

Bottom Hemming Automat

JTR-MF7923 / BHA Series

INSTRUCTION MANUAL



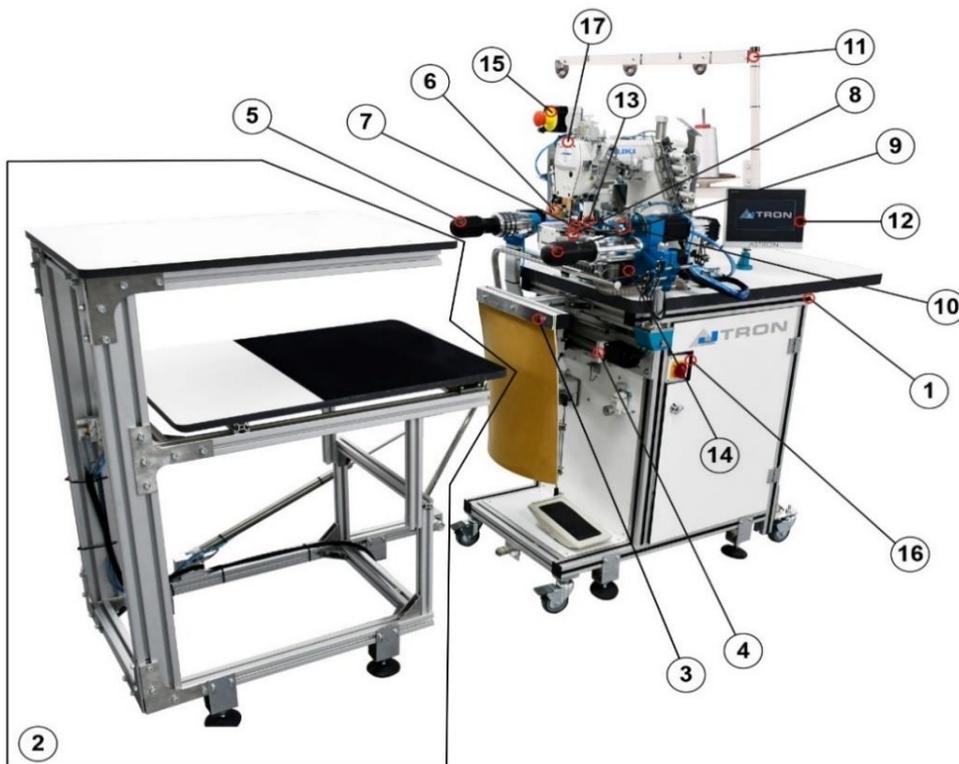
No.JTR001

MF7923BHA-TM

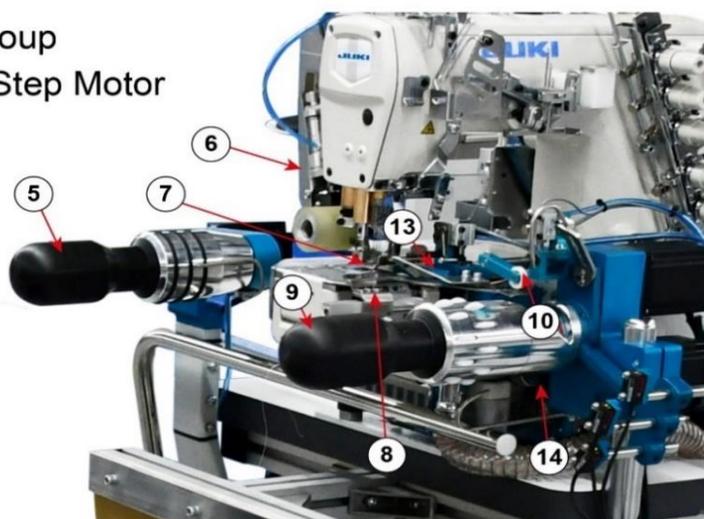
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1) CONFIGURATION OF THE MACHINE



1. Chassis Group
2. Stacking Chassis Group
3. Stacking Holder Profile Group
4. Tension Control Unit with Step Motor
5. Tension Control Unit
6. Roller Group
7. Knife Group
8. Attachment Group
9. Fabric Transport Group
10. Additional Sensing Group
11. Thread Stand
12. Operating Panel
13. Fabric Transport Guard
14. Knife Group Complete Assembly
15. Emergency Stop Switch
16. Main Switch
17. Machine Head



2) SPECIFICATION

No.	Category	Description
1	MACHINE HEAD	MF7972H23 / MF7923DH23 / MF7923DH25
2	MODEL NAME	JTR-MF7923-BHA
3	MAIN MOTOR	EFKA AB221 DC1500 / 400W
4	MAIN MOTOR DRIVE	EFKA AB221 A5132 / 230V
5	MAXIMUM SEWING SPEED	Max: 5500 sti/min DELIVERY SPEED : 4500 sti/min
6	STITCH LENGTH	Min : 2mm Max: 3,5mm delivery stitch length : 2.5mm
7	NEEDLE TYPE	GB - UY128 - #11
8	GAUGE	Standard gauge - B56
9	HEMMING SIZE	Shipment value: 20mm (16,22mm is available by changing gauges) Up to 28 mm (special order)
10	SEWING AREA	35-78 cm
11	FABRIC CUTTING SYSTEM	EXTERNAL SERVO MOTOR CONTROLLED FABRIC EDGE TRIMMER SYSTEM
12	SEWING SPECIFICATIONS	THIN TO MEDIUM THICKNESS
13	TARGET PROCESS	Bottom Hemming
14	AIR PRESSURE	MIN: 0.45 MPa MAX: 0.7 MPa Standard: 0.6 Mpa
15	AIR CONSUMPTION	23 L / min
16	VOLTAGE CLASSIFICATION	Single-phase 200-240V/50Hz
17	CAPACITY	2400-3000 pcs/9h (1operator 1machine) 4500-5000 pcs/9h (1operator 2machine)
18	DAILY PIECE COUNTER	YES
19	POWER CONSUMPTION	1200 VA

3) INSTALLATION

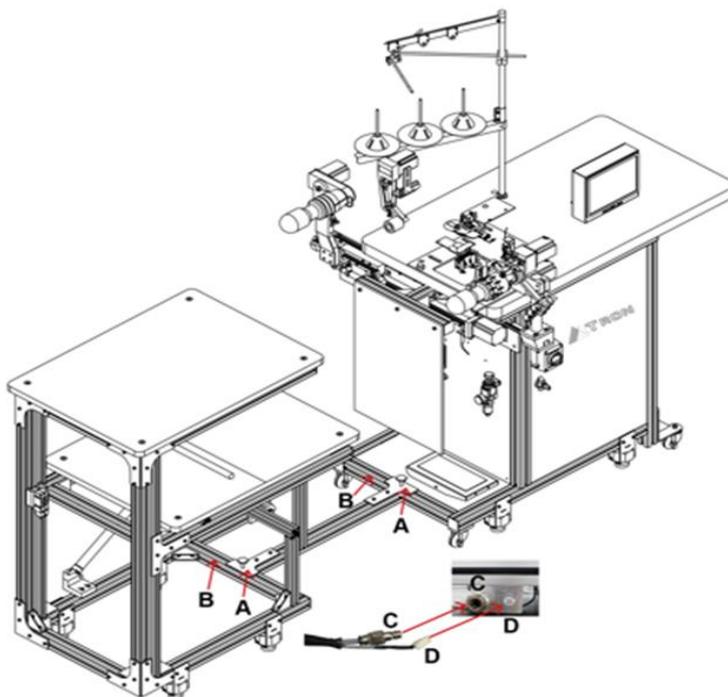
The machine is going to be delivered in 2 pieces in a wooden box. One piece is a stacking group and the other piece is bottom hemming automat.

In order to assemble it;

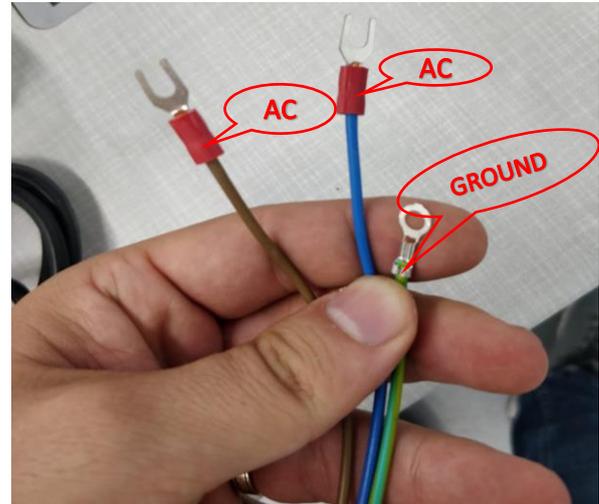
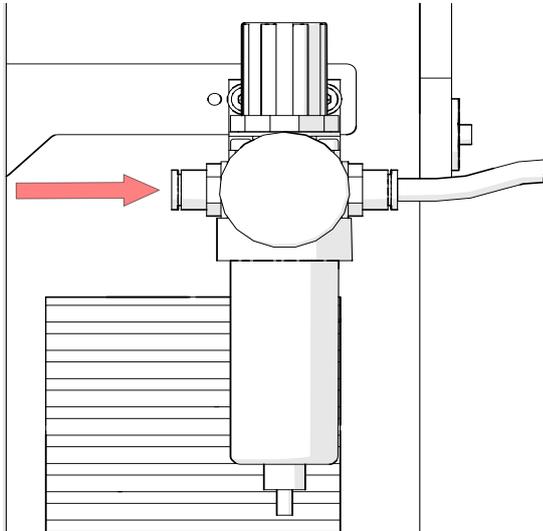
- 1) "A" and "B" should be fixed with screws.
- 2) "C" and "D" should be connected to each correspondent.
- 3) The lock plate indicated with "E" should be removed after the delivery. Since those stabilizing parts are for transportation purposes.

CAUTION!

While transporting the machine, parts indicated with "E" should be fixed to the machine. Do not forget to remove it before operation.

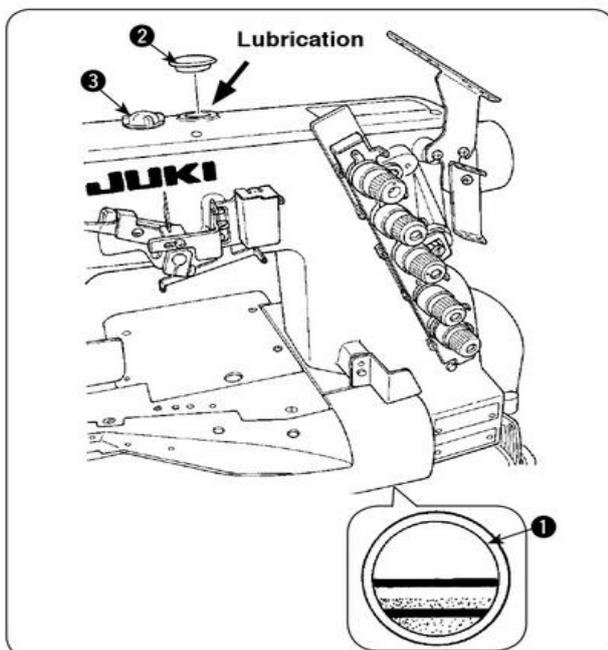


3.2) Connecting the air tube to the air regulator. 3.3) Connecting the power supply



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) Please put the Juki genuine oil 18 from the upper cover of the machine head. (Please refer to instructions for MF-7900 Series)



<When using the sewing machine for the first time>

Lubricating oil has been taken out at the time of delivery. Be sure to supply lubricating oil before using the sewing machine for the first time.

• Oil used : JUKI GENUINE OIL 18

Caution Do not use oil addition agent since deterioration of lubricating oil or machine trouble will be caused.

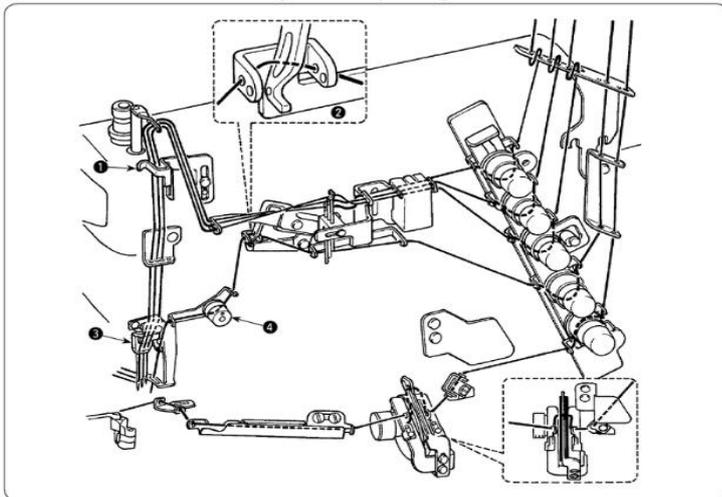
Remove oil hole cap ② on which "OIL" is indicated and fill the oil reservoir with lubricating oil up to the level between the upper and lower engraved marker lines.

<Checking before using the sewing machine>

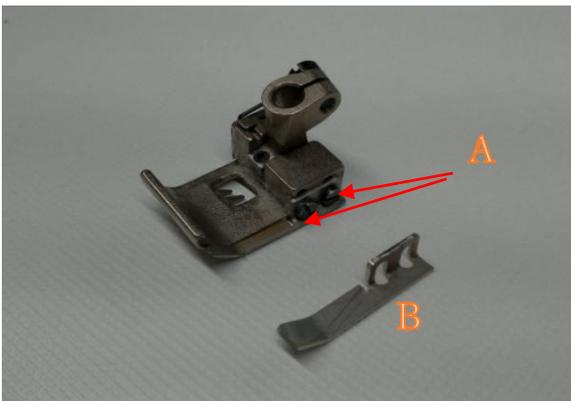
- 1) Check oil gauge ① and make sure that lubricating oil level is between the upper and lower two lines. When lubricating oil level lowers below the lower line, supply lubricating oil.
- 2) Make sure that lubricating oil comes out from the nozzle of oil circulation identification window ③ when rotating the sewing machine. When lubricating oil does not come out, perform

4) PREPARATION FOR OPERATION

4.1) Threading the machine. (Please refer to instructions for MF-7900 Series)



4.2) Select the presser width gauge which is shown in the below picture, according to the desired hemming width.



By loosening the “A” screws (2 pieces), the hemming width gauge can be replaced.

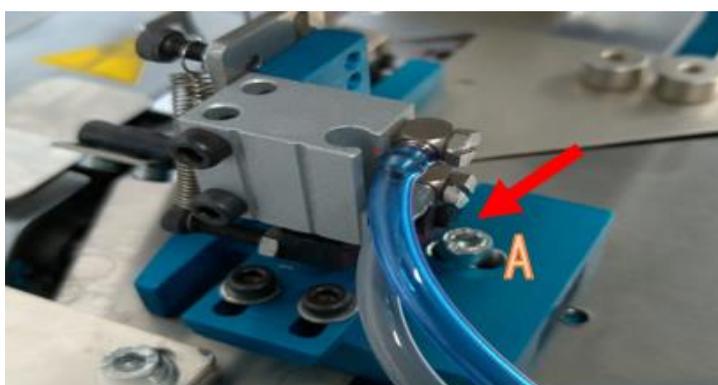
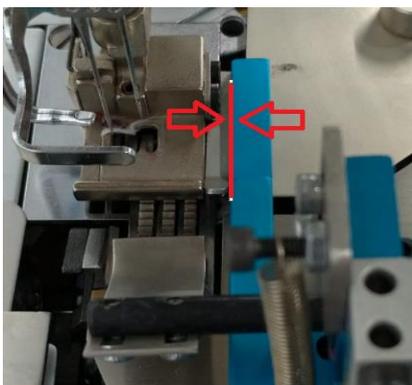
Gauge sized:

16mm: Without gauge

20 mm: Standard gauge (It has been assembled since delivery)

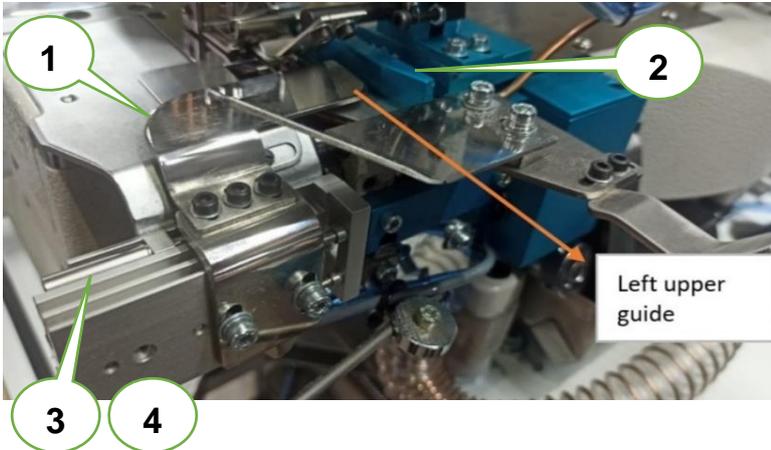
22 mm: Accessory bag

4.3) Align the edge guide to the hemming width gauge by the gap of 0.2 mm. The adjustments is done by the “A” screw.



4.4) The edge guard (1) adjustment

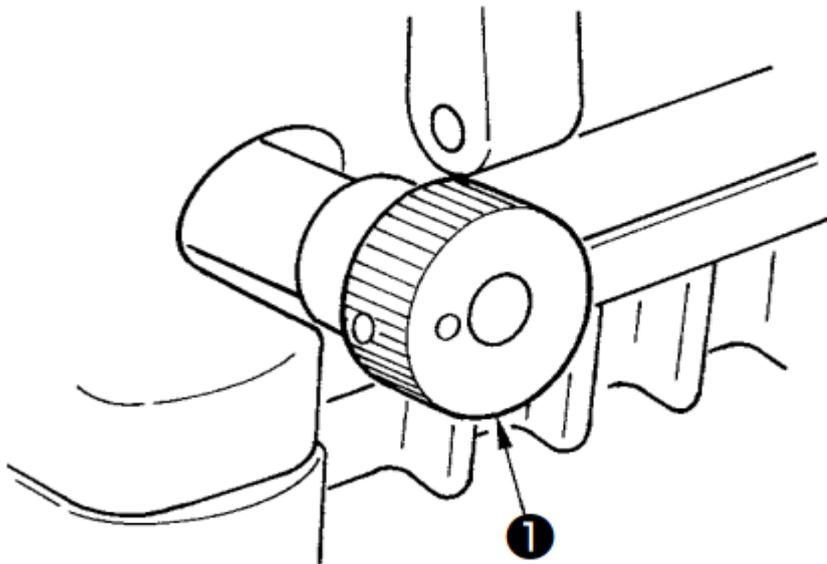
For edge guard (1), loosen the outer lock screw (3) and adjust the position with the inner adjustment screw (4). After adjustment, tighten the outer lock screw (3).



Important note; The gap between the edge guard and the edge guide should be adjusted with the minimum space that the side overlock seam passes without getting stuck between the guard and the edge guide. In case of bad adjustment:

- If the gap is too small, the side seam gets stuck between the guard and edge guide. The machine cannot feed the fabric properly.
- If the gap is too big, the sewing line cannot be straight.

4.5) The desired stitch length could be set from instructions for MF-7900 Series.



The stitch length can be infinitely adjusted from 0.9 mm to 3.6 mm.

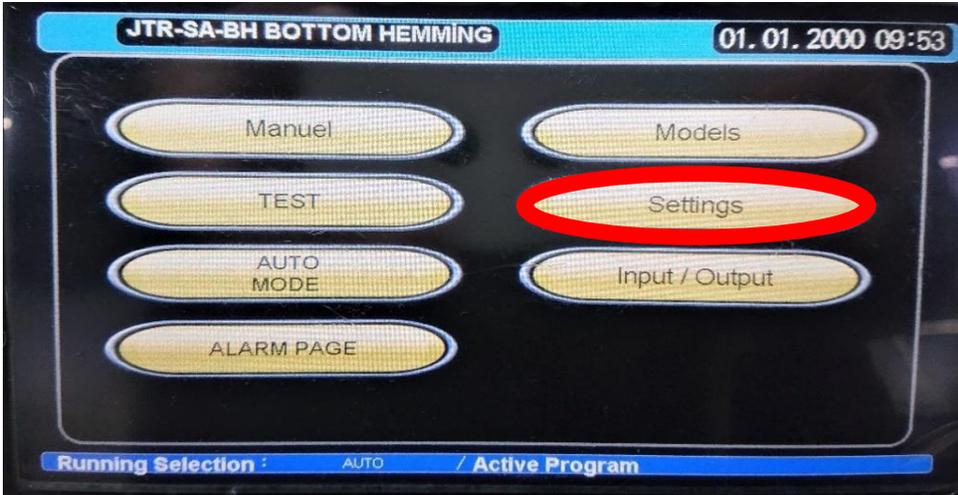
The actually sewn stitch length varies in accordance with kind and thickness of the materials.

How to change the stitch length ?

Turn clockwise feed regulating knob (1) to increase the stitch length.

4.6) The stitch length of the rollers and the width between the rollers could be adjusted from the setting page with below.

4.6.1) Select "Settings" in the Main menu screen.



4.6.2) First, select "Sewing Start" in the setting screen. Next, select "Settings" in this screen.

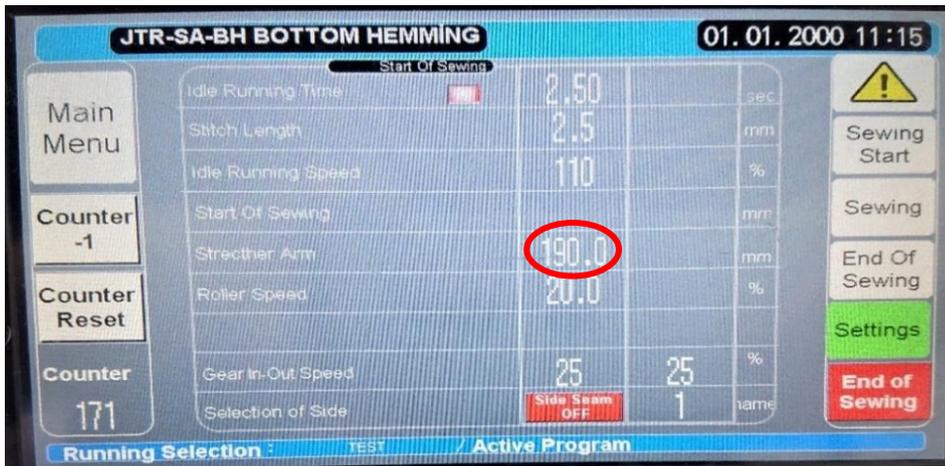


4.6.3) Select Stitch Length's number in the edit screen. Then, the numeric keypad screen will be displayed, so enter the value.



Note : Set both front and rear brake speed to match the speed of the sewing machine head.

4.7) Select Stretcher Arm's number in the edit screen. Then, the numeric keypad screen will be displayed, so enter the value.

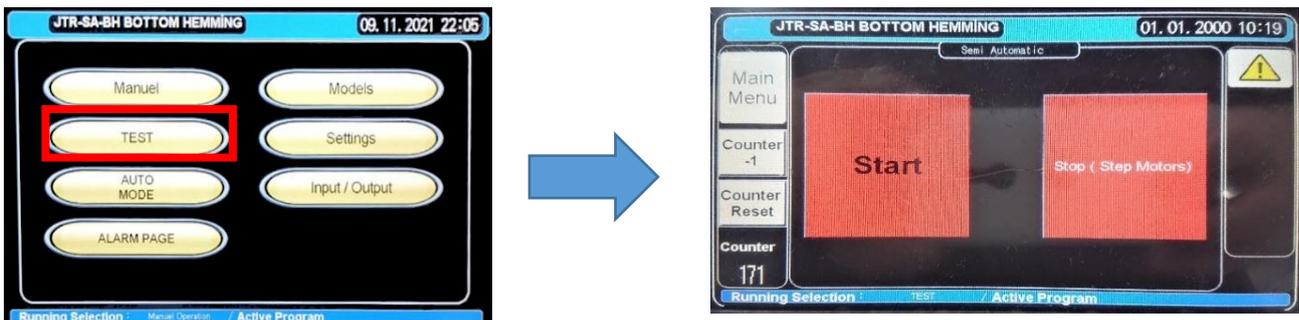


Note: The width adjustment should be done by stretching arm according to the fabric. The important point is in mind that the fabric should not be stretched neither too narrow nor too loose.

In case of improper adjustment:

- A. If the fabric is stretched while placing on to rollers, sewing quality will be effected and the bottom of the t-shirt will be deformed.
- B. If the fabric is placed too loose on to rollers, t-shirt will fall down from the machine while sewing

4.8) Check if the adjustment is correct by sewing the sample.



Enter in to the test page from the main menu and set the fabric to the machine.

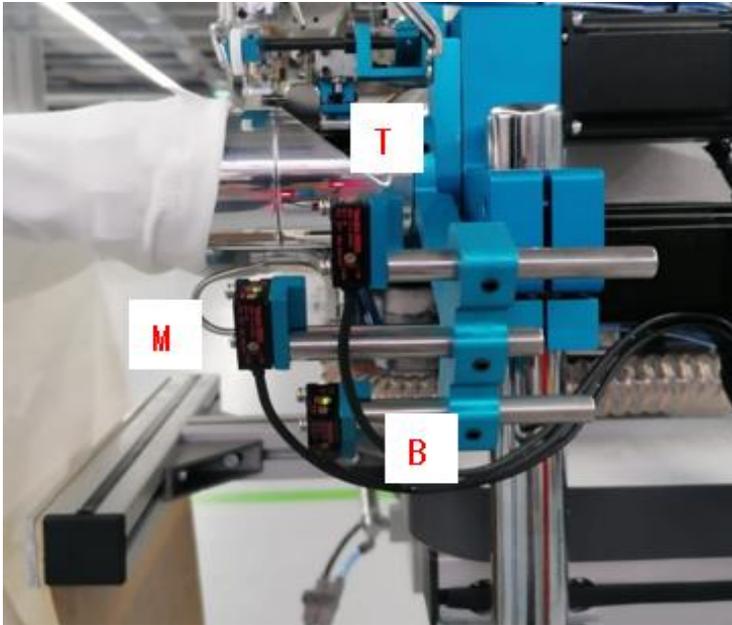
Subsequently, by pressing the start button the rotation of the fabric is started.

If the user detects any fault on the sewing sample, the guard positions should be readjusted (please see "6.5) BOTTOM HEMMING SETTING" for detailed adjustment procedure.)

4.9) If adjusting the guard does not solve the problem, adjust the sensor position.

Triple sensor must be adjusted according to fabric which will be sewn.

(Please see p.29 "6.2) Top, Mid and Bottom Sensor Adjustments" for detailed adjustment procedure.)



After adjustment of the triple sensors is completed, please make a test sewing.

5) PANEL

5.1) MAIN PAGE



Number	Item	Explanation	Remark
1	Manuel	To open to the Manuel Page	Ref; 5.2) MANUEL PAGE
		It is an individual manual operation.	
2	TEST	To open to the Test Page	Ref; 5.3) TEST PAGE
		It is a continuous manual operation and used in the pre-sewing test.	
3	AUTO MODE	To open to the AUTO MODE Page	Ref; 5.4) AUTO PAGE
		It is an automatic sewing mode and production display screen.	
4	ALARM PAGE	To open to the ALARM Page	Ref; 5.5) ALARM PAGE
		It is an error history screen.	
5	Models	To open to the Models Page	Ref; 5.6) MODEL PAGE
		It is available to choose from 19 models size.	
6	Settings	To open to the Settings Page	Ref; 5.7) SETTINGS PAGE
		It is available to set any parameter.	
7	Input / Output	To open the Input / Output Page	Ref; 5.8) INPUT/OUTPUT PAGE
		It is available to check the input and output.	

5.2) MANUEL PAGE



No.	Explanation	Remark
1	FABRIC FRONT ROLLER OPENING AIR	ref; 5.2.1)
2	FRONT FABRIC OPENER AIR PIPE CONTROL	ref; 5.2.2)
3	PRESSER FOOT LIFTING	ref; 5.2.3)
4	WIPER BLOWING	ref; 5.2.4)
5	ROLLER PISTON	ref; 5.2.5)
6	FABRIC SEPARATOR BLOWING & REAR MOTOR BLOWING	ref; 5.2.6)
7	SIDE SEAM PISTON	ref; 5.2.7)
8	VACUUM : UNDER TRIMMER	ref; 5.2.8)
9	FABRIC TOLERANCE SYSTEM	ref; 5.2.9)
10	STACKING 1 : SLIDE TABLE PISTON	ref; 5.2.10)
11	STACKING 2 : SEPERATE BAR PISTON	ref; 5.2.11)
12	EDGE GUARD CYLINDER	ref; 5.2.12)
13	MANUAL PEDAL FUNCTION CANCELLING	ref; 5.2.13)
14	FRONT MOTOR	ref; 5.2.14)
15	REAR MOTOR	ref; 5.2.15)
16	KNIFE MOTOR	ref; 5.2.16)
17	PLATEN MOTOR	ref; 5.2.17)
18	INWARD EDGE CONTROL	ref; 5.2.18)
19	OUTWARD EDGE CONTROL	ref; 5.2.19)
20	REAR STRECHING ARM MOVEMENT CONTROL : BACWARD	ref; 5.2.20)
21	REAR STRECHING ARM MOVEMENT CONTROL : FORWARD	ref; 5.2.20)
22	ERROR DISPLAY PAGE	ref; 5.2.21)
23	MAIN MENU	ref; 5.2.22)
24	COUNTER DECREASE	ref; 5.2.23)
25	COUNTER RESET	ref; 5.2.23)
26	DAILY COUNTER	ref; 5.2.23)
27	Front motor speed (Percentage of the set value)	setting of 5.3)
28	Rear motor speed (Percentage of the set value)	setting of 5.3)
29	Under-Trimmer Moving Speed (rpm)	setting of 5.3)
30	Rear motor speed (Percentage of the set value)	setting of 5.3)
31	Edge motor speed (Percentage of the set value)	setting of 5.3)

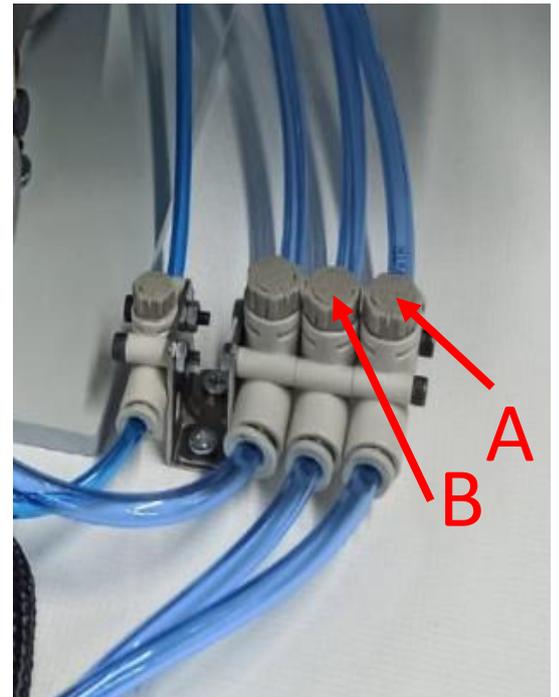
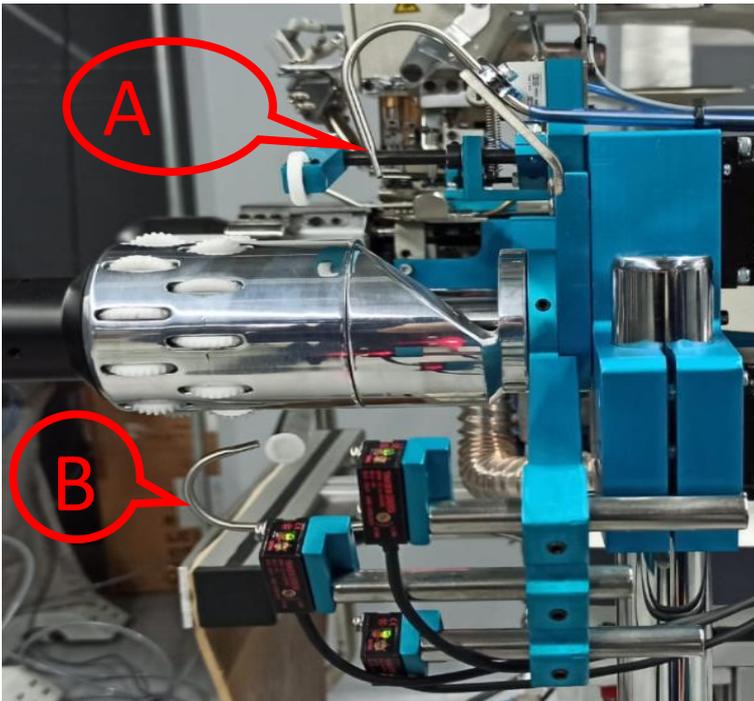
5.2.1) FABRIC FRONT ROLLER OPENING AIR

You can test the upper & lower positioning air in here.

5.2.1.1) When 1st button is pressed, the button turns into green. The air blowing starts from both pipes "A" and "B".

In "B" pipe, the positing of the fabric is adjusted until detected by the sensor.
the air adjustment in both "A" and "B" adjuster should be adjusted according to fabric.

5.2.1.2) When 1st button is pressed again, the button turns into red. The air blowing stopes from both pipes.

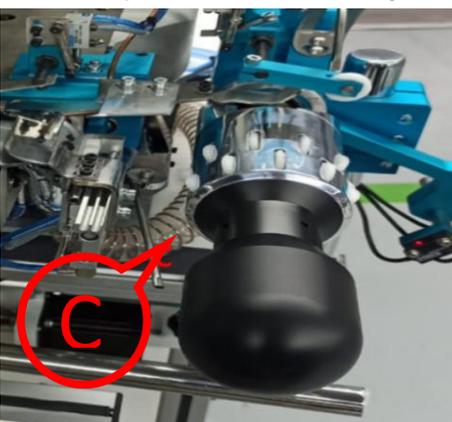


5.2.2) FRONT FABRIC OPENER AIR PIPE CONTROL

When the 2nd button is pressed, the button turns green. And, air blowing starts from the front roller fabric opener air pipes.

The 'C' air-blowing pipe enables the fabric to hold the roller properly.

Note: Air pressure should be adjusted from the 'C' air adjuster according to the fabric's weight



5.2.3) PRESSER FOOT LIFTING

5.2.3.1) When 3rd button is pressed, the button turns into green. And, it lifts the presser foot.

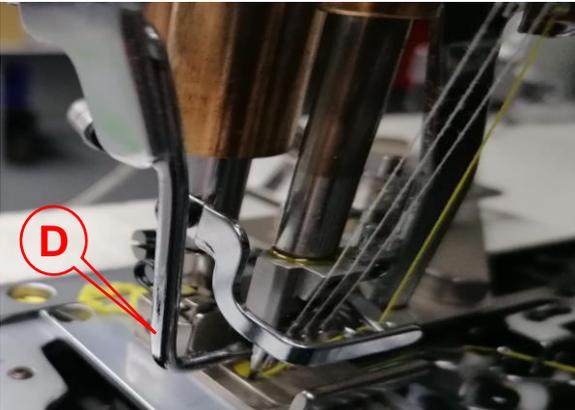
5.2.3.2) When 3rd button is pressed again, the button turns into red. Then the presser lifting is downed.

5.2.4) WIPER BLOWING

5.2.4.1) When 4th button is pressed, it activates the air thread wiper "D" (Air blowing starts).

Note: This feature is only usable in chainstich machine model of MF-7900. the other hand it is not applicable in top cover stitching models of MF-7900.

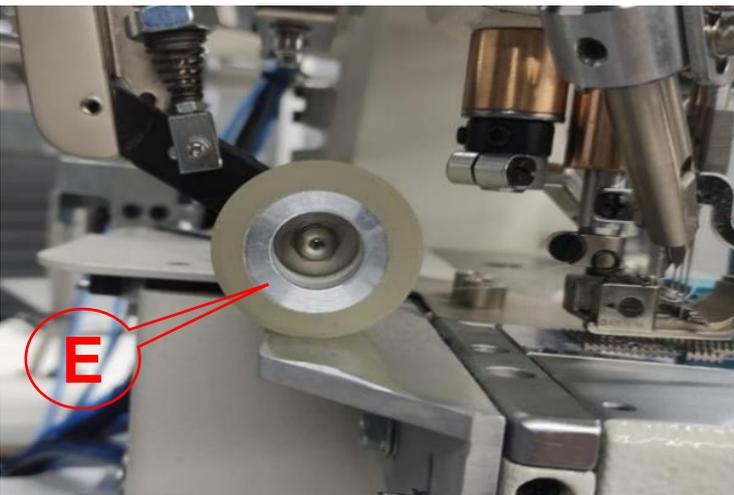
5.2.4.2) When 4th button is pressed again, it deactivates the air thread wiper "D" (Air blowing stops).



5.2.5) ROLLER PISTON

5.2.5.1) When 5th button is pressed, the button turns into green. And, it lifts the roller (puller / E).

5.2.5.1) When 5th button is repressed again, the button turns into red. The roller (puller / E) is lowerd.



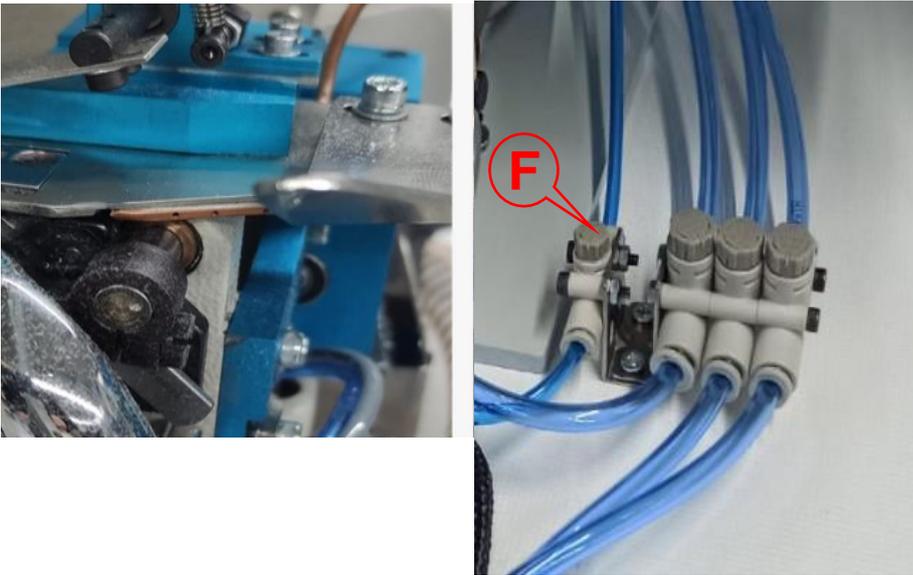
5.2.6) FABRIC SEPARATOR BLOWING & REAR MOTOR BLOWING

When 6th button is pressed, the button turns into green. It provides two operation of Fabric separator blowing and REAR MOTOR blowing at the same time.

5.2.6.1) FABRIC SEPARATOR BLOWING

Fabric separator blowing is for correcting the last position of the fabric before cutting.

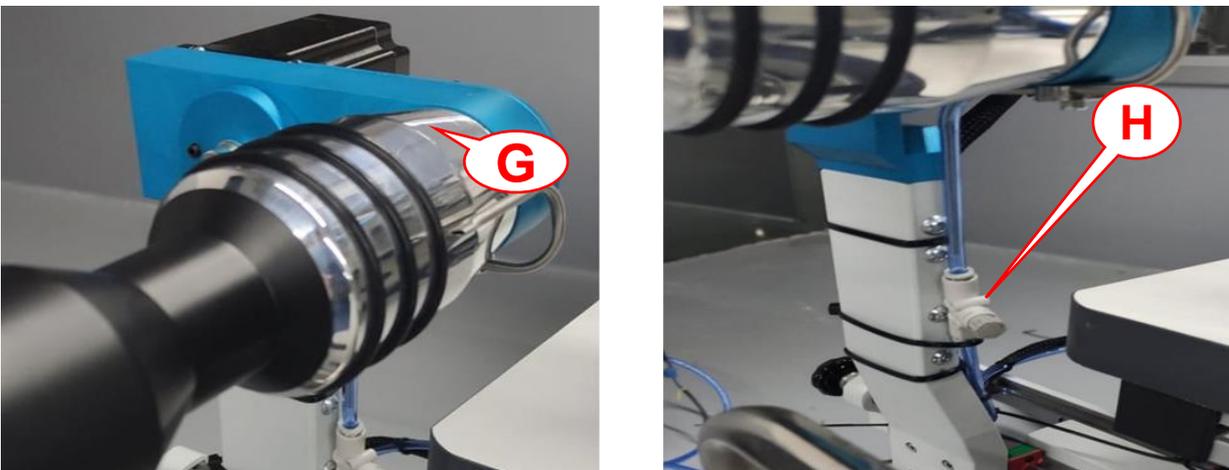
Air presser of the fabric separator blowing can be adjusted at the air adjuster which shown as "F".



5.2.6.2) REAR MOTOR BLOWING

The rear motor blowing "G" corrects the position of the fabric during rotation for sewing preparation.

The air presser of the rear motor blowing can be adjusted at the air adjuster which shown as "H".



When 6th button is pressed again, the button turns into red. it is passive at both features.

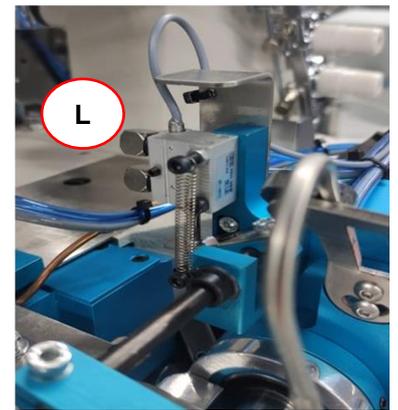
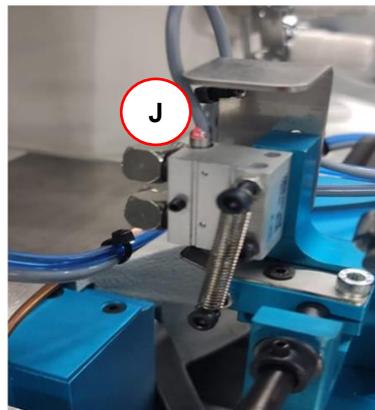
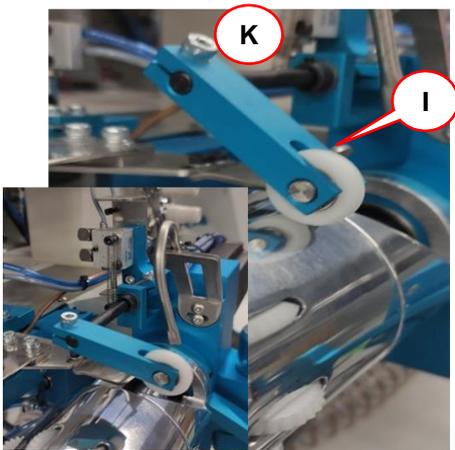
5.2.7) SIDE SEAM PISTON

5.2.7.1) When 7th button is pressed, the button turns into green. And, it downs the wheel lever "I". The wheel lever stays at the down position, and at the same time the sensor becomes red as it is seen in the picture with "J". And, When the thickness of the fabric changes, the sensor can detect the side seam.

Note: The sensitivity of the sensor can be adjusted by the screw "K".

5.2.7.2) When 7th button is pressed again, the button turns into red. It lifts the wheel lever "I".

The wheel lever stays at the up position, and the sensor light becomes off as it seen in the picture with "L".

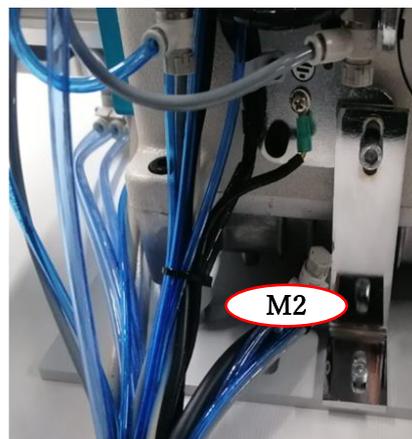
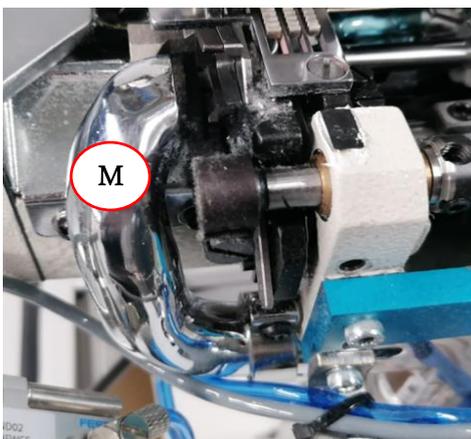


5.2.8) VACUUM

5.2.8.1) When the 8th button is pressed, the button turns into green. And, it activates the fabric waste suction vacuum "M".

Note: Vacuum power could be adjusted from the adjuster "M2"!

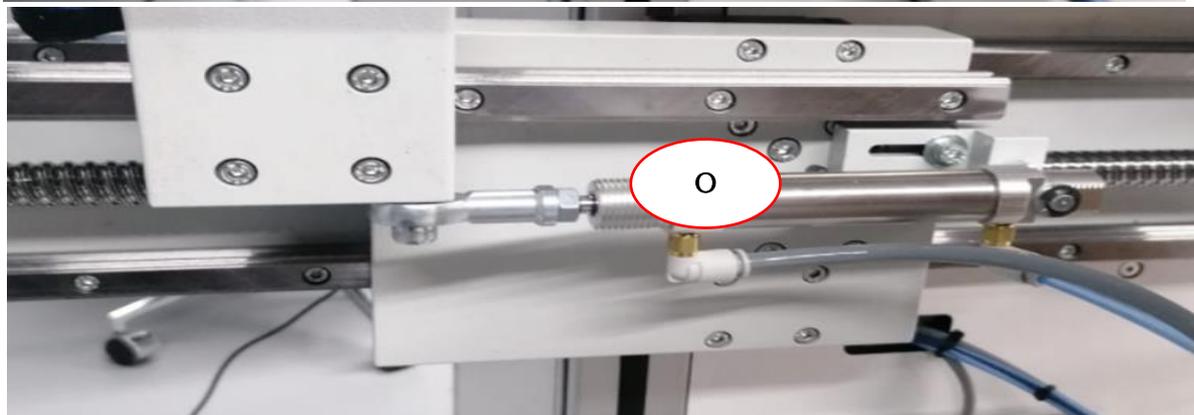
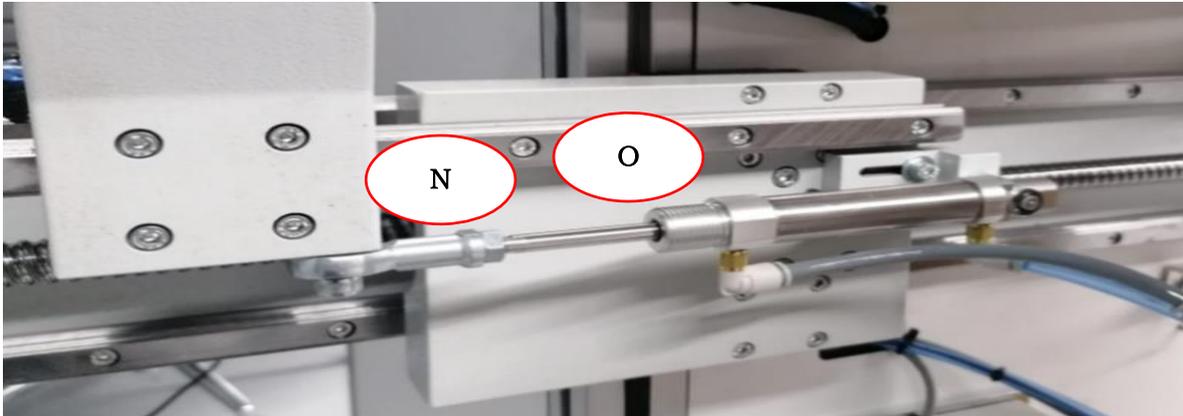
5.2.8.2) When 8th button is pressed again, the button turns into red. It deactivates vacuum.



5.2.9) FABRIC TOLERANCE SYSTEM

5.2.9.1) When 9th button is pressed, the button turns into green. And, it activates the fabric tolerance system. The cylinder moves towards “N” direction.

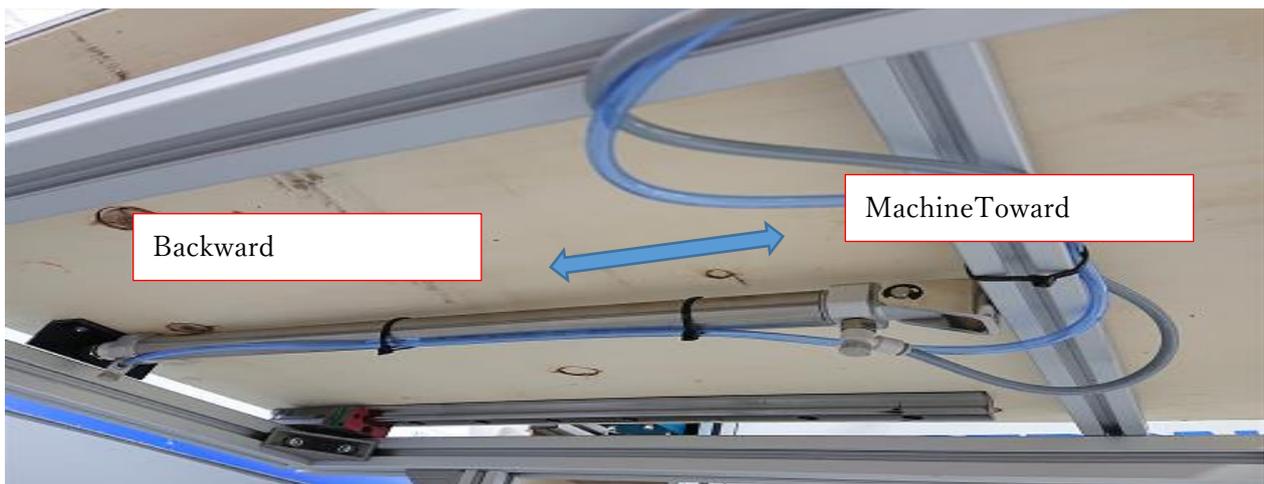
5.2.9.2) When 9th button is pressed again. The button turns into red. And, the cylinder moves towards “O” direction. It deactivates fabric tolerance system.



5.2.10) STACKING 1

5.2.10.1) When 10th button is pressed, the button turns into green. And, It activates stacking table (see visual below) and moves toward the machine.

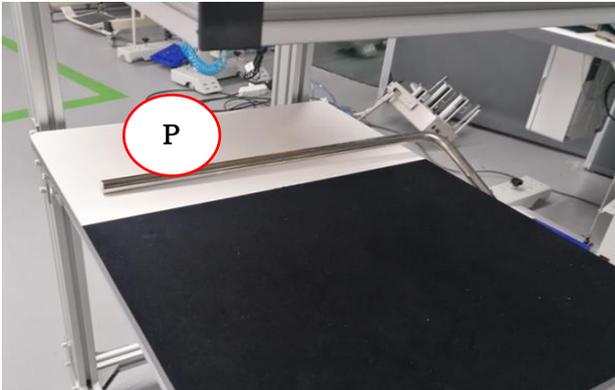
5.2.10.2) When 10th button is pressed again, the button turns into red. it deactivates stacking table and moves backward.



5.2.11) STACKING 2

5.2.11.1) When 11th button is pressed, the button turns into green. And, it activates stacking arm "P" and moves towards stacking table.

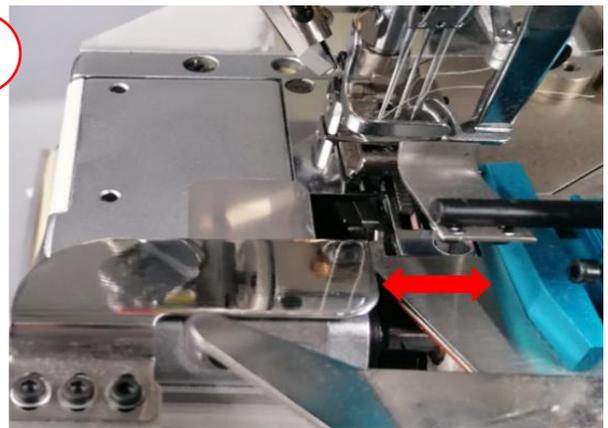
5.2.11.2) When 11th button is pressed again, the button turns into red. And, stacking arm "P" becomes deactivated.



5.2.12) EDGE GUARD CYLINDER

5.2.12.1) When 12th button is pressed, the button turns into green and activates edge guard cylinder. Edge guard "Q" moves toward edge guide "R".

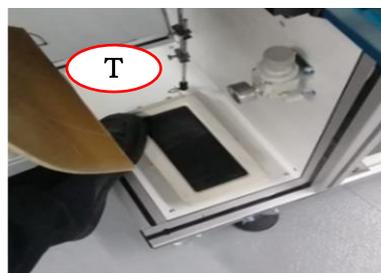
5.2.12.2) When 12th button is pressed again, the button turns into red. And, the edge guard cylinder is deactivated.



5.2.13) MANUAL PEDAL FUNCTION CANCELLING (On/Off)

5.2.13.1) When 13th button is pressed, it turns into green. The warning 'A2' "S" could be seen at Control box in in the door. And, the pedal which could be seen in the visual "T" is not usable.

5.2.13.2) When 13th button is pressed again, the botton turns into red. And, the pedal becomes usable again.

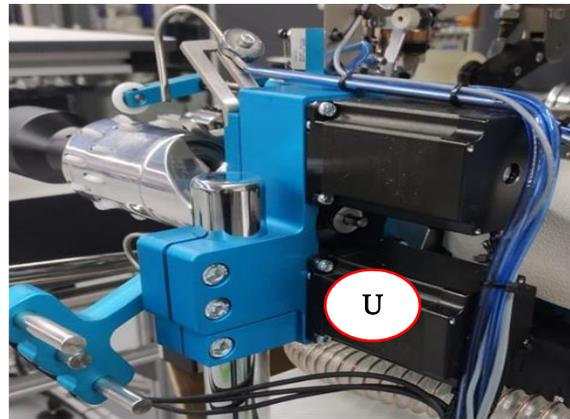
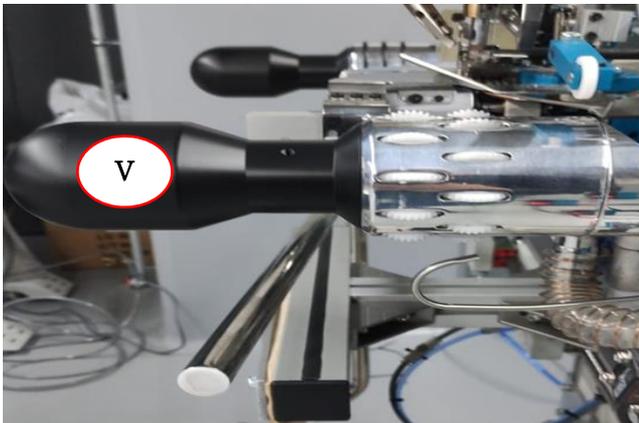


The warning has disappeared

5.2.14) FRONT MOTOR

5.2.14.1) When 14th button is pressed, it turns green and active. And, The front roller which shown as “V” starts to turn. The front roller is driven by motor “U”.

5.2.14.2) When 14th button is repressed, it becomes red and passive.



5.2.15) REAR MOTOR

5.2.15.1) When 15th button is pressed, it turns green and active. the rear roller which shown as “X” starts to turn. The front roller is driven by motor “W”.

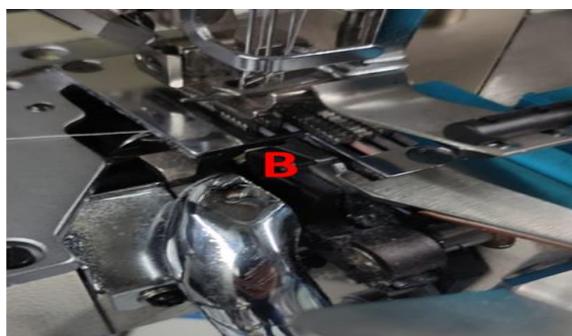
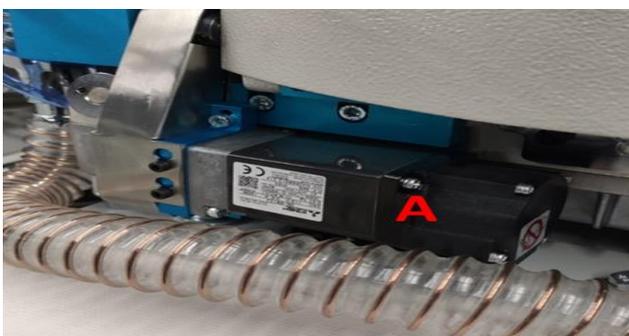
5.2.15.2) When 15th button is repressed, it becomes red and passive.



5.2.16) KNIFE MOTOR

5.2.16.1) When 16th button is pressed, it turns green and active. The knife motor which shown as “A” starts to turn. the knife which shown as “B” starts to work.

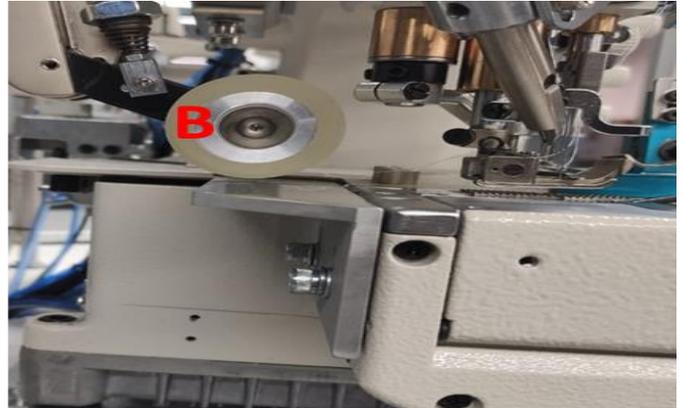
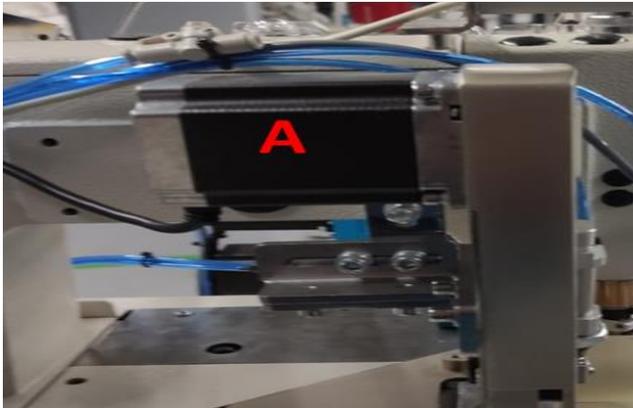
5.2.16.2) When 16th button is repressed again, it becomes red and passive.



5.2.17) PLATEN MOTOR

5.2.17.1) When 17th button is pressed, it turns green and active. the platen motor which shown as “A” starts to turn. the platen motor turns the roler which shown as “B”.

5.2.17.2) When 17th button is repressed, it becomes red and passive.



5.2.18) INWARD EDGE CONTROL

5.2.18.1) When 18th button is pressed, the Edge Control button becomes highlighted red. The white discs rotate inward rotation.

5.2.18.2) When 18th button is pressed again, it disappears highlighted. the feature becomes inactive.



5.2.19) OUTWARD EDGE CONTROL

5.2.19.1) When 19th button is pressed, the Edge Control button becomes highlighted red. The white discs rotate outward rotation.

5.2.19.2) When 19th button is pressed again, it disappears highlighted. the feature becomes inactive.



5.2.20) REAR STRECHING ARM MOVEMENT CONTROL

5.2.20.1) When 20th&21th button is constantly pressed, The rear roller slide constantly.
When the user stops pressing the button, The rear roller stops, too.



5.2.21) ERROR DISPLAY PAGE

5.2.21.1) When 22th button is pressed, it directs the user to the error display page.
When the user stops pressing the button, The rear roller stops, too.



5.2.21.2) If there is any error, the reset button “Y” should be used.this clear out the messages from the page.



5.2.21.3) In order to exit from this page, the main menu button “Z” has to be pressed.



5.2.22) MAIN MENU

5.2.22.1) When 23th button is pressed, the operation panel display returns to the main menu.



5.2.23) COUNTER

5.2.23.1) When 24th button is pressed while the machine working at the automatic mode, it provides to decrease the counter one from the total value.

5.2.23.2) When 25th button is pressed, it provides to reset the daily counter. counter reset button should hold press as 5 seconds to reset the daily counter.

5.2.23.3) The 26th button shows the daily counter.



5.3) TEST PAGE

The aim of the test mode is to check the system.

5.3.1) You press the Start button (a) on the display.

5.3.2) Place the material to roller arms in a way that could be detected by the top sensor. Then material starts to rotate automatically, top sensor starts searching side seam.

5.3.3) When the top sensor detects it, the puller will move up.

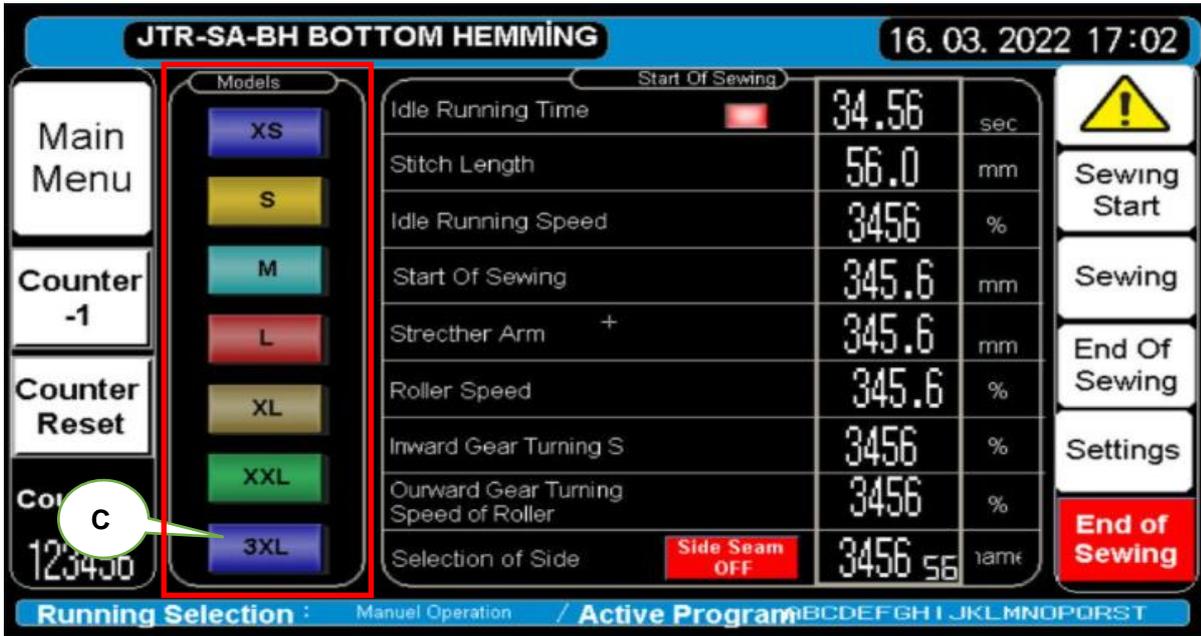
5.3.4) You can check each 3 sensors as if they are working properly.

Note: If you want to check each 5 air blow flow rate, press the " Stop (Step Motors)" button (b).

In case of any improper adjustment detected in the steps mentioned above, please check them one by one.



5.4) AUTO MODE PAGE



5.4.1) Select from Models selection (C), according to the work size.

5.4.1) Place the material to roller arms in a way that could be detected by the top sensor. Then material starts to rotate automatically.

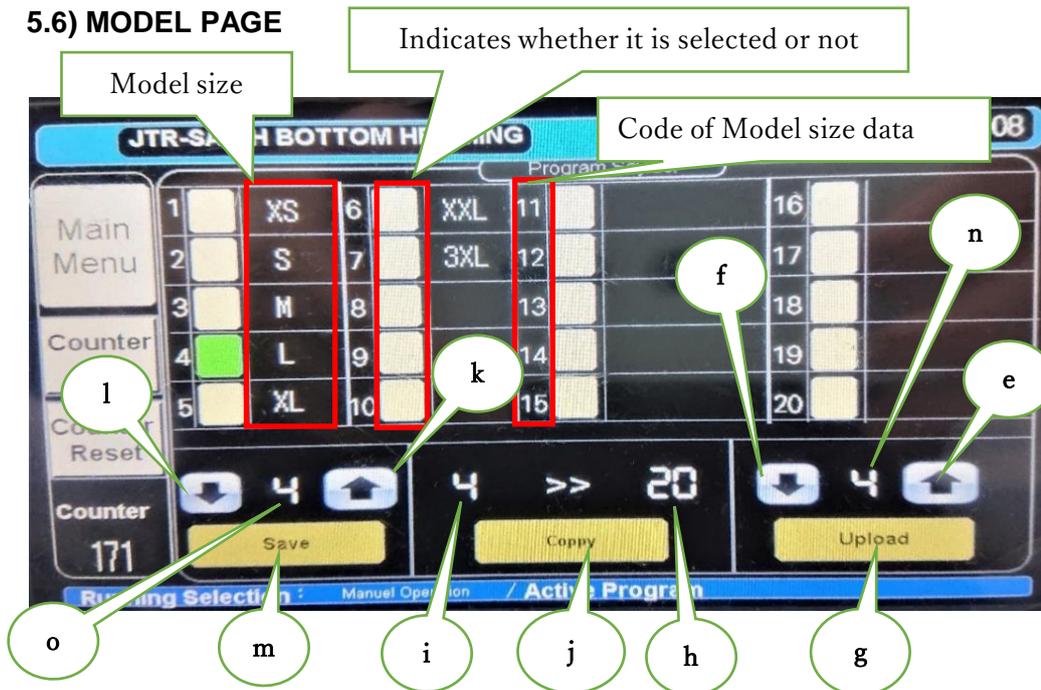
5.5) ALARM PAGE

On this panel, all occurred errors are displayed.

All records can be deleted by pressing reset button.



5.6) MODEL PAGE



5.6.1) How to read the saved data ?

Press the Up button (e) and Down button (f) to set the model size code (n) you want to read. Then press the upload button (g) to load the model size data.

Note: You can enter the code with the numeric keypad by pressing the the model size code (n) you want to read..

5.6.2) How to copy existing data ?

When you press the model size code (i) of the copy source, the numeric keypad is displayed, so enter the code of the copy source. When you press the model size code (h) of the copy destination, the numeric keypad is displayed, so enter the code of the copy destination.

Then press the copy button (j) and the model size data will be written to the destination code.

5.6.3) How to save named data ?

Press the Up button (l) and Down button (k) to set the model size code (o) you want to save. Then press the save button (m) to save the model size data.

Note: You can enter the code with the numeric keypad by pressing the model size code (o) you want to save.

5.6.4) How to call the default data ?

Enter 20 for the model size code (n) to read or the model size code (o) to save. When you press the model size code (h) of the copy destination, the numeric keypad is displayed, so enter the code of the copy destination.

Then press the Copy button (j) and the default data will be written to the destination code.

Supplement 1 : The indicator, the model size code (n) to read, and the model size code (o) to save are synchronized. If you change the code of the model size to read (n) or the code of the model size to save (o), the other two will be changed to the same value.

Supplement 2 : Press the Model Size field, so you can see the input screen. Use it to enter the model size (model name).

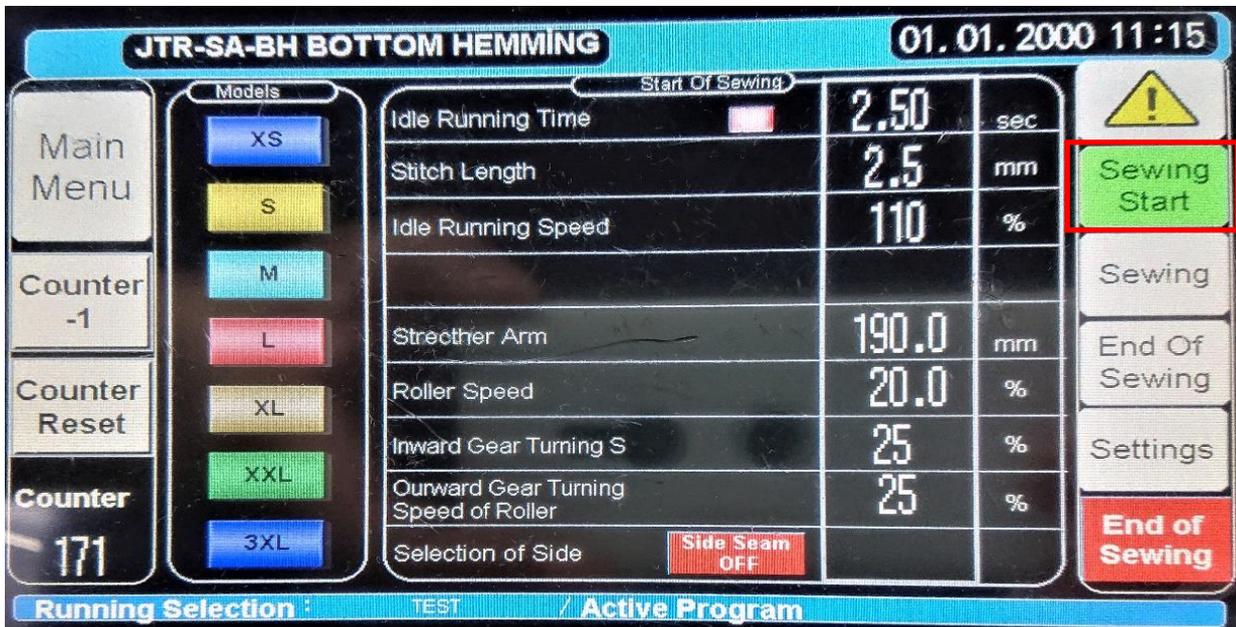
Supplement 3 : When the indicator is green, it means that it is selected.

Supplement 4 : Code 20 stores M size data at the time of shipment. Therefore, do not assign other model size data to code 20.

5.7) SETTINGS PAGE

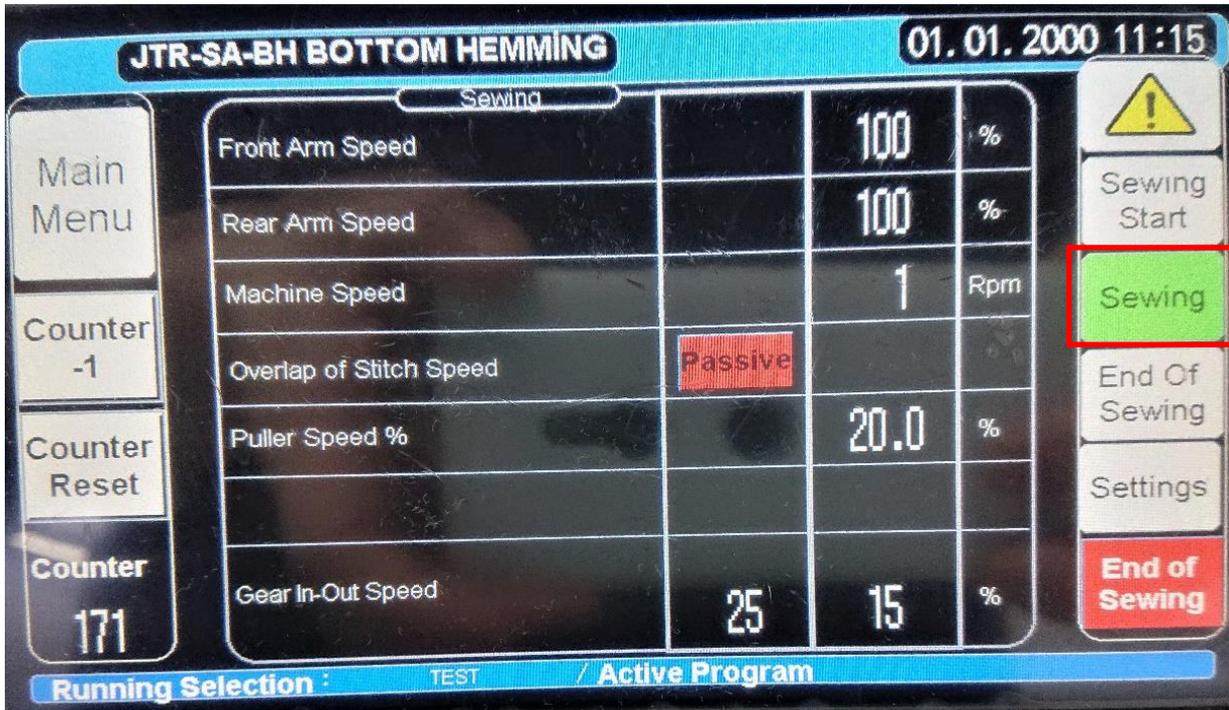
Normally, you do not need to change any parameter in this section!

5.7.1) PREPARING FOR SEWING SETTINGS



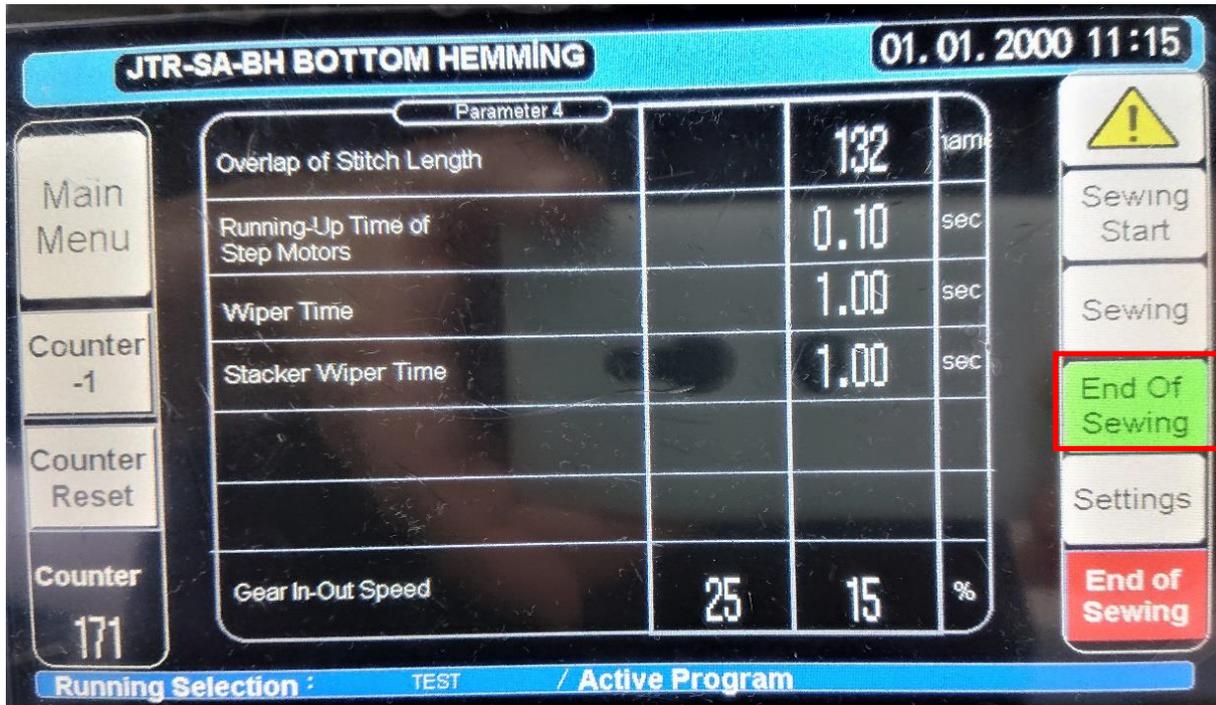
No.	Item	Explanation
1	Idle Running Time	This can be set when No. 8 has no side seams. It is available to set the time to start sewing when there is no side seams.
2	Stitch Length	Length in sewing hem.
3	Idle Running Speed	When the sensor detects it, the sewn object is idled and sewing is started with the side seams as a trigger. Set the speed at the time of this idle rotation. Note: If there is no side seams, the speed when idling for the time set in No.1.
4	Start Of Sewing	Sewing pitch for starting.
5	Strecther Arm	Size of strecther arm.
6	Roller Speed	Puller rotation speed.
7	Inward Gear Turning S	The speed of the gears that put the fabric in
8	Ourward Gear Turning Speed of Roller	The speed of the gears that put the fabric out
9	Selection of Side	Enable or disable side seams setting.

5.7.2) SEWING SETTINGS



No.	Item	Explanation
1	Front Arm Speed	Front Arm Speed.
2	Rear Arm Speed	Back arm speed.
3	Machine Speed	Rotational speed of the sewing machine main shaft.
4	Overlap of Stitch Speed	This is the sewing speed at the point where the start and end of sewing overlap. The speed at the beginning and end of sewing is the same.
5	Puller Speed	Puller rotation speed.
6	Gear In-Out Speed	The speed of the gears that put the fabric in and out.

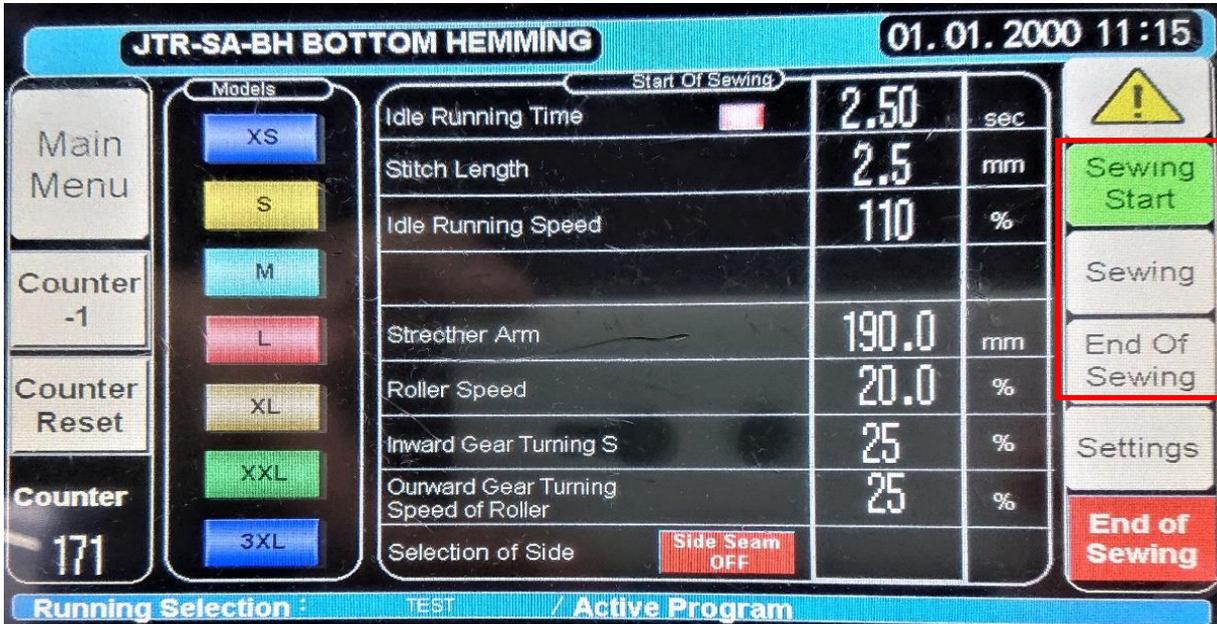
5.7.3) END OF SEWING SETTINGS



No.	Item	Explanation
1	Overlap of Stitch Length	It is the sewing pitch that will overlap at the end of sewing.
2	Running-Up Time of Step Motors	It is the stop time which is required to stop at the end of sewing.
3	Wiper Time	It is the time to send the fabric to stacking at the end of sewing.
4	Stacker Wiper Time	The time to carry the stacker wiper to stacker table.
5	Gear In-Out Speed	The speed of the gears that put the fabric in and out.

5.7.4) SETTING PROCEDURE

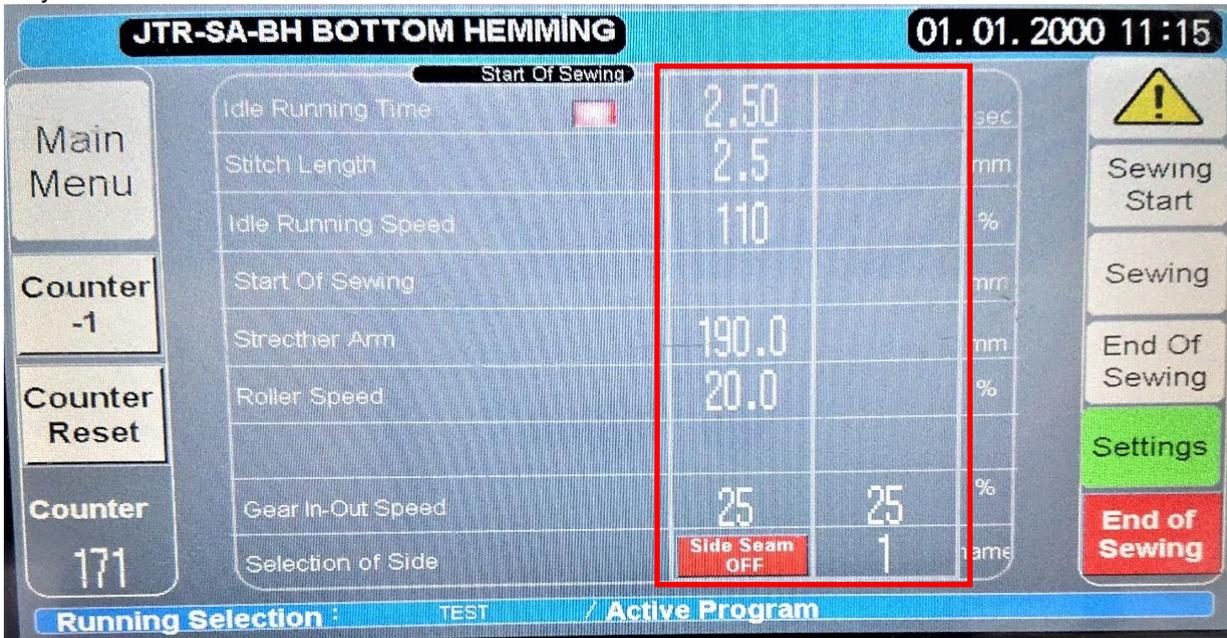
5.7.4.1) When "Sewing" and "End of Sewing" button is pressed, All parameters can be edited. By the way when "Sewing Start" button is pressed, Some of parameters can be edited not all of them.



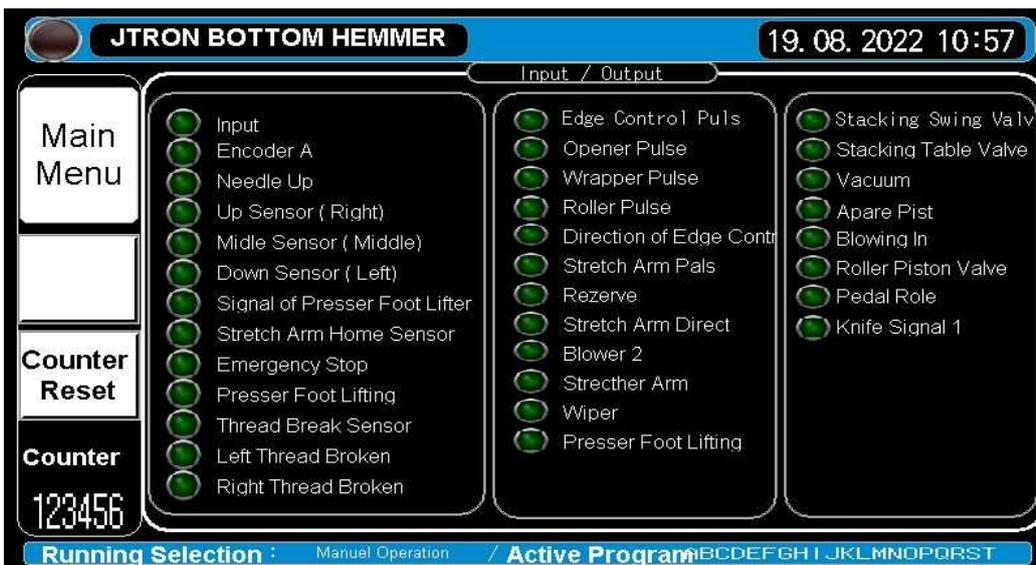
5.7.4.2) If you want to edit all parameters of "Sewing Start" , Press the "Settings" button.



5.7.4.3) When you press the value of the item you want to change, the numeric keypad will be displayed, so enter any value.



5.8) INPUT/OUTPUT PAGE

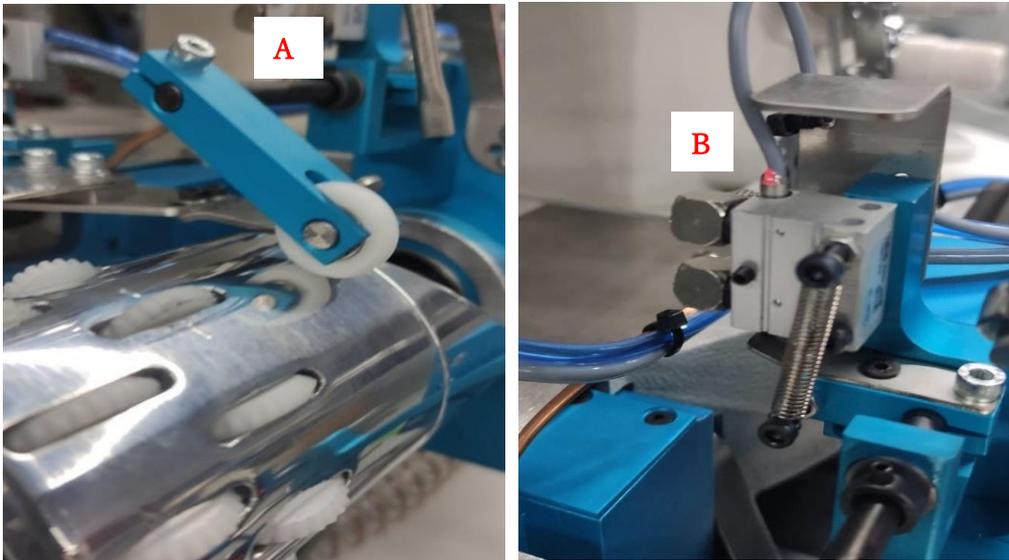


All connections are checked in this page.

6) ADJUSTMENT

6.1) Side Seams Sensor Adjustments

It is setting the sewing start point. The Side seams sensor arm adjusts the operating time of the machine after it detects the side seam.



6.1.1) The additional detection adjustment according to tickness of the fabric is done via "A" screw.

6.1.2) If the "B" LED light turns to red when the lever is lowered, it works correctly.

6.2) Top, Mid and Bottom Sensor Adjustments

In order the machine to run with the fabric underneath in auto-mode, top sensor's lights (red & green) should be on.

After detecting fabric by top sensor (T), the machine starts the process of preparation movements and tries to detect the overlock side seam.

Right after the machine detects the side seam, starts sewing predetermined model.

The Top sensor (T) stays active from the beginning of the end of the hemming operation.

The bottom sensor (B) detects the end of the hemming operation and the middle sensor (M) takes over the function.

The middle sensor (M) monitors the last part of the operation. It enables the decent overlap of the two side of the seam.

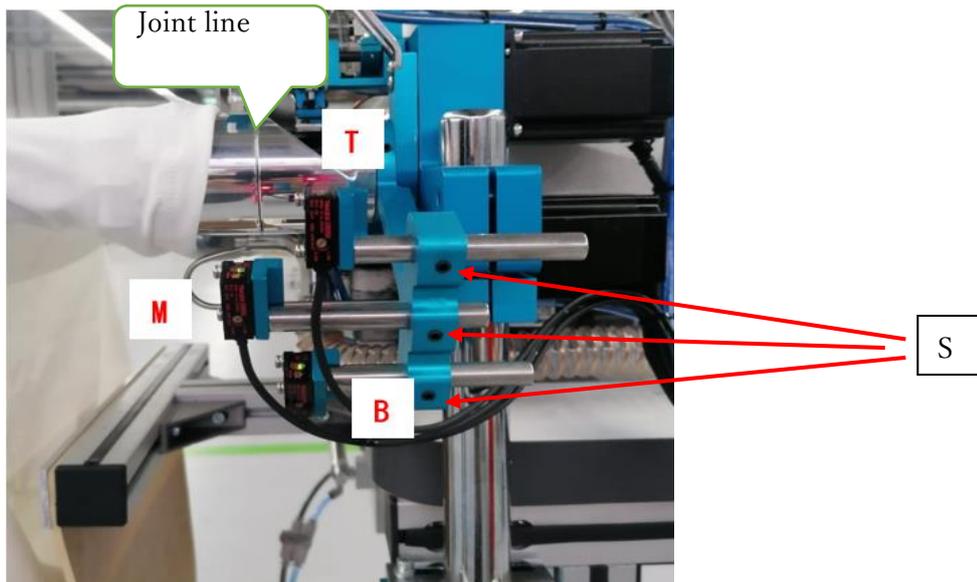
Important Note!

The bottom sensor (B) should not blink during the whole time of the sewing!

Sensors angles should be located as their lights's pin points takes back the reflection with the same angle.

Finally, the machine should be set the auto mode and a sample can be made and observed.

If the user detects any problem in the sample, he/she detects the root of the problem and interfere with the solutions mentioned above



6.2.1) Loosen the screws (s) (3 pieces). Adjust sensor positions and angle. Then tighten the screws again when the adjustment is finished.

Note: Align the left edge of the middle sensor (M) light with the joint line of the front roller.

6.3) Front and Back Arms

A) (A) and (B) arms hold the the fabric lead the fabric rotate. Please note that (A) arm is fixed where (B) is moving.

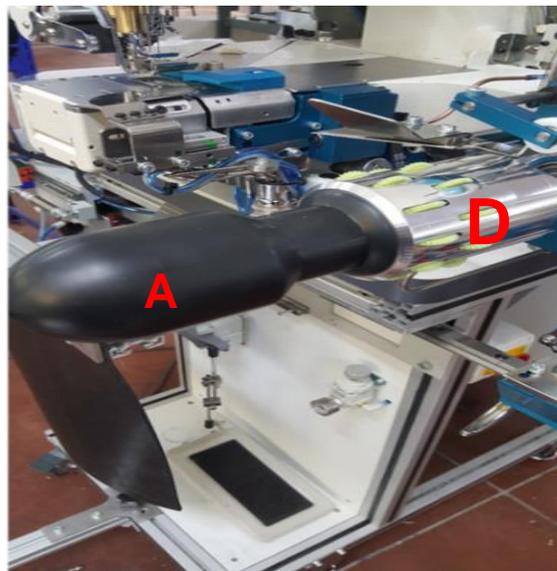
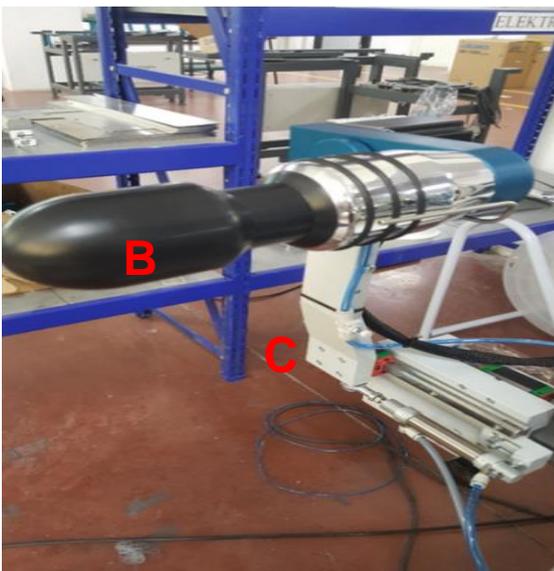
B) These arms holds and rotates the fabric to be sewn.

C) This cylinder slides (B) arms for controlling tension.

D) These gears give the directions the fabric to be sewn.

6.3.1) The arm width should be adjusted according to the fabric.

Note: The desired length and sewing distances can be set from the automatic sewing section of the panel.

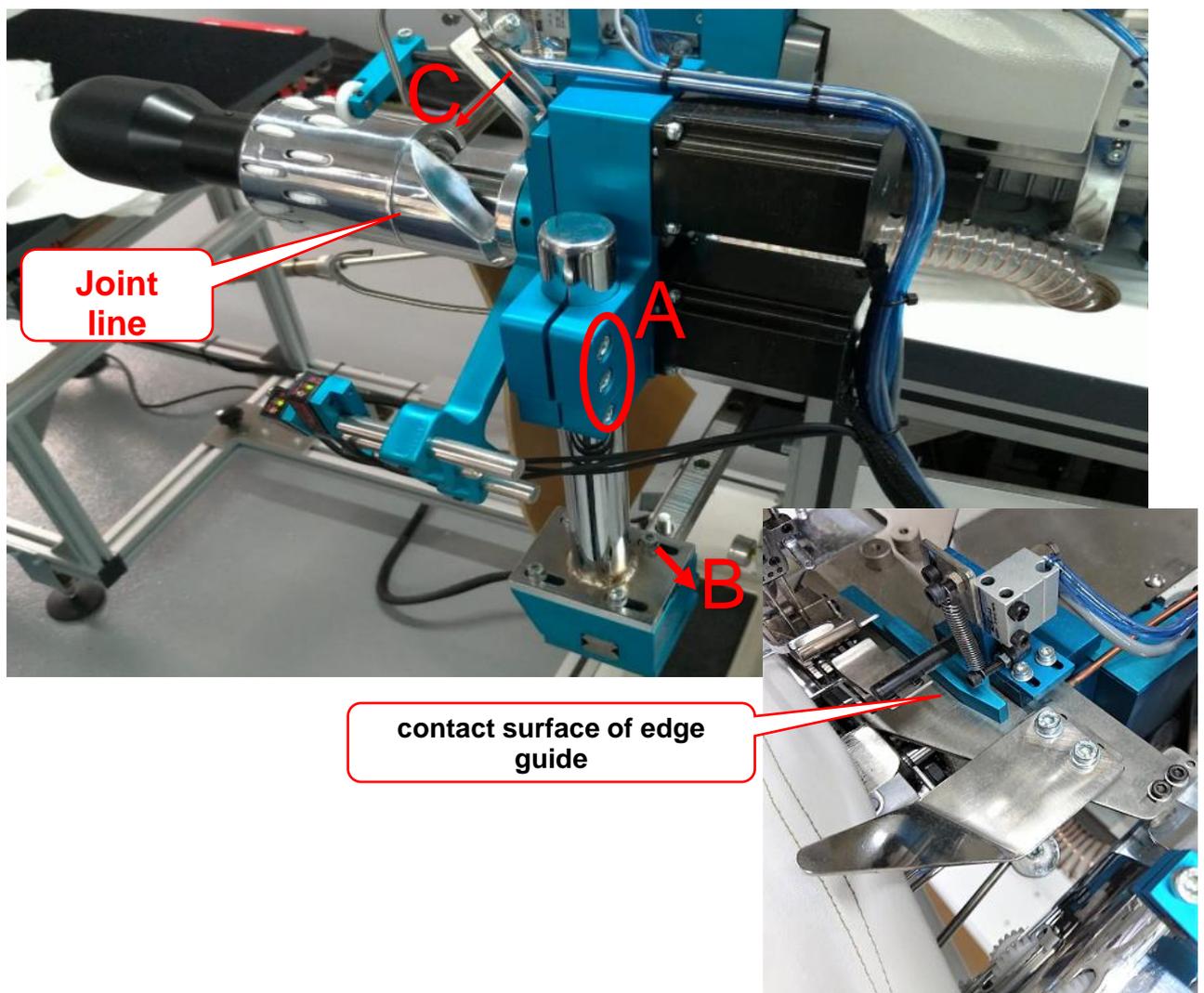


6.4) Front Roller Adjustment

The front roller position should be set as follows.

6.4.1) From screws (A) (3 pieces), the height of roller arm top should adjust with same level of the needle plate.

6.4.2) 2. The joint line of front roller should match line (c) extending from contact surface of edge guide. The left/right adjustments are done via (B) screws (4 pieces).



All connections are checked in this page.

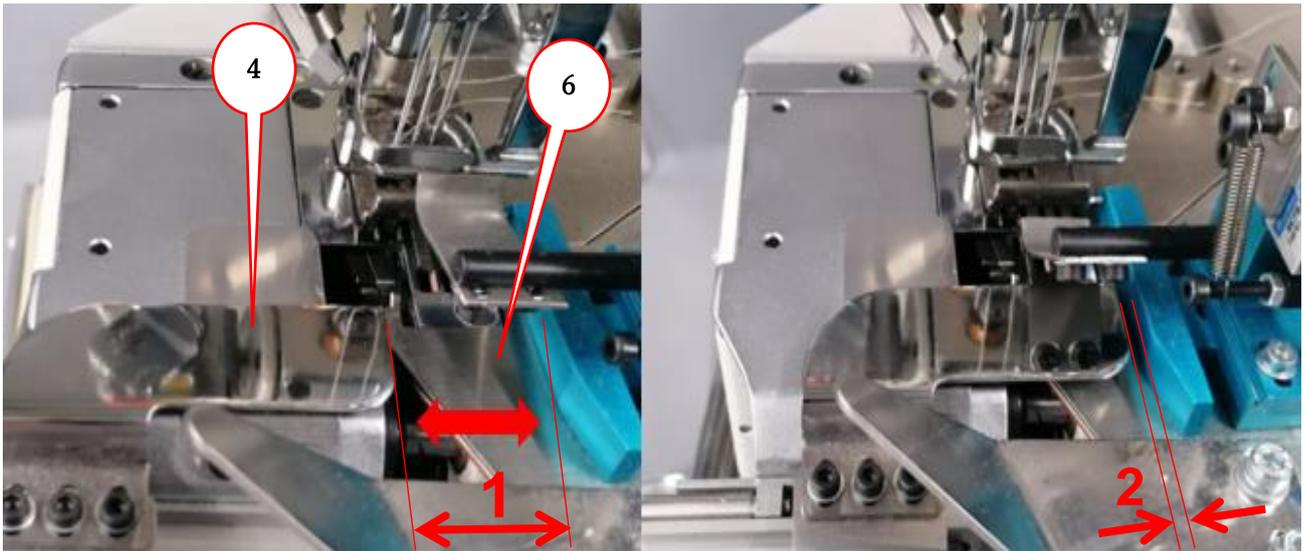
6.5) Bottom Hemming Settings

6.5.1) Opening portion of the fabric hemming adjustment guide (edge guide) gap(1) = 24mm

6.5.2) Closed position of the fabric hemming adjustment guide (edge guide) gap(2) = 4mm

6.5.3) Height of fabric hemming adjustment guide [gap from (6) to (4)] hight(3) = 5mm

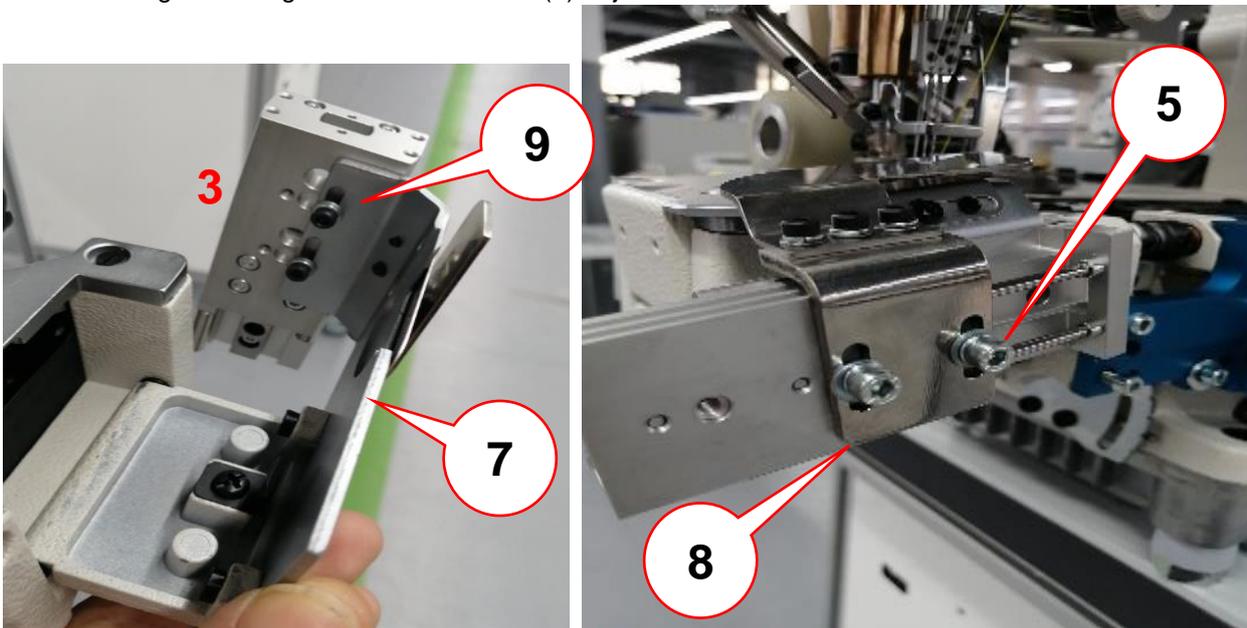
Refer to the photos below;



6.5.4) Adjust the gap (1) via the screws (9) (2 pieces) of PISTON CONNECTION COVER (7). If the side seams get caught, fine-tune according to matching the thickness of the side seam fabric.

Note: The way to adjust the gap(2) refer to 5)

6.5.5) Adjust the hight (3) via the screws (5) (2pieces) of edge guard braket (8). If the side seams get caught, fine-tune accordig to Making the fabric thickness (3) adjustment.

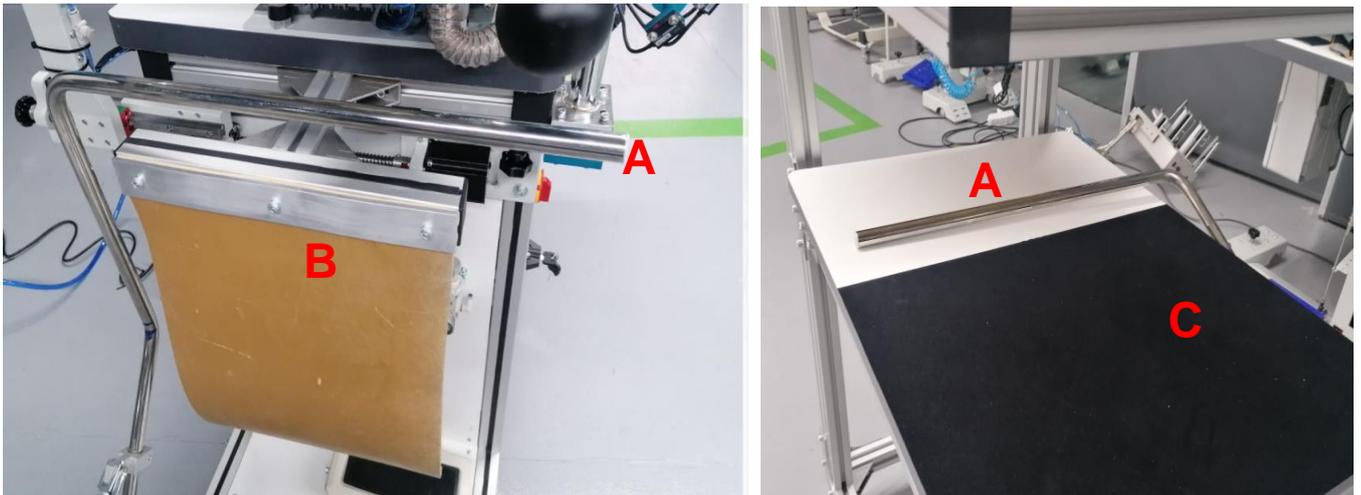


6.6) Stacking Arm

A: The fabric stacking arm.

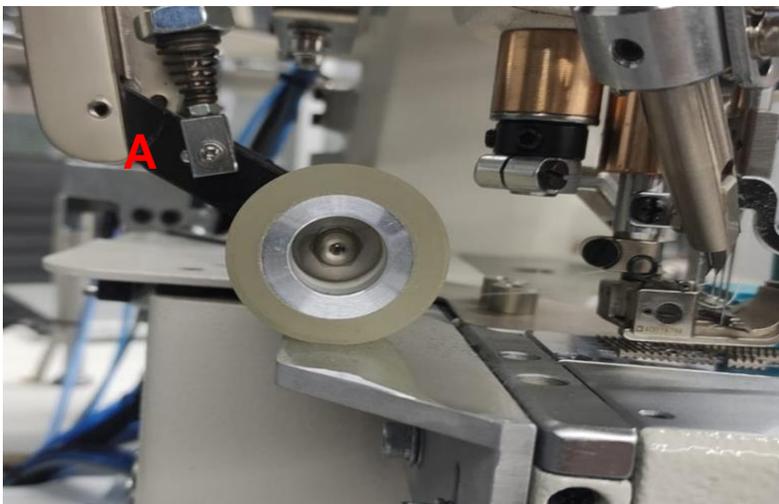
B: The stacking fabric holder.

Where fabric stacking arm (A) rotates towards the left side of the machine during this movement the table (C) move towards right side of the machine. This action transports the to the fabric to the stacking operation.



6.7) Rear Roller Unit

The aim of the roller is to stabilize the hemming position before sewing get started.

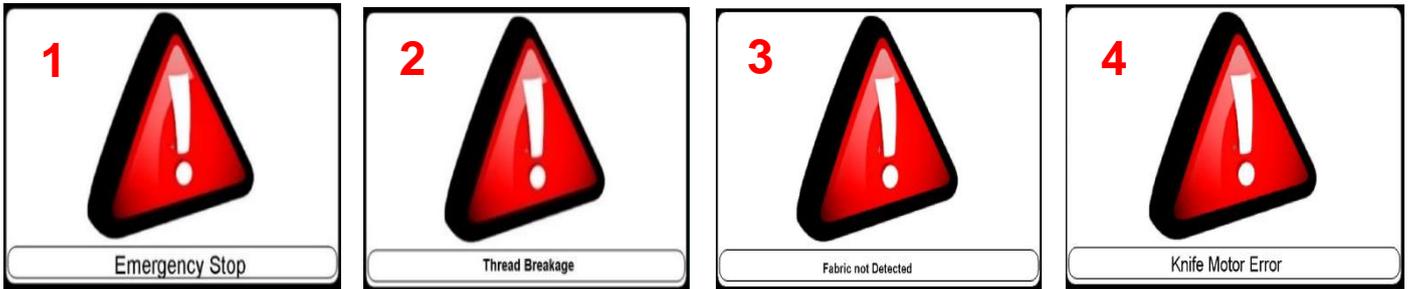


6.7.1) The roller speed is adjusted from the control panel.

6.7.2) Presser adjustment is adjusted from “A” screw

Note: According to the stitch length, the speed of the roller should be adjusted from the control panel.

7) LISTING OF ERROR CODES

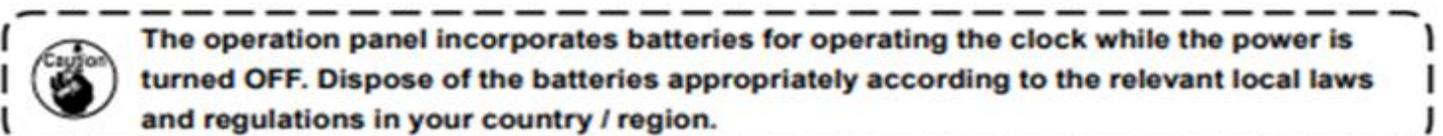


No.	Messages	Workaround
1	Emergency Stop	Where emergy button has pressed, machine stops immediately
2	Thread Breakage	Indicates that the thred breakage has occurred. When the thread breakage occurs the red light becomes on. When the light is green, it means the machine is ready for sewing. Note : Turn off the power when threading.
3	Fabric not Detected	If the fabric drops this warning pops-out.
4	Knife Motor Error	The machine has to cool down for 20-25 seconds after switching it off.Pleasemind this information if the machine has to stop and run because of some ircumstance/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

Machine head is standard JUKI.Please refer to original machine heads instructins manual.
The machine could be cleaned with pressed air blowing where it is unclean.
If the thread tangled the part should be removed and should be cleaned separately.

9) DISPOSAL OF BATTARIES



10) CAUSES AND COUNTERMEASURES

No.	Trouble	Causes and Countermeasures
1	The machine does not start sewing!	Please check "T" sensor's position.(ref ;"6.2) Top, Mid and Bottom Sensor Adjustments")
2	The machine does not stop at the end of sewing and keeps working.	Please check "B"sensor. (ref ; "6.2) Top, Mid and Bottom Sensor Adjustments")
3	The ending stitches and the beginning stitches does not overlap.	Please check "M"sensor. (ref ; "6.2) Top, Mid and Bottom Sensor Adjustments")
4	The fabric feed is not smooth because gauges are not aligned properly.	Please check edge guide and fabric separator. (ref ; "6.4) Front Roller Adjustment")



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