

JUKI

DOUBLE STACKER FOR ASN-395, 397
SS42

INSTRUCTION MANUAL

Note) In the case of the ASN-397, some of the parts have already been installed, so use caution.

No. 00
29145000

INTRODUCTION

Congratulations on your purchase of a JUKI SS42 double stacker for use with the ASN-395 and ASN-397.

To get the most out of many functions of double stacker and operate it in safety, it is necessary to use the unit correctly, so please read this Instruction Manual carefully before using it. We hope you will enjoy using it for a long time.

It is also necessary to keep this Instruction Manual taking care not to lose it.

PRECAUTIONS IN USE

1. When connecting wiring and piping to the ASN-395 or -397, be careful that wires and pipes do not contact the driving components.
2. When connecting the solenoid valve wiring to the connector on the main unit, first confirm that the main power switch is OFF.
3. Do not place any objects within the stacker's range of motion.

I . OUTLINE

This double stacker is a system which makes it possible for a user who is already using an ASN-395 or ASN-397 and needs a stacking function to add it later.

This double stacker has the capabilities to stack the left and right garment body parts of slacks separately and to stack double the quantity of an ordinary stacker.

1. Features

- 1) Since the left and right body parts are stacked separately, the efficiency of the next step in production is increased.
- 2) Twice as much can be stacked as with an ordinary stacker.
- 3) Can also use as ordinary single stacker.

2. Specifications

Material to be stacked -----Length 800 mm to 1200 mm
Width 70mm to 500mm

Stacking capacity -----100 garment parts (the stacking capacity change depending on the height of the cloth support board).

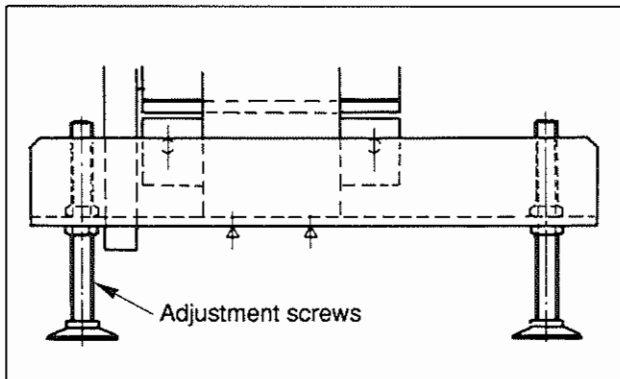
Air pressure -----5 kgf/cm² (0.5 MPa)

Dimensions -----1225 mm × 355 mm × 900 mm

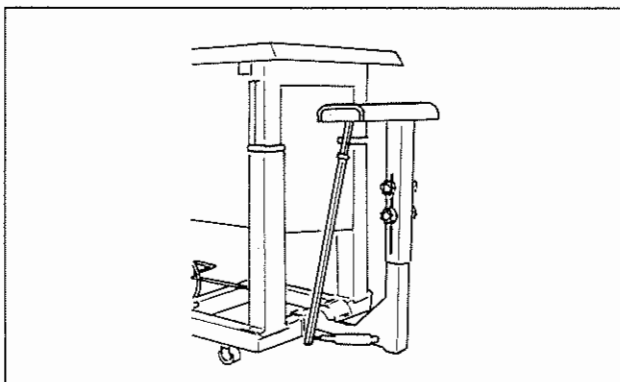
Weight -----19.5 kg

II. INSTALLATION

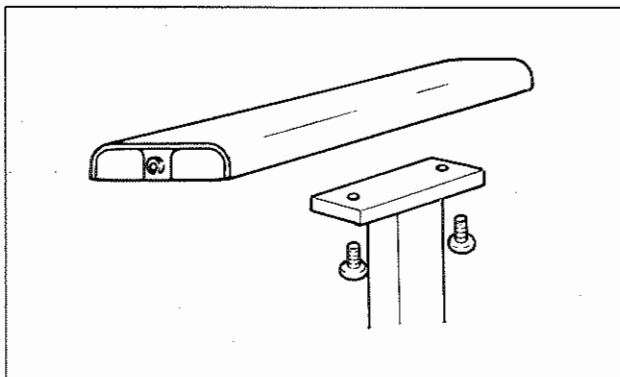
1. Stacker installation



(1) Attach the two adjustment screws into the main frame.



(2) Attach the stacker support column to the frame with two screws.



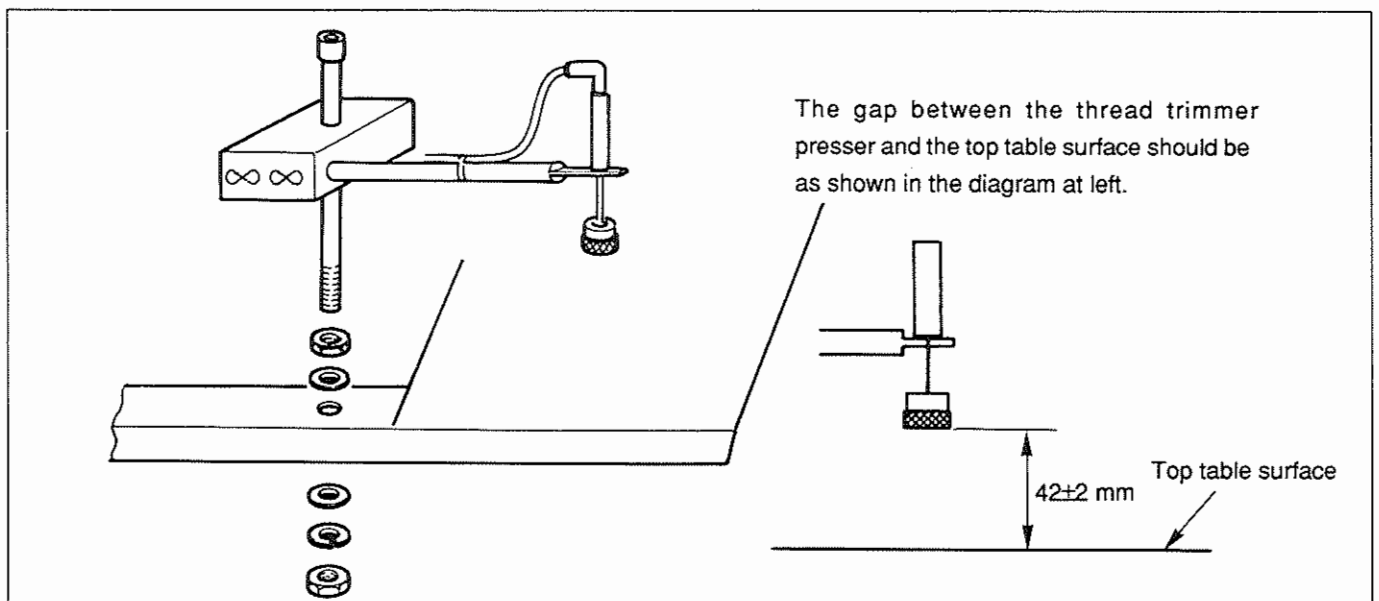
(3) Attach the cloth support board to the stacker support column with two screws.

Caution)

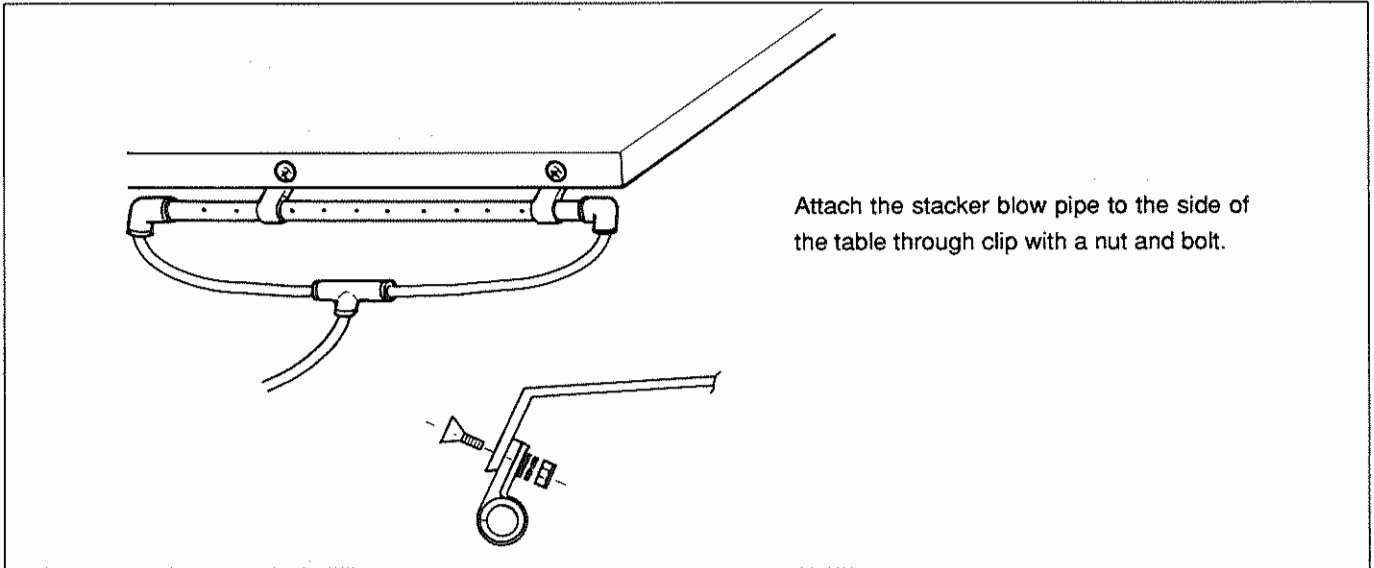
The cloth support board is very heavy. So, be sure to carefully attach it to the column.

2. Attachment of thread trimmer presser

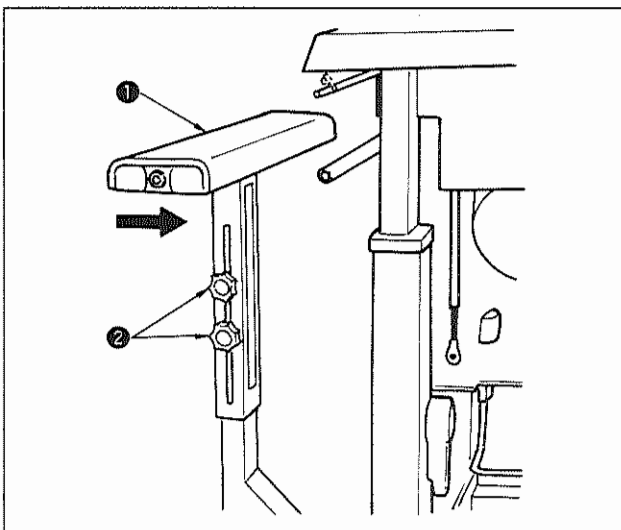
Attach to the hole in the sewing machine leg main unit with washers and a nuts.



3. Stacker blow pipe attachment

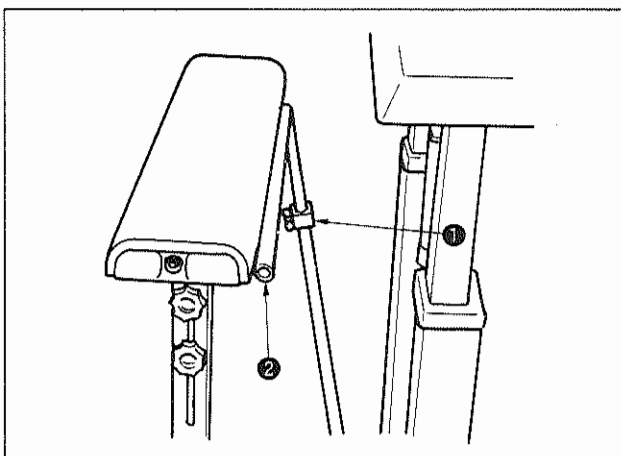


4. Adjustment of the stacker support board



- (1) The stacker support board ① can be raised and lowered by loosening handle ②. When it is in the correct position, tighten the handle tightly.
- (2) When stacking short items, loosen the two screws below the stacker support board and move it in the direction of the arrow.

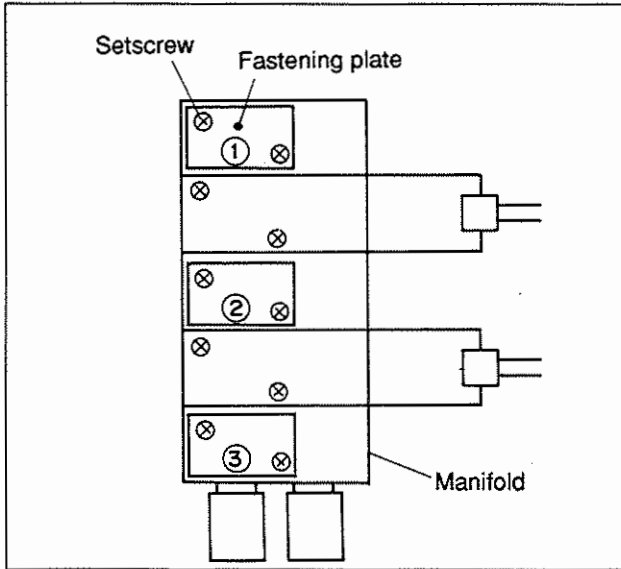
5. Stacker bar adjustment



Loosen the wing nut ①; then the stacker bar ② position can be adjusted upward or downward to match the height of the cloth support board.

6. Solenoid valve attachment

(1) Solenoid valve attachment

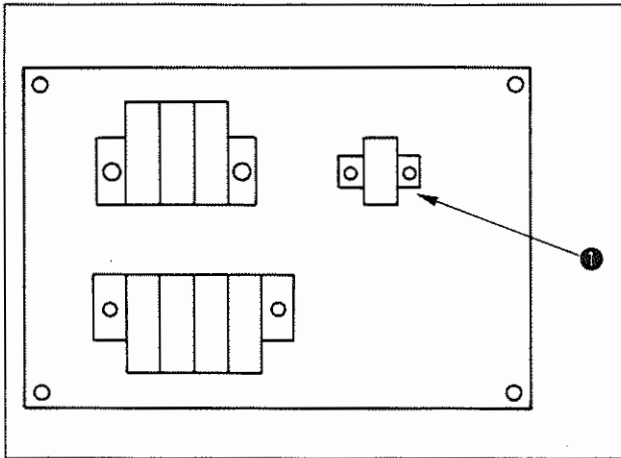


Remove the fastening plates and the setscrews from the solenoid valve manifold attached to the ASN main unit, then attach the following three solenoid valves:

- 5-port solenoid valve (1104E1-8W) to ①
- 3-port solenoid valve (110E1-J41-8W) to ②
- 5-port solenoid valve (1104E1-8W) to ③

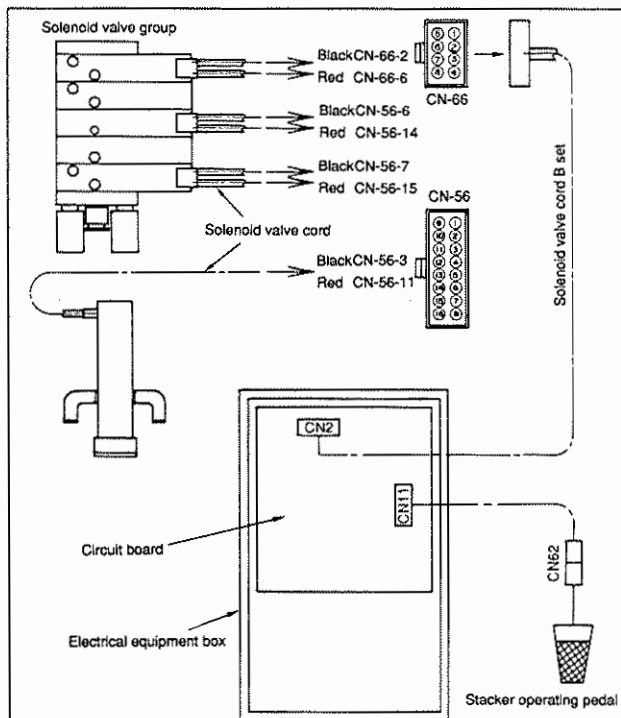
Note) The fastening plates and setscrews are no longer necessary after the solenoid valves are attached.

(2) Attachment of a single solenoid valve



Attach a single solenoid valve to ①.

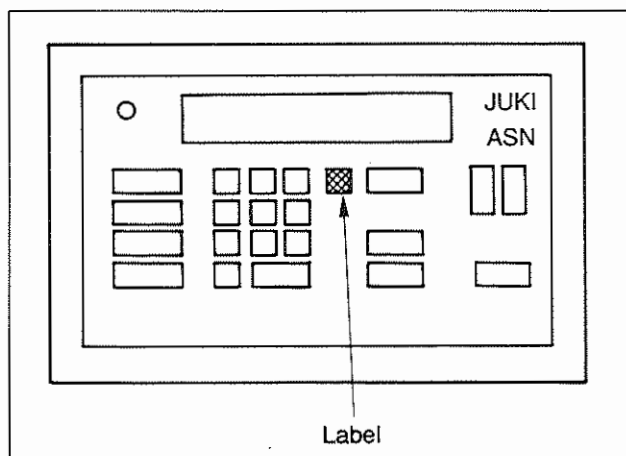
7. Wiring solenoid valve cord and stacker operating pedal



Wire the cords coming out of the solenoid valves to the connectors indicated below.

The stacker operating pedal is optionally available. If you use the pedal, wire the pedal cord to the connector shown in the figure.

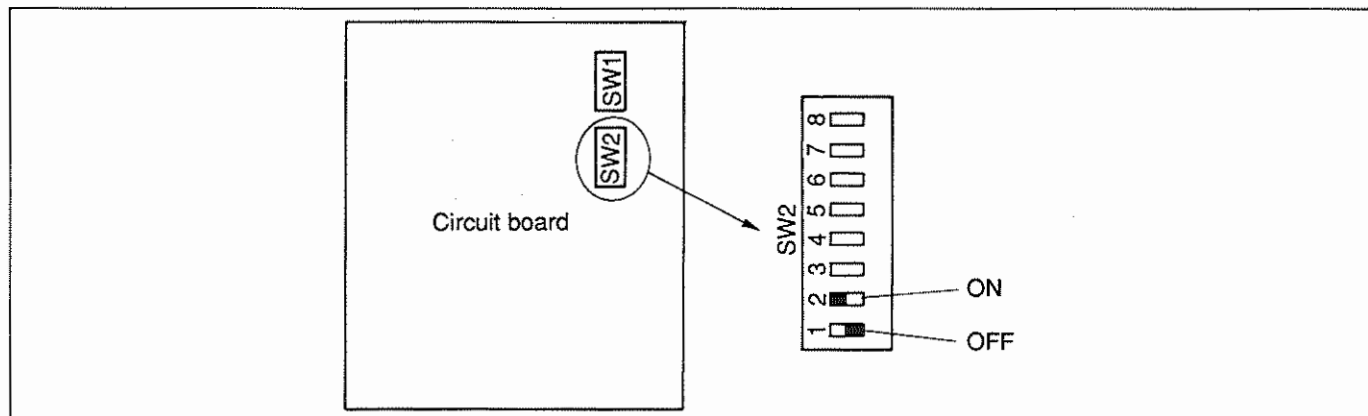
8. Attach the double stacker label to the operation panel



- (1) Attach the $\boxed{L/R}$ label in the SS42 accessory bag to the location shown by the arrow.
- (2) When the $\boxed{L/R}$ switch is pressed, the stacker support board can be moved forward and backward.

Setting the dip switches inside the electrical equipment box

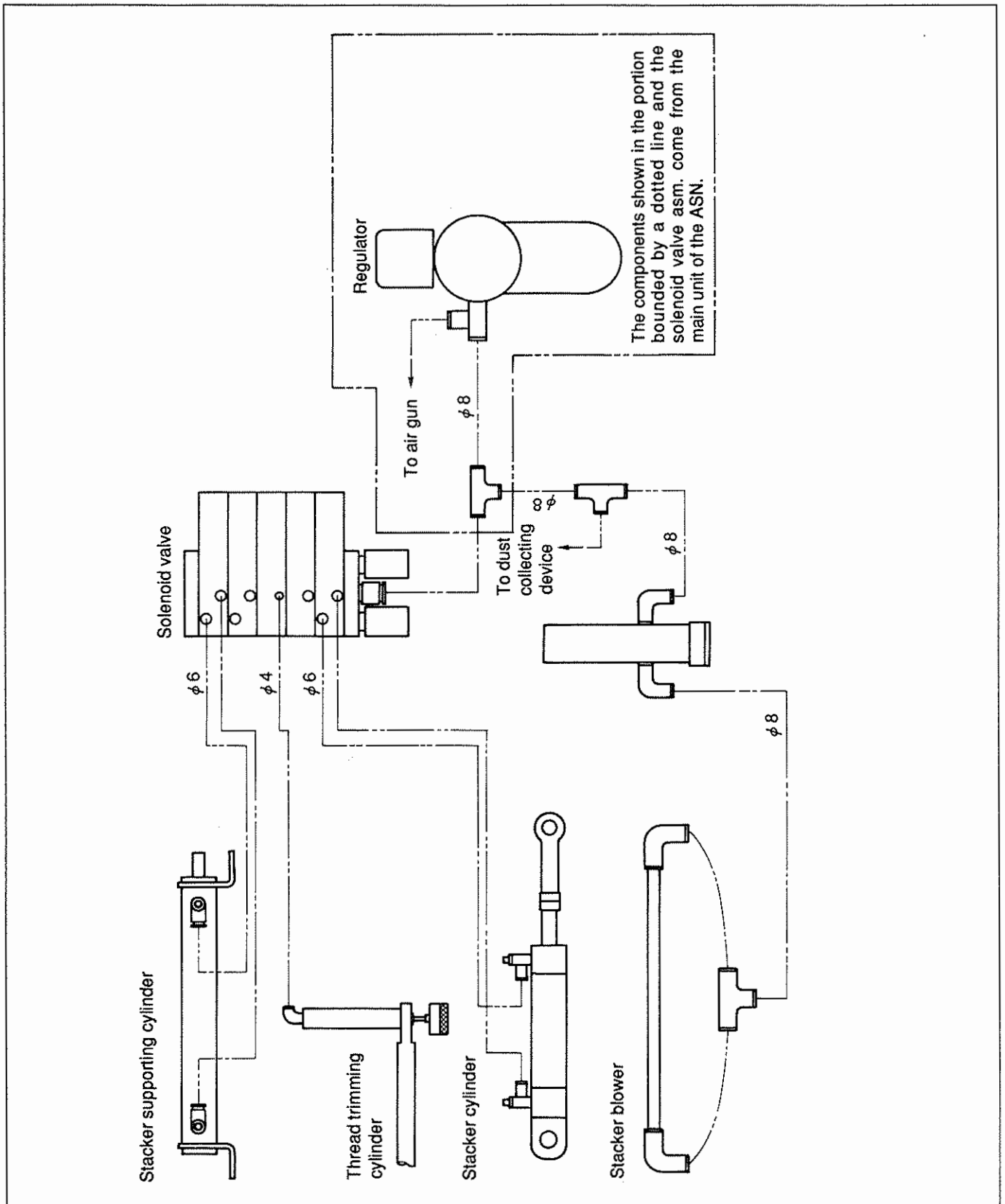
- 1) Turn the main power switch OFF.
- 2) Remove the screws holding the electrical equipment box cover in place, then remove the cover.
- 3) Set No. 1 of dip switch SW2 which place at the upper right of the circuit board OFF and No. 2 ON; this makes the double stacker operational.



III. OPERATION

1. The double stacker will function immediately as soon as the dip switch set and main power switch is ON.
2. When the $\boxed{L/R}$ switch is pressed, the cloth support board moves (in case of manual operation).
3. In the case of automatic operation, refer to the ASN-395 SS40 Instruction Manual.
If the number of seaming times is 1, the left and right stackers are used alternately after 1 use on each side.
4. Stacker operating pedal
When the pedal is pressed, the stacker operates on the next seam.
When the pedal is pressed while sewing is in progress, the stacker operates as soon as the sewing is completed.

IV. Pneumatic piping diagram



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To order or for further information, please contact:

Please do not hesitate to contact our distributors or agents in your area for further information when necessary.

※The description covered in this instruction manual is subject to change for improvement of the commodity without notice.

1993.11 Printed in Japan (A)