

**JUKI**

# JEANS





# The Finest Quality with High Produ

## FRONT

### Waist belt corner



Direct-drive, High-speed, Needle-feed, Lockstitch Machine  
**DLN-9010ASH-WB/CP-180/AK-118**



1-needle, Needle-feed, Lockstitch Machine  
**DLN-5410NH-7-WB/CP-180/AK-85**



Computer-controlled Cycle Machine with Input Function  
**AMS-210EN HS1306SZ**  
/Waist Band Corner Clamp

### Pocket Hemming



Semi-dry head, 2-needle, Lockstitch Machine  
**LH-3578AGF-7-WB/CP-180/AK-135**



High-speed, Flat-bed,  
2-needle Double Chainstitch Machine  
**MH-380FU/AT28/L050**

### Attach Pocket Facing



**SIRUBA**  
3-needle, flatbed, top cover stitch machine  
with safety stitch for attaching pocket facings.  
**F007K-W722-388/FY**

### Sew Pocket bag



Direct-drive, High-speed, 1-needle Lockstitch Machine  
**DDL-9000BSH-WB/CP-180/AK-141**



1-needle, Lockstitch Machine  
**DDL-8700H-7-WB/CP-180/AK-85**

### Serge Front Fly



Super-high-speed, Overlock Stitch Machine  
**MO-6904S-0F6-50H**



High-speed, Overlock Stitch Machine  
**MO-6704S-DF6-50H**



# ctivity & Efficiency

**BACK**

## *Sew Eyelet Buttonhole*



Computer-controlled, Eyelet Buttonholing Machine  
**MEB-3810 J01AA1**

## *Belt Loop Attaching*



Automatic 2-needle Belt-loop Attaching Machine  
**MOL-254**

## *Sew Waistband*



**SIRUBA**  
4-needle, flatbed double chainstitch machine  
**HF008-0464-254/HPR**

## *Topstitch Side Waist*



Post-bed, 1-needle, Unison-feed,  
Lockstitch Machine with Vertical-axis Large Hook  
**PLC-1710S-7-0B/CP-180**  
**/AK-136B/X55211**

## *Belt Loop Making*



**SIRUBA**  
2-needle, flatbed making belt loop machine  
**HF008-02064/FBQ14C**

## *Sew Inseam / Attaching Yoke / Seat Seaming*



Feed-off-the-arm, 3-needle Double Chainstitch Machine  
**MS-3580S FISN**



Feed-off-the-arm, Double Chainstitch Machine  
**MS-1261/V045S**

## *Sew Side Seam*



Bottom-feed, Safety Stitch Machine  
for Extra Heavy-weight Materials  
**MO-6916G-FH6-700**

## *Bottom Hemming*



High-speed, Cylinder-bed, 1-needle,  
Needle-feed Lockstitch Machine with Large Hook  
**DLN-6390S-7-W0A**



#### Belt Loop Bartacking



Computer-controlled, High-speed Bartacking Machine  
**LK-1900AN ws000**

#### Leather Label Attaching



Computer-controlled Cycle Machine with Input Function  
**AMS-210EN HS1510SZ5000C/FU05**

#### Hip Pocket Decoration Stitch



Computer-controlled Cycle Machine with Input Function  
**AMS-210EN HL2210SZ5000D**

#### Pocket Hemming



Semi-dry head, 2-needle, Lockstitch Machine  
**LH-3578AGF-7-WB/CP-180/AK-135**



High-speed, Flat-bed, 2-needle Double Chainstitch Machine  
**MH-380FU/AT28/L050**

#### Automatic Pocket Setter



Automatic Pocket Setter (Full-automatic)  
**AP-876S**

Jeans Pocket Setter (Semi-automatic)  
**AP-874S**



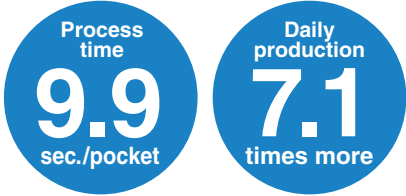
Computer-controlled Cycle Machine with Input Function  
(for sewing pockets on jeans)  
**AMS-221EN-HS03020SZ/7200**

# Merits by using Automatic Machine

## Example for AP-876S / General-purpose machine

### Increased productivity

The machine carries out a series of pocket setting processes at 9.9 seconds/pocket. It achieves 7.1 times as productive as general-purpose machines.



#### Comparison of process time and productivity

Attach hip pocket process	General-purpose machine	AP-876S
Fold hip pocket (Iron)	14 sec.	9.9 sec.
Sew hip pocket to back	48 sec.	
Bartack hip pocket edge	8 sec.	
Daily production	316 pockets	2,237 pockets

※Condition: Hours of work: 8 hours, Allowance rate: 30%

#### Comparison of effect achieved by the introduction of the AP-876S

	General-purpose machine	AP-876S	Comparison
Daily production	316 pockets	2,237 pockets	7.1 times
Process time	63 sec.	9.9 sec.	Process time has been reduced by approximately one minute.
Number of operators	8 operators	1 operator	The number of operators has been reduced by seven.
Number of machines	8 machines	1 machine	The number of machines has been reduced by seven.
Number of processes	3 processes	1 process	The number of processes has been reduced by two.

※The daily production given above is the per-capita production.

#### ●9.9 sec./pocket※

The machine is able to fold a subsequent pocket and place it on a garment body while the machine is still engaged in the sewing of the current pocket. This means higher productivity can be achieved simply with one machine. The exclusive high-speed, 1-needle lockstitch zigzag stitch machine with an automatic thread trimmer has been adopted as the machine head for the AP-876. The maximum sewing speed is 4,000 sti/min. The AP-876 reduces the cycle time by 5% as compared with JUKI's conventional model, AVP-875.

※Pocket sewing condition: 340 stitches (medium-size pocket)

#### ●Reduction in the number of facilities and that of operators to be used

The AP-876 fully automatizes a series of pocket setting processes. If these processes are done by means of the general-purpose machine, the following eight facilities (eight operators) will be required to achieve the daily production equivalent to that of the AP-876.

- Iron: two machines (Fold hip pocket)
  - 1-needle lockstitch machines with automatic thread trimmer: five machines (Sew hip pocket to back)
  - Bartacking machine: one machine (Bartack hip pocket edge)
- The AP-876 is able to carry out these processes alone (one operator).

### Process time of hip pocket attaching and Productivity

Sew hip pocket (Machine)	AP-876S 1 machine	AP-874S 1 machine	AMS-221EN3020/7200		General-purpose machine 1 machine
			2 machines	1 machine	
Layout (Operation by 1 person)					
Process time of hip pocket					
Fold hip pocket (Press or Iron) ※1	×	● (Press)	● (Press)	● (Press)	● (Iron)
Sew hip pocket to back ※2	●	●	●	●	●
Bartack hip pocket edge ※3	×	×	×	×	●
Total Cycle time (Operation by 1 person)	9.9 sec./pocket	13.4 sec./pocket	15.0 sec./pocket	25.0 sec./pocket	70.0 sec./pocket
Daily production (Allowance rate; 25%)	2,327 pockets	1,719 pockets	1,536 pockets	1,006 pockets	354 pockets
Daily production (Allowance rate; 30%)	2,237 pockets	1,653 pockets	1,476 pockets	886 pockets	316 pockets

※ Hours of work; 8 hours, Allowance rate; 25% or 30%

※ with stacker

※ without stacker

※1 Press Machine : P, Iron machine : I

※2 Hip pocket Machine : AP(876S, 874S), AMS or General-purpose machine(G)

※3 Bartack Machine : B(LK-1900AN)



## Example for MOL-254 / LK-1900AN



### The machine time of MOL-254 is 1.2 seconds per belt-loop (with 28 stitches).

MOL-254 head specifically developed for belt-loop attaching machines runs at a maximum sewing speed of 2,500rpm and is equipped with a direct-drive system that improves start up performance and shortens sewing time. The belt-loop feeding device is now provided with a halfway standby capability for subsequent belt-loops, and its faster belt-loop supply action shortens the time required for supplying belt-loops and helps speed up the machine time to 1.2 seconds per belt-loop (with 28 stitches).



#### Process time of belt-loop attaching and Productivity

	MOL-254	LK-1900AN
Attach belt loops (5pcs)	13.8 sec./pair	44.0 sec./pair
<b>Daily production</b> (Allowance rate; 25%)	<b>1,669 pockets</b>	<b>523 pockets</b>
<b>Daily production</b> (Allowance rate; 30%)	<b>1,605 pockets</b>	<b>503 pockets</b>

※ Hours of work; 8 hours, Allowance rate; 25% or 30%

## Example for AMS-210EN2210 / DDL-8700H-7



### Productivity / Desking / Quality

Hip pocket decoration stitches are to be the brand symbols (seams) of each manufacturer, therefore one of the most important processes of jeans making. In the pursuit of consistent seam quality as well as high productivity and desking the machine is best-suited for your requirements.

#### Process time of pocket decoration stitching and Productivity

	AMS-210EN2210	DDL-8700H-7
Hip pocket decoration stitch Marking pocket	7.0 sec./pocket Not Required } 7.0 sec./pocket	12.0 sec./pocket 4.0 sec./pocket } 16.0 sec./pocket
<b>Daily production [2 pocket]</b> (Allowance rate; 25%)	<b>1,645 pairs</b>	<b>720 pairs</b>
<b>Daily production [2 pocket]</b> (Allowance rate; 30%)	<b>1,582 pairs</b>	<b>692 pairs</b>

※ Hours of work; 8 hours, Allowance rate; 25% or 30%

# JUKI

**JUKI CORPORATION**  
SEWING MACHINERY BUSINESS UNIT

※ 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 catalogue prints with environment-friendly soyink on recycle paper.



#### JUKI CORPORATION HEAD OFFICE

Juki Corporation operates an environmental management system to promote and conduct the following as the company engages in the research, development, design, sales, distribution, and maintenance of industrial sewing machines, household sewing machines, industrial robots, etc., and in the provision of sales and maintenance services for data entry systems:

- (1) The development of products and engineering processes that are safe to the environment
- (2) Green procurement and green purchasing
- (3) Energy conservation (reduction in carbon-dioxide emissions)
- (4) Resource saving (reduction of papers purchased, etc.)
- (5) Reduction and recycling of waste
- (6) Improvement of logistics efficiency (modal shift and improvement of packaging, packing, etc.)



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