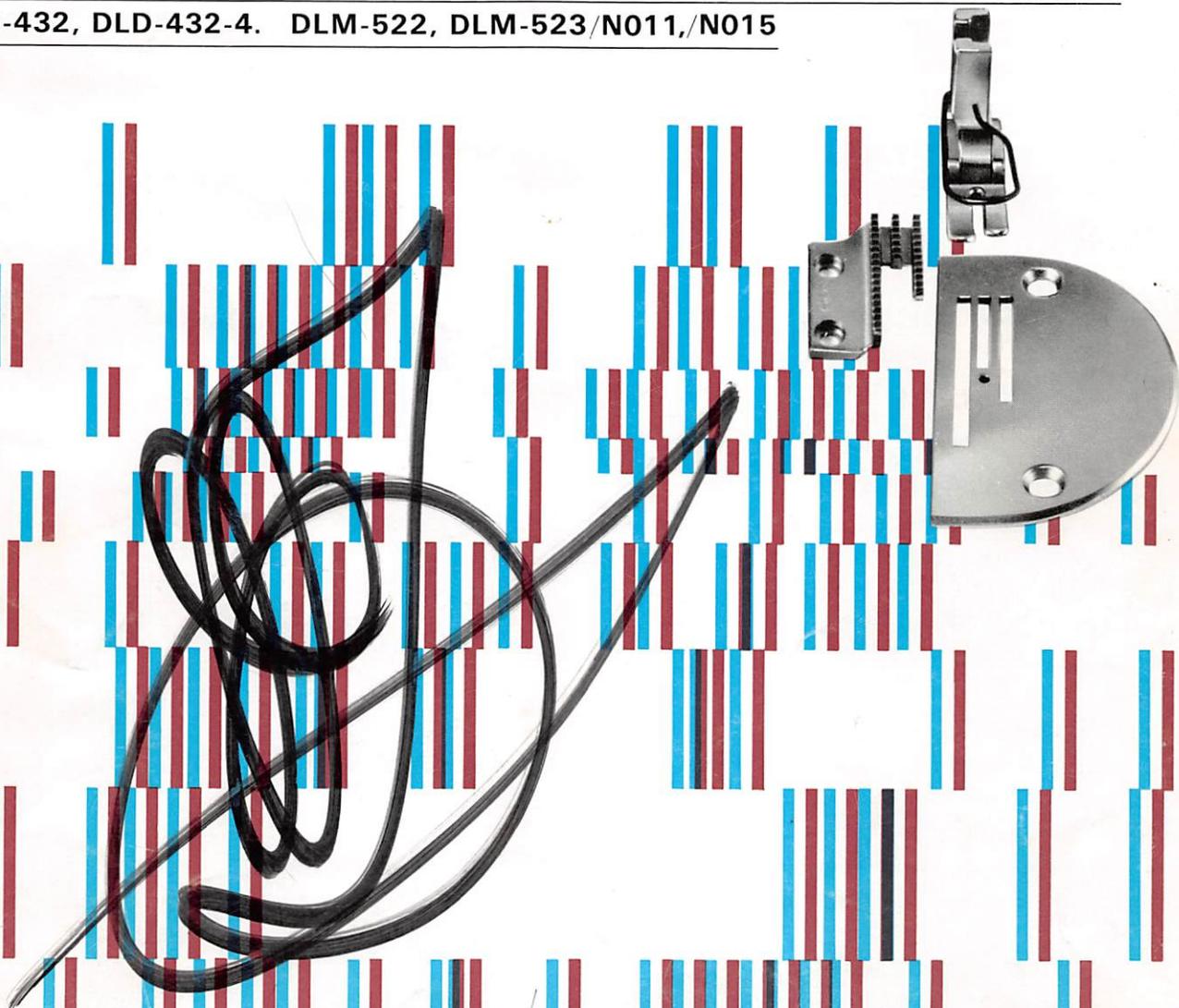


JUKI®

GAUGE SET MANUAL

DDL-227, DDL-555, DDL-555-4. DLN-415, DLN-415-4. DLU-450, DLU-450-4.
DLD-432, DLD-432-4. DLM-522, DLM-523/N011,/N015



CONTENTS

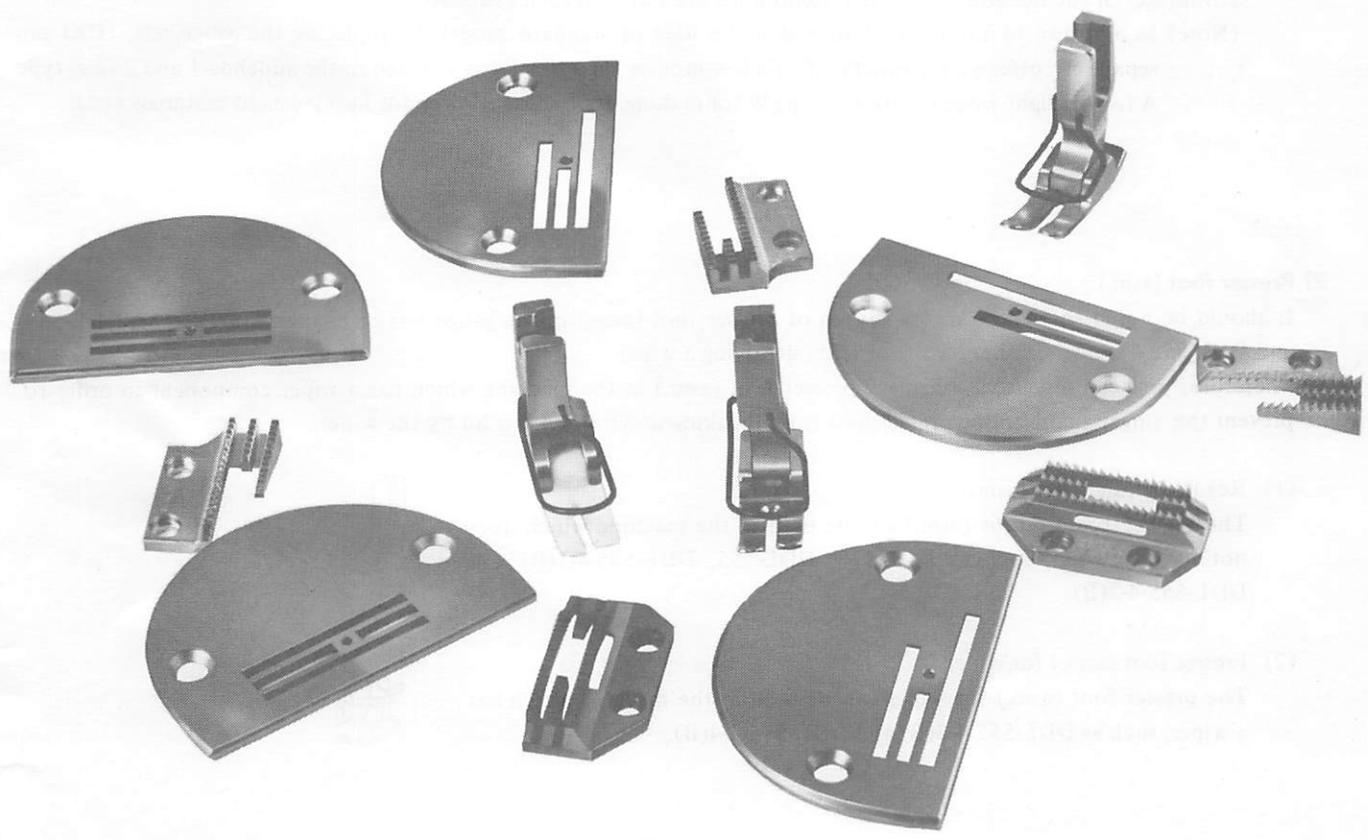
1. Introduction	1
2. How to use the Gauge Set Manual	2
3. Classification of fabrics	4
I. DDL-227, DDL-555, DDL-555-4	5
1. List of Standard Gauge Sets (Throat Plate, Feed Dog, Presser Foot (asm.))	6
2. Classification of Gauge Sets (Advantages, Applications)	7
3. Index of the Presser Foot with or without Finger Guard	21
4. Drawing of each Presser Foot (asm.)	22
II. DLN-415, DLN-415-4	23
1. List of Standard Gauge Sets (Throat Plate, Feed Dog, Presser Foot (asm.))	24
2. Classification of Gauge Sets (Advantages, Applications)	25
3. Drawing of each Presser Foot & Index of the Presser Foot with or without Finger Guard	33
4. Drawing of each Feed Dog	34
III. DLU-450, DLU-450-4	35
1. List of Standard Gauge Sets (Throat Plate, Feed Dog, Presser Foot (asm.))	36
2. Classification of Gauge Sets (Advantages, Applications)	37
3. Drawing of each Presser Foot (asm.)	46
IV. DLD-432, DLD-432-4	47
1. List of Standard Gauge Sets (Throat Plate, Feed Dog, Presser Foot (asm.))	48
2. Classification of Gauge Sets (Advantages, Applications)	49
3. Drawing of each Feed Dog	51
4. Drawing of each Differential Feed Dog	52
5. Drawing of each Presser Foot (asm.)	53
V. DLM-522	54
1. List of Standard Gauge Sets (Throat Plate, Feed Dog, Presser Foot (asm.))	55
2. Classification of Gauge Sets	56
3. Drawing of each Gauge Plate	57
4. Drawing of each Throat Plate, Throat Plate Open Cover, Waste Material Guard	58
5. Drawing of each Feed Dog & Presser Foot (asm.)	59
VI. DLM-523/N011, DLM-523/N015	60
1. List of Standard Gauge Sets (Throat Plate, Feed Dog, Presser Foot (asm.))	61
2. Classification of Gauge Sets	62
Addenda : List of subclass models	63

1. INTRODUCTION

As you know well, 1-Needle Lockstitch Machine is one of the most popular sewing machines both in the household and industrial sewing work. The official statistics tell us that the Lockstitch Sewing Machines amount to more than 60% of all sewing equipments presently used in the garment industry and are playing the important roles in a variety of fields of applications.

However, as the type of new fabrics is increasing, operators of lockstitch machines will frequently face to difficulties in coping with handling of various fabrics by operating their lockstitch machines being equipped with the standard gauge set.

In order to help JUKI users with selection of the most suitable gauge set for respective applications, we have worked out this GAUGE SET MANUAL. Since this Manual covers our typical gauge sets consisting of the throat plate, feed dog, presser foot (asm.) and necessary components, we believe that you will use a suitable gauge set for your particular sewing work and improve the quality of your products.



2. HOW TO USE THE GAUGE SET MANUAL

1) Coverage

This Manual covers the throat plate, feed dogs and presser feet (asm.) to be used in the JUKI 1-needle lockstitch machines presently available.

(1) Scope of gauge set exchange

This Manual covers only the gauge set exchange which is made to replace the standard throat plate, feed dog and presser foot (asm.) by the corresponding components being designed for special purposes. In other words, it does not include the cases when a joint exchange of other components such as the hook, needle bar etc. is required.

For example, when DDL-555-4 standard model (for medium-heavy weight material) has to be used to sew the garment of light-weight material, its throat plate, feed dog and presser foot must be replaced by a gauge set consisting of the same components but having a smaller needle hole in order to prevent such stitching problems as puckering and stitch skipping. (see "Classification of Fabrics")

(2) How to choose the gauge set

Choose a suitable gauge set for the type of fabric and class of work by referring to the List of Standard Gauge Sets for the needle hole diameter and number of slits in the throat plate. With regard to the needle hole diameters of DLN series models which do not have a needle hole in the throat plate because of "needle feed" mechanism, the needle hole diameters in the feed dog instead of those in the throat plate are stated in the same column of the List of Standard Gauge Sets.

In addition to the needle hole diameters, the important dimensions of each component, typical applications, advantages of the use and some other useful hints are stated in each gauge set.

(Note) In addition to the method to widen the uses of standard models by replacing the gauge sets, JUKI can separately offer you a variety of subclass models for special uses as listed in the addenda 1 and 2 (e.g. type A for the light-weight material, type W for making dress shirts, H type for heavy-weight materials etc.).

2) Presser foot (asm.)

It should be noted that there are two types of presser foot (asm.) in the gauge sets to be used in DDL-227, DDL-555 and DDL-555-4 models, either having or without having a wiper.

Therefore, you can not use a "regular" presser foot (asm.) in the machine which has a wiper component in order to prevent the finger guard on the presser foot from breaking down when it is hit by the wiper.

(1) Regular presser foot (asm.)

The regular presser foot (asm.) can be used in the machine which does not have a wiper, such as DDL-227, DDL-555, DDL-555-4-1(B) and DDL-555-4-2(B).



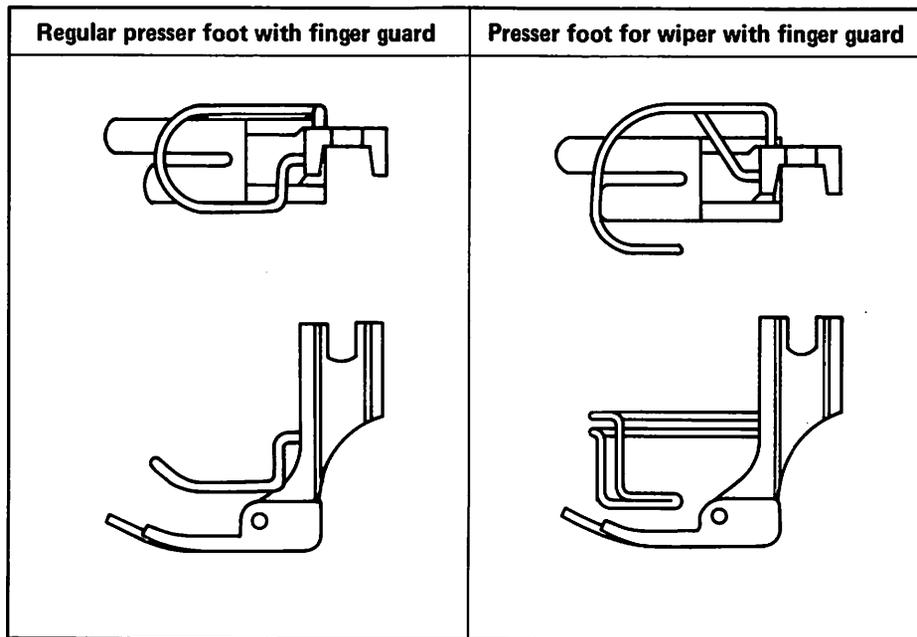
(2) Presser foot (asm.) for wiper

The presser foot (asm.) for wiper can be used in the machine which has a wiper, such as DDL-555-4-3(B) and DDL-555-4-4(B).



(3) Difference in shape

The difference in shape of the “regular” and the “wiper” presser foot having the finger guard is shown by the illustration below;

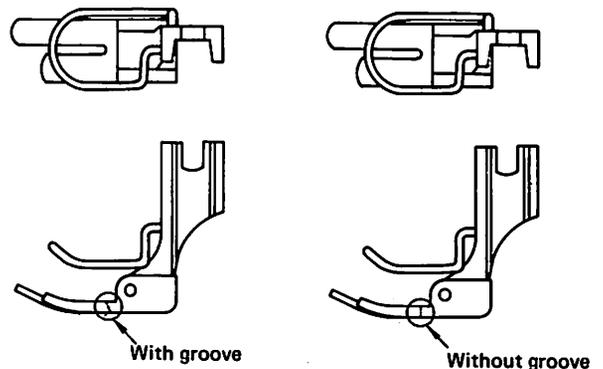


Please note that those presser feet for wipers which do not have their Part Nos. in this Manual are not included in our regular production but can be specially manufactured upon your request.

(4) Groove on the sole of presser foot (asm.)

In general, each presser foot (asm.) has a groove on its sole. Those presser feet which do not have a groove on the sole are used to prevent the needle thread from slipping out of the needle at the start of sewing.

They can be identified by an explanation “without groove” in the sketch of presser foot (asm.)



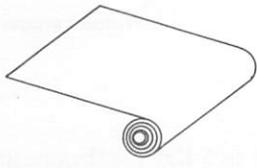
3) Pressing force of the presser foot and the size of the needle.

The indication in Remarks column of each gauge set being referred to as “standard” means “4 to 5 Kg” for the pressing force of the presser foot and “#14” for the size of the needle.

3. CLASSIFICATION OF FABRICS

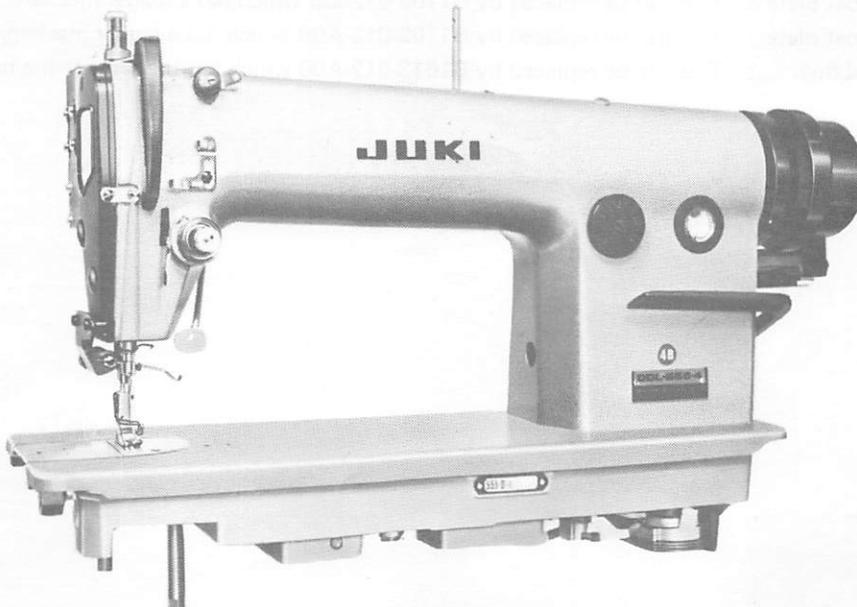
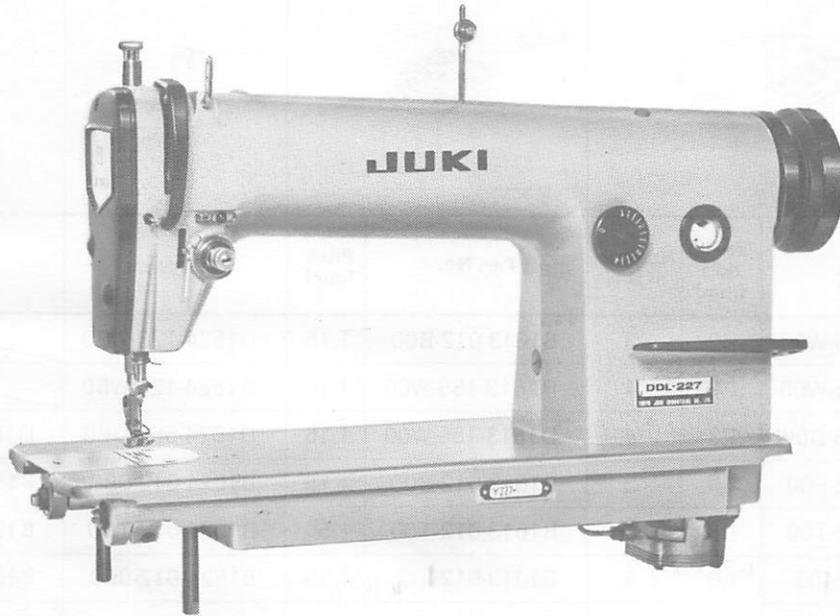
Since it is almost impossible to classify all fabrics presently available in the market, we roughly classified them by weight aiming at filling the requirements in the use of JUKI Lockstitch Machines with a suitable gauge set.

CLASSIFICATION OF FABRICS BY WEIGHT

Type of fabric		Light weight	Medium-heavy weight	Heavy weight
Item				
Weight		50~150g/m ²	150~320g/m ²	320~500g/m ²
Needle 	JAPAN	#8 ~ #10	#10 ~ #14	#16 ~ #23
	EUROPE	#62 ~ #70	#70 ~ #90	#100 ~ #160
	AMERICA	#8 ~ #10	#10 ~ #14	#16 ~ #23
Thread (cotton) 	JAPAN	#60 ~ #100	#40 ~ #60	#30, #40, #50
	EUROPE	#100 ~ #170	#70 ~ #100	#50, #70, #80
	AMERICA	#60 ~ #100	#40 ~ #60	#30, #40, #50
Typical fabric 	Broadcloth Single georgette Crepe de chine Single jersey	Gabardine Serge Denim(lighter than 12 oz.) Double jersey	Denim (12 oz. or heavier) Mossy	
Typical garment 	Shirts Blouse One-piece dresses Dresses	Suits Coats Student uniforms Jackets Jersey	Denim jeans Heavy overcoats	

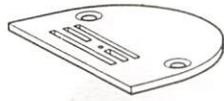
I. DDL-227, DDL-555, DDL-555-4

1-Needle, Lockstitch Machine



From the library of: Superior Sewing Machine & Supply LLC

1. List of Standard Gauge Sets (DDL-227, DDL-555, DDL-555-4)

Page	Throat plate			Feed dog		Presser foot (asm.)		Remarks
						For mach. without wiper	For mach. with wiper	
								
Part No.	Needle hole (mm)	Number of slits	Part No.	Pitch (mm)	Part No.	Part No.		
7	D1109-126-W00	1.2	3	**** B1613-012-B00	1.15	D1524-126-WB0		
8	D1109-155-W00	1.3	4	D1613-155-W00	1.15	D1524-126-WB0		
9	D1109-555-D0W	1.3	4	D1613-155-W00	1.15	D1524-555-DB0	D1524-555-DBA	
10	B1109-012-F00	1.6	3	B1613-012-B00	1.15	B1524-012-0B0	B1524-012-0BA	
11	* B1109-012-T00	1.6	3	B1613-012-T00	1.5	B1524-012-TB0	B1524-012-TBA	
12	** B1109-012-100	1.6	4	B1613-012-100	1.15	B1524-012-0B0	B1524-012-0BA	
13	D1109-555-D01	1.6	4	B1613-012-100	1.15	D1524-555-DB0	D1524-555-DBA	(Standard for DDL-555-4)
14	B1109-012-G00	1.6	4	B1613-012-D00	1.15	B1524-012-0B0	B1524-012-0BA	
15	*** B1109-012-A00	1.9	3	B1613-012-A00	1.5	B1524-012-0B0	B1524-012-0BA	(Standard for DDL-227, DDL-555)
16	B1109-012-C00	1.9	4	B1613-012-C00	1.5	B1524-012-0B0	B1524-012-0BA	
17	B1109-012-D00	1.9	4	B1613-012-D00	1.15	B1524-012-0B0	B1524-012-0BA	
18	B1109-012-B00	2.2	3	B1613-012-A00	1.5	B1524-012-0B0	B1524-012-0BA	
19	B1109-012-E00	2.4	3	B1613-012-A00	1.5	B1524-012-0B0	B1524-012-0BA	
20	B1109-543-000	2.4	3	B1621-543-000	1.8	B1511-543-BB0		

(Note) 1. The above table suggests you the typical combinations of the throat plate, feed dog and presser foot (asm.). Besides the above examples, a variety of other combinations is possible. Refer to each gauge set for further details.

2. * Throat plate : This can be replaced by B1109-012-T0B which has a higher mechanical strength.
 ** Throat plate : This can be replaced by B1109-012-i0B which has a higher mechanical strength.
 *** Throat plate : This can be replaced by B1109-012-A0B which has a higher mechanical strength.
 **** Feed dog : This can be replaced by B1613-012-A00 which has the same shape but a 1.5 mm pitch.

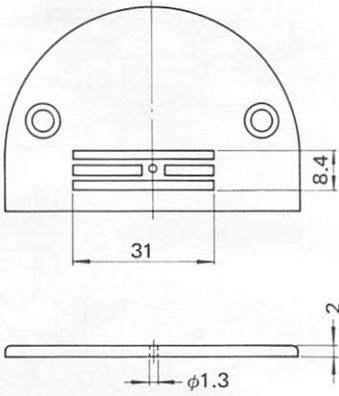
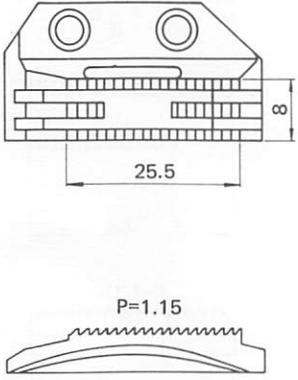
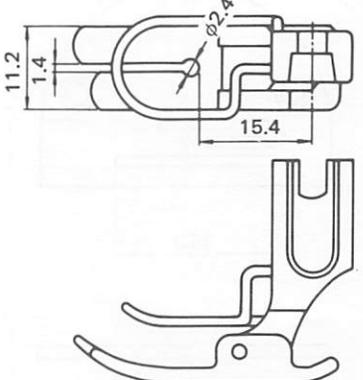
B-1109-552-000
147150LG

B-1613-552-000
149057

2. Classification of Gauge Sets (Advantages, Applications)

Standard set			
Throat plate D1109-126-W00	Feed dog B1613-012-B00	Presser foot (asm.) For mach. without wiper: D1524-126-WB0 For mach. with wiper:	
Alternative components			
	B1613-012-A00	For mach. without wiper	For mach. with wiper
		B1524-012-0B0 B1524-012-TB0 B1511-155-BB0 B1524-552-0B0 D1524-555-DB0 B1524-227-AB0	B1524-012-0BA B1524-012-TBA B1511-155-BBA B1524-552-0BA D1524-555-DBA B1524-227-AB0
Advantages	Typical garment	Typical fabrics	
Suitable for sewing the light weight materials which tend to cause puckering and stitch skipping.	Blouse Nightwear Scarf One-piece dress (light weight) Skirt	Chiffon georgette Crepe de chine Single jersey Palace crepe	
Applicable models	Remarks		
DDL-227 DDL-555 DDL-555-4	(1) Slightly reduce the pressing force of the presser foot. (2) Use a thinner needle than the standard. (3) Feed dog : B1613-012-B00 1.15 mm pitch B1613-012-A00 1.5 mm pitch		

Standard set			
Throat plate D1109-155-W00	Feed dog D1613-155-W00	Presser foot (asm.) D1524-126-WB0	
		For mach. without wiper For mach. with wiper	
Alternative components			
		For mach. without wiper	For mach. with wiper
		B1524-012-0B0 B1524-012-TB0 B1511-155-BB0 B1524-552-0B0 D1524-555-DB0 B1524-227-AB0	B1524-012-0BA B1524-012-TBA B1511-155-BBA B1524-552-0BA D1524-555-DBA B1524-227-AB0
Advantages	Typical garment	Typical fabrics	
Suitable for sewing the light weight materials which tend to pucker.	Blouse Nightwear Scarf One-piece dress (light weight) Dress shirt Skirt	Chiffon georgette Crepe de chine Single jersey Palace crepe	
Applicable models	Remarks		
DDL-227 DDL-555 DDL-555-4	(1) Slightly reduce the pressing force of the presser foot. (2) Use a thinner needle than the standard. (3) The standard gauge set is equipped in DDL-555W and DDL-227W types.		

Standard set																
Throat plate D1109-555-D0W	Feed dog D1613-155-W00	Presser foot (asm.) For mach. without wiper D1524-555-DB0 For mach. with wiper D1524-555-DBA														
																
Alternative components																
		<table border="1"> <thead> <tr> <th>For mach. without wiper</th> <th>For mach. with wiper</th> </tr> </thead> <tbody> <tr> <td>B1524-012-0B0</td> <td>B1524-012-0BA</td> </tr> <tr> <td>B1524-012-TB0</td> <td>B1524-012-TBA</td> </tr> <tr> <td>D1524-126-WB0</td> <td></td> </tr> <tr> <td>B1511-155-BB0</td> <td>B1511-155-BBA</td> </tr> <tr> <td>B1524-552-0B0</td> <td>B1524-552-0BA</td> </tr> <tr> <td>B1524-227-AB0</td> <td>B1524-227-AB0</td> </tr> </tbody> </table>	For mach. without wiper	For mach. with wiper	B1524-012-0B0	B1524-012-0BA	B1524-012-TB0	B1524-012-TBA	D1524-126-WB0		B1511-155-BB0	B1511-155-BBA	B1524-552-0B0	B1524-552-0BA	B1524-227-AB0	B1524-227-AB0
For mach. without wiper	For mach. with wiper															
B1524-012-0B0	B1524-012-0BA															
B1524-012-TB0	B1524-012-TBA															
D1524-126-WB0																
B1511-155-BB0	B1511-155-BBA															
B1524-552-0B0	B1524-552-0BA															
B1524-227-AB0	B1524-227-AB0															
Advantages	Typical garment	Typical fabrics														
Suitable for sewing the light weight material which tend to pucker.	Blouse Nightwear Scarf One-piece dress (light weight) Dress shirt Skirt	Chiffon georgette Crepe de chine Single jersey Palace crepe														
Applicable models	Remarks															
DDL-227 DDL-555 DDL-555-4	(1) Slightly reduce the pressing force of the presser foot. (2) Use a thinner needle than the standard. (3) Throat plate D1109-555-D0W has a higher mechanical strength than D1109-155-W00 and does not have a relief angle in the needle hole.															

Standard set			
Throat plate	Feed dog	Presser foot (asm.)	
B1109-012-F00	B1613-012-B00	For mach. without wiper	B1524-012-0B0
		For mach. with wiper	B1524-012-0BA
Alternative components			
	B1613-012-A00	For mach. without wiper	For mach. with wiper
		B1524-012-TB0 D1524-126-WB0 B1511-155-BB0 B1524-552-0B0 D1524-555-DB0 B1524-227-AB0	B1524-012-TBA B1511-155-BBA B1524-552-0BA D1524-555-DBA B1524-227-AB0
Advantages	Typical garment	Typical fabrics	
<p>(1) Only for general light weight materials (excluding fabrics for permanent press)</p> <p>(2) Three-row feed dog is more suitable to make a sharp-curved seamline than those of four-row feed dogs.</p>	<p>Dress shirt</p> <p>Blouse</p> <p>One-piece dress</p> <p>Linings</p> <p>Apron</p> <p>Pinafore</p>	<p>Chiffon georgette</p> <p>Crepe de chine</p> <p>Palace crepe</p> <p>Yoryu georgette crepe</p>	
Applicable models	Remarks		
<p>DDL-227</p> <p>DDL-555</p> <p>DDL-555-4</p>	<p>Slightly reduce the pressing force of the presser foot.</p>		

Standard set			
Throat plate	Feed dog	Presser foot (asm.)	
B1109-012-T00	B1613-012-T00	For mach. without wiper	B1524-012-TB0
		For mach. with wiper	B1524-012-TBA
Alternative components			
B1109-012-T0B		For mach. without wiper	For mach. with wiper
		B1524-012-0B0 D1524-126-WB0 B1524-155-BB0 B1524-552-0B0 D1524-555-DB0 B1524-227-AB0	B1524-012-0BA B1524-155-BBA B1524-552-0BA D1524-555-DBA B1524-227-AB0
Advantages	Typical garment	Typical fabrics	
<p>Suitable for sewing the light weight materials which tend to cause puckering or stitch skipping.</p>	<p>Sew lace to slip Lingerie Runstitch on tricot goods Raincoat</p>	<p>Tricot</p>	
Applicable models	Remarks		
DDL-227 DDL-555 DDL-555-4	<ol style="list-style-type: none"> (1) Slightly reduce the pressing force of the presser foot. (2) Use a thinner needle than the standard. (3) Throat plate B1109-012-T0B has a higher durability than that of B1109-012-T00. Use the durable throat plate in the machine which is equipped with a thread trimmer. 		

Standard set

Throat plate	Feed dog	Presser foot (asm.)	
B1109-012-i00	B1613-012-i00	For mach. without wiper	B1524-012-0B0
		For mach. with wiper	B1524-012-0BA
<p><i>REC'D GENUINE IT'S ALL SEWER, SM. No. 1404</i></p>			

Alternative components

D1109-012-i0B	For mach. without wiper	For mach. with wiper
	B1524-012-TB0 D1524-126-WB0 B1511-155-BB0 B1524-552-0B0 D1524-555-DB0 B1524-227-AB0	B1524-012-TBA B1511-155-BBA B1524-552-0BA D1524-555-DBA B1524-227-AB0

Advantages

Suitable to make a long and straight seam on the light weight materials

Typical garment

Sheet
Puff cover
Dress shirt
Blouse
One-piece dress
Linings
General cloths

Typical fabrics

Broadcloth
Tropical
Voile
Linings

Applicable models

DDL-227
DDL-555
DDL-555-4

Remarks

- (1) Slightly reduce the pressing force of the presser foot.
- (2) Use a thinner needle than the standard.
- (3) This gauge set is used in DDL-555A and DDL-227A.
- (4) Throat plate B1109-012-i0B is more durable than B1109-012-i00.
Use the durable throat plate in the machine which is equipped with a thread trimmer.

Standard set			
Throat plate	Feed dog	Presser foot (asm.)	
D1109-555-D0i	B1613-012-i00	For mach. without wiper	D1524-555-DB0
		For mach. with wiper	D1524-555-DBA
Alternative components			
		For mach. without wiper	For mach. with wiper
		B1524-012-0B0 B1524-012-TB0 D1524-126-WB0 B1524-155-BB0 B1524-552-0B0 B1524-227-AB0	B1524-012-0BA B1524-012-TBA B1511-155-BBA B1524-552-0BA B1524-227-AB0
Advantage	Typical garment	Typical fabrics	
Suitable to make a long and straight seam on the light weight materials.	Sheet Puff cover Dress shirt Blouse One-piece dress Linings General cloth	Broadcloth Tropical Voile Linings	
Applicable models	Remarks		
DDL-227 DDL-555 DDL-555-4	(1) Slightly reduce the pressing force of the presser foot. (2) Use a thinner needle than the standard. (3) Throat plate D1109-555-D0i ensures more accurate straightness than D1109-012-i00. (4) The standard gauge set is equipped in DDL-555A-4.		

Standard set

Throat plate	Feed dog	Presser foot (asm.)	
B1109-012-G00	B1613-012-D00	For mach. without wiper	B1524-012-0B0
		For mach. with wiper	B1524-012-0BA

Alternative components

		For mach. without wiper	For mach. with wiper
		B1524-012-TB0 D1524-126-WB0 B1511-155-BB0 B1524-552-0B0 D1524-555-DB0 B1524-227-AB0	B1524-012-TBA B1511-155-BBA B1524-552-0BA D1524-555-DBA B1524-227-AB0

Advantages

- (1) For general light weight materials
- (2) Ensure efficient curve sewing comparing with other four-row feed dogs.

Typical garment

Lingerie
Shapers
Dress shirt
Blouse
One-piece dress
General cloth

Typical fabrics

Two-way tricot
Spandex
Lace

Applicable models

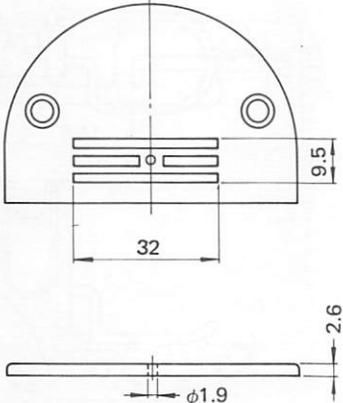
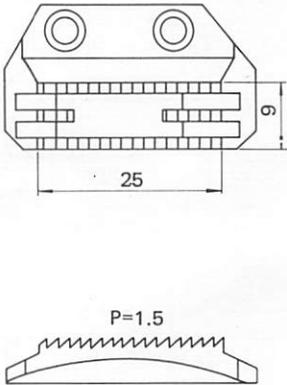
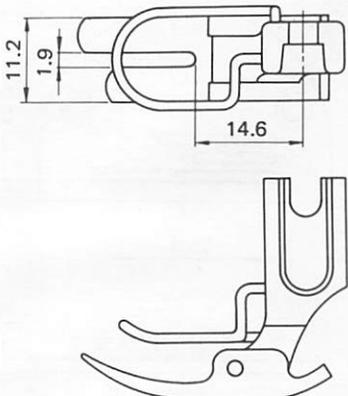
DDL-227
DDL-555
DDL-555-4

Remarks

Slightly reduce the pressing force of the presser foot.

Standard set			
Throat plate	Feed dog	Presser foot (asm.)	
B1109-012-A00	B1613-012-A00	For mach. without wiper	B1524-012-0B0
		For mach. with wiper	B1524-012-0BA
Alternative components			
B1109-012-A0B		For mach. without wiper	For mach. with wiper
		B1524-012-TB0 D1524-126-WB0 B1511-155-BB0 B1524-552-0B0 D1524-555-DB0 B1524-227-AB0	B1524-012-TBA B1511-155-BBA B1524-552-0BA D1524-555-DBA B1524-227-AB0
Advantages	Typical garment	Typical fabrics	
For general work	Working wear General clothings (student uniform, men's wear, ladies' and children's wear), Sportswear	Gabardine Doeskin Kersey Double jersey	
Applicable models	Remarks		
DDL-227 DDL-555 DDL-555-4	(1) Apply the standard pressing force of the presser foot. (2) Throat plate B1109-012-A0B is more durable than B1109-012-A00.		

Standard set

Throat plate	Feed dog	Presser foot (asm.)	
B1109-012-C00	B1613-012-C00	For mach. without wiper	B1524-012-0B0
		For mach. with wiper	B1524-012-0BA
			

Alternative components

		For mach. without wiper	For mach. with wiper
		B1524-012-TB0 D1524-126-WB0 B1511-155-BB0 B1524-552-0B0 D1524-555-DB0 B1524-227-AB0	B1524-012-TBA B1511-155-BBA B1524-552-0BA D1524-555-DBA B1524-227-AB0

Advantages	Typical garment	Typical fabrics
Suitable for sewing a long and straight seam on the medium-heavy weight materials.	Medium-heavy weight materials Knit shirt Working wear General clothings Sheet Cardigan and similar knit wear	Gabardine Wool gabardine Serge

Applicable models	Remarks
DDL-227 DDL-555 DDL-555-4	Apply the standard pressing force of the presser foot.

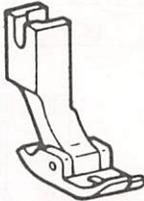
Standard set		
Throat plate	Feed dog	Presser foot (asm.)
B1109-012-D00	B1613-012-D00	For mach. without wiper B1524-012-0B0
		For mach. with wiper B1524-012-0BA
Alternative components		
		For mach. without wiper
		For mach. with wiper
		B1524-012-TB0 D1524-126-WB0 B1511-155-BB0 B1524-552-0B0 D1524-555-DB0 B1524-227-AB0
		B1524-012-TBA B1511-155-BBA B1524-552-0BA D1524-555-DBA B1524-227-AB0
Advantages	Typical garment	Typical fabrics
(1) For general medium-heavy weight material (2) Ensures efficient curve sewing comparing with other four-row feed dogs.	Blouse Dress shirt Sportswear Light weight one-piece dress Suit Jumper-skirt	Doeskin Voile Etamine Middle serge
Applicable models	Remarks	
DDL-227 DDL-555 DDL-555-4	Apply the standard pressing force of the presser foot.	

Standard set			
Throat plate	Feed dog	Presser foot (asm.)	
B1109-012-B00	B1613-012-A00	For mach. without wiper	B1524-012-0B0
		For mach. with wiper	B1524-012-0BA
Alternative components			
		For mach. without wiper	For mach. with wiper
		B1524-012-TB0 D1524-126-WB0 B1511-155-BB0 B1524-552-0B0 D1524-555-DB0 B1524-227-AB0	B1524-012-TBA B1511-155-BBA B1524-552-0BA D1524-555-DBA B1524-227-AB0
Advantages	Typical garment	Typical fabrics	
For general heavy weight materials	Heavy weight overcoat Curtain Jeans pants	Mossy Beaver cloth Denim	
Applicable models	Remarks		
DDL-227 DDL-555 DDL-555-4	Apply the standard pressing force of the presser foot.		

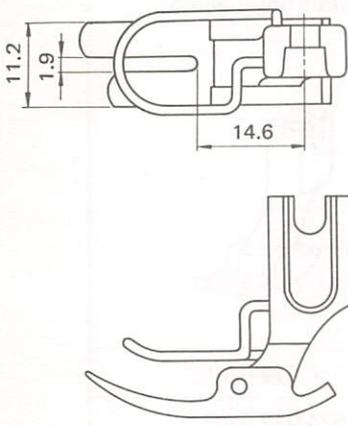
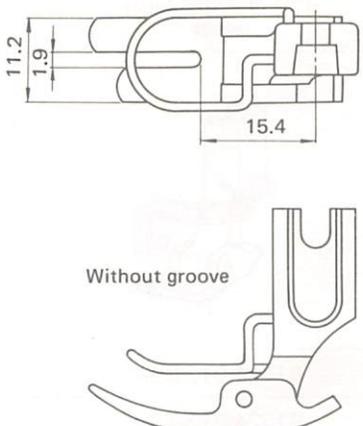
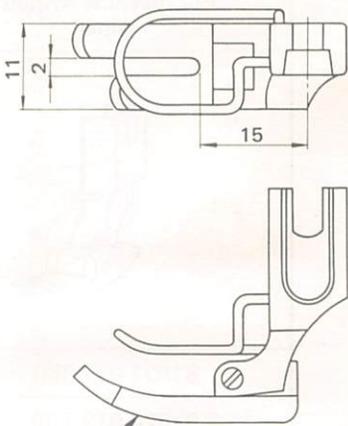
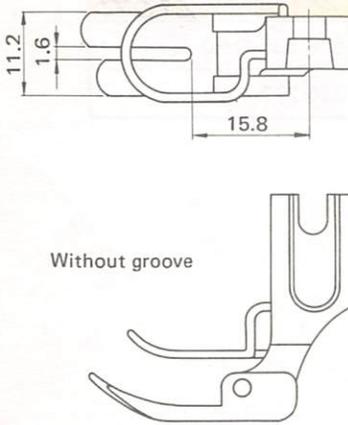
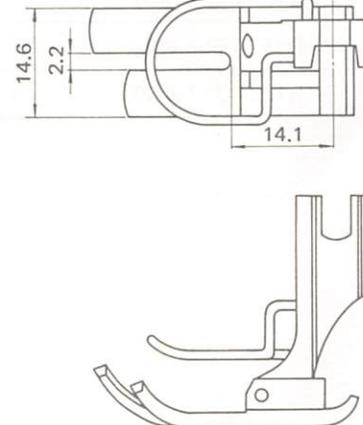
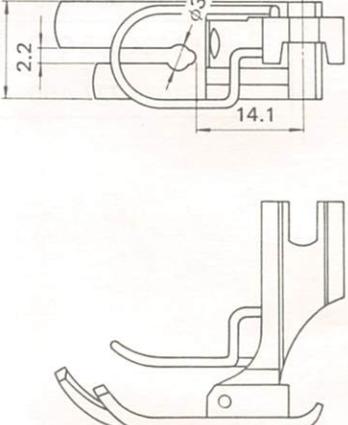
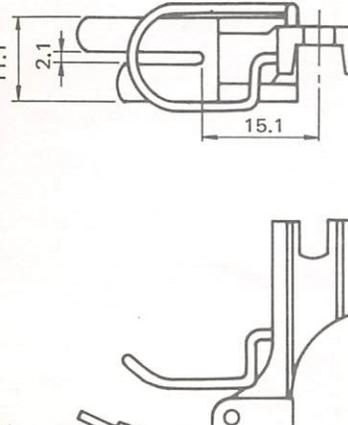
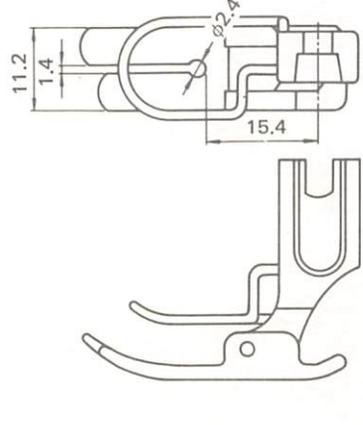
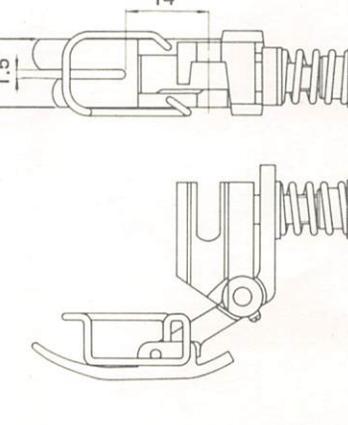
Standard set			
Throat plate	Feed dog	Presser foot (asm.)	
B1109-012-E00	B1613-012-A00	For mach. without wiper	B1524-012-0B0
		For mach. with wiper	B1524-012-0BA
Alternative components			
		For mach. without wiper	For mach. with wiper
		B1524-012-TB0 D1524-126-WB0 B1511-155-BB0 B1524-552-0B0 D1524-555-DB0 B1524-227-AB0	B1524-012-TBA B1511-155-BBA B1524-552-0BA D1524-555-DBA B1524-227-AB0
Advantages	Typical garment	Typical fabrics	
(1) Effective to provide a sufficient tension to stitches. (2) For heavy weight materials.	Vinyl leather Canvas bag Sneakers Jeans pants	Man-made leather Mossy Denim	
Applicable models	Remarks		
DDL-227 DDL-555 DDL-555-4	Slightly increase the pressing force of the presser foot.		

Standard set			
Throat plate	Feed dog	Presser foot (asm.)	
B1109-543-000	B1621-543-000	For mach. without wiper	B1511-543-BB0
		For mach. with wiper	
Alternative components			
		For mach. without wiper	For mach. with wiper
		B1511-543-0B0	
Advantages	Typical garment	Typical fabrics	
For general heavy weight materials	Heavy weight fabric Denim Overcoatings Curtain Jeans	Denim	
Applicable models	Remarks		
DDL-227 DDL-555 DDL-555-4	Apply the standard pressing force of the presser foot		

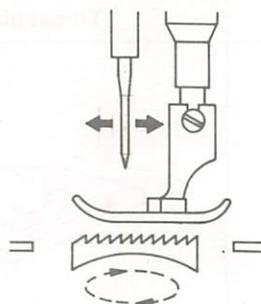
3. Index of the Presser Foot with or without Finger Guard

Presser foot (asm.) with finger guard		Presser foot (asm.) without finger guard
For machine without wiper	For machine with wiper	
		
B1524-012-0B0	B1524-012-0BA	B1524-012-0A0
B1524-012-TB0	B1524-012-TBA	B1524-012-TA0
D1524-126-WB0		D1524-126-WA0
B1511-155-BB0	B1511-155-BBA	B1511-155-BA0
B1511-543-0B0		B1511-543-0A0
B1511-543-BB0		B1511-543-BA0
B1524-552-0B0	B1524-552-0BA	B1524-552-0A0 <i>24545</i>
D1524-555-DB0	D1524-555-DBA	D1524-555-DA0
B1524-227-AB0	B1524-227-AB0	B1524-227-AA0

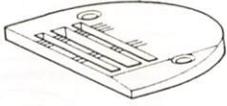
4. Drawing of each Presser Foot (asm.)

<p>B1524-012-0B0</p>  <p>11.2 1.9 14.6</p>	<p>B1524-012-TB0</p>  <p>11.2 1.9 15.4</p> <p>Without groove</p>	<p>D1524-126-WB0</p>  <p>11 2 15</p> <p>Teflon coated sole</p>
<p>B1511-155-BB0</p>  <p>11.2 1.6 15.8</p> <p>Without groove</p>	<p>B1511-543-0B0</p>  <p>14.6 2.2 14.1</p>	<p>B1511-543-BB0</p>  <p>13.1 2.2 14.1 $\varnothing 3.5$</p>
<p>B1524-552-0B0</p>  <p>11.1 2.1 15.1</p>	<p>D1524-555-DB0</p>  <p>11.2 1.4 15.4 $\varnothing 2.4$</p>	<p>B1524-227-AB0</p>  <p>12 1.5 14</p>

II. DLN-415, DLN-415-4 1-Needle, Needle Feed, Lockstitch Machine



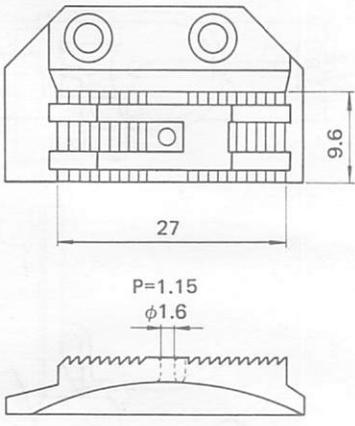
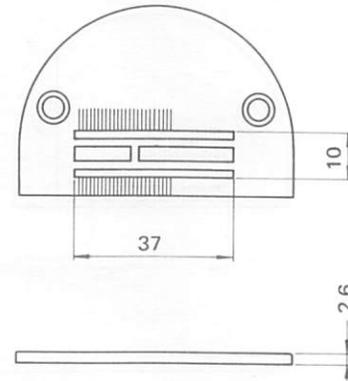
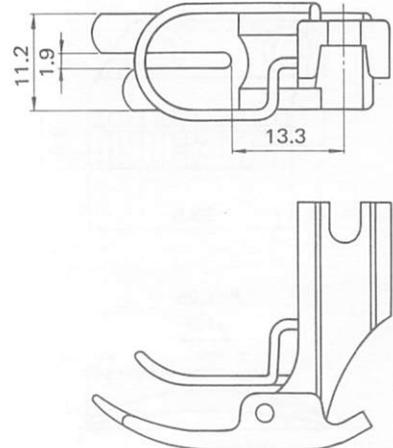
1. List of Standard Gauge Sets (DLN-415, DLN-415-4)

Page	Feed dog			Throat plate		Presser foot (asm.)	Remarks
							
	Part No.	Needle hole (mm)	Pitch (mm)	Part No.	Number of slits	Part No. <i>have 000</i>	
25	B1609-415-B00	1.6	1.15	B1109-415-B00	4	B1524-412-0B0	
26	B1609-041-C00	1.9	1.25	B1109-041-C00	1	B1524-412-0B0	
27	B1609-041-D00	1.9	1.15	B1109-041-D00	1	B1524-412-0B0	
28	B1609-041-A00	1.9	1.7	B1109-041-A00	2	B1524-041-AA0	
29	B1609-041-B00	1.9	1.15	B1109-041-B00	2	B1524-041-AA0	
30	B1609-041-F00	1.9	1.15	*B1109-041-F00	3	B1524-412-0B0	(Standard for DLN-415)
31	D1609-415-B00 ^N ₅₇₅ <i>MEM NO STOCK</i>	1.9	1.15	B1109-041-F0B	3	B1524-412-0B0	(Standard for DLN-415-4)
32	B1609-041-E00	1.9	1.7	B1109-041-E00	3	B1524-041-EB0	

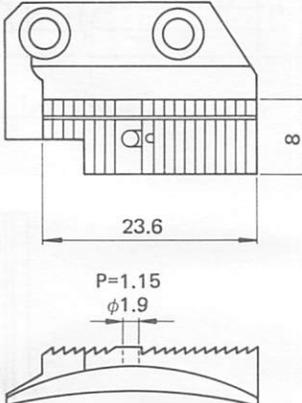
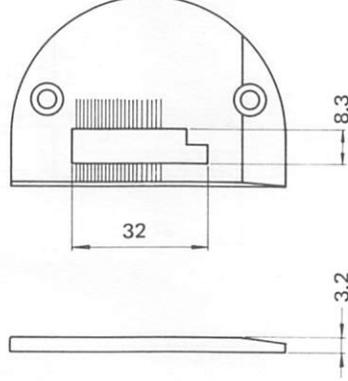
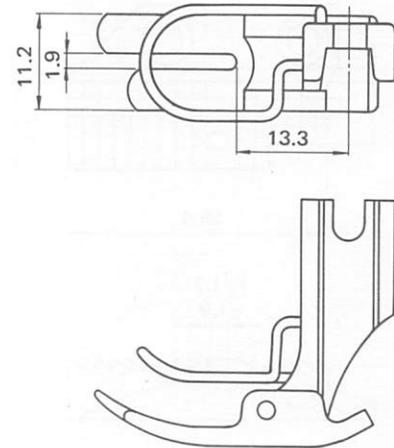
(Note) 1. The above table suggests you the typical combinations of the throat plate, feed dog and presser foot (asm.). Besides the above example, a variety of other combinations is possible. Refer to each gauge set for further details.

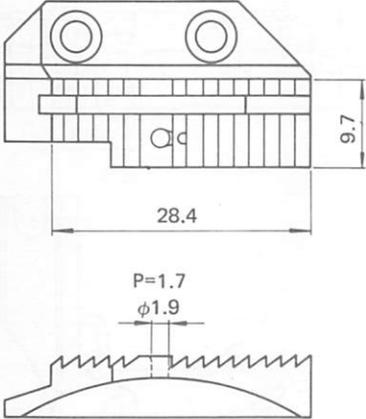
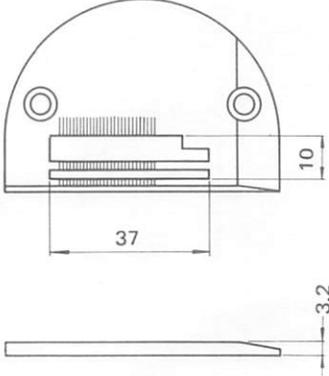
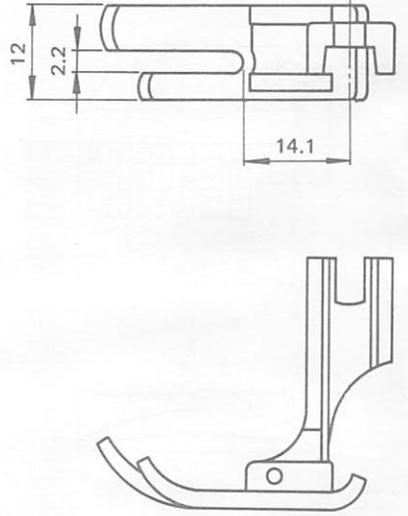
2. *Throat plate : This can be replaced by B1109-041-F0B which has a higher mechanical strength.

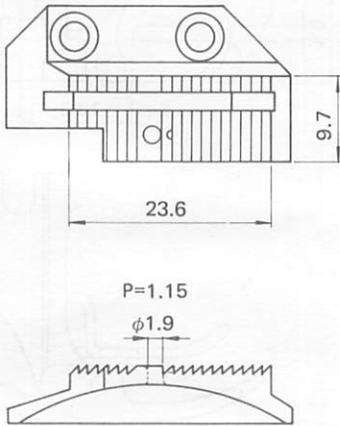
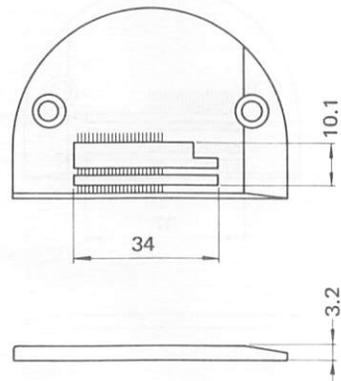
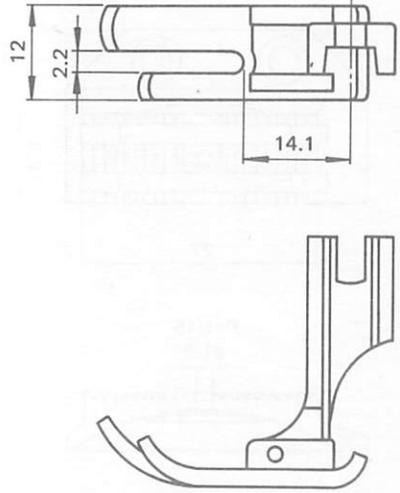
2. Classification of Gauge Sets (Advantages, Applications)

Standard set		
Feed dog B1609-415-B00	Throat plate B1109-415-B00	Presser foot (asm.) B1524-412-0B0
		
Alternative components		
		D1524-415-BBA D1524-415-BBB
Advantages	Typical garment	Typical fabrics
<ul style="list-style-type: none"> (1) For general light weight materials. (2) Suitable for the workpiece which has to be forcedly fed into the machine at the start of sewing. (3) Suitable also for the workpiece which has a raised part or rolled hem at the end of sewing and sometimes effective to prevent the stitch from skipping. 	<ul style="list-style-type: none"> Blouse Scarf Sew lace to garment 	<ul style="list-style-type: none"> Georgette Crepe de chine Lace
Applicable models	Remarks	
DLN-415 DLN-415-4	<ul style="list-style-type: none"> (1) Set a feed pitch (stitch length) to 2.5 mm (3/32") or less. (2) Slightly reduce the pressing force of the presser foot. (3) Use a thinner needle than the standard. 	

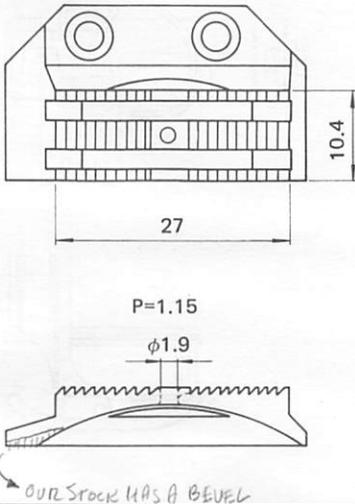
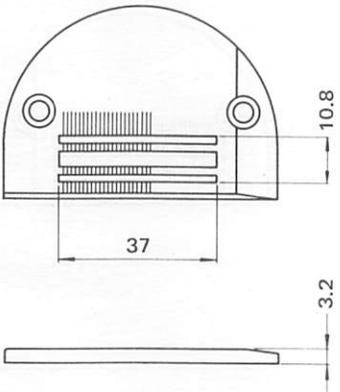
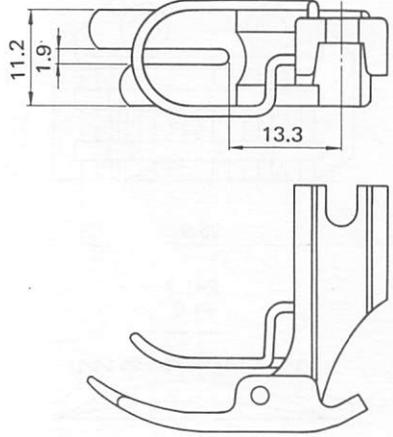
Standard set		
Feed dog B1609-041-C00	Throat plate B1109-041-C00	Presser foot (asm.) B1524-412-0B0
Alternative components		
		D1524-415-BBA D1524-415-BBB
Advantages	Typical garment	Typical fabrics
(1) For general medium-heavy weight materials. (2) Suitable for sharp curve sewing. (3) Effective when the workpiece is sewn with the use of a binder. (4) Suitable for sewing the edge of workpiece.	Rainproof coat Quilting wear Skiwear	Man-made leather Quilting
Applicable models	Remarks	
DLN-415 DLN-415-4	(1) Set the pressing force of the presser foot to a standard level or slightly lower. (2) Use a standard or slightly thicker needle.	

Standard set		
Feed dog	Throat plate	Presser foot (asm.)
B1609-041-D00	B1109-041-D00	B1524-412-0B0
		
Alternative components		
		D1524-415-BBA D1524-415-BBB
Advantages	Typical garment	Typical fabrics
<ul style="list-style-type: none"> (1) For general medium-heavy weight materials. (2) Ensures straight feed better than B1609-041-C00. (3) Suitable for the relatively resilient fabric. (4) Suitable for sewing the edge of workpiece. 	Rainproof coat, Quilting wear (Skiwear)	Man-made leather Quilting
Applicable models	Remarks	
DLN-415 DLN-415-4	<ul style="list-style-type: none"> (1) Set the pressing force of the presser foot to a standard or slightly lower. (2) Use a standard or slightly thicker needle. 	

Standard set		
Feed dog	Throat plate	Presser foot (asm.)
B1609-041-A00	B1609-041-A00	B1524-041-AA0
		
Alternative components		
		B1524-041-EB0 B1524-412-0B0 D1524-415-BBA D1524-415-BBB
Advantages	Typical garment	Typical fabrics
(1) For general medium-heavy or heavy weight materials (2) Suitable for sharp curve sewing. (3) Suitable for sewing the edge of workpiece.	Jeans pants Working wear Outdoor sheet	Denim Man-made leather
Applicable models	Remarks	
DLN-415 DLN-415-4	(1) Slightly increase the pressing force of the presser foot. (2) Use a slightly thicker needle than the standard.	

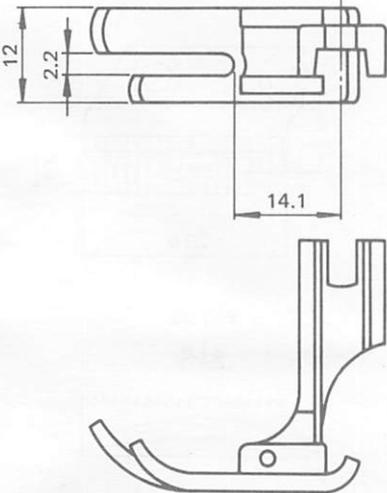
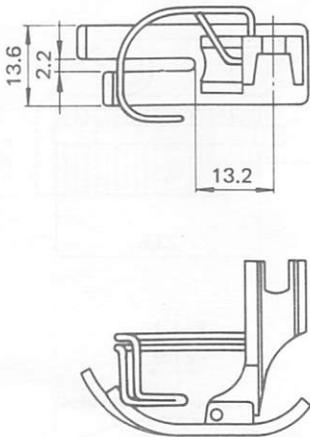
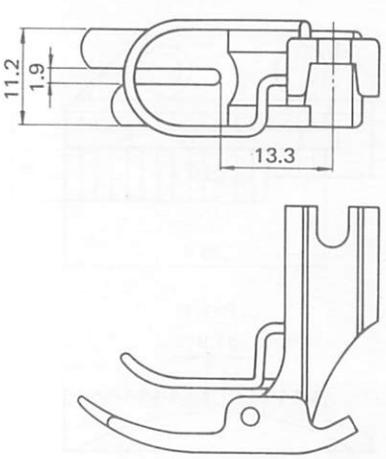
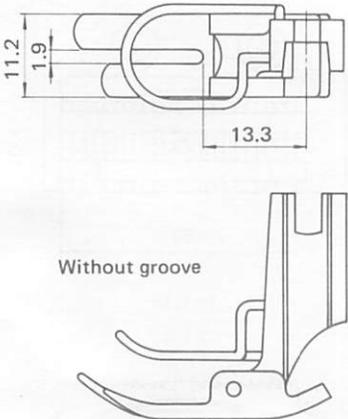
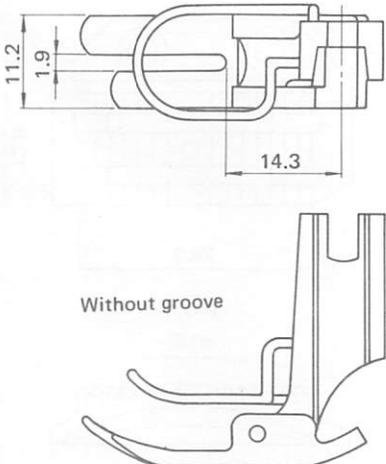
Standard set		
Feed dog B1609-041-B00	Throat plate B1109-041-B00	Presser foot (asm.) B1524-041-AA0
		
Alternative components		
		B1524-041-EB0 B1524-412-0B0 D1524-415-BBA D1524-415-BBB
Advantages	Typical garment	Typical fabrics
(1) For general medium-heavy weight materials. (2) Suitable for the workpiece which has to be turned round or sharply curved while being sewn. (3) Suitable for sewing the edge of workpiece.	Sports shirt General clothings	Gabardine Woollen fabric
Applicable models	Remarks	
DLN-415 DLN-415-4	(1) Set the presser foot to the standard pressure. (2) Use a needle of standard thickness.	

Standard set		
Feed dog B1609-041-F00	Throat plate B1109-041-F00	Presser foot (asm.) B1524-412-0B0
Alternative components		
D1609-415-B00		D1524-415-BBA D1524-415-BBB
Advantages	Typical garment	Typical fabrics
(1) For general light weight or medium-heavy weight materials. (2) The most popular gauge set being used in the standard machines.	Men's wear Ladies' wear Working wear Shirt	Woollen fabric Drill General cloth
Applicable models	Remarks	
DLN-415	(1) Set the presser foot to the standard pressure. (2) Use a needle of the standard thickness.	

Standard set		
Feed dog D1609-415-B00	Throat plate B1109-041-F0B	Presser foot (asm.) B1524-412-0B0
		
Alternative components		
B1609-041-F00		D1524-415-BBA D1524-415-BBB
Advantages	Typical garment	Typical fabrics
<p>(1) Suitable to prevent the thread from slipping out of the needle at the start of sewing and also to prevent stitch skipping.</p> <p>(2) This gauge set is widely used as a standard in the machines equipped with a thread trimmer.</p>	<p>Men's wear Ladies' wear Working wear Shirt</p>	<p>Woollen fabric Drill General cloths</p>
Applicable models	Remarks	
DLN-415-4	<p>(1) Set the presser foot to the standard pressure. (2) Use a needle of the standard thickness.</p>	

Standard set		
Feed dog B1609-041-E00	Throat plate B1109-041-E00	Presser foot (asm.) B1524-041-EB0
Alternative components		
		D1524-415-BBA D1524-415-BBB
Advantages	Typical garment	Typical fabrics
For general heavy weight materials	Jean pants Outdoor sheet	Denim Man-made leather
Applicable models	Remarks	
DLN-415 DLN-415-4	(1) Set the presser foot to the standard pressure. (2) Use a thick needle.	

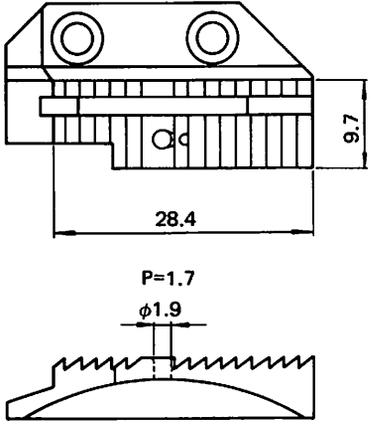
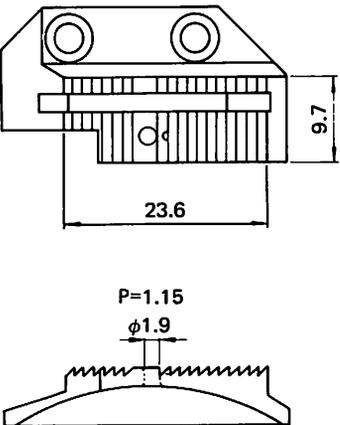
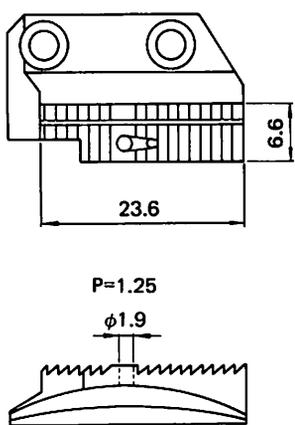
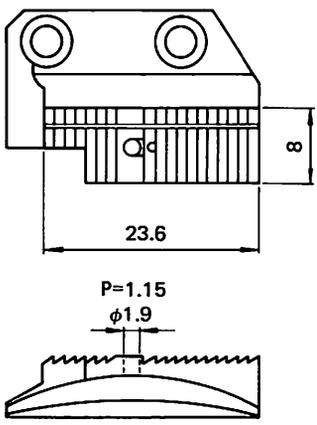
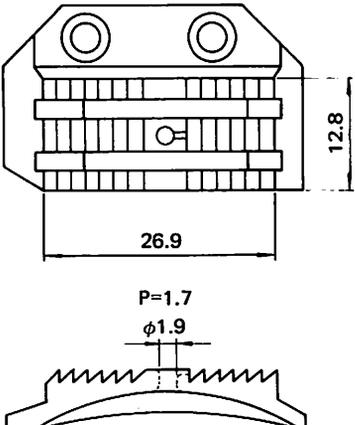
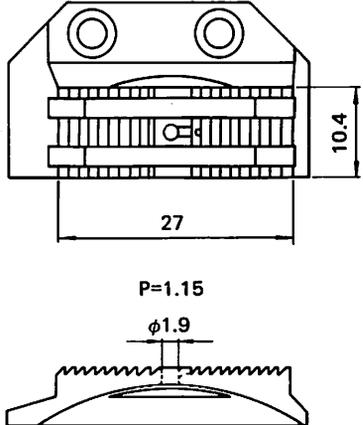
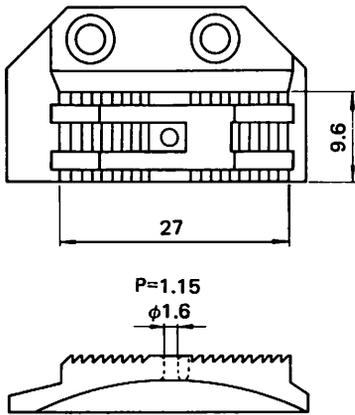
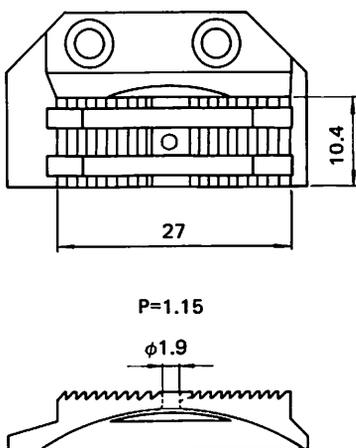
3. Drawing of Each Presser Foot (asm.)

B1524-041-AA0	B1524-041-EB0	B1524-412-0B0
		
D1524-415-BBA	D1524-415-BBB	
 <p>Without groove</p>	 <p>Without groove</p>	

Index of the Presser Foot with or without Finger Guard

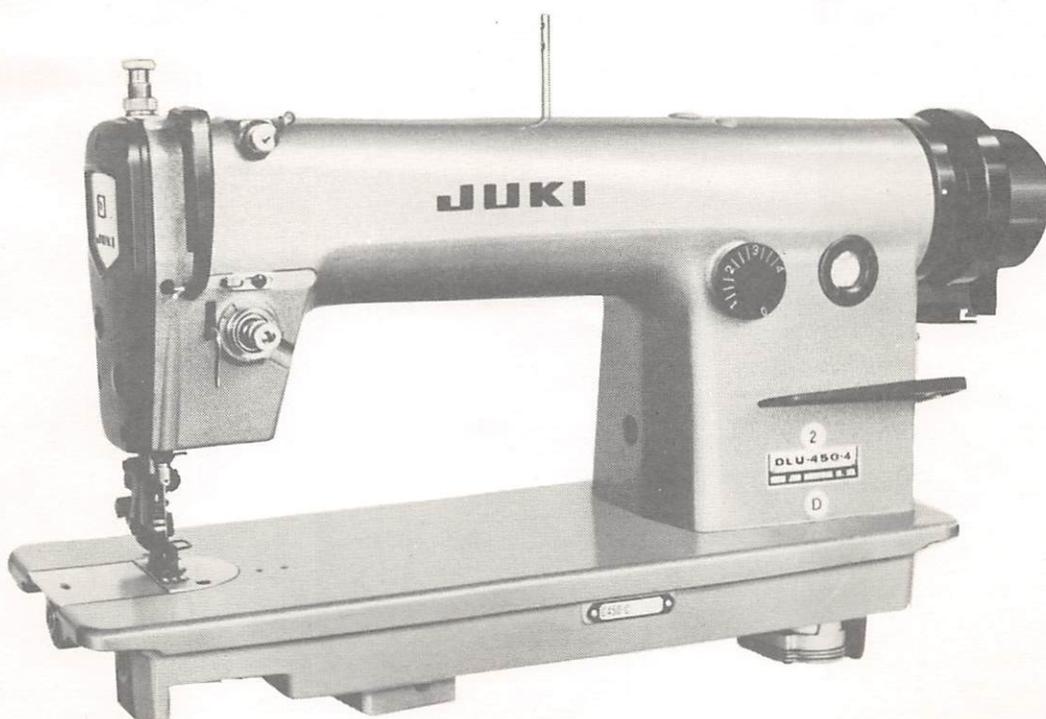
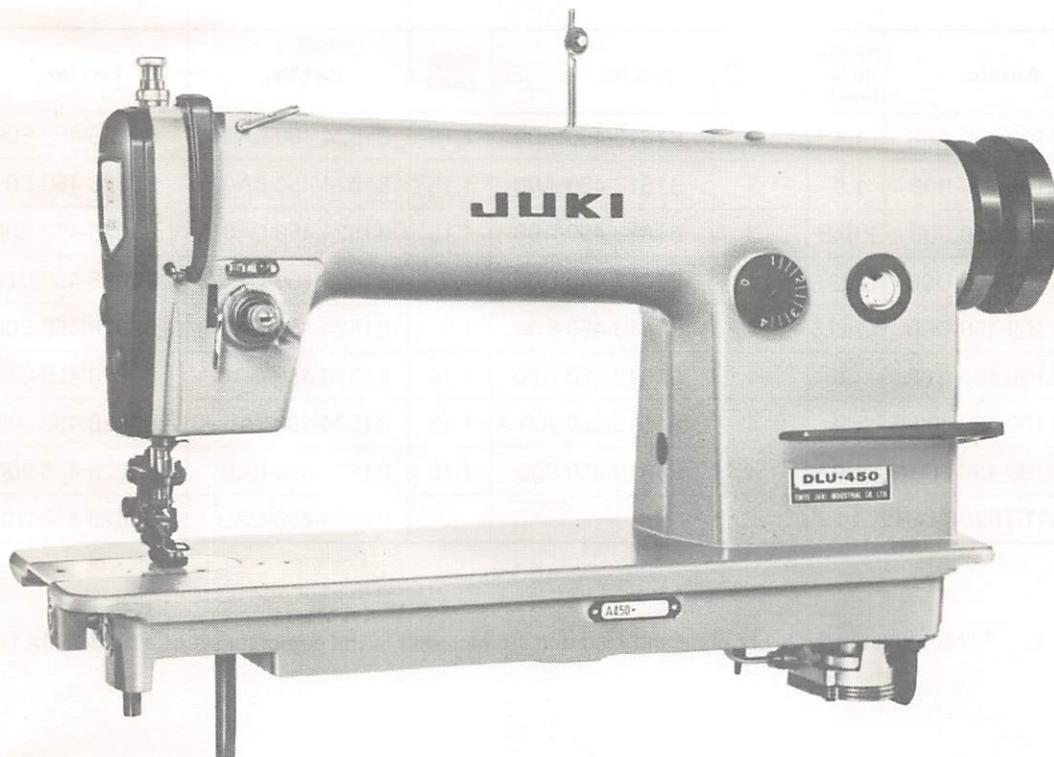
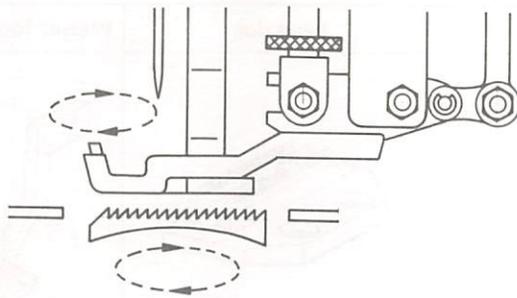
Presser foot (asm.) with finger guard	Presser foot (asm.) without finger guard	Remarks
		
	B1524-041-AA0	
B1524-041-EB0	B1524-041-EA0	
B1524-412-0B0	B1524-412-0A0	
D1524-415-BBA	D1524-415-BAA	For synthetic thread
D1524-415-BBB	D1524-415-BAB	

4. Drawing of Each Feed Dog

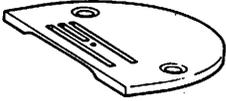
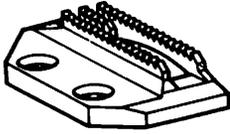
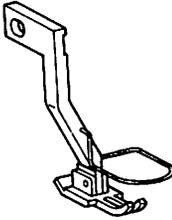
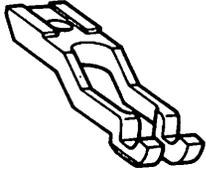
B1609-041-A00	B1609-041-B00	B1609-041-C00
		
B1609-041-D00	B1609-041-E00	B1609-041-F00
		
B1609-415-B00	D1609-415-B00	
		

III. DLU-450, DLU-450-4

1-Needle, Top and Bottom Feed, Lockstitch Machine



1. List of Standard Gauge Sets (DLU-450, DLU-450-4)

Page	Throat plate			Feed dog		Presser foot (asm.)	Walking foot	Remarks
	Part No.	Needle hole (mm)	Number of slits	Part No.	Pitch (mm)	Part No.	Part No.	
								
37	B1109-450-A0B	1.4	3	B1613-450-A00	1.15	B1524-450-0A0-A	B3026-450-E00	
38	B1109-450-B0B	1.9	3	B1613-450-A00	1.15	B1524-450-0A0-A	B3026-450-E00	(Standard)
39	B1109-450-C0B	1.6x3	3	B1613-450-A00	1.15	B1524-450-0A0-A	B3026-450-E00	
40	B1109-450-D0B	1.7x2.5	4	B1613-450-D00	1.5	B1524-450-DA0	B3026-450-D00	
41	B1109-450-D0B	1.7x2.5	4	B1613-450-E00	1.5	B1524-450-EA0	B3026-450-E00	
42	B1109-450-G0B	1.6	4	B1613-450-G00	1.15	B1524-450-GA0	B3026-450-G00	
43	B1109-450-J00-A	1.9	4	B1613-450-J00-A	1.15	B1524-450-JA0-A	B3026-450-J00	
44	B1109-450-P00	1.9	4	B1613-450-P00	1.15	B1524-450-PA0	B3026-450-P00	
45	*MAT-10901NAB					B1524-450-LA0	B3026-450-D00	

(Note) 1. *Throat plate : Throat plate and feed dog are included in the complete set of a binder MAT-10901NAB.

2. Classification of Gauge Sets (Advantages, Applications)

Standard set (Type A)			
Throat plate	Feed dog	Presser foot (asm.)	Walking foot
B1109-450-A0B	B1613-450-A00	B1524-450-0A0-A	B3026-450-E00
Alternative components			
Advantages	Typical garment	Typical fabrics	
<ul style="list-style-type: none"> (1) For light weight and medium-heavy weight materials. (2) Effective to prevent fabric from slipping while sewing. (3) Suitable for sewing a long and straight seam. 	Runstitch on knit fabric or suitings and coatings.	Knit fabric	
Applicable models	Remarks		
DLU-450 DLU-450-4	<ul style="list-style-type: none"> (1) Use a needle of standard thickness. (2) Relation of the walking foot to the presser foot. 		

Standard set (Type B)

Throat plate	Feed dog	Presser foot (asm.)	Walking foot
B1109-450-B0B	B1613-450-A00	B1524-450-0A0-A	B3026-450-E00

Alternative components

--	--	--	--

Advantages

- (1) For light weight and medium-heavy weight materials.
- (2) Effective to prevent the fabric from slipping while sewing.
- (3) Suitable to sew a long and straight seam.

Typical garment

Runstitch on the knit fabric.
Runstitch on suitings and coatings.

Typical fabrics

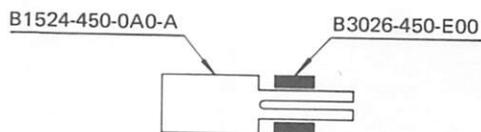
Knit fabrics

Applicable models

DLU-450
DLU-450-4

Remarks

- (1) Use a needle of standard thickness.
- (2) Relation of the walking foot to the presser foot.



Standard set (Type C)

Throat plate B1109-450-C0B	Feed dog B1613-450-A00	Presser foot (asm.) B1524-450-0A0-A	Walking foot B3026-450-E00

Alternative components

--	--	--	--

Advantages	Typical garment	Typical fabrics
<ul style="list-style-type: none"> (1) For general medium-heavy and heavy weight materials. (2) Effective to prevent the fabric from slipping while sewing. (3) Suitable to sew a long and straight seam. 	<p>Working wear, Runstitch on the man-made leather products (jumper)</p>	<p>Man-made leather Drill Gabardine</p>

Applicable models	Remarks
<p>DLU-450 DLU-450-4</p>	<ul style="list-style-type: none"> (1) Use a standard or slightly thicker needle. (2) Relation of the walking foot to the presser foot.

Standard set (Type D)			
Throat plate	Feed dog	Presser foot (asm.)	Walking foot
B1109-450-D0B	B1613-450-D00	B1524-450-DA0	B3026-450-D00
Alternative components			
		D1524-450-BAD	
Advantages	Typical garment	Typical fabrics	
<ul style="list-style-type: none"> (1) Suitable for sewing the fabric which tends to pucker. (2) Suitable for making top stitches. (3) Effective when sewing sharp curve seams. (4) Ensures to positively feed the fabric even in the raised or overlapped part. 	<ul style="list-style-type: none"> Join the left and right coat backs Sew cuffs to the sleeves of shirt Set pocket Blouse Sew linings to the garment fabric 	<ul style="list-style-type: none"> Polyester/cotton bland broadcloth Burberry 	
Applicable models	Remarks		
<p>DLU-450 DLU-450-4</p>	<ul style="list-style-type: none"> (1) Use a standard needle. (2) Relation of the walking foot to the presser foot. 		

Standard set (Type E)

Throat plate	Feed dog	Presser foot (asm.)	Walking foot
B1109-450-D0B	B1613-450-E00	B1524-450-EA0	B3026-450-E00

Alternative components

--	--	--	--

Advantages

- (1) For medium-heavy weight materials.
- (2) Suitable for sewing the fabric which tends to slip when sewing.
- (3) Suitable for sewing a long and straight seam.

Typical garment

Quilting coat
Heavy weight overcoat
(comparatively long fiber)

Typical fabrics

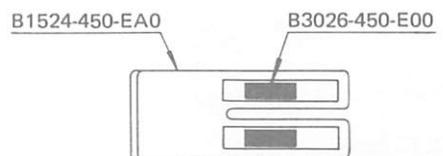
Mossy (man-made fur)
Quiltings

Applicable models

DLU-450
DLU-450-4

Remarks

- (1) Use a standard or slightly thicker needle.
- (2) Relation of the walking foot to the presser foot.



Standard set (Type G)			
Throat plate	Feed dog	Presser foot (asm.)	Walking foot
B1109-450-G0B	B1613-450-G00	B1524-450-GA0	B3026-450-G00
Alternative components			
Advantages	Typical garment	Typical fabrics	
<ul style="list-style-type: none"> (1) For sewing the edge of workpiece. (2) Suitable for top stitches. 	Sew edge or decorative stitch on collar and cuffs of shirt	Polyester/cotton blend broadcloth	
Applicable models	Remarks		
DLU-450 DLU-450-4	<ul style="list-style-type: none"> (1) Jointly use a guide (MAT-10301HAG) (2) Use a needle slightly thinner than the standard. (3) Relation of the walking foot to the presser foot. 		

Standard set (Type J)			
Throat plate	Feed dog	Presser foot (asm.)	Walking foot
B1109-450-J00-A	B1613-450-J00-A	B1524-450-JA0-A	B3026-450-J00
Alternative components			
Advantages	Typical garment	Typical fabrics	
<p>(1) Sew left zipper to garment fabric. (2) For medium-heavy weight materials.</p>	Sportswear Jumper	Double jersey	
Applicable models	Remarks		
DLU-450 DLU-450-4	<p>(1) Sew left zipper to garment fabric. (2) Relation of the walking foot to the presser foot.</p>		

Standard set (Type P)

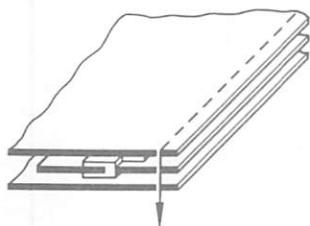
Throat plate B1109-450-P00	Feed dog B1613-450-P00	Presser foot (asm.) B1524-450-PA0	Walking foot B3026-450-P00

Alternative components

--	--	--	--

Advantages

- (1) Sew right zipper to the garment fabric.
- (2) For medium-heavy weight materials.



Typical garment

Sportswear
Jumper

Typical fabrics

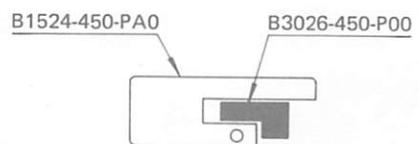
Double jersey

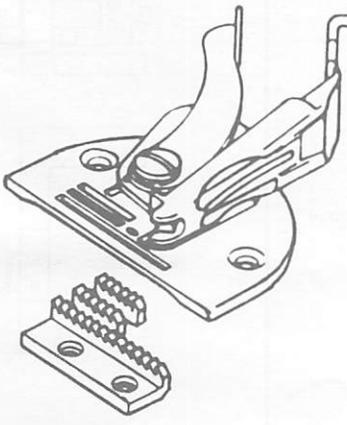
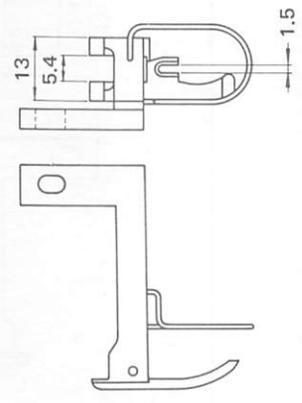
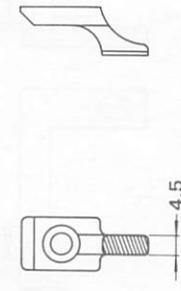
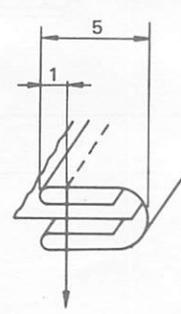
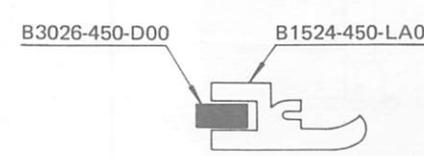
Applicable models

DLU-450
DLU-450-4

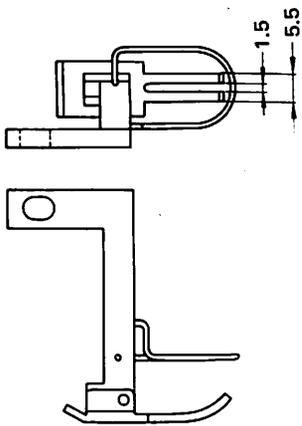
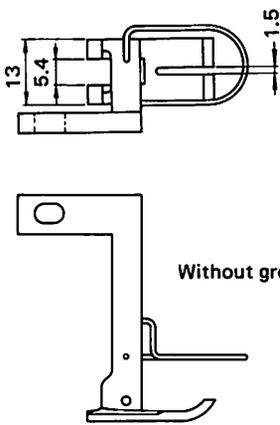
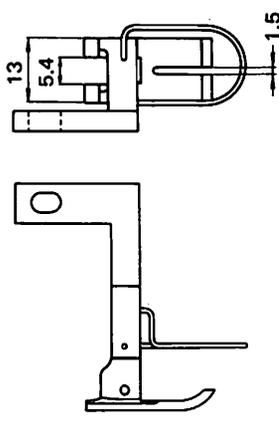
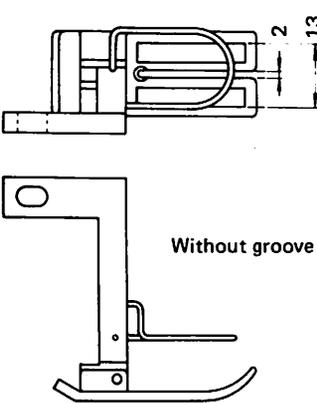
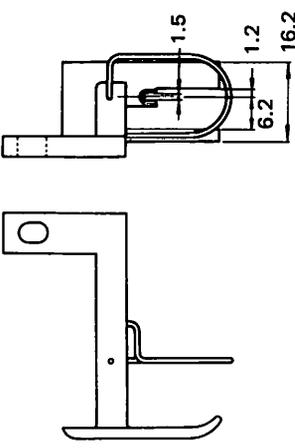
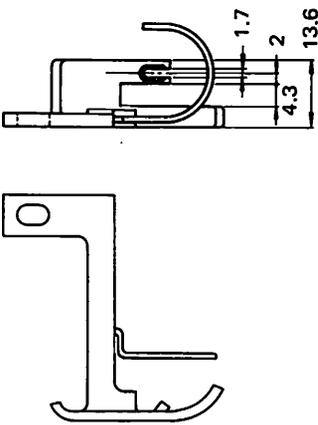
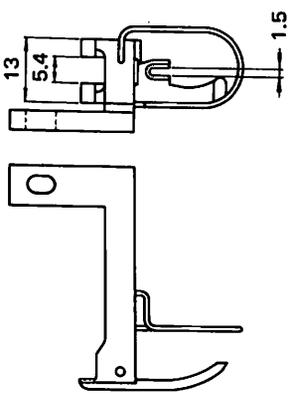
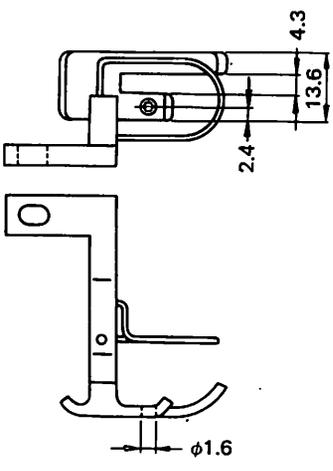
Remarks

- (1) Use a standard needle.
- (2) Relation of the walking foot to the presser foot.



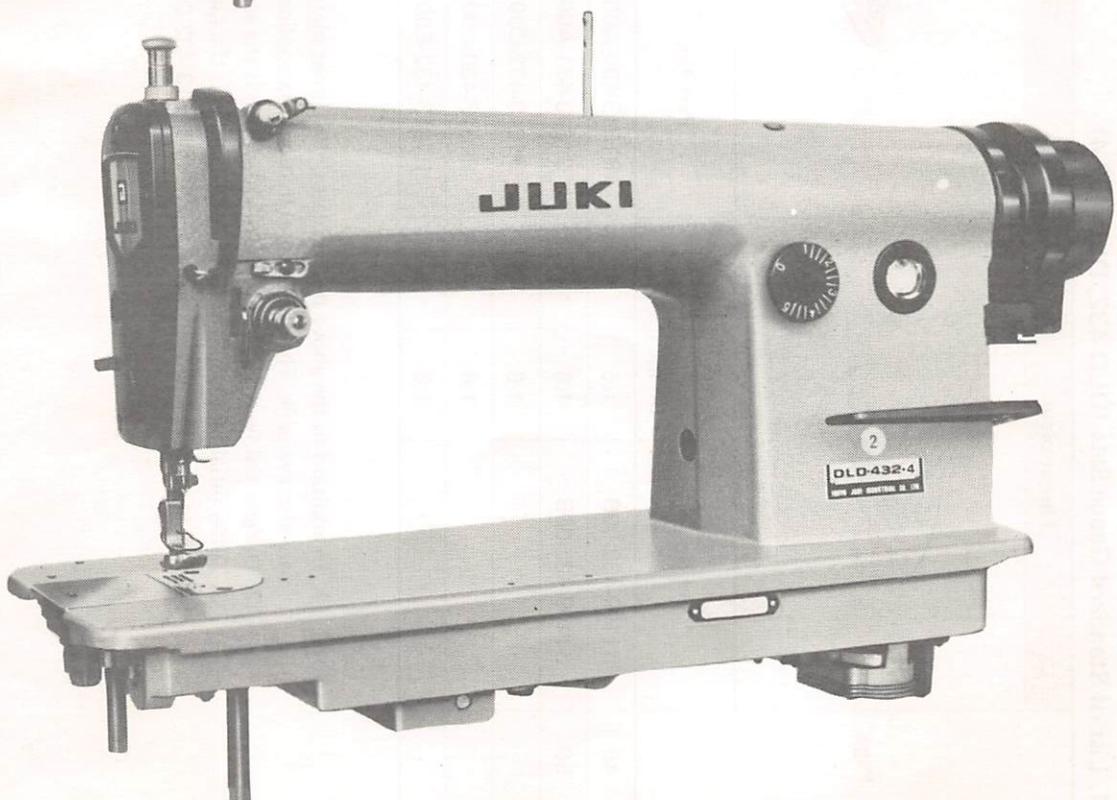
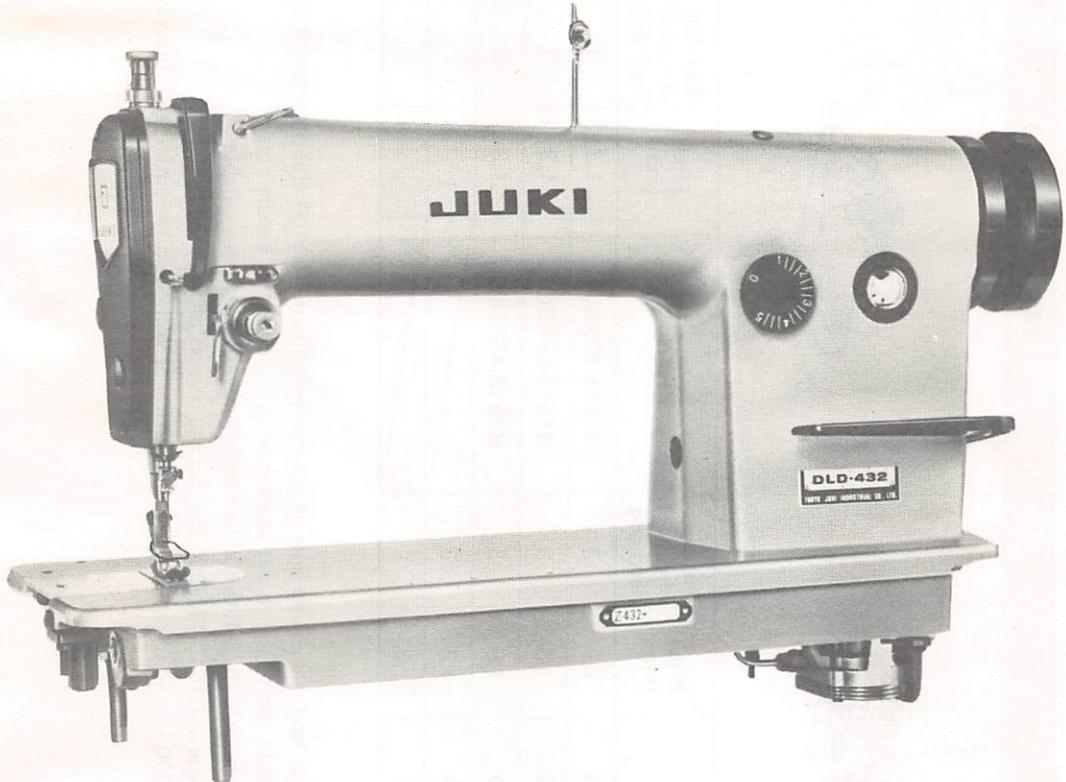
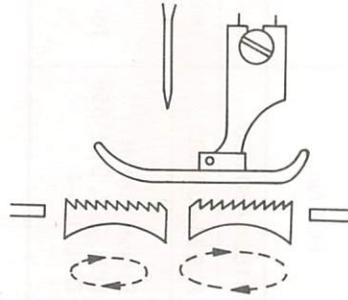
Standard set (Type L)		
Binder (asm.)	Presser foot (asm.)	Walking foot
MAT-10901 NAB	B1524-450-LA0	B3026-450-D00
		
Alternative components		
Advantages	Typical garment	Typical fabrics
<p>(1) For binding. (2) For medium-heavy weight materials.</p>  <p>Tape width : 20mm Finished width : 5mm</p>	<p>Bind the edges of pajama Apron Men's wear Ladies' wear Sportswear etc. and other garments</p>	<p>Knit fabric General cloths</p>
Applicable models	Remarks	
<p>DLU-450 DLU-450-4</p> 	<p>(1) Use a standard needle. (2) The throat plate and feed dog are included in the complete set of a binder. (asm.) (3) Relation of the walking foot to the presser foot.</p> 	

3. Drawing of each Presser Foot (asm.)

B1524-450-0A0-A	D1524-450-BAD	B1524-450-DA0
 <p>1.5 5.5</p>	 <p>13 5.4 1.5</p> <p>Without groove</p>	 <p>13 5.4 1.5</p>
B1524-450-EA0	B1524-450-GA0	B1524-450-JA0-A
 <p>2 13</p> <p>Without groove</p>	 <p>1.5 1.2 16.2 6.2</p>	 <p>1.7 2 13.6 4.3</p>
B1524-450-LA0	B1524-450-PA0	
 <p>13 5.4 1.5</p>	 <p>4.3 13.6 2.4 φ1.6</p>	

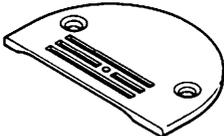
IV. DLD-432, DLD-432-4

1-Needle, Differential Feed, Lockstitch Machine



From the library of: Superior Sewing Machine & Supply LLC

1. List of Standard Gauge Sets (DLD-432, DLD-432-4)

Page	Throat plate			Feed dog			Differential feed dog			Presser foot (asm.)	Remarks
	Part No.	Needle hole (mm)	Number of slits	Part No.	Pitch (mm)	Number of row of feed dog	Part No.	Pitch (mm)	Number of row of feed dog	Part No.	
											
49	B1109-432-00B	1.6	4	B1613-430-A00	1.3	3	B1613-430-B00	1.3	3	B1524-430-0B0	for stretching
50	B1109-432-00B	1.6	4	B1613-431-A00	1.3	3	B1613-431-B00	1.3	3	B1524-431-0B0	for gathering
	"	1.6	4	B1613-432-C00	1.5	3	B1613-432-D00	1.3	3	Presser foot of DDL-227, DDL-555 DDL-555-4	for plain sewing
	"	1.6	4	B1613-430-C00	1.3	3					
	"	1.6	4	B1613-432-E00	1.5	4					

- (Note)
1. In addition to the above throat plates, the throat plates having a needle hole of 1.9 mm in diameter (B1109-430-00B) and 1.2 mm in diameter (B1109-432-00C) are also available. The above combinations are applicable also to the throat plates having the different needle holes.
 2. Differential feed dog B1613-432-A00, which is the same as B1613-430-B00 but has the reverse teeth, is available.
 3. Differential feed dog B1613-432-B00, which is the same as B1613-431-B00 but has the reverse teeth, is available.
 4. Gauge set with the differential feed dog B1613-432-D00 is used to make normal lockstitches without differential feed. (maximum feed pitch: 2 mm)

2. Classification of Gauge Sets (Advantages, Applications)

Standard set (For stretching)			
Throat plate	Feed dog	Differential feed dog	Presser foot (asm.)
B1109-432-00B	B1613-430-A00	B1613-430-B00	For mach. without wiper B1524-430-0B0 For mach. with wiper B1524-430-0BA
Alternative components			
B1109-430-00B(ϕ 1.9) B1109-432-00C(ϕ 1.2)		B1613-432-A00 (Reverse teeth)	For mach. without wiper B1524-432-0B0 For mach. with wiper B1524-432-0BA
Advantages of stretching		Applicable models	
(1) Effective to prevent the fabric from puckering. (2) Suitable for sewing the stretching fabric.		DLD-432 DLD-432-4	

Work Classification by Needle Hole of Throat Plate

Needle hole	Material	Class of work	Typical fabric	Remarks
ϕ 1.9	Medium-heavy weight	Runstitch of Men's wear Ladies' wear Children's wear Swimsuit Sweater, etc.	Jersey Double jersey Woolen fabric	Use a standard needle.
ϕ 1.6	Comparatively light weight	Runstitch of Sportswear Men's wear Ladies' wear Children's wear, etc.	Knit fabric Woolen gabardine Broadcloth	Use a standard or slightly thinner needle.
ϕ 1.2	Light weight (Effective to prevent stitch skipping)	Runstitch of Sportswear, Shirt, Blouse, etc.	Broadcloth Georgette Crepe de chine Knit fabric General cloths	Use a needle thinner than the standard.

Standard set (For gathering)

Throat plate	Feed dog	Differential feed dog	Presser foot (asm.)
B1109-432-00B	B1613-431-A00	B1613-431-B00	For mach. without wiper B1524-431-0B0 For mach. with wiper B1524-431-0BA

Alternative components

B1109-430-00B (φ1.9) B1109-432-00C (φ1.2)			
--	--	--	--

Advantages of stretching

- (1) For gathering and shirring.
- (2) Suitable for sewing the stretching fabric.

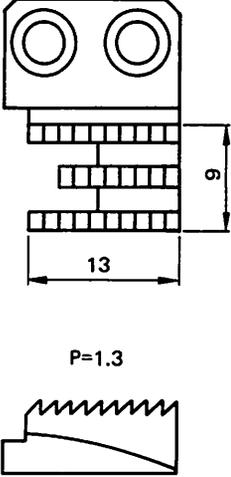
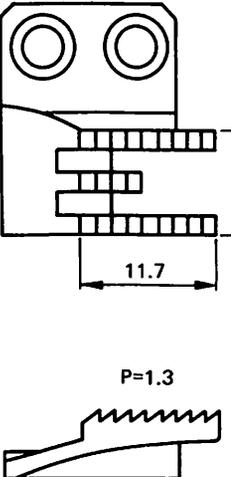
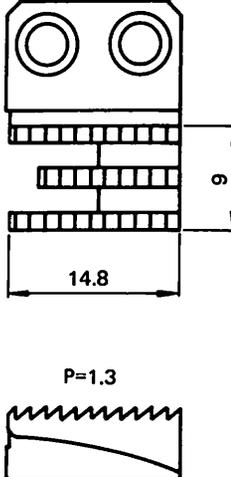
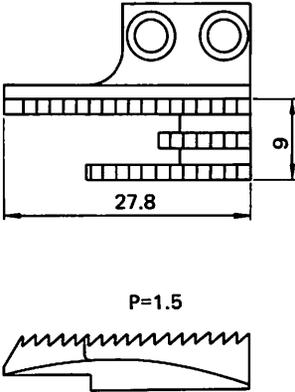
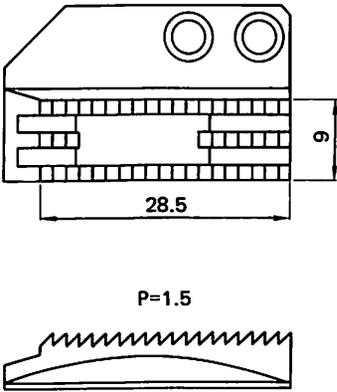
Applicable models

DLD-432
DLD-432-4

Work Classification by Needle hole

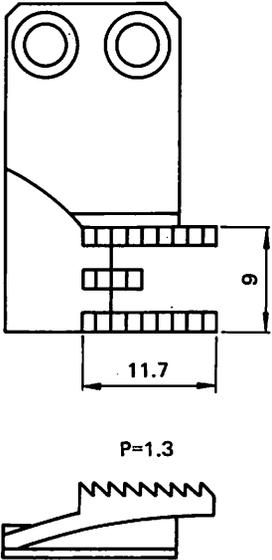
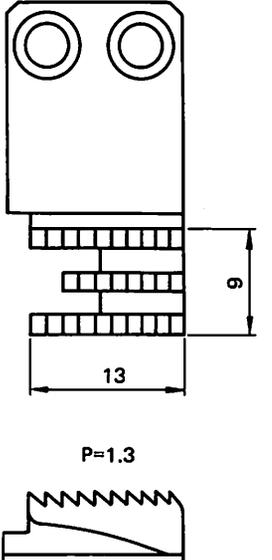
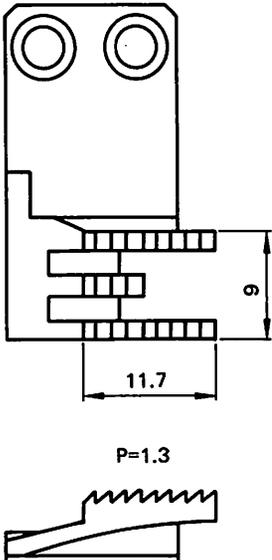
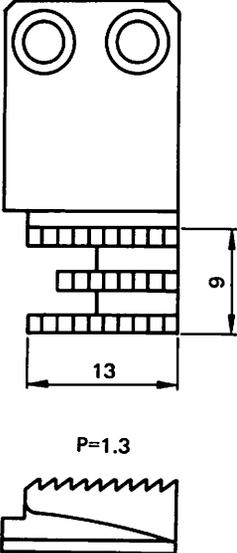
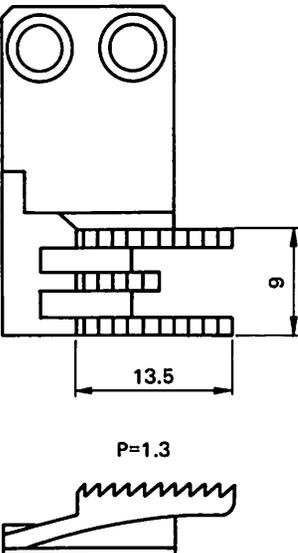
Needle hole	Material	Class of work	Typical fabric	Remarks
φ1.9	(1) Medium-heavy weight (2) Effective to prevent the needle from breaking the fabric.	Gathering the dress, apron, etc. Runstitch of Men's wear Ladies' wear Children's wear, etc.	Double jersey Gabardine	Use a standard needle.
φ1.6	Comparatively light weight	Gather curtain or bed cover, shir Children's wear, apron, sportswear etc.	Broadcloth Jersey Knit fabric	Use a standard or thinner needle.
φ1.2	(1) Light weight (2) Effective to prevent stitch skipping	Decorative stitches on slip, blouse etc.	Broadcloth Georgette Crepe de chine Knit fabric	Use a thin needle.

3. Drawing of Each Feed Dog

B1613-430-A00	B1613-431-A00	B1613-432-C00
 <p>P=1.3</p>	 <p>P=1.3</p>	 <p>P=1.3</p>
B1613-430-C00	B1613-432-E00	
 <p>P=1.5</p>	 <p>P=1.5</p>	

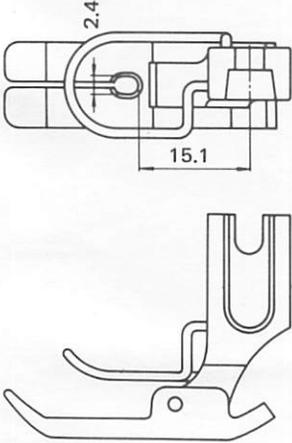
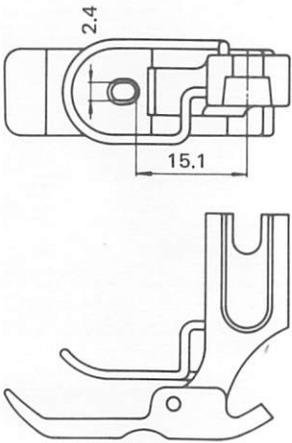
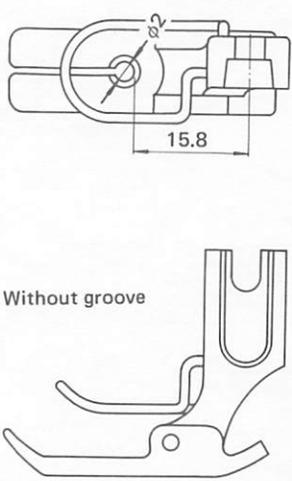
- (Note)
1. Feed dog B1613-432-C00 can be used for the normal lockstitch without providing a differential feed.
(Maximum feed pitch : 2 mm)
 2. Feed dogs B1613-430-C00 and B1613-432-E00 are not for the differential feed.

4. Drawing of each Differential Feed Dog

B1613-430-B00	B1613-431-B00	B1613-432-A00
		
B1613-432-B00	B1613-432-D00	
		

- (Note)
1. Differential feed dog B1613-432-A00 has the reverse teeth for stretching.
 2. Differential feed dog B1613-432-B00 has the reverse teeth for gathering.
 3. Differential feed dog B1613-432-D00 can be used for the normal lockstitch without differential feed.
(Maximum feed pitch : 2 mm)

5. Drawing of Each Presser Foot (asm.)

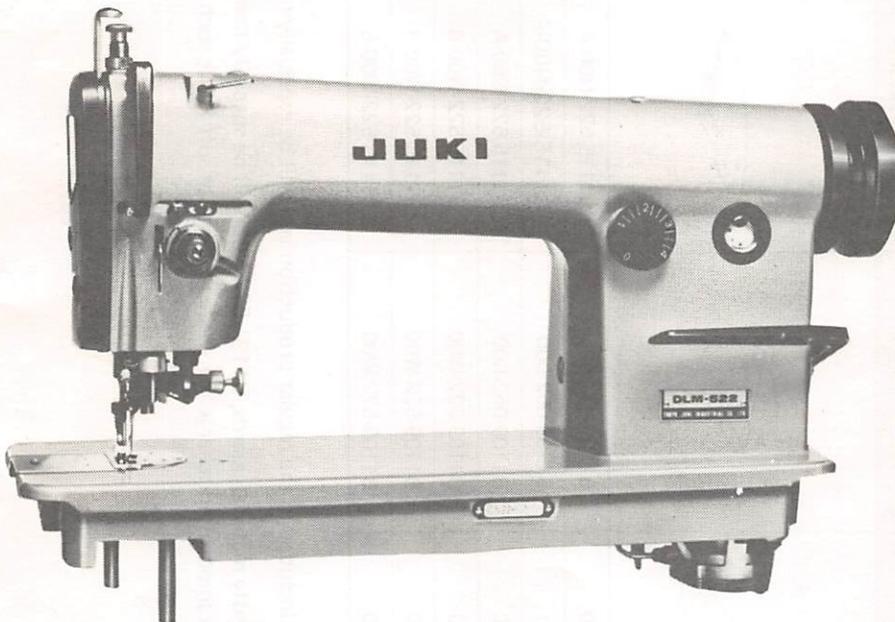
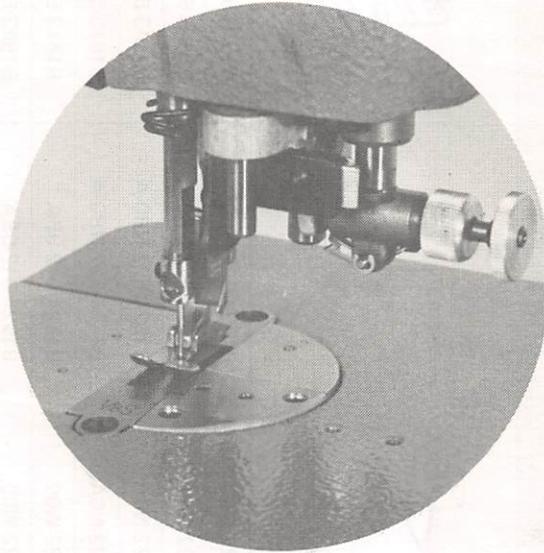
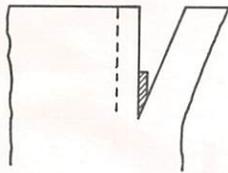
B1524-430-0B0	B1524-431-0B0	B1524-432-0B0
		

Index of the Presser Foot with or without Finger Guard

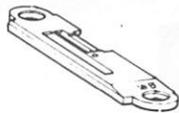
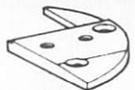
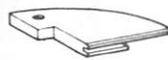
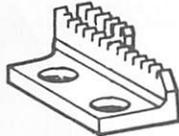
Presser foot (asm.) with finger guard		Presser foot (asm.) without finger guard	Remarks
For machine without wiper	For machine with wiper		
			Presser foot (asm.) for stretching
B1524-431-0B0	B1524-431-0BA	B1524-431-0A0	Presser foot (asm.) for gathering
B1524-432-0B0	B1524-432-0BA	B1524-432-0A0	Presser foot (asm.) for stretching and for synthetic thread

V. DLM-522

1-Needle, Lockstitch Machine with Built-in **Trimming Knife** (Center Type)

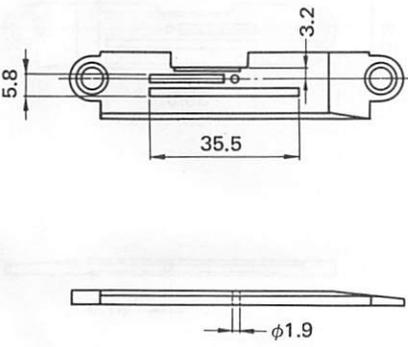
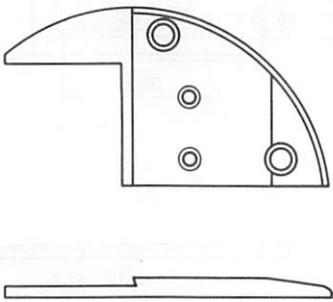
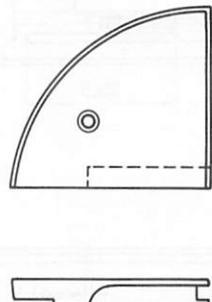
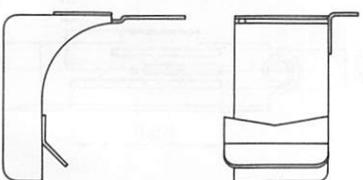
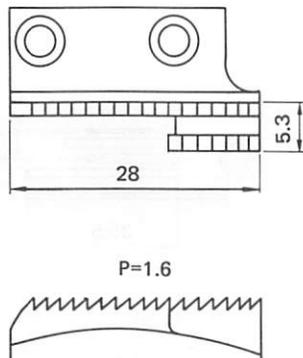
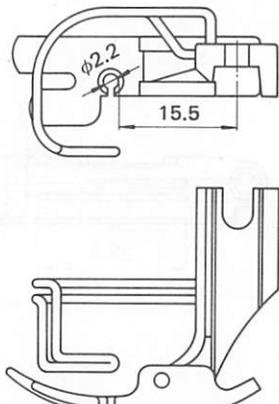


1. List of Standard Gauge Sets (DLM-522)

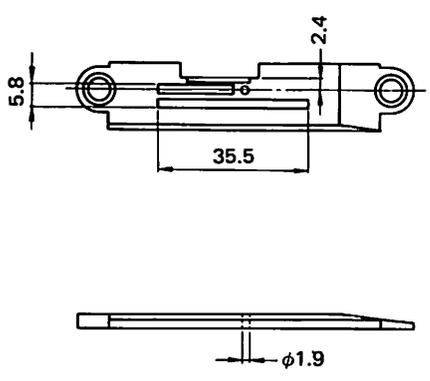
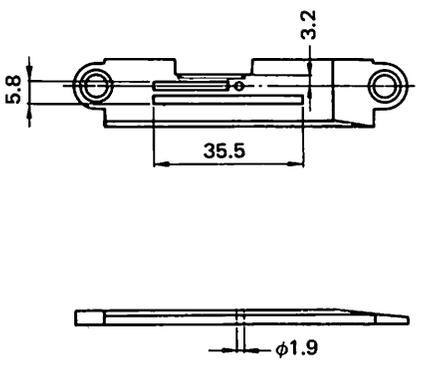
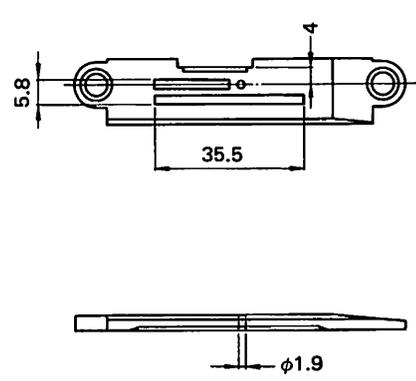
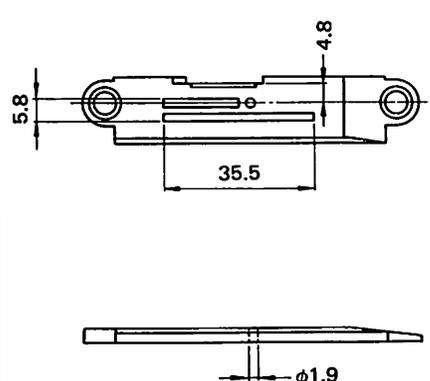
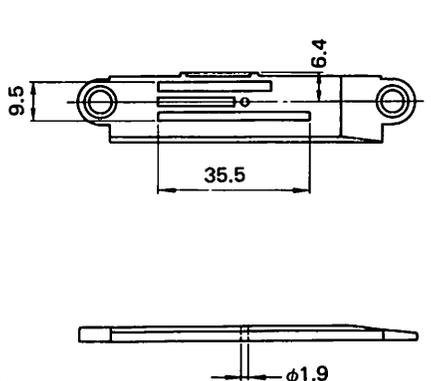
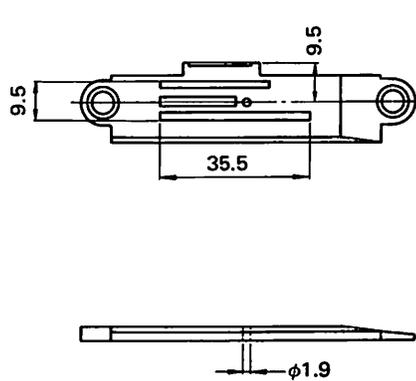
Size (Trimming margin)	Gauge plate	Throat plate	Throat plate open cover	Waste material guard	Presser foot (with finger guard) asm.	Feed dog	Remarks
							
3/32" (2.4 m/m)	B1190-522-X00	B1109-052-000	B1115-522-N00-A	**B1191-522-N0A	B1524-522-NB0-A	B1613-522-N00	
1/8" (3.2 m/m)	B1190-522-S00	B1109-052-000	B1115-522-N00-A	B1191-522-N0A	B1524-522-NB0-A	B1613-522-N00	(Standard)
*5/32" (4 m/m)	B1190-522-Y00	B1109-052-000	B1115-522-N00-A	B1191-522-N0A	B1524-522-NB0-A	B1613-522-N00	
3/16" (4.8 m/m)	B1190-522-T00	B1109-522-W00	B1115-522-W00-B	B1191-522-N0A	B1524-522-NB0-A	B1613-522-N00	
1/4" (6.4 m/m)	B1190-522-U00	B1109-522-W00	B1115-522-W00-B	B1191-522-W00	B1524-012-0BA	B1613-522-W00	
3/8" (9.5 m/m)	B1190-522-V00	B1109-522-W00	B1115-522-W00-B	B1191-522-W00	B1524-012-0BA	B1613-522-W00	

- (Note) 1. * : This item is not included in the regular production and will be especially manufactured upon request.
 2. ** : Besides these waste material guards, B1191-522-N0B will be specially manufactured upon request.
 This will help to smoothly discharge the waste material of soft fabric such as tricot.

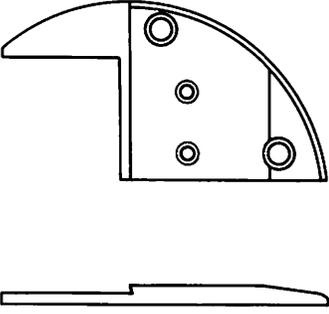
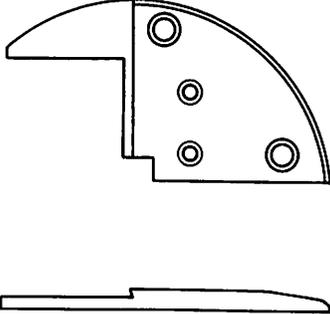
2. Classification of Gauge Sets

Standard set		
Gauge plate B1190-522-S00	Throat plate B1109-052-000	Throat plate open cover B1115-522-N00-A
		
Waste material guard B1191-522-N0A	Feed dog B1613-522-N00	Presser foot (asm.) B1524-522-NB0-A
		
Advantages	Typical garment	Typical fabrics
(1) Suitable for making runstitch with even seam allowance.	Runstitch of collar and cuffs of shirt Pocket and pocket flap of men's and ladies' wear raincoat	Jersey Coatings Broadcloth Georgette Woollen fabric
Applicable models	Remarks	
DLM-522	(1) The above-mentioned combinations are only for the size (trimming margin) 3.2 m/m (1/8"). Refer to the List of Standard Gauge Sets for other sizes. (2) Use a standard needle. (3) Set the presser foot to the standard pressing force.	

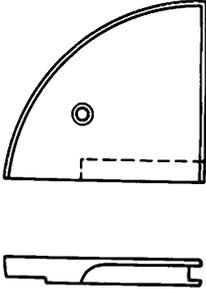
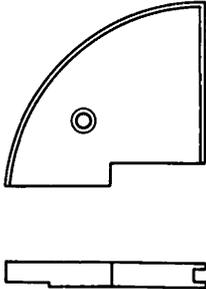
3. Drawing of Each Gauge Plate

B1190-522-X00	B1190-522-S00	B1190-522-Y00
		
B1190-522-T00	B1190-522-U00	B1190-522-V00
		

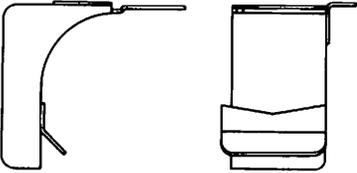
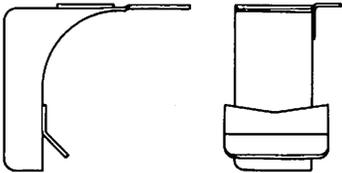
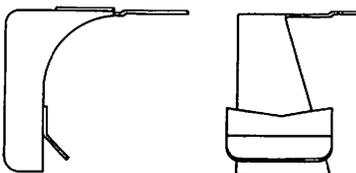
4. Drawing of Each Throat Plate

B1109-052-000	B1109-522-W00	
		

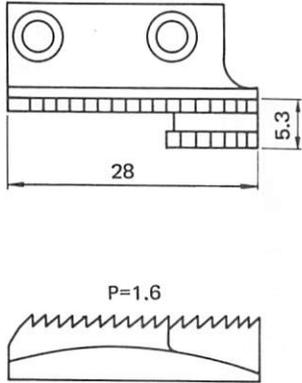
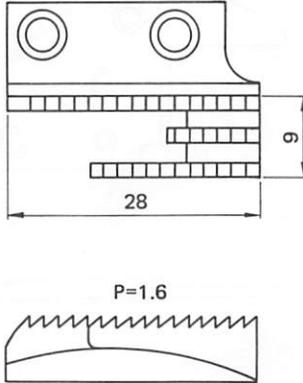
Drawing of Each Throat Plate Open Cover

B1115-522-N00-A	B1115-522-W00-B	
		

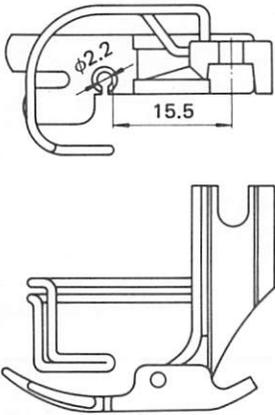
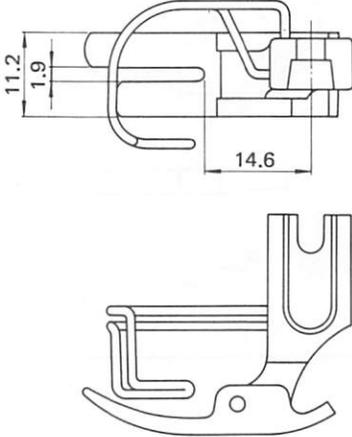
Drawing of Each Waste Material Guard

B1191-522-N0A	B1191-522-W00	B1191-522-N0B
		

5. Drawing of Each Feed Dog

B1613-522-N00	B1613-522-W00	
		

Drawing of Each Presser Foot (asm.)

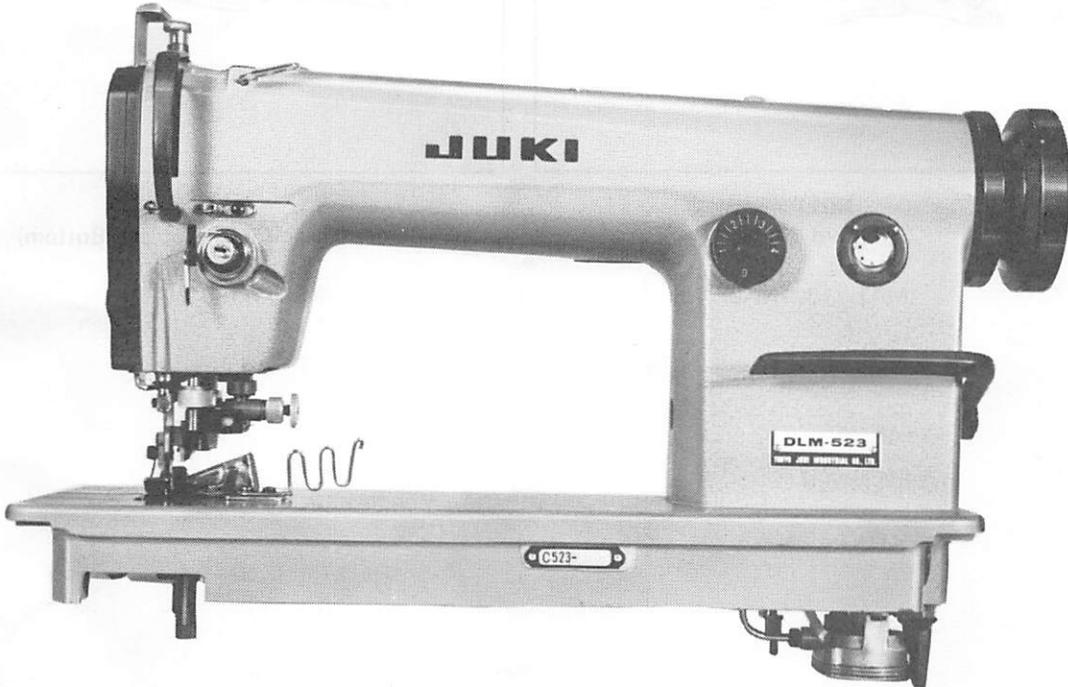
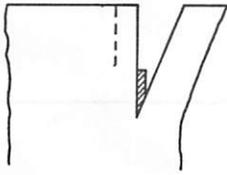
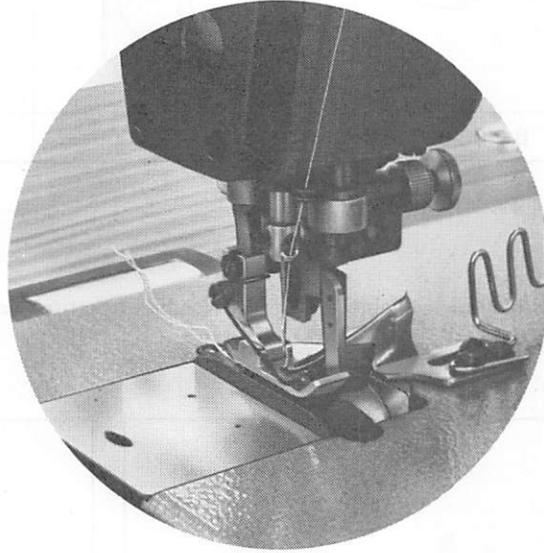
B1524-522-NB0-A	B1524-012-0BA	
		

Index of the Presser Foot with or without Finger Guard

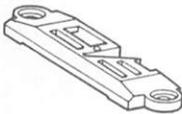
Presser foot (asm.) with finger guard	Presser foot (asm.) without finger guard
	
B1524-522-NB0-A	B1524-522-NA0-A
B1524-012-0BA	B1524-012-0A0

VI. DLM-523/N011, DLM-523/N015

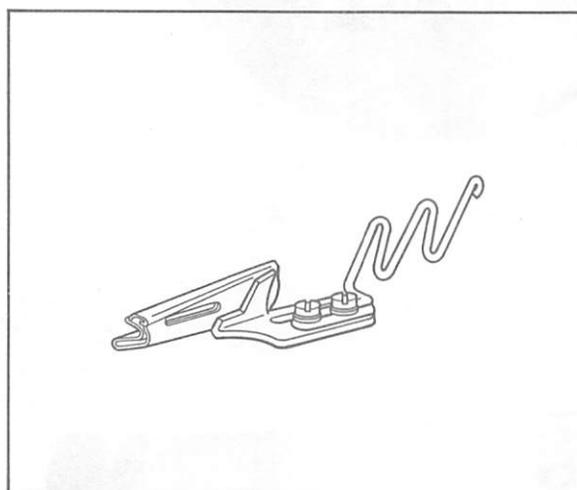
1-Needle, Lockstitch Machine with Built-in Trimming Knife (Front Type) with Binder



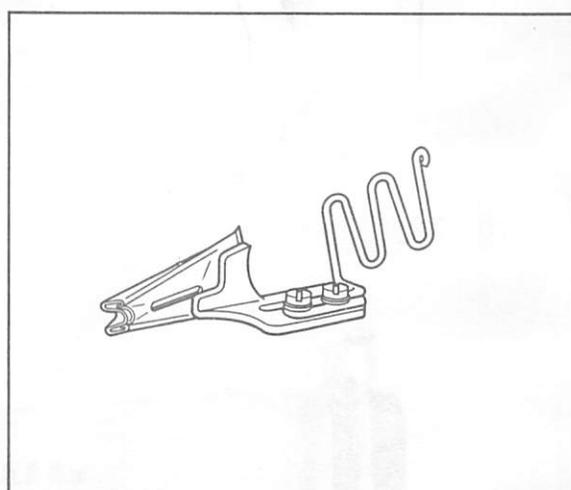
1. List of Standard Gauge Sets (DLM-523/N011, DLM-523/N015)

Gauge plate	Throat plate	Waste material guard	Presser foot	Feed dog
				
B1190-523-000	B1109-523-000	B1191-523-000	B1524-523-0A0	B1613-523-000

(Note) Two types of binder are available for these 1-Needle Lockstitch Sewing Machines with Built-in Trimming Knife (Front type)



N011
Semi-fold Binder
(MAT-11801NA0)



N015
Binder (Clean Finish Top and Bottom)
(MAT-11901NA0)

2. Classification of Gauge Sets

Standard set			
Gauge plate	Throat plate	Waste material guard	
B1190-523-000	B1109-523-000	B1191-523-000	
Feed dog	Presser foot (asm.)	Binder	
B1613-523-000	B1524-523-0A0	N011	N015
		<p>Tape width : 20 mm Finish width : 5 mm</p>	<p>Tape width : 20 mm Finish width : 5 mm</p>
Advantages		Typical garment	Typical fabrics
<p>N011: Edge of the garment is cut, bound with a cotton bias tape into the form of semi-fold binding and stitched. For piping or making decorative stitches on back center seam.</p> <p>N015: The same as N011, but the edges are bound with clean finish top and bottom.</p>		<p>Bind back center seam and pipe bottom on men's wear, ladies' wear, coat</p>	<p>Woollen fabric Gabardine Coating</p>
Applicable models		Remarks	
<p>DLM-523</p>		<p>(1) Model DLM-523 can not be converted to DLM-522. (2) Use a standard needle. (3) Set the presser foot to the standard pressing force.</p>	

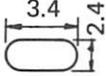
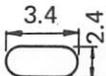
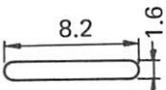
ADDENDUM 1

SUBCLASS MODELS OF DDL-227, DDL-555 and DDL-555-4

Subclass	Application	Needle bar stroke (mm)	Throat plate		Remarks
			Needle hole (mm)	Number of slits	
Standard	Medium-heavy weight	30.5	φ 1.9	3	DDL-227, DDL-555
			φ 1.6	4	DDL-555-4
Type A	Light weight	29	φ 1.6	4	
Type W	Shirting	29	φ 1.3	4	(DDL-227 and DDL-555 only)
Type H	Heavy weight	35	φ 2.4	3	(Wiper is not equipped on a machine with thread trimmer.)
Type M	Medium-heavy weight for long stitch (Maximum stitch length: 5 mm)	30.5	φ 1.9	3	(DDL-227 only)

ADDENDUM 2

SUBCLASS MODELS OF DLN-415 and DLN-415-4

Subclass	Material	Needle bar stroke (mm)	Feed dog	Throat plate	Remarks
			Needle hole (mm)	Number of slits	
Standard	Midium-heavy weight	30.5	φ 1.9	3	Maximum stitch length: 4 mm (5/32")
Type H	Heavy weight	30.5		3	Maximum stitch length: 4.5 mm (11/64")
Type L	Coarse feed	30.5		3	DLN-415L only. Maximum stitch length: 6 mm (15/64")
				3	DLN-415-4 only for EUROPE. Stitch length: Mini. 3 mm (1/8") ~ Max. 6 mm (15/64")
			φ 1.5	3	

JUKI®

TOKYO JUKI INDUSTRIAL CO., LTD.

Address : 23-3, Kabuki-cho 1-chome, Shinjuku-ku,

Tokyo 160, Japan

Cable : JUKI TOKYO

Telex : 22967, 232-2301

Phone : 03 (205) 1188, 1189, 1190