



Care Labels Combining and Sewing Automat

JTR-LK1900BN / CLA Series

INSTRUCTION MANUAL



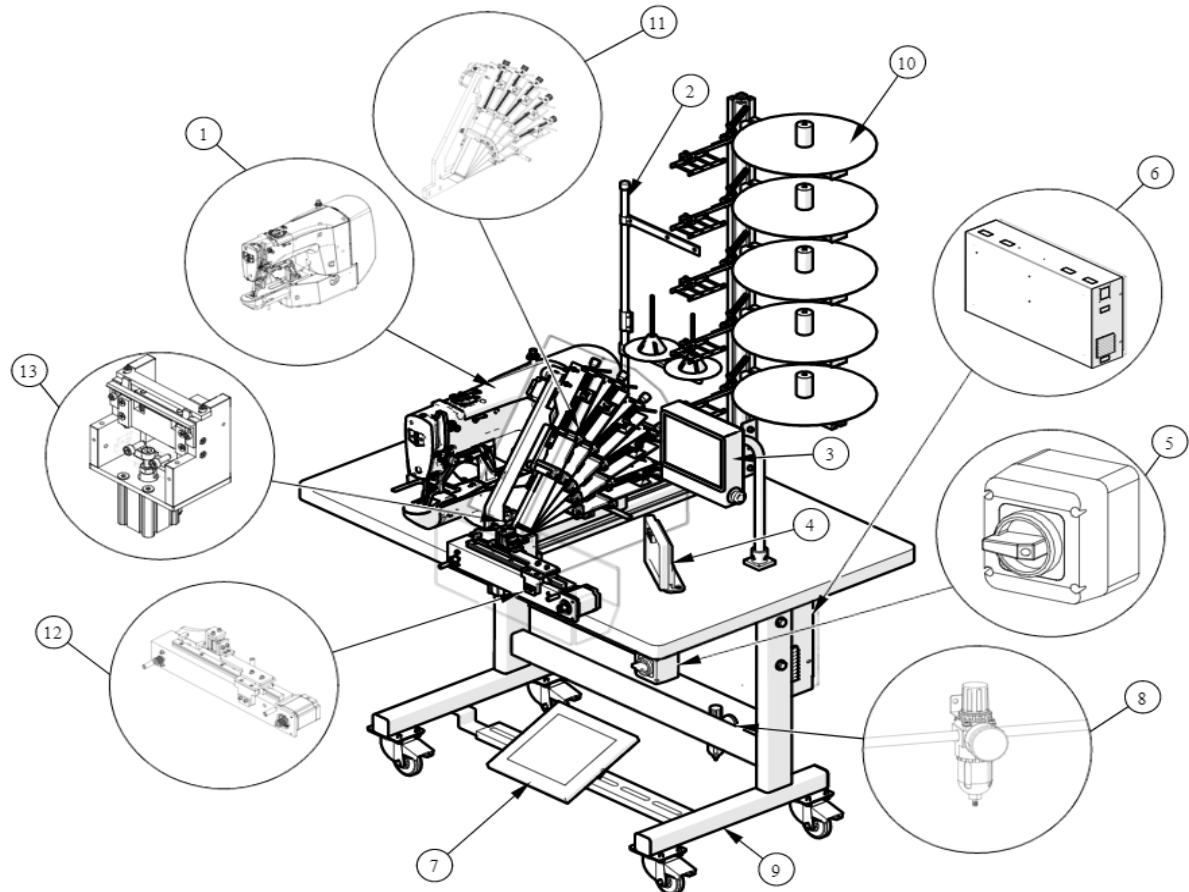
No.JTR000

LK1900BNCLA-TM

CONTENTS

- 1) CONFIGURATION OF THE MACHINE**
- 2) SPECIFICATION**
- 3) INSTALLATION**
- 4) PREPERATION FOR OPERATION**
- 5) PANEL**
- 6) ADJUSTMENT**
- 7) LIST OF PATTERN DATA**
- 8) CAUSES AND COUNTERMEASURES**
- 9) DISPOSAL OF BATTERIES**

1) CONFIGURATION OF THE MACHINE



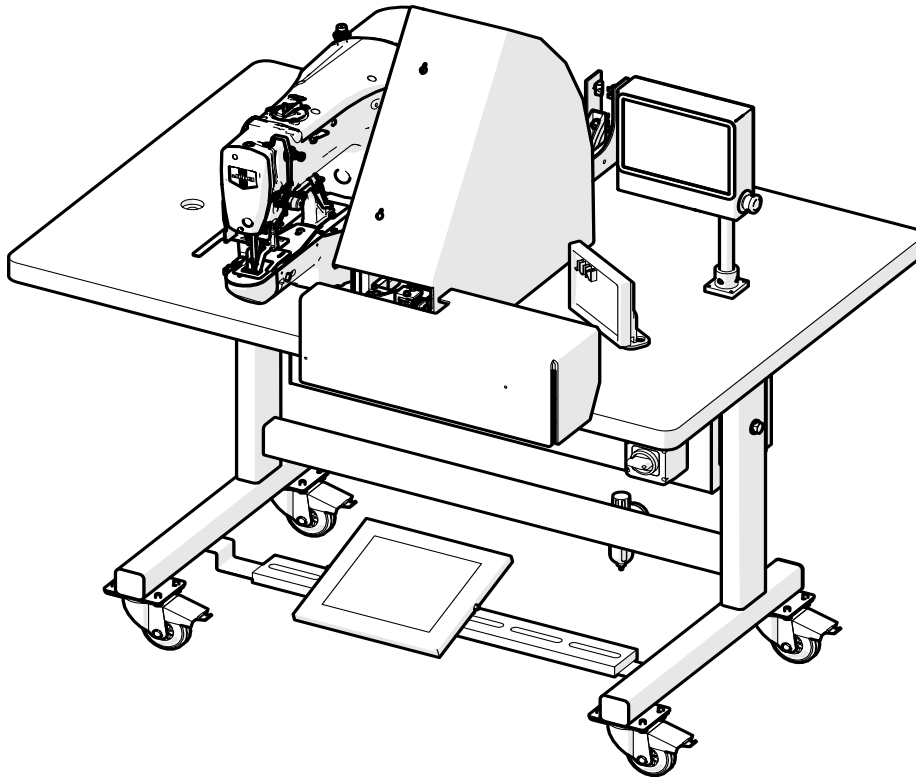
1	MACHINE HEAD	8	AIR REGULATOR
2	THREAD STAND	9	CHASIS GROUP
3	PLC PANEL	10	CARE LABEL STAND
4	JUKI PANEL	11	LABEL FEEDING GROUP
5	MAIN SWITCH	12	LABEL TRANSPORTER
6	CONTROL BOX	13	CUTTING GROUP
7	PEDAL		

2) SPECIFICATION

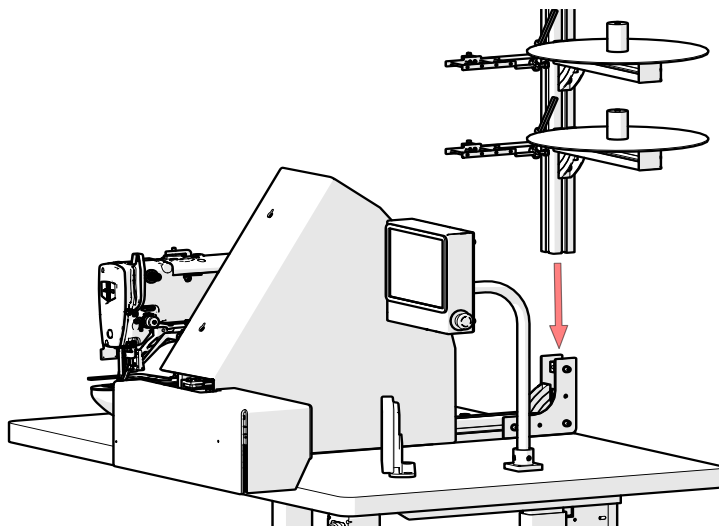
No.	Category	Description
1	MACHINE HEAD	LK1900BN
2	MODEL NAME	JTR-LK1900BN/CLA
3	MAIN MOTOR	JUKI AC SERVO MOTOR
4	MAIN MOTOR DRIVE	JUKI MC673
5	MAXIMUM SEWING SPEED	3200 sti/min, at the delivery: 2800 sti/min
6	STITCH LENGTH	2mm - 3.5mm / at the delivery: 2.5mm - 3mm
7	NEEDLE TYPE	GB / DPX17 #12-14
8	GAUGE	Juki original gauge used
9	LABEL LENGHT	30 mm - 180 mm
10	LABEL WITDH	10 mm - 50 mm
11	FABRIC CUTTNG SYSTEM	Original Jtron cutting system (Chopper-type)
12	SEWING SPECIFICATIONS	FROM THIN TO MEDIUM THICKNESS
13	TARGET PROCESS	CARE LABEL ATTACHING
14	AIR PRESSURE	Min: 0.6 MPa Max: 0.8 MPa Delivery: 0.6 MPa
15	AIR CONSUMPTION	3.5 L / min
16	VOLTAGE CLASSIFICATION	Single-phase 220V - 240V / 50Hz
17	CAPACITY	5000 - 6000 pcs / 9 hours
18	DAILY PIECE COUNTER	YES
19	POWER CONSUMPTION	270VA

3) INSTALLATION

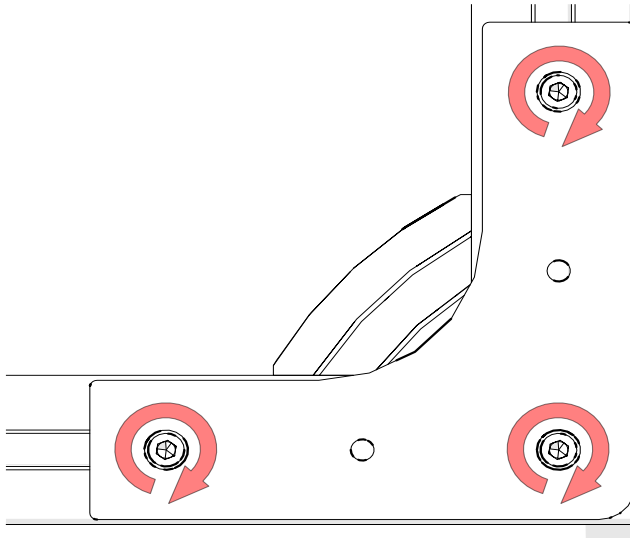
3.1) The machine is delivered as below



3.2) Install the care label stand.

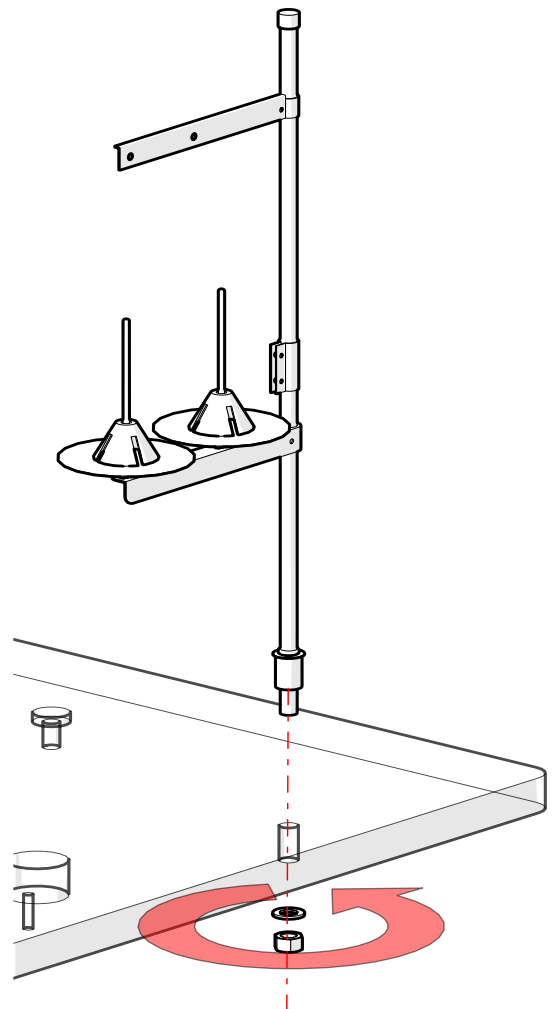


3.2.1) Tighten the screws.



3.3) Install the thread stand.

3.3.1) Tighten the nut and washer.

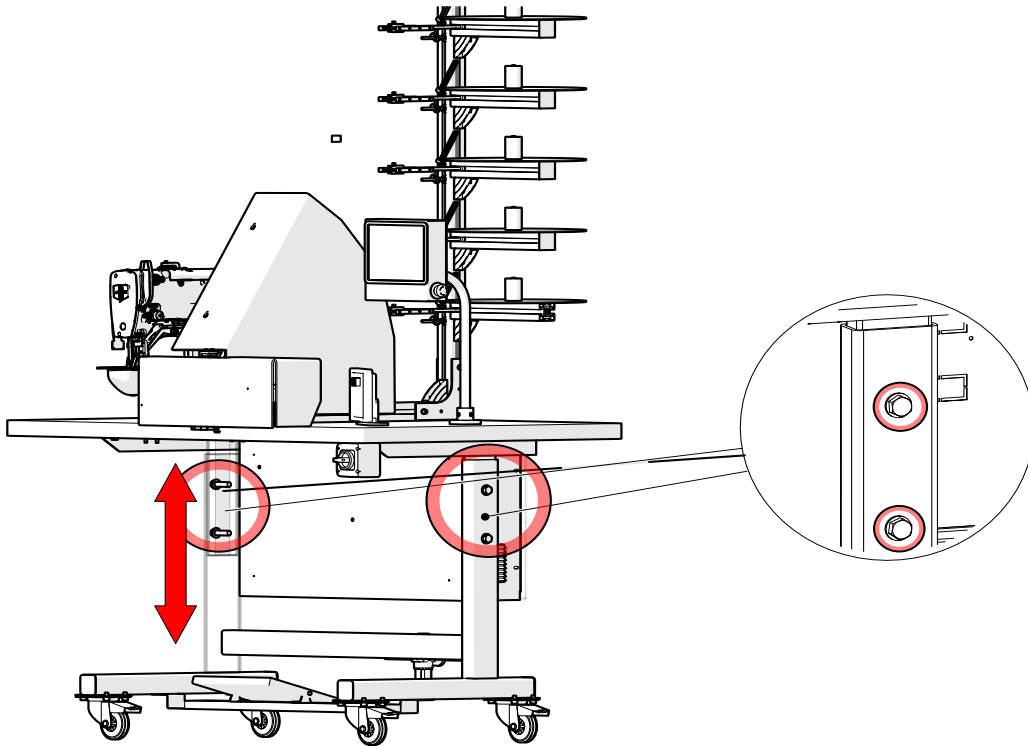


3.4) How to adjust the table height?

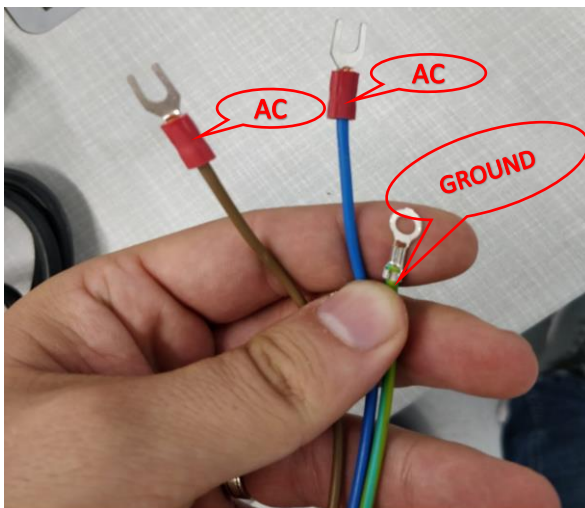
Remove the screws(4 pieces).

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

Tighten the screws(4 pieces) when the desired height is reached.

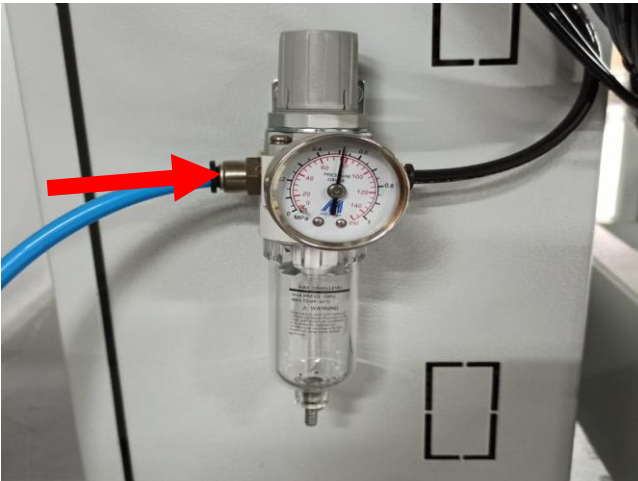


3.5) Connecting the power supply



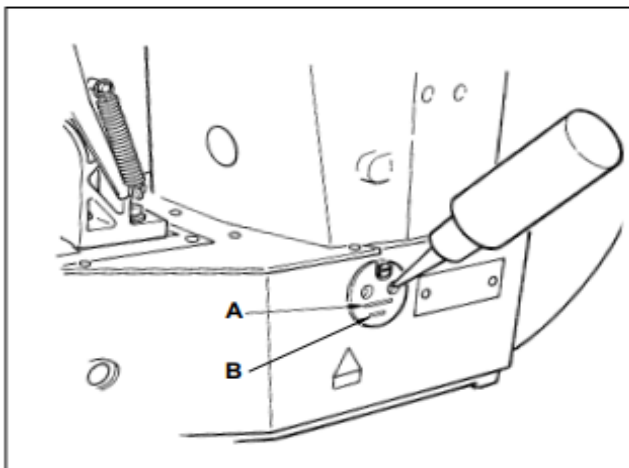
The machine is not supplied with a power plug. It is therefore necessary for you to select a plug that matches the receptacle available under a given operating environment and attach it to the power cable.

3.6) Connect the air tube to the air regulator.

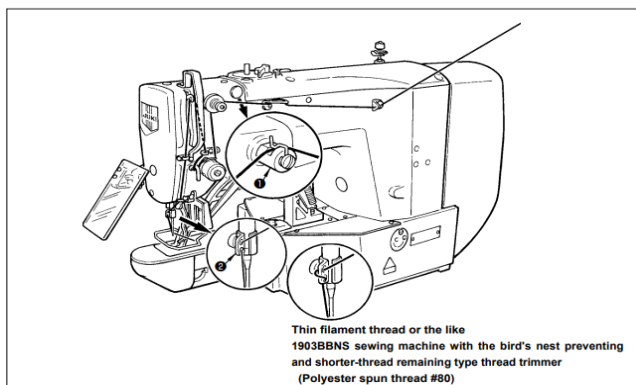


4) PREPARATION FOR OPERATION

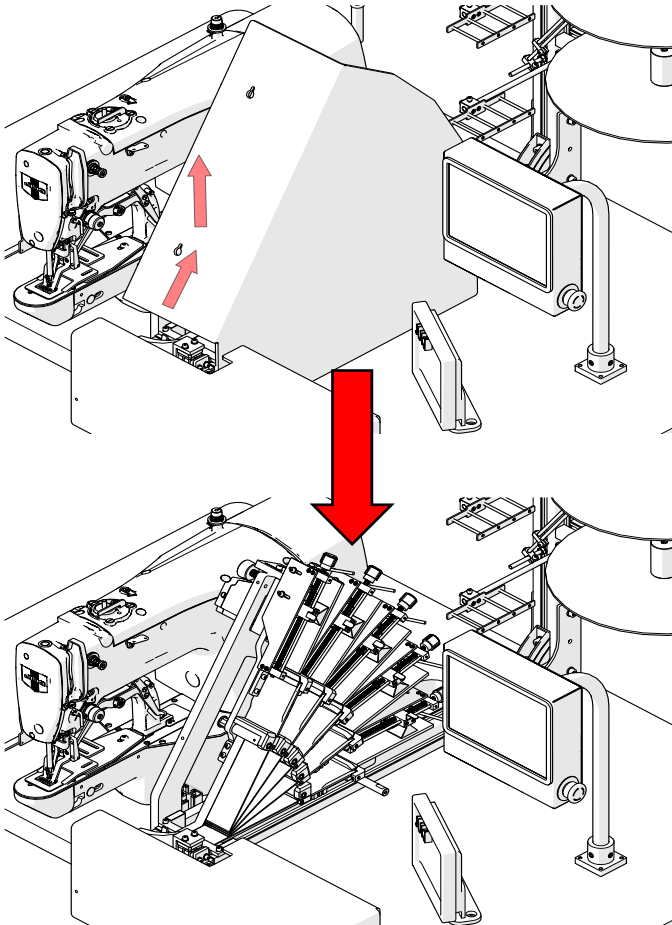
**4.1) Please put the JUKI original oil.
(Please refer to machine head instructions -LK1900BN Series)**



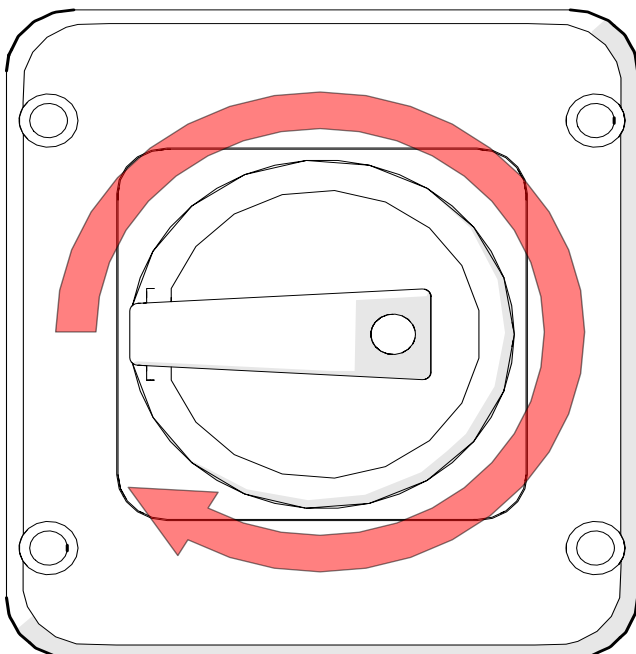
4.2) Threading the machine. (Please refer to machine head instructions – LK1900BN Series)



4.3) Remove the cover.



4.4) Switch on the machine.



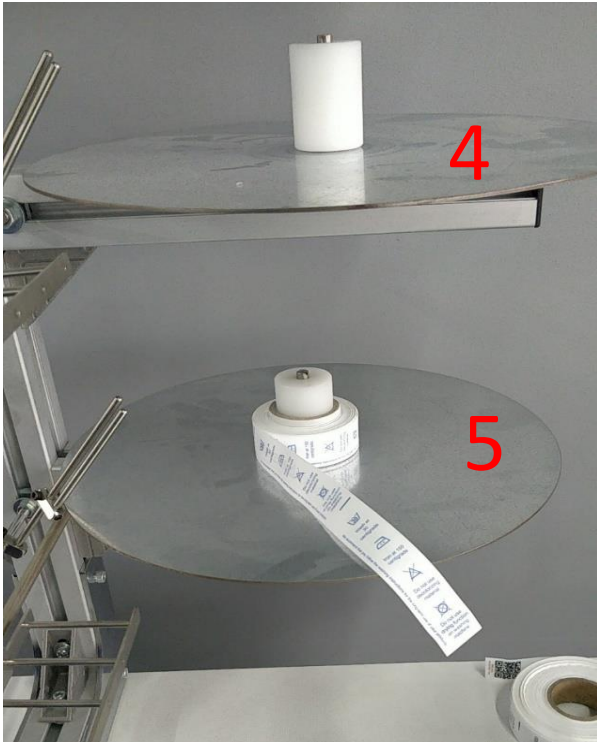
4.5) Enter Automatic mode.



4.6) Measure the distance between the two sensor lines on the labels.



4.7) First, the label roll should be placed at the lowest (bottom) stand.

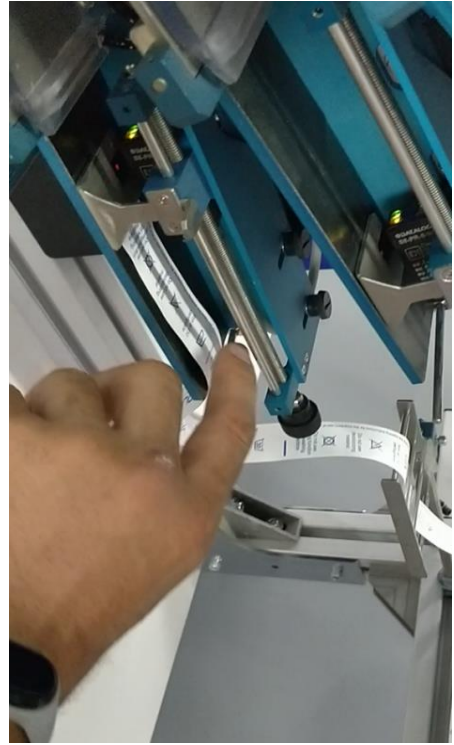


Subsequently, the label placing principle should be starting from the lowest one and place the other label at the one level upper one. Until all five stands have their label rolls.

4.8) Second, place the label in order according to the images.



4.9) Third, place the label in order according to the images.



4.10) Entering the measured label length.

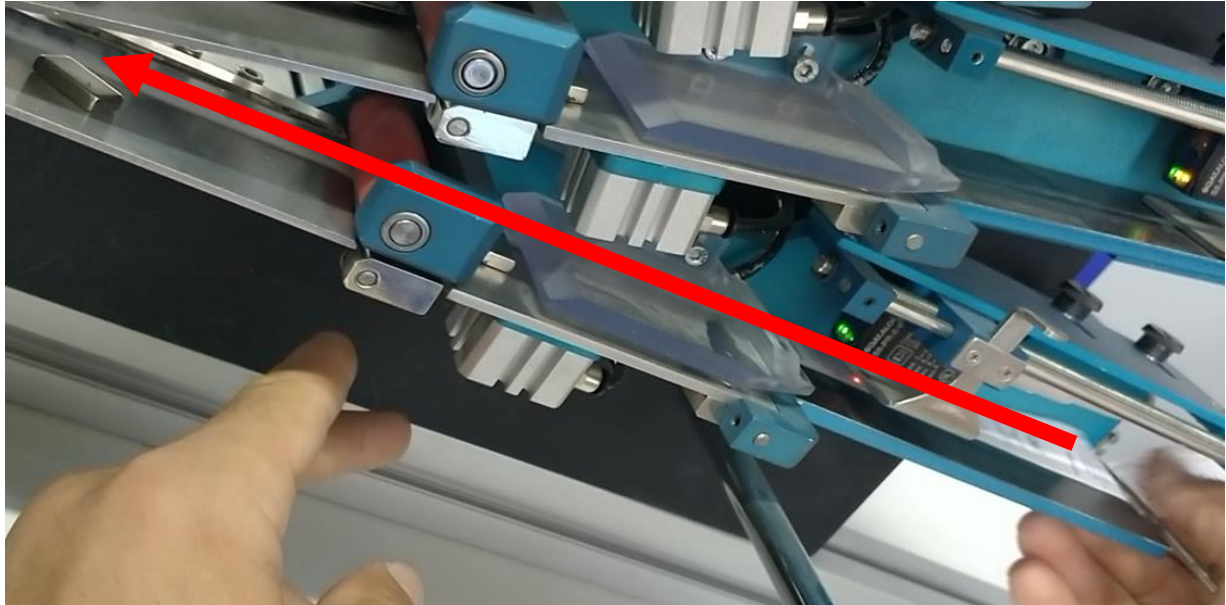


Please click on the measurement on the placed label and enter your measured value.

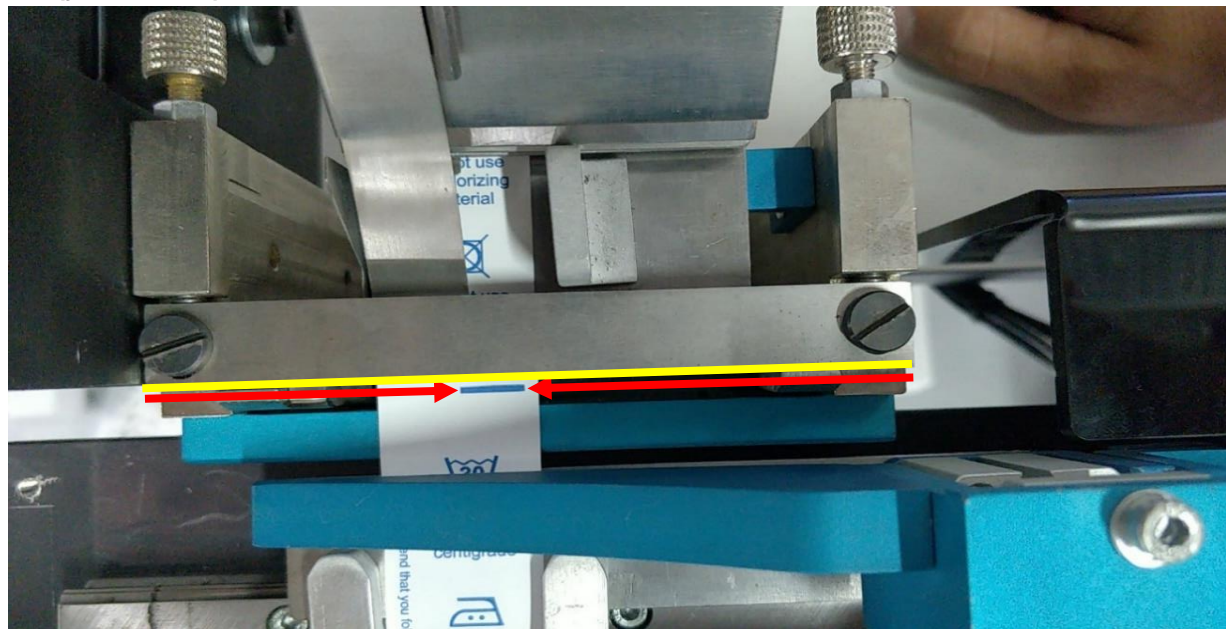
4.11) Active air blowing with click label placement.



4.12) Place the label in the direction of arrow.

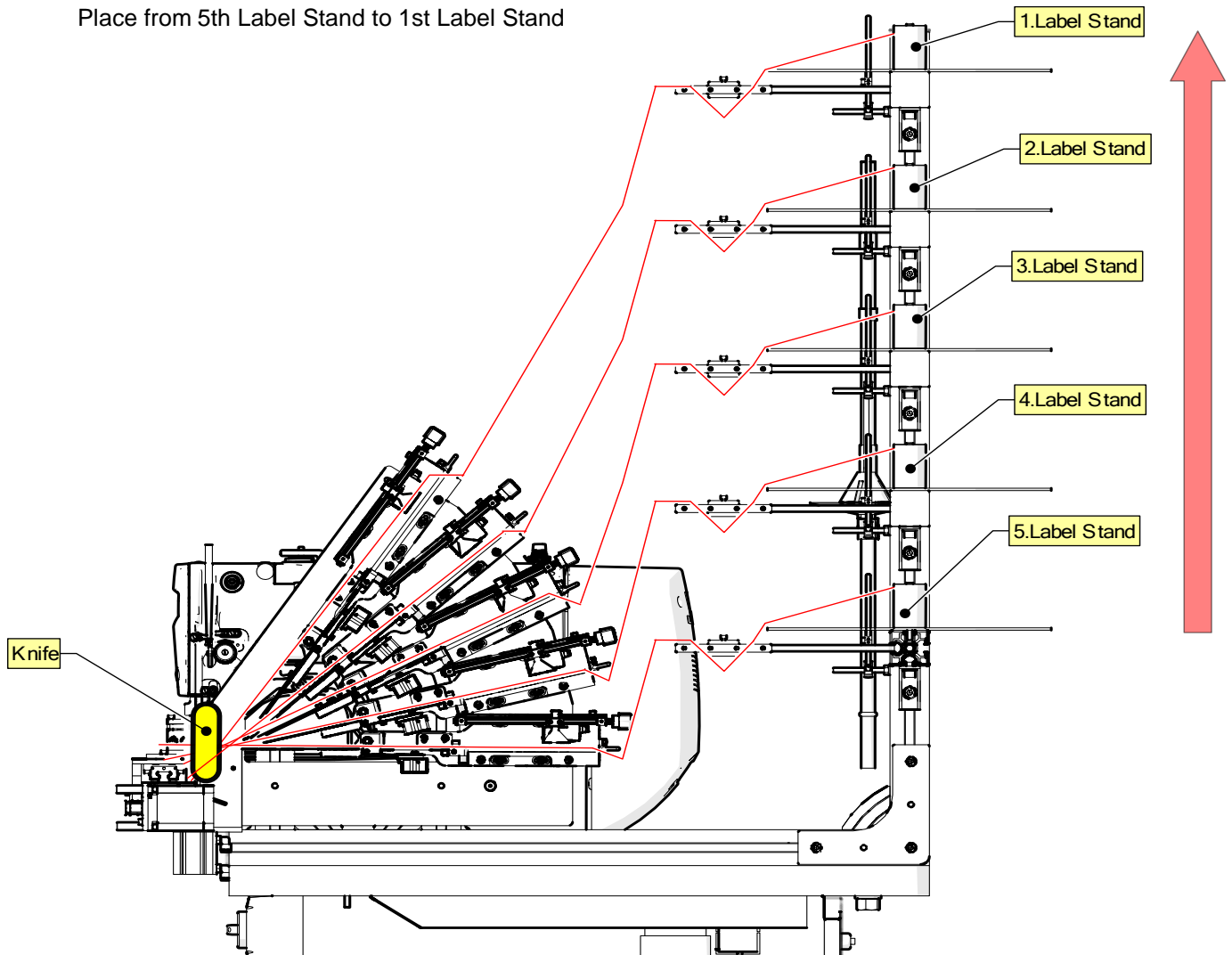


4.13) Place the sensor line(between the red arrows) on the label until it is in front of the knife line(yellow line).



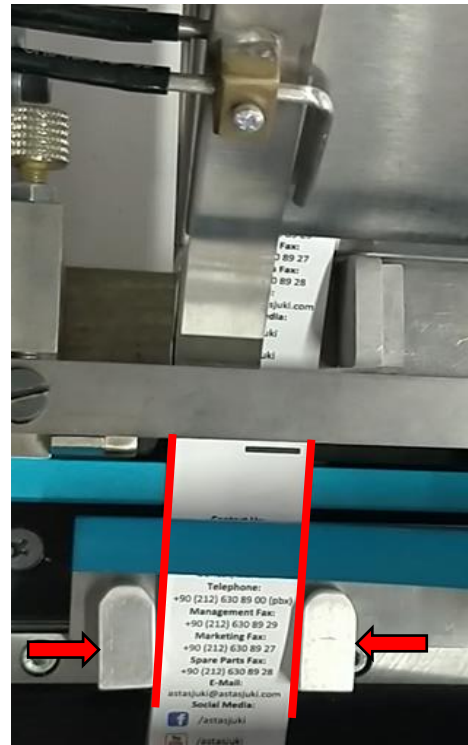
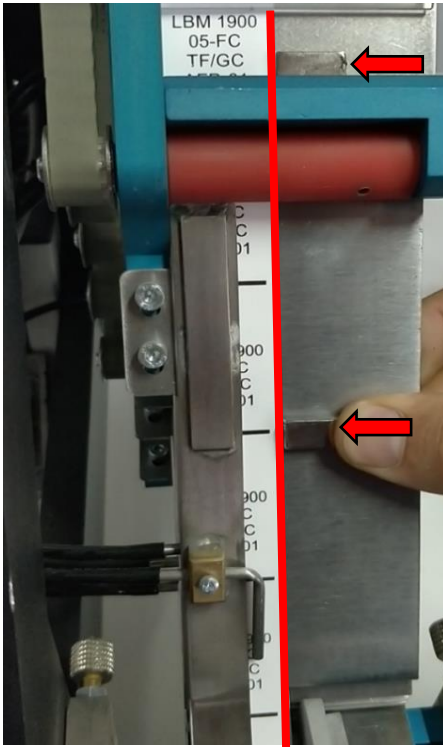
4.14) Place the other label rolls(According to from 4.5 to 4.13).

Place from 5th Label Stand to 1st Label Stand

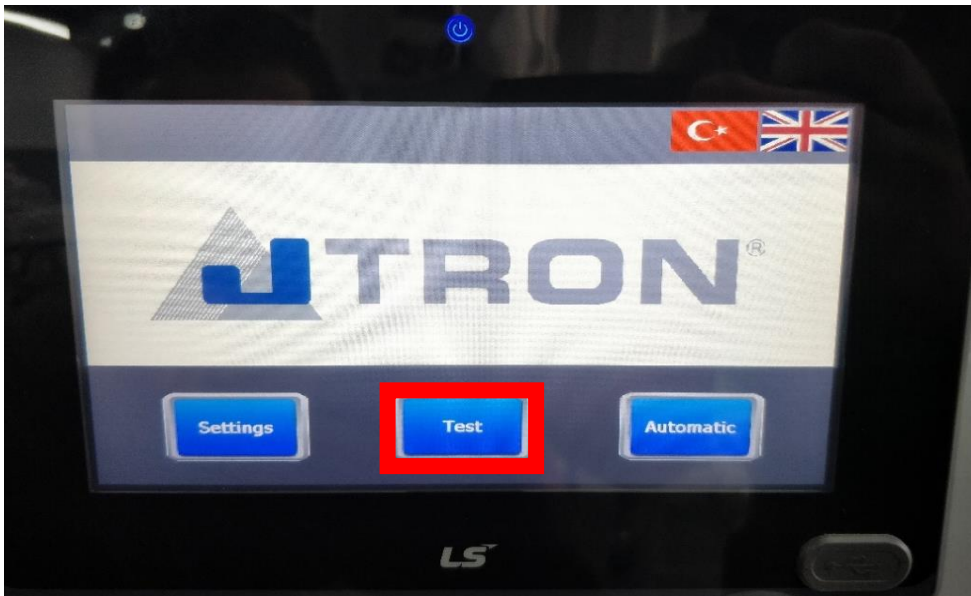


Subsequently, the label placing principle should be starting from the lowest one and place the other label at the one level upper one. Until all five stands have their label rolls.

4.15) Adjust the magnets to align the labels.

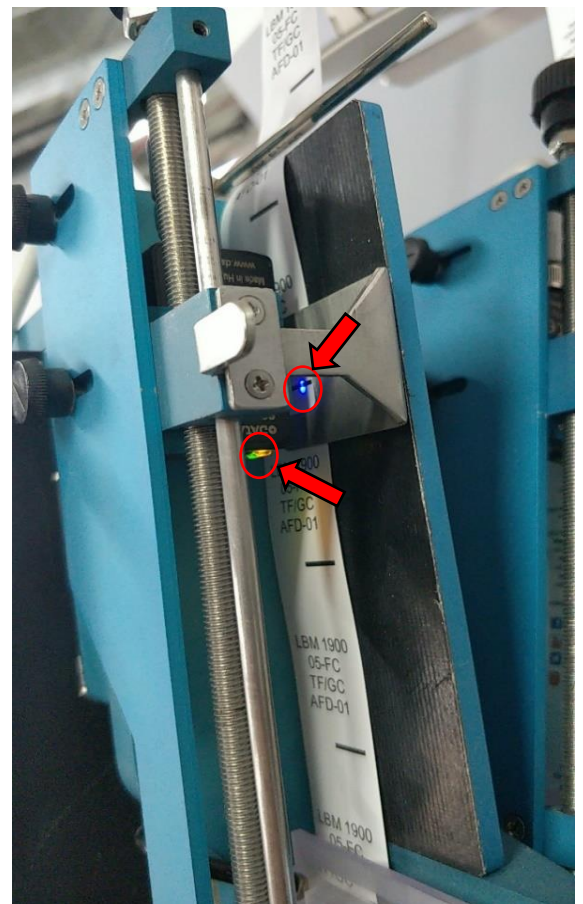
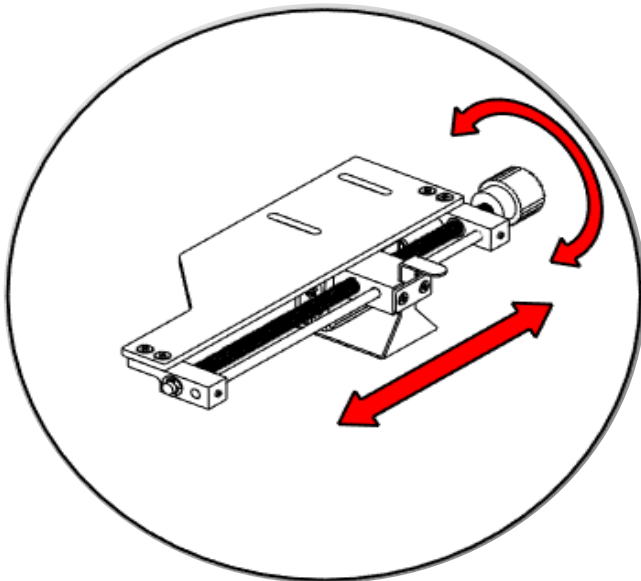


4.16) Enter test mode.

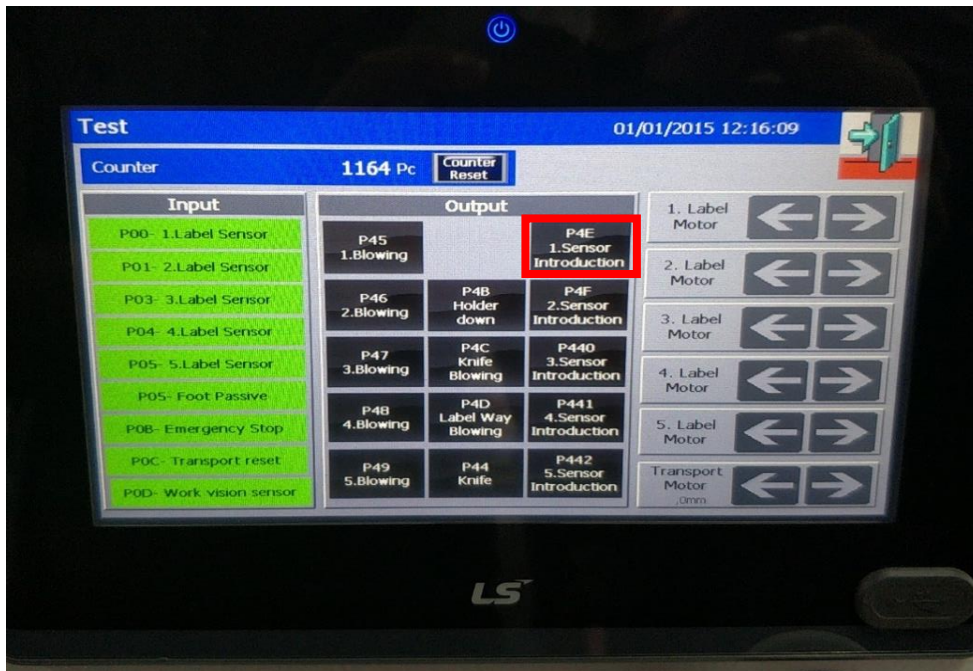


4.17) Identify the label to sensor..

4.17.1) Turn the adjustment screw to the right or left to bring the sensor light above the sensor line.
Make sure that both (green and yellow) colored lights on the sensor are on.

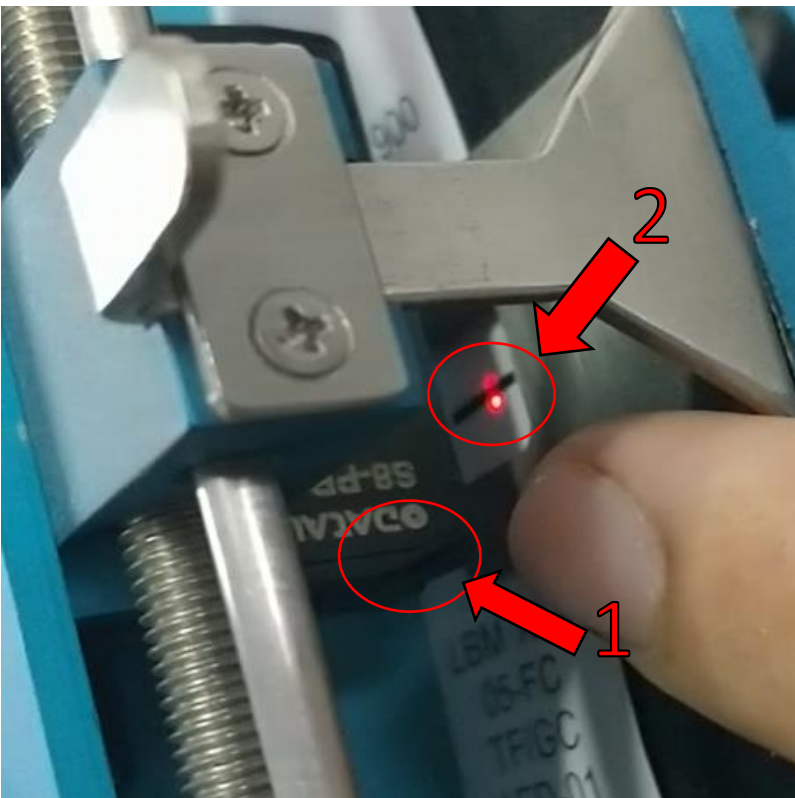


4.17.2) Identify the label to sensor.

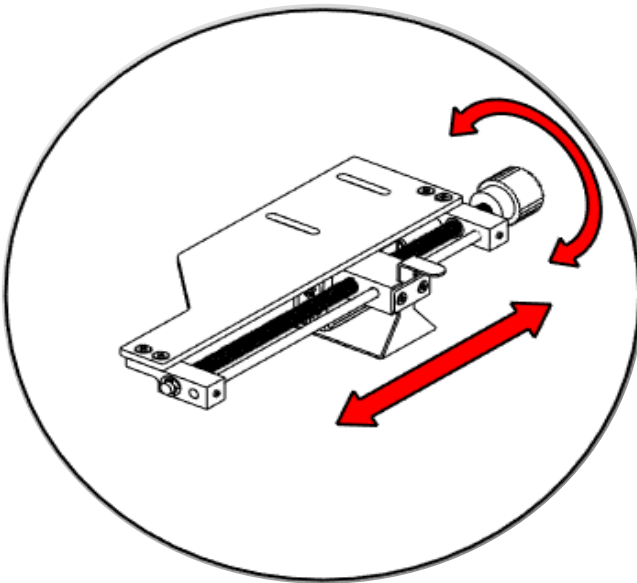


Press and hold the "P4E 1st Sensor Introduction" button for 3 seconds.

Make sure that both (green and yellow) colored lights on the sensor are off and the light on the label line is red as it shown with 2nd arrow.



4.17.3) Identify the label to sensor.



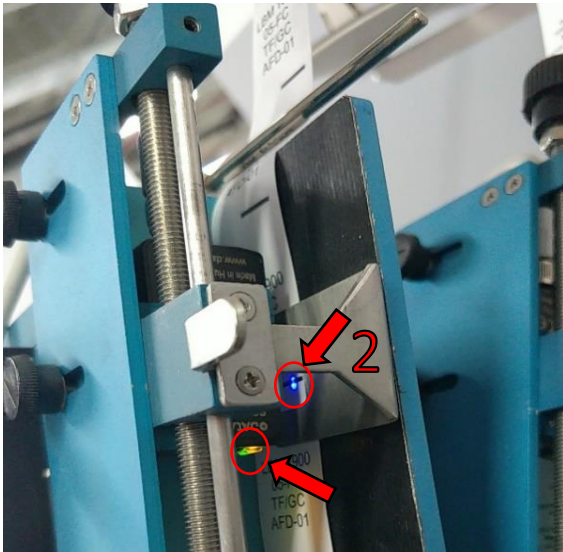
Turn the adjustment screw left or right to move the sensor point to the white (blank) area of the label.



Press and hold the "P4E 1st Sensor Introduction" button for 1 seconds.

Make sure that the green light on the sensor is on and the blue light is reflected on the label.

4.17.4) Identify the label to sensor.

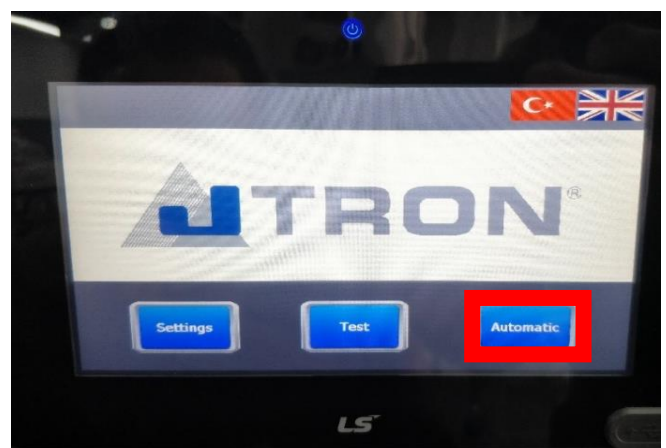


Make sure that both (green and yellow) colored lights on the sensor are off and the light on the label line is blue as it shown with 2nd arrow.

4.18) Identify the other labels to sensor.

Apply "4.15)" process to all other care labels one by one.

4.19) Enter Automatic mode.



4.20) Cut the label.



4.21) Adjust the label quantity.



Turn the label feed motor on or off as many labels as required.

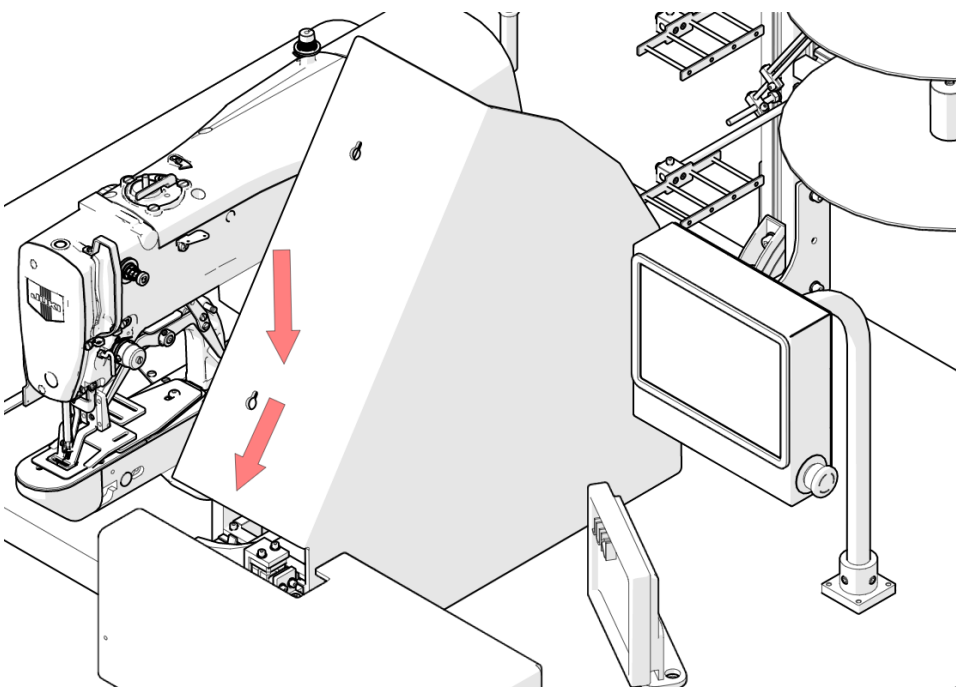
4.22) Activation of knife blowing .



Activation of knife blowing to open the gap between joined labels after the knife has cut the labels.

This operation is necessary for the label feeding system to transport the labels in different sizes.

4.23) Install the cover.



5) PANEL

5.1) Start Page



5.2) Settings Page - 1

Setting 1		05/10/2022 15:38:38
1- Sensor search deceleration distance (mm)	12.3	
2- Sensor search tolerance range(mm)	12.3	
3- Holder wait time	1234	
4- Knife wait time (ms)	1234	
5- Knife passive time (ms)	1234	
6- Knife blowing time (ms)	1234	
7- Label advance time (ms)	1234	
8- Waiting time of transport for stitch	123	


1- Sensor search deceleration distance (mm)	5- Knife passive time (ms)
2- Sensor search tolerance range (mm)	6- Knife blowing time (ms)
3- Holder wait time	7- Label advance time (ms)
4- Knife wait time (ms)	8- Waiting time of transport for stitch

5.3) Settings Page - 2

Settings 2

×

05/10/2022 15:41:08



9- Distance of transport for stitch	<div style="background-color: blue; color: white; padding: 2px 10px; border-radius: 3px;">123.4</div>
10- Transport speed (%)	<div style="background-color: blue; color: white; padding: 2px 10px; border-radius: 3px;">123</div>
11- Holder release delay (ms)	<div style="background-color: blue; color: white; padding: 2px 10px; border-radius: 3px;">1234</div>
12- Transport backward waiting time (ms)	<div style="background-color: blue; color: white; padding: 2px 10px; border-radius: 3px;">1234</div>
13- Transport back stop distance (mm)	<div style="background-color: blue; color: white; padding: 2px 10px; border-radius: 3px;">-123.4</div>

Settings
1

Fabric
setting

9 - Distance of transport for stitch	12 - Transport backward waiting time (ms)
10 - Transport speed (%)	13 - Transport back stop distance (mm)
11 - Holder release delay (ms)	Fabric setting : Factory Reset

5.4) Test Page



1 - Counter and Counter Reset		
2 - Input		
P00 - 1.Label Sensor	P04 - 4. Label Sensor	P0B - Emergency Stop
P01 - 2. Label Sensor	P05 - 5. Label Sensor	P0C - Transport reset
P03 - 3. Label Sensor	P05 - Foot Passive	P0D - Work vision sensor
3 - Output		
P45 - 1.Blowing		P4E - 1.Sensor Introduction
P46 - 2.Blowing	P4B - Holder Down	P4F - 2.Sensor Introduction
P47 - 3.Blowing	P4C - Knife Blowing	P440 - 3.Sensor Introduction
P48 - 4.Blowing	P4D - Label Way Blowing	P441 - 4.Sensor Introduction
P49 - 5.Blowing	P44 - Knife	P442 - 5.Sensor Introduction
4- Motor Movement Adjustment		
1.Label Motor	3.Label Motor	5.Label Motor
2.Label Motor	4.Label Motor	Transport Motor
5- Quit Page		

5.5) Automatic Page

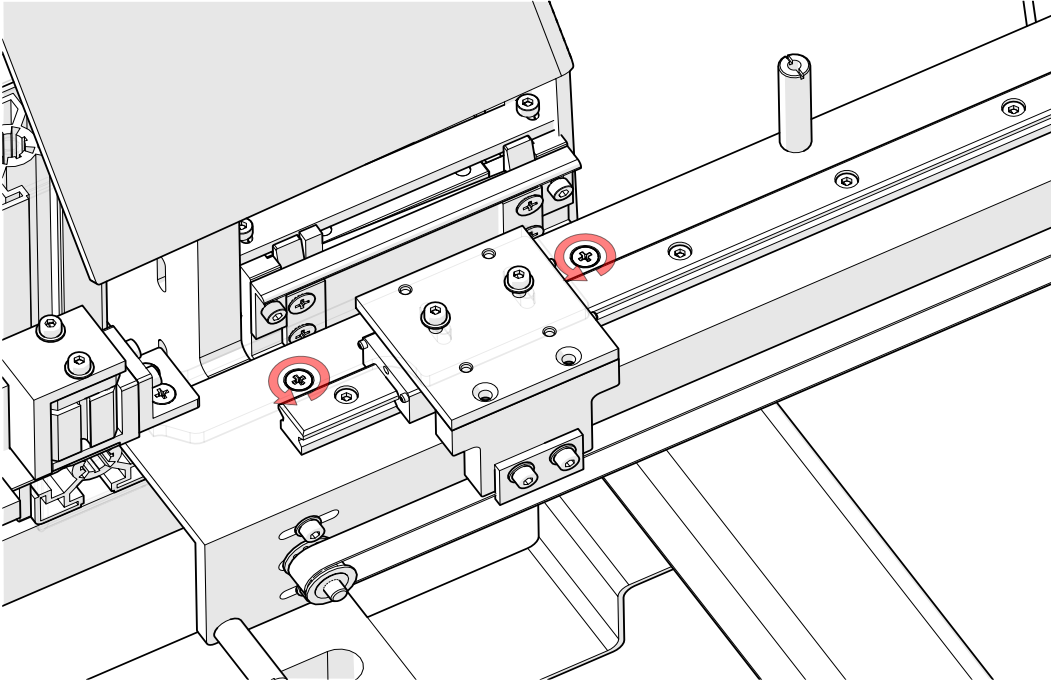


1 - Alarm On / Off - Counter Reset
2 - Knife On / Off
3 - Transport On / Off
4 - 1.Label measure (mm)
5 - 2.Label measure (mm)
6 - 3.Label measure (mm)
7 - 4.Label measure (mm)
8 - 5.Label measure (mm)
9 - Start
10 - Sensor 1 On / Off
11 - Sensor 2 On / Off

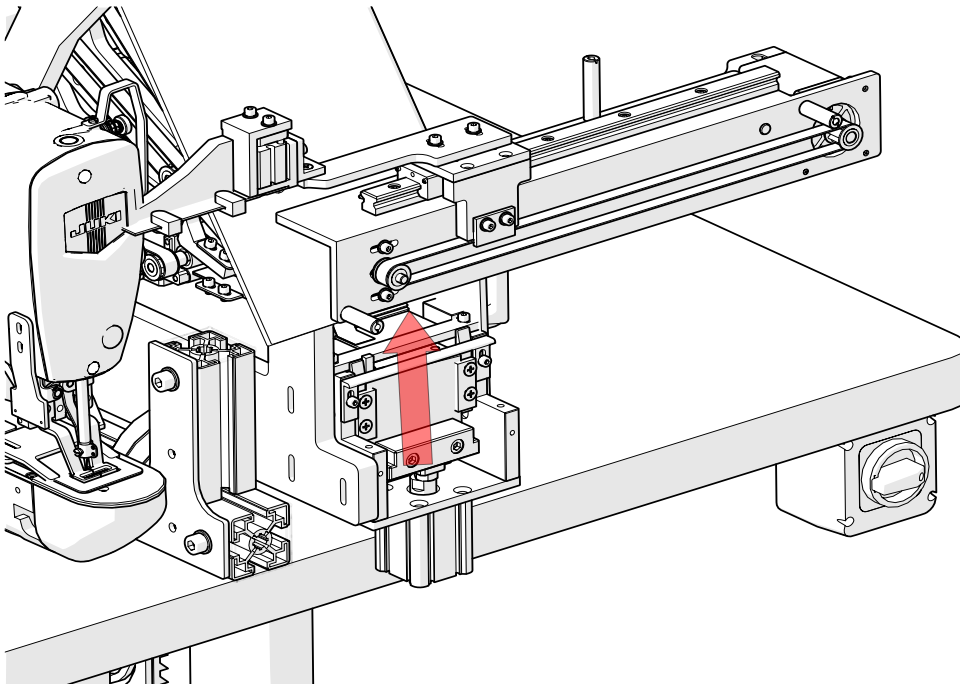
12 - Sensor 3 On / Off
13 - Sensor 4 On / Off
14 - Sensor 5 On / Off
15 - Label Placement (1)
16 - Label Placement (2)
17 - Label Placement (3)
18 - Label Placement (4)
19 - Label Placement (5)
20 - Reset
21 - Manuel Knife
22 - Knife Blowing

6) ADJUSTMENT

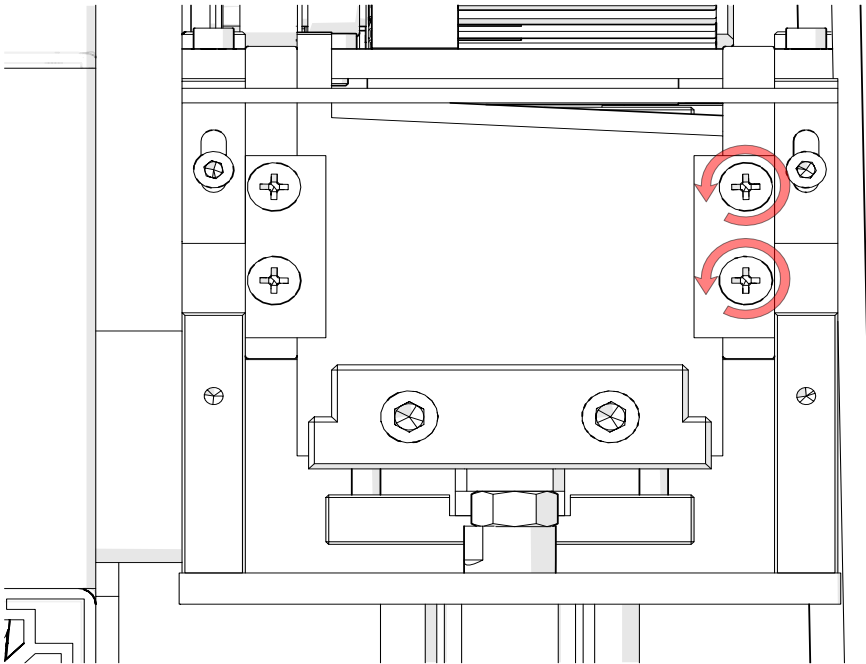
6.1) Changing the knife



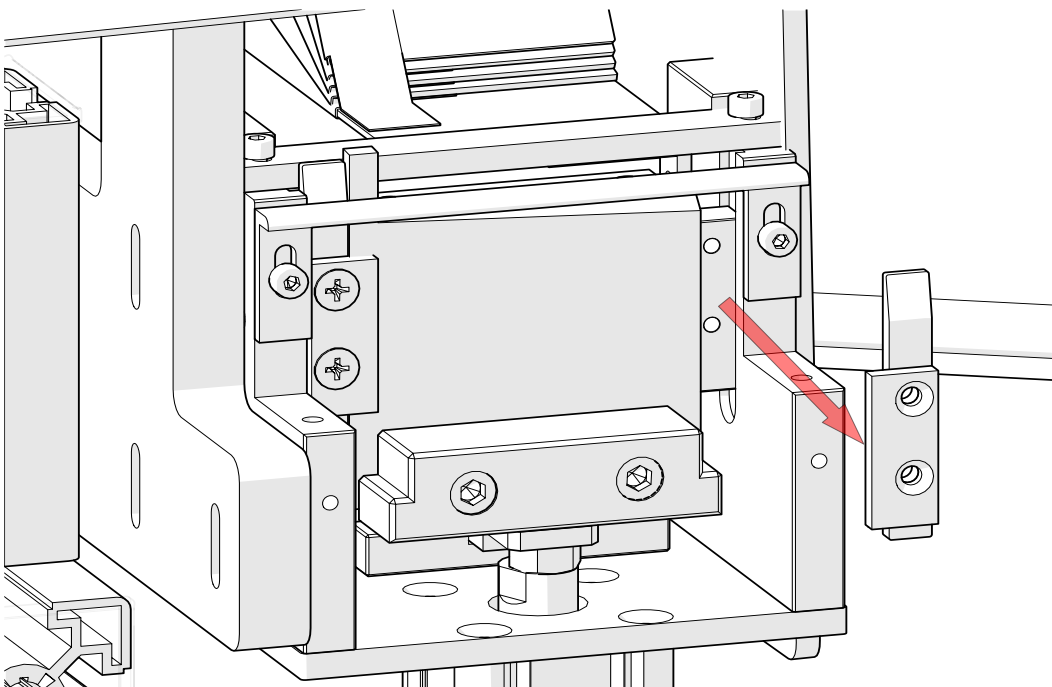
Remove the screws.



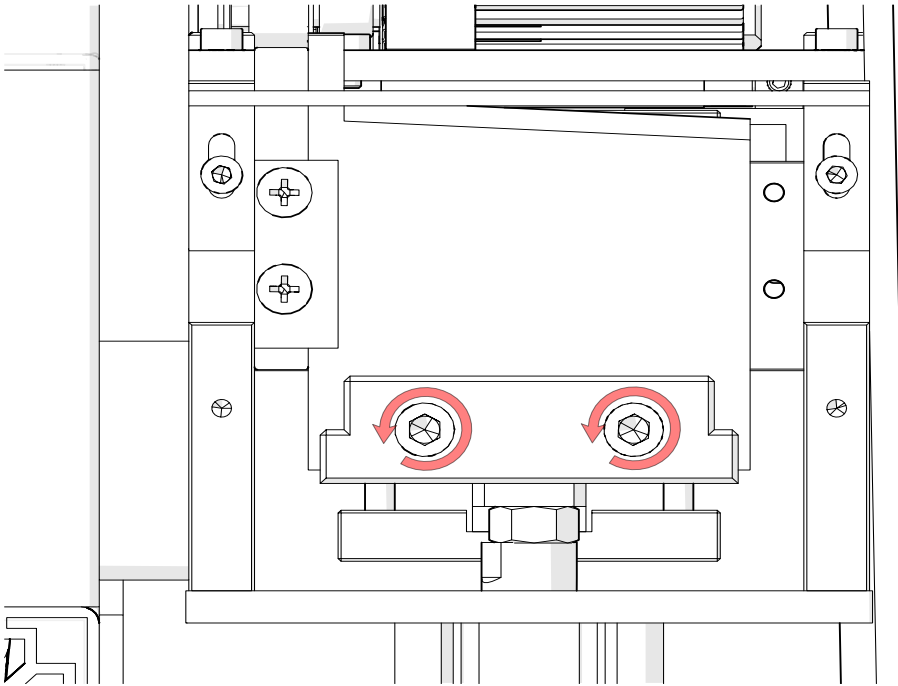
Remove the label transport group.



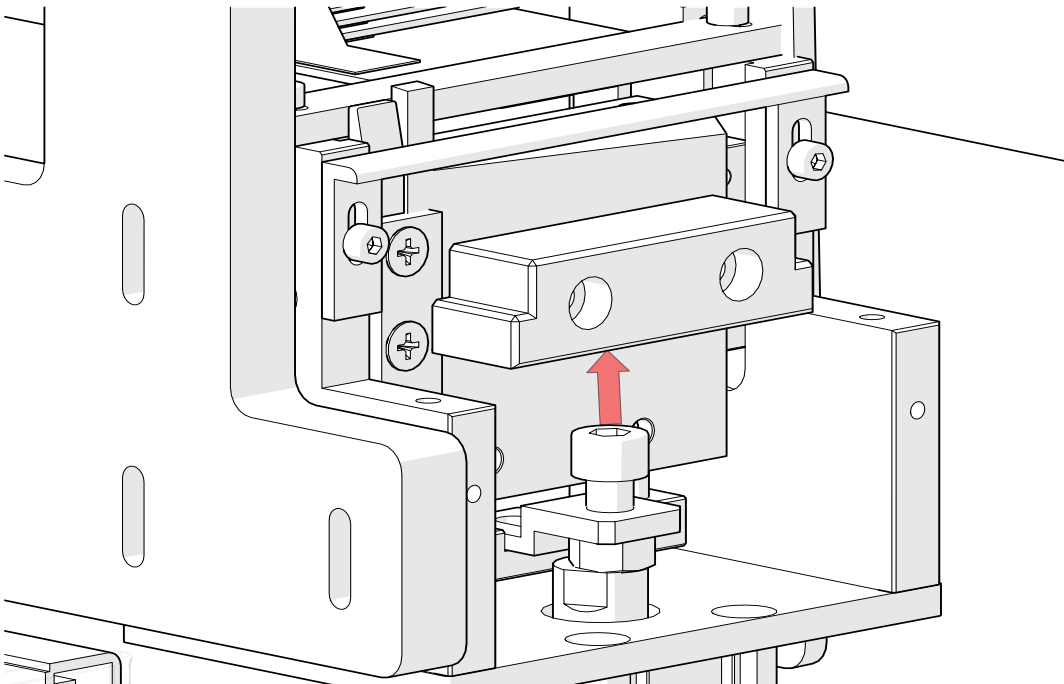
Remove the screws.



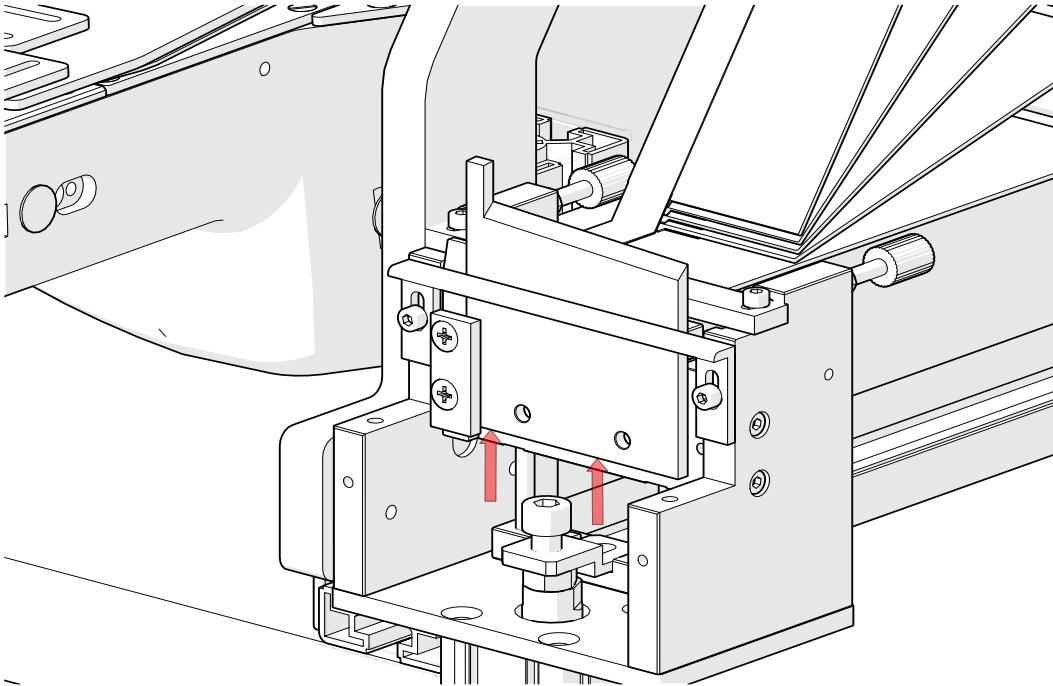
Remove the knife aligner.



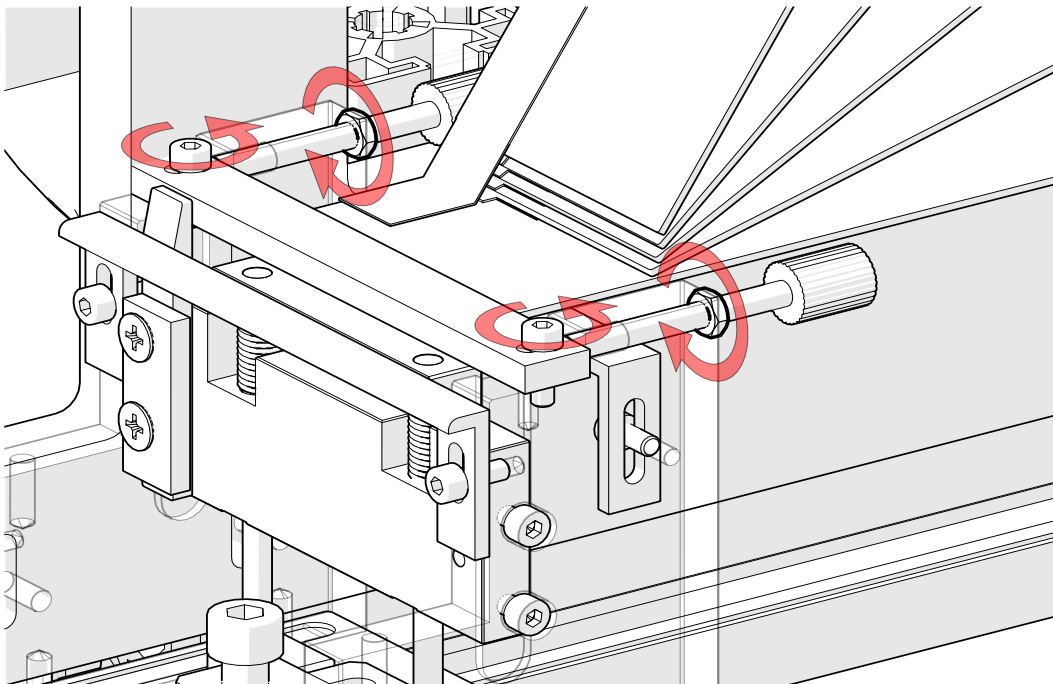
Remove the screws.



Remove the Cylinder Booster Part.

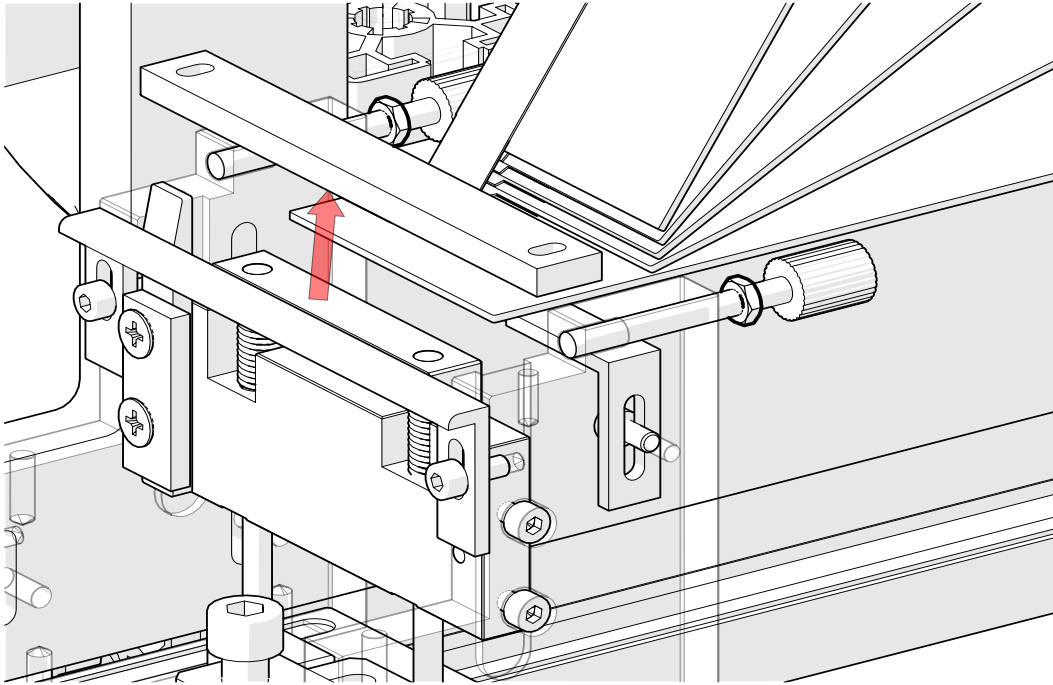


Remove the lower knife.

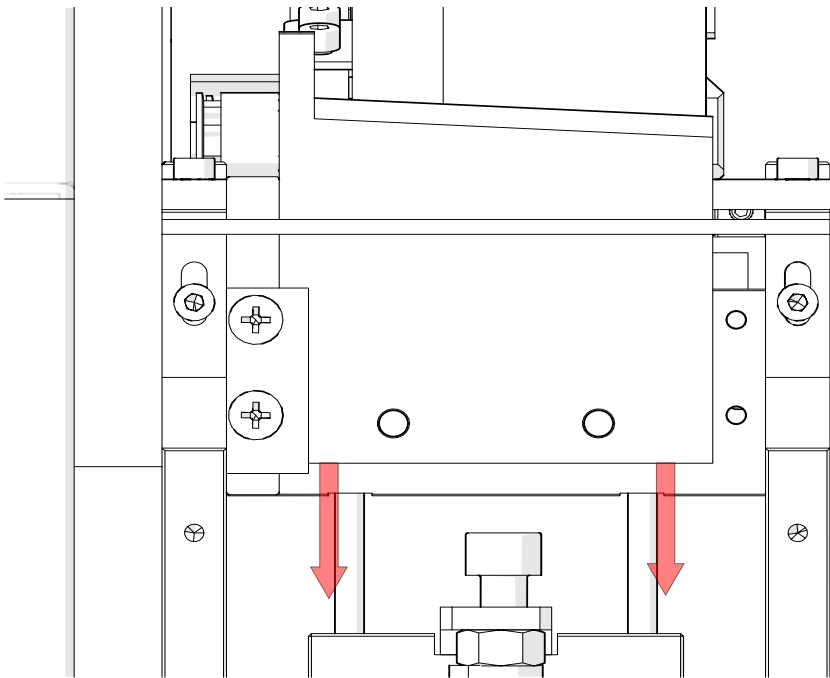


Loosen the nuts.

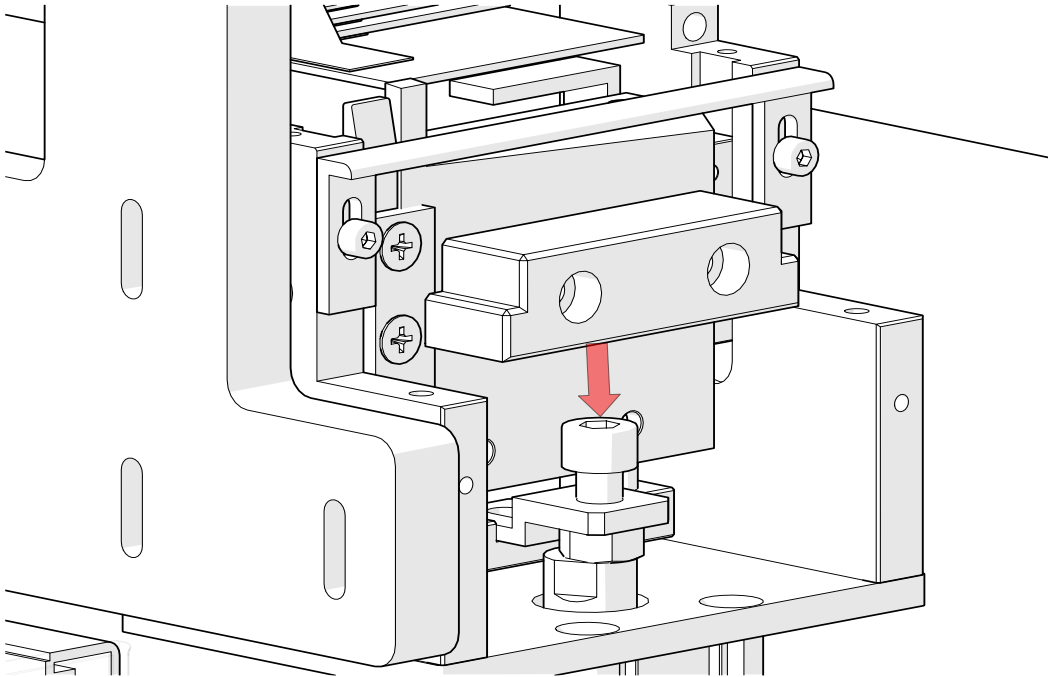
Remove the screws.



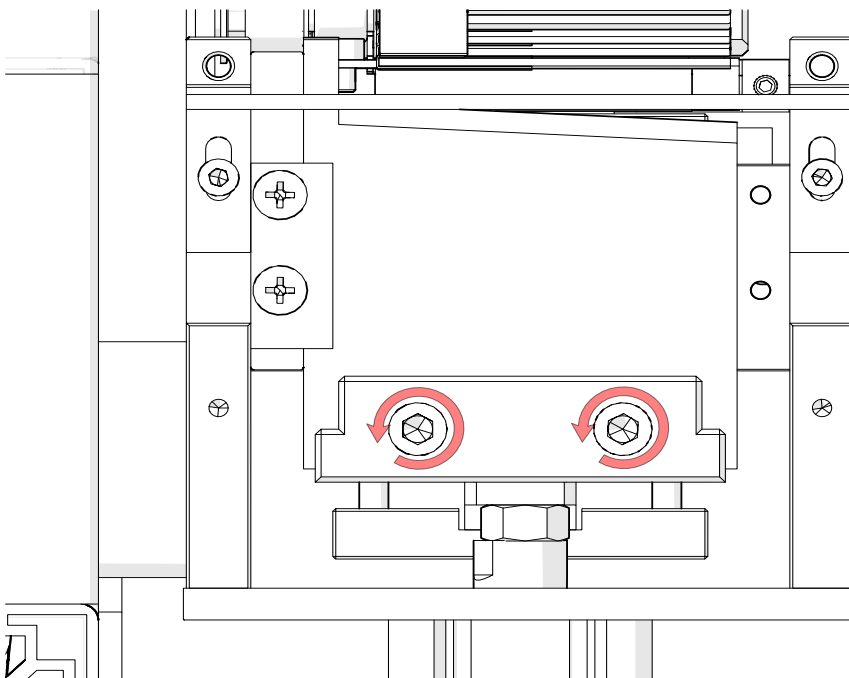
Remove the upper knife.



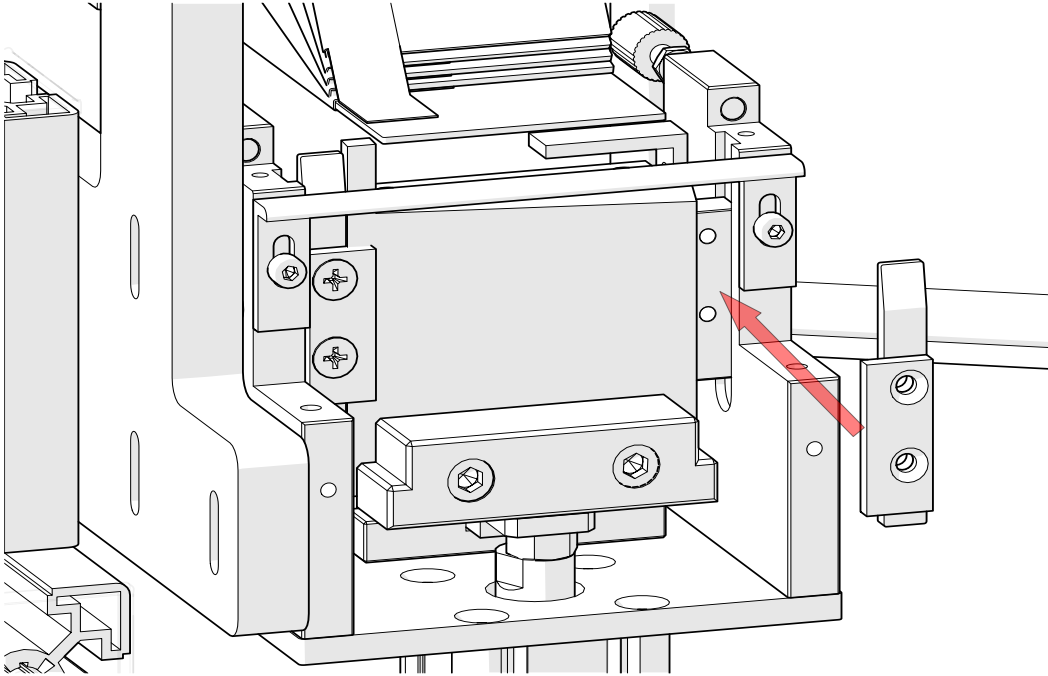
Install the lower knife.



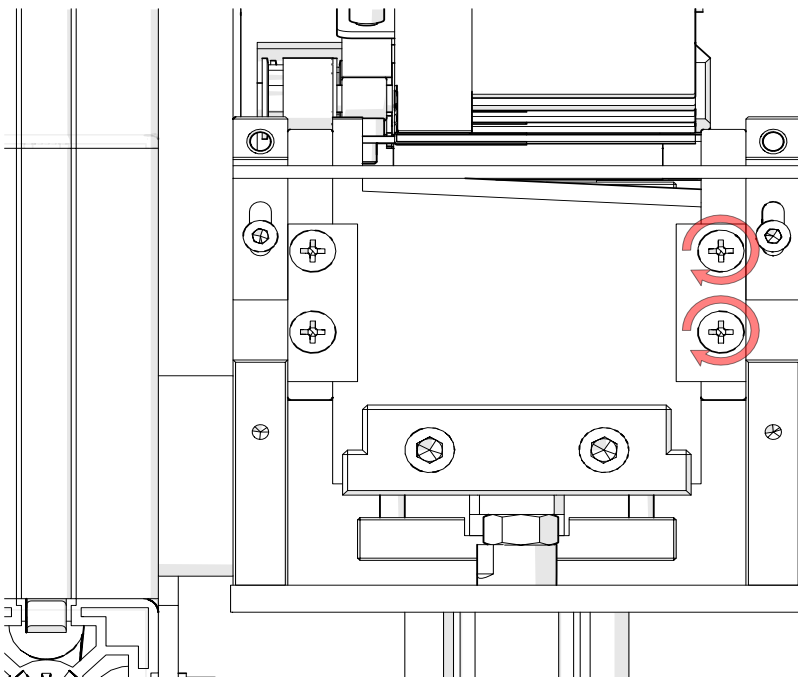
Install the Cylinder Booster Part.



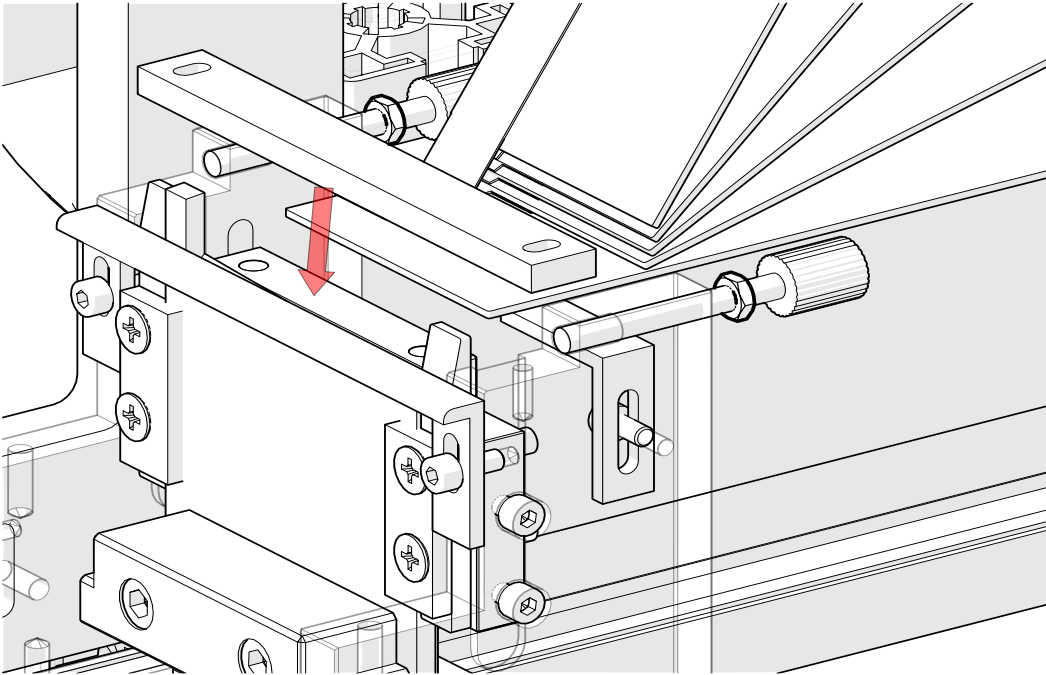
Tighten the screws.



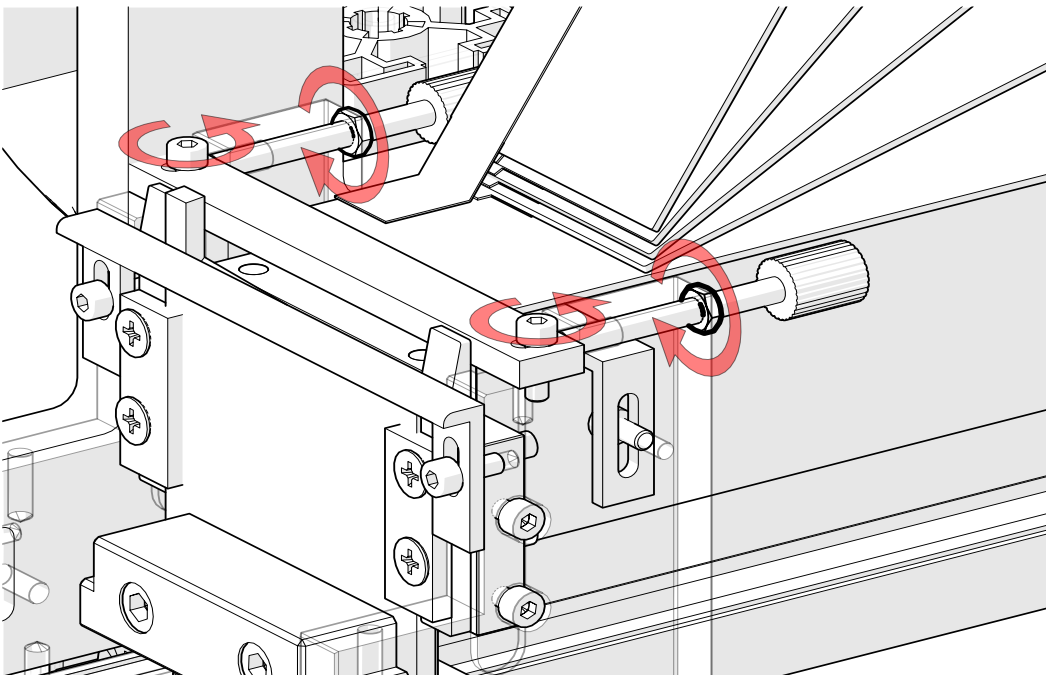
Install the knife aligner.



Install the screws.



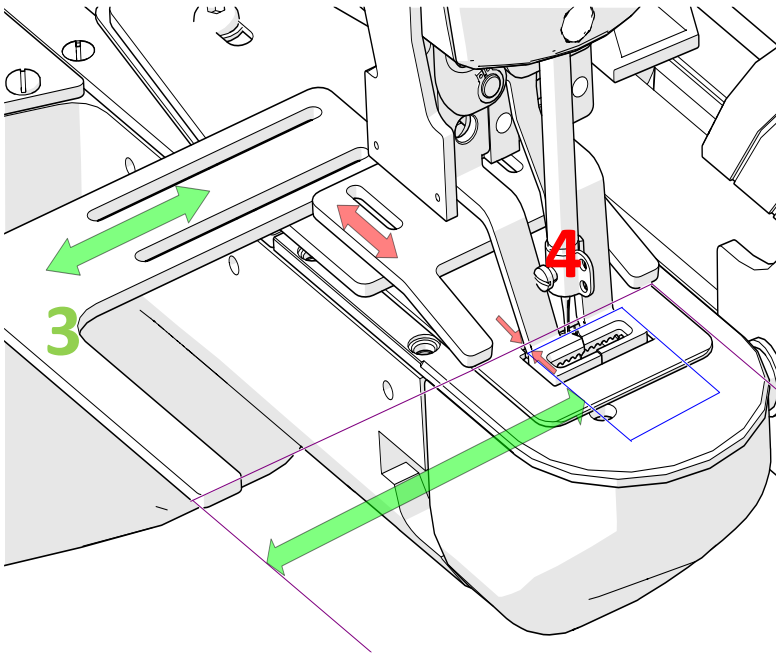
Install the upper knife.



Install the screws.

Tighten the nuts.

6.2) Adjustment of the position of the label on the fabric.

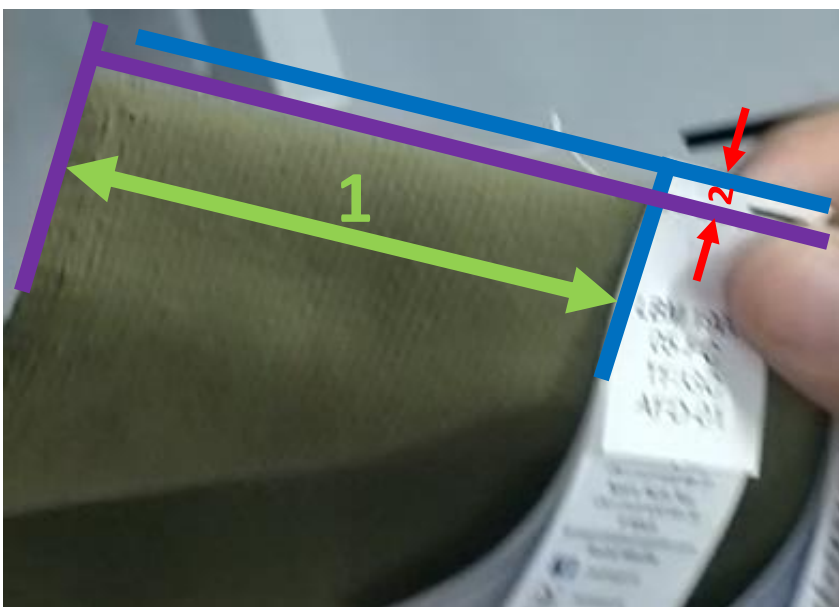


If you want to adjust the distance (1) from where the fabric begins to where the label begins.

Adjust the measure guide(3) to the desired size by sliding it left or right and fix it.

If you want to adjust the distance (2) between the fabric and the peak of the label.

Adjust the supporting guide(4) to the desired size by sliding it forward or backward and fix it.



7) LIST OF PATTERN DATA(SHIPPING VALUES)

Setting 1 01/01/2015 12:00:31

1- Sensor search deceleration distance (mm)	3.0
2- Sensor search tolerance range(mm)	4.0
3- Holder wait time	150
4- Knife wait time (ms)	100
5- Knife passive time (ms)	100
6- Knife blowing time (ms)	700
7- Label advance time (ms)	900
8- Waiting time of transport for stitch	200

Settings 2

Settings 2 01/01/2015 12:00:37

9- Distance of transport for stitch	239.0
10- Transport speed (%)	80
11- Holder release delay (ms)	150
12- Transport backward waiting time (ms)	100
13- Transport back stop distance (mm)	0.0

Settings 1

Fabric setting

8) CAUSES AND COUNTERMEASURES

Q.1) The labels are jammed and not feeding.

A1) Re-place the label, re-identify the label to the sensor, check the alignment magnets and feed motors.

Q.2) The label is not sewn in the desired position.

A2) Please check the positions of supporting guide and measure guide.

9) DISPOSAL OF BATTARIES



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.

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. POLECZKI 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

