

**JUKI**

# MEB-3200 Series

Computer-controlled, Eyelet Buttonholing Machine  
with Trimmer for Needle and Looper Thread with Gimp



# MEB-3200 Series

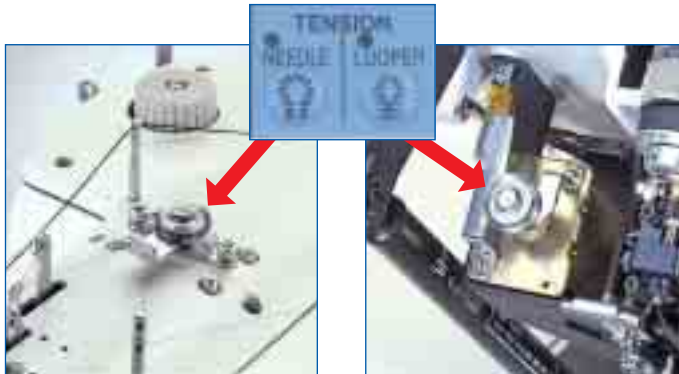
*The world's first machine that incorporating an active tension mechanism  
(computer-controlled thread tension mechanism)*

**THE FIRST  
IN THE  
WORLD!**

## **AN ACTIVE TENSION MECHANISM (COMPUTER-CONTROLLED THREAD TENSION MECHANISM) THAT ELECTRONICALLY CONTROLS THE NEEDLE AND LOOPER THREAD TENSIONS.**

**Needle and looper thread tensions can be digitally established on the operation panel according to sewing conditions. Data can be registered on a pattern-by-pattern basis to easily reproduce the same sewing conditions.**

- Using conventional machines, it's often quite difficult to reproduce the same sewing conditions. This machine does it with ease. With this capability, the MEB-3200 responds immediately to material changes, significantly reducing the time required for setup changes or adjustments. The machine also ensures the consistent production of high-quality seams.



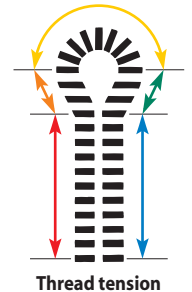
For needle thread

For looper thread

**Thread tensions can be separately established for various sections of a buttonhole such as eyelet sections and parallel sections.**

- The machine promises high-quality seams by smoothly responding to changes in stitch formation and allowing the operator to set a separate thread tension for the bartacking sections of buttonholes.

- Thread tensions for the beginning and end of sewing can also be separately established. This helps prevent loose stitches or slip-off or raveling of thread at the beginning of sewing.



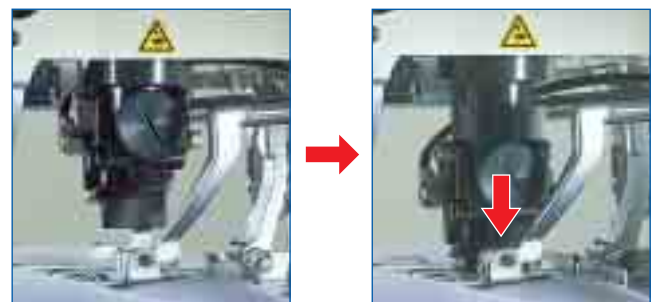
**Threading work can be more easily.**

- Since fewer parts need to be threaded, the machine can be threaded more quickly and easily than conventional buttonholing machines.

## **EXCELLENT CAPABILITIES TO HELP IMPROVE SEAM QUALITY**

### **Vertically driven cloth cutting knife controlled by a stepping motor.**

- The knife is controlled by a stepping motor. This enables easy adjustment of the knife pressure on the operation panel to be used, thereby preventing irregular cutting.
- Data on knife pressure can be registered on pattern-by-pattern basis to establish the best-suited knife pressure according to sewing specifications. Adequate knife pressure improves durability of cloth-cutting knife and knife guard.
- Selection between the cut-before knife and cut-after knife can be made on the operation panel.
- The stepping-motor-controlled cloth-cutting knife is free from the troubles likely to affect air-driven knives, including dull cutting and the breakage of parts such as the knife-driving arm. In addition, a large-capacity compressor is no longer required since the machine uses less compressed air.



Knife comes down

### **Separately driven right and left work clamps.**

- The right and left work clamps are separately driven by independent air cylinders. With this mechanism, the work clamps reliably clamp materials of different thicknesses to prevent the materials from flopping.



MEB-3200SS

## **EASY-TO-OPERATE MULTI-FUNCTIONAL OPERATION PANEL**









**All pieces of data on sewing specifications can be established/selected on the operation panel.**



## HIGHER FLEXIBILITY

Thanks to the computer control, many different eyelet shapes and straight buttonhole shapes can be selected or established on the operation panel.

- The machine is provided as standard with 10 different stitching shape patterns. As many as 89 different patterns can be stored in memory and selected.

			
*	**	**	**
Buttonhole without a bartack	Buttonhole with a taper bar	Buttonhole with a straight bartack	Buttonhole with a round bartack
<b>Eyelet buttonhole</b>			
			
*	*	*	*
Buttonhole without a bartack	Buttonhole with a taper bar	Buttonhole with a straight bartack	Buttonhole with a round bartack
<b>Straight buttonhole</b>			

\* Registered in standard patterns (S, R type)  
\*\* Registered in standard patterns (J, C type)

## HIGHER PRODUCTIVITY

Reliable overall thread-trimming mechanism.

- The MEB-3200SS/RS for men's and ladies' wear cuts needle threads, looper threads and gimps to leave longer threads on the material. The thread trimmer cuts the thread on the material to lengths that allow the machine to easily retain the thread ends. This facilitates the subsequent bartacking process.



Longer thread type  
(MEB-3200SS/RS)

## HIGHER OPERABILITY

Newly developed machine head that efficiently sews longitudinal buttonholes.

- JUKI has newly developed a machine head with a shallow recess. For the efficient sewing of longitudinal buttonholing.  
\* Use MEB-3200RS for combined use for lateral and longitudinal buttonholing.
- The machine head has a wider space under the work clamps to permit easy placement of a sewing product, thereby improving workability.
- The semi-sunken machine head promises easy placement and smooth handling of sewing products.
- The amount of material opened can be easily adjusted using the screw mounted outside the machine head.



Material opening amount adjusting screw MEB-3200SS

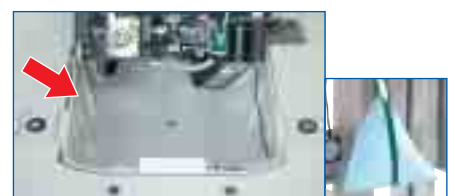
Direct-drive motor is adopted.

- The machine has adopted a direct-drive method that connects a compact AC servomotor directly to the hook-driving shaft. The quick startup and increased stopping accuracy obtained as a result guarantees outstanding responsiveness. In addition, the direct-drive motor does not use a V-belt to reduce power consumption.



Improvements of working environment.

- Designed without a clutch mechanism or stop-motion mechanism, the machine produces no stop-motion noise.
- The machine automatically reclaims cloth chips after cloth cutting action to keep the working environment cleaner.



No cloth-chips drop under the bed.

Dust bag

Excellent maintainability.

- The computer controlled design eliminates most of the complicated mechanisms. This dramatically improves maintainability.
- The machine head is supported by a gas-spring that makes it easy to raise for smoother cleaning and threading.





## MEB-3200SS□□M, provided with multi-cutting device

• The multi-cutting device incorporates a separate cloth cutting knife with two sections of blade --- one intended for the eyelet sections of buttonholes and one intended for straight sections. When sewing men's wear, the machine can sew eyelet buttonholes on a front body and straight buttonholes on a lapel without changing the knife. Conventionally, two different types of buttonholing machines are required for these processes. By performing two different kinds of buttonholing, the MEB-3200□□□M halves the time required for the setup procedure, including color thread changing. The end result is increased productivity.

• By dropping the knife two or more times per cycle, the machine can sew buttonholes of various sizes without changing the knife guard (18mm to 38mm for eyelet buttonholes and 10mm to 38mm for straight buttonholes). The machine is best suited for small-lot production of ladies' wear subject to frequent design changes.

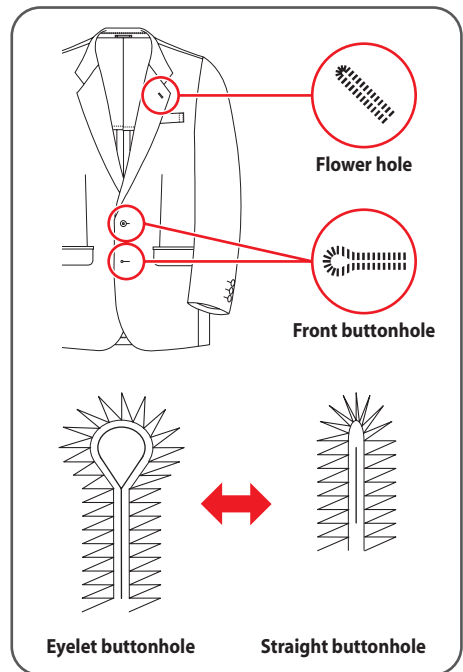
The machine is equipped as standard with a needle thread clamp device.



Eyelet shape



Straight shape



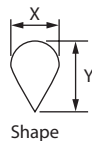
## REPLACEMENT GAUGES

### Knife guard (for combined use for eyelet and straight buttonhole)

Knife guard shape	Knife guard length (mm)	Part No.	Max. sewing length (mm)		Min. sewing length (mm)		Application S
			Eyelet buttonhole	Straight buttonhole	Eyelet buttonhole	Straight buttonhole	
No-step type	32	320-87603	38	38	32	22	
	26	320-87702	38	38	26	16	
	18	320-87801	38	38	18	10	◎
Stepped type	32	320-87900	38	38	22	22	
	26	320-88007	38	38	16	16	
	18	320-88106	38	38	10	10	

### Cloth cutting knife (eyelet)

Multi-cutting type				
Eyelet name	Part No.	Shape (mm)		Application S
		X	Y	
3A	320-87207	2.9	4.4	◎
6A	320-87306	2.7	5.1	



Multi-cutting type (knife-dropping one time)				
Eyelet name	Part No.	Shape (mm)		Max. sewing length (mm)
		X	Y	
3B	400-12587	2.9	4.4	32
6B	400-12588	2.7	5.1	32

## MEB-3200□□□A, provided with needle thread clamp device

- The needle thread clamp device eliminates the thread securing procedure by tucking the needle thread in the finished seams.
- The needle thread clamp device retains the needle thread to ensure neat seam formation from the very first stitch.
  - \*The needle thread clamp device can be retrofitted to the machine. Optional part: Part No.: 320-24481



Needle thread clamp device

# LIST OF THE REPLACEMENT GAUGES

○ : Provided as standard      No symbol : Optional  
 △ : Accessory                      - : Installation is invalid.

## Throat plate

Part name	Part No.	Application		Needle size
		S	R	
Throat plate A (standard)	320-42715	○	○	Nm90 ~ Nm110
Throat plate B (for semi-wide stitch bite)	320-42913			Nm90 ~ Nm110
Throat plate C (for wide stitch bite)	320-43010			Nm90 ~ Nm110
Throat plate D (for narrow stitch bite)	320-43218			Nm90 ~ Nm110

## Work clamp, complete

Part name	Part No.	Application	
		S	R
Work clamp, complete for longitudinal buttonholes	320-31064		○

## Work clamp

Work clamp (left)				
Part name	Part No.	Application		
		S	R	
For eyelet buttonhole 40mm	140-10102	○	○	
For eyelet buttonhole 32mm	140-59604			
For eyelet buttonhole 22mm	140-59802			
For straight buttonhole 40mm	140-13908			
Compensating work clamp H, 40mm for eyelet buttonholes	140-58903			
Compensating work clamp M, 32mm for eyelet buttonholes	320-28706			
Compensating work clamp S, 24mm for eyelet buttonholes	320-28300			
Compensating foot for eyelet buttonhole 32mm	400-35239			
Compensating foot for eyelet buttonhole 22mm	400-39844			

Work clamp (right)				
Part name	Part No.	Application		
		S	R	
For eyelet buttonhole 40mm	140-10003	○	○	
For eyelet buttonhole 32mm	140-59505			
For eyelet buttonhole 22mm	140-59703			
For straight buttonhole 40mm	140-13809			
Compensating work clamp H, 40mm for eyelet buttonholes	140-58804			
Compensating work clamp M, 32mm for eyelet buttonholes	320-28607			
Compensating work clamp S, 24mm for eyelet buttonholes	320-28201			
Compensating foot for eyelet buttonhole 32mm	400-35238			
Compensating foot for eyelet buttonhole 22mm	400-39843			

\* Provided as standard for JE

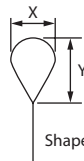
## Presser support plate

Presser support plate (left)				
Part name	Part No.	Application		
		S	R	
Presser support plate for eyelet buttonholes	320-27104	○	○	
Presser support plate for straight buttonholes	320-29506			

Presser support plate (right)				
Part name	Part No.	Application		
		S	R	
Presser support plate for eyelet buttonholes	320-27005	○	○	
Presser support plate for straight buttonholes	320-29407			

## Cloth cutting knife

For eyelet buttonhole					
Part No.	Shape (mm)		Max. cutting length (mm)	Application	
	X	Y		S	R
140-41206	2.9	4.4	38	○	○
320-63604	2.9	4.4	24		
320-63703	2.9	4.4	32		
320-63802	2.1	3.2	38		
320-63901	2.1	3.2	24		
320-64008	2.1	3.2	32		
320-64107	3.2	5.4	38		
320-64206	3.2	5.4	24		
320-64305	3.2	5.4	32		
320-66904	2.7	5.1	38		



For straight buttonhole					
Part No.	Shape (mm)		Max. cutting length (mm)	Application	
	X	Y		S	R
140-41404	0	0	38	△	△
320-65302	0	0	24		
320-65401	0	0	32		

## Knife guard

For eyelet buttonhole (standard)			
Size (mm)	Part No.	Application	
		S	R
38	320-67209	△	△
36	320-67308		
34	320-67407		
32	320-67506		
30	320-67605		
28	320-67704		
26	320-67803		
24	320-67902		
22	320-68009	○	○
20	320-68108	△	△
18	320-68207		
16	320-68306	△	△
14	320-68405		
12	320-68504		
10	320-68603		

For eyelet buttonhole			
Size (mm)	Part No.	Application	
		S	R
38	320-62101		
36	320-62200		
34	320-62309		
32	320-62408		
30	320-62507		
28	320-62606		
26	320-62705		
24	320-62804		
22	320-62903		
20	320-63000		
18	320-63109		
16	320-63208		
14	320-63307		
12	320-63406		
10	320-63505		

For straight buttonhole			
Size (mm)	Part No.	Application	
		S	R
40	140-42501		
36	320-64404		
34	320-64503		
32	140-42600		
30	320-64602		
28	320-64701		
26	140-42808		
24	320-64800		
22	140-42907	△	△
20	320-64909		
18	320-65005		
16	140-43103		
14	320-65104		
12	320-65203		
10	140-43301		

## Left looper, left spreader

Applicable zigzag width (mm)	Left looper	Left spreader	Application	
	Part No.	Part No.	S	R
2.0~3.2	320-40800	320-40917	○	○
2.6~4.0	140-30902	140-31116		

# SPECIFICATIONS

Model name	MEB-3200SS	MEB-3200RS	MEB-3200JS	MEB-3200CS	MEB-3200TS
Application	Men's and ladies' wear	Combined use for lateral and longitudinal buttonholing: for men's and ladies' wear	Jeans	Cotton pants and working wear	Trousers
Thread trimming style	Longer remaining thread		Shorter remaining thread		Shorter thread cutting without gimp
Stitch system	1-needle, double chainstitch (with gimp)				1-needle, double chainstitch (without gimp)
Max. sewing speed	400~2,200sti/min*1 (100sti/min*1 step)				
Sewing length	10~38mm (with thread trimmer) 10~50mm (in case looper thread trimming device is removed)*2		Work clamp type S 16~24 (26)mm: optional Work clamp type M 24~32 (34)mm: standard Work clamp type L 32~40 (42)mm: optional	Work clamp type S 16~24 (26)mm: standard Work clamp type M 24~32 (34)mm: optional Work clamp type L 32~40 (42)mm: optional	10~34mm Compensating work clamp S, 24mm for eyelet buttonholes: standard
Needle throwing width (at the time of delivery)	2.0~3.2mm*2		2.6~4.0mm*3	2.0~3.2mm*3	2.0~3.2mm
	(2.3mm)		(2.5mm)	(2.5mm)	(2.3mm)
Taper bar length	0mm, 3~15mm				
Work clamp height	13mm (max. 16mm)				
Method for changing stitch shape	By selecting a program				
Buttonhole cutting method	By cut-before knife or cut-after or without buttonhole cutting				
Feed system	Intermittent feed by stepping motor				
Cloth cutting knife drive system	Vertically driven by stepping motor				
Needle (at the time of delivery)	DO×558 (Nm100) Nm90~Nm110		DO×558 (Nm120) Nm110~Nm120	DO×558 (Nm110) Nm110~Nm130	DO×558 (Nm100) Nm100~Nm110
Lubrication	Automatic (looper and spreader: by an oiler)				
Lubricating oil	JUKI New Defrix Oil No.2 (equivalent to ISO VG32)				
Compressed air and air consumption	0.5MPa 6dm <sup>3</sup> /min (ANR) [8cycle/min]				
Power requirement and power consumption	Single-/3-phase, 550VA				
Dimensions	1,060mm (W) × 790mm (D) × 1,230mm (H)				
Total weight	185kg				

\*1 "sti/min" stands for "Stitches per Minute."

\*2 When the sewing length of 38~50mm without thread trimmer is selected, the work clamp can be provided by placing special order. Please use the Multi-cutting device when you cut the cloth.

\*3 By selecting the left looper and left spreader, the range of stitch bite can be changed to 2.6~4.0mm from 2.0~3.2mm (TS model is excluded)

## WHEN YOU PLACE ORDERS (COMPLETE)

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

Application	Code
Men's and ladies' wear	S
Combined use for lateral and longitudinal buttonholing: for men's and ladies' wear	R
Jeans	J
Cotton pants and working wear	C
Prevent bottom thread weast	B
Trousers*	T

Power supply	Code
Single-phase 220~240V	K
3-phase 220~240V	D
3-phase 220~415V	L
Single-/3-phase 220~415V (for CE)	M

\* When the sewing specification category T (trousers) is selected, A is the only option category available for selection (needle thread clamp device).

**MEB3200** 

Table stand	Code
Standard	S
On the table	A

The table stand "A" is applicable for the MEB3200J/C/T only.

Option	Code
Not provided	Z
Needle thread clamp device	A
Multi-cutting device Needle thread clamp device *1	M
Multi-cutting device B Needle thread clamp device *2	B

\*1 When option category M is selected, S and R are the only sewing specification category available for selection (men's and ladies' wear).

\*2 When option category B is selected, B is the only sewing specification category available for selection (prevent bottom thread weast).

● To order, please contact your nearest JUKI distributor.

**JUKI**  
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\* Specifications and appearance are subject to change without prior notice for improvement.  
\* Read the instruction manual before putting the machine into service to ensure safety.  
\* This catalogue prints with environment-friendly soy ink on recycle paper.

## OPTIONS

Part No.	Description	Feature
M8590-513-0AA	Pedal switch, asm.	The work clamp can be lifted/lowered and the machine can be stand using the pedal switch.
M9014-620-0A0	Pedal switchcable, asm.	



Pedal switch, asm.



Registered Organization : JUKI CORPORATION Head Office  
The Scope of the Registration : The activities of research, development, design, sales, distribution, and maintenance services of industrial sewing machines, household sewing machines and industrial robots, etc., including sales and maintenance services of data entry systems.