

Jeans Front Pocket Tape Sewing Unit

JTR-LH3578 / PTA Series

INSTRUCTION MANUAL



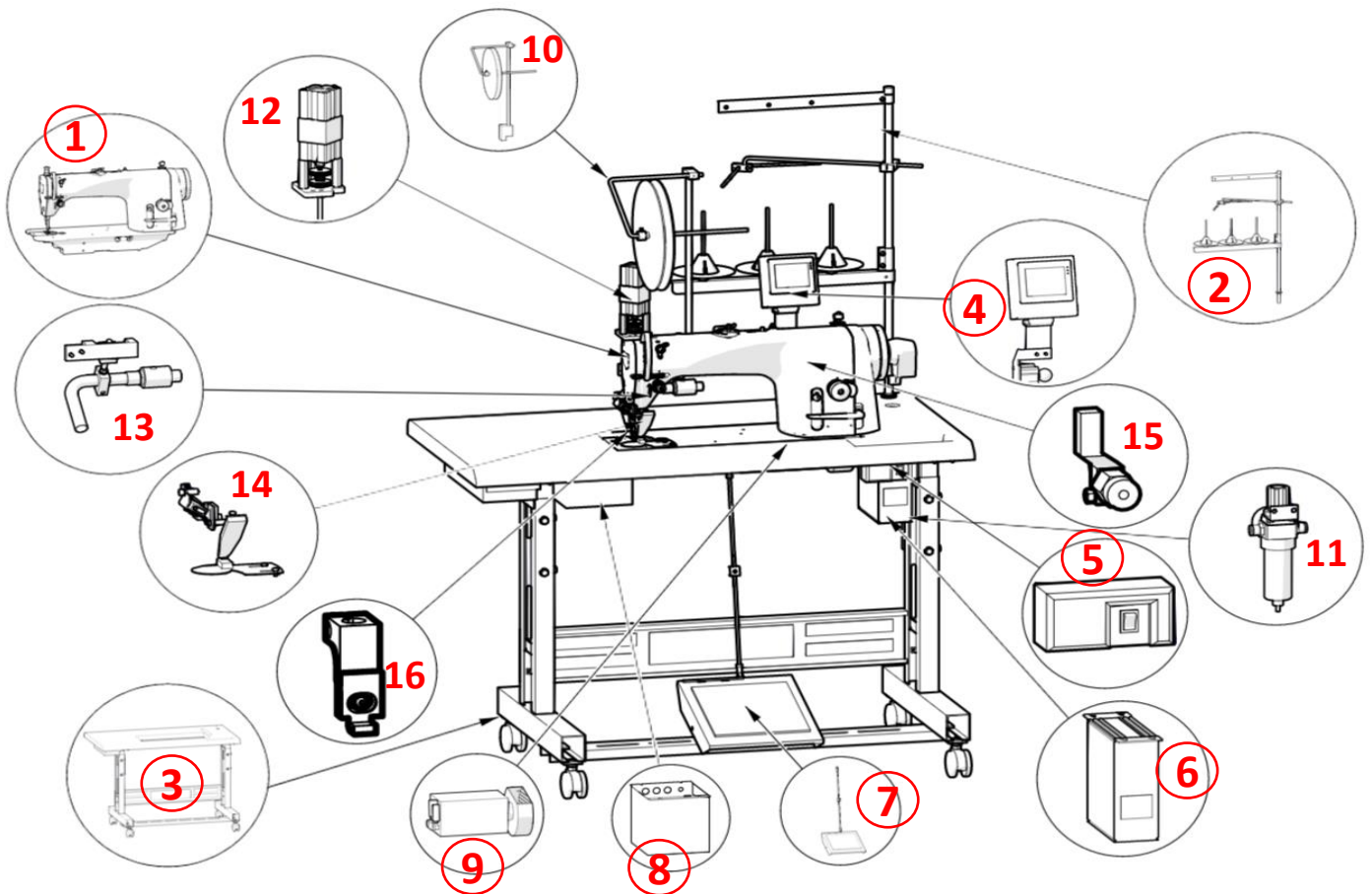
No.JTR000

LH3578PTA-TM

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1) CONFIGURATION OF THE MACHINE



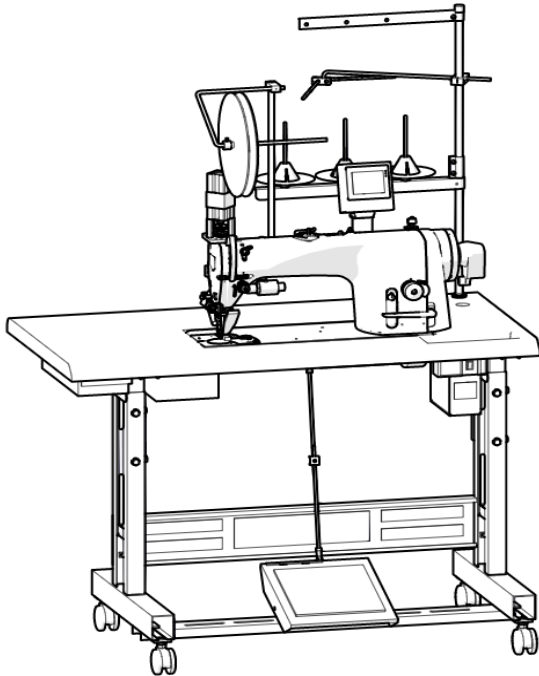
1	MACHINE HEAD	9	MOTOR
2	THREAD STAND	10	TAPE STAND
3	CHASSIS GROUP	11	AIR REGULATOR
4	PANEL	12	KNIFE GROUP
5	MAIN SWITCH	13	SUCTION GROUP
6	JTRON CONTROL BOX	14	ATTACHMENT GROUP
7	PEDAL	15	FOOT LIFTING GROUP
8	PLC BOX	16	FOOT AND CONNECTION GROUP

2) SPECIFICATION

No.	Category	Description
1	MACHINE HEAD	LH-3578AGF
2	MODEL NAME	JTR-LH3578/PTA
3	MAIN MOTOR	HOHSING M10-60-J
4	MAIN MOTOR DRIVE	HOHSING G60-4
5	MAXIMUM SEWING SPEED	3000sti/min, delivery speed: 2700sti/min
6	STITCH LENGTH	2.5mm-4mm, at the delivery: 3mm
7	NEEDLE TYPE	GB / DPX5 #18
8	GAUGE	6.4MM (Standard)
9	TAPE SIZE	Input : 20 mm / Output : 10 mm (Standard)
10	FABRIC CUTTING SYSTEM	ORIGINAL JTRON CUTTING SYSTEM
11	SEWING SPECIFICATIONS	THIN TO MEDIUM THICKNESS
12	TARGET PROCESS	Tape Attaching
13	AIR PRESSURE	MIN: 0.6 MPa MAX: 0.8 MPa Standard: 0.6 Mpa
14	VOLTAGE CLASSIFICATION	Single-phase 200V - 240V/50Hz
15	AIR CONSUMPTION	3 L / min
16	POWER CONSUMPTION	520VA
17	CAPACITY	4000 - 4500 pcs / 9 hours
18	DAILY PIECE COUNTER	Available

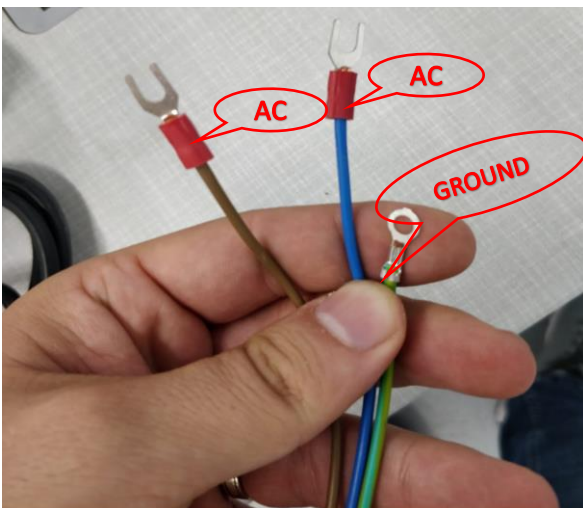
3) INSTALLATION

3.1) The machine is delivered as below



There is not any special occasion for transportation of the machine thus there is no need for extra installation notes.

3.2) Connecting the power supply

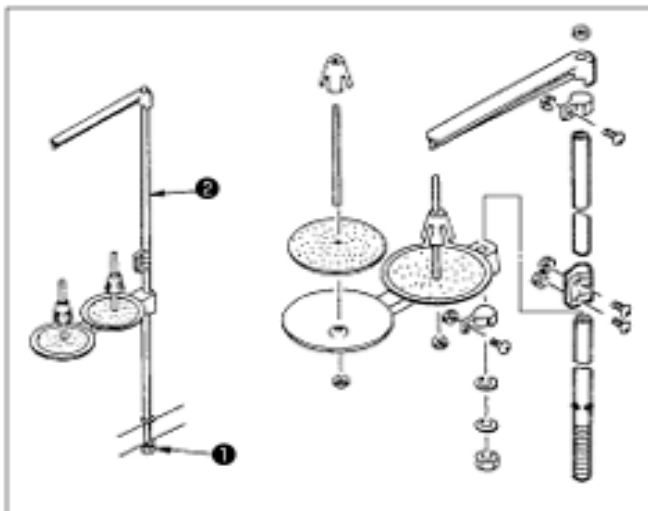


The machine is not supplied with a power plug. It is therefore necessary for you to select a plug that matches the receptacle available under a given operating environment and attach it to the power cable.

3.3) The supply air to the machine

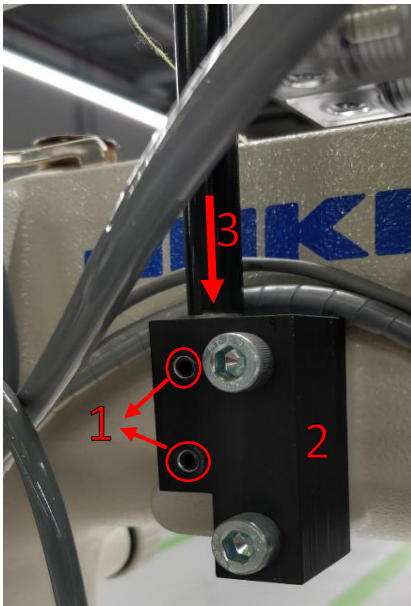


3.4) Installing the thread stand.

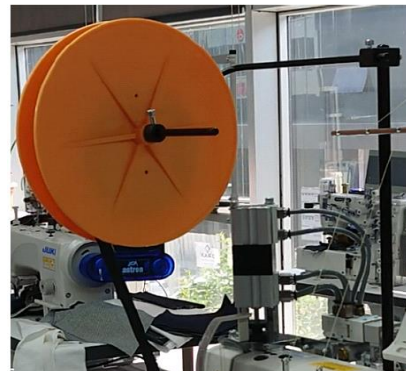


- 1) Assemble the thread stand unit, and insert it in the hole in the machine table.
- 2) Tighten locknut ❶ to fix the thread stand.
- 3) For ceiling wiring, pass the power cord through spool rest rod ❷ .

3.5) Installing the tape stand.

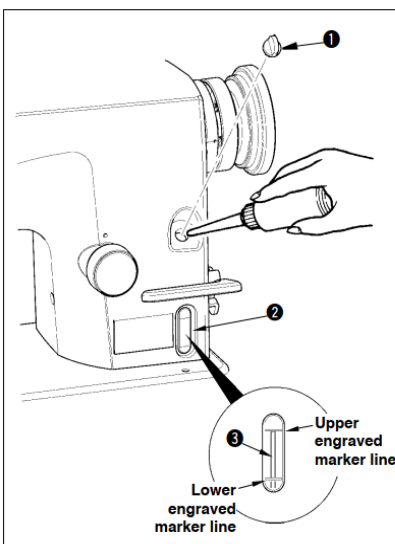


Loosen the set screws(1). Then insert the "tape stand shaft(3)" into the block(2). Complete the process by tightening the set screws(1).



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 – LH-3500A)



Fill the oil tank with oil for hook lubrication before operating the sewing machine.

- 1) Remove oil hole cap ① and fill the oil tank with JUKI NEW DEFRIX OIL No.1 (Part No. : MD-FRX1600C0) or JUKI MACHINE OIL #7 (Part No. : MML007600CA) using the oiler supplied with the machine.
- 2) Add oil until the top end of oil amount indicating rod ③ does not go above the upper engraved marker line.
If the oil tank is filled with an excessive amount of oil, oil will leak from the air vent hole in the ball float case or proper lubrication will not be carried out. So, be careful.
- 3) When you operate the sewing machine, refill oil if the top end of oil amount indicating rod ③ comes down to the lower engraved marker line of oil amount indicating window ②.

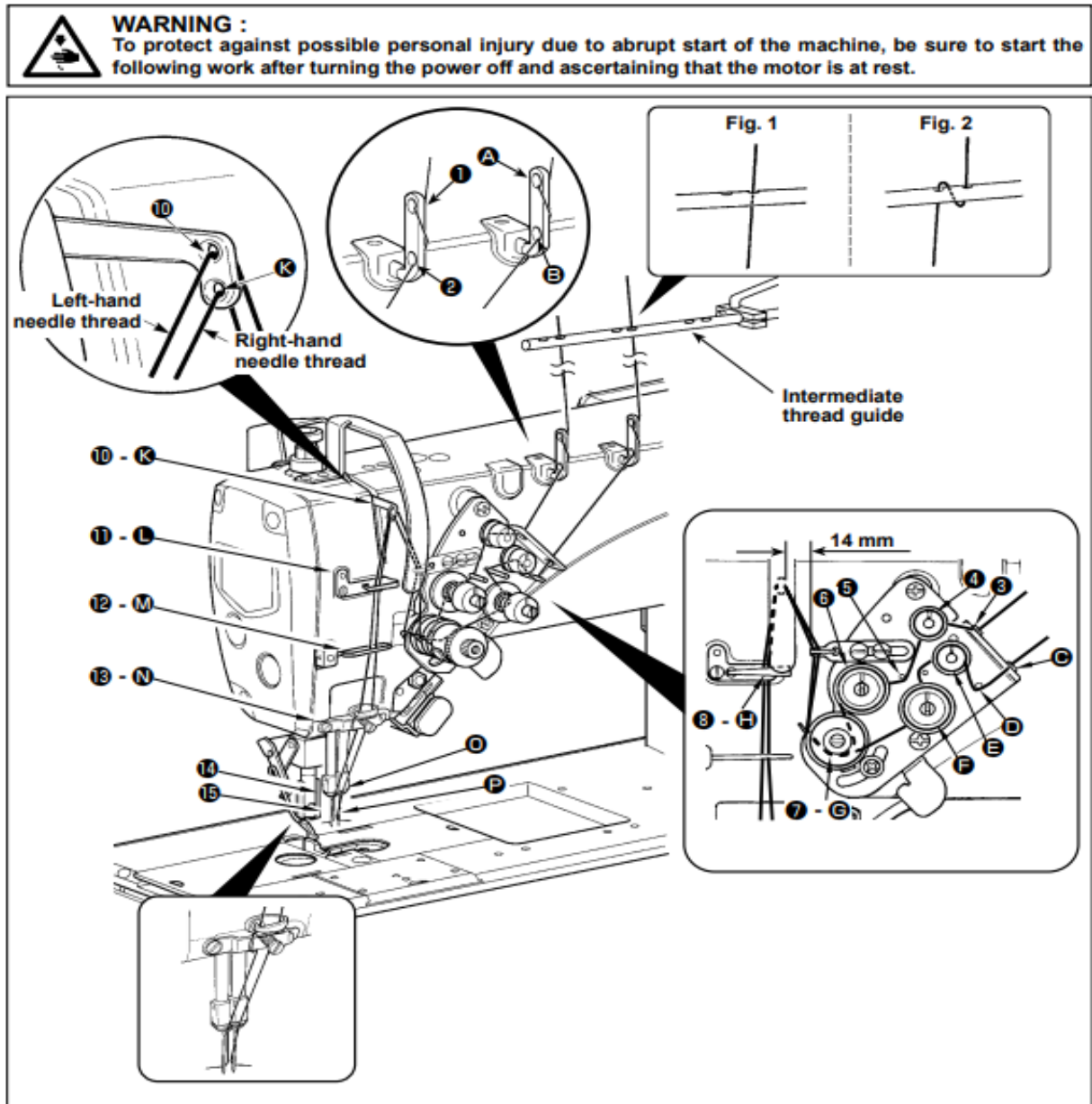


- For the first time you fill the oil tank with oil, add 280 cc of oil as a guide and check to be sure that the oil amount indicating rod works. If the oil amount indicating rod does not work, bring it to the workable state by tilting the sewing machine once.
- When you use a new sewing machine or a sewing machine after an extended period of disuse, use the sewing machine after performing break-in at 2,000 sti/min or less.
- For the oil for hook lubrication, purchase JUKI NEW DEFRIX OIL No. 1 (Part No. : MD-FRX1600C0) or JUKI MACHINE OIL #7 (Part No. : MML007600CA).
- Be sure to lubricate clean oil.



In case of the circulation type lubrication method, when using the sewing machine for the first time, the oil amount in the oil tank decreases until the oil has collected in the filer for circulation. When the top end of oil amount indicating rod is lower than the lower engraved marker line, add the oil to the oil tank again so that the top end enters between the upper and lower engraved marker lines.

4.2) Threading the machine(Please refer to machine head instructions – LH-3500A).



Thread the machine head following the order as illustrated in the figure.

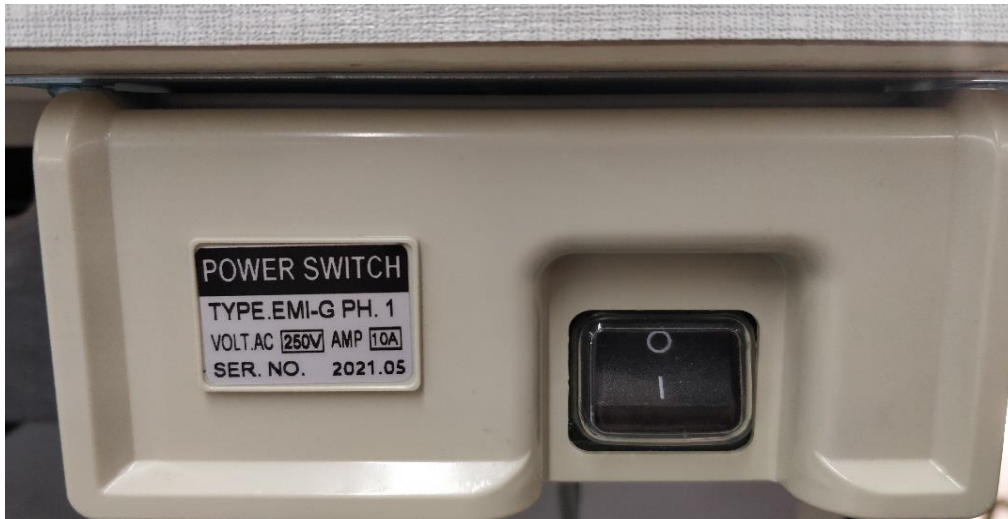
Pass the left-hand needle thread, toward the machine head, in the order of ① to ⑮. Pass the right-hand needle thread in the order of A to P.



1. Thread guide (⑮, ⑭) is able to prevent the needle thread from flapping according to its inclination. If the thread guide is inclined excessively, the needle thread can tangle on thread guide (⑮, ⑭). So, carefully adjust the inclination of the thread guide.
2. For the LH-3578A-7 or LH-3588A-7, thread the intermediate thread guide as follows:
 - For polyester spun thread, see Fig. 1. For filament thread, see Fig. 2.

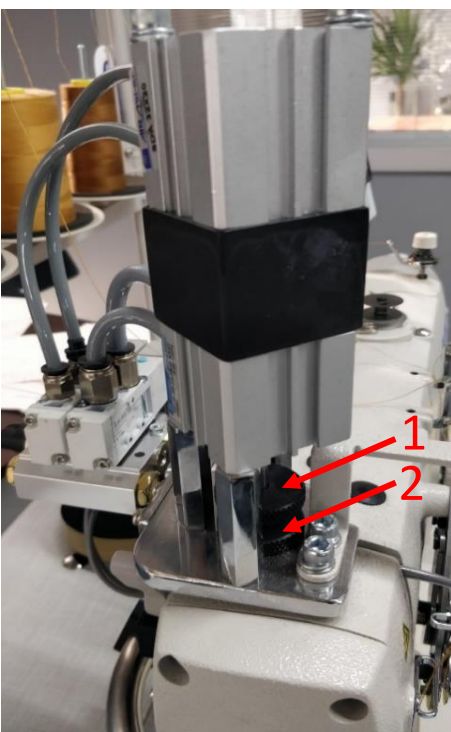
4.3) Adjusting the stitch length(Please refer to machine head instructions – LH-3500A).

4.4) Switch on the machine.



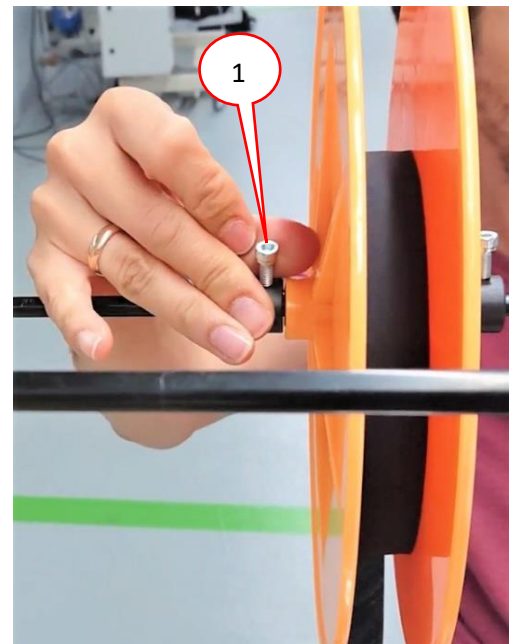
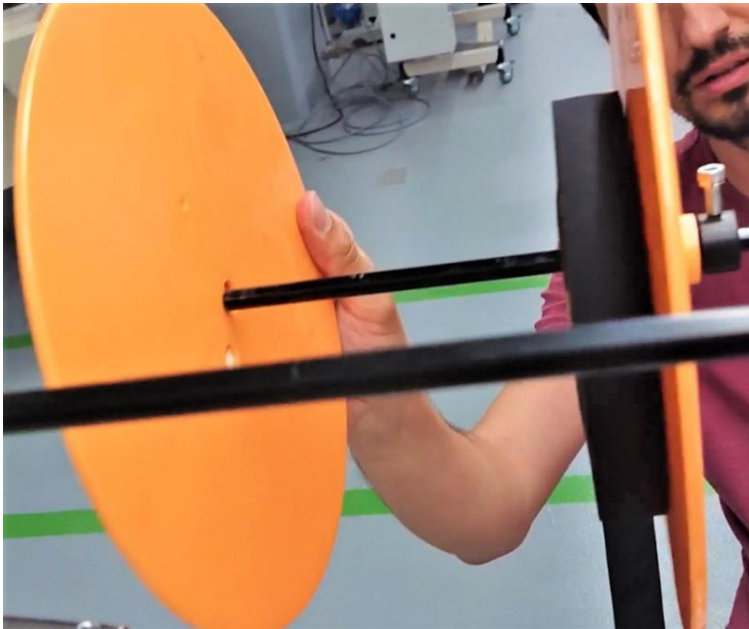
4.5) Adjusting the pressure of the presser foot.

Loosen the lock nut(2) and rotate the screw(1) to increase or descent the pressure of the presser foot.



4.6) How to install tape to feeder ?

Put the tape to stand as in the picture. Fit the holder cover and tighten the screw(1).



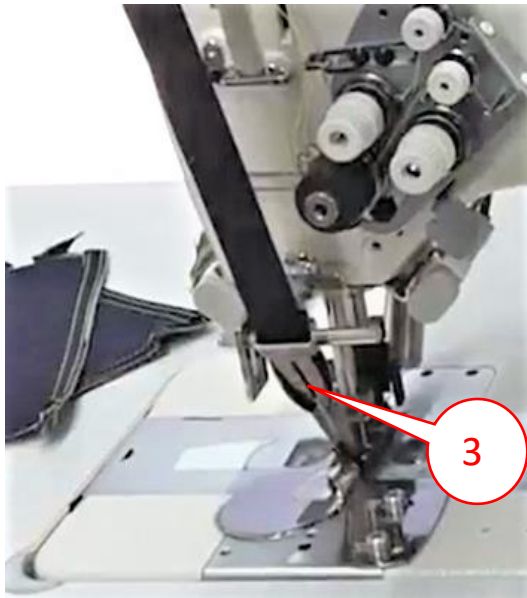
4.7) How to feed tape to attachment ?

4.7.1) The edges of the tape should be cut on front edges to insert the tape to attachment easier.

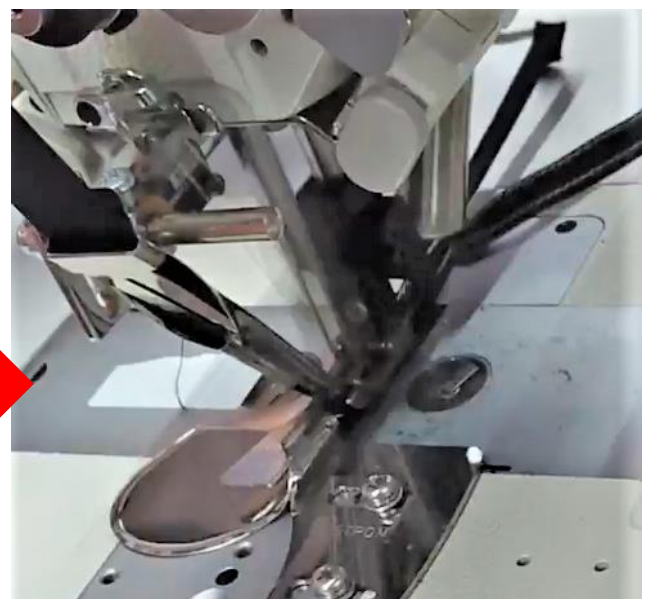
Like the picture below, The end should be a narrow shape.



4.7.2) While pulling the tape out of the holder, feed the tape to the attachments canal with tweezers(4). Insert the tweezers into the groove(3) of the attachment canal and push the tape downwards.



4.7.3) Once the tape is out of the attachment canal, hold the end of the tape with tweezers(4) and tape through under the presser foot(5). Then, feed the tape with the pedal until the tape is folded correctly.



4.8) The cutting adjustment of remaining waste tape.

NOTE: If the cutting piece of tape is not suctioned you will need to adjust it. If the cut piece is normally suctioned, you do not need to adjust it.

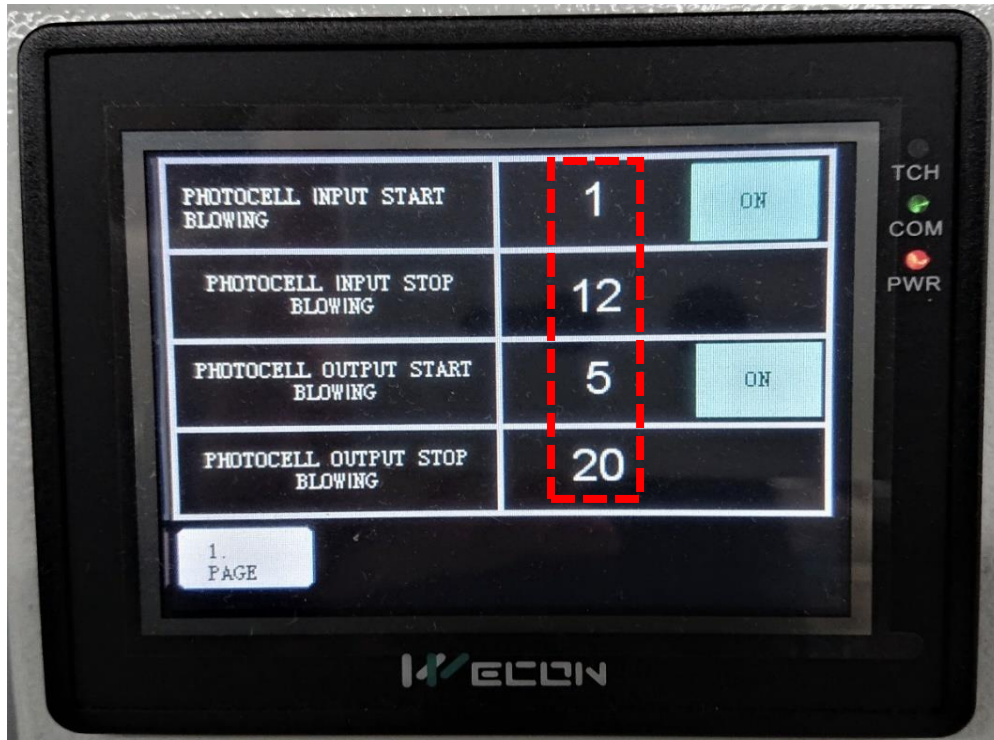
4.8.1) When the panel appears as below, select the language. For Turkish, press the flag of Turkish. For English, press the flag of the United Kingdom.



Press "2.PAGE" button.

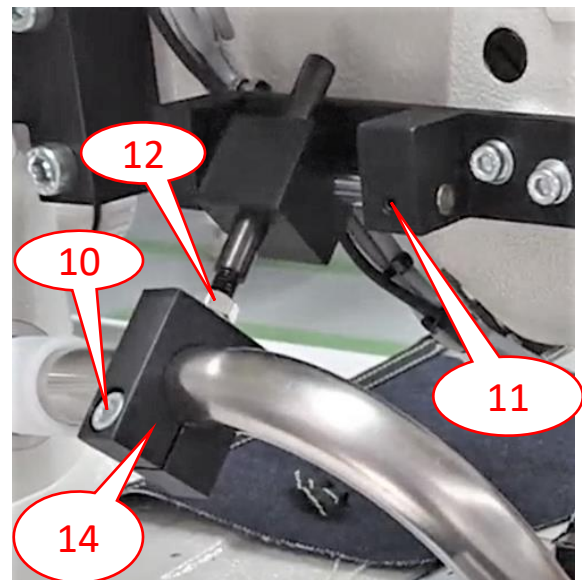


Press numbers to display the numeric keypad screen and enter the number of stitches. Change the number of stitches to adjust the suction timing and length of time.



4.8.2) If the cutting piece is not sucked in, adjust the position of the suction opening in the suction duct(13).

Loosen screws(10) and (11) and adjust the angle of the the suction opening. Loosen lock nut(12) and rotate bracket(14) to set it's height (When you set the suction duct(13) height, it must be removed beforehand).



5) PANEL

5.1) Intro Screen (Select Language)



5.2) Page 1



1 - Photocell input knife initial step: Which step the knife should start cutting, after photocell detects the front side of the fabric.

2 - Photocell output knife initial step: Which step the knife should start cutting, after photocell detects the rear side of the fabric.

3 - Knife runtime : Knife working time

4 - Current number : Counter

5 - Knife push wait : The upper piston lowers the knife to the upper surface of the tape and the lower piston pushes the knife into the tape to cut it. This setting is the time for the lower piston until starting to operate.

6 - Counter Reset : To reset counter

7 - 2.PAGE : Skip to second page [Ref 5.3]

5.3) Page 2



1 - Photocell input start blowing : Which step the vacuumer should start vacuuming, after photocell detects the front side of the fabric.

2 - Photocell input stop blowing : Which step the vacuumer should stop vacuuming, after photocell detects the front side of the fabric.

3 - Photocell output start blowing : Which step the vacuumer should start vacuuming, after photocell detects the rear side of the fabric.

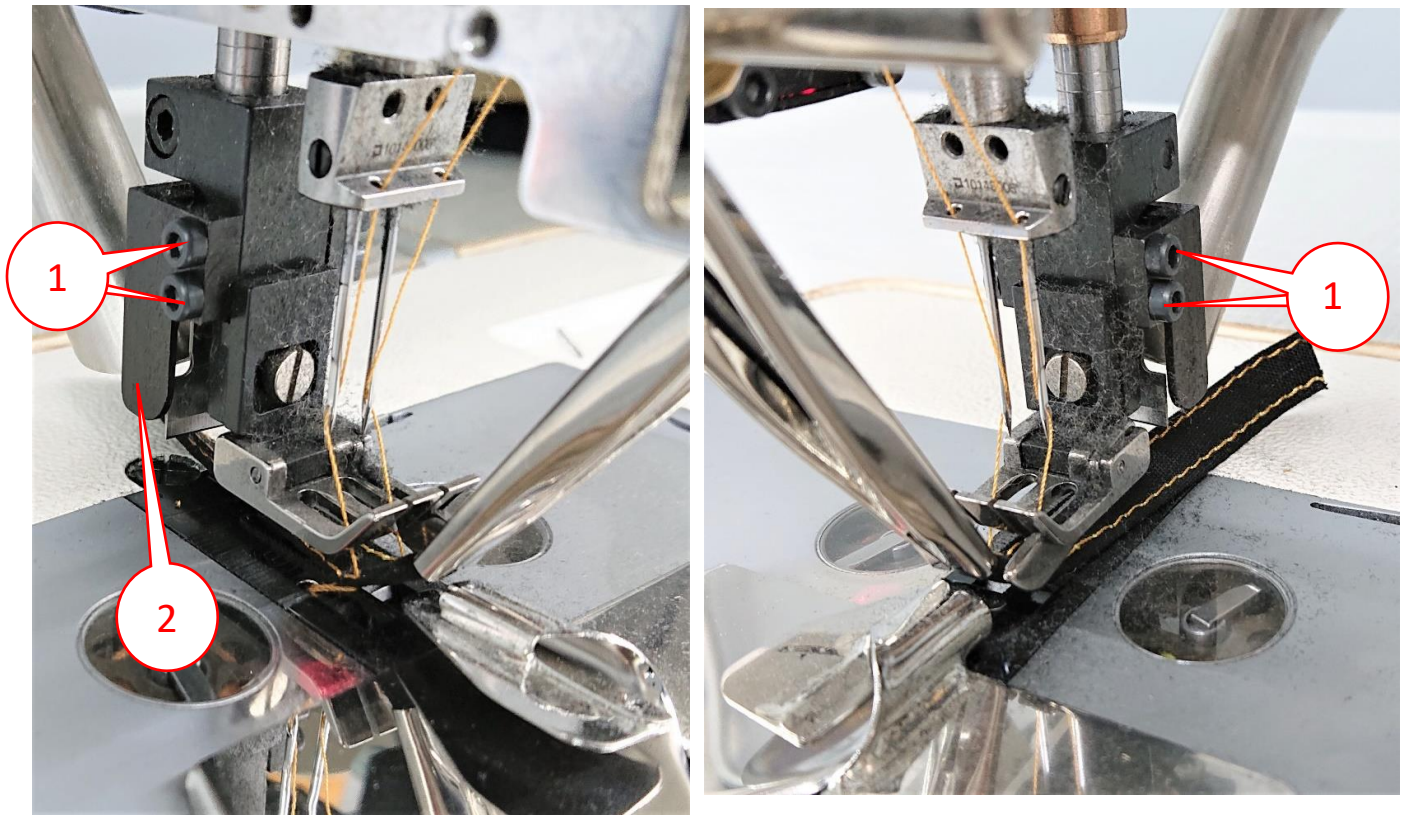
4 - Photocell output stop blowing : Which step the vacuumer should stop vacuuming, after photocell detects the rear side of the fabric.

5 - 1.PAGE : Skip to first page.[Ref 5.2]]

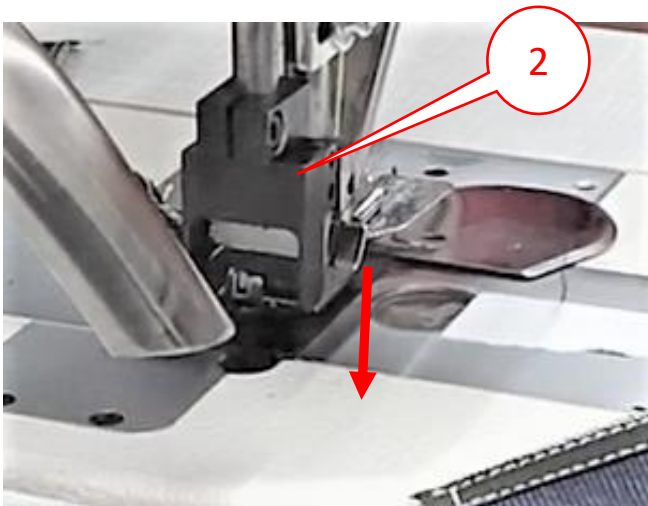
6) ADJUSTMENT

6.1) Knife replacement

6.1.1) Loosen 4 screws (1) and remove the tape knife cover(2).

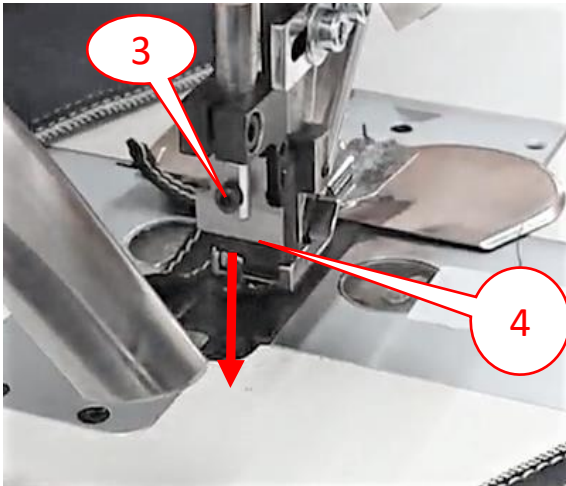


6.1.2) Remove the tape knife cover (2) while pulling it downwards.



Note: When fitting the tape knife cover (2), fit it so that it is inserted from below.

6.1.3) Remove the screw (3) and pull out the tape knife (4) at the bottom.

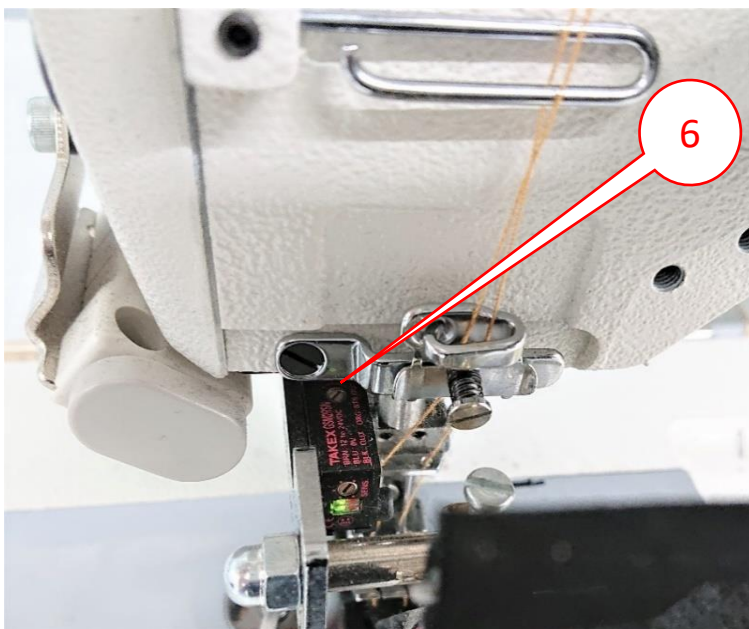


Note: When you assemble the tape knife (4),tighten the screw (3) while pushing it to top.

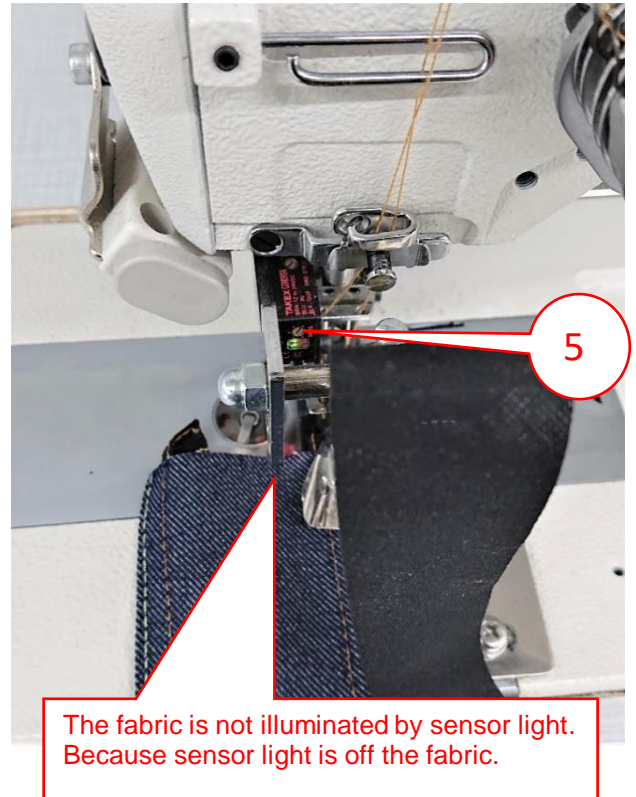
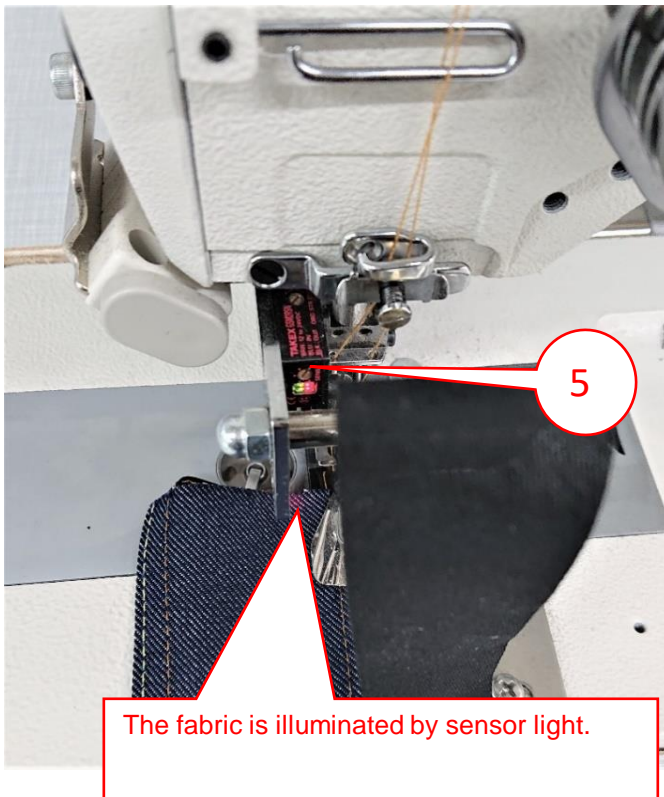
6.2) Adjust the sensitivity of the sensor to suit the fabric.

Note: The sensor position may also need to be adjusted, as it starts counting the number of stitches when it detects it.

6.2.1) Check that switch(6) on the sensor is set to turn on when it detects fabric. If not, set it to dark ON (D.ON).

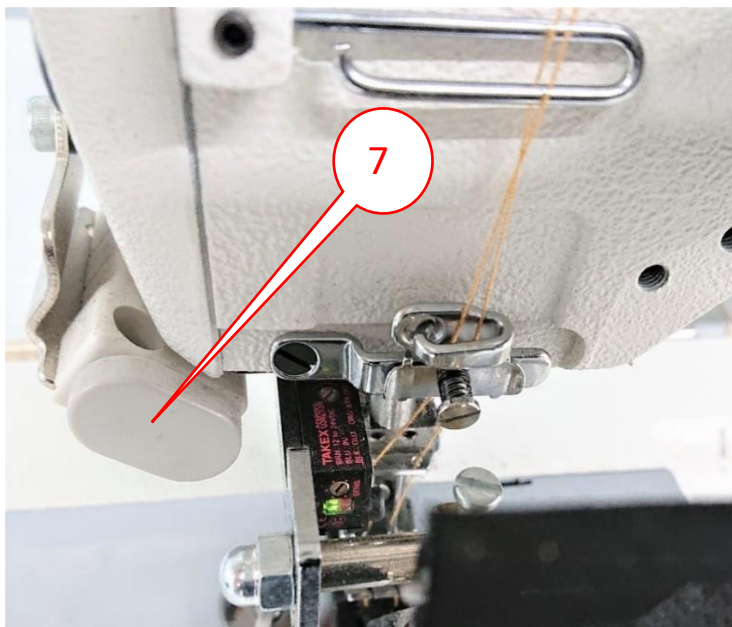


6.2.2) When a fabric is undetected, adjust volume ⑤ so that only the blue lamp lights up.
Then, when a fabric is detected, adjust the volume ⑤ so that the blue and red lamps light up.



Tip: The tape scalpel does not descend when the sensor detects fabric.

When the sensor detects fabric, pressing the handheld switch(7) does not lower the tape knife.



7) MAINTENANCE

Machine head is standard JUKI. Please refer to original machine heads instructions manual.

The machine could be cleaned with pressed air blowing where it is unclear.

If the thread tangled the part should be removed and should be cleaned separately.

8) 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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