

# MOL-254

## FOR THE USE OF MACHINE

No.00  
40190207

JUKI®

注意：正しくミシンをセットアップし、安全にご使用いただくために、WEB 取扱説明書を必ずお読み下さい。  
下記 URL、または右の QR コードから、当社サイトにアクセスし閲覧することができます。  
本書は大切に保管してください。  
<http://www.juki.co.jp/manual/ism/00047>



NOTE : In order to set up the sewing machine correctly and use it safely, be sure to read the online instruction Manual.  
The online Instruction Manual can be found on the JUKI website which can be accessed by entering the below-stated URL or by scanning the QR code shown on the right.  
Be sure to keep these documents carefully.  
<http://www.juki.co.jp/manual/ism/00047>

HINWEIS : Um die Nähmaschine korrekt einzurichten und sicher zu benutzen, lesen Sie unbedingt die Online-Bedienungsanleitung durch.  
Sie finden die Online-Bedienungsanleitung auf der JUKI-Website, die durch Eingeben der unten angegebenen URL oder durch Scannen des rechts gezeigten QR-Codes aufgerufen werden kann.  
Bewahren Sie diese Dokumente unbedingt sorgfältig auf.  
<http://www.juki.co.jp/manual/ism/00047>

REMARQUE : Afin d'installer correctement la machine à coudre et de l'utiliser en toute sécurité, veiller à lire le mode d'emploi en ligne.  
Le mode d'emploi en ligne est disponible sur le site Web de JUKI accessible en saisissant l'URL ci-dessous ou en scannant le code QR illustré à droite.  
Veiller à soigneusement conserver ces documents.  
<http://www.juki.co.jp/manual/ism/00047>

NOTA : Para instalar y configurar la máquina de coser correctamente y usarla en condiciones de seguridad, asegúrese de leer el Manual de Instrucciones en línea.  
El Manual de Instrucciones en línea se encuentra disponible en el sitio web de JUKI, que es accesible introduciendo la dirección URL indicada a continuación o escaneando el código QR que se muestra a la derecha.  
Asegúrese de guardar estos documentos cuidadosamente.  
<http://www.juki.co.jp/manual/ism/00047>

NOTA : Al fine di installare la macchina per cucire correttamente e utilizzarla in modo sicuro, assicurarsi di leggere attentamente il Manuale d'Istruzioni online.  
Il Manuale d'Istruzioni online può essere trovato sul sito web JUKI a cui si può accedere inserendo l'URL indicato di seguito o scannerizzando il codice QR mostrato sulla destra.  
Conservare questi documenti in un luogo sicuro.  
<http://www.juki.co.jp/manual/ism/00047>

注意：为了正确地设置和 safely 地使用本缝纫机，请一定阅读 WEB 使用说明书。  
可以利用下列 URL 或者右面的 QR 二维码访问本公司网站进行浏览。  
请妥善地保管本说明文件。  
<http://www.juki.co.jp/manual/ism/00047>

ПРИМЕЧАНИЕ : Для правильной настройки и безопасного использования швейной машины обязательно прочитайте в Интернете «Руководство по эксплуатации».  
«Руководство по эксплуатации» в Интернете может быть найдено на веб-сайте JUKI, к которому можно получить доступ путем входа по нижеуказанному унифицированному указателю информационного ресурса, или путем просмотра QR-кода, указанного справа.  
Обязательно тщательно сохранять эти документы.  
<http://www.juki.co.jp/manual/ism/00047>

### TO ENSURE SAFE USE OF YOUR SEWING MACHINE

For the sewing machine, automatic machine and ancillary devices (hereinafter collectively referred to as "machine"), it is inevitable to conduct sewing work near moving parts of the machine. This means that there is always a possibility of unintentionally coming in contact with the moving parts. Operators who actually operate the machine and maintenance personnel who are involved in maintenance and repair of the machine are strongly recommended to carefully read to fully understand the following **SAFETY PRECAUTIONS** before using/maintaining the machine. The content of the **SAFETY PRECAUTIONS** includes items which are not contained in the specifications of your product.  
The risk indications are classified into the following three different categories to help understand the meaning of the labels. Be sure to fully understand the following description and strictly observe the instructions.

#### (I) Explanation of risk levels

	<b>DANGER :</b> This indication is given where there is an immediate danger of death or serious injury if the person in charge or any third party mishandles the machine or does not avoid the dangerous situation when operating or maintaining the machine.
	<b>WARNING :</b> This indication is given where there is a potentiality for death or serious injury if the person in charge or any third party mishandles the machine or does not avoid the dangerous situation when operating or maintaining the machine.
	<b>CAUTION :</b> This indication is given where there is a danger of medium to minor injury if the person in charge or any third party mishandles the machine or does not avoid the dangerous situation when operating or maintaining the machine.
	Items requiring special attention.

#### (II) Explanation of pictorial warning indications and warning labels

Pictorial warning indication		There is a risk of injury if contacting a moving section.	Pictorial warning indication		Be aware that holding the sewing machine during operation can hurt your hands.
		There is a risk of electrical shock if contacting a high-voltage section.			There is a risk of entanglement in the belt resulting in injury.
		There is a risk of a burn if contacting a high-temperature section.			There is a risk of injury if you touch the button carrier.
		Be aware that eye deficiency can be caused by looking directly at the laser beam.	Indication label		The correct direction is indicated.
		There is a risk of contact between your head and the sewing machine.			Connection of a earth cable is indicated.

Warning label						
	<ul style="list-style-type: none"><li>① • There is the possibility that slight to serious injury or death may be caused.<ul style="list-style-type: none"><li>• There is the possibility that injury may be caused by touching moving part.</li></ul></li><li>② • To perform sewing work with safety guard.<ul style="list-style-type: none"><li>• To perform sewing work with safety cover.</li><li>• To perform sewing work with safety protection device.</li></ul></li><li>③ • Be sure to turn the power OFF before carrying out "machine-head threading", "needle changing", "bobbin changing" or "oiling and cleaning".</li></ul>					
Electrical-shock danger label		<b>危険</b> 高電圧部分に触れて、大けがをすることがある。 電源を切って、5分以上たってからカバーをはずすこと。		<b>DANGER</b> Hazardous voltage will cause injury. Turn off main switch and unplug power cord and wait at least 5 minutes before opening this cover.		

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### SAFETY PRECAUTIONS

Accident means "to cause personal injury or death or damage to property."



#### DANGER

- When it is necessary to open the control box containing electrical parts, be sure to turn the power off and wait for five minutes or more before opening the cover in order to prevent accident leading to electrical shock.



#### CAUTION

##### Basic precaution

- Be sure to read the instruction manual and other explanatory documents supplied with accessories of the machine before using the machine. Carefully keep the instruction manual and the explanatory documents at hand for quick reference.
- The content of this section includes items which are not contained in the specifications of your product.
- Be sure to wear safety goggles to protect against accident caused by needle breakage.
- Those who use a heart pacer have to use the machine after consultation with a medical specialist.

##### Safety devices and warning labels

- Be sure to operate the machine after verifying that safety device(s) is correctly installed in place and works normally in order to prevent accident caused by lack of the device(s).
- If any of the safety devices is removed, be sure to replace it and verify that it works normally in order to prevent accident that can result in personal injury or death.
- Be sure to keep the warning labels adhered on the machine clearly visible in order to prevent accident that can result in personal injury or death. If any of the labels has stained or come unstuck, be sure to change it with a new one.

##### Application and modification

- Never use the machine for any application other than its intended one and in any manner other than that prescribed in the instruction manual in order to prevent accident that can result in personal injury or death. JUKI assumes no responsibility for damages or personal injury or death resulting from the use of the machine for any application other than the intended one.
- Never modify and alter the machine in order to prevent accident that can result in personal injury or death. JUKI assumes no responsibility for damages or personal injury or death resulting from the machine which has been modified or altered.

##### Education and training

- In order to prevent accident resulting from unfamiliarity with the machine, the machine has to be used only by the operator who has been trained/educated by the employer with respect to the machine operation and how to operate the machine with safety to acquire adequate knowledge and operation skill. To ensure the above, the employer has to establish an education/training plan for the operators and educate/train them beforehand.

##### Items for which the power to the machine has to be turned off

Turning the power off: Turning the power switch off, then removing the power plug from the outlet.  
This applies to the following.

- Be sure to immediately turn the power off if any abnormality or failure is found or in the case of power failure in order to protect against accident that can result in personal injury or death.
- To protect against accident resulting from abrupt start of the machine, be sure to carry out the following operations after turning the power off. For the machine incorporating a clutch motor, in particular, be sure to carry out the following operations after turning the power off and verifying that the machine stops completely.
  - For example, threading the parts such as the needle, looper, spreader etc. which have to be threaded, or changing the bobbin.
  - For example, changing or adjusting all component parts of the machine.
  - For example, when inspecting, repairing or cleaning the machine or leaving the machine.
- Be sure to remove the power plug by holding the plug section instead of the cord section in order to prevent electrical-shock, earth-leakage or fire accident.
- Be sure to turn the power off whenever the machine is left unattended between works.
- Be sure to turn the power off in the case of power failure in order to prevent accident resulting of breakage of electrical components.

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### PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

#### Transportation

- Be sure to lift and move the machine in a safe manner taking the machine weight in consideration. Refer to the text of the instruction manual for the mass of the machine.
- Be sure to take sufficient safety measures to prevent falling or dropping before lifting or moving the machine in order to protect against accident that can result in personal injury or death.
- Once the machine has been unpacked, never re-pack it for transportation to protect the machine against breakage resulting from unexpected accident or dropping.

#### Unpacking

- Be sure to unpack the machine in the prescribed order in order to prevent accident that can result in personal injury or death. In the case the machine is crated, in particular, be sure to carefully check nails. The nails have to be removed.
- Be sure to check the machine for the position of its center of gravity and take it out from the package carefully in order to prevent accident that can result in personal injury or death.

#### Installation

##### (I) Table and table stand

- Be sure to use JUKI genuine table and table stand in order to prevent accident that can result in personal injury or death. If it is inevitable to use a table and table stand which are not JUKI genuine ones, select the table and table stand which are able to support the machine weight and reaction force during operation.
- If casters are fitted to the table stand, be sure to use the casters with a locking mechanism and lock them to secure the machine during the operation, maintenance, inspection and repair in order to prevent accident that can result in personal injury or death.

##### (II) Cable and wiring

- Be sure to prevent an extra force from being applied to the cable during the use in order to prevent electrical-shock, earth-leakage or fire accident. In addition, if it is necessary to cable near the operating section such as the V-belt, be sure to provide a space of 30 mm or more between the operating section and the cable.
- Be sure to avoid starburst connection in order to prevent electrical-shock, earth-leakage or fire accident.
- Be sure to securely connect the connectors in order to prevent electrical-shock, earth-leakage or fire accident. In addition, be sure to remove the connector while holding its connector section.

##### (III) Grounding

- Be sure to have an electrical expert install an appropriate power plug in order to prevent accident caused by earth-leakage or dielectric strength voltage fault. In addition, be sure to connect the power plug to the grounded outlet without exceptions.
- Be sure to ground the earth cable in order to prevent accident caused by earth leakage.

##### (IV) Motor

- Be sure to use the specified rated motor (JUKI genuine product) in order to prevent accident caused by burnout.
- If a commercially available clutch motor is used with the machine, be sure to select one with an entanglement preventive pulley cover in order to protect against being entangled by the V-belt.

#### Before operation

- Be sure to make sure that the connectors and cables are free from damage, dropout and looseness before turning the power on in order to prevent accident resulting in personal injury or death.
- Never put your hand into the moving sections of the machine in order to prevent accident that can result in personal injury or death.  
In addition, check to be sure that the direction of rotation of the pulley agrees with the arrow shown on pulley.
- If the table stand with casters is used, be sure to secure the table stand by locking the casters or with adjusters, if provided, in order to protect against accident caused by abrupt start of the machine.

#### During operation

- Be sure not to put your fingers, hair or clothing close to the moving sections such as the handwheel, hand pulley and motor or place something near those sections while the machine is in operation in order to prevent accident caused by entanglement that can result in personal injury or death.
- Be sure not to place your fingers near the needle or inside the thread take-up lever cover when turning the power on or while the machine is in operation in order to prevent accident that can result in personal injury or death.
- The machine runs at a high speed. Never bring your hands near the moving sections such as looper, spreader, needle bar, hook and cloth trimming knife during operation in order to protect your hands against injury. In addition, be sure to turn the power off and check to be sure that the machine completely stops before changing the thread.
- Be careful not to allow your fingers or any other parts of your body to be caught between the machine and table when removing the machine from or replacing it on the table in order to prevent accident that can result in personal injury or death.

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5. Be sure to turn the power off and check to be sure that the machine and motor completely stop before removing the belt cover and V-belt in order to prevent accident caused by abrupt start of the machine or motor.
6. If a servomotor is used with the machine, the motor does not produce noise while the machine is at rest. Be sure not to forget to turn the power off in order to prevent accident caused by abrupt start of the motor.
7. Never use the machine with the cooling opening of the motor power box shielded in order to prevent fire accident by overheat.

#### Lubrication

1. Be sure to use JUKI genuine oil and JUKI genuine grease to the parts to be lubricated.
2. If the oil adheres on your eye or body, be sure to immediately wash it off in order to prevent inflammation or irritation.
3. If the oil is swallowed unintentionally, be sure to immediately consult a medical doctor in order to prevent diarrhea or vomiting.

#### Maintenance

1. In prevention of accident caused by unfamiliarity with the machine, repair and adjustment has to be carried out by a service technician who is thoroughly familiar with the machine within the scope defined in the instruction manual. Be sure to use JUKI genuine parts when replacing any of the machine parts. JUKI assumes no responsibility for any accident caused by improper repair or adjustment or the use of any part other than JUKI genuine one.
2. In prevention of accident caused by unfamiliarity with the machine or electrical-shock accident, be sure to ask an electrical technician of your company or JUKI or distributor in your area for repair and maintenance (including wiring) of electrical components.
3. When carrying out repair or maintenance of the machine which uses air-driven parts such as an air cylinder, be sure to remove the air supply pipe to expel air remaining in the machine beforehand, in order to prevent accident caused by abrupt start of the air-driven parts.
4. Be sure to check that screws and nuts are free from looseness after completion of repair, adjustment and part replacement.
5. Be sure to periodically clean up the machine during its duration of use. Be sure to turn the power off and verify that the machine and motor stop completely before cleaning the machine in order to prevent accident caused by abrupt start of the machine or motor.
6. Be sure to turn the power off and verify that the machine and motor stop completely before carrying out maintenance, inspection or repair of the machine. (For the machine with a clutch motor, the motor will keep running for a while by inertia even after turning the power off. So, be careful.)
7. If the machine cannot be normally operated after repair or adjustment, immediately stop operation and contact JUKI or the distributor in your area for repair in order to prevent accident that can result in personal injury or death.
8. If the fuse has blown, be sure to turn the power off and eliminate the cause of blowing of the fuse and replace the blown fuse with a new one in order to prevent accident that can result in personal injury or death.
9. Be sure to periodically clean up the air vent of the fan and inspect the area around the wiring in order to prevent fire accident of the motor.

#### Operating environment

1. Be sure to use the machine under the environment which is not affected by strong noise source (electromagnetic waves) such as a high-frequency welder in order to prevent accident caused by malfunction of the machine.
2. Never operate the machine in any place where the voltage fluctuates by more than "rated voltage  $\pm 10\%$ " in order to prevent accident caused by malfunction of the machine.
3. Be sure to verify that the air-driven device such as an air cylinder operates at the specified air pressure before using it in order to prevent accident caused by malfunction of the machine.
4. To use the machine with safety, be sure to use it under the environment which satisfies the following conditions:
- Ambient temperature during operation 5°C to 35°C
- Relative humidity during operation 35 % to 85 %
5. Dew condensation can occur if bringing the machine suddenly from a cold environment to a warm one. So, be sure to turn the power on after having waited for a sufficient period of time until there is no sign of water droplet in order to prevent accident caused by breakage or malfunction of the electrical components.
6. Be sure to stop operation when lightning flashes for the sake of safety and remove the power plug in order to prevent accident caused by breakage or malfunction of the electrical components.
7. Depending on the radio wave signal condition, the machine may generate noise in the TV or radio. If this occurs, use the TV or radio with kept well away from the machine.
8. In order to ensure the work environment, local laws and regulations in the country where the sewing machine is installed shall be followed.
- In the case the noise control is necessary, an ear protector or other protective gear should be worn according to the applicable laws and regulations.
9. Disposal of products and packages and treatment of used lubricating oil should be carried out properly according to the relevant laws of the country in which the sewing machine is used.

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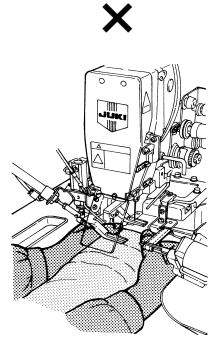
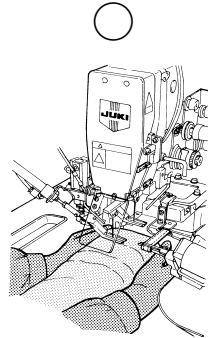
## Precautions to be taken so as to use the MOL-254 more safely



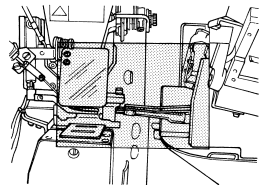
1. To prevent accidents caused by electric shock hazards, do not open the control box cover of motor or touch the components inside the control box.



1. To prevent accidents caused by abrupt start of the machine, depress the start switch after confirming that there is no interference under the needle when winding thread.
2. To prevent accidents caused by abrupt start of the machine, when turning ON the set ready switch or threading switch, do not place your fingers under the cloth presser foot since the cloth presser foot automatically comes down. Do not place your fingers near the cloth presser foot while the machine is in operation.
3. Do not place your fingers near the needle entry area or inside the thread take-up cover while the machine is in operation.
4. Before removing any of the covers provided for your machine, the power switch has to be turned OFF without fail.
5. If your machine is provided with safety devices such as covers, finger guards and eye guards, never operate your machine with any of them removed. Whenever you detach any of them from the machine, reinstall it in its original position.
6. Casters and adjusting bolts have to be fixed before putting the machine into service.
7. If it is necessary to suddenly stop the machine while it is in operation, press the temporary stop switch located on the control panel.
8. Carefully tilt/raise the machine with your both hands, when necessary, after having turned OFF the power switch.
9. The belt loop supplying device starts to work, simultaneously with the turning-ON of the set ready switch, to allow its fork to move at a high speed with a belt loop toward the area under the needle. This means that the fork could pierce into your hands or fingers if you place your hand within the dangerous area. So, it is quite necessary for you to place your hand at the correct operating position and not to put it in the dangerous area.



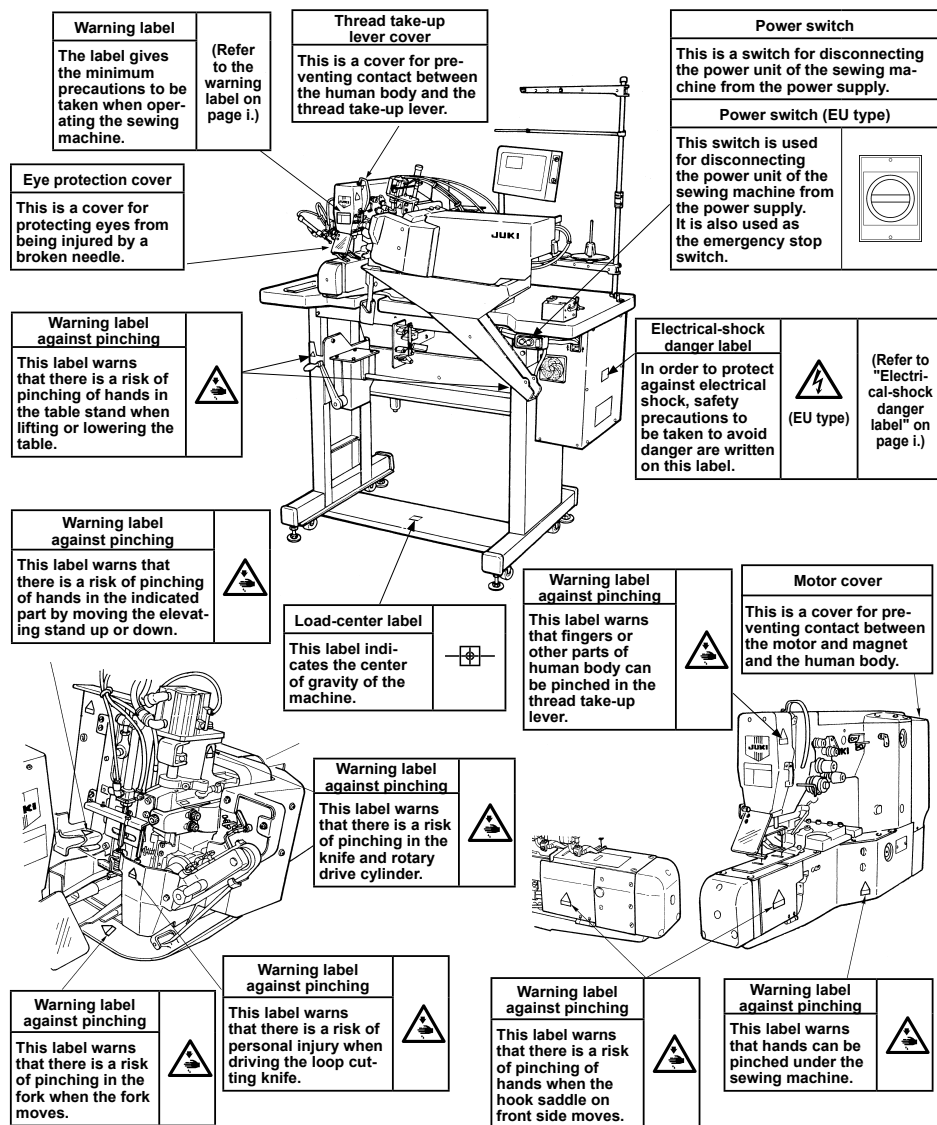
Hazardous area



10. To ensure safety, never operate the machine with the ground wire for the power supply removed.
11. The motor is completely silent when the machine is at rest. So, attention has to be paid not to forget to turn OFF the power to the machine after the termination of work.
12. If the machine is suddenly moved from a cold place to a warm place, dew condensation may be observed. In this case, turn ON the power to the machine after you have confirmed that there is no danger of water drops in the machine.
13. When inserting/removing the power connector, the power switch has to be turned OFF in prior.
14. Be careful of handling this product so as not to pour water or oil, shock by dropping, and the like since this product is a precision instrument.
15. This is a Class A product. In a domestic environment this product may cause radio interference, in which case the user may be required to make corrective actions.
16. Be careful to keep your hands away from the operating area of the fork, loop cutter, loop draw-out device, hook moving device and the presser foot since those parts carry out their initial operation when you press the RESET switch after having turned the power ON.

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## Safety devices and warning labels



In addition, be aware that the safety devices such as the "eye protection cover" and "finger guard" are sometimes omitted in the sketches, illustrations and figures included in the Instruction Manual for the explanation's sake. In the practical use, never remove those safety devices.

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## EC DECLARATION OF CONFORMITY

We hereby declare that the sewing unit or sewing system described as

Model	MOL-254
Description	Industrial Sewing Unit
Function	automatically make stitches and sew

complies with the following applicable regulations :

EU Machinery Directive 2006/42/EC

EU EMC Directive 2014/30/EU

EU RoHS Directive 2011/65/EU

Applied harmonized standards, in particular :

EN ISO12100, EN ISO10821, EN IEC 60204-31, EN 50581

Manufacturer :

JUKI CORPORATION

2-11-1, Tsurumaki, Tama-shi, Tokyo, Japan

**JUKI**

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17 - 05 Printed in Japan