

***ENGLISH***

**MEB-3200C**  
**Multi cutting device**  
**INSTRUCTION MANUAL**

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# 1. SPECIFICATIONS

Specifications	SS △ M type, RS △ M type
Application	Men's and ladies' wear
Sewing speed	400 to 2,200 sti/min (adjustable in 100 sti/min steps)
Stitch length (Notes 1 and 2)	10 to 38 mm (with looper thread trimmer) 10 to 50 mm (in case of removing looper thread trimming device)
Stitch bite width (Notes 3 and 4)	2.0 to 3.2 mm
Taper bar length	0 mm, 3 to 15 mm
Lift of presser foot	13 mm (Max. 16 mm)
Method of changing sewing shape	Program selection method
Buttonhole cutting system (Note 5)	Cut-before knife, cut-after knife, without knife
Feed system	Intermittent feed by stepping motor
Cloth cutting drive	Vertical drive by stepping motor
Needle (Note 3)	DO × 558 #90 to 110
Safety device	Temporary stop switch and automatic stop function at the time of detection of trouble
Lubricating oil	JUKI New Defrix Oil No. 2
Air pressure	0.49 Mpa
Air consumption	9 l/min (7-cycle/min)
Noise level	81.5 dB/max. speed 2,200 sti/min
Dimensions	1,060 mm (W) × 790 mm (L) × 1,230 mm (H) (Excluding thread stand)
Power consumption	550 VA
Gross weight	178 kg

Note 1 : Stitch length becomes as follows in accordance with the knife holder.

## ■ Provided with the looper thread trimmer (memory switch "U56" (looper thread trimmer) "0")

Part No.	Knife holder length (mm)	Max. stitch length		Min. stitch length		Shape of the knife holder
		Eyelet button-hole (mm)	Decorative buttonhole (mm)	Eyelet button-hole (mm)	Decorative buttonhole (mm)	
32087801 (*)	18	38 (*)	38 (*)	18	10	Without step
32087702	26	38 (*)	38 (*)	26	16	
32087603	32	38 (*)	38 (*)	32	22	
32088106	18	38 (*)	38 (*)	10	10	With step
32088007	26	38 (*)	38 (*)	16	16	
32087900	32	38 (*)	38 (*)	22	22	

\* : Provided as standard

(\*) : When stitch length exceeds 32 mm at the time of straight bartacking and round bartacking, defective clamping or defective cutting of looper thread, and gimp may occur.

## ■ Provided without the looper thread trimmer (memory switch "U56" (looper thread trimmer) "1")

Knife holder length (mm)	Max. stitch length	
	Eyelet buttonhole (mm)	Decorative buttonhole (mm)
18	38	38
26	46	46
32	50	50

\* Min. stitch length is the same as that with looper thread trimmer.

Note 2 : Be sure to use the knife holders exclusive for the multicutting device (32087801, 32087702, 32087603, 32088106, 32088007 and 32087900).

In addition, be careful of the clearances between the knife holder and the right/left presser feet.  
(The knife holder may come in contact with the presser holding plate at the time of cloth cutting.)

Note 3 : Stitch bite width and needle No. are set as follows at the time of delivery from the factory.

Stitch bite width : 2.3 mm

Needle No. : #100

(When changing the stitch bite width or the needle No., make sure of the installing positions of needle and looper, and the spreaders, the timing to open/close the spreaders, and the clearance between the needle and the needle guard.)

Note 4 : The range of stitch bite width can be changed from 2.0 to 3.2 mm to 2.6 to 4.0 mm by changing the optional left looper and the optional left spreader.

Note 5 : When the clearances between the knife holder and the right/left presser feet are narrow, the knife holder, presser feet and presser holding plate may interfere with one another.

Note 6 : Confirm the material before using since it may be damaged according to the material to be sewn.  
When the material is damaged, replace the presser holding plate with the presser holding plate supplied as accessories (40040681 or 40040682), perform the adjustment of cloth open amount, and widen the clearance between the presser holding plate and the knife holder.  
(Refer to **"8. CLEARANCE BETWEEN THE PRESSER HOLDING PLATE AND THE KNIFE HOLDER"** p.14. Confirm again after the adjustment.

Note 7 : When cloth chip or waste thread is caught between the knife section on eyelet side and that on straight stitch side, the knife on the eyelet side may break. Perform periodical cleaning more than once a day as the standard.

Note 8 : If you want to retrofit the multi cutting device to your sewing machine, refer to **"6. MODEL SETTING"** p.12.

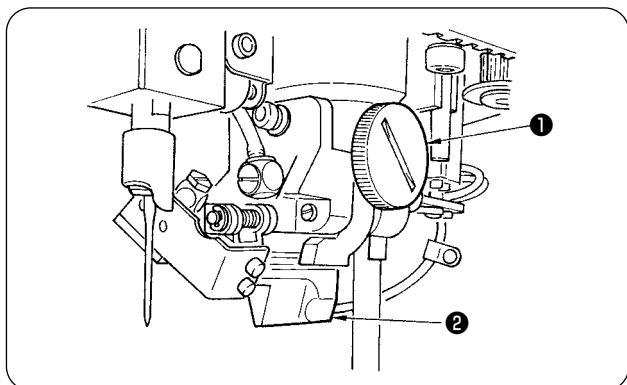
## 2. INSTALLING THE MULTICUTTING DEVICE



### WARNING :

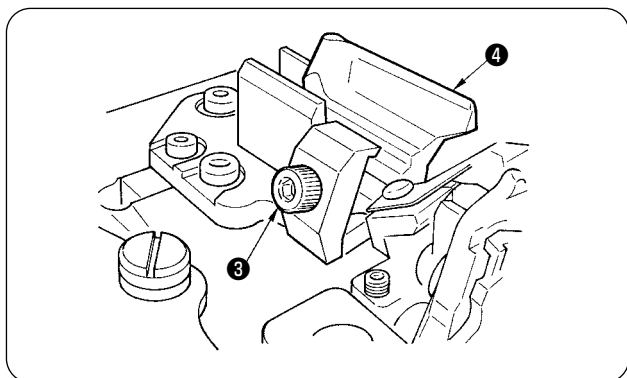
Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

- Before installing
- Check new/old of the knife installing base. When the old components are installed, replace them with new ones.
  - System ROM corresponds to that after Rev.011G. Confirm Rev. of system ROM which is installed.

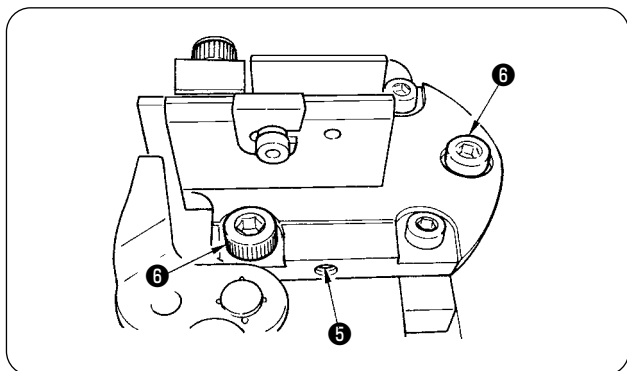


### (1) Removing the cloth cutting knife base

- 1) Turn OFF the power and the air to the machine.
- 2) Loosen fixed screw ❶ and remove knife holder ❷ .



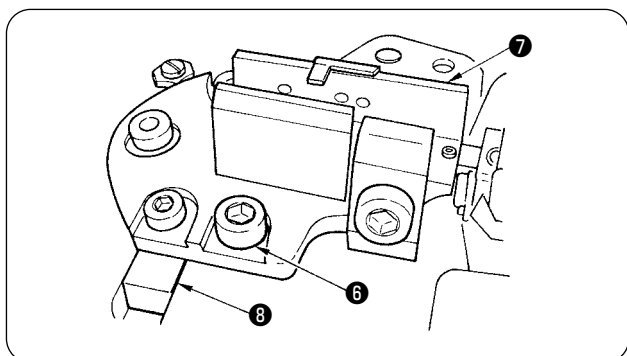
- 3) Loosen setscrew ❸ and remove cloth cutting knife ❹ .

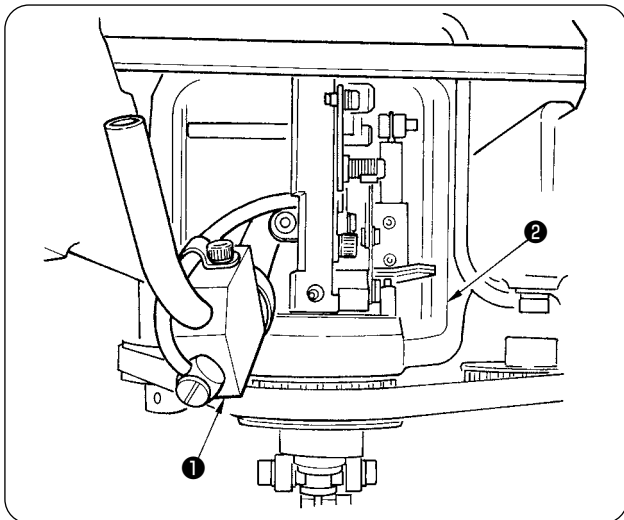


- 4) Loosen setscrew ❺ .
- 5) Remove three setscrews ❻ in the knife base and remove cloth cutting knife base ❼ (together with knife base key ❽ ) from the machine bed. (Remove the piping connected to the base as well.)



Three setscrews ❻ in the knife base are used again. Keep them without losing.

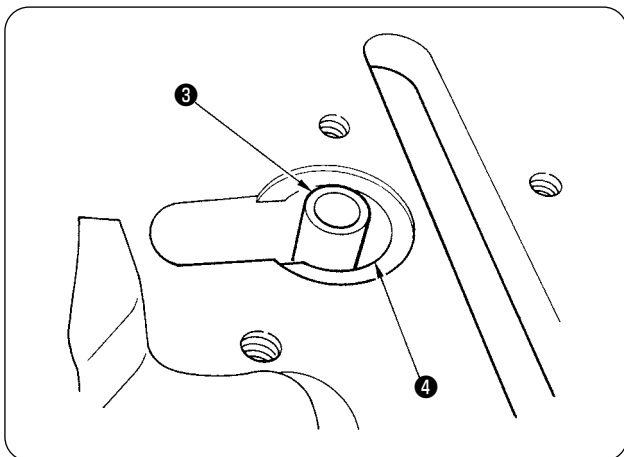




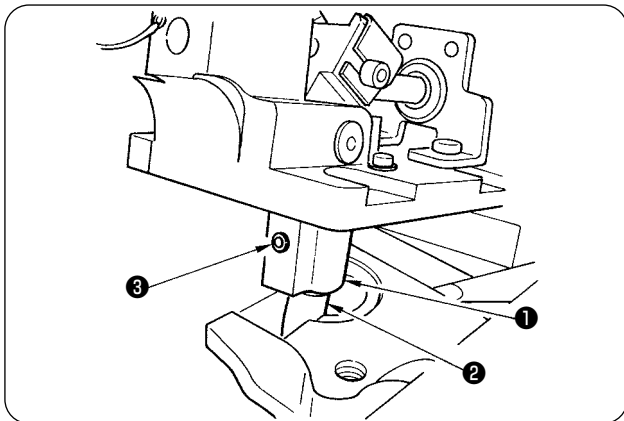
## (2) Installing the cloth chip suction device asm.

- 1) Remove the cloth chip chute hose from the bottom cover.
- 2) Insert cloth chip suction device asm. ❶ to machine bed ❷ and adjust so that cloth chip chute A ❸ appears from hole ❹ of the machine bed. (It is possible to insert it from the rear side.)

[Pass the air tube (black) of the cloth chip suction device and the cloth chip hose (white) up to the rear side of the machine bed.]



- 3) Attach the cloth chip chute hose of the cloth chip suction device asm. to the bottom cover after connecting with the cloth cutting knife base A. (When the diaphragm elbow [Part No. : PJ304120002] is assembled to the bottom cover, remove it and replace it with cloth chip bush [Part No. : 32006504].)



### (3) Installing the cloth cutting knife base A asm.

- 1) Loosen two setscrews and remove cloth cutting knife (eyelet) and cloth cutting knife (straight) from the device.

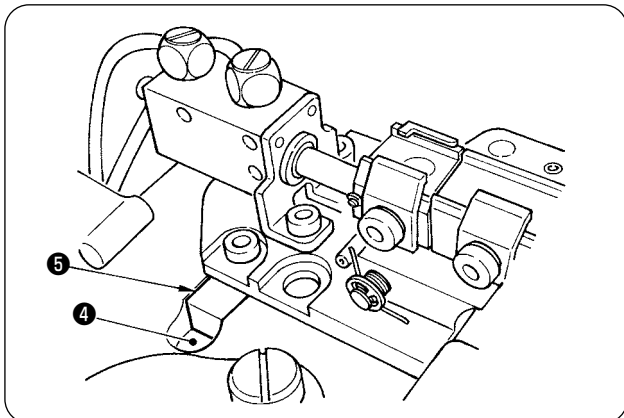
(Refer to **"7. REPLACING THE CLOTH CUTTING KNIFE"** p.13.)

- 2) Insert cloth chip chute A (2) into cloth chip chute boss (1) and fix it with setscrew (3) .

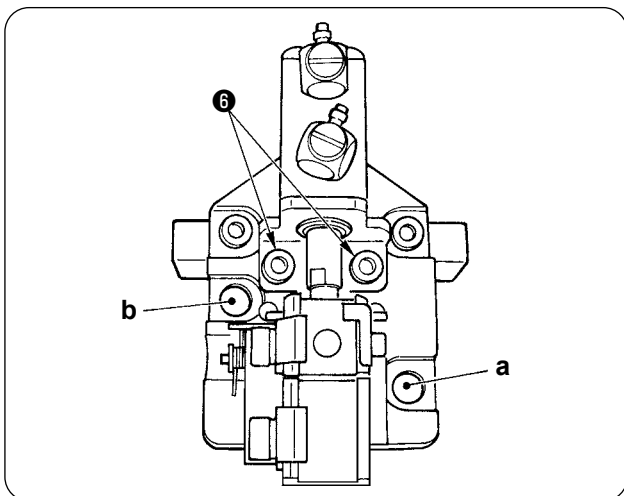


**Fix the cloth chip chute asm. so that it does not tilt.**

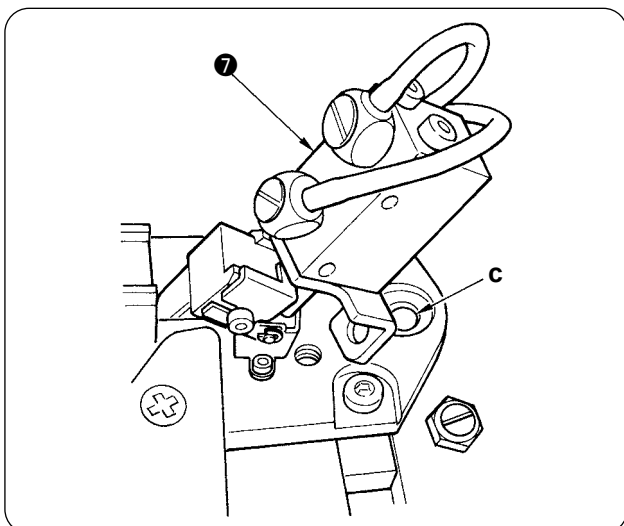
- 3) Put cloth cutting knife base key (5) in key slot (4) of the machine bed.



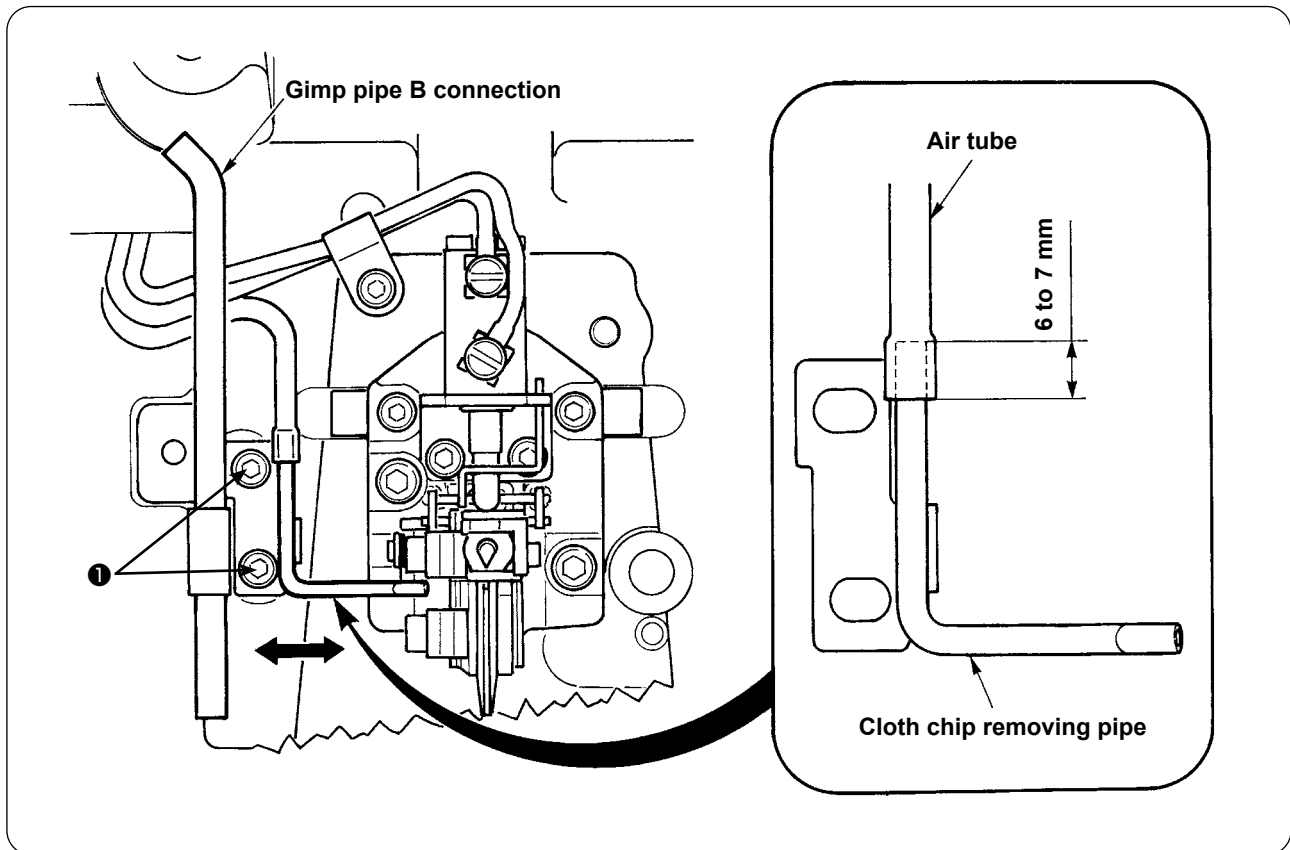
- 4) Put two setscrews in the knife base which have been removed in the process 5) of (1) in the mounting holes, **a** and **b**. Then fix them after checking the lateral position of the device (refer to **"4.-(1) Adjusting the knife dropping position"** p.11.).



- 5) Remove two setscrews (6) and raise knife base cylinder (7) .
- 6) Put one setscrew in the knife base which has been removed in the process 5) of (1) in the mounting hole, **c** and fix it.
- 7) Return knife base cylinder (7) to its home position and fix it with two setscrews (6) .

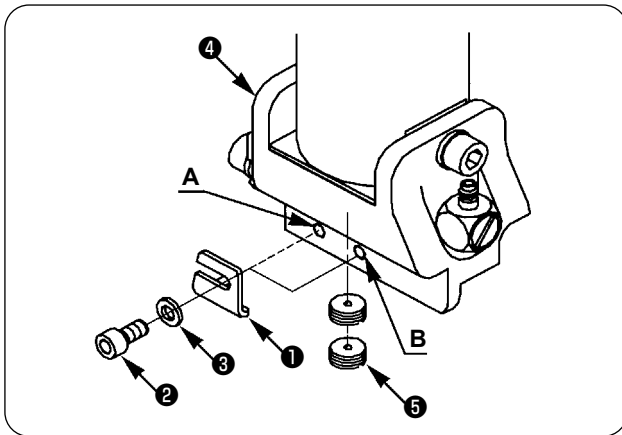


#### (4) Installing the cloth chip removing pipe



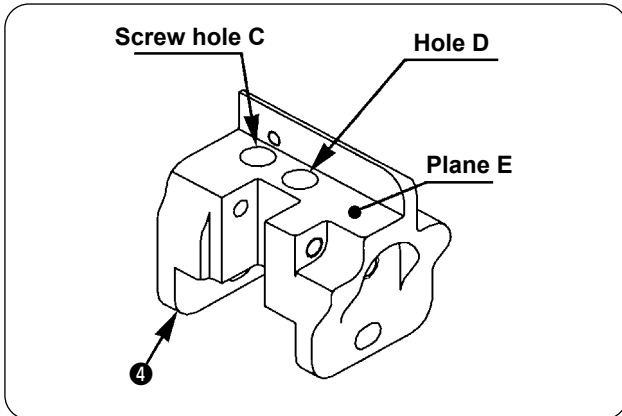
- 1) Insert the air tube supplied as accessories by 6 to 7 mm into the cloth chip removing pipe.
- 2) Remove the setscrews of gimp pipe B connection ❶, place the cloth chip removing pipe on the gimp pipe B connection ❶, and tighten the both with the setscrews.
- 3) Move the cloth chip removing pipe in the direction of the arrow mark and set it to the position where it comes in contact with the knife base.



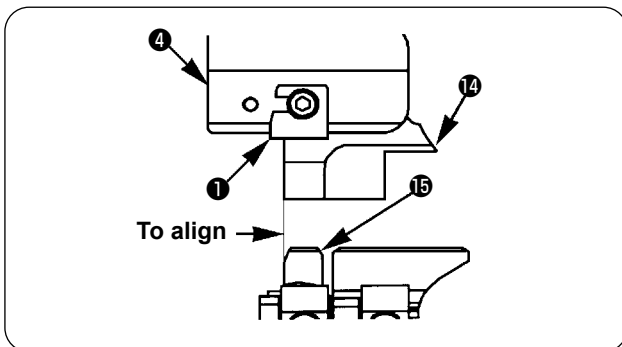


## (5) Changing the position of the knife stopper

- 1) Remove knife stopper ① of knife fitting base ④, setscrew ② and washer ③, and change from screw hole A to screw hole B.



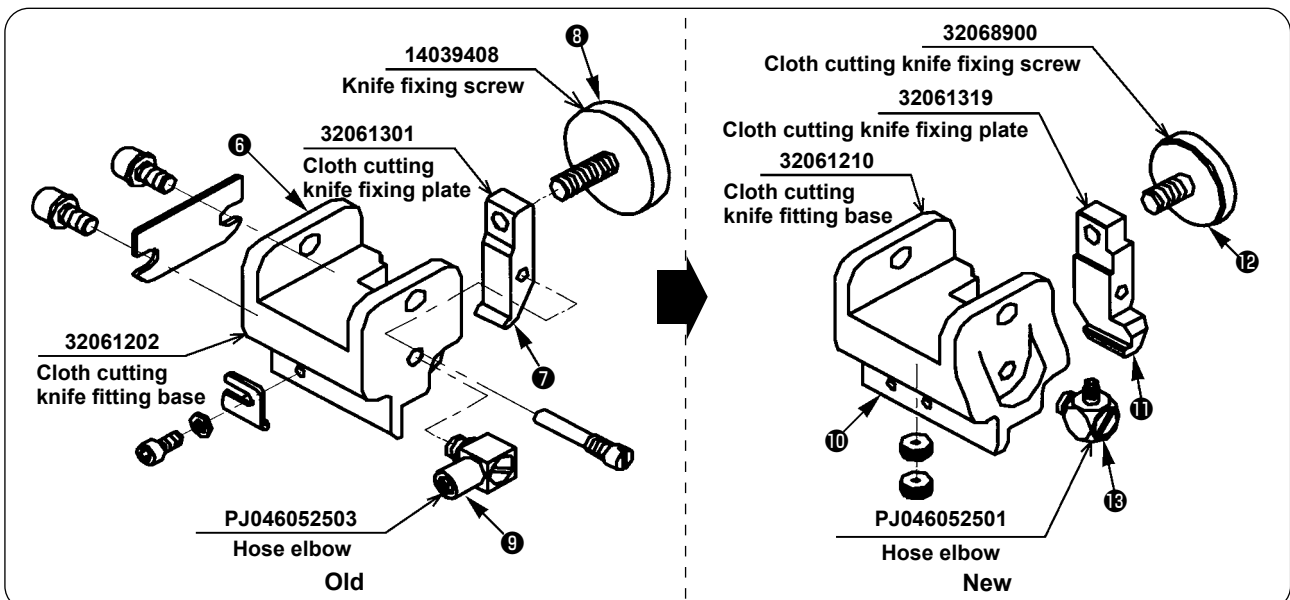
- 2) Attach two stop plugs ⑤ to screw hole C so that the stop plugs do not protrude from the knife fitting plane E.



- 3) Adjust the position of knife stopper ⑭ so that the back of cloth cutting knife (eyelet) ⑮ and that of knife holder ① align with each other.



When old parts below ( ⑥ , ⑦ , ⑧ and ⑨ ) are assembled into the sewing machine, replace all of them with new parts ( ⑩ , ⑪ , ⑫ and ⑬ ). (Assemble the other old parts in the illustration into new parts without replacing them.)

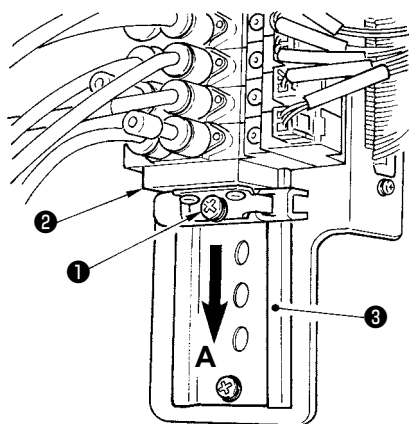


### 3. CONNECTING THE PNEUMATIC COMPONENTS



#### WARNING :

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

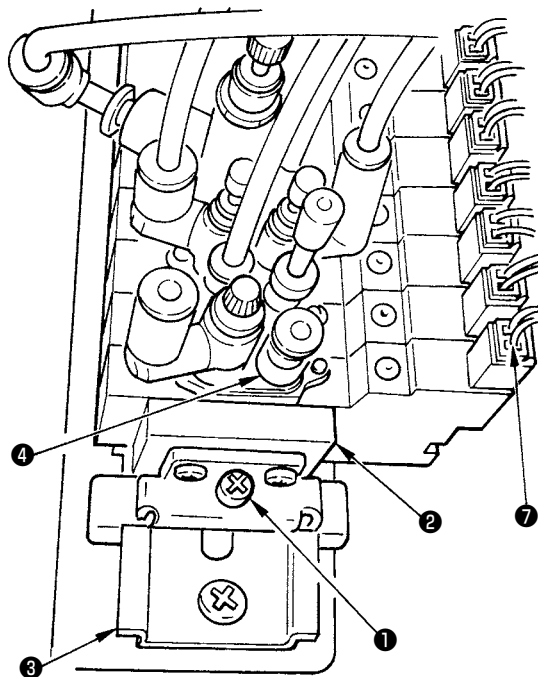


#### (1) Piping the knife base cylinder

- 1) Loosen setscrew ❶ in the end block, draw end block ❷ in the direction A, and draw it out from rail ❸ .
- 2) Attach three bushes supplied with the device as accessories to solenoid valve ❹ and insert solenoid valve ❹ into rail ❸ .
- 3) Insert end block ❷ into rail ❸ and making the solenoid valve come in close contact with it, tighten setscrew ❶ .

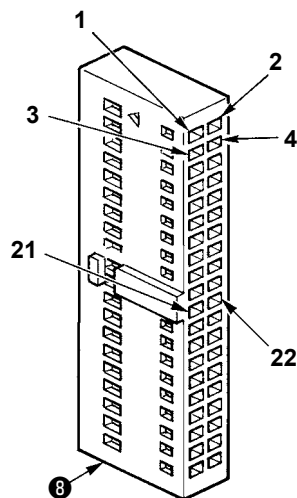


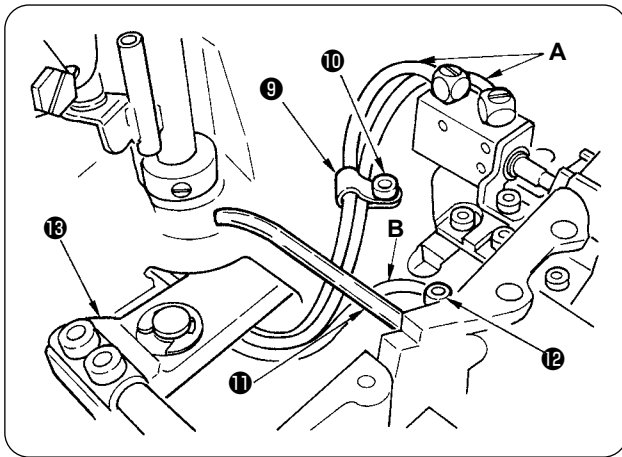
1. When tightening setscrew ❶ , air leakage will be caused unless the respective solenoid valves come in close contact with each other. Be careful that there is no clearance between them.
2. Check that the bushes supplied with the device as accessories are put between the respective solenoid valves and the end block.



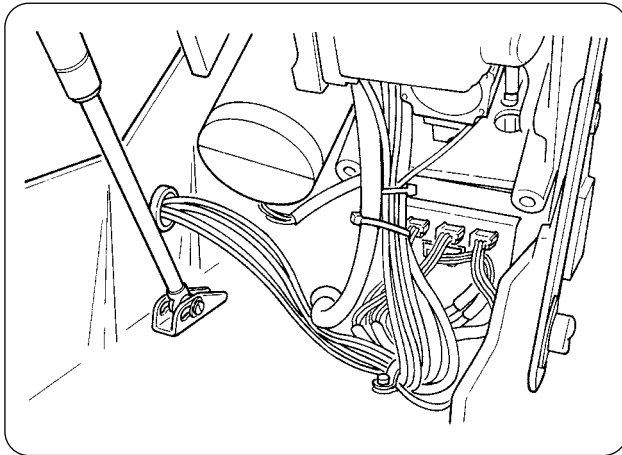
- 4) Connect solenoid valve cable ❷ to solenoid valve ❹ .
- 5) Insert the pins of solenoid valve cable ❷ to the designated places of connector ❸ .

Solenoid valve No.	Cable color	Connector No.
❹	Red	21
❹	Black	22

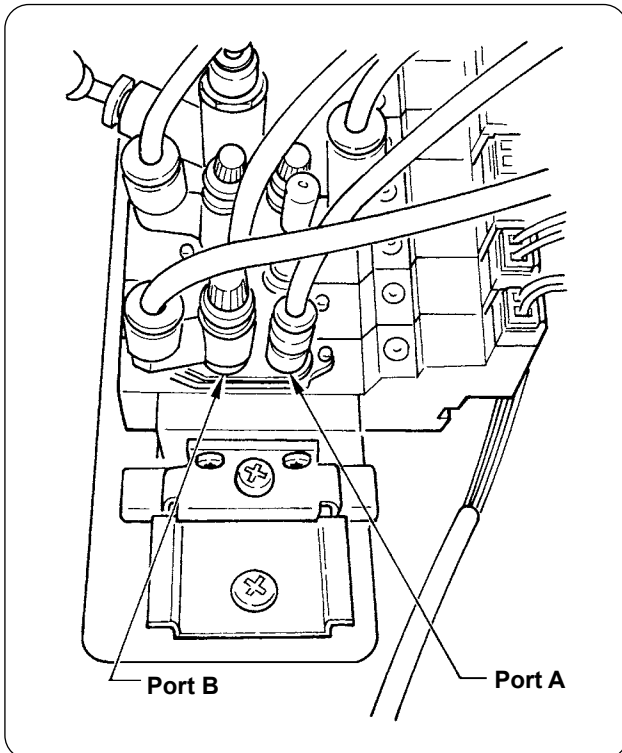




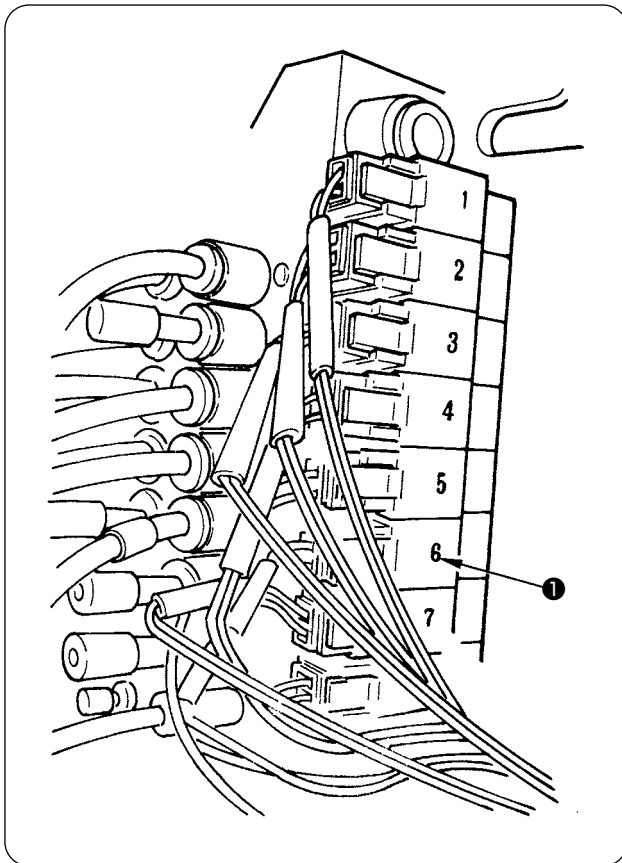
- 6) Fix the air tubes **A** of air cylinder with cable clip **9** and setscrew **10** supplied with the device as accessories, loosen two gimp pipe B setscrews **12** and pass air tube **A** of the air cylinder and air tube **B** of the cloth chip removing pipe between gimp pipe B **11** and the machine bed.
- 7) Pass them under lengthwise feed guide shaft fixing base **13** and insert them into the inside of the machine bed.



- 8) Perform piping of the air tubes up to the bottom of the machine table as shown in the illustration and fix them with the air tube of the cloth chip suction device with the clip band supplied with the device as accessories.

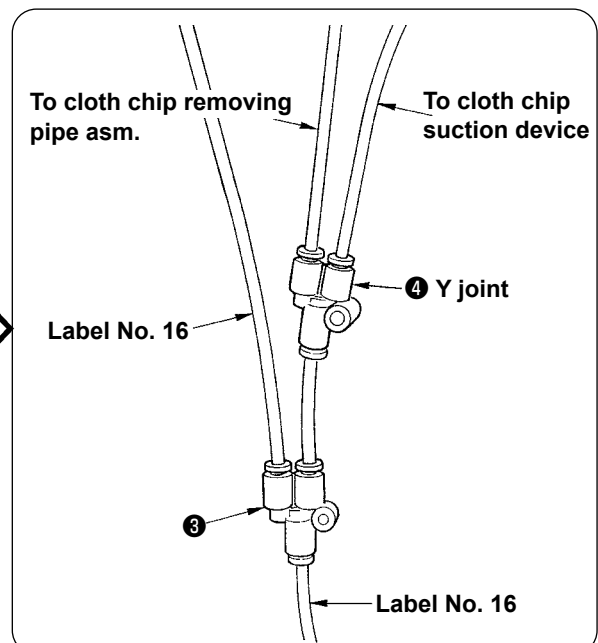
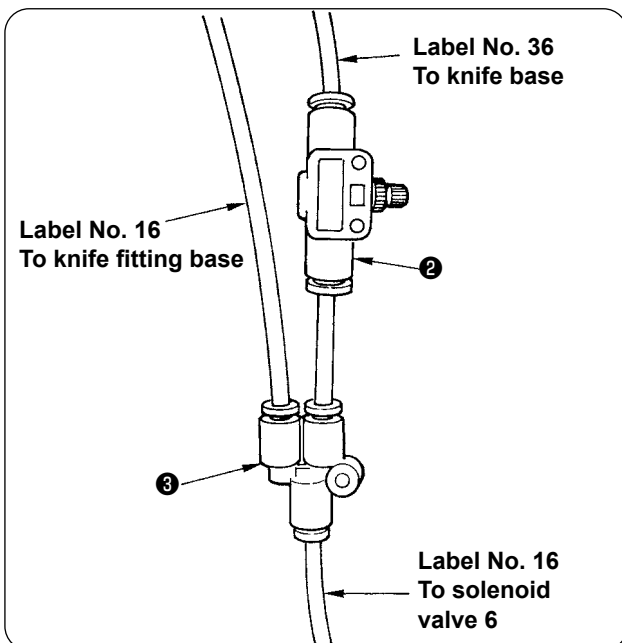


- 9) Connect the air tube on the side where the cloth cutting knife (eyelet) tilts to port **A**.
- 10) Connect the air tube on the side where the cloth cutting knife (eyelet) rises to port **B**.



## (2) Piping the cloth chip suction device

- 1) Remove the piping of label No. 36 (to knife base) of solenoid valve No. 6 (cloth chip blow) ① from the end of speed controller ② (including speed controller ②).
- 2) Insert Y joint ④ supplied as accessories to the end of Y joint ③ from which the piping has been removed, and insert the respective pipings from the cloth chip suction device and the cloth chip removing pipe asm. to Y joint ④.

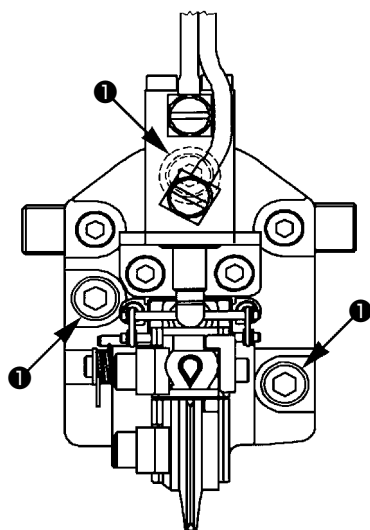


## 4. ADJUSTING THE MULTICUTTING DEVICE



### WARNING :

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

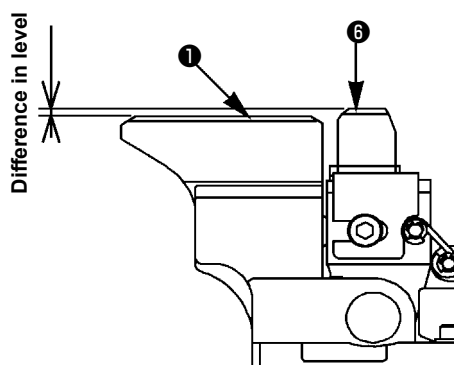


### (1) Adjusting the knife dropping position

- 1) Loosen three setscrews ① in the knife base and adjust the lateral position of the device so that the cutting portion is laterally equal to the stitches.



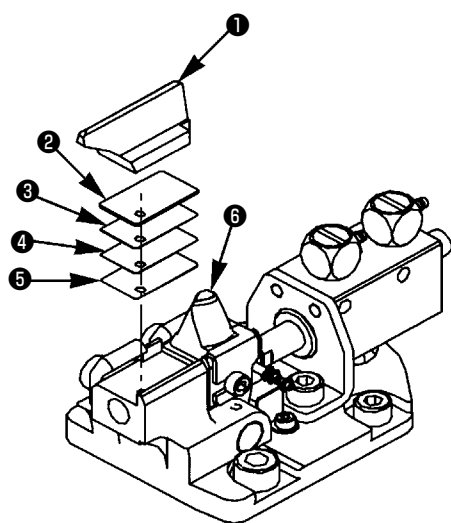
Adjust the lateral position of the knife holder as well and adjust so that the cloth cutting knife comes to the center of the knife holder.



### (2) Adjusting the difference in level between the knives

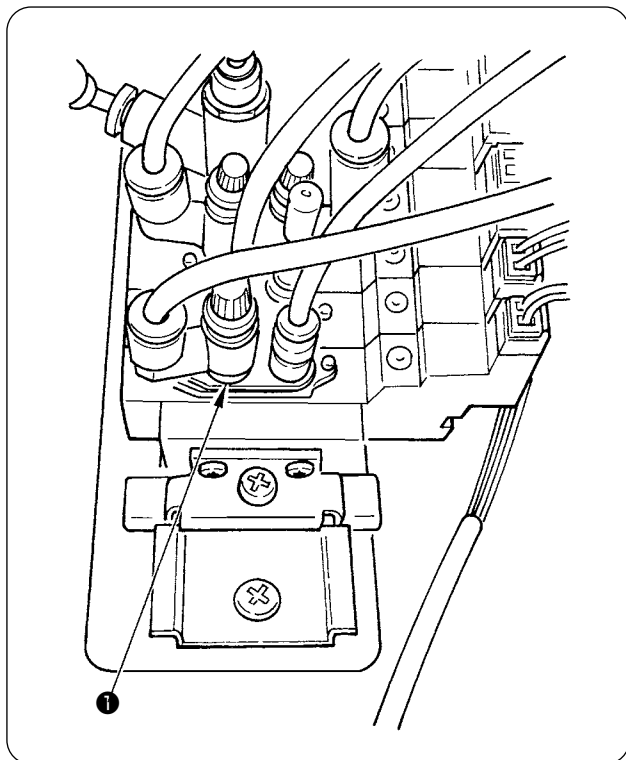
When replacing the respective cloth cutting knives, difference in level may occur between cloth cutting knife (eyelet) ⑥ and cloth cutting knife (straight) ①. Adjust so that there is no difference in level between cloth cutting knife (eyelet) ⑥ and cloth cutting knife (straight) ①.

- 1) Remove cloth cutting knife (straight) ① and knife base spacer A ②.
- 2) Adjust so that there is no difference in level by means of a combination of knife base spacer B ③, knife base spacer C ④ and knife base spacer D ⑤ supplied with the unit as accessories or those attached to the unit.



1. When replacing either cloth cutting knife (eyelet) or cloth cutting knife (straight), be sure to check the height.
2. When cloth cutting knife (eyelet) is higher, parallel portion cannot be cut.
3. When cloth cutting knife (straight) is higher, eyelet portion cannot be cut.
4. Be sure to fit knife base spacers B, C and D between knife base spacer A and the knife base.

## 5. ADJUSTING THE PNEUMATIC COMPONENTS



### (1) Adjusting the speed controller

Adjust speed controller ❶ to such an extent that there is shock when returning the cloth cutting knife (eyelet) from the tilted state.

(Standard : Adjust the adjustment screw of the speed controller to the open by approximately one turn from the full close. <Speed controller has been factory-adjusted at the time of delivery.>)



When the return speed of cloth cutting knife (eyelet) is too fast, the position of cloth cutting knife may slip.

## 6. MODEL SETTING

Set the memory switch "K71" (model selection) as described below.

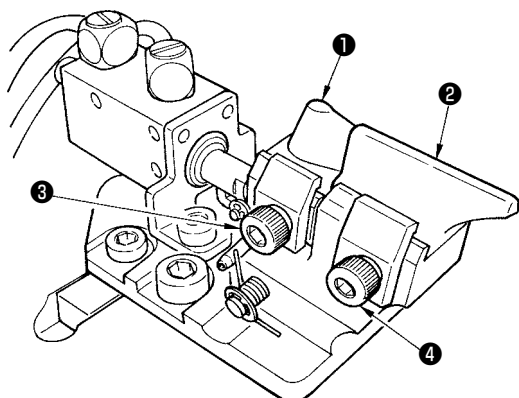
- 9: S type multi cut (for domestic use)
- 10: S type multi cut (for export)

## 7. REPLACING THE CLOTH CUTTING KNIFE



### WARNING :

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



### (1) Replacing the cloth cutting knife (eyelet)

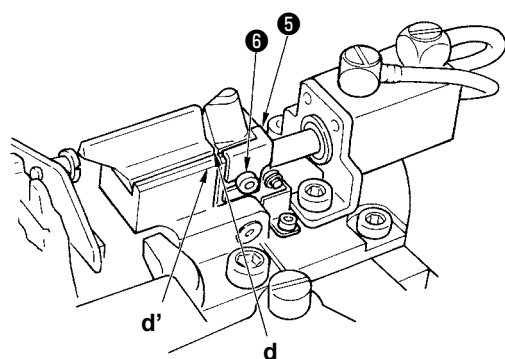
- 1) Loosen setscrew ③ and remove cloth cutting knife (eyelet) ①.
- 2) Press the knife you desire to replace to stopper ⑤ and tighten setscrew ③ to fix the knife.



Do not loosen screw ⑤ since stopper ⑥ is for positioning.

### (2) Replacing the cloth cutting knife (straight)

- 1) Loosen setscrew ④ and remove cloth cutting knife (straight) ②.
- 2) Adjust edge "d" of the knife you desire to replace to edge "d'" of knife base A and tighten setscrew ④ to fix the knife.

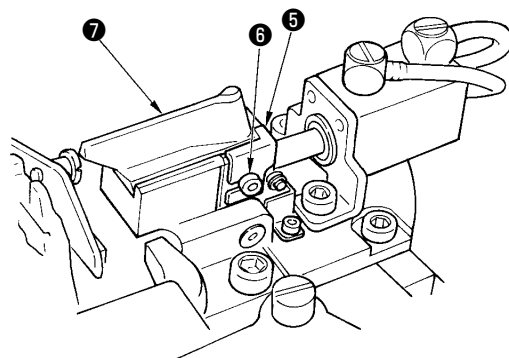


### (3) Replacing the knife with one-time cutting knife (optional)

- 1) Loosen setscrews ③ and ④, and remove cloth cutting knife (eyelet) ① and cloth cutting knife (straight) ②.
- 2) Press knife ⑦ you desire to replace to stopper ⑤, and tighten setscrews ③ and ④ to fix it.

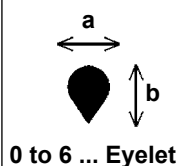


Do not remove the cutting knife spacer under cloth cutting knife (straight) ②.



- \* One-time cutting knives described in the list below are prepared.

Part No.	Eyelet size		Remarks	
	a	b	Knife No.	Max. cut length
40012587	2.9	4.4	3	32
40012588	2.7	5.1	6	32
40251323	2.1	3.1	1	32



No.	a	b	Remarks
0	0.0	0.0	
1	2.1	3.2	Option
2	2.5	3.8	
3	2.9	4.4	Option
4	3.0	4.6	
5	3.2	5.4	
6	2.7	5.1	Option

- \* When using one-time cutting knife, select knife Nos. 0 to 6. (Nos. 1, 3 and 6 correspond to optional cloth cutting knives.)
- \* Use knife Nos. 2, 4 and 5 when increasing or decreasing the eyelet shape in terms of the knife shape which is installed.
- \* Knife No. 0 is of decorative buttonholing shape. When using optional cloth cutting knife, do not use it.
- \* If you use the one-time cutting knife (optional), set the memory switch "U90" to "OFF".

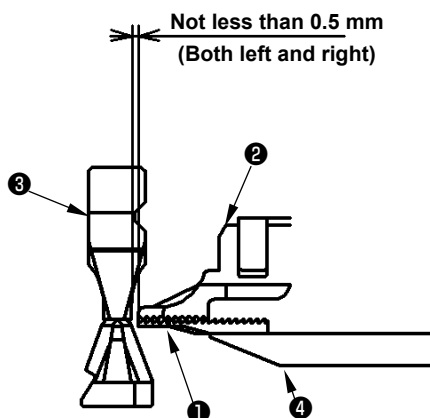
## 8. CLEARANCE BETWEEN THE PRESSER HOLDING PLATE AND THE KNIFE HOLDER



### WARNING :

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

In case of standard presser holding plate ①  
(32027005, 32027104)



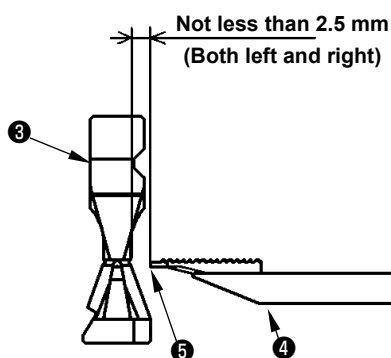
Confirm that there is a clearance of not less than 0.5 mm between presser foot ② and presser holding plate ① (Parts Nos. : 32027005 and 32027104) and knife holder ③ with left and right presser plates ④ closed.

In addition, when sewing the material which is easily damaged, replace presser holding plate ① with presser holding plate supplied as accessories ⑤ (Part No. : 40040681 or 40040682), and confirm that there is a clearance of not less than 2.5 mm between presser holding plate ⑤ and knife holder ③.



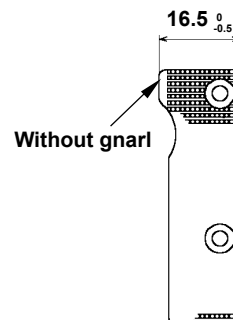
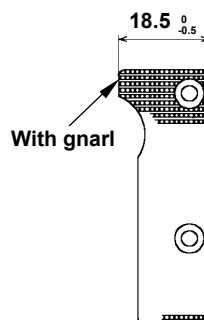
When adjustment is necessary, refer to "(9) Adjusting the cloth open of 4. STANDARD ADJUSTMENT of ENGINEER'S MANUAL.

In case of presser holding plate supplied as accessories ⑤  
(40040681, 40040682)



(Standard)  
Right) 32027005  
Left) 32027104

(Accessories)  
Right) 40040681  
Left) 40040682



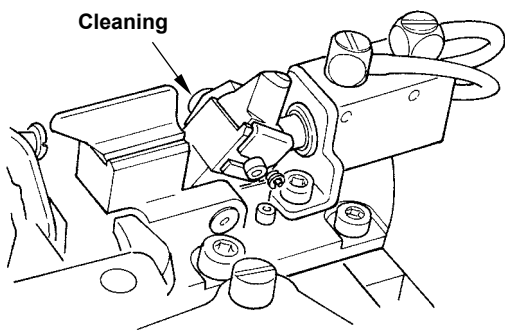
## 9. CLEANING OF THE MULTICUTTING DEVICE



### WARNING :

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

Cleaning



Remove cloth chip or waste thread before it is caught between the knife section on eyelet side and that on straight stitch side since malfunction or knife breakage may occur.

Perform periodical cleaning more than once a day as the standard. (Standard of cleaning depends on the frequency of use or kinds of sewing products.)



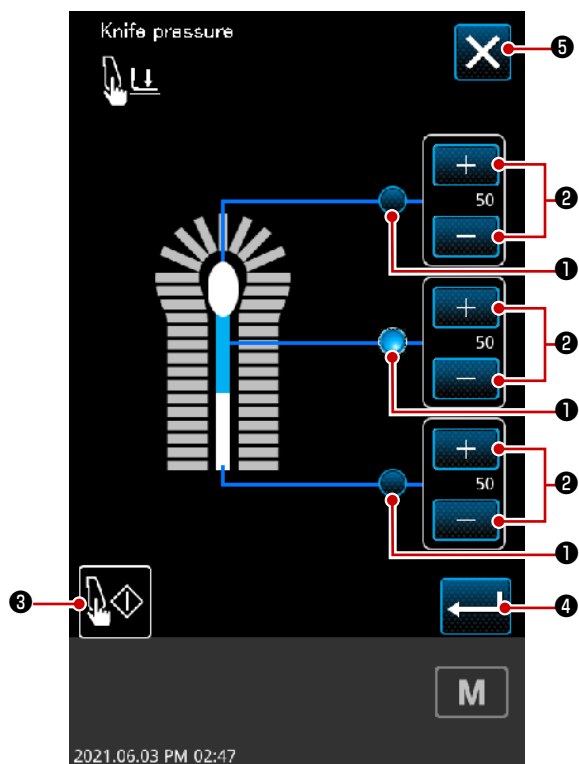
When cloth chip or waste thread is caught between the knife section on eyelet side and that on straight stitch side, the eyelet knife fails to return to the normal position and cloth cutting failure, slip of position or knife breakage due to one-side contact will be caused.



## 10. ADJUSTING THE CLOTH CUTTING KNIFE PRESSURE

- The knife pressure of the knife can be changed.
- When you have replaced the cloth cutting knife or the knife holder or have changed the sewing material, the knife pressure has to be checked.
- Change the set value after thoroughly checking the knife holder surface and the knife.
- It is recommended to gradually increase the set value from a small value.

### (1) Adjusting the knife pressure



- 1) Set a value of the multiple times selection (S091).
- 2) Press to confirm the set value. Then, press .
- 3) Press ① to select the position you want to set the knife pressure.
- 4) Press ② to change the knife pressure.  
The setting range is from 0 (zero) to 225.  
The larger the number, the higher the knife pressure.
- 5) Press ④ to save the setting.
- 6) Press ③ to operate the knife with the knife pressure you have set.  
Press ⑤ to cancel the setting and terminate editing.

**\*Press the start switch to operate the knife only for the first time.**

Set the knife pressure as small as possible.



If the knife pressure is excessively increased, a malfunction of the drive motor, breakage of the knife, etc. may be caused.

## 11. SETTING THE PATTERN DATA

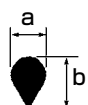
### (1) Setting the knife number (S011)

No.



Set the knife number (S011) in accordance with the size of the eyelet shape.

- \* Select "0" for sewing lockstitch buttonholes.
- Select "7" for sewing radial stitch eyelets.

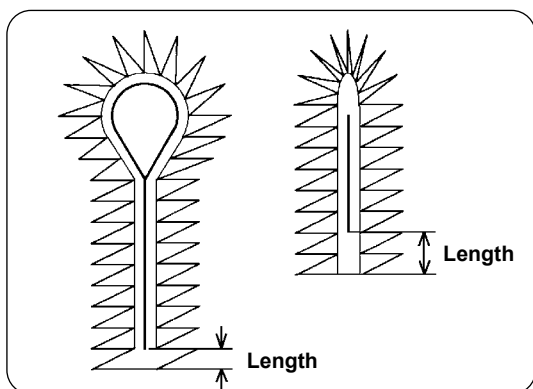


S011		a × b
0	Lockstitch buttonholes	-
1	Eyelet	2.1×3.2 (Option)
2	Eyelet	2.5×3.8
3	Eyelet	2.9×4.4 (Standard)
4	Eyelet	3.0×4.6
5	Eyelet	3.2×5.4
6	Eyelet	2.7×5.1 (Option)
7	Radial stitch eyelet	-

### (2) Cut length compensation (S090)



- 1) Cut length in terms of the sewing length can be shortened.
- 2) The cut length can be set in increments of 0.1 mm from 0 to 5 mm.



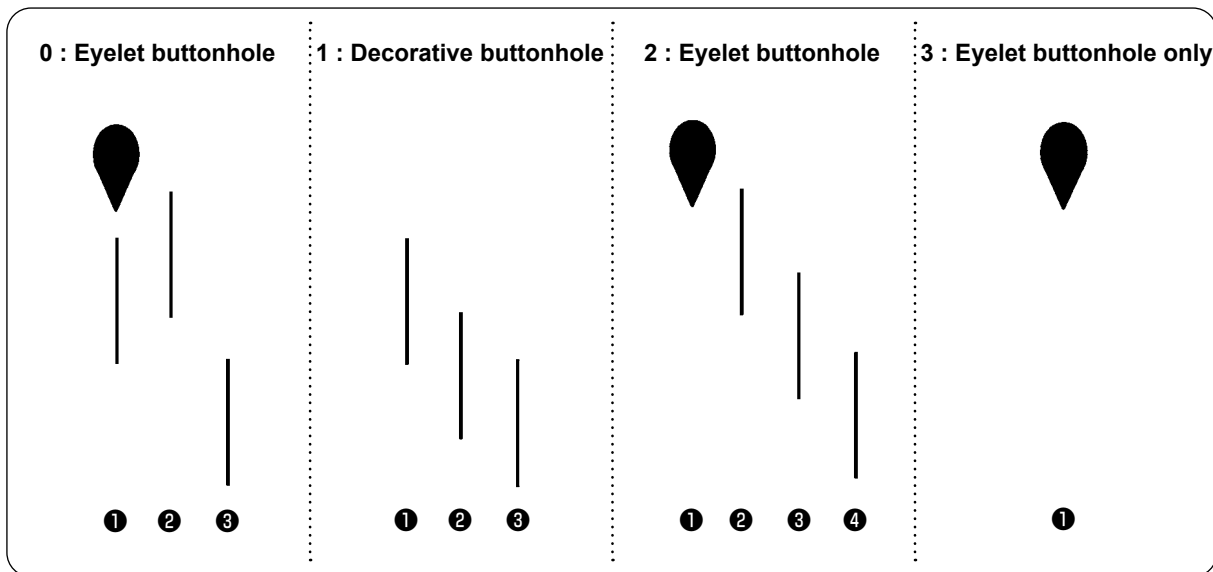
### (3) Multiple times selection (S091)



- 1) Set the operation pattern of the cloth cutting knife.
- 2) Use one of the following in accordance with the knife holder shape.

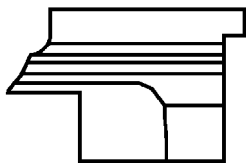
	S091
Without step	0, 1
With step	1, 2, 3

In the case of using the knife holder with step, the knife may operate more times than the case of using the knife holder without step at the time of the same cutting length.

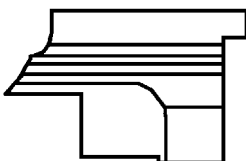


#### Shape of the knife holder

**Without step**  
(32087603, 32087702, 32087801)

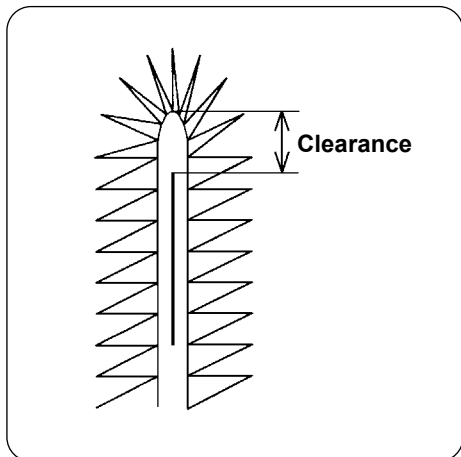


**With step**  
(32087900, 32088007, 32088106)



In case of using the knife holder with step, be careful of the thickness of material.  
(In case of thick material, not only the eyelet buttonhole but also the straight portion may be cut.)

#### (4) Lockstitch buttonhole offset (S092)



- 1) Clearance from the top of the stitches of decorative buttonhole to the cutting position can be set.
- 2) The cut length can be set in increments of 0.1 mm from 0 to 5 mm.

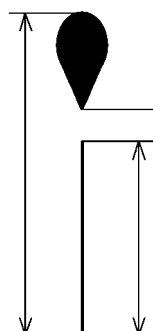


- Enabled only when the S091 is set to "1".
- If the S091 is set differently, the lockstitch buttonhole offset (S092) is disabled.

## 12. MEMORY SWITCH

Sections to which the memory switches K051 to K068 correspond

Knife length 1st time  
(Knife holder length)  
[K051, K054, K057, K060,  
K063, K066]



Remainder cutting amount  
[K053, K056, K059, K062,  
K065, K068]

Knife length 2nd time  
[K052, K055, K058,  
K061, K064, K067]

- 1) The "remainder cut amount" setting point (K053, K056, K059, K062, K065, K068) differs with the knife number (S011).

Change the setting in accordance with the knife to be installed.

The "remainder cut amount" setting point corresponding to the knife number (S011)

Knife number (S011)	Corresponding memory switch	Initial value (mm)
1	K053	6
2	K056	5
3	K059	5
4	K062	5
5	K065	4
6	K068	4

- \* If you have changed the cloth cutting knife (eyelet), change the setting of the "remainder cut amount" as described below.

Part number of the cloth cutting knife	Size		Remainder cut amount (mm)
	X	Y	
32087207	2.9	4.4	5
32087306	2.7	5.1	4
40251323	2.1	3.2	6

- 2) Setting point of the "Knife length 1st time" (K051, K054, K057, K060, K063, K066) and of the "Knife length 2nd time" (K052, K055, K058, K061, K064, K067) differs with the knife number (S011).

Change the setting in accordance with the knife to be installed.

"Knife length 1st time" setting point for the knife number (S011)

Knife number (S011)	Corresponding memory switch	Initial value (mm)
1	K051	18
2	K054	18
3	K057	18
4	K060	18
5	K063	18
6	K066	18

"Knife length 2nd time" setting point for the knife number (S011)

Knife number (S011)	Corresponding memory switch	Initial value (mm)
1	K052	8
2	K055	8
3	K058	8
4	K061	8
5	K064	8
6	K067	8

- \* The initial value is the set value used when installing the knife holder length of which is 18 mm (part No. 32087801).
- \* Change the set value if the knife holder length is shortened.

Example) In the case the knife holder length is cut by 1 mm from 18 mm to 17 mm

Knife length 1st time: 17 mm

Knife length 2nd time: 17 mm



**After cutting, remainders of cutting occur at the eyelet section and straight stitch section. Do not reduce the length of the "Knife length 2nd time" by 2 mm or more from the "Remainder cut length".**

- \* If you have replaced the knife holder, change the set value of the "Knife length, 1st time" (K051, K054, K057, K060, K063, K066) and that of the "Knife length, 2nd time" (K052, K055, K058, K061, K064, K067).

Part number of the knife holder	Knife length, 1st time set value (mm)	Knife length, 2nd time set value (mm)
32087801	18	8
32088106		
32087702		
32088007	26	16
32087603		
32087900	32	22

Example) When using the knife holder of 32087702 with the knife No. 6:

- \* Set value: K066 = 26, K067 = 16

## ■ MEMORY SWITCH

No.	Function	Description of setting	Initial value	Setting range	Unit
K51	Multicutting knife 1, knife length 1st time	Knife number (S011) = 1st time knife length of 1	18	10 to 38	mm
K52	Multicutting knife 1, knife length 2nd time	Knife number (S011) = 2nd time knife length of 1	8	5 to 38	mm
K53	Multicutting knife 1, remainder cut amount	Knife number (S011) = Dimension between the eyelet and parallel sections of 1	6	0 to 20	mm
K54	Multicutting knife 2, knife length 2nd time	Knife number (S011) = 1st time knife length of 2	18	10 to 38	mm
K55	Multicutting knife 2, knife length 2nd time	Knife number (S011) = 2nd time knife length of 2	8	5 to 38	mm
K56	Multicutting knife 2, remainder cut amount	Knife number (S011) = Dimension between the eyelet and parallel sections of 2	5	0 to 20	mm
K57	Multicutting knife 3, knife length 1st time	Knife number (S011) = 1st time knife length of 3	18	10 to 38	mm
K58	Multicutting knife 3, knife length 2nd time	Knife number (S011) = 2nd time knife length of 3	8	5 to 38	mm
K59	Multicutting knife 3, remainder cut amount	Knife number (S011) = Dimension between the eyelet and parallel sections of 3	5	0 to 20	mm
K60	Multicutting knife 4, knife length 1st time	Knife number (S011) = 1st time knife length of 4	18	10 to 38	mm
K61	Multicutting knife 4, knife length 2nd time	Knife number (S011) = 2nd time knife length of 4	8	5 to 38	mm
K62	Multicutting knife 4, remainder cut amount	Knife number (S011) = Dimension between the eyelet and parallel sections of 4	5	0 to 20	mm
K63	Multicutting knife 5, knife length 1st time	Knife number (S011) = 1st time knife length of 5	18	10 to 38	mm
K64	Multicutting knife 5, knife length 2nd time	Knife number (S011) = 2nd time knife length of 5	8	5 to 38	mm
K65	Multicutting knife 5, remainder cut amount	Knife number (S011) = Dimension between the eyelet and parallel sections of 5	4	0 to 20	mm
K66	Multicutting knife 6, knife length 1st time	Knife number (S011) = 1st time knife length of 6	18	10 to 38	mm
K67	Multicutting knife 6, knife length 2nd time	Knife number (S011) = 2nd time knife length of 6	8	5 to 38	mm
K68	Multicutting knife 6, remainder cut amount	Knife number (S011) = Dimension between the eyelet and parallel sections of 6	4	0 to 20	mm