

Instruction manual
Manuel d'instructions
Brugsanvisning
Bedienungsanleitung

JUKI

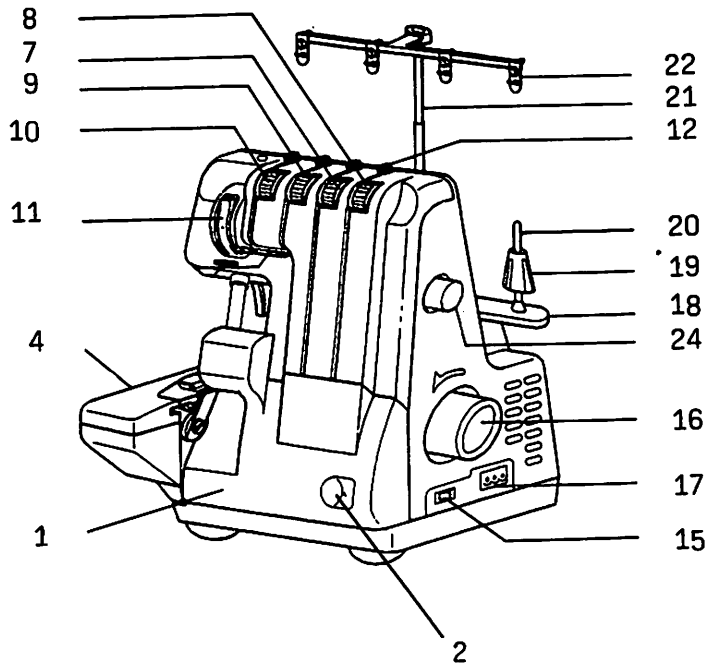
MO-613;-634;634D

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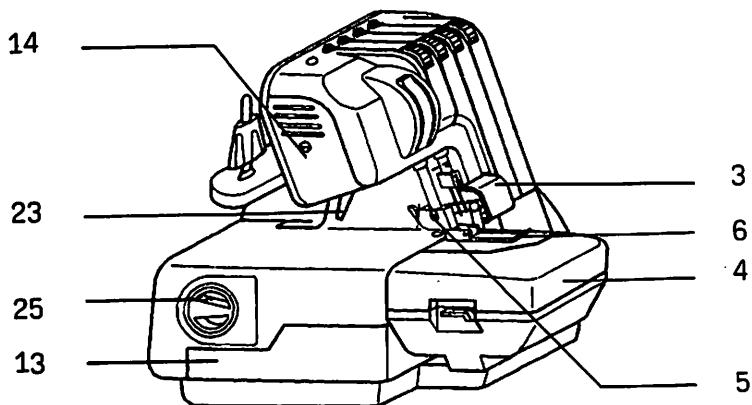
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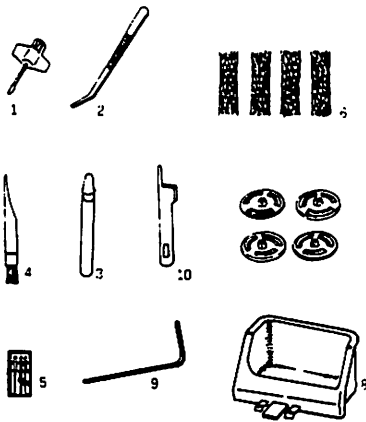
Details of the machine

Details of the machine



- 1 Looper cover
- 2 Looper cover opening indent
- 3 Knife guard
- 4 Cloth plate
- 5 Stitch plate
- 6 Presser foot
- 7 Lower looper tension dial
- 8 Upper looper tension dial
- 9 Right needle tension dial
- 10 Left needle tension dial
- 11 Thread take up cover
- 12 Thread guide plate
- 13 Accessory box
- 14 Bulb cover
- 15 Power/light switch
- 16 Handwheel
- 17 Machine socket
- 18 Thread stand
- 19 Anti-vibration cone
- 20 Spool holder pin
- 21 Retractable support rod
- 22 Open thread guide
- 23 Presser foot lifter
- 24 Stitch length dial
- 25 Differential feed dial





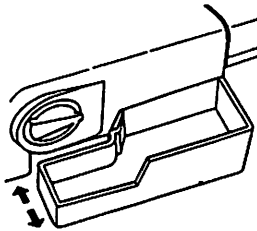
Preparing the machine

Accessories

- 1 Screwdriver
- 2 Tweezers
- 3 Oiler
- 4 Cleaning brush
- 5 Set of needles HAx1
- 6 Net
- 7 Spool caps
- 8 Waste collector
- 9 Hexagon wrench
- 10 Upper knife

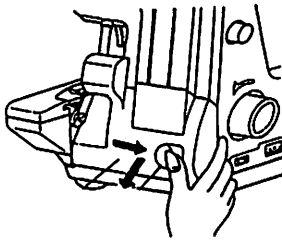
Accessory Box

All standard accessories are stored in the box. Pull out to open, push in to close.



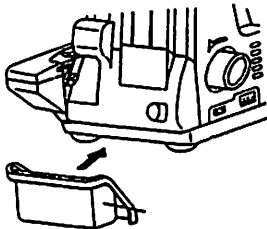
Looper cover

To open push to the right with your thumb in the indent and tilt towards you. To close push it up and the cover engages automatically.



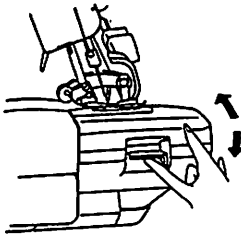
Waste collector

Fabric waste will be collected as you sew. Push the waste collector under the front of the machine and slightly to the left towards the cloth plate cover.



Cloth plate cover

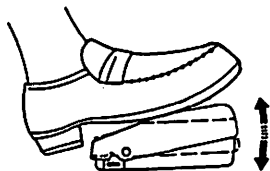
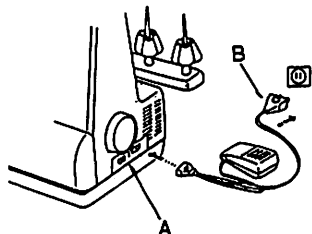
To open push the lever up. To close push the cover up to the right, it snaps into position automatically.



Preparing the machine

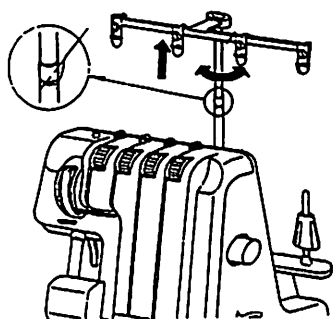
Attaching the foot control

Plug foot control into machine socket (A) and then into main socket (B).



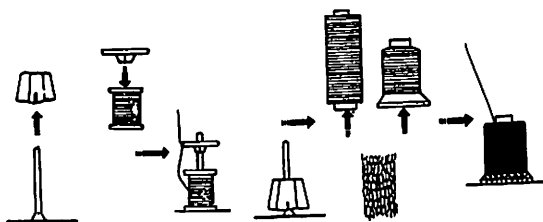
Sewing speed

The sewing speed can be adjusted by increasing or decreasing the pressure on the foot control (C).



Assembling the thread stand

Raise the support rod fully, turning slightly until the positioning catches engage.



Thread cones

The anti-vibration cone should be used with the wider edge to the bottom on the spool holder pin when sewing with cones. When using household spools remove the anti-vibration cones. Place spool on spool holder pins and push the spool caps on. If threads slip and get twisted, cover the spools with the nets supplied in the accessory box.

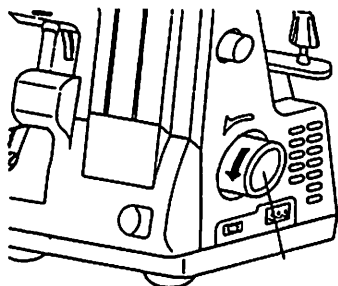


Power/light switch

The power switch is conveniently placed on the handwheel side of the machine.

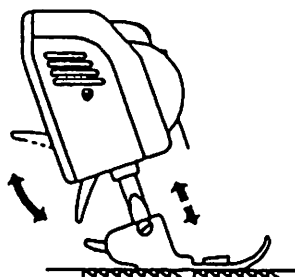
"I" - ON
"O" - OFF

Using the machine



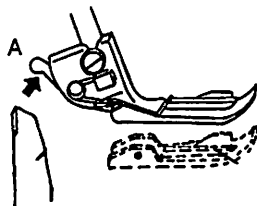
Handwheel

The handwheel turns counterclockwise.



Presser foot lifter

To raise the presser foot, raise the lever on the rear of the machine until it engages.



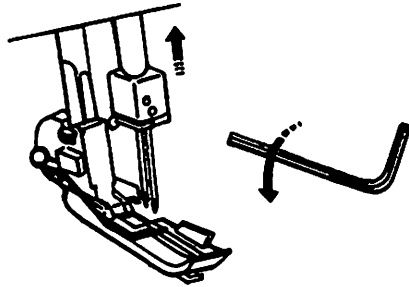
Changing the presser foot

- Switch the machine off "O".
- Raise the presser foot.

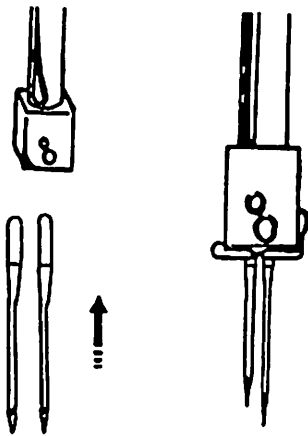
Press the catch (A) to release the presser foot from the clamp. Raise the presser foot lifter to the highest position and remove the presser foot sole to the left. To attach the presser foot sole, place it under the shaft. The groove in the shaft should line up exactly with the presser foot pin. Lower the shank and the presser foot will engage automatically.

Using the machine

Inserting needles

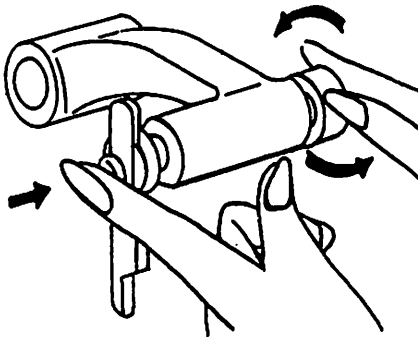


- Switch the machine off "O".
Disconnect machine from electricity supply.
- Turn the handwheel until needles are fully raised.
- Lower the presser foot.
- Use the hexagon wrench to loosen the needle setscrew. Remove needle.
- Insert the needle flat side towards the back, as far as possible into the needle clamp. Tighten the screw.
- The left needle is set higher than the right needle.



Raising the upper knife

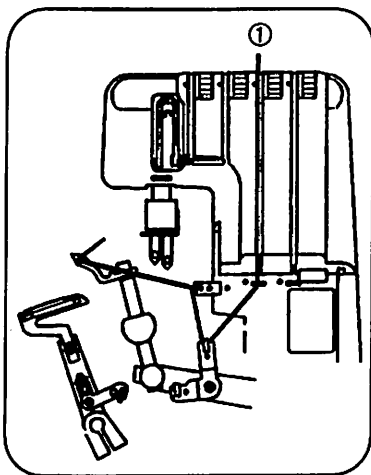
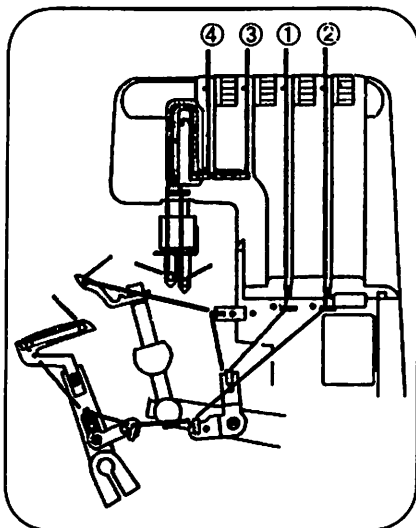
- Turn the handwheel to raise the needles.
- Open the looper cover.
- Press the upper knife holder to the right. Turn the knob clockwise until the knife engages.
- Close the looper cover.



To lower the upper knife:

- Turn the knob anti-clockwise. The knife snaps automatically into its lower position. Close the looper cover.

Threading



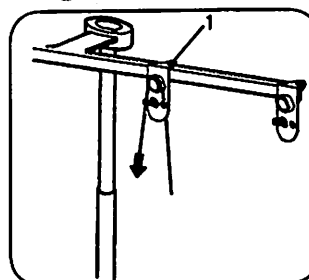
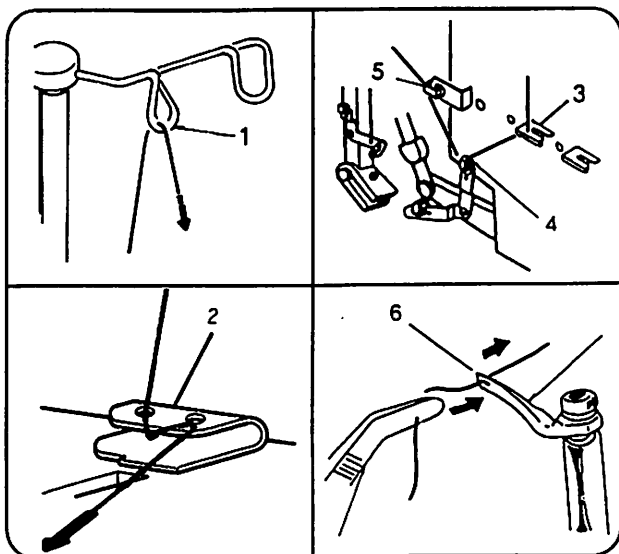
Threading / Preparation

- Disconnect machine from electricity supply.
- Support rod with thread guide must be fully raised.
- Open the looper cover and the cloth plate cover.
- Turn the handwheel towards you until needles are fully raised.

- Thread the machine in the correct sequence.

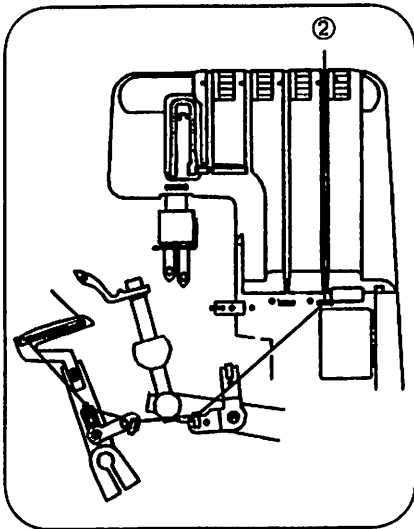
Upper looper (Green)

- Place the spool on the spool holder pin.
- Bring thread up from back to front through guide (1).
- Make s-loop through holes in thread guide bar (2).
- Thread guide (3,4,5)
- Thread looper eye (6)



- For Certain models only
- Pour un certain modèles uniquement
- Kun for visse modeller
- Nur für gewisse Modelle

Threading



Lower looper (red)

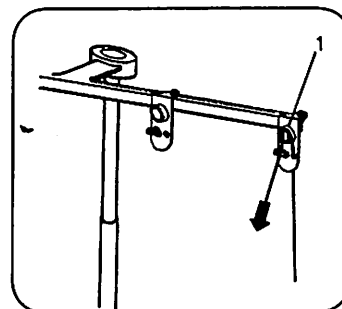
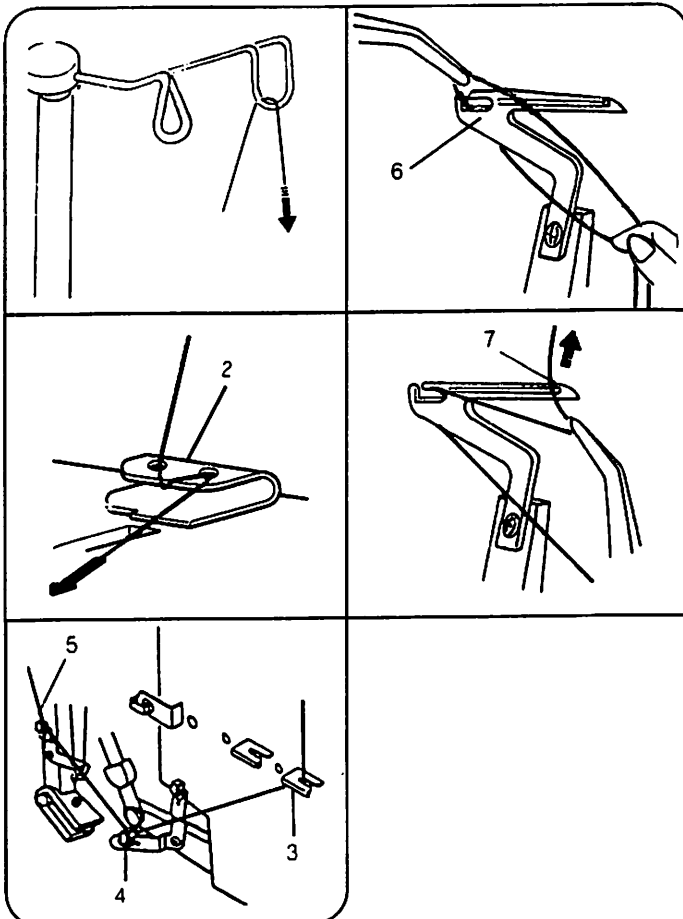
- Place the spool on the spool holder pin.
- Bring thread up from back to front through guide (1).
- Make S-loop through holes in thread guide bar (2).
- Thread guide (3, 4, 5)

FOR CERTAIN MODEL ONLY

*If machine attached with the lower looper automatic threader, then please refer to page 33 continuously and disregard the following instruction.

Turn the handwheel towards you until the lower looper is in the left-most position. Use the tweezers to pull a thread loop (not thread end) from right side to left. Insert the thread into the slit on the lower looper (6). Turn the handwheel towards you until the lower looper is in the rightmost position.

- Thread the looper eye (7) so that the thread lies in the long groove on the lower looper.
- Place thread under presser foot.

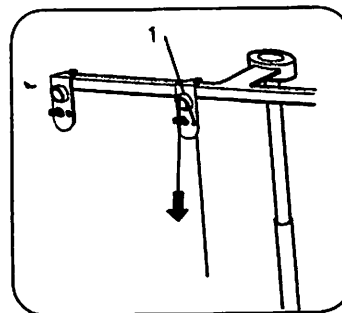
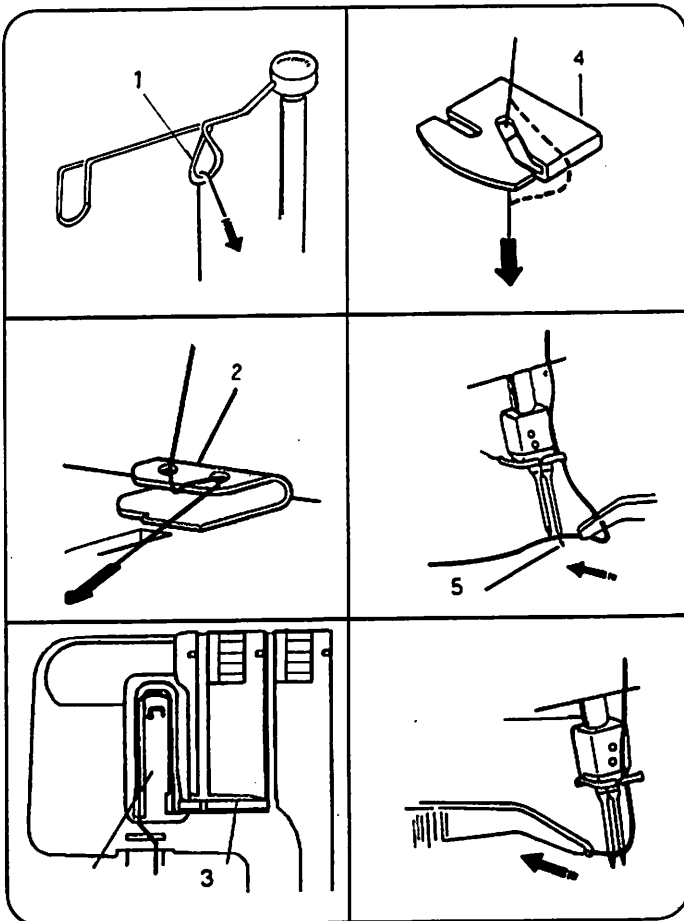
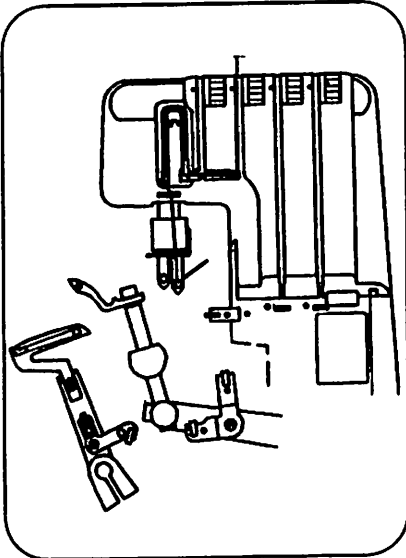


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Threading

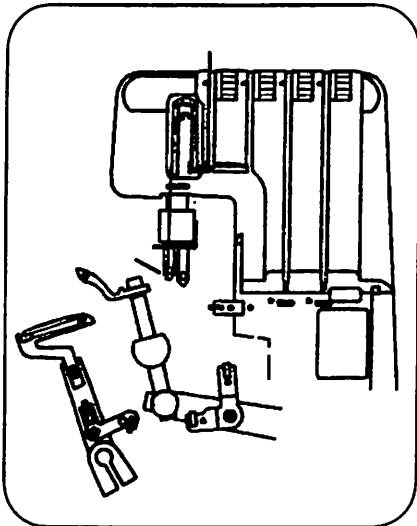
Right needle (Blue)

- Place the spool on the spool holder pin.
- Bring thread up through guide (1).
- Make S-loop through holes in thread guide bar (2).
- Thread guide (3,4)
- Thread right needle eye (5)
- Place thread under presser foot.



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Threading



Left needle (Yellow)

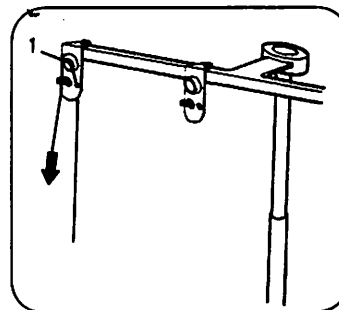
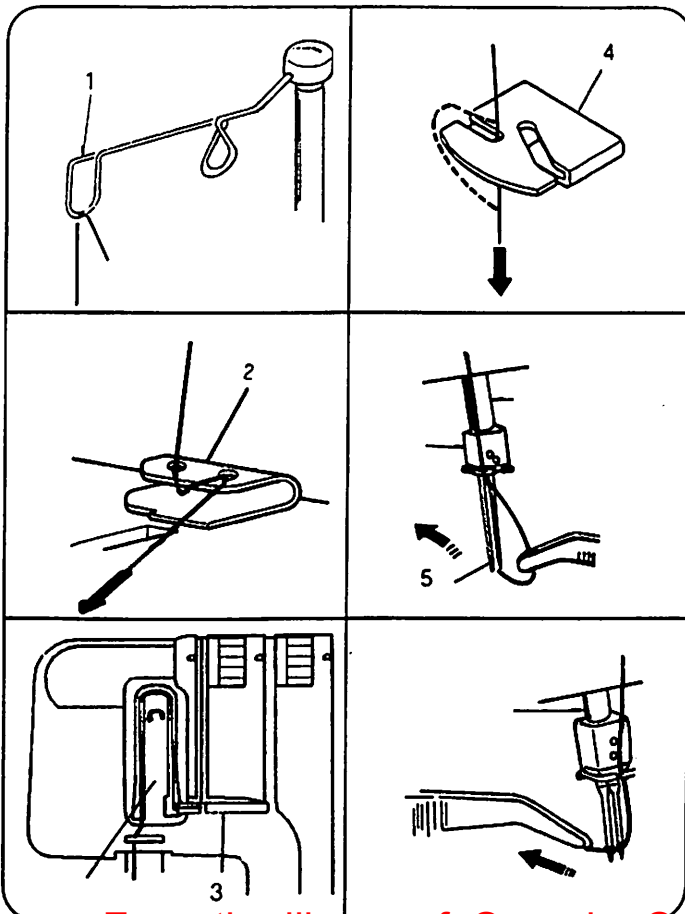
- Place the spool on the spool holder pin.
- Bring thread through guide (1).
- Make S-loop through holes in thread guide bar (2).
- Thread guide (3,4)
- Thread left needle eye (5)
- Place thread under presser foot.

After threading

When threading is complete, lower the presser foot and close the looper cover and cloth plate.

Note:

If the lower looper has to be re-threaded, cut both needle threads off at the needle eye and remove surplus thread from below. Thread the looper and then re-thread the needles.



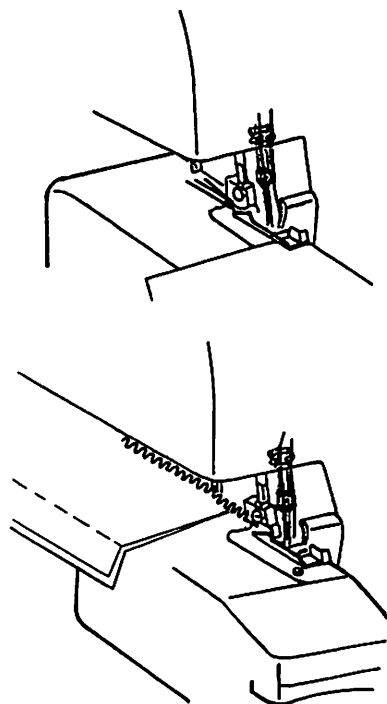
- For Certain models only
- Pour un certain modèles uniquement
- Kun for visse modeller
- Nur für gewisse Modelle

Trial sewing, thread tension

Sewing test

After threading make a trial run. Always use a double layer of fabric in order to be able to check the stitch formation and thread tension properly.

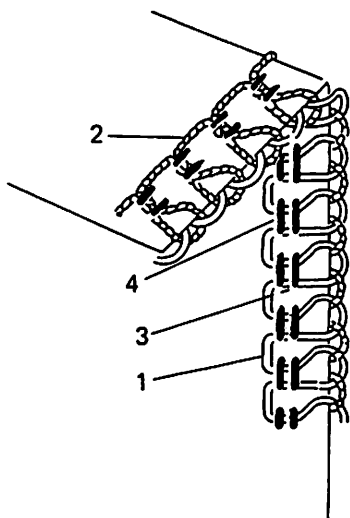
- Switch the machine on "I".
- Set all tension dials to 4.
- Raise the front of the presser foot slightly with your thumb and position the fabric under the foot just up to the knife.
- Sew.
- At the end of the seam continue sewing a 8cm (4") long thread chain.
- Cut the thread chain and remove work.



Check your trial run

- 1 Upper looper thread (blue)
- 2 Lower looper thread (red)
- 3 Right needle thread (green)
- 4 Left needle thread (yellow)

Perfect stitch formation is when both looper threads meet at the fabric edge. The needle threads form straight stitches for a stretchy and durable seam.

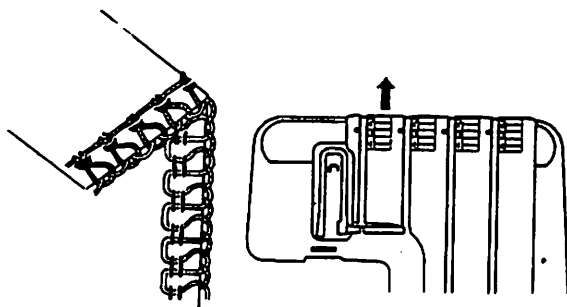


Thread tension adjustments may be required depending on the type of fabric and thread being used.

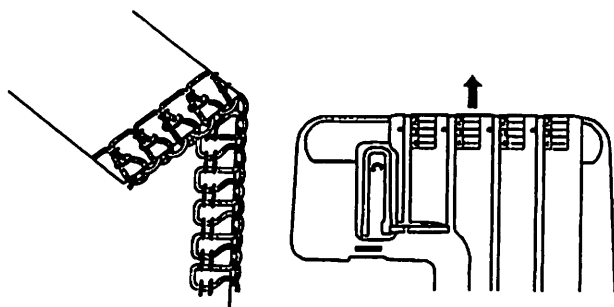
Adjusting the thread tension

Adjusting the thread tension

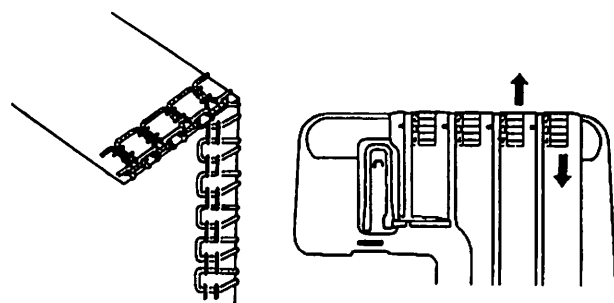
The left needle thread forms loops on the underside:
Tighten the left needle thread tension (yellow).



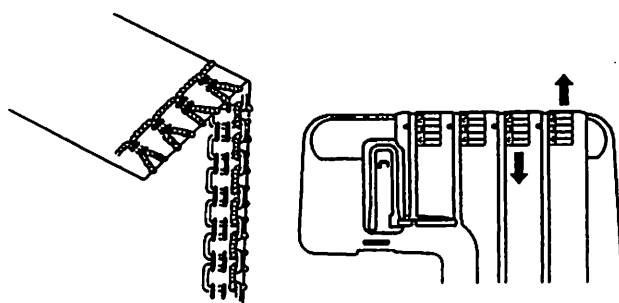
The right needle thread forms loops on the underside:
Tighten the right needle thread tension (green):



The looper loops are formed on the underside:
Tighten the upper looper tension (blue), or loosen the lower looper tension (red).



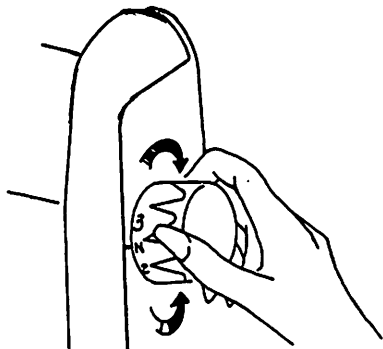
The looper loops are formed on the upper side:
Tighten the lower looper tension (red), or loosen the upper looper tension (blue).



Adjustments and settings

Stitch length

- The stitch length can be adjusted from 1 to 4 mm.
- Higher number = longer stitch, lower number = shorter stitch.
- Basic stitch length = N.

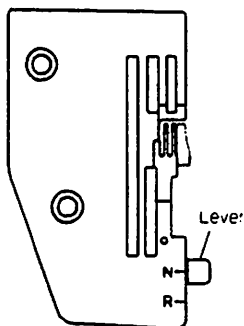
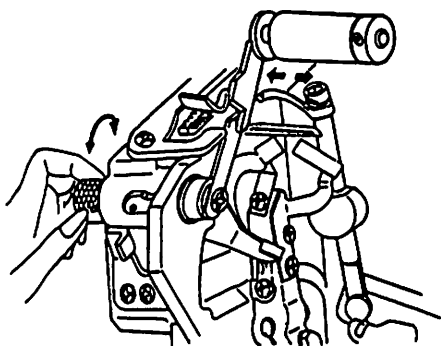


Cutting width

The cutting width should be adjusted according to the type of fabric being sewn. Check the seam each time and adjust the cutting width accordingly.

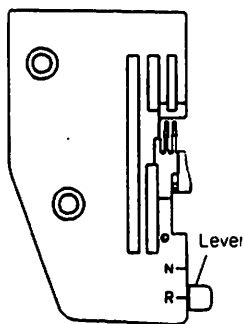
Adjusting the cutting width:

- Open cloth plate cover
- Turn cutting width dial:
- Clockwise to move knife to the left (for heavier fabrics).
- Counter-clockwise to move the knife to the right (for lighter fabrics).



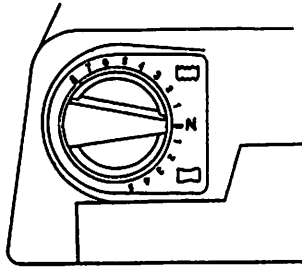
How to use the needle plate

Switch the lever to select the regular or rolled hem and narrow hem sewing. "N" for regular sewing.



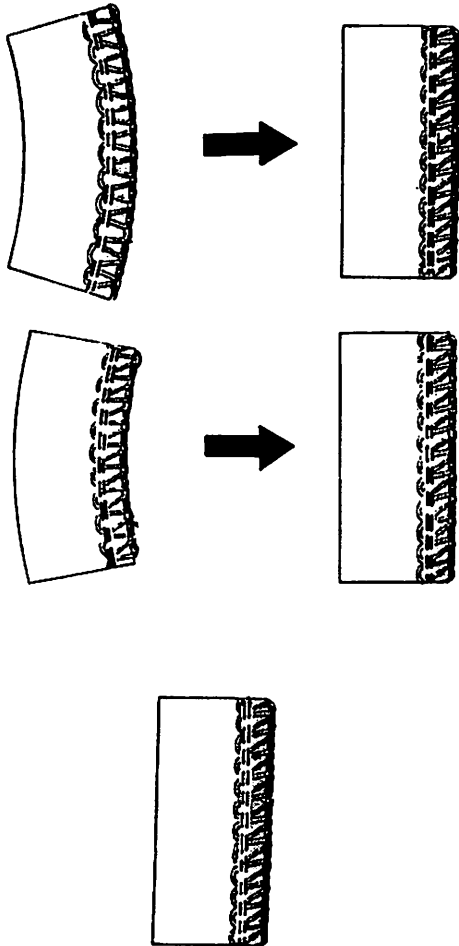
"R" for rolled and narrow hem sewing.

Differential feed*




Differential feed*

There are two feed dogs: one front and one rear. The two feed dogs move independently and the distance each feed dog travels during one complete movement can be adjusted.




Stretching effect

To stretch the fabric select a number from N to 5 in the section "  ".

This prevents fine nylon jerseys or closely woven fabrics from puckering.

Pushing effect

To prevent waving or to gather select a number from N to 8 in the section "  ".

This prevents waving or fluting in knits or puckers in fine woven fabrics. It also can be used to gather single layers of fine woven fabric.

Note:

When sewing without differential feed the dial should be on position N.

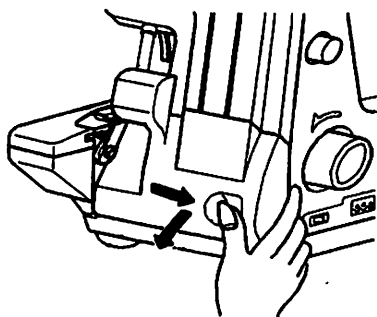
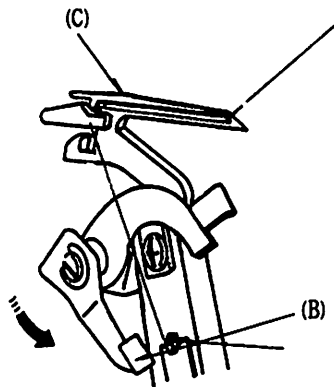
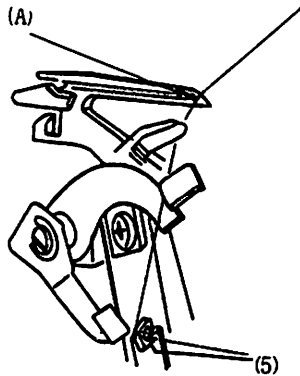
Gathering*

Use the differential feed to gather a single layer of fabric. For example sleeve heads, yokes, lace edging or frills.

Threading

AUTOMATIC LOWER LOOPER THREADER (FOR CERTAIN TYPE ONLY)

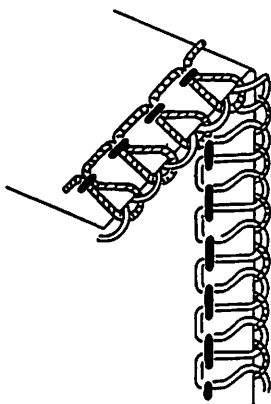
1. passing the thread through the hole on lower looper thread guide (5).
2. Turn the balance wheel toward you until the lower looper extending out 5-10mm from the needle plate edge.
3. Pull the thread with tweezers to pass the lower looper hole (A).
4. Draw the thread with your left hand tightly.
5. Use your finger to push the automatic threader (B) up to the topmost, and then thread goes through the lower looper (C) automatically.



⚠:Security "auto switch off"

when you open the panel
infront of the loopers the
machine stops automatically
-FINGERPROTECHTION.

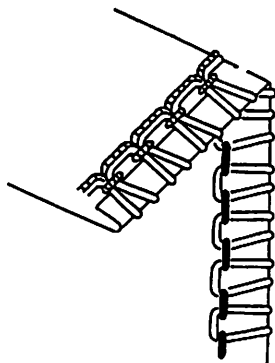
Practical sewing



3 thread overlock

For a 3-5 mm wide 3 thread overlock, remove the left needle. Thread both loopers and then the right needle.

For a 5-7 mm wide 3 thread overlock, remove the right needle. Thread both loopers and then the left needle.



3 thread roll hém

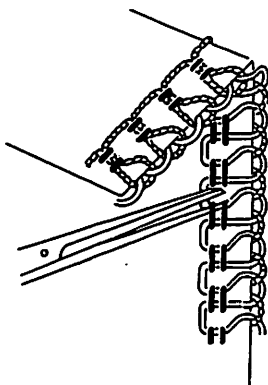
Switch the lever to "R". See page 29.

Note:

The tensions may need to be adjusted depending on the type of fabric or thread being used.

Setting:

Stitch:	3 thread overlock
Needle:	right
Tensions:	
Needle:	3-5
Upper looper	3-5
Lower looper	7-9
Stitch length	1.5-2
Differential feed	N (depending on fabric)



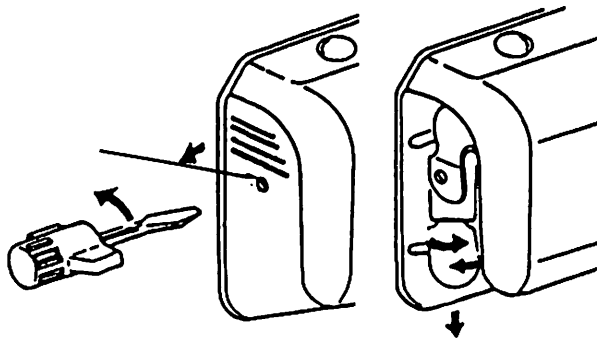
Unpicking seams

Cut the loops with sharp scissors. Pull the needle thread and the stitches will come undone.

Maintenance

Knives

The knives are made from special material and are very durable. They can be replaced if the blades become dull or damaged.

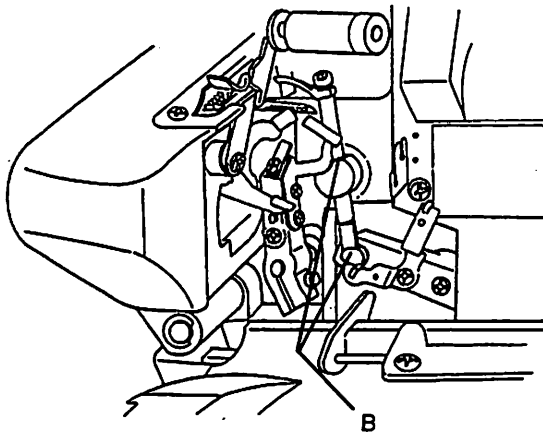


Changing light bulb

- Switch the machine off "O" and disconnect it from electricity supply by removing the mains plug.
- Loosen the bulb cover setscrew (A) and remove the bulb cover.
- Unscrew the bulb and replace it with a new one.
- Attach bulb cover and retighten the setscrew.

Note:

Always use 110V/230V/240V 15W bulbs. Bulbs are available from your local dealer.





Cleaning and lubricating

- Disconnect machine from electricity supply.

During sewing dust and fluff collect in and on the machine. This should be removed regularly.

Your overlocker requires very little lubrication but if used frequently, lubricate the points illustrated (B) with a drop of oil.

Trouble shooting guide

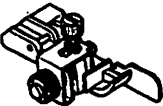
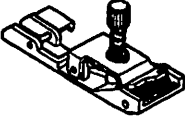
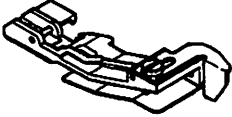
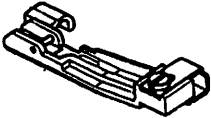
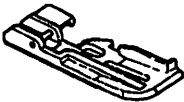
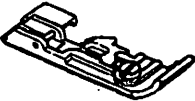
Thread breaks	Thread tension is too tight for thread used.	Reduce thread tension.	27
	The machine is not threaded correctly.	Check the threading.	17/19 21/23
	Needles are incorrectly inserted.	Insert needles fully into needle clamp with flat side to the back.	15
Needles break	Needles are bent, blunt or the points are damaged.	Replace the needles.	15
	Needles not inserted correctly.	Insert needles fully into needle clamp with flat side to the back.	15
	Fabric was pulled while sewing.	Guide fabric gently with both hands.	25
Skipped stitches	Needles are bent or blunt.	Replace the needles.	15
	Wrong needles used.	Use system HAX1 (130/705H) needles.	
Poor stitch formation	Thread is not wound correctly round tension dials.	Check threading.	17/19 21/23
Seams flute or wave (knits)	Differential feed is set incorrectly.	Adjust differential feed between N and 8	31
	Fabric was pulled while sewing.	"  ".	
Seams pucker	Differential feed is set incorrectly.	Adjust differential feed between N and 5	31
		"  ".	
Fabric edges curl	Too much fabric in the stitch formation.	Reduce cutting width, knife to the left.	29
Thread loops are loose	Too little fabric in the stitch formation.	Increase the cutting width, knife to the right.	29
Machine does not sew	Cord not plugged in correctly.	Check plug.	11
	Main switch not on.	Switch machine on " 1 ".	

Technical data

Données techniques

Stitch types: -2 needles, 4 thread overlock with integrated safety seam -1 needle, 3-thread overlock, 3 thread rollhem, Needle system: HAX1 (130/705H) Seam width: 3-7 mm Stitch length: 1-4 mm Presser foot lift: max. 6mm Handwheel: rotates counter-clockwise Sewing speed: up to 1300 s.p.m. Weight: 7.3 kg Dimensions: 340W x 370D x 350H mm	Points réalisables: - 2 aiguilles, surjet à 4 fils avec point de sécurité intégré - 1 aiguille, surjet à 3 fils Ourlet roulé à 3 fils Système d'aiguille: HAX1 (130/705 H) Largeur de couture: 3 - 7 mm Longueur de point: 1 - 4 mm Élève pied-de biche 6 mm au max. Rotation du volant: En sens inverse des aiguilles d'une montre Vitesse de travail Jusqu'à 1300 points,omite/mi Poids: 7,3 kg. Dimensions: - 340 (L) x 370 (P) x 350 (H) mm.
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Standard accessory: Dust cover	Accessoires standard Housse de protection
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	Special accessories	Accessoires spéciaux:
	Blind stitch foot	Pied pour points invisibles
	Elasticator foot	Pied pour poser des élastiques
	Shirring foot	
	Bead/sequin foot	
	Cording foot	
	Taping foot	
Special accessories are available from your dealer		Les accessoires ad speciaux sont disponibles auprès de l'agent.

English

The product in this manual fulfil the demands in below norms:

72/23 EEC
89/336 EEC
89/392 EEC

Please pay attention on the needle area: The needle area can not be completely protected, as a totally protection will spoil the fundamental function of the overlock machine.

Great caution should be shown when working in the needle area. It is recommended to disconnect the overlock machine by remove plug from outlet when changing needle, bulb or when other work in the needle area is required.

The right to change in construction and specification reserved.

Dansk

Produktet i denne betjeningsvejledning opfylder kravene i nedenstående normer:

72/23 EEC
89/336 EEC
89/392 EEC

Dog henledes opmærksomheden på, at nålens arbejdsområde på overlock maskinen ikke kan beskyttes fuldt ud, idet en total beskyttelse af nåleområdet vil ødelægge overlock maskinens grundlæggende funktion. Der bør derfor udvises stor forsigtighed ved arbejde i nåleområdet, og det anbefales derfor at overlock maskinen afbrydes på net-stikket ved udskiftning af nål eller ved andet arbejde i nåleområdet.

Ret til ændring i konstruktion og specifikation forbeholdes.

Fran

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