



Waistband Sewing Unit (Double Chainstitch)

JTR-KM3680N/WSU Series

INSTRUCTION MANUAL



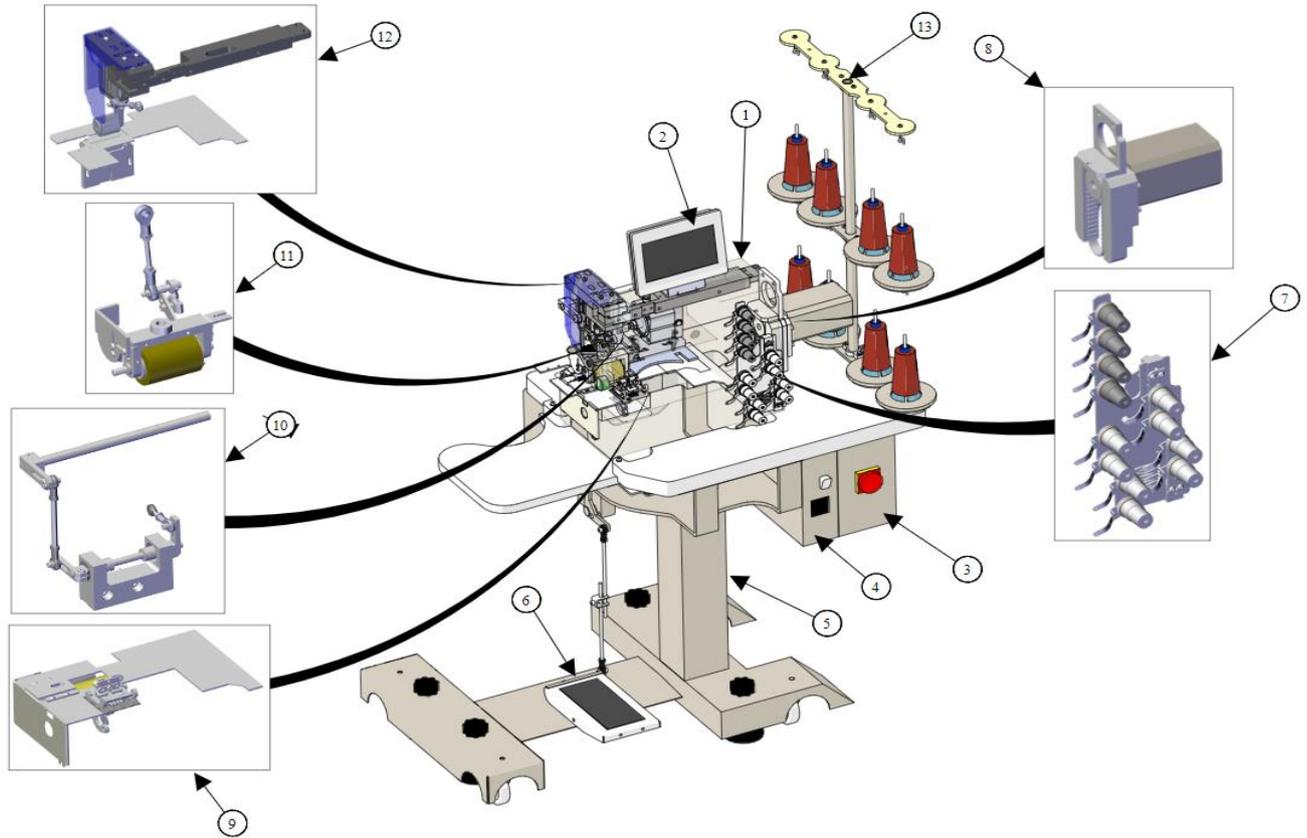
No.JTR001

KM3680NWSU-TM

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1) CONFIGURATION OF THE MACHINE



①	MACHINE HEAD	⑧	MOTOR GROUP
②	PANEL	⑨	SEWING AND FOOT GROUP
③	MAIN SWITCH	⑩	PULLER GROUP
④	CONTROL BOX	⑪	UPPER PULLER GROUP
⑤	CHASSIS	⑫	AIR BLOWING GROUP
⑥	PEDAL SET	⑬	THREAD STAND
⑦	THREAD TENSION GROUP		

2) SPECIFICATION

No.	Category	Description
1	MACHINE HEAD	K/S DLR-1509P
2	MODEL NAME	JTR-KM3680N-WSU
3	MAIN MOTOR	EFKA SERVO MOTOR DC 1550
4	MAIN MOTOR DRIVE	EFKA AB321A
5	MAXIMUM SEWING SPEED	3200sti/min DELIVERY SPEED : 2800sti/min
6	STITCH LENGTH	Min : 1,5mm Max: 3,5mm
7	NEEDLE TYPE	TV-5 #21
8	GAUGE	JTRON GAUGE(1/8"-1/8"- 1"-1/8"-1/8")
9	WAISTBAND CUTTER WITDH	MAX 55 MM
10	FABRIC CUTTNG SYSTEM	PLC CONTROLLED FABRIC CUTTING SYSTEM
11	SEWING SPECIFICATIONS	THIN TO MEDIUM THICKNESS
12	TARGET PROCESS	Waistband Attachment
13	AIR PRESSURE	MIN: 0.6 MPa MAX: 0.8 MPa Standard: 0.6 Mpa
14	AIR CONSUMPTION	16 L / min
15	VOLTAGE CLASSIFICATION	Single-phase 200-240V/50Hz
16	CAPACITY	2000 to 2.500 jeans / 9 hours
17	DAILY PIECE COUNTER	YES
18	POWER CONSUMPTION	650VA

3) INSTALLATION

3.1) The machine is delivered as below

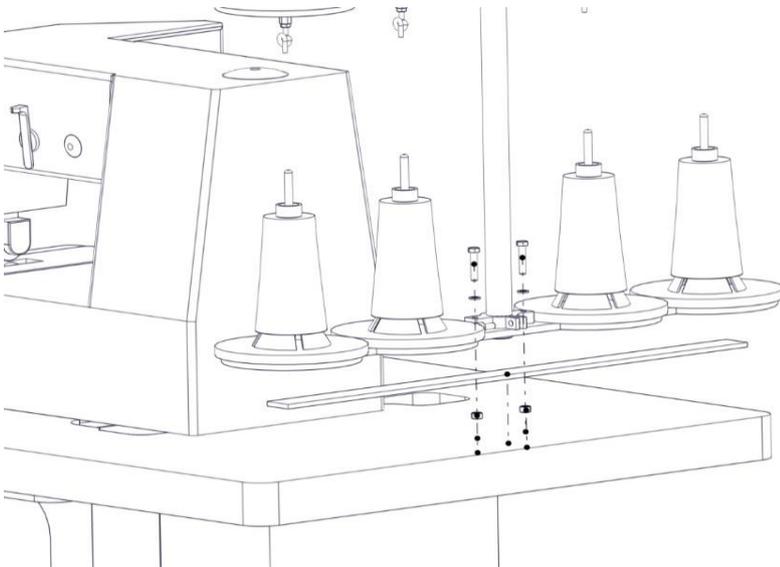


There are 10 pieces of screws to stabilize the machine to the wooden box.



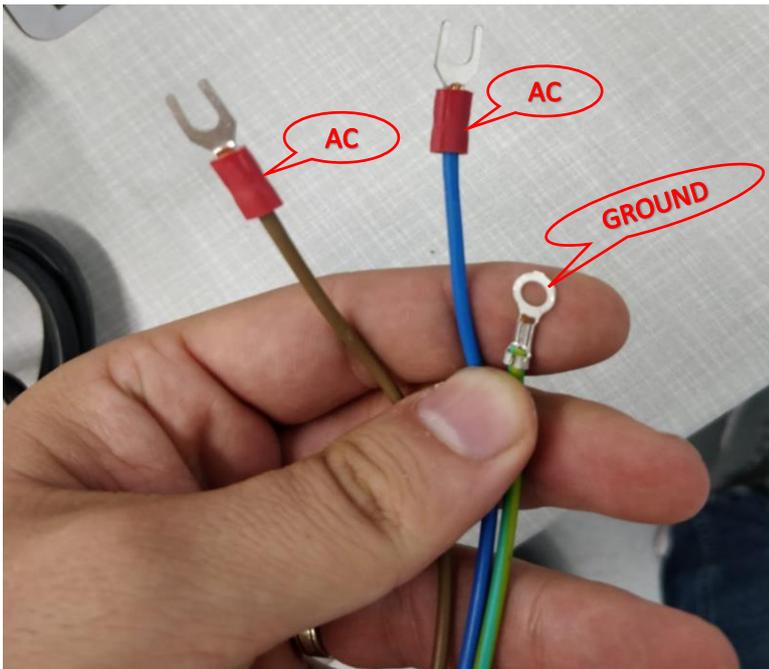
When the stated screws removed machine is ready to use such as in the photo.

3.2) Thread stand assembly



Insert thread stand and rubber into the table. Tighten lock nut so that the thread stand will not be able to move.

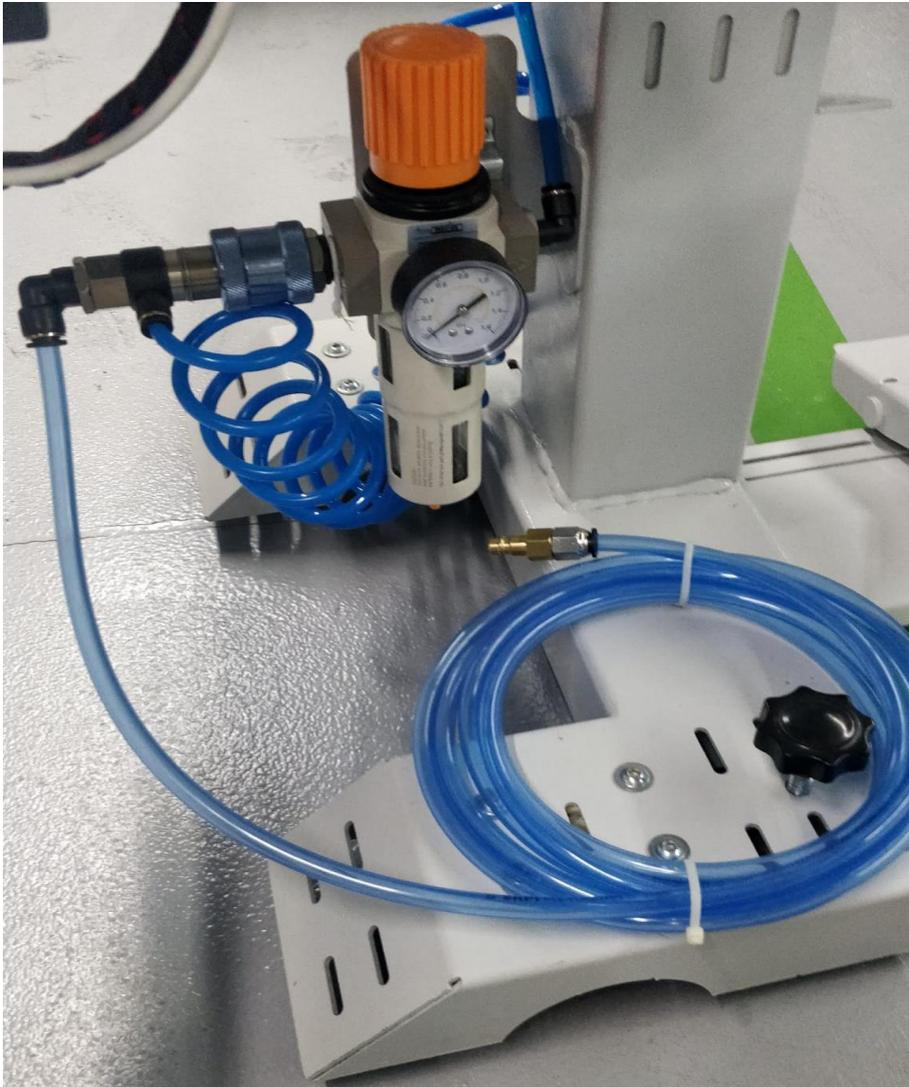
3.3) Connecting the power supply



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

3.4) The supply air to the machine

The air hose is shipped ready to use.

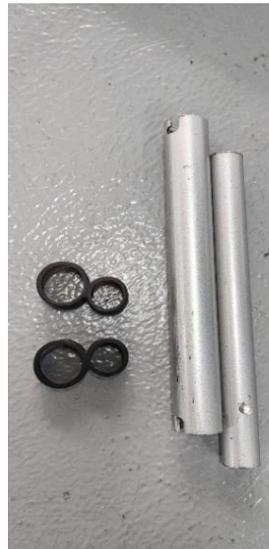


3.5) How to adjust the table height?

3.5.1) Remove the hexagon-head bolt (2 pieces).



3.5.2) Prepare the bottle jack arm.



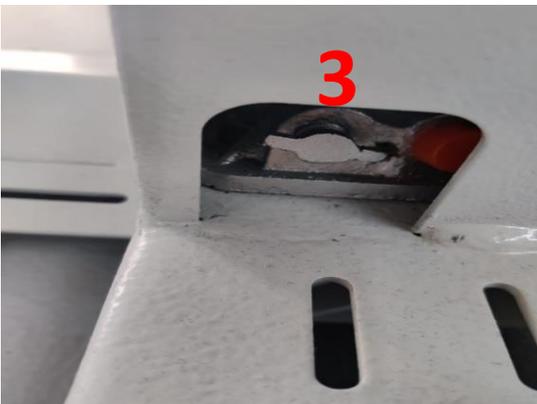
3.5.3) Remove handle bolt.



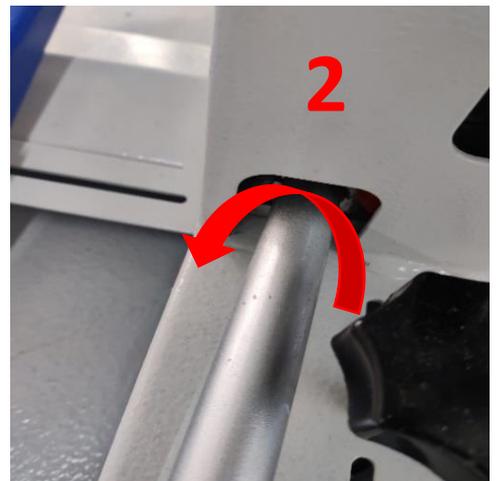
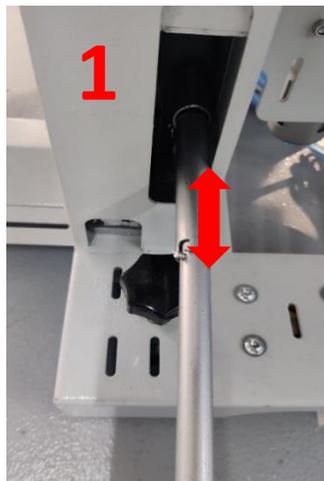
If the handle bolt does not turn, reduce the load by moving the arm up and down(1) or counterclockwise(2).

Loosening the hand bolt may cause the table to be lowered sharply.

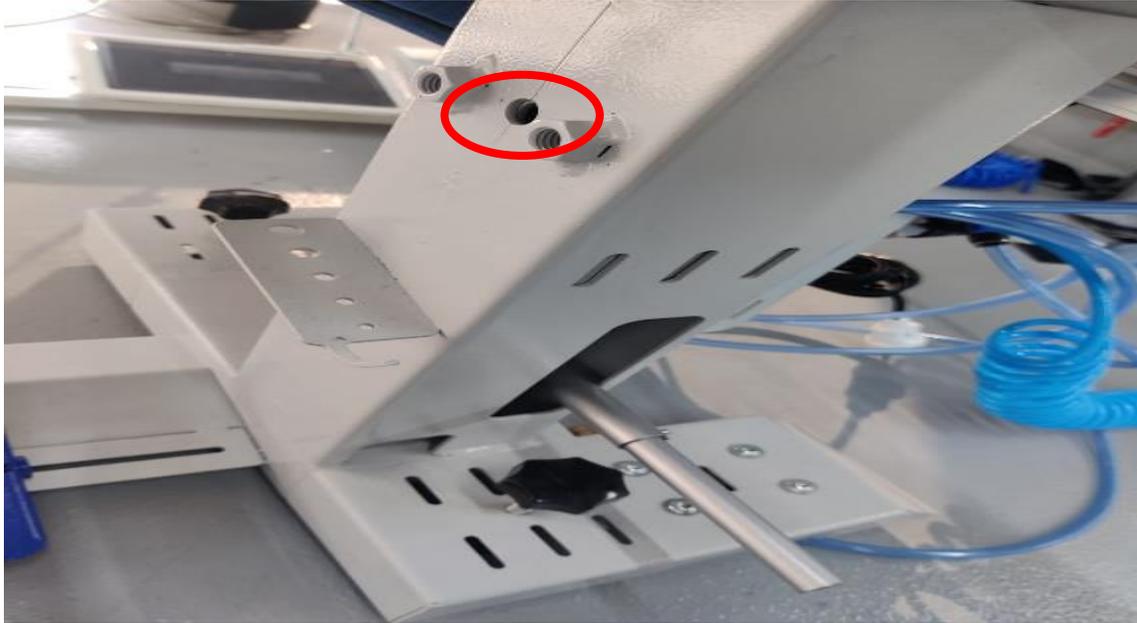
3.5.4) Put the arm into knob (3) and turn clockwise until they no longer turn. If the bolts are tight, it cannot be lifted.



3.5.5) Put the arm (1) into the joint (4) of bottle jack and swing the arm up and down to lift up the table. If the screw (2) is loosened slightly, the down speed is slow. If the screw is loosened a lot, the down speed is fast.

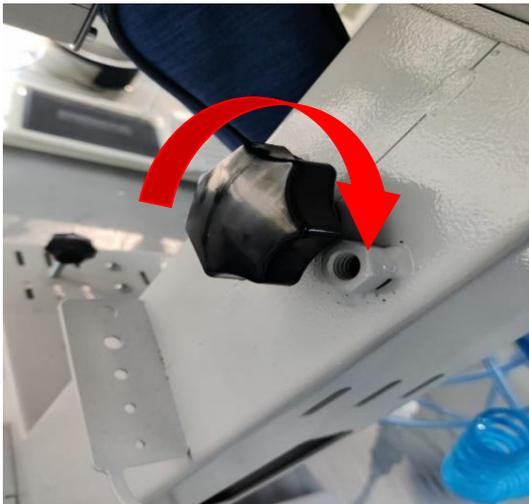


3.5.6) Adjust the table height



Adjust the table height by moving the arm up and down or counterclockwise. The table height can be changed at certain distances. Therefore, adjust according to the hole marked in red.

3.5.7) Install handle bolt.



3.5.8) Install the hexagon-head bolt (2 pieces).



4) PREPARATION FOR OPERATION

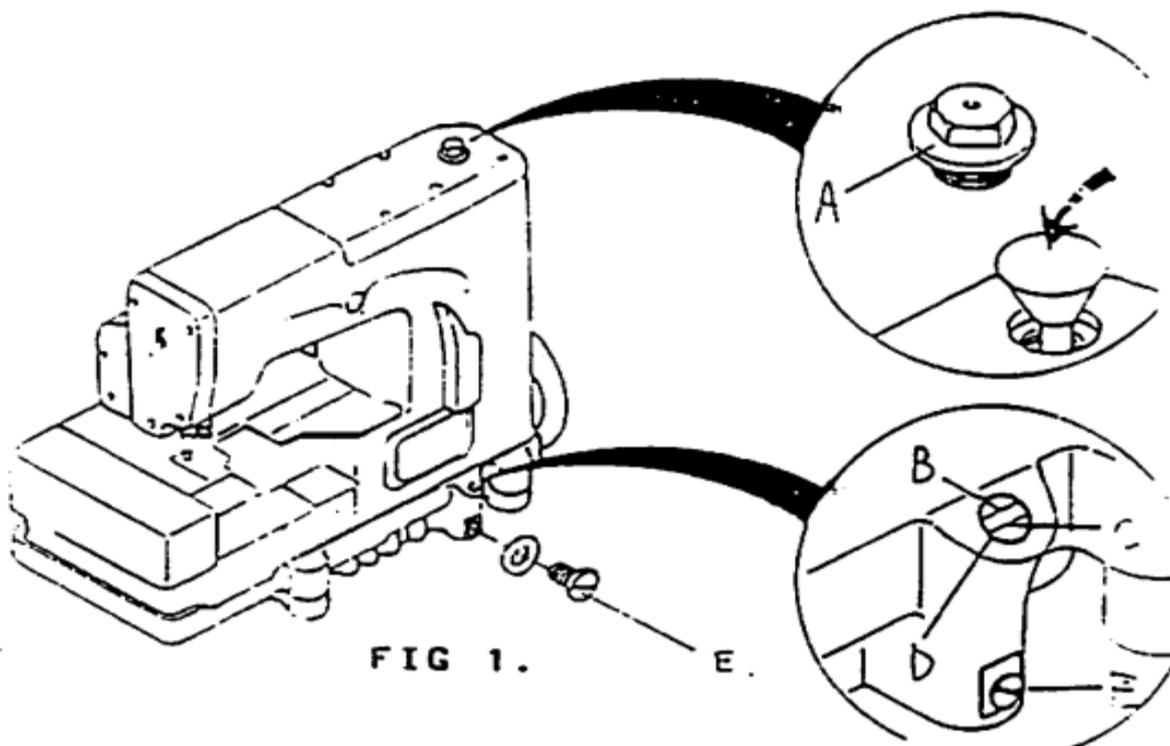
4.1) Please put the Kansai genuine oil from upper cover of the machine head. (Please refer to machine head instructions KS-DLR1509P)

a) Remove oil viewer A and supply oil until oil is being filled up to the line B of oil gauge C.

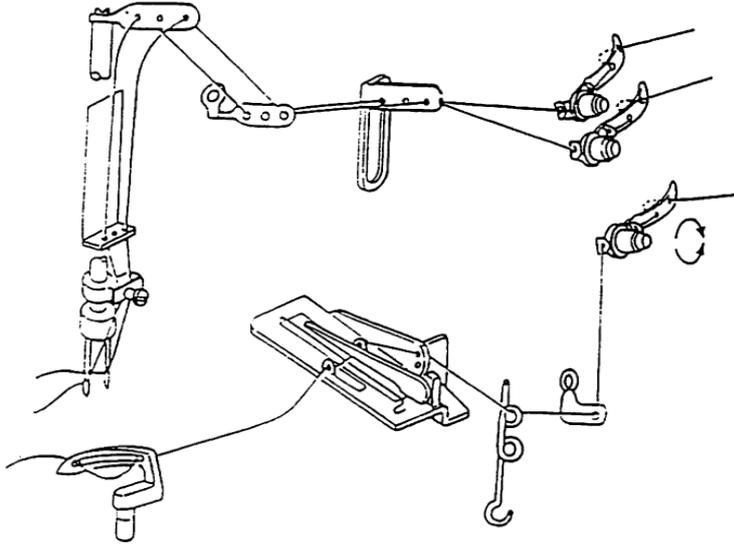
The oil level should be checked and kept between line B and D while machine is in use.

b) Draining oil can be done with removing screw E.

It is recommended that oil change one in first one month and once in every 6 months afterward.



4.2) Threading the machine. (Please refer to machine head instructions – KS-DLR1509P)



4.3) Switch on the machine.



4.4) How to install waistband to stand and feed the waistband attachment?

4.4.1) Put waistband to its stand as in the picture.



4.4.2) Feed the waistband to its attachment with the given steps.

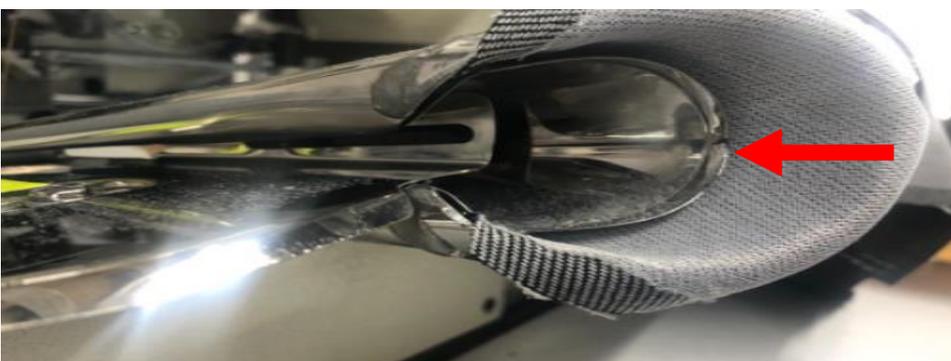
4.4.2.1) The edges of the waistband should be cut on front edges to insert the band to attachment easier.(see picture below)



4.4.2.2) After feeding the waistband to all the way of the attachments first canal, turn the waist band and insert the second canal.



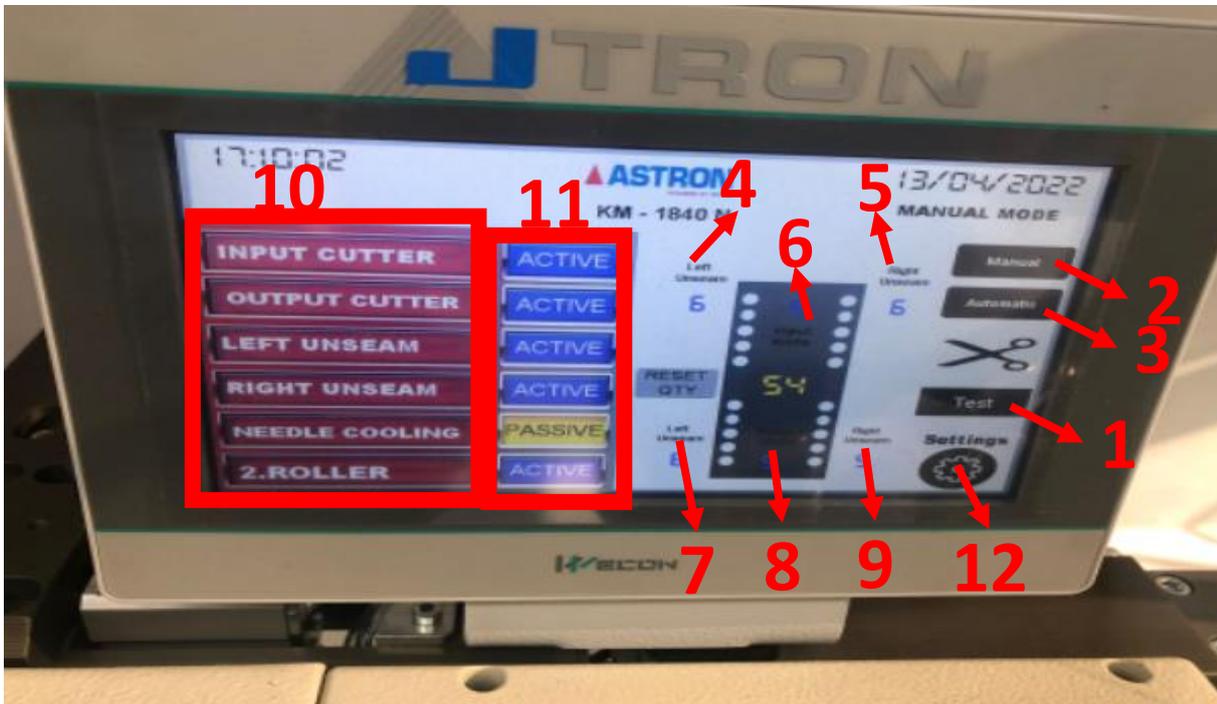
4.4.2.3) Once the waistband is inserted in to second canal, push it till the waist band faces with the presser foot.



4.4.2.3) When waist band reaches the presser foot it is ready sew when the pedal is pressed.

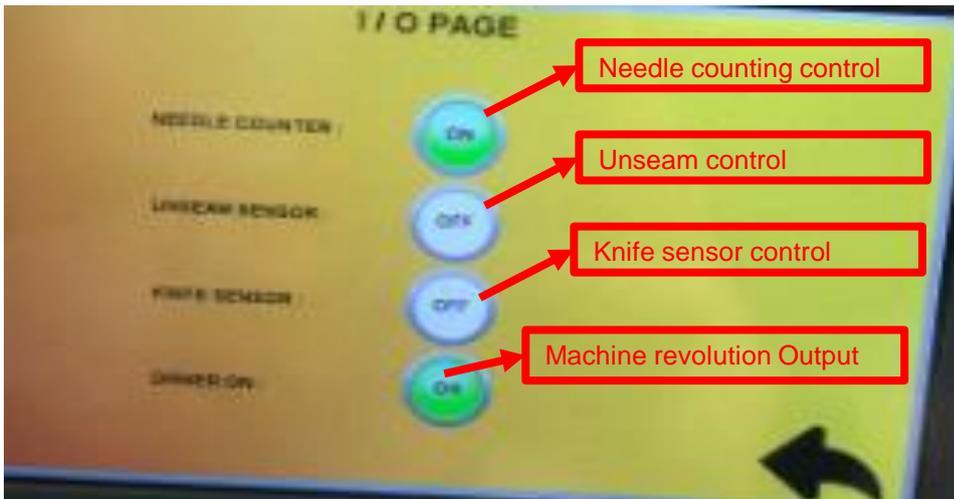
5) PANEL

5.1) Main Page

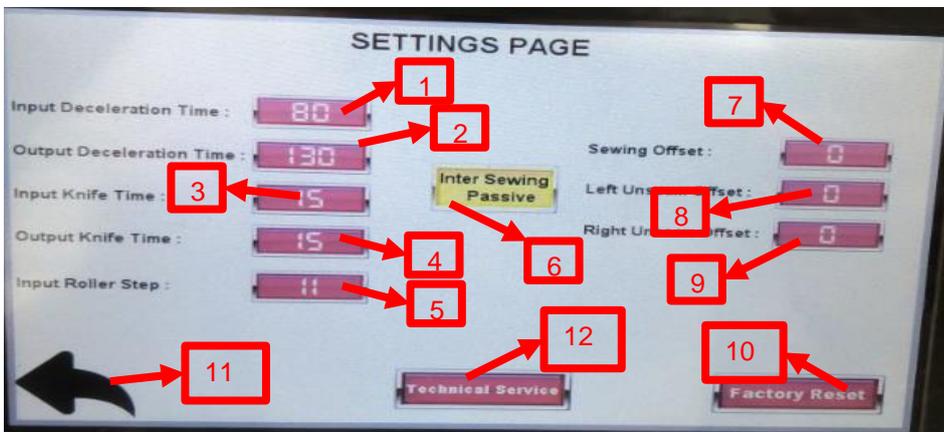


No.	Description
1	Test: I/O Check Page [Ref : 5.2]
2	Manual mode button
3	Automatic mode button
4	Needle count of left needle stitch skipping at the beginning
5	Needle count of right needle stitch skipping at the beginning
6	Cloth cutting at the beginning
7	Left stitch skipping at the end
8	Cloth cutting at the end
9	Right stitch skipping at the end
10	Test buttons Note! "Input cutter" and output cutter" is not usable in testing.
11	Activation buttons (Note! The Buttons are for activating or the deactivation of the features at the left hand sight.)
12	Settings page [Ref : 5.3]

5.2) I/O Check Page(Test page)



5.3) Settings Page



- 1) The setting of the low speed time at the beginning of the cutting of waistband (Pulse input)
- 2) The setting of the low speed time at the end of the cutting of waistband (Pulse input)
- 3) Knife movement time at the beginning (ms)
- 4) Knife movement time at the end (ms)
- 5) The stitch count until the air cylinder of the rear roller becomes active after front fabric sensor is activated.
- 6) Inter sewing option On/Off button
- 7) Start of the unseam process(beginning of the stitch skipping) stitch count
- 8) Left unseam step count
- 9) Right unseam step count
- 10) Resets the determined measure to origin point
- 11) Back button(brings user to main menu)
- 12) Technical service: Designer level settings. Password required.

6) ADJUSTMENT

6.1) Knife replacement

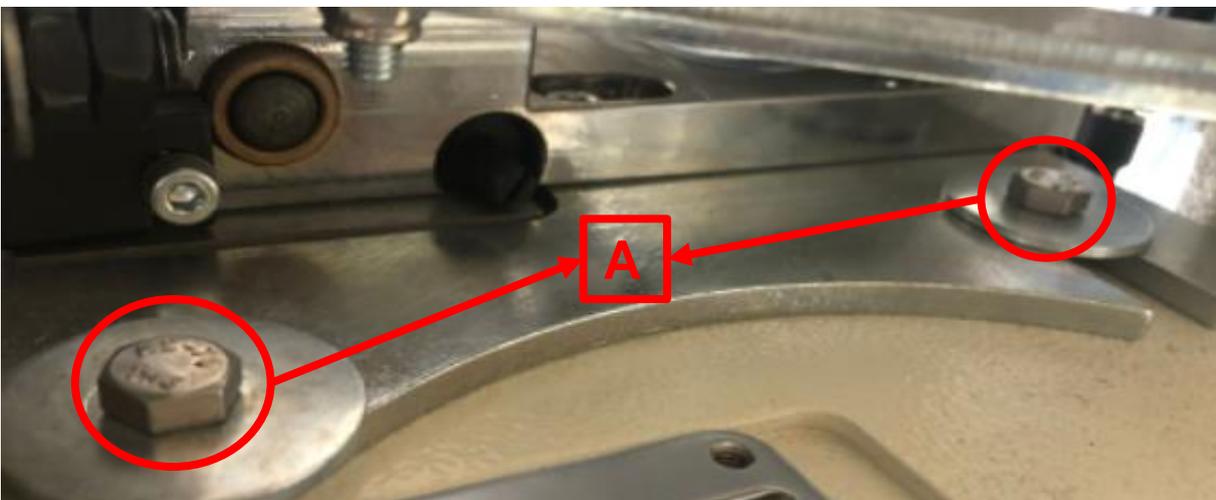
Note! Cut the air compressor of the machine at first!

6.1.1) Remove air tubes from air clinder



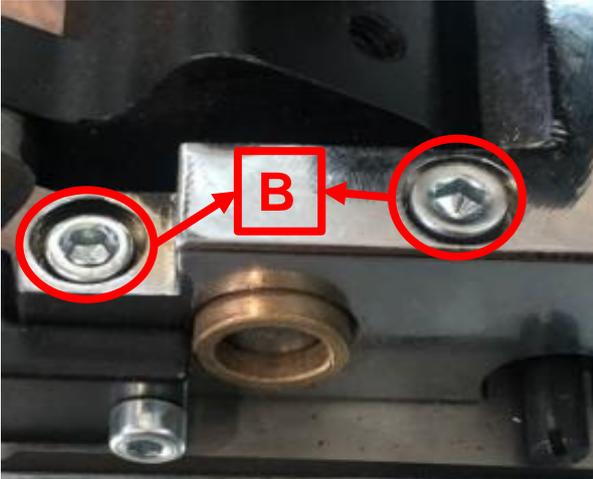
Unplug the tubes from the stated sockets.

6.1.2) Eject the knife unit from machine

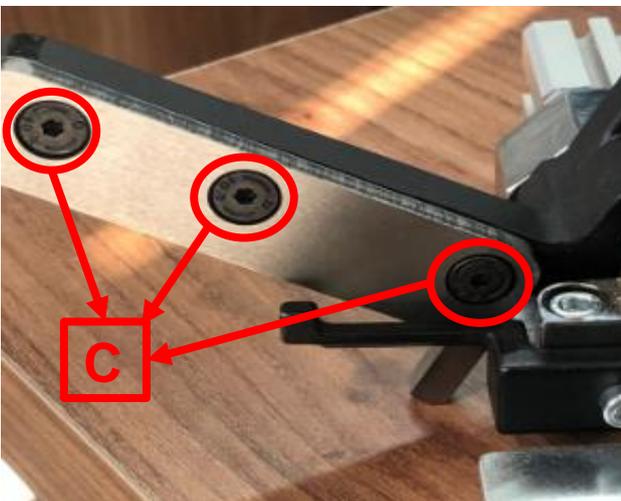


Loosen the "A" screws (2pieces) to eject the knife unit.

6.1.3) Detach the fixed knife from the “B” screws(2 pieces)



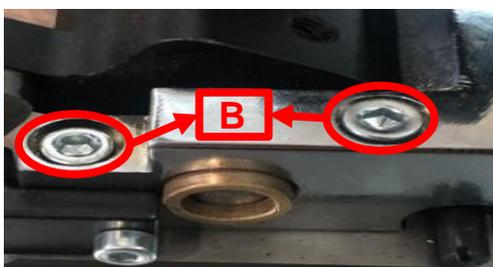
6.1.4) Detach the moving knife from the “C” screws(3 pices)



6.1.5) Adjust knife tightness

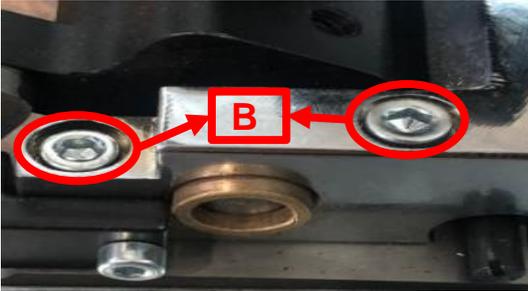


Make the adjustment the distance between the moving and the fixed knife with the stated screw



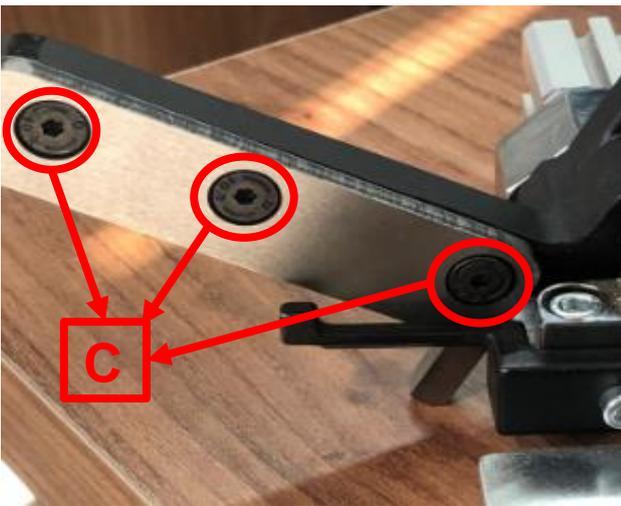
Note! It is necessary to loosen “B” screws to make this adjustment

6.1.6) Placing the new fixed knife

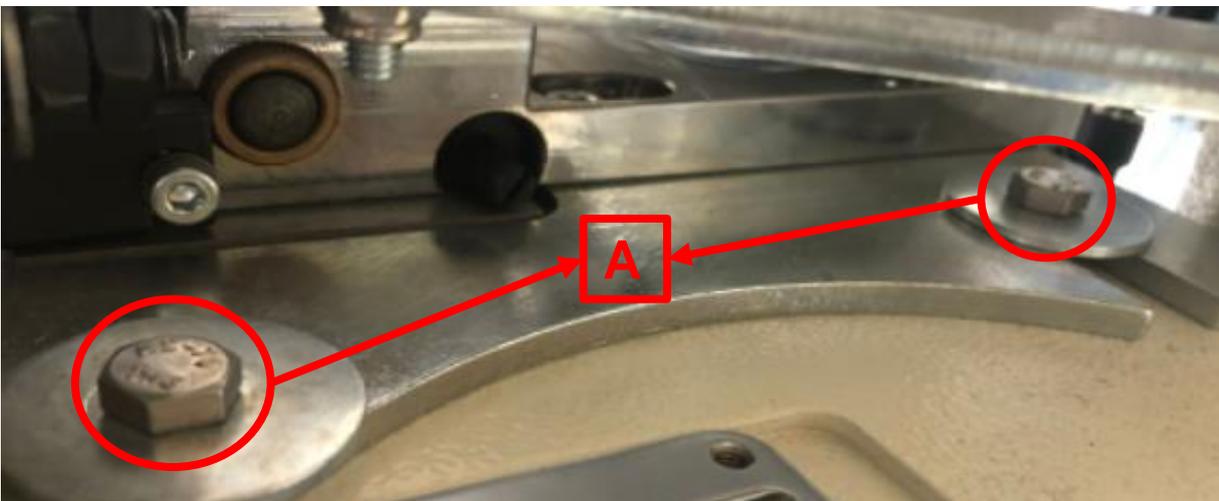


After placing the new fixed knife tighten the "B" screws(2 pieces)

6.1.7) Placing the moving knife



After placing the new fixed knife tighten the "C" screws(3 pieces)

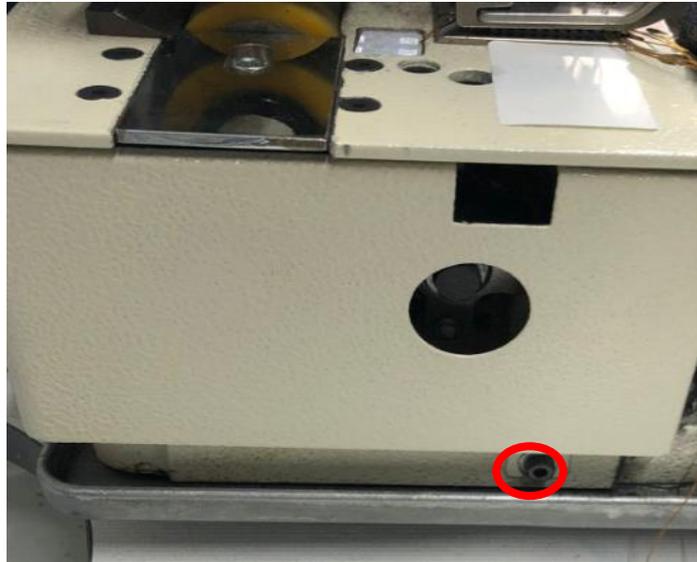


Tighten the "A" screws (2 pieces) to attach the unit in the correct position, the sharp edge of the fixed knife should be aligned parallel with the puller.

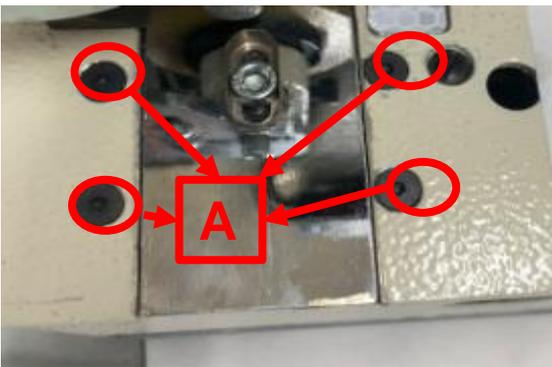
6.2) Roller replacement

6.2.1) Lower puller replacement

6.2.1.1) Detach the cover from the stated screws (2 pieces)



6.2.1.1) Remove assembly plate with the "A" screws (4 pieces)



6.2.1.1) Remove the plate by removing the imbus screw (1 piece)



6.2.1) Upper puller replacement

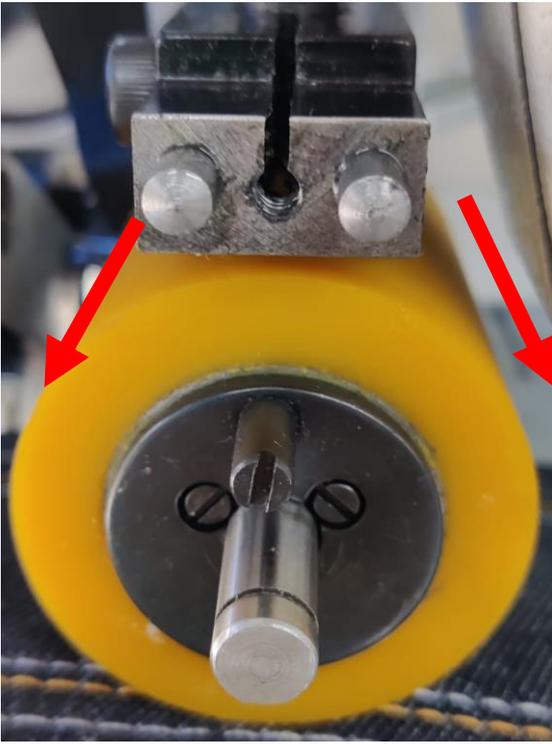
6.2.2.1) Loosen the imbus screw (2 pieces) and remove retaining ring(E-Type).



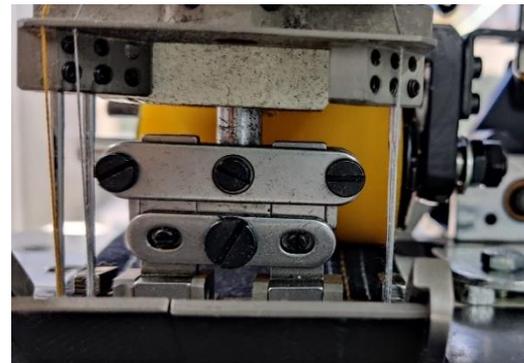
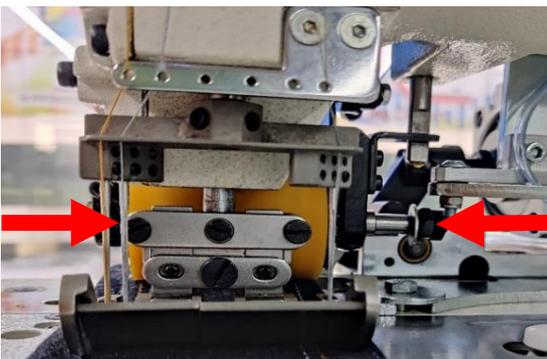
6.2.2.2) Remove the washer and detach the black plate from other plate.



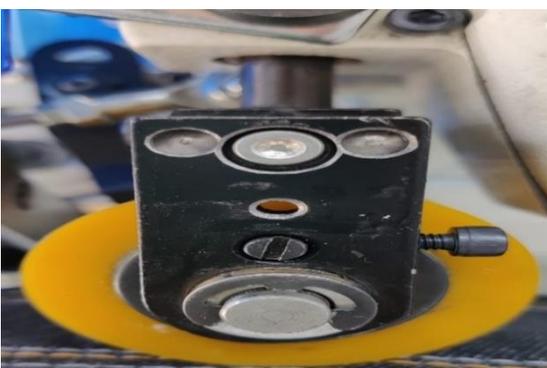
6.2.2.3) Remove upper puller roller



6.2.2.4) Install upper puller roller



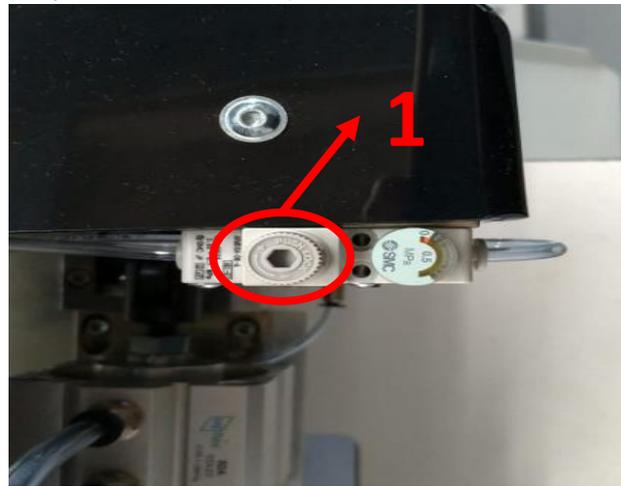
Then complete the assembly(as in the picture) by reversing the previous steps.



6.3) Air tubes

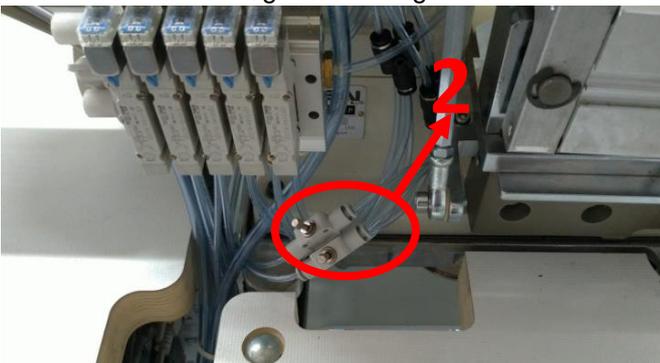
6.3.1) Rear roller presser adjustment is done via speed controller "1".

Note: Adjustment should be done when air cylinder is at down position.

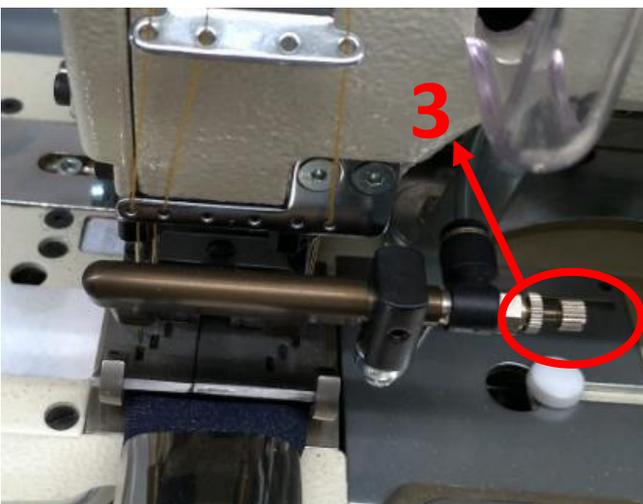


6.3.2) Unseam air amount is adjusted via speed controller "2".

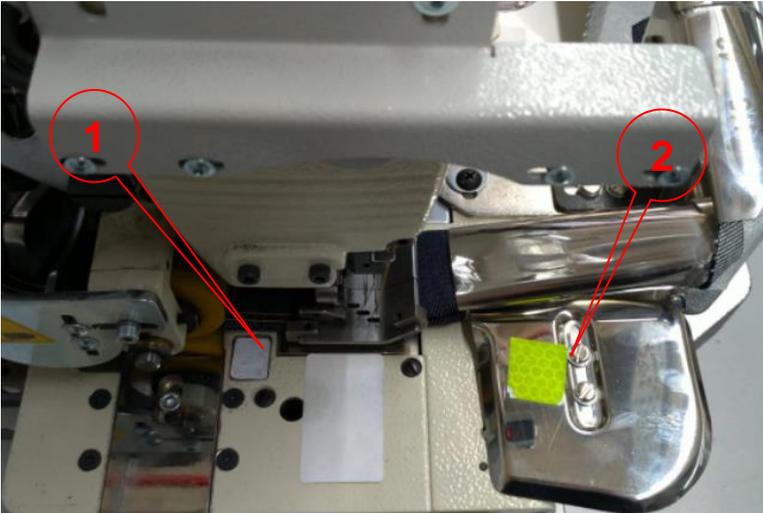
The adjustment should be adjusted as strong as it provides unseam and but at the same time the adjustment should be weak enough not to tangle the thread to needle.



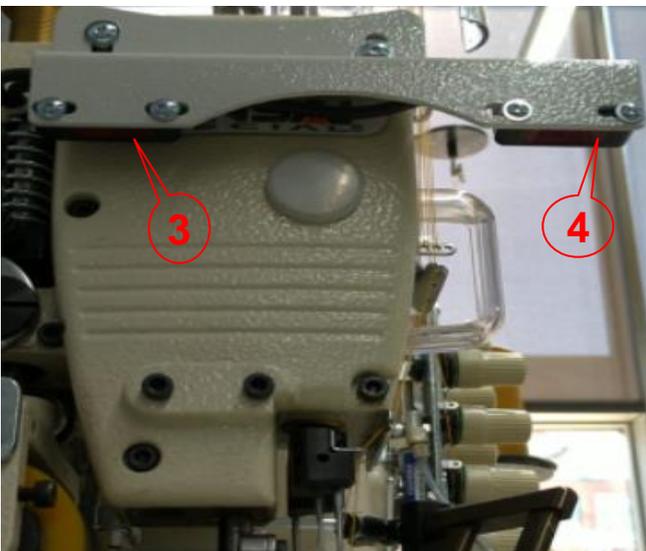
6.3.3) Needle cooler air amount is adjusted via speed controller "3".



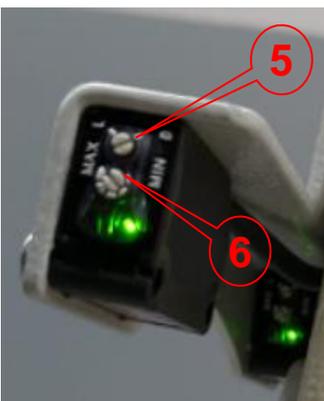
6.4) Sensor adjustment



Reflectors(1-2) should be new and should be reflecting back to the sensors

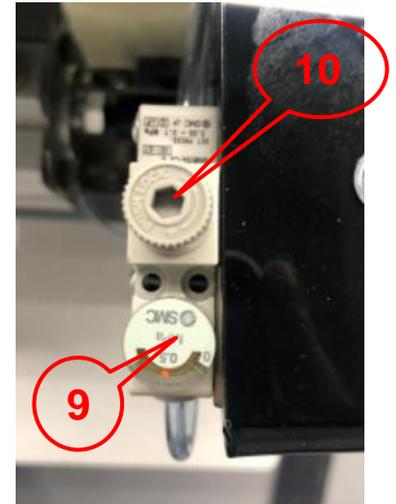
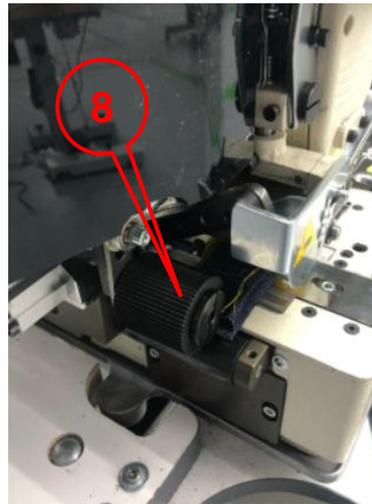
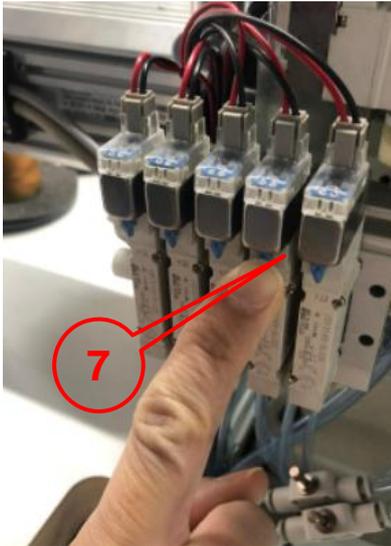


Sensor positions(3-4) should be aligned the way they could see the reflectors.



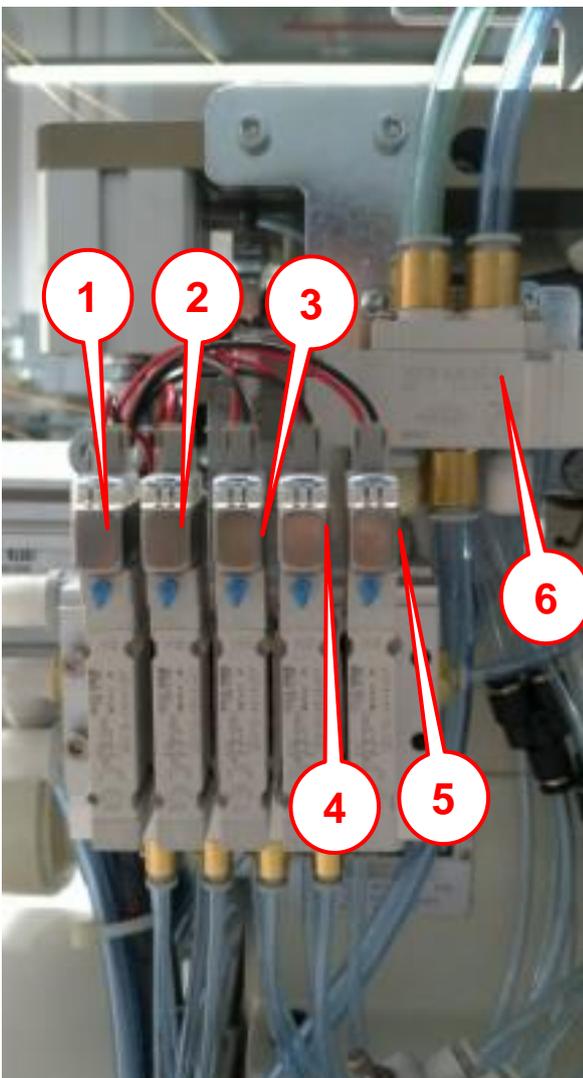
The machine should be operated on dark mode(5) And the sensitivity(6) adjustment should be at the maximum margin.

Note! If there is not a fabric on the reflector only green light is on but if there is fabric on the reflector both green and red light will be on



The button(7) should be pressed to lower down the rear roller(8). When the rear roller is at the down position(8) The dial bar(9) should be adjusted 0.5 MPa via the knob(10)

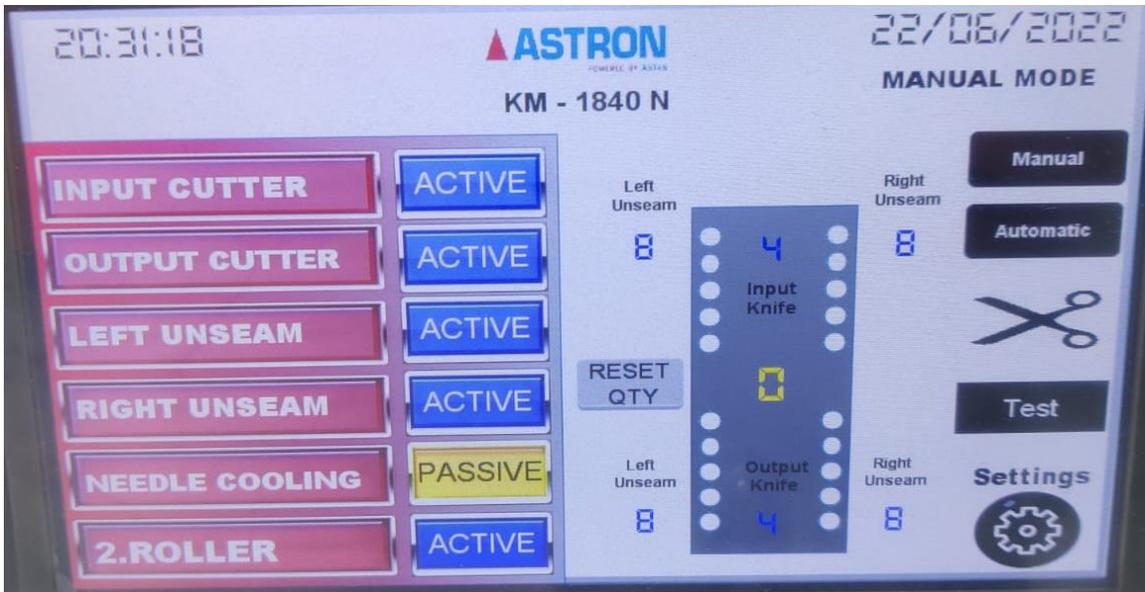
6.5) Air valves



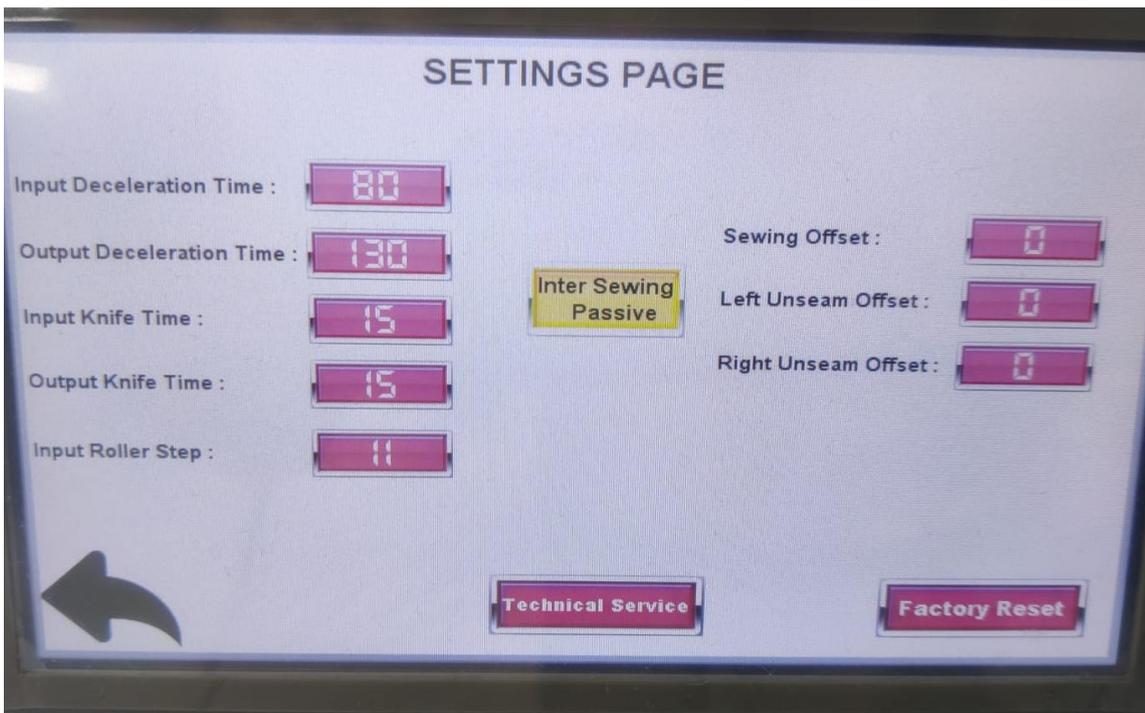
- | |
|-------------------------------------------------|
| 1)Tension release & left needles unseam feature |
| 2)Tension release & right needle unseam feature |
| 3)Foot & rear roller lifting |
| 4)Rear roller (black) lowering |
| 5)Needle cooler |
| 6)Scissors adjustment |

7) LIST OF PATTERN DATA(SHIPPING VALUES)

7.1) MAIN PAGE



7.1) SETTINGS PAGE



8) CAUSES AND COUNTERMEASURES

Q.1) Sensor does not detect the fabric.

A1) Check and change the reflectors.

Q.2) Rollers does not work properly after a year!

A2) Change the rollers. (refer 6.2 Roller replacement)



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