

**Waistband Shadow Stitch Sewing Unit**

**JTR-DLN9010 / WSU Series**

# **INSTRUCTION MANUAL**



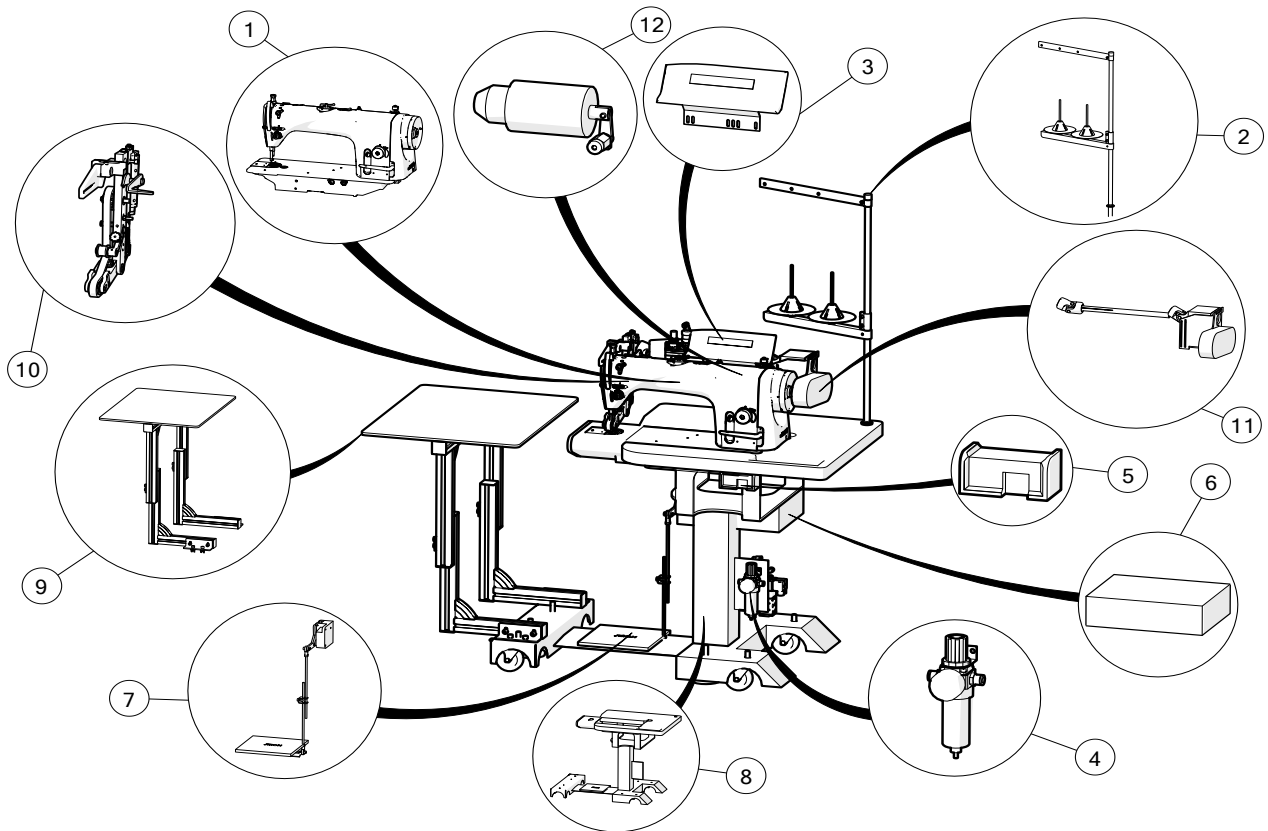
**No.JTR000**

**DLN9010WSU-TM**

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## 1) CONFIGURATION OF THE MACHINE



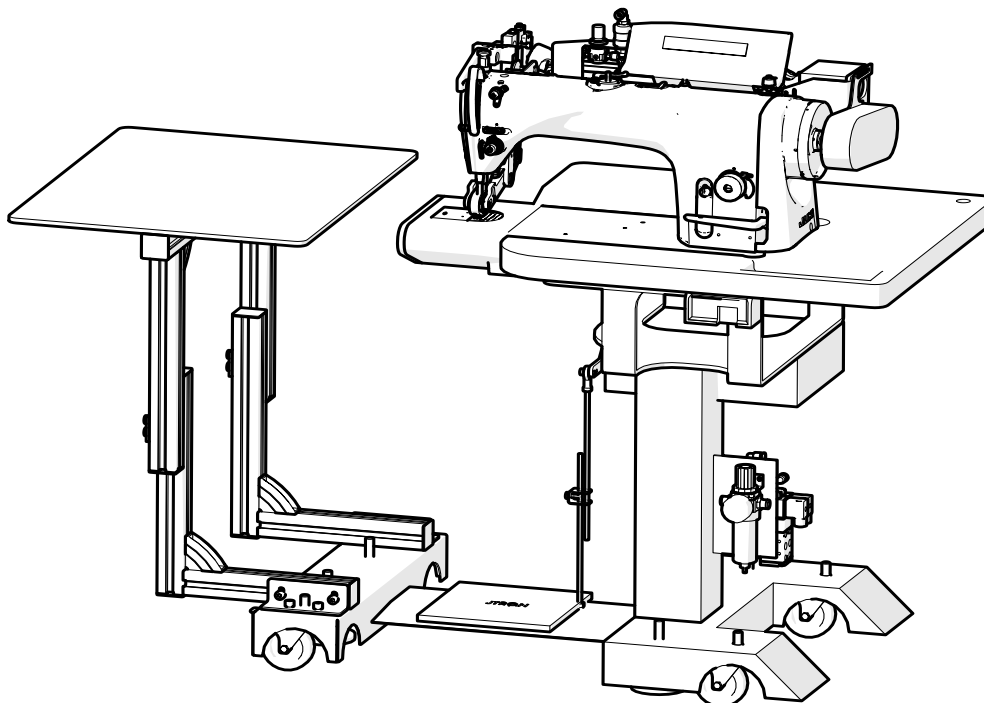
|   |               |    |                            |
|---|---------------|----|----------------------------|
| 1 | MACHINE HEAD  | 7  | PEDAL                      |
| 2 | THREAD STAND  | 8  | CHASSIS GROUP              |
| 3 | PANEL         | 9  | STACKING GROUP             |
| 4 | AIR REGULATOR | 10 | PULLER GROUP               |
| 5 | MAIN SWITCH   | 11 | TRANSMISSION BOX           |
| 6 | CONTROL BOX   | 12 | PRESSER FOOT LIFTING GROUP |

## 2) SPECIFICATION

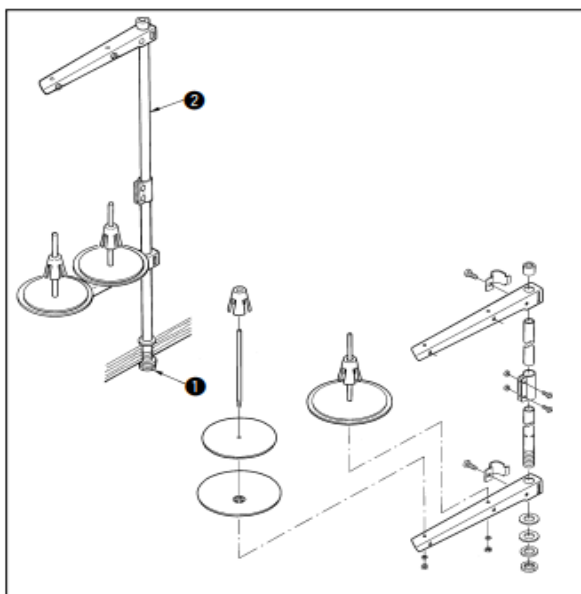
| No. | Category               | Description                                 |
|-----|------------------------|---------------------------------------------|
| 1   | MACHINE HEAD           | DLN9010A-SH                                 |
| 2   | MODEL NAME             | JTR-DLN9010/WSU                             |
| 3   | MAIN MOTOR             | Juki IPM MOTOR                              |
| 4   | MAIN MOTOR DRIVE       | Juki SC-920                                 |
| 5   | MAXIMUM SEWING SPEED   | 4000sti/min - delivery speed: 4000sti/min   |
| 6   | STITCH LENGTH          | 1.5mm - 4mm / delivery stitch length: 2.5mm |
| 7   | NEEDLE TYPE            | GB / DPX5 #17                               |
| 8   | GAUGE                  | Jtron original presser foot                 |
| 9   | SEWING SPECIFICATIONS  | THIN TO MEDIUM THICKNESS                    |
| 10  | TARGET PROCESS         | WAISTBAND SHADOW STITCH                     |
| 11  | FABRIC CUTTING SYSTEM  | Original Juki cutting system                |
| 12  | AIR PRESSURE           | Min: 0.6 MPa Max: 0.8 MPa Delivery: 0.6 MPa |
| 13  | AIR CONSUMPTION        | 2 L / min                                   |
| 14  | VOLTAGE CLASSIFICATION | Single-phase 200-240V/50Hz                  |
| 15  | CAPACITY               | 2000 - 2500 pcs / 9 hours                   |
| 16  | BOBBIN & TRIM COUNTER  | Available                                   |
| 17  | POWER CONSUMPTION      | 310VA                                       |

### 3) INSTALLATION

#### 3.1) The machine is delivered as below



#### 3.2) Installing the thread stand.



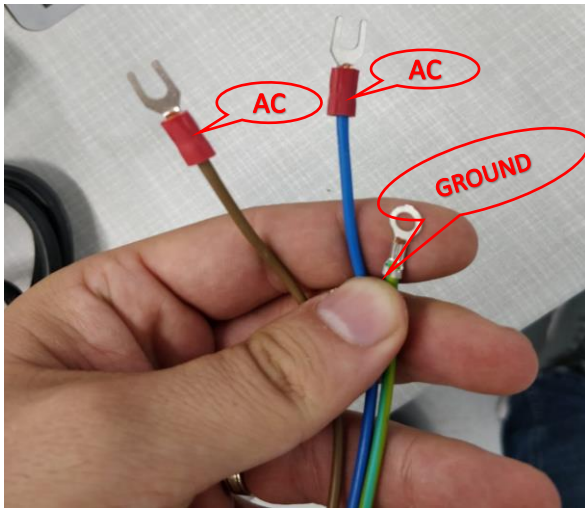
- 1) 糸立装置を図のように組み付け、テーブルの穴に取り付けてください。
- 2) 糸立装置が動かない程度に、止めナット ❶ を締めてください。
- 3) 天井配線を行う場合は、電源コードを糸立棒 ❷ の中に通してください。

- 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.

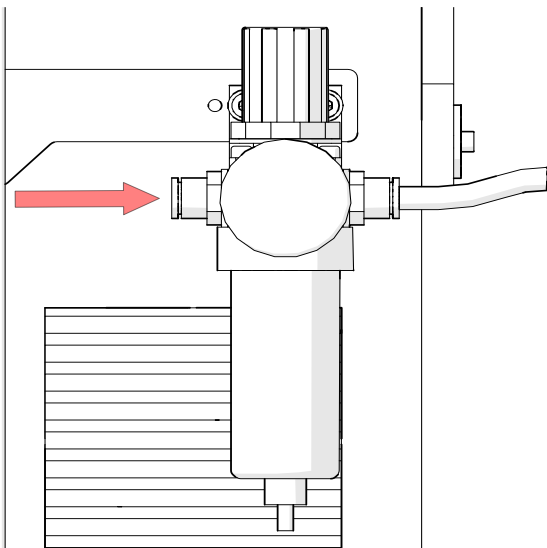
- 1) Assembler le porte-bobines et l'introduire dans l'orifice de la table de la machine.
- 2) Serrer le contre-écrou ❶ pour fixer le porte-bobines.
- 3) Dans le cas où la machine est alimentée depuis le plafond, faire passer le câble d'alimentation à travers la tige du porte-bobines ❷.

### 3.3) 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.

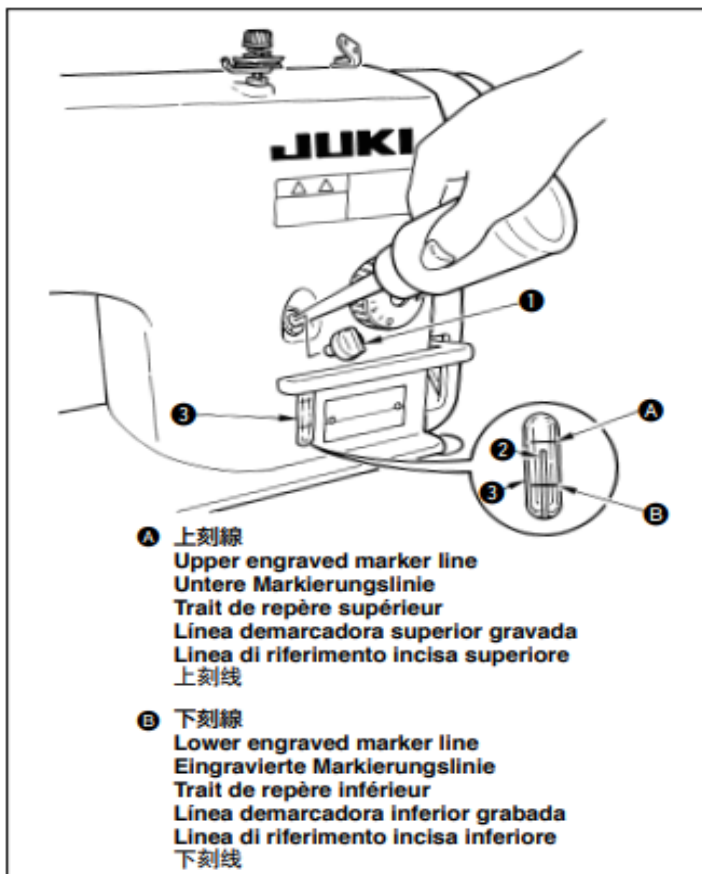
### 3.4) Connect the air tube to the air regulator.



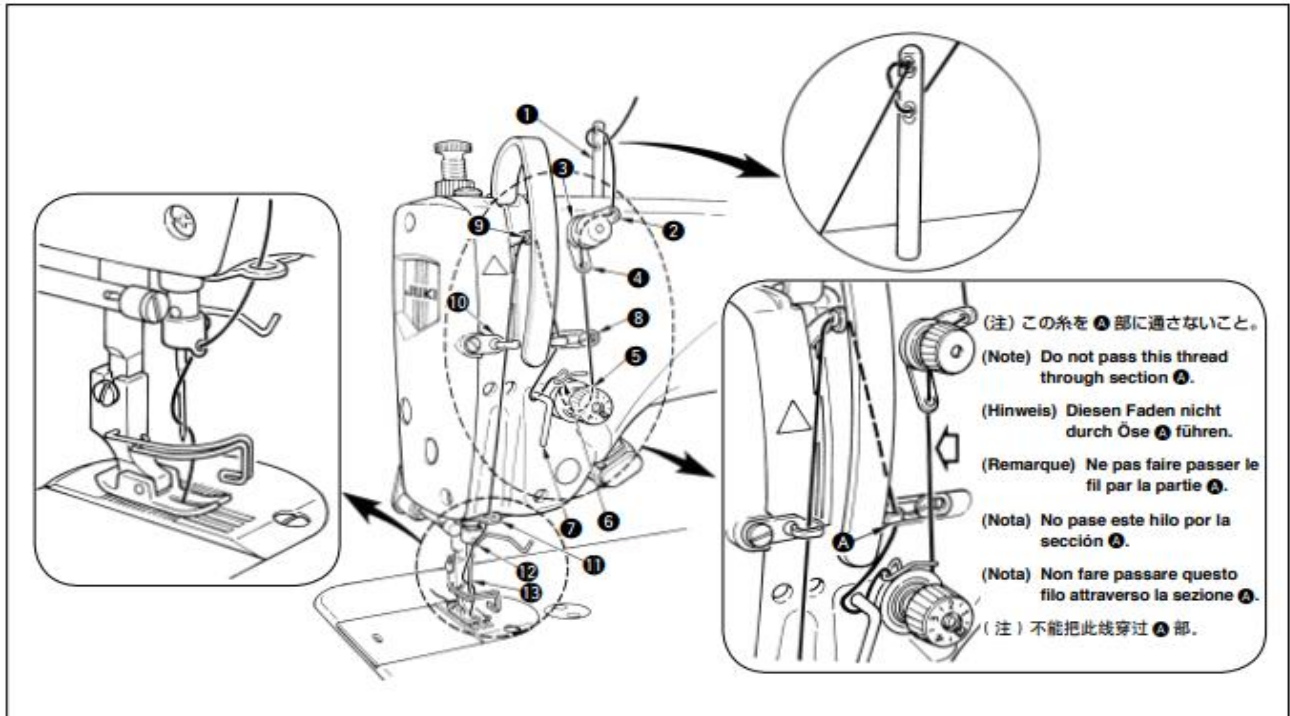
#### 4) PREPARATION FOR OPERATION

Note : For the operation method of the JUKI DLN-9010, refer to the instruction manual of the JUKI DLN-9010 series.

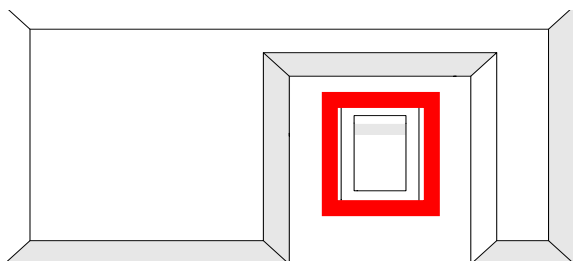
**4.1) Please put the JUKI original oil.**  
**(Please refer to machine head instructions DLN9010 Series)**



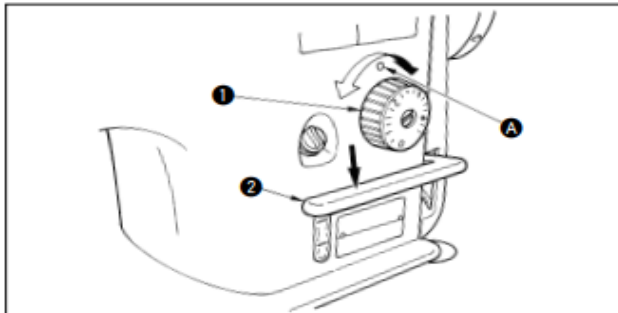
#### 4.2) Threading the machine. (Please refer to machine head instructions – DLN9010 Series)



#### 4.3) Switch on the machine.



#### 4.4) Adjusting the stitch length.



- 1) 送り調節ダイヤル ① を矢印の方向に回して、希望する数字をアームの刻点 A に合わせます。
- 2) 目盛の数字は mm で示してあります。
- 3) 送り目盛を大から小に変更する時は、送りレバー ② を矢印の方向に押しながら送り調節ダイヤル ① を回してください。

- 1) Turn stitch length dial ① in the direction of the arrow, and align the desired number to marker dot A on the machine arm.
- 2) The dial calibration is in millimeters.
- 3) When you want to decrease the stitch length, turn stitch length dial ① while pressing feed lever ② in the direction of the arrow.

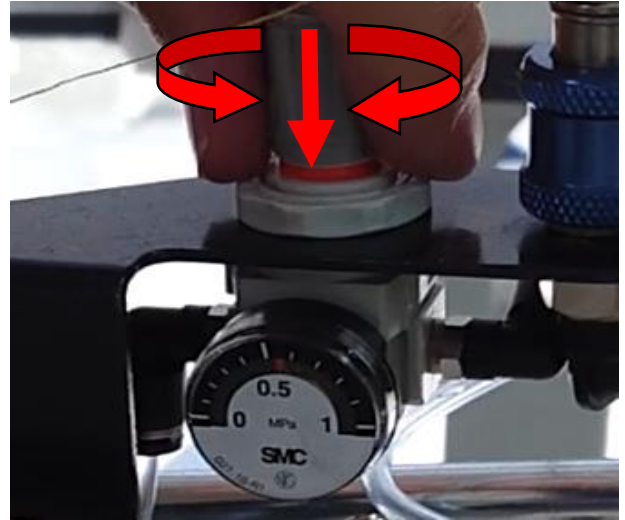
#### 4.5) Puller adjustment according to stitch length.



#### 4.6) How to adjust pressure of the presser foot by the piston.



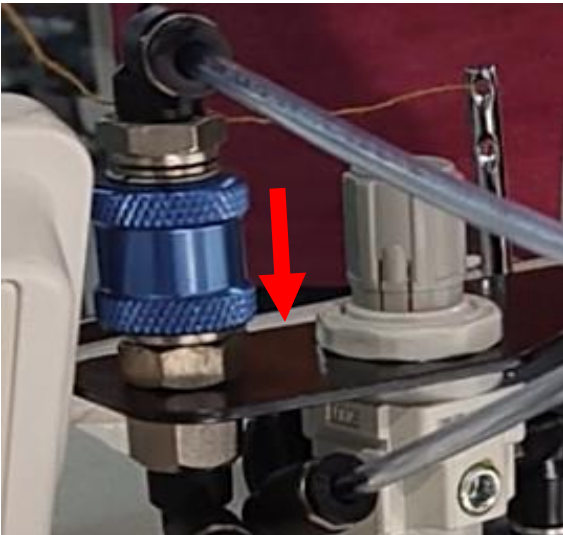
Lift up to make adjustments.



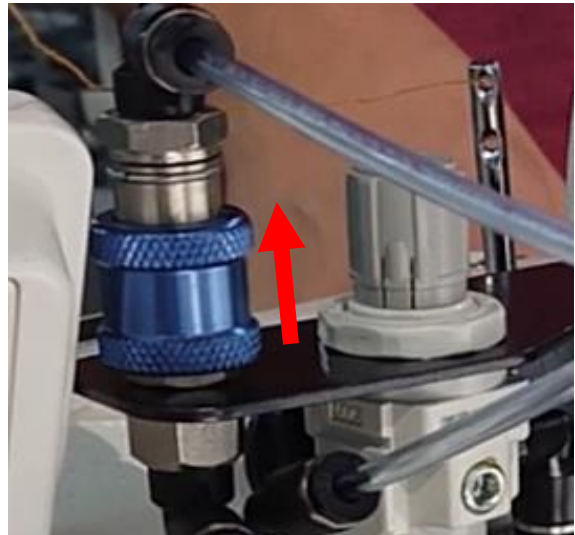
Adjust the pressure by turning the valve to the right or left.

Then lift down.

#### 4.7) Adjustment of puller and foot pressing simultaneously or individually.



The presser foot and puller move together in the down position.



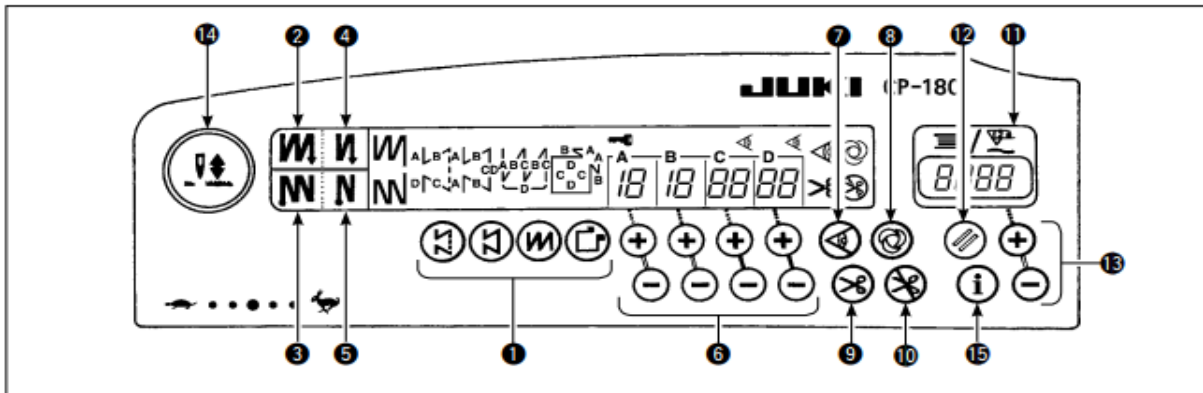
The presser foot moves alone in the up position.

4.8) How to adjust tension of puller by the spring.



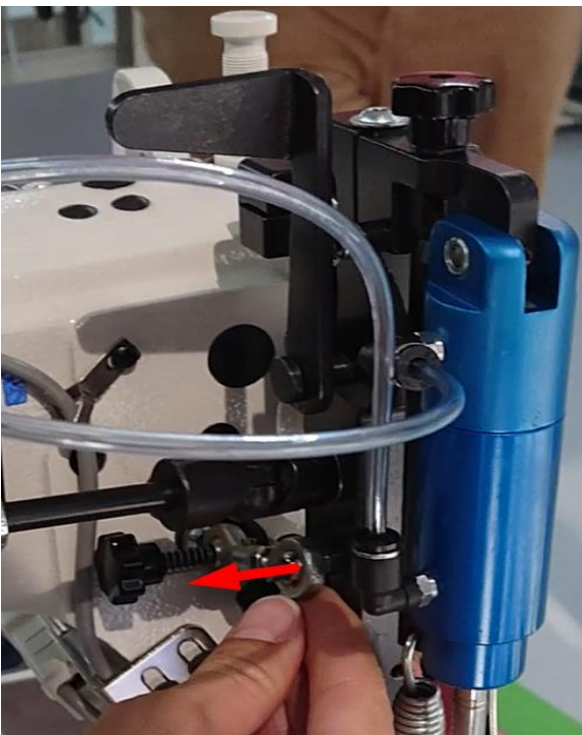
## 5) PANEL

Please refer to panel instructions (CP-180 Instruction Manual).

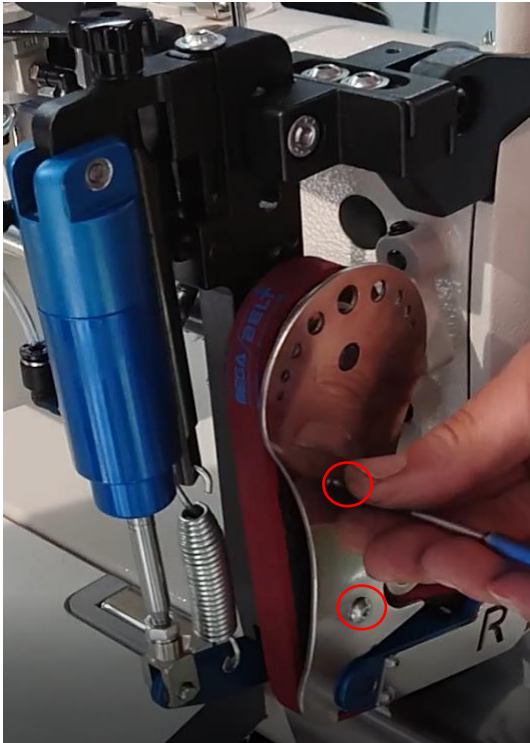


## 6) ADJUSTMENT

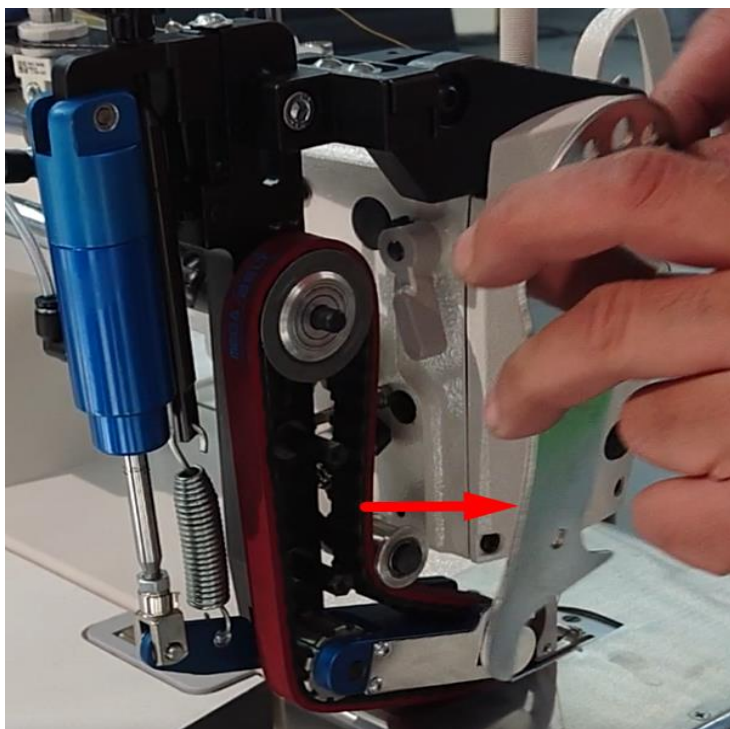
### 6.1) Change the puller belt.



Remove the rod eye.



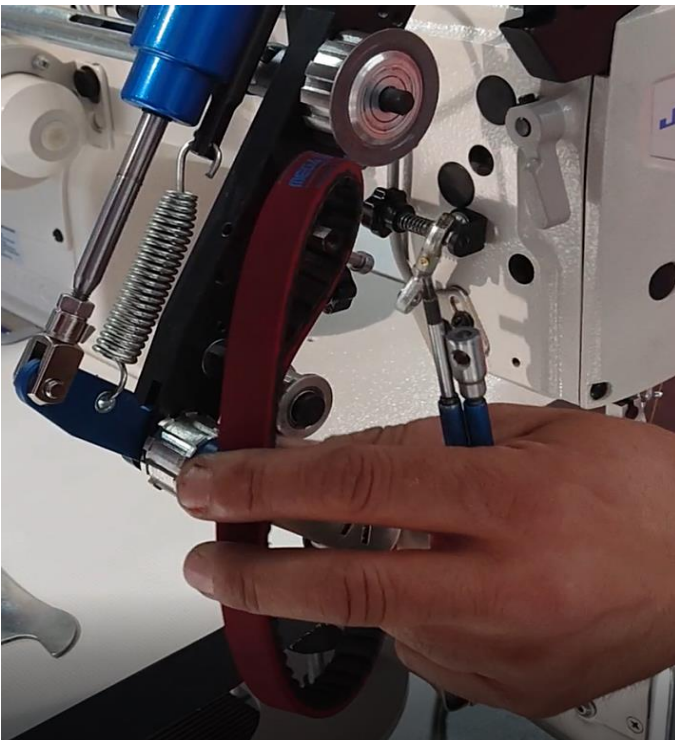
Remove the screws.



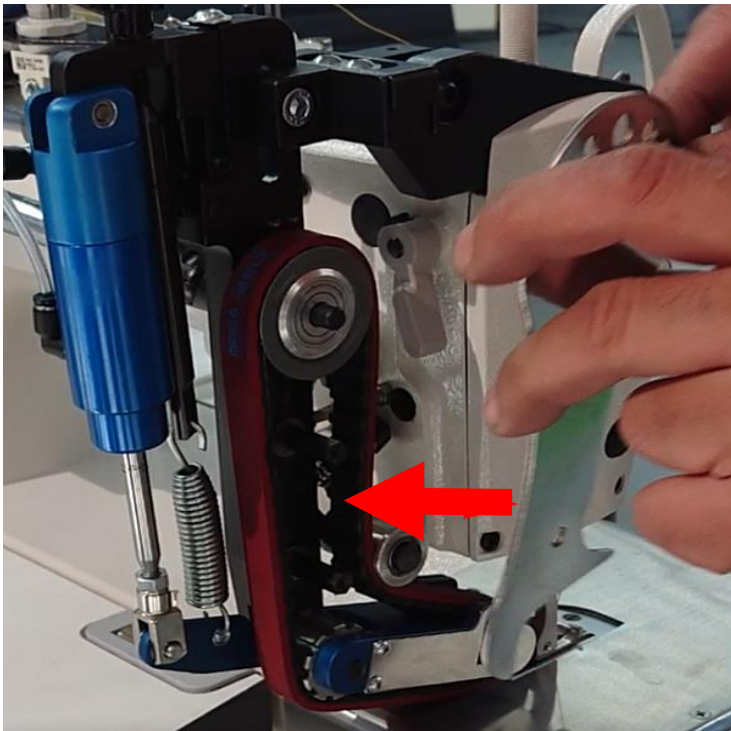
Remove the cover plate.



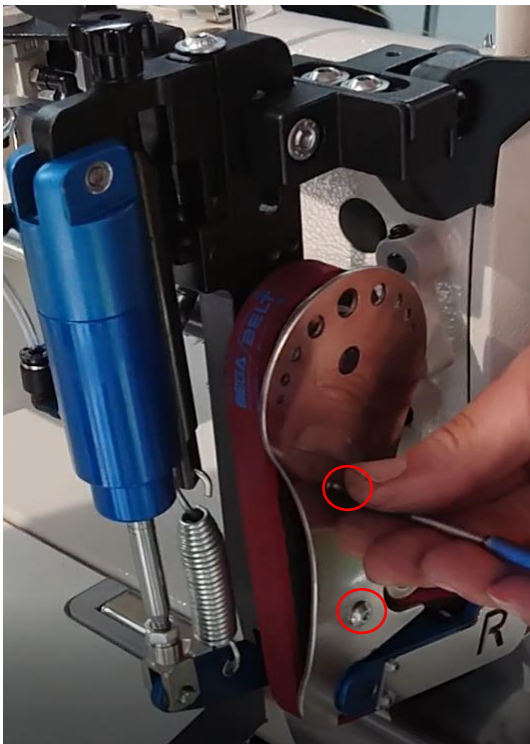
Remove the belt.



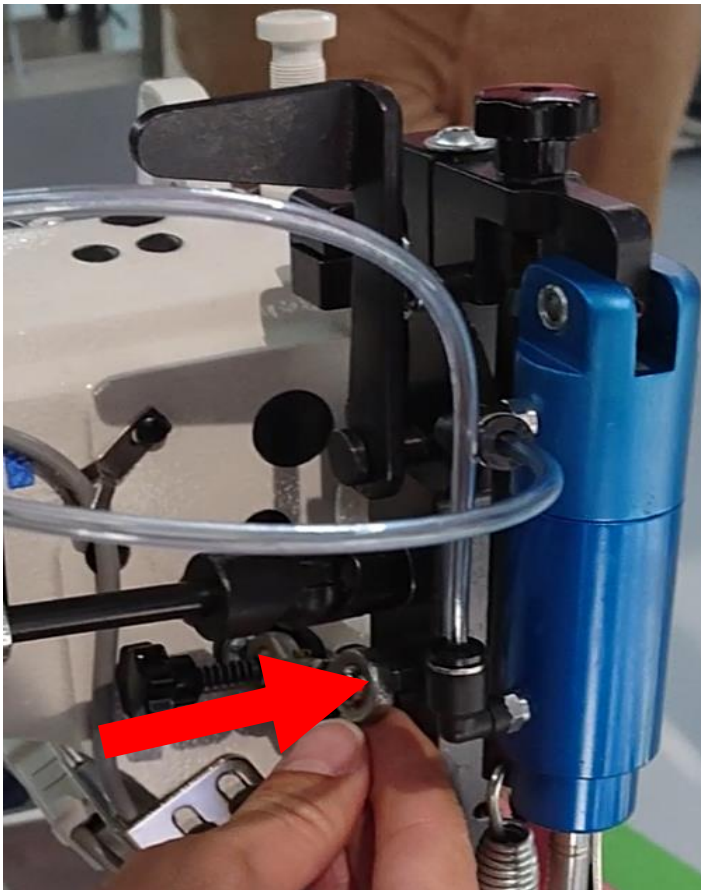
Install the new belt.



Install the cover plate.



Install the screws.



Install the rod eye.

## 7) CAUSES AND COUNTERMEASURES

**Q.1)** Needle breakage.

**A1)** Check thread, thread path, thread tension, needle and needle heat.



|                     |   |                                                                                                                   |
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