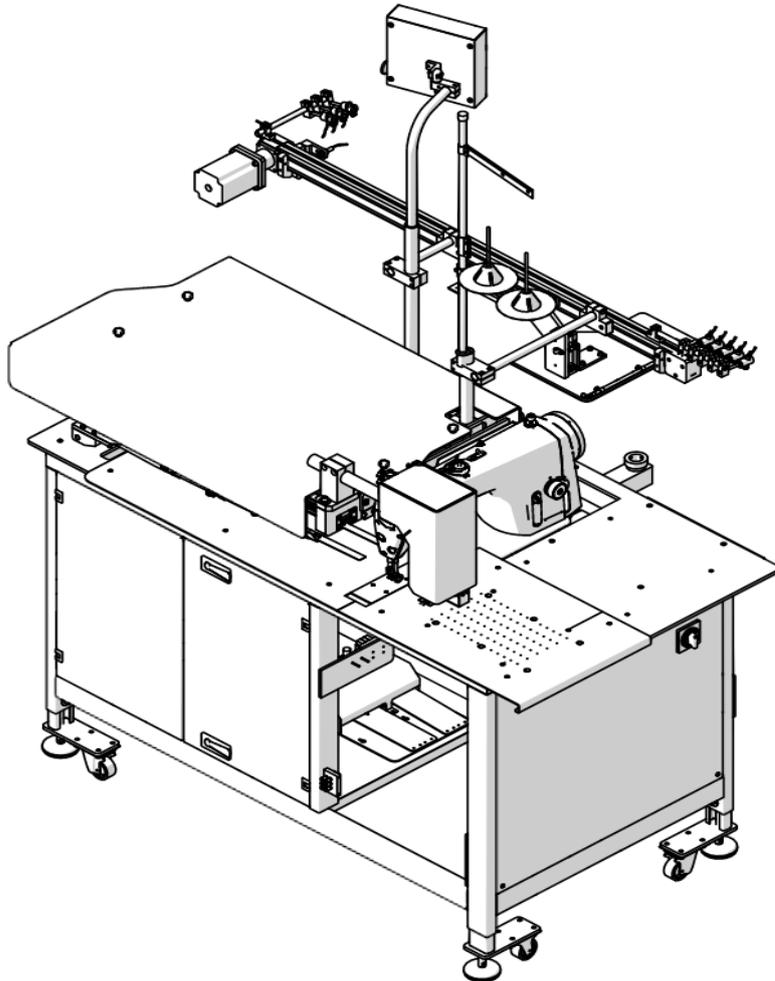
1	CHASSIS GROUP	8	PEDAL GROUP
2	MACHINE HEAD	9	MAIN SWITCH
3	KNIFE GROUP	10	FABRIC CARRIER
4	RAIL GROUP	11	MATERAIL HOLDER
5	STITCH MOVEMENT CARRIER	12	PLC PANEL
6	VACUUM MOTOR GROUP	13	THREAD STAND
7	STACKING GROUP		

2) SPECIFICATION

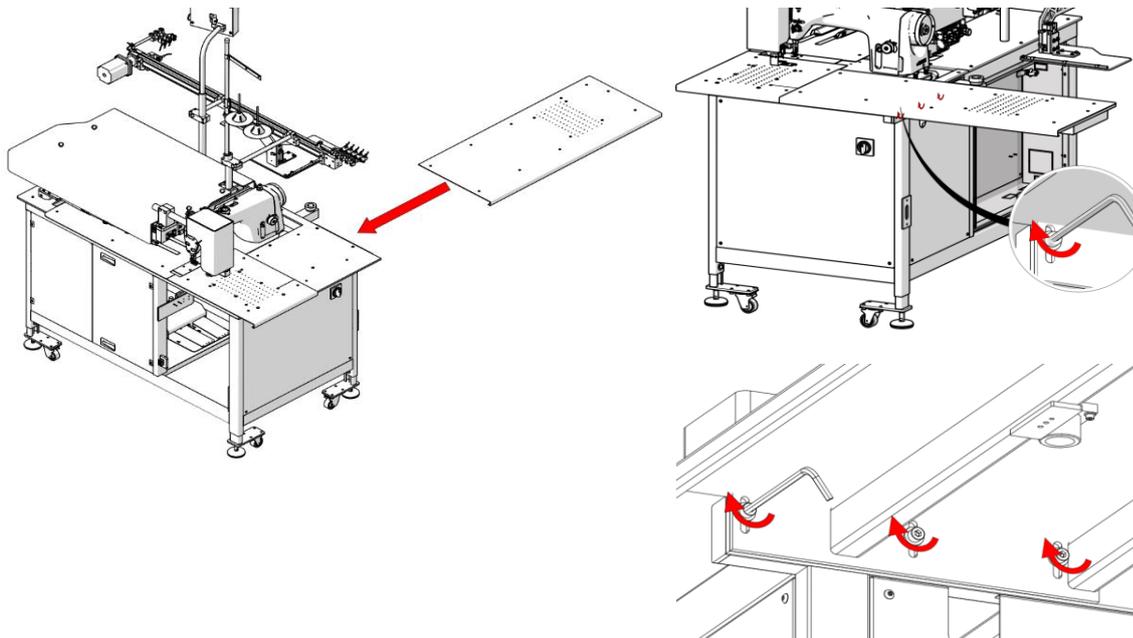
No.	Category	Description
1	MACHINE HEAD	DDL9000BSS-WB
2	MODEL NAME	JTR-DDL9000B / PPA
3	MAIN MOTOR	Juki IPW550 MOTOR
4	MAIN MOTOR DRIVE	JUKI SC920
5	MAXIMUM SEWING SPEED	Max: 4000 sti/min DELIVERY SPEED : 4000 sti/min
6	STITCH LENGTH	Min : 2mm Max: 4.5mm delivery stitch length : 3mm
7	NEEDLE TYPE	GB - DPX5 - #10
8	GAUGE	Jtron original
9	SEWING AREA	240mm - 30mm
10	Polo t-shirt size	2mm - 55mm
11	FABRIC CUTTING SYSTEM	PLC controlled fabric cutting system
12	SEWING SPECIFICATIONS	THIN TO MEDIUM THICKNESS
13	TARGET PROCESS	POLO PLACKET
14	AIR PRESSURE	MIN: 0.5 MPa MAX: 0.7 MPa Standard: 0.6 Mpa
15	AIR CONSUMPTION	6 L / min
16	VOLTAGE CLASSIFICATION	Single-phase 200-240V/50Hz
17	CAPACITY	3000 polo shirts / 9 hours
18	DAILY PIECE COUNTER	YES
19	POWER CONSUMPTION	1150 VA

3) INSTALLATION

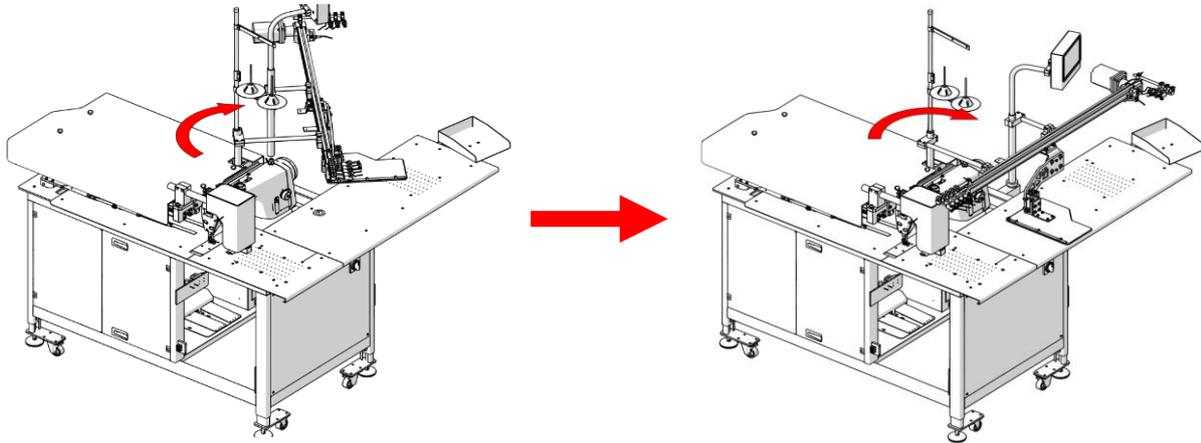
3.1) The machine is delivered as below.



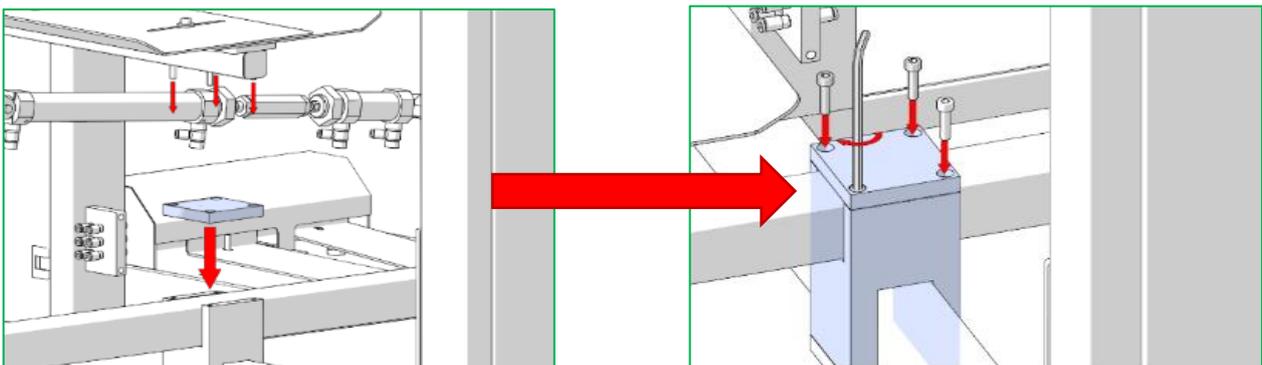
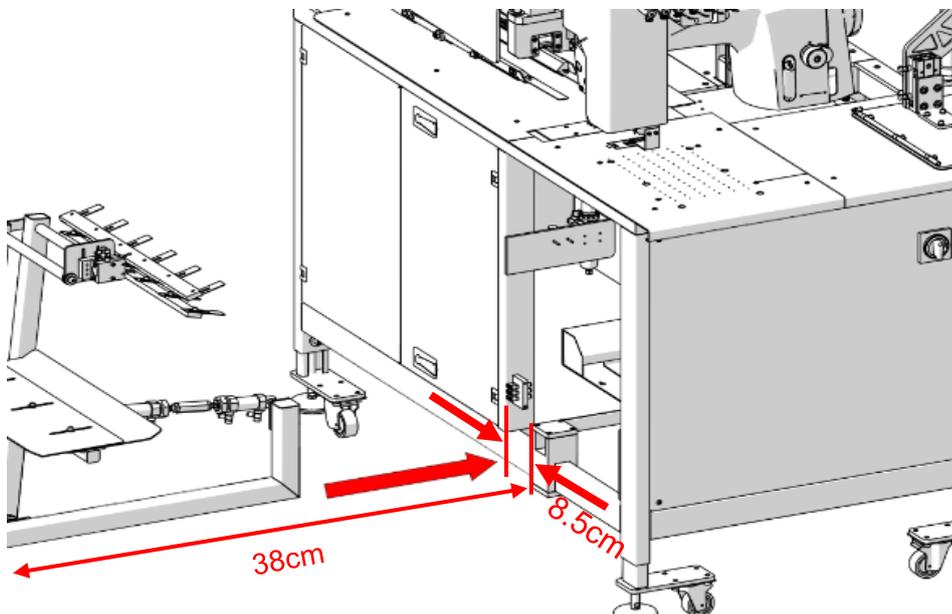
3.2) Install the table shown below.



3.3) Open the cloth carrier arm as shown the image below.



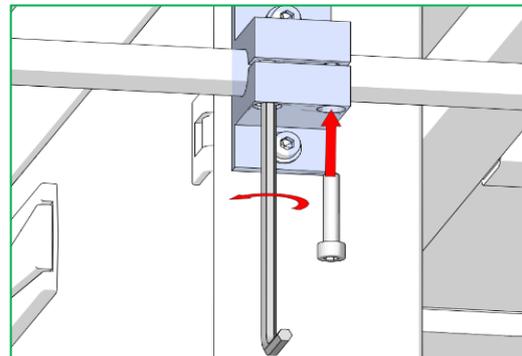
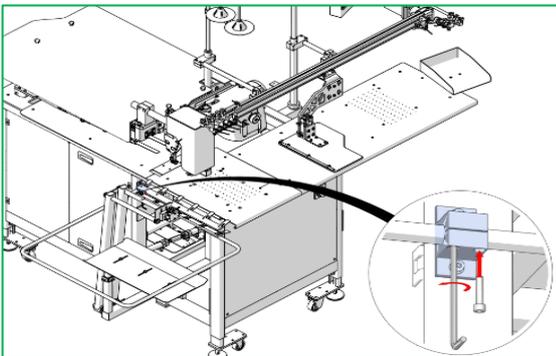
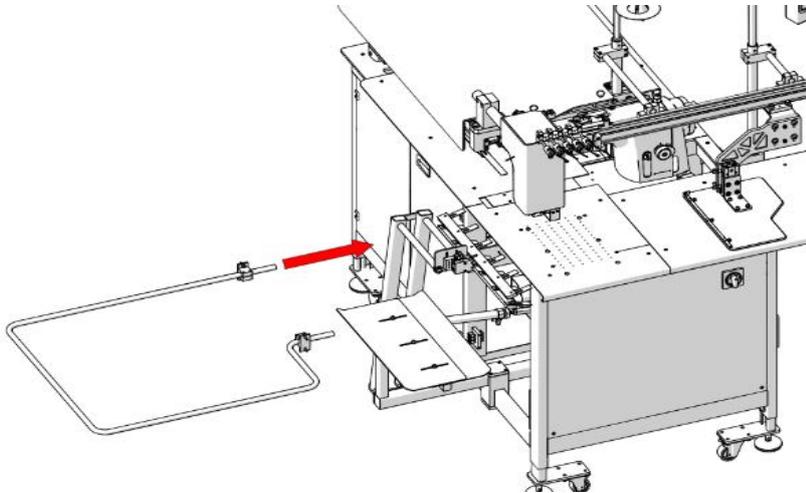
3.4) Attach the stacker to the main frame.



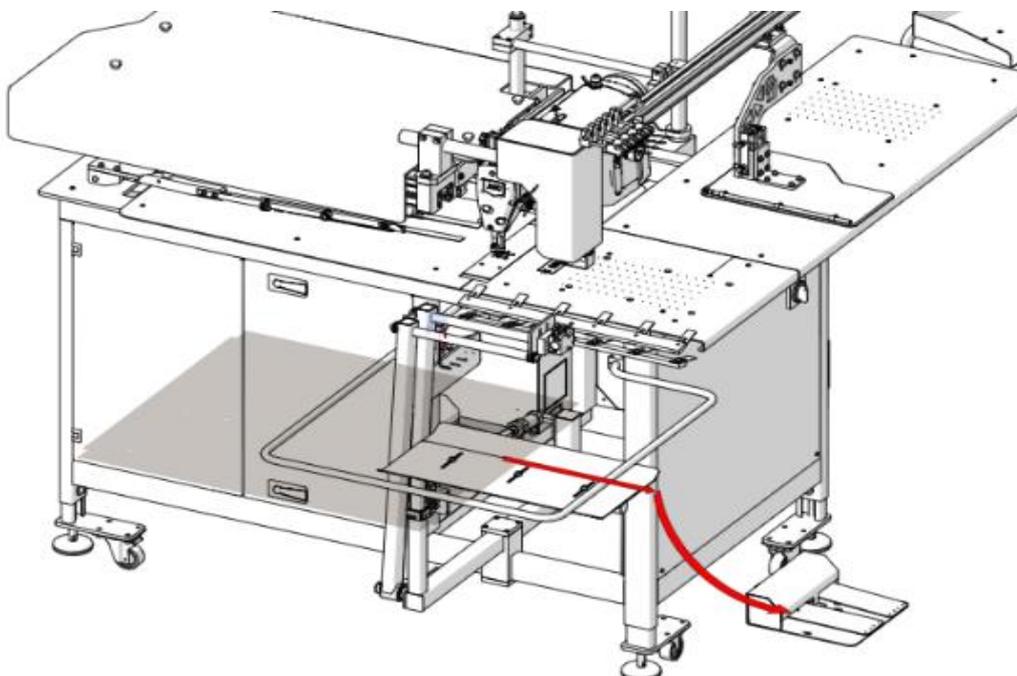
It should be 38 cm from the beginning of the stacker to bracket.

It should be 8.5 cm from the of the foot of the table to stacker joint.

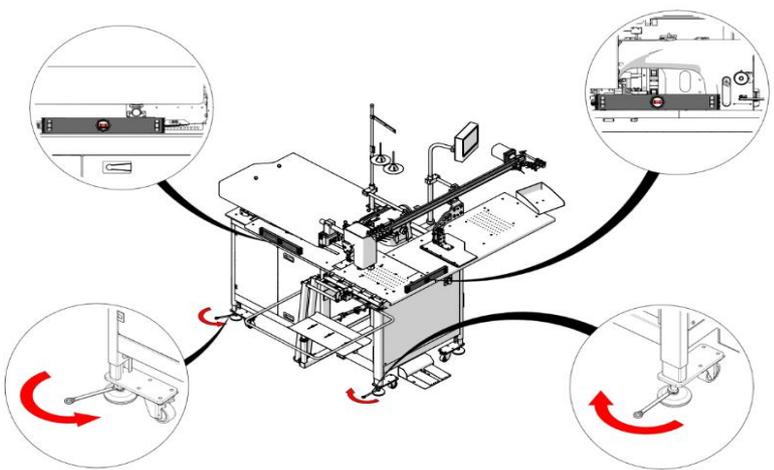
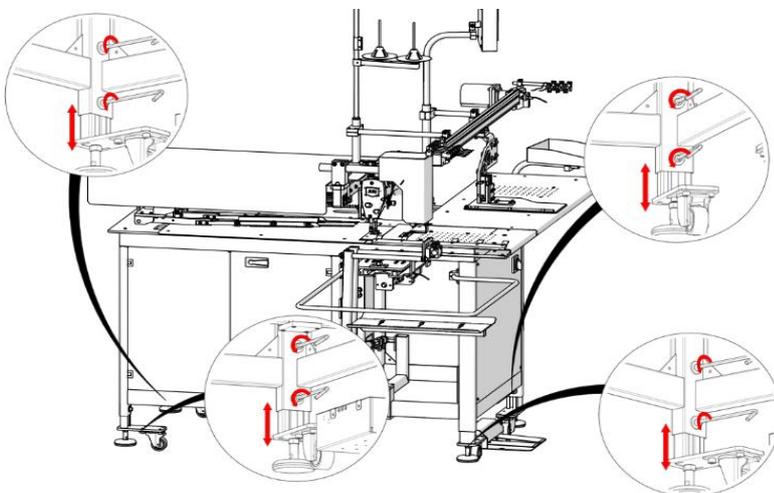
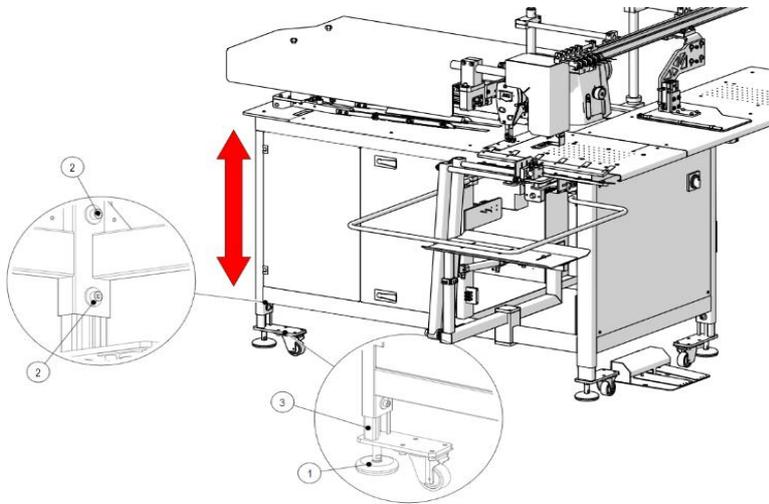
3.5) Attach the stacker protection bar to the stacker.



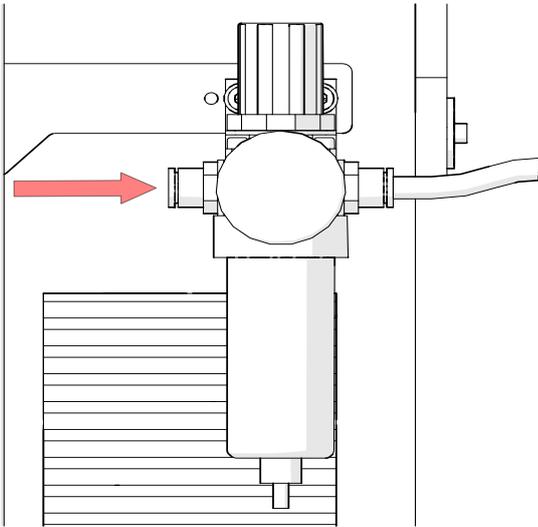
3.6) Place the pedals on the ground.



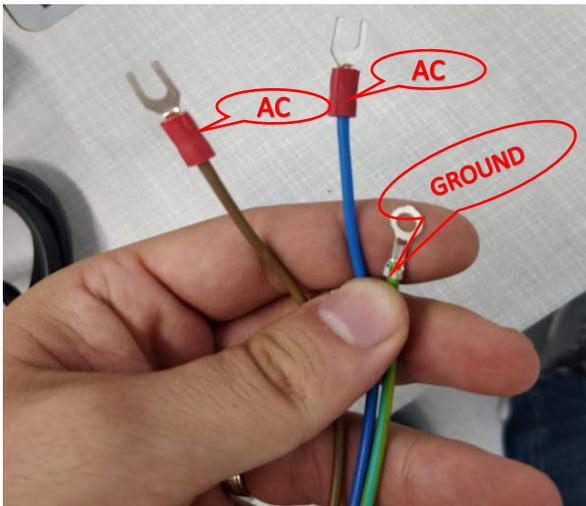
3.7) Adjust the table height and balance via frame stoppers which you can see at the below images.



3.8) Connect the air tube to the air regulator.

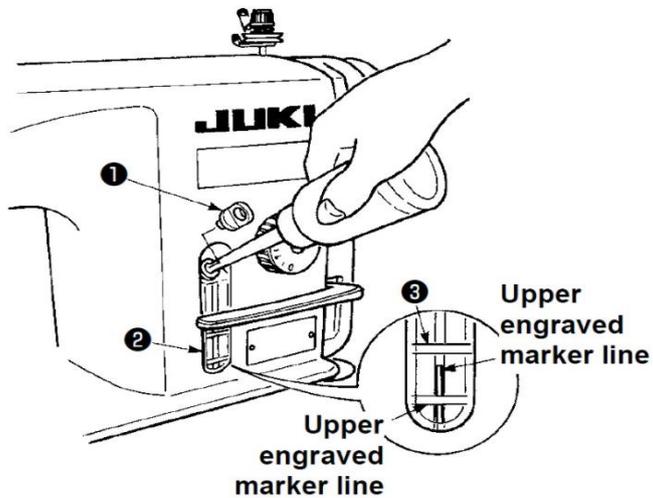


3.9) Connecting the power supply



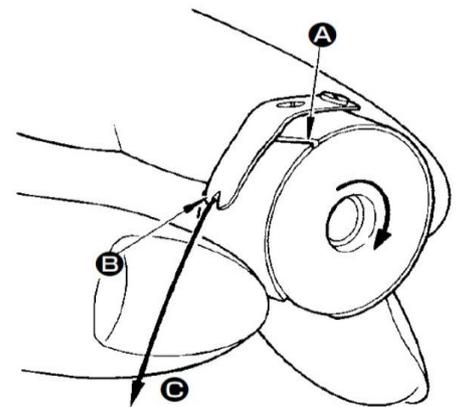
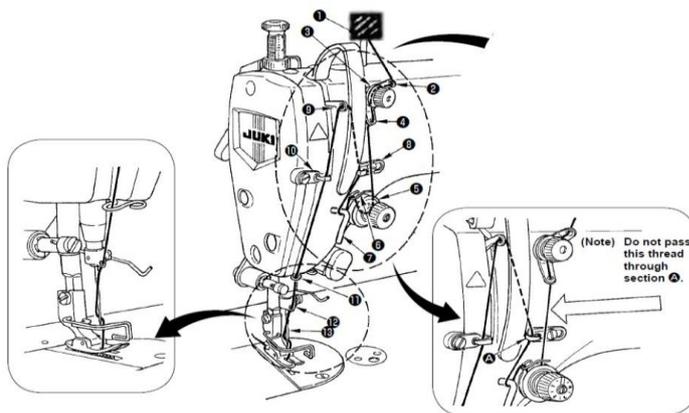
The machine is not supplied with a power plug. It is therefore necessary for you to select a plug that matches the receptacle available under a given operating environment and attach it to the power cable.

3.10) Please put the Juki genuine oil 7 from upper cover of the machine head. (Please refer to machine head instructions –DDL9000B)

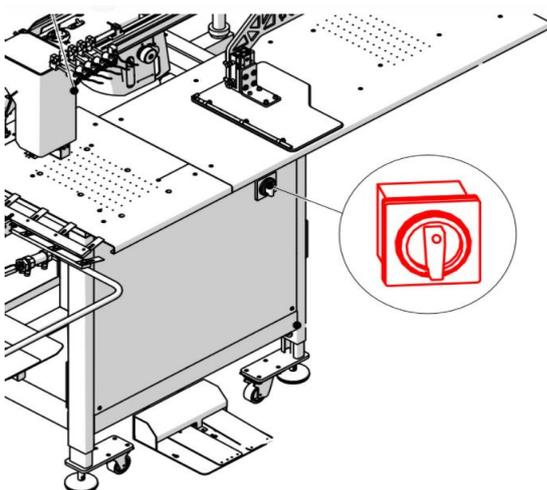


4) PREPERATION FOR OPERATION

4.1) Threading the machine. (Please refer to machine head instructions – DDL9000B)



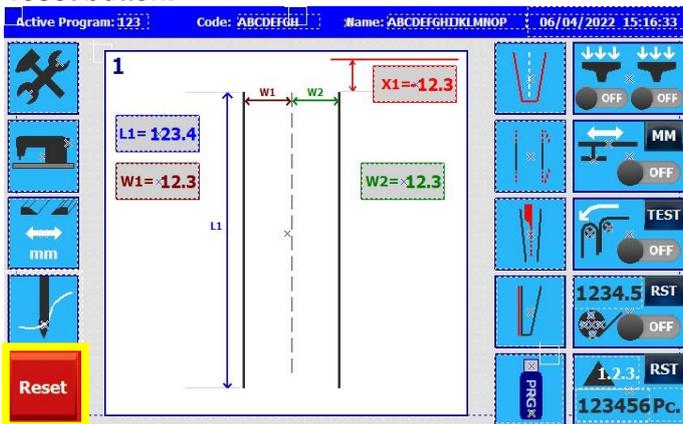
4.2) Switch on the machine.



4.3) Once the machine is switched on the JTRON opening page displays.

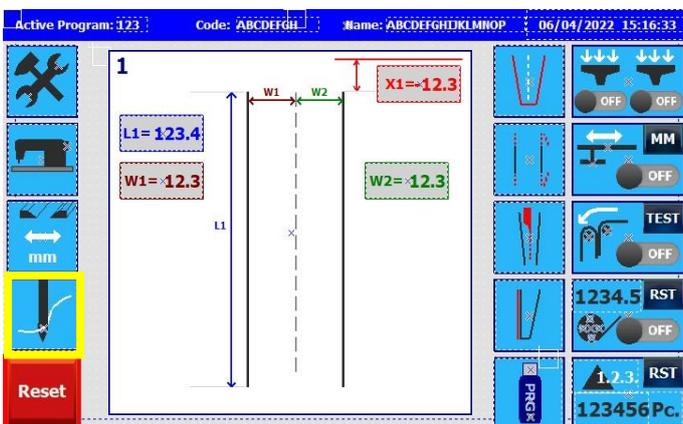


4.4) When the panel is touched, it brings the user to main menu. Reset the machine by pressing the reset button.



When reset button is pressed, the machine travels to origin position.

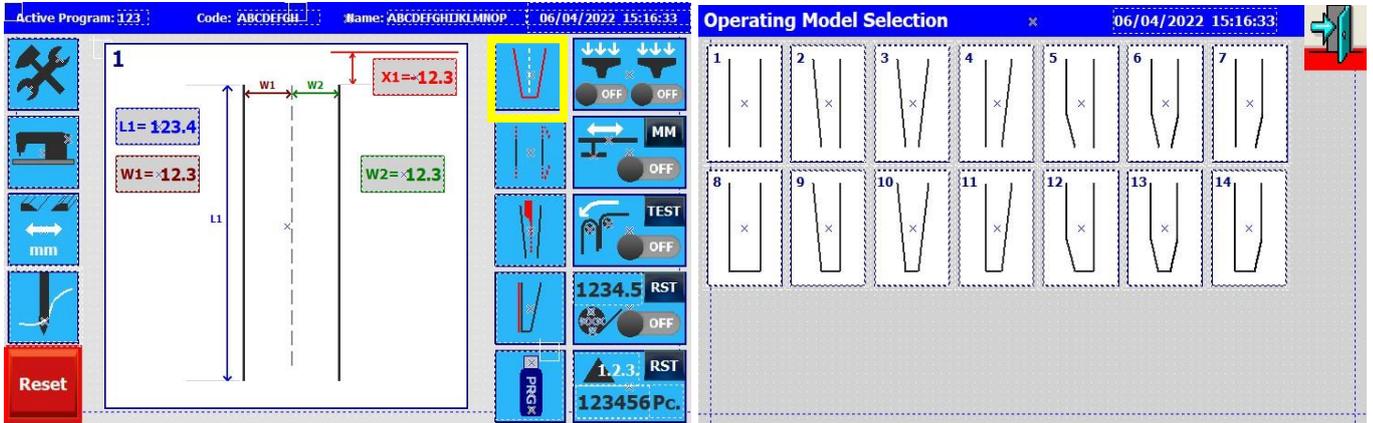
4.5) Check the upper thread



Use the threading button in the red square in order to check the upper and lower thread.

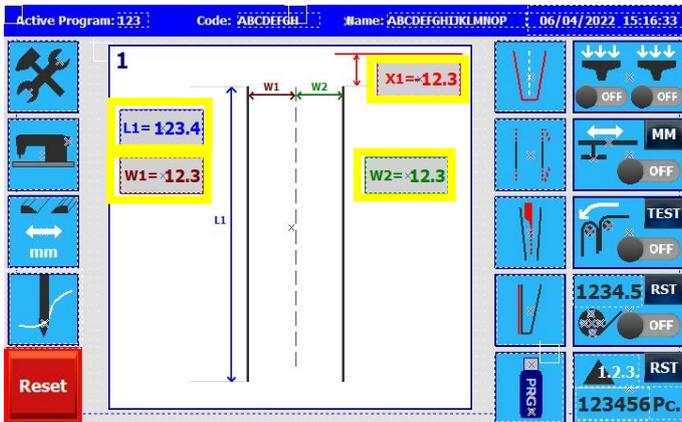
Note! that the machine won't work when this button is pressed. Additionally, when threading is finished and the button is pressed again, the machine will travel to the origin position.

4.6) Select pattern



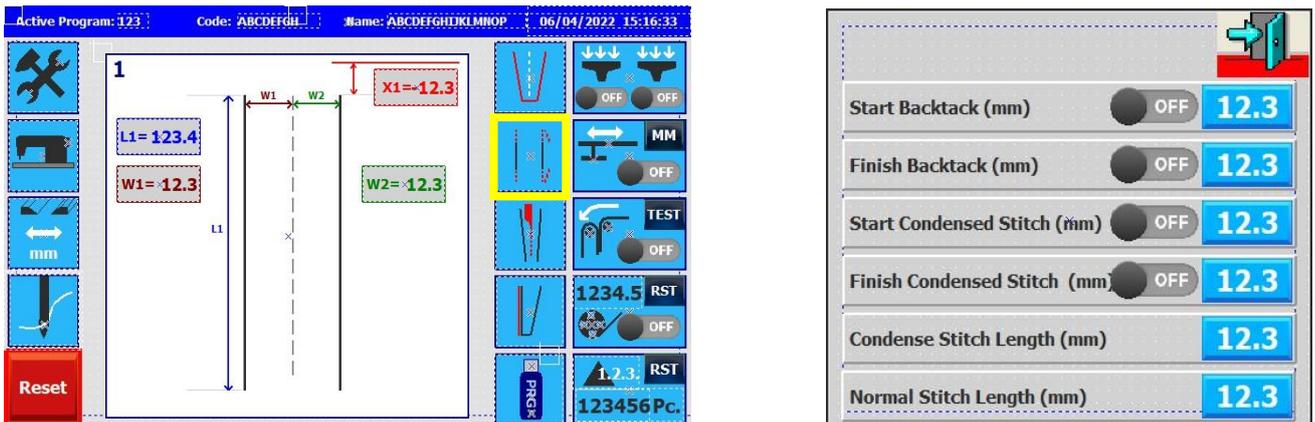
To select pattern, use the pattern selection button stated with yellow square.

4.7) Edit pattern size

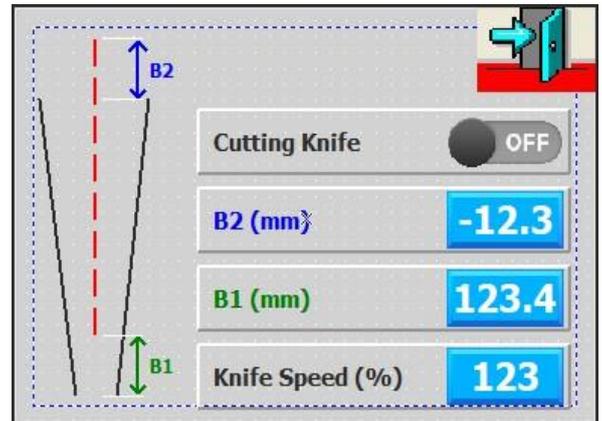
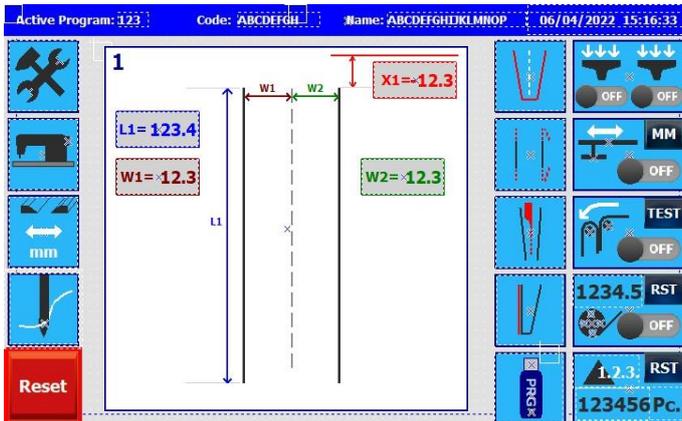


Enter the desired values to "L1", "W1,"W2" and "X1"

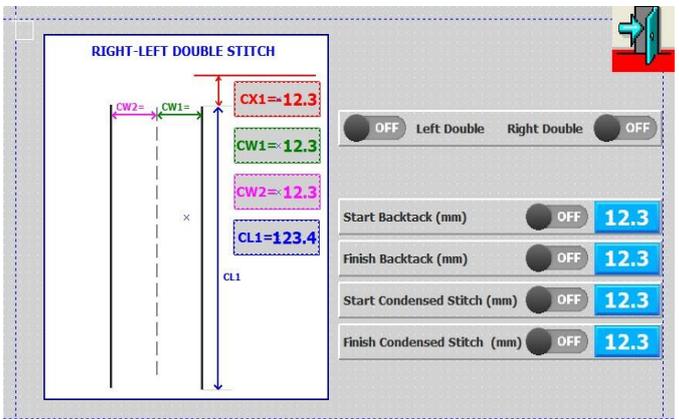
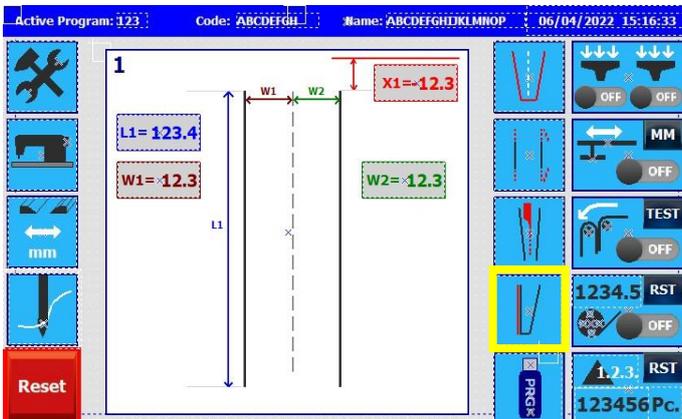
4.8) Edit back tacks, condense stitches, and sewing pitch via the below images.



4.9) Edit cloth cutting knives' parameters.



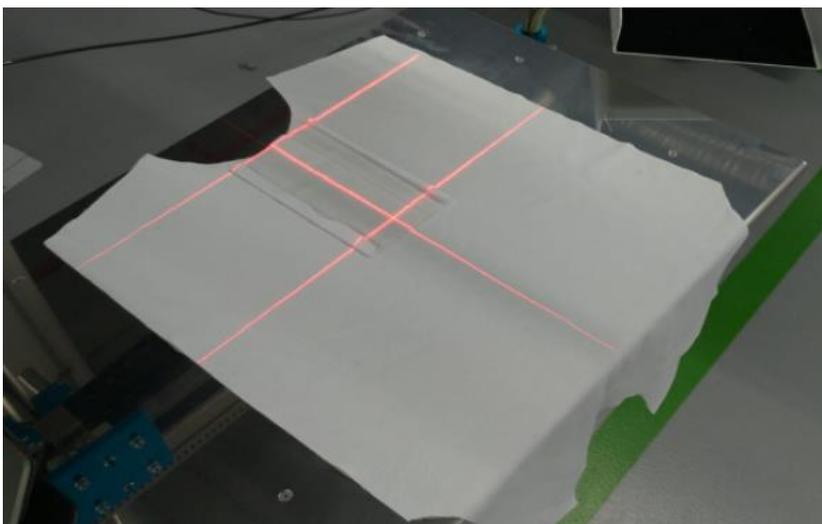
Important Note: If double needle stitching required, adjustments could be done via below images.



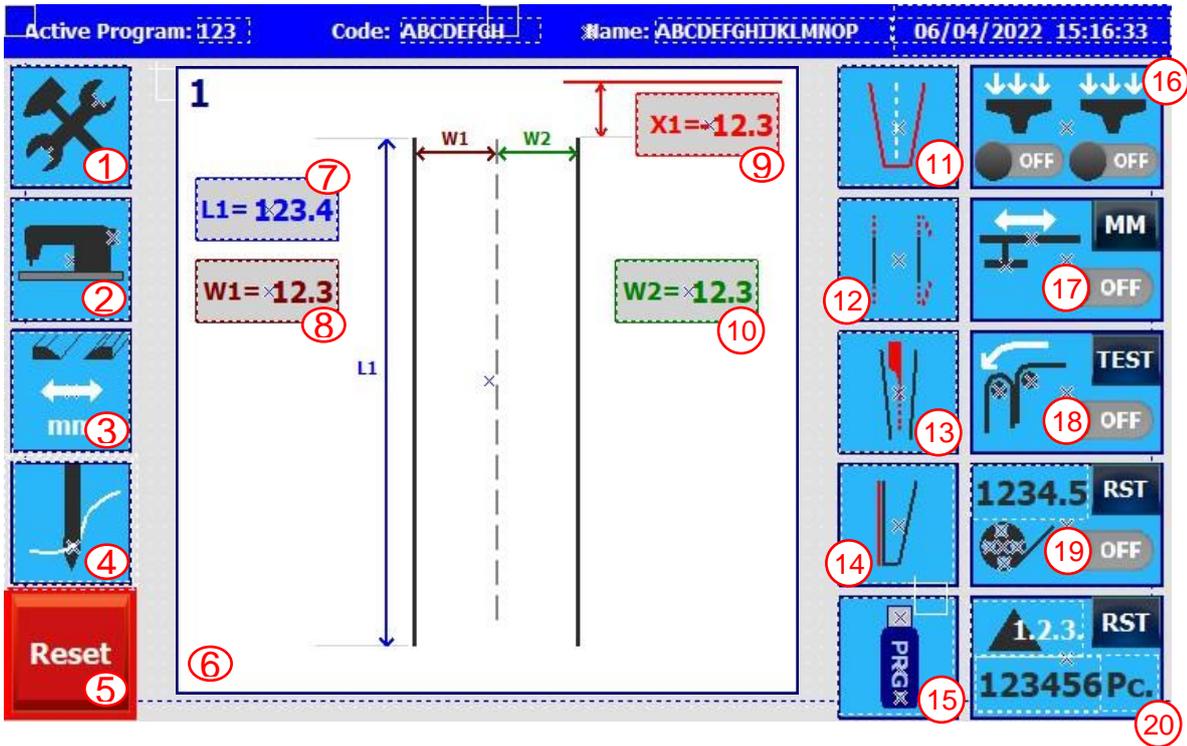
Align fabrics to marking lines as it is seen below and start sewing pressing start pedal.

Note: In case of using machine without carrier vacuum, depressing pedal one time will start sewing.

If carrier vacuum is on, sewing will start after depressing the same pedal two times.



5) PANEL

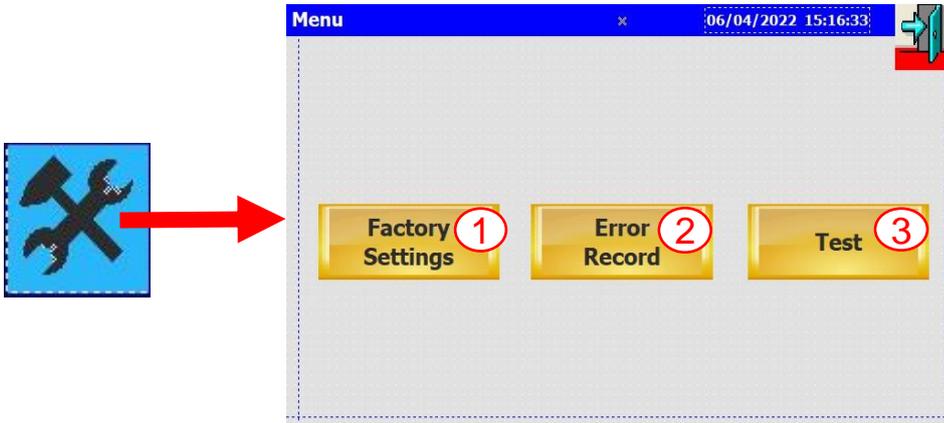


1	MENU	11	SEWING PATTERN SELECTION
2	MACHINE HEAD SETTINGS	12	BACKTRACK - CONDENSE - SEWING PITCH SETTING
3	CLOTH PRESSER SETTINGS	13	CLOTH CUTTING KNIFE SETTINGS
4	THREADING	14	DOUBLE STITCH OPTION SETTINGS
5	RESET BUTTON	15	DATA SAVE - RECALL
6	PATTERN EDITING SECTION	16	CLOTH PRESSER AND CARRIER VACUUM SWITCH BUTTON
7	L1 DIMENSION EDITING	17	CARRIER SWITCH AND SETTINGS
8	W1 DIMENSION EDITING	18	STACKER SWITCH AND TESTING
9	X1 DEMENSION EDITING	19	BOBBIN COUNTER SWITCH AND RESETTING
10	W2 DIMENSION EDITING	20	PIECE COUNTER



Common exit button for all pages.

5.1) Menu



5.1.1) Designer-level settings.

Note: Password is needed to enter.

5.1.2) Error Record(History).



Error history can be seen on this page. To delete the error history long press to "A" button. Administrative password is needed to delete the history.

5.1.3) I/O Test Page.



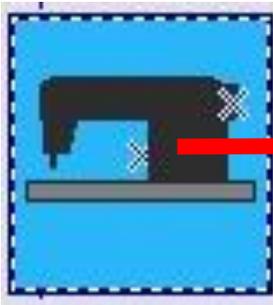
INPUTS

P00: Pulse
 P01: Pulse
 P0A: SDRV1 Error
 P0C: Cloth presser origin sensor
 P0D: Carrier origin sensor
 P0E: Machine head movement origin sensor
 P0F: Cloth cutting knife upper position sensor
 P10: Thread breakage sensor
 P11: Forward pedal
 P12: Backward pedal
 P13: Emergency stop button

OUTPUTS

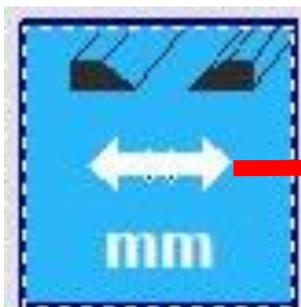
P44: Cloth presser pressure
 P45: Cloth presser opening
 P46: Carrier lowering
 P47: Carrier air blowing
 P48: Table air blowing
 P49: Left vacuum sensor
 P4B: Vacuum bypass
 P4C: Foot lifting
 P4D: Stacker long piston
 P4E: Stacker short piston
 P4F: Stacker holder
 P80: Cloth cutting knife lowering
 P81: Cloth cutting knife guard
 P86: Thread trimming
 P87: Vacuum motor

5.2) Machine head settings



	
Thread Break Alarm	OFF
Condense Stitch Speed (%)	1234
Normal Stitch Speed (%)	1234
Bobbing Thread Length (mt)	1234.5

5.3) Cloth presser settings



Carrier Open(mm)	 OFF	
Carrier Release Distance (mm)	-123.4	
Carrier Dropout delay time (ms)	123	
Carrier Arm Waiting Position (mm)	123.4	

5.4) Threading



Note! If this button is activated, the machine can't operate.

5.5) Reset

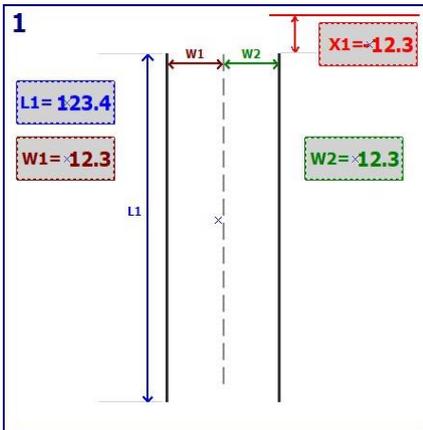


When this this icon is pressed, all motors travel to origin position.

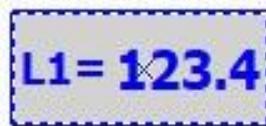
Note! Note that if this icon is blinking, the machine must be reset before any operation.

Otherwise the machine won't operate.

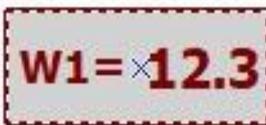
5.6) Pattern editing section



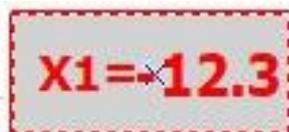
5.7) L1 dimension editing (Adjustment of placket length)



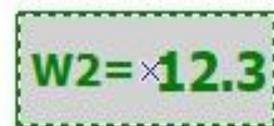
5.8) W1 dimension editing (Adjusting the sewing position of left stitches from center of placket)



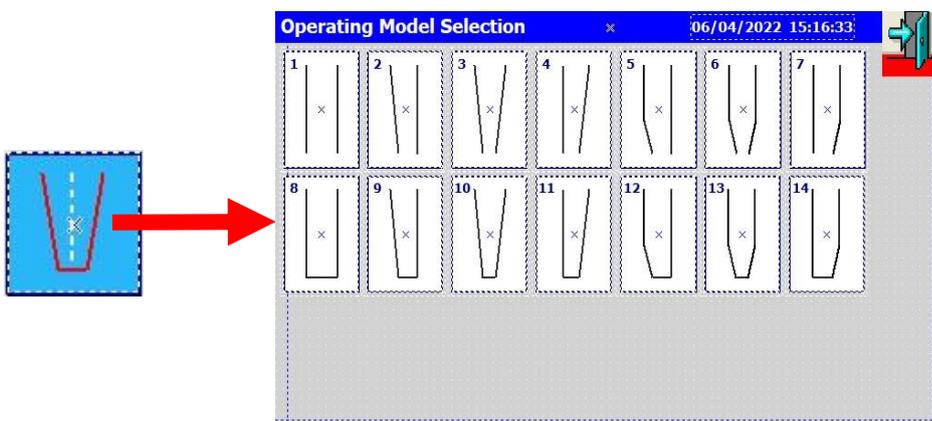
5.9) X1 dimension editing (Stitch start position)



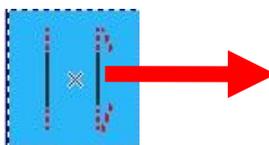
5.10) W2 dimension editing (Adjusting the sewing position of right stitches from center of placket)

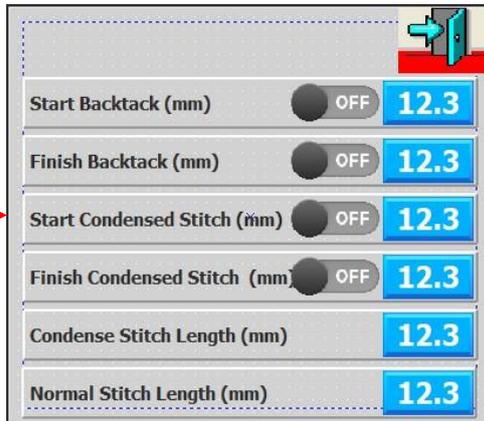


5.11) Sewing Pattern Selection



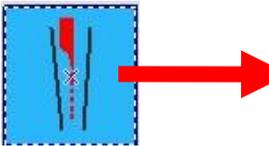
5.12) Backtrack - Condense - Sewing pitch settings

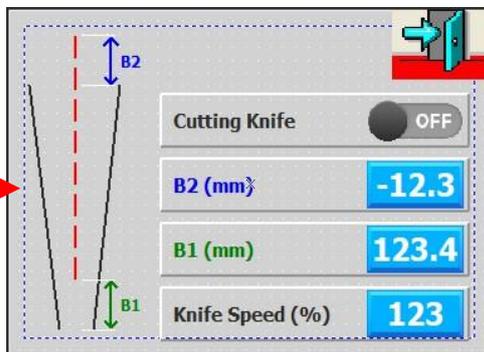




Start Backtack (mm)	<input type="radio"/> OFF	12.3
Finish Backtack (mm)	<input type="radio"/> OFF	12.3
Start Condensed Stitch (mm)	<input type="radio"/> OFF	12.3
Finish Condensed Stitch (mm)	<input type="radio"/> OFF	12.3
Condense Stitch Length (mm)		12.3
Normal Stitch Length (mm)		12.3

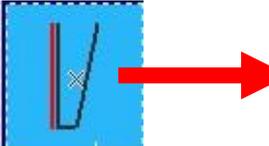
5.13) Cloth cutting knife settings

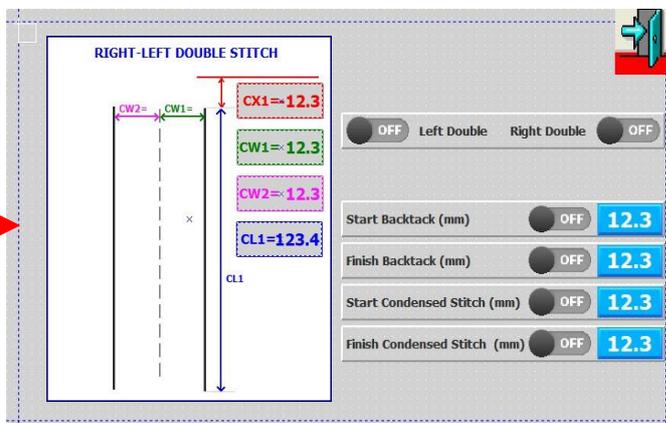




Cutting Knife	<input type="radio"/> OFF	
B2 (mm)		-12.3
B1 (mm)		123.4
Knife Speed (%)		123

5.14) Double stitch option settings





RIGHT-LEFT DOUBLE STITCH

CX1=12.3
CW1=12.3
CW2=12.3
CL1=123.4

OFF Left Double Right Double OFF

Start Backtack (mm)	<input type="radio"/> OFF	12.3
Finish Backtack (mm)	<input type="radio"/> OFF	12.3
Start Condensed Stitch (mm)	<input type="radio"/> OFF	12.3
Finish Condensed Stitch (mm)	<input type="radio"/> OFF	12.3

*Please refer 5.6 ~ 5.12.

5.15) Data Save - Recall



No	Product Code	Product Name	Saving Time	Select
123	ABCDEFGH	ABCDEFGHJKLMNOP	**/**/1234 ** : 12	Select
123	ABCDEFGH	ABCDEFGHJKLMNOP	**/**/1234 ** : 12	Select
123	ABCDEFGH	ABCDEFGHJKLMNOP	**/**/1234 ** : 12	Select
123	ABCDEFGH	ABCDEFGHJKLMNOP	**/**/1234 ** : 12	Select
123	ABCDEFGH	ABCDEFGHJKLMNOP	**/**/1234 ** : 12	Select
123	ABCDEFGH	ABCDEFGHJKLMNOP	**/**/1234 ** : 12	Select
123	ABCDEFGH	ABCDEFGHJKLMNOP	**/**/1234 ** : 12	Select
123	ABCDEFGH	ABCDEFGHJKLMNOP	**/**/1234 ** : 12	Select
123	ABCDEFGH	ABCDEFGHJKLMNOP	**/**/1234 ** : 12	Select

Active Program: 123 Product Code: ABCDEFGH Product Name: ABCDEFGHJKLMNOP

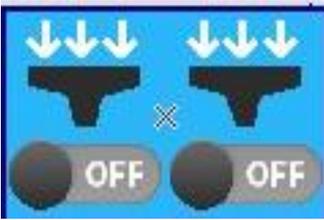


If you want to save the settings from memory to USB.



If you want to save the settings from USB to memory.

5.16) Cloth presser and Carrier vacuum switch button



5.17) Carrier switch and settings



5.18) Stacker switch and testing.



5.19) Bobbin counter switch and resetting

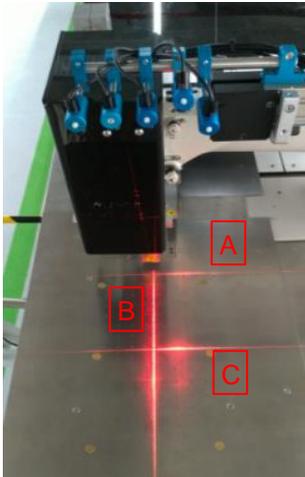


5.20) Piece counter switch and resetting



6) ADJUSTMENT

6.1) Positioning Lasers

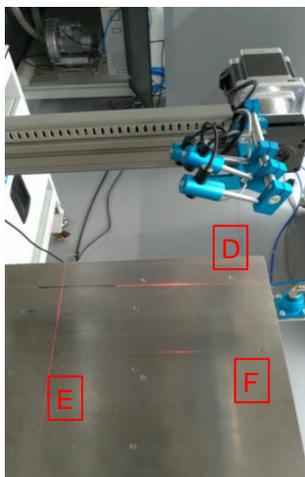


Left laser

A is adjusted according to needle. The distance between laser and needle is 165mm.

B is aligned with center of the needle.

Distance between A and C is adjusted according to the seam length.



Right laser

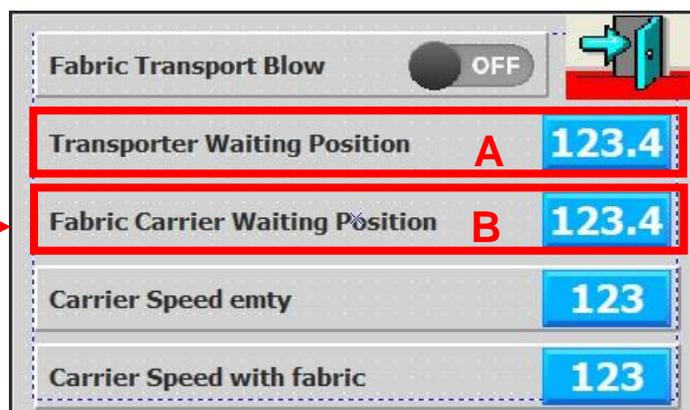
Right laser positions are aligned to left.

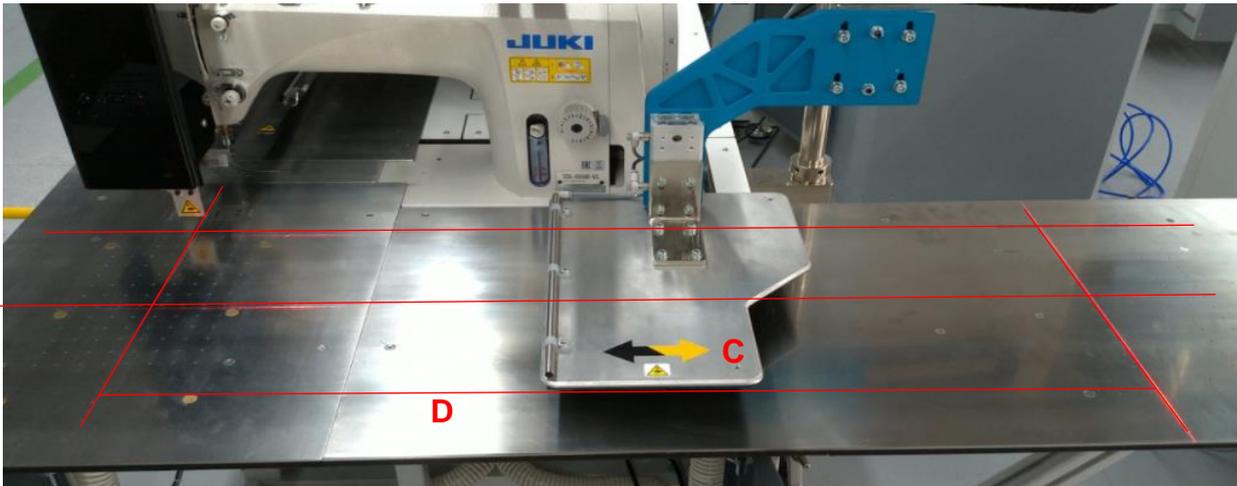
"D" line aligns with "A" line.

"E" is the marker line for fabric setting. It corresponds to line "B" after transport.

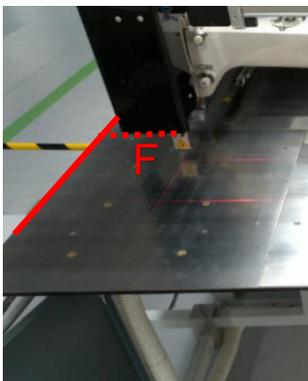
"F" line aligns with "C" line.

6.2) Carrier positioning.



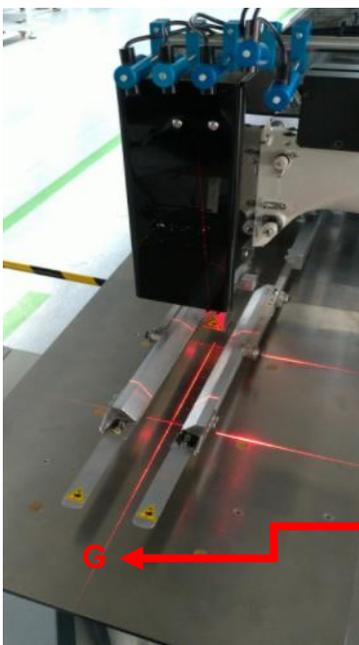


Waiting position of the carrier(C) is adjusted by panel A button.
 D dimension is the moving range of the carrier. D is adjusted by panel B button.



Note! Needles origin position (F) is 195 mm from left edge of the metal table.

6.3) Cloth presser



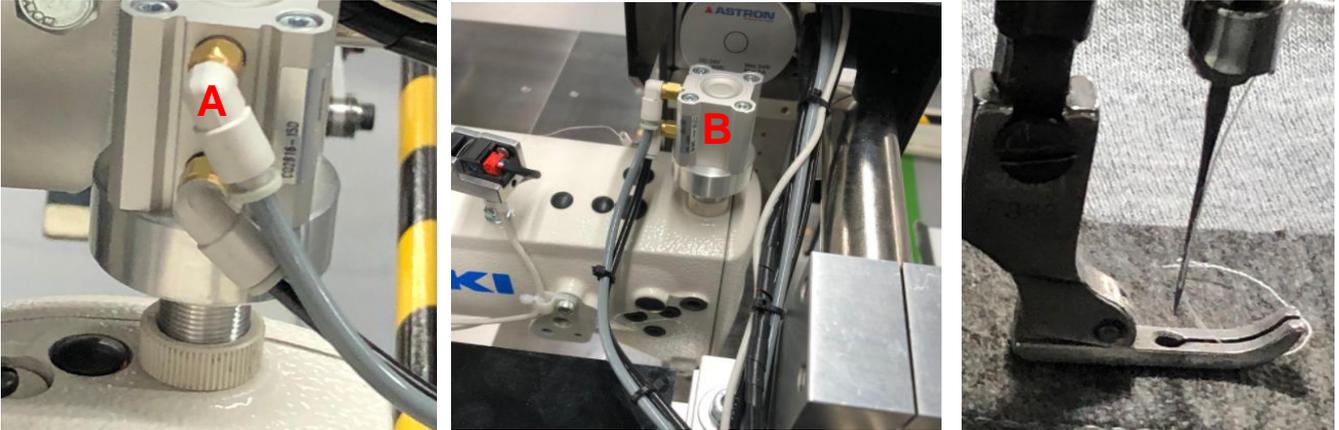
G is the front position (mm) -120.0

H is the rear position (mm) 120

Adjustments are done by the lower panel.



6.3) The mechanical presser foot high adjustment;



Switch of the compressed air in the machine

Put out the air tubes "A" air cylinder

List up or down the presser foot via rotating the lifting air cylinder "B".

7) LISTING OF ERROR CODES

7.1) Where emergency button has pressed, machine stops immediately.

7.2) Indicates that the thread breakage has occurred.

When the thread breakage occurs the red light becomes on. When the light is green, it means the machine is ready for sewing.

Note : Turn off the power when threading.

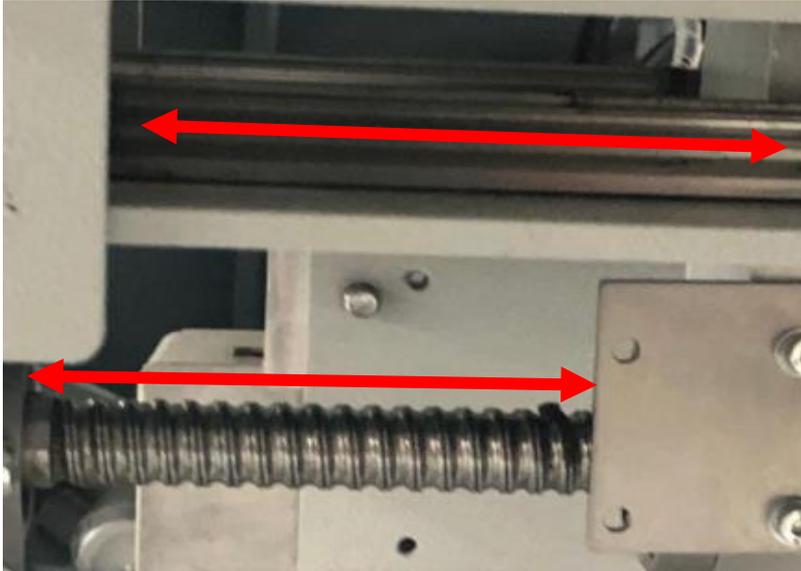
7.3) If the fabric drops this warning pops-out.

7.4) The machine has to cool down for 20-25 seconds after switching it off. Please mind this information if the machine has to stop and run because of some circumstance/incident.

If the user switches on again without waiting, the motor error warning could pop-out.

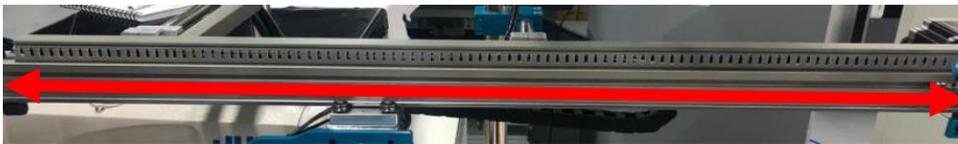
In order to get rid of this problem, the machine has to be switched off and restarted.

8) MAINTENANCE



The head transport rail should be greased every 6 months.

The head transport shaft should be greased every 6 months.



The fabric carrier should be greased every six months.

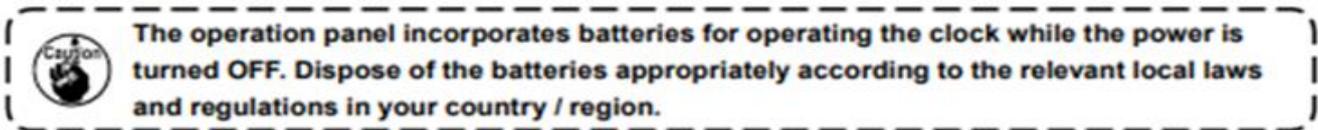


The knife shaft rail should be greased every 6 months.

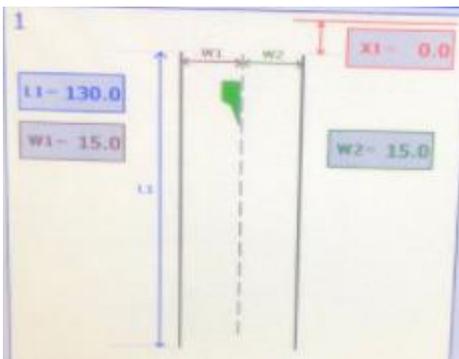


Open the cover of the air filters cover and take out the felts. Air filter can be cleaned with the compressed air gun.

9) DISPOSAL OF BATTARIES



10) LIST OF PATTERN DATA (SHIPPING VALUES)



11) CAUSES AND COUNTERMEASURES

Q1) The stitching does not match with the laser marks!

A1) Laser adjustment should be checked. [refer to 6.1) Positioning Lasers

Q2) Continuous thread breakage error.

A2) Check threading again from the head and also from the panel 5.4

Q3) Bobbin finishes so fast.

A3) Please change the finished bobbin with the unused bobbin and reset the bobbin counter.

Q4) The fabric gets stuck under the presser foot.

The fabric gets loose under the presser foot.

A4) Adjust the presser foot according to fabric from the section 6.3



Company Name	:	JUKI SINGAPORE PTE LTD.
ADD	:	20 BENDEMEER ROAD,#04-12 BS BENDEMEER CENTRE SINGAPRE 339914
PHONE	:	(65) 6553-4388
HTTP	:	http://www.juki.com.sg
E-Mail	:	we.sgp-sales@ml.juki.com
Company Name	:	JUKI Machinery Vietnam Company Ltd
ADD	:	153 HOA LAN STR.,WARD 2, PHU NHUAN DIST., HO CHI MINH CITY, VIETNAM
PHONE	:	(84) 28-35178833
FAX	:	(84) 28-35178318
E-Mail	:	sales@jukimv.com
Company Name	:	JUKI Machinery Bangladesh Ltd
ADD	:	NATORE TOWER(5TH FLOOR) PLOT#32-D & 32-E, ROAD#2, SECOR#03 ,UTTARA MODEL TOWN, DHAKA, BANGLADESH
PHONE	:	(880)2-48954731
FAX	:	(880)2-48954733
E-Mail	:	vl.mbl-info@ml.juki.com
Company Name	:	JUKI India Private Limited
ADD	:	GAOUND AND 1ST FLOOR, NO.1090/I, 18TH CROSS ROAD,3RD SECTOR, HSR LAYOUT BANGALORE-560 102, KARNATAKA STATE, INDIA
PHONE	:	(91)80-4251-1900
FAX	:	(91)80-4251-1999
HTTP	:	http://jukiindia.com
E-Mail	:	jukiblr@jukiindia.com
Company Name	:	JUKI CENTRAL EUROPE
ADD	:	UL. POLE CZKI 21(PLATAN PARK C) 02-822 WARSAW , POLAND
PHONE	:	(48)22-545-0400
FAX	:	(48)22-545-0411
HTTP	:	http://jukieurope.com
Company Name	:	JUKI America INC
ADD	:	8500 NW 17TH STREET, SUITE 100, DORAL, FL 33126-1035, U.S.A.
PHONE	:	(1)305-594-0059
HTTP	:	https://juki.com
Company Name	:	JUKI MIDDLE EAST (JUKI SINGAPORE PTE. LTD. UAE BRANCH)
ADD	:	OFFICE NO, 2511. BLOCK A JAFZA 1, PO BOX 18031, JEBEL ALI, DUBAI UAE
PHONE	:	(971)4-8833228
FAX	:	(971)4-8833230
HTTP	:	http://www.juki.com.sg
Company Name	:	JUKI (China) CO LTD.
ADD	:	ROOM 901-903, HAILIANG BUILDING, NO.22, LANE 118 ZHONGJIANG ROAD, PUTUO DISTRICT SHANGHAI, CHINA, 200062
PHONE	:	8621-6236-8888
HTTP	:	http://www.jukichina.com



JUKI CORPORATION

SEWING MACHINERY & SYSTEMS BUSINESS UNIT

2-11-1, Tsurumaki, Tama-shi, Tokyo 206-8551, Japan

Phone: (81) 42-357-2211

