

High-speed, Flat-bed, 2-needle Double Chainstitch Machine

# MH-380

 (parallel 2-needle)

# MH-382

 (tandem 2-needle)

MH-380



MH-382



#### JUKI CORPORATION HEAD OFFICE

The environmental management system to promote and conduct

- ① the technological and technical research, the development and design of the products in which the environmental impact is considered,
- ② the conservation of the energy and resources, and the recycling, in the research, development, design, distribution, sale and maintenance service of the industrial sewing machines, household sewing machines and industrial-use robots, etc. and in the purchase, distribution and sale of the household commodities including the healthcare products.



MH-382

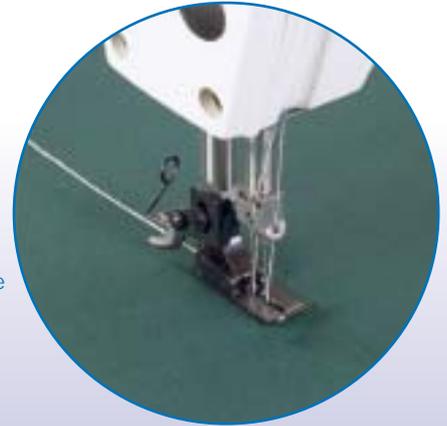
MH-380

# Various attachments allow the machine to adapt to many different processes.

Many different attachments have been developed for the machine. This means that the JUKI MH Series sewing machine can adapt to many kinds of processes and specifications including hemming, welting and decorative stitching. Accurate stitching performance and durable finished seams are particularly necessary in the chainstitching process. JUKI ensures high-quality sewing with a higher degree of consistency with its unique looper mechanism and consistent condensation stitching mechanism. Furthermore, highly efficient operation is achieved by using a chain-off thread cutting device.



**MH-380**  
(Parallel 2-needle, double chainstitching machine)  
\* Equipped with a lapping seam folder as standard



**MH-382**  
(Tandem 2-needle, double chainstitching machine)



Stitch dial

Lever for condensation stitching

MH-380

## The machine ensures outstanding reliability and durability.

It comes with JUKI's unique inclined crank type looper mechanism. This gives the machine outstanding durability. You can use the sewing machine for a long time without ever worrying about looper failure.

## Stitch length can be adjusted with ease.

The machine incorporates a stitch dial for adjusting the stitch length. For lockstitch machines, which are the most popular type of sewing machines, the stitch length is also adjusted using a stitch dial. This means you can adjust the stitch length as desired without difficulty.

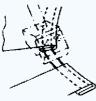
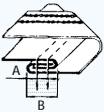
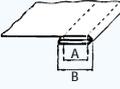
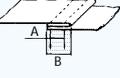
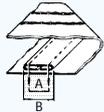
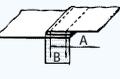
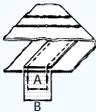
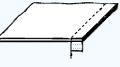
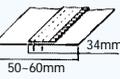
## The machine is capable of performing consistent condensation stitching, ensuring finished seams of higher quality.

You can easily set the machine to perform condensation stitching by operating the lever. Condensation stitches that prevent the thread from fraying can be consistently sewn.

## Many different kinds of attachments contribute to enhanced production efficiency.

Attachments (optional) have been prepared for many different applications, including sewing sides of jeans, slacks and skirts, hemming pockets, making decorative stitches on tape for sportswear. Furthermore, a chain-off thread cutter (AT-8, optional) that helps enhance production efficiency is also available.

## DEVICES AND ATTACHMENTS

<p>●Chain-off thread cutter</p> <p><b>AT-8</b></p> 	<p><b>Applicable machines:</b> MH-380, MH-382  <b>Class of work:</b> Jeans, Working wear  <b>Applications:</b> Cut a chaining thread bridging two workpieces continuously sewn by chainstitch in the way that a knife blade of the cutter is dropped. Best suited for continuous sewing on pocket openings of jeans or working wear.</p> <table border="1" data-bbox="287 291 782 470"> <thead> <tr> <th>Guide width mm (in)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>Tandem 2-needle</td> <td>GAT-080000AC</td> </tr> <tr> <td>4.0 (5/32)</td> <td>GAT-08000CAC</td> </tr> <tr> <td>4.8 (3/16)</td> <td>GAT-08000DAC</td> </tr> <tr> <td>6.4 (1/4)</td> <td>GAT-08000FAC</td> </tr> <tr> <td>7.9 (5/16)</td> <td>GAT-08000HAC</td> </tr> </tbody> </table>	Guide width mm (in)	Part No.	Tandem 2-needle	GAT-080000AC	4.0 (5/32)	GAT-08000CAC	4.8 (3/16)	GAT-08000DAC	6.4 (1/4)	GAT-08000FAC	7.9 (5/16)	GAT-08000HAC	<p>●Lap seam folder (Reverse)</p> <p><b>M052</b></p>  <p>A: Needle gauge B: Finished width</p>	<p><b>Applicable machines:</b> MH-380  <b>Class of work:</b> Jeans, Working pants, Pants, Overalls  <b>Applications:</b> Sew side seams  <b>Materials:</b> Medium heavy-weight materials and heavy-weight materials such as denim, drill, etc.</p> <table border="1" data-bbox="957 291 1452 515"> <thead> <tr> <th>Finished width (mm)</th> <th>Needle gauge mm (in)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>17</td> <td>12.7 (1/2)</td> <td>MAM-0520S0AO</td> </tr> <tr> <td>14</td> <td>9.5 (3/8)</td> <td>MAM-0520P0AO</td> </tr> <tr> <td>12</td> <td>7.9 (5/16)</td> <td>MAM-0520M0AO</td> </tr> <tr> <td>10</td> <td>6.4 (1/4)</td> <td>MAM-0520K0AO</td> </tr> <tr> <td>10</td> <td>5.6 (7/32)</td> <td>MAM-0520K0AO</td> </tr> <tr> <td>9</td> <td>4.8 (3/16)</td> <td>MAM-0520J0AO</td> </tr> </tbody> </table>	Finished width (mm)	Needle gauge mm (in)	Part No.	17	12.7 (1/2)	MAM-0520S0AO	14	9.5 (3/8)	MAM-0520P0AO	12	7.9 (5/16)	MAM-0520M0AO	10	6.4 (1/4)	MAM-0520K0AO	10	5.6 (7/32)	MAM-0520K0AO	9	4.8 (3/16)	MAM-0520J0AO																			
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<p>●Down turn hemmer</p> <p><b>L050</b></p>  <p>A: Needle gauge B: Finished width</p>	<p><b>Applicable machines:</b> MH-380  <b>Class of work:</b> Jeans, Working pants  <b>Applications:</b> Hem jeans hip pocket mouth, especially suit for sections where high quality straight stitch is required.</p> <table border="1" data-bbox="287 604 782 750"> <thead> <tr> <th>Finished width (mm)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>14</td> <td>MAL-0500P0AO</td> </tr> <tr> <td>12</td> <td>MAL-0500M0AO</td> </tr> <tr> <td>11</td> <td>MAL-0500L0AO</td> </tr> <tr> <td>10</td> <td>MAL-0500K0AO</td> </tr> </tbody> </table>	Finished width (mm)	Part No.	14	MAL-0500P0AO	12	MAL-0500M0AO	11	MAL-0500L0AO	10	MAL-0500K0AO	<p>●Left feed top stitch folder</p> <p><b>M054</b></p>  <p>A: Needle gauge B: Finished width</p>	<p><b>Applicable machines:</b> MH-380  <b>Class of work:</b> Jeans, Working pants, Jackets, Skirts  <b>Applications:</b> Sew side seams. Attach flat faces of garments.</p> <table border="1" data-bbox="957 649 1452 907"> <thead> <tr> <th>Finished width (mm)</th> <th>Needle gauge mm (in)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>17</td> <td>12.7 (1/2)</td> <td>MAM-0540S0AO</td> </tr> <tr> <td>14</td> <td>9.5 (3/8)</td> <td>MAM-0540P0AO</td> </tr> <tr> <td>12</td> <td>7.9 (5/16)</td> <td>MAM-0540M0AO</td> </tr> <tr> <td>10</td> <td>6.4 (1/4)</td> <td>MAM-0540K0AO</td> </tr> <tr> <td>10</td> <td>5.6 (7/32)</td> <td>MAM-0540K0AO</td> </tr> <tr> <td>9</td> <td>4.8 (3/16)</td> <td>MAM-0540J0AO</td> </tr> <tr> <td>8</td> <td>4.0 (5/32)</td> <td>MAM-0540H0AO</td> </tr> </tbody> </table>	Finished width (mm)	Needle gauge mm (in)	Part No.	17	12.7 (1/2)	MAM-0540S0AO	14	9.5 (3/8)	MAM-0540P0AO	12	7.9 (5/16)	MAM-0540M0AO	10	6.4 (1/4)	MAM-0540K0AO	10	5.6 (7/32)	MAM-0540K0AO	9	4.8 (3/16)	MAM-0540J0AO	8	4.0 (5/32)	MAM-0540H0AO																		
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<p>●Decorative tape attaching foot</p> <p><b>B050</b></p>  <p>A: Needle gauge B: Finished width</p>	<p><b>Applicable machines:</b> MH-380  <b>Class of work:</b> Sportswear, Training wear, Swimsuits, Uniforms, Boxer pants, Rompers  <b>Applications:</b> Stitch accent line attach tapes  <b>Materials:</b> Cotton bias tape, or plain woven tape for some limited process.</p> <table border="1" data-bbox="287 918 782 1153"> <thead> <tr> <th>Finished width (mm)</th> <th>Needle gauge mm (in)</th> <th>Tape width (mm)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>17</td> <td>12.7 (1/2)</td> <td>34</td> <td>MAB-0500SLAO</td> </tr> <tr> <td>15</td> <td>9.5 (3/8)</td> <td>30</td> <td>MAB-0500QKAO</td> </tr> <tr> <td>12</td> <td>7.9 (5/16)</td> <td>24</td> <td>MAB-0500MHAO</td> </tr> <tr> <td>10</td> <td>6.4 (1/4)</td> <td>20</td> <td>MAB-0500KFAO</td> </tr> <tr> <td>8</td> <td>4.8 (3/16)</td> <td>16</td> <td>MAB-0500HDAO</td> </tr> <tr> <td>6</td> <td>4.0 (5/32)</td> <td>14</td> <td>MAB-0500GCAO</td> </tr> </tbody> </table>	Finished width (mm)	Needle gauge mm (in)	Tape width (mm)	Part No.	17	12.7 (1/2)	34	MAB-0500SLAO	15	9.5 (3/8)	30	MAB-0500QKAO	12	7.9 (5/16)	24	MAB-0500MHAO	10	6.4 (1/4)	20	MAB-0500KFAO	8	4.8 (3/16)	16	MAB-0500HDAO	6	4.0 (5/32)	14	MAB-0500GCAO	<p>●Right feed top stitch folder</p> <p><b>M055</b></p>  <p>A: Needle gauge B: Finished width</p>	<p><b>Applicable machines:</b> MH-380  <b>Class of work:</b> Jeans, Working pants, Jackets, Skirts  <b>Applications:</b> Sew side seams. Attach flat faces of garments.</p> <table border="1" data-bbox="957 1075 1452 1332"> <thead> <tr> <th>Finished width (mm)</th> <th>Needle gauge mm (in)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>17</td> <td>12.7 (1/2)</td> <td>MAM-0550S0AO</td> </tr> <tr> <td>14</td> <td>9.5 (3/8)</td> <td>MAM-0550P0AO</td> </tr> <tr> <td>12</td> <td>7.9 (5/16)</td> <td>MAM-0550M0AO</td> </tr> <tr> <td>10</td> <td>6.4 (1/4)</td> <td>MAM-0550K0AO</td> </tr> <tr> <td>10</td> <td>5.6 (7/32)</td> <td>MAM-0550K0AO</td> </tr> <tr> <td>9</td> <td>4.8 (3/16)</td> <td>MAM-0550J0AO</td> </tr> <tr> <td>8</td> <td>4.0 (5/32)</td> <td>MAM-0550H0AO</td> </tr> </tbody> </table>	Finished width (mm)	Needle gauge mm (in)	Part No.	17	12.7 (1/2)	MAM-0550S0AO	14	9.5 (3/8)	MAM-0550P0AO	12	7.9 (5/16)	MAM-0550M0AO	10	6.4 (1/4)	MAM-0550K0AO	10	5.6 (7/32)	MAM-0550K0AO	9	4.8 (3/16)	MAM-0550J0AO	8	4.0 (5/32)	MAM-0550H0AO
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<p>●Decorative tape attaching foot</p> <p><b>B051</b></p>  <p>A: Needle gauge B: Finished width</p>	<p><b>Applicable machines:</b> MH-380  <b>Class of work:</b> Ladies' wear, Children' wear, Sportswear, Uniforms  <b>Applications:</b> Attach decorative tapes and reinforcement tapes  <b>Materials:</b> Tape: Synthetic suede cloth tape, decorative tape, plain woven tape. Contact us for special type of tapes.</p> <table border="1" data-bbox="287 1355 782 1579"> <thead> <tr> <th>Finished width (mm)</th> <th>Needle gauge mm (in)</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>17</td> <td>12.7 (1/2)</td> <td>MAB-0510SLAO</td> </tr> <tr> <td>15</td> <td>9.5 (3/8)</td> <td>MAB-0510QKAO</td> </tr> <tr> <td>12</td> <td>7.9 (5/16)</td> <td>MAB-0510MHAO</td> </tr> <tr> <td>10</td> <td>6.4 (1/4)</td> <td>MAB-0510KFAO</td> </tr> <tr> <td>9</td> <td>5.6 (7/32)</td> <td>MAB-0510JEAO</td> </tr> <tr> <td>8</td> <td>4.8 (3/16)</td> <td>MAB-0510HDAO</td> </tr> </tbody> </table>	Finished width (mm)	Needle gauge mm (in)	Part No.	17	12.7 (1/2)	MAB-0510SLAO	15	9.5 (3/8)	MAB-0510QKAO	12	7.9 (5/16)	MAB-0510MHAO	10	6.4 (1/4)	MAB-0510KFAO	9	5.6 (7/32)	MAB-0510JEAO	8	4.8 (3/16)	MAB-0510HDAO	<p>●Superpose joining guide</p>  <p>Edge allowance: Max. 20mm</p>	<p><b>Applicable machines:</b> MH-382  <b>Applications:</b> Used with lockstitch machines or chainstitch machines to sew side seam, and similar runstitch &amp; joining edge of garments with different curve lines</p> <table border="1" data-bbox="957 1456 1452 1601"> <thead> <tr> <th>Type</th> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>Light-weight material</td> <td>MAH-027000AA</td> </tr> <tr> <td>Medium-weight material</td> <td>MAH-027000AB</td> </tr> <tr> <td>Heavy-weight material</td> <td>MAH-027000AH</td> </tr> <tr> <td>Spacer (assy.)</td> <td>MAH-025020AO</td> </tr> </tbody> </table>	Type	Part No.	Light-weight material	MAH-027000AA	Medium-weight material	MAH-027000AB	Heavy-weight material	MAH-027000AH	Spacer (assy.)	MAH-025020AO																					
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<p>●Tape cutter</p> <p><b>AT28</b></p>	<p>▶ <b>WHEN YOU PLACE ORDERS</b></p> <p><b>AT28</b></p>  <table border="1" data-bbox="311 1736 774 1915"> <thead> <tr> <th>Switch</th> <th>Code</th> <th>Needle gauge mm (in)</th> <th>Code</th> </tr> </thead> <tbody> <tr> <td>Finger switch</td> <td>A</td> <td>3.2 (1/8")</td> <td>B</td> </tr> <tr> <td>Knee switch</td> <td>B</td> <td>4.0 (5/32")</td> <td>C</td> </tr> <tr> <td></td> <td></td> <td>4.8 (3/16")</td> <td>D</td> </tr> <tr> <td></td> <td></td> <td>5.6 (7/32")</td> <td>E</td> </tr> <tr> <td></td> <td></td> <td>6.4 (1/4")</td> <td>F</td> </tr> <tr> <td></td> <td></td> <td>7.9 (5/16")</td> <td>H</td> </tr> <tr> <td></td> <td></td> <td>9.5 (3/8")</td> <td>K</td> </tr> <tr> <td></td> <td></td> <td>12.7 (1/2")</td> <td>L</td> </tr> </tbody> </table> <p>* Needle gauges, 1/8, 5/32, 3/16, 3/8 and 1/2, should be specially orderd.</p>	Switch	Code	Needle gauge mm (in)	Code	Finger switch	A	3.2 (1/8")	B	Knee switch	B	4.0 (5/32")	C			4.8 (3/16")	D			5.6 (7/32")	E			6.4 (1/4")	F			7.9 (5/16")	H			9.5 (3/8")	K			12.7 (1/2")	L	<p>●Zipper guide</p>  <p>50-60mm 34mm</p> <table border="1" data-bbox="957 1758 1452 1825"> <thead> <tr> <th>Part No.</th> </tr> </thead> <tbody> <tr> <td>MAQ-020000AO</td> </tr> </tbody> </table>	Part No.	MAQ-020000AO	<p><b>Applicable machines:</b> MH-380  <b>Class of work:</b> Jeans, Working pants  <b>Applications:</b> Sew zippers on left files  <b>Materials:</b> Medium-weight materials such as jeans denim, cotton gabardine, drill etc.</p>														
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<p>▶ <b>SPECIFICATIONS</b></p> <p><b>Applicable model :</b> MH-380 (Cannot be use with the thread trimmer type.)  <b>Operating method:</b> Air drive by air switch  <b>Applications :</b> Cutting various tapes related to attaching reinforcement tape and decorative tape  <b>Cut specifications :</b> Knife width 20mm  Cutting range of the knife 16mm or less  <b>Air pressure :</b> 0.15~0.5 MPa (1.5~5.0kgf/cm<sup>2</sup>)</p>	<p>▶ <b>APPLICATIONS</b></p> <table border="1" data-bbox="813 1892 1452 2049"> <thead> <tr> <th>Model</th> <th>Application</th> </tr> </thead> <tbody> <tr> <td>MH-380 (parallel 2-needle)</td> <td> <ul style="list-style-type: none"> <li>Sewing sides of slacks</li> <li>Hemming or welting garment parts</li> <li>Attaching lining tape</li> </ul> </td> </tr> <tr> <td>MH-382 (tandem 2-needle)</td> <td> <ul style="list-style-type: none"> <li>Joining seat of slacks</li> </ul> </td> </tr> </tbody> </table>	Model	Application	MH-380 (parallel 2-needle)	<ul style="list-style-type: none"> <li>Sewing sides of slacks</li> <li>Hemming or welting garment parts</li> <li>Attaching lining tape</li> </ul>	MH-382 (tandem 2-needle)	<ul style="list-style-type: none"> <li>Joining seat of slacks</li> </ul>																																																
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## TABLE OF EXCHANGING GAUGE SETS

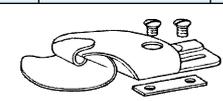
### MH-380

Description	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog	Rear moving needle guard	Right fix needle guard	Left needle guard
<b>Gauge components</b>							
3.2mm (1/8")	B1103-380-B00	B1406-019-BA0	B1509-038-BB0	B1613-380-B00	B2311-380-B00	B2315-380-000	B2312-380-000
4.0mm (5/32")	B1103-380-C00	B1406-019-CA0	B1509-038-CB0				
4.8mm (3/16")	B1103-380-D00	B1406-019-DA0	B1509-038-DB0	B1613-380-D00			
5.6mm (7/32")	B1103-380-E00	B1406-019-EA0	B1509-038-EB0	B1613-380-F00	B2311-380-E00		
6.4mm (1/4")	B1103-380-F00	B1406-019-FA0	B1509-038-FB0				
7.9mm (5/16")	B1103-380-H00	B1406-038-HA0	B1509-038-HB0	B1613-380-H00	B2311-380-H00		
9.5mm (3/8")	B1103-380-K00	B1406-038-KA0	B1509-038-KB0	B1613-380-K00			
12.7mm (1/2")	B1103-380-L00	B1406-038-LA0	B1509-038-LBB	B1613-380-L00	B2311-380-L00		

### MH-382

	B1103-382-000	B1406-038-BA0	B1524-382-0B0	B1613-382-000	B2311-382-000	B2312-382-000
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### MH-380

Description	Right looper	Left looper	Bed slide asm.	Bed slide asm.	Folder		
					M	MH	H
<b>Gauge components</b>							
3.2mm (1/8")	B2030-380-000	B2031-380-000	B1104-380-AA0	B1108-380-BA0	B9126-038-BAA	B9126-038-BAB	B9126-038-BAC
4.0mm (5/32")					B9126-038-CAA	B9126-038-CAB	B9126-038-CAC
4.8mm (3/16")					B9126-038-DAA	B9126-038-DAB	B9126-038-DAC
5.6mm (7/32")					B9126-038-EAA	B9126-038-EAB	B9126-038-EAC
6.4mm (1/4")					B9126-038-FAA	B9126-038-FAB	B9126-038-FAC
7.9mm (5/16")					B9126-038-HAA	B9126-038-HAB	B9126-038-HAC
9.5mm (3/8")							
12.7mm (1/2")						B1104-380-LA0	B1108-380-LA0

### MH-382

	B2030-380-000	B2031-380-000	B1104-380-A00	B1108-380-B00		
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#### 1) Size code

3.2mm (1/8") = B
4.0mm (5/32") = C
4.8mm (3/16") = D
5.6mm (7/32") = E
6.4mm (1/4") = F
7.9mm (5/16") = H
9.5mm (3/8") = K
12.7mm (1/2") = L

#### 2) Folder code

M (for light weight materials) = A
MH (for medium heavy weight materials) = B
H (for heavy weight materials) = C

## SPECIFICATIONS

Model name	MH-380	MH-382
		Parallel 2-needle
Max. sewing speed	6,000rpm	
Stitch length	4mm	
Lift of the presser foot	By hand: 5.5mm, By knee: 10mm	
Needle bar stroke	30mm	
Needle (at the time of delivery)	TV x 7 (#14) #9 ~ #21	
Thread take-up	Needle bar thread take-up	
Stitch length adjustment	By stitch dial (lockstitch)	
Condensation stitches	By lever for condensation stitching	
Looper system	Rocking type looper	
Looper stroke	22.6mm	
Elliptical motion	2.4 ~ 3.7mm	
Lubrication	Automatic	
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	
Needle cooler	Optional	

## WHEN YOU PLACE ORDERS

Please note when placing orders, that the model name should be written as follows:

MH380 U MH382U

Needle gauge	Code	B	C	D	E	F	G	H	K	L	N
	mm		3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	12.7
inch		1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	1/2	3/4

● To order, please contact your nearest JUKI distributor.

**JUKI**  
JUKI CORPORATION  
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8-2-1, KOKURYO-CHO, CHOFU-SHI,  
TOKYO 182-8655, JAPAN  
PHONE : (81) 3-3480-2357, 2358  
FAX : (81) 3-3430-4909, 4914  
http://www.juki.com

\* Specifications and appearance are subject to change without prior notice for improvement.  
\* Read the instruction manual before putting the machine into service to ensure safety.  
\* This catalog is printed on recycle paper.