

**Shirt Bottom Hemming Sewing Unit**

**JTR-DLU5490/SHU Series**

# **INSTRUCTION MANUAL**



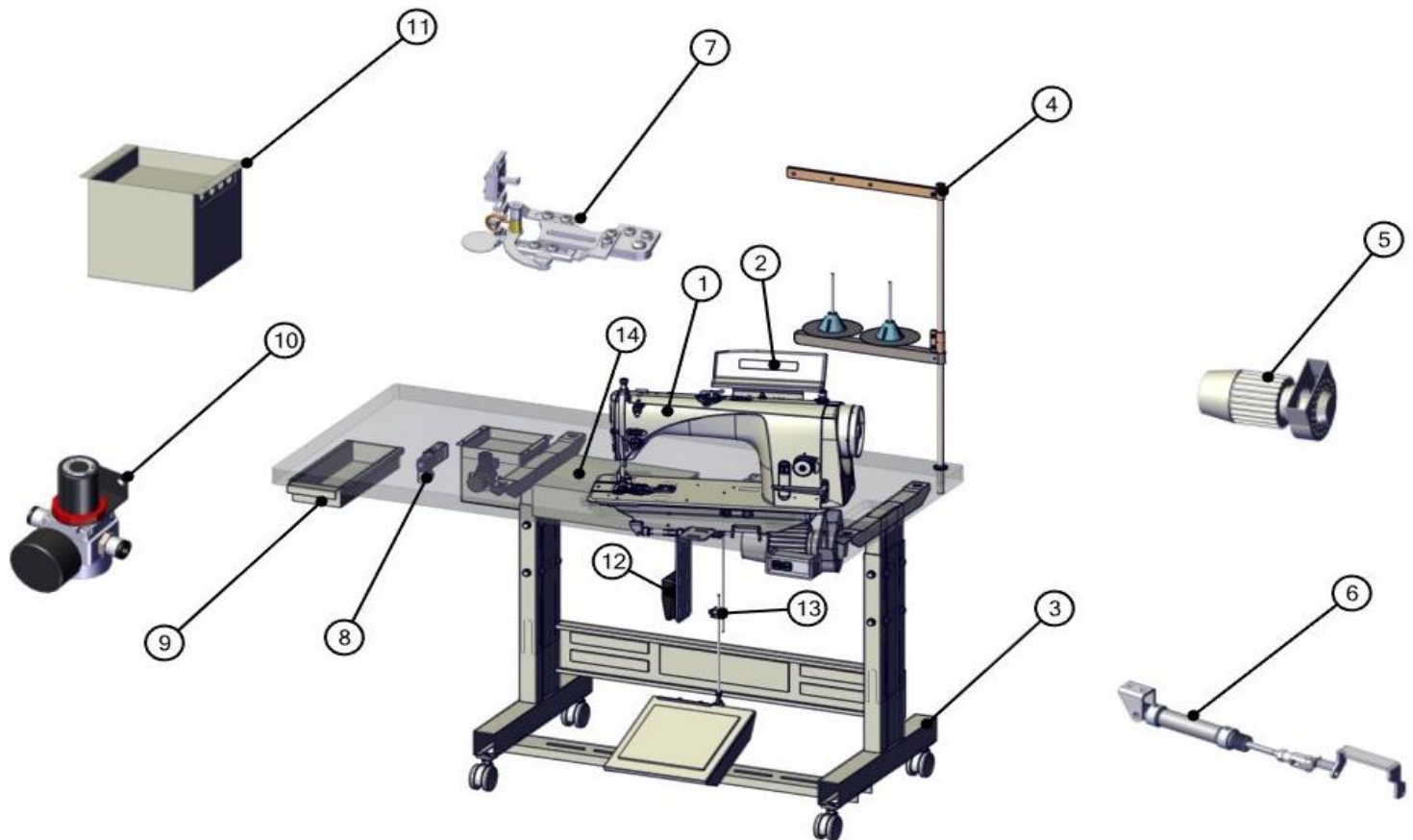
**No.JTR000**

**DLU5490SHU-TM**

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## 1) CONFIGURATION OF THE MACHINE



|   |                   |    |                    |
|---|-------------------|----|--------------------|
| 1 | MACHINE HEAD      | 8  | AIR VALVE          |
| 2 | CP180 PANEL       | 9  | DRAWER             |
| 3 | CHASSIS GROUP     | 10 | AIR REGULATOR      |
| 4 | THREAD STAND      | 11 | CONTROL BOX(P1022) |
| 5 | MOTOR             | 12 | KNEE SWITCH        |
| 6 | UPPER FEED SYSTEM | 13 | PEDAL              |
| 7 | ATTACHMENT        | 14 | JUKI CONTROL BOX   |

## 2) SPECIFICATION

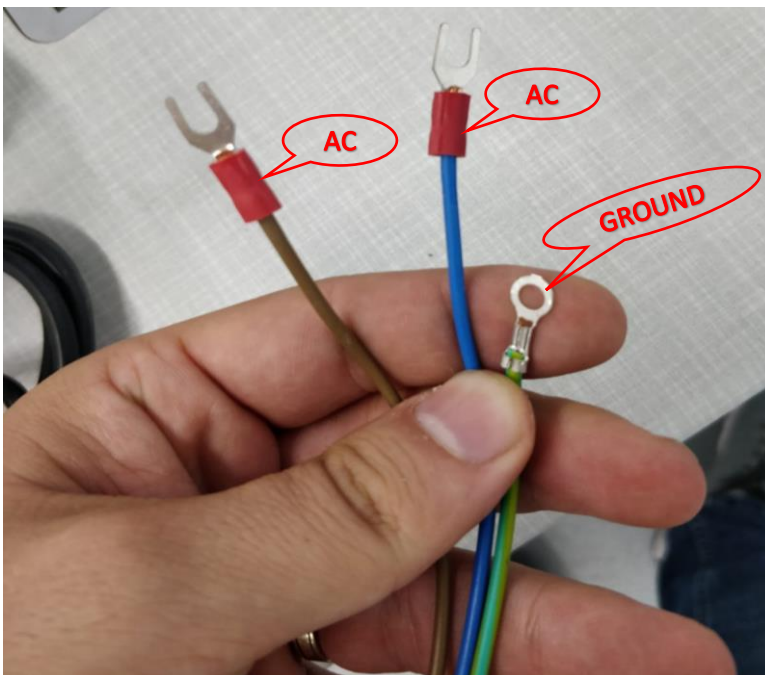
| No. | Category               | Description                               |
|-----|------------------------|---|
| 1   | MACHINE HEAD           | DLU-5490N-7                               |
| 2   | MODEL NAME             | JTR-DLU5490/SHU                           |
| 3   | MOTOR                  | JUKI M92                                  |
| 4   | MAIN MOTOR DRIVE       | JUKI SC920                                |
| 5   | MAXIMUM SEWING SPEED   | 5000sti/min - delivery speed: 4000sti/min |
| 6   | STITCH LENGTH          | Min : 1,5mm Max: 3,5mm at delivery 2,5mm  |
| 7   | NEEDLE TYPE            | GB / DPX5 / #12                           |
| 8   | GAUGE                  | P1022                                     |
| 9   | FABRIC CUTTING SYSTEM  | ORIGINAL JUKI CUTTING SYSTEM              |
| 10  | SEWING SPECIFICATIONS  | THIN TO MEDIUM THICKNESS                  |
| 11  | TARGET PROCESS         | SHIRT HEMMING                             |
| 12  | ATTACHMENT             | DELIVERY 6MM (Optional : 4-5-7)           |
| 13  | AIR PRESSURE           | Min: 0.5 MPa / Max: 1.0 Mpa               |
| 14  | VOLTAGE CLASSIFICATION | Single-phase 220V - 240V 50 Hz            |
| 15  | CAPACITY               | 2700 - 3000 pcs / 9 hours                 |
| 16  | AIR CONSUMPTION        | 1,5 L / min                               |
| 17  | POWER CONSUMPTION      | 140VA                                     |

### 3) INSTALLATION

3.1) The machine is delivered as below

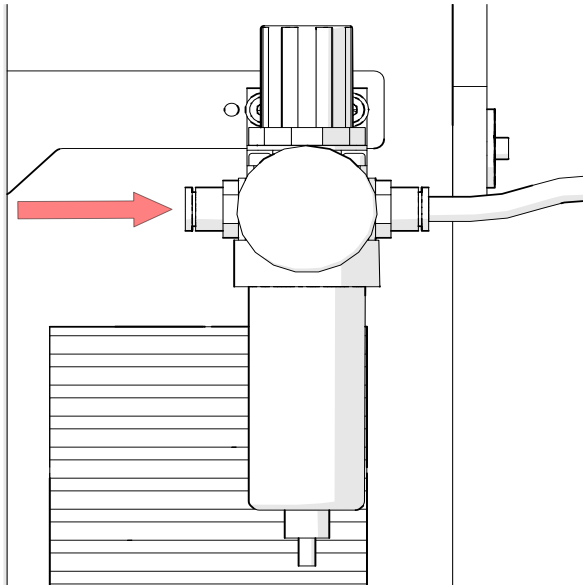


3.2) Connecting the power supply.



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.

**3.3) Connect the air tube to the air regulator.**



## **4) PREPARATION FOR OPERATION**

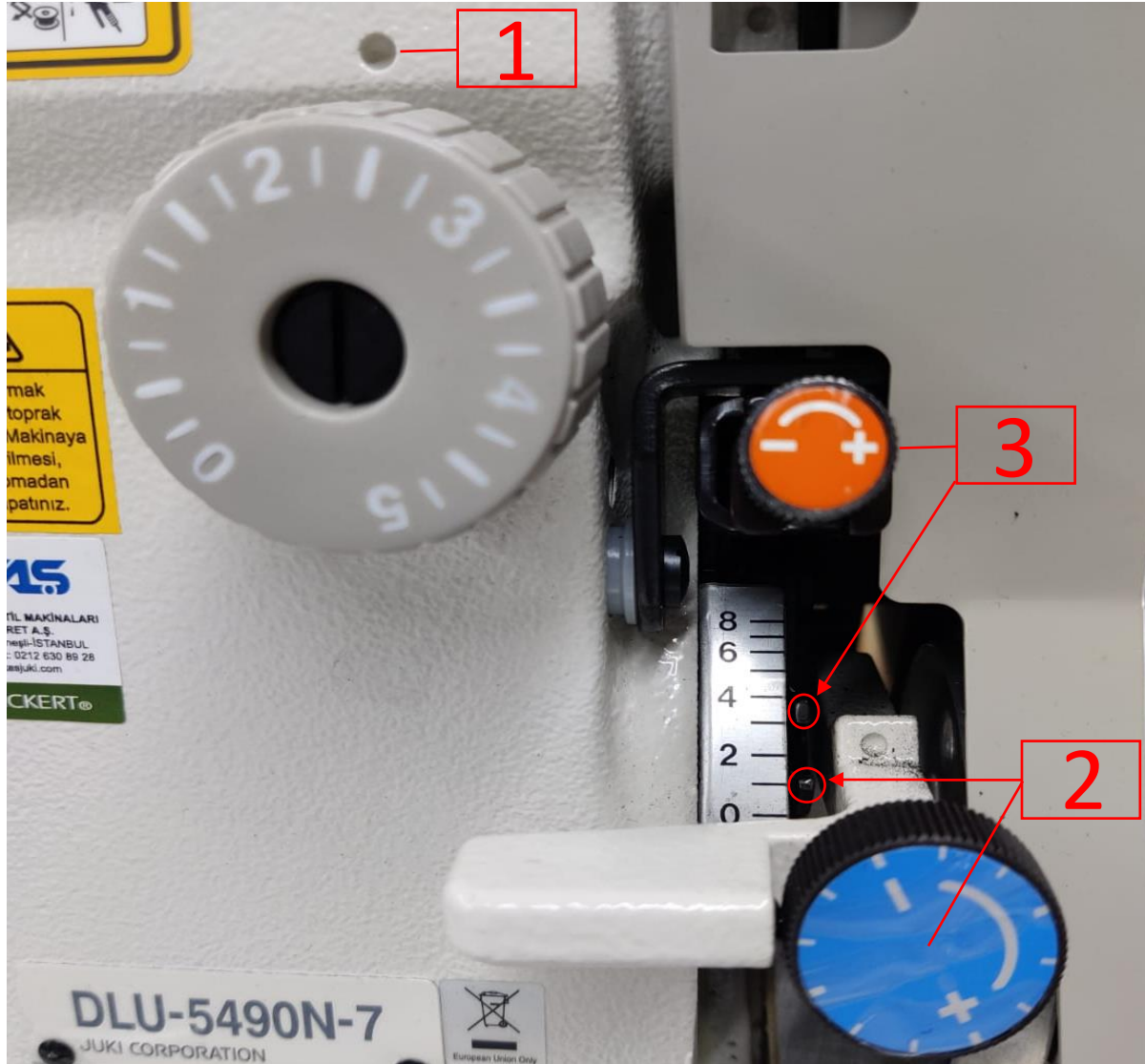
**4.1)** Please put the Juki genuine oil 7 from upper cover of the machine head. (Please refer to machine head instructions –DLU5490N-7)

**4.2)** Lower bobbing case thread should be properly squeezed.(not so loose also not so tight)

**4.3)** After wrapping the shirt hem and clamping it with the presser foot, sew a few stitches. Then set the attachment guide and align the wrapping shirt hem with the guide.



#### 4.4) Adjustment of Upper Transport



##### 4.4.1) Stitch Length Adjustments

The stitch step adjustment(1) should be done as min : 1,5mm Max: 3,5mm at delivery 2,5mm

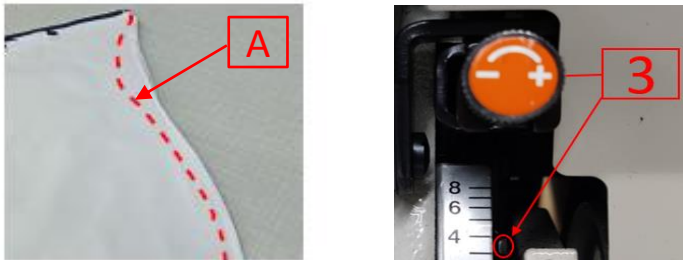
##### 4.4.2) Upper Transport Adjustments

Adjust the upper transport length using adjustment bar(2) to reduce sewing wrinkles.

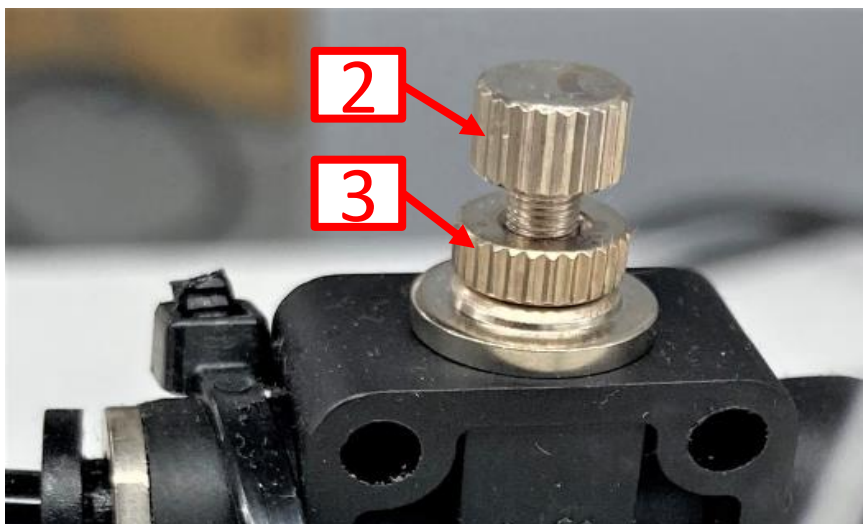


#### 4.4.3) Upper Transport Limiter Adjustments

When the knee switch is switched ON, the upper transport length can be increased up to this upper transport limiter. This will make curves (e.g. A) easier to turn and reduce sewing wrinkles, prevent stitch lengths from shortening. Adjust the upper transport limiter with the adjustment bar (3).



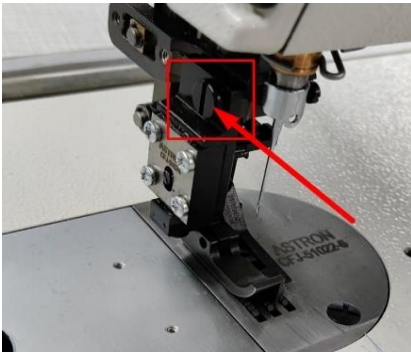
**4.5)** Adjust the blow flow rate blowing from the nozzle (4) of the attachment to achieve the correct amount of shirt hem roll-in. Loosen the lock nut (3) on the speed controller (1) and turn the knob (2) to adjust.



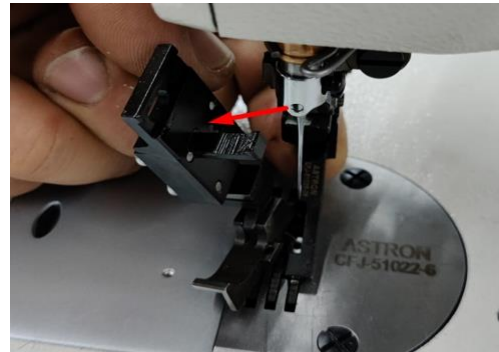


## 5) ADJUSTMENT

### 5.1) P1022 Gauge Adjustments



Step 1 : Remove the screw



Step 2 : Remove the presser foot from the gauge

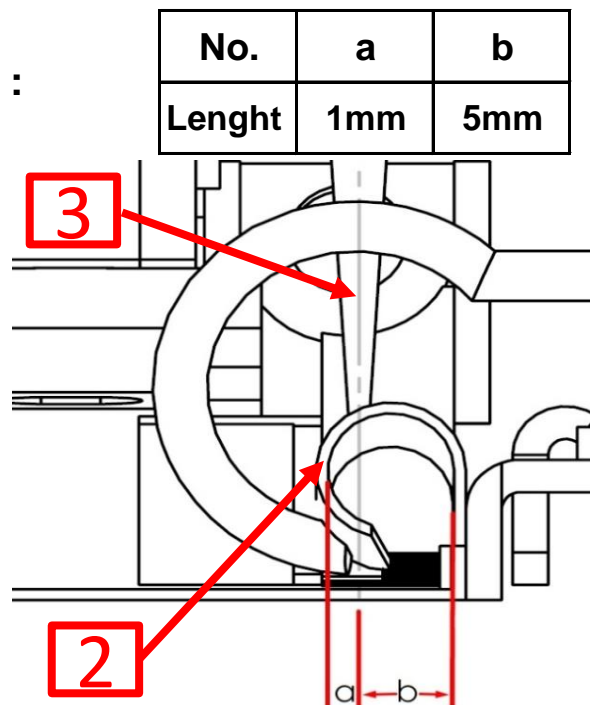
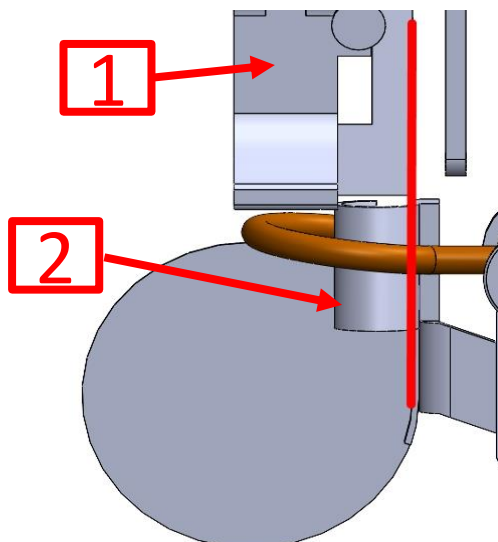


Step 3 : Adjust with an Allen key so that the end of the presser foot (1) is aligned with the end of the guide (2).



Step 4 : Loosen two screws (4) and adjust the positional relationship between the guide (2) and needle (3) as shown on the right figure.

### P1022 Gauge (6mm) :



| No.    | a   | b   |
|--------|-----|-----|
| Lenght | 1mm | 5mm |

## 5.2) Presser Foot Height Adjustments



**Step 1 : Remove the screw**



**Step 2 : Turn clockwise to the end as the picture**



**Step 3 : Center the screw in the slot**



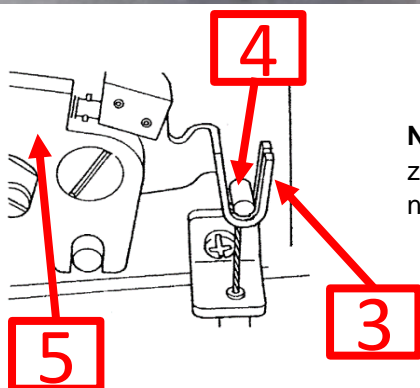
**Step 4 : Tighten the screw with a little play in the direction of rotation.**

## 6) ASSEMBLING UPPER FEED SYSTEM

**6.1)** When the machine head was lean, adjust the upper transport system as number 0. While zigzag arm was pressing, move on to the next step(6.2).



**6.2)** While the wire is slightly tightened, pinpoint the place(1-2) with a pencil. Then drill the demonstrated points. After that mount the upper feed system as the picture.



**Note)** Check the assembly position with no play between the hook (4) of the zigzag arm (5) and the wire stopper (3) that rests on it. If there is a gap, it will not operate normally.

## **7) CAUSES AND COUNTERMEASURES**

**Q.1)** Fabric gets loose when sewing at the hemming area.

**A1)** When upper puller becomes insufficient at the turning points , the upper limit should be activated via knee switch.

**Q.2)** Fabric gets curled away when sewing in the hemming area.

**A2)** This incident occurs when the upper transport pulls excessively or too light. This problem could be solved by synchronizing the upper transport and gear.

**Q.3)** Uneven sewing occurs in hemming.

**A3)** The distance between the gear and the presser foot should be synchronizing to edge stitch with allen.

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