LK-1900B Series
Computer-controlled, High-speed, Bartacking Machine

Higher productivity.
Low-noise and low-vibration.

The machine is provided with an active tension mechanism which enables the electronic control of "stitching."

LK-1900BB Series
The world’s first
Bird’s nest preventing / Shorter-thread remaining functions
LK-1900B Series

Higher productivity.
Low-noise and low-vibration.

Higher productivity.
- The machine achieves sewing speed of 3,200st/min. The machine’s starting, stopping, thread-trimming and automatic presser lifting speeds have been increased to significantly shorten total cycle time.

Excellent workability and operability.
(Low-noise and low-vibration)
- The direct-drive head (with no belt), which is directly connected to a compact AC servomotor, achieves outstanding. This head helps create a comfortable working environment with reduced vibration and noise.
- The arm section of the machine head is fitted with a hand pulley. This allows the operator to visually check the needle entry points.

Excellent seam quality.
- Needle thread grasping mechanism helps produce consistent knot tying at the beginning of sewing. (This device has been factory-set to "invoking prohibited" status at the time of delivery.)

Many different sewing patterns.
- The machine is provided as standard with 51 different sewing patterns. The machine permits easy changeover of sewing patterns for effortless execution of an inexhaustible range of sewing specifications. *For LK-1900B, the standard no. of sewing patterns is 50.
- The LK-1900B is also able to sew buttons using the same data used for the LK-1900 (EP-ROM).

The sewing starting point can be corrected.
- In cases where the needle entry point for button sewing is to be corrected, the sewing starting point can be corrected without the adjustment of the relevant mechanism.

Many different models are prepared according to the type of materials.
- The LK-1900B model comes in five different subclass models, such as S type (standard), H type (for heavy-weight materials), F type (for foundation), M type (for knits and knitted materials), W type (with a large shuttle hook for heavy-weight materials) and (bird’s nest preventing /shorter-thread remaining functions) , to offer a choice according to any application.
- Presser foot for vertical bartacking is supplied with the unit as an accessory.

STANDARD LIQUID CRYSTAL PANEL (NEW)
- The operation panel IP-420U is used in combination with the active tension, the needle thread tension can be set on a stitch-by-stitch basis. This helps eliminate undesired thread tension variations at a multi-layered part of a material or with sewing direction, thereby contributing to upgraded seam quality.
- Functional settings, such as pattern numbers and needle thread tensions can be established through the operation panel with ease. Distance between holes in a button can be easily changed by means of pattern enlargement/reduction feature.
- Standard sewing patterns can be assigned to pattern keys P1 to P50. Any of the sewing patterns assigned to the P1 to P25 pattern keys can be activated with a touch of the corresponding key. This means that workability is improved by assigning 25 sewing patterns that are most frequently used to those pattern keys.
- As many as 99 different cycle sewing patterns, each of which combines a maximum of 99 different sewing patterns, can be stored in the memory.

Auto-lifter mechanism utilizing a system.
- The machine is provided as standard with auto-lifter that uses a stepping-motor system. This helps reduce operator fatigue.
- It is also possible to change over the stroke of the auto-lifter from a one-step stroke to a double-step stroke, which offers easier positioning of a material on the machine. For the double-step stroke, an intermediate stopping height can be established on the operation panel.
- The work clamp foot lift can be set to a maximum of 17mm. (Standard 14mm)

Oil stains are eliminated.
- Thanks to our advanced dry-head technology, the frame (needle bar and thread take-up) no longer requires lubrication. This prevents the material from being stained with lubricating oil.
- Just a small quantity of clean oil is supplied from the oil tank to the hook.

Eco-friendly power saving
- An encoder is installed in the pulse motor, thereby achieving substantially improved power-consumption saving.
- The machine is provided as standard with auto-lifter that allows the operator to visually check the needle entry points.
- Since the machine is provided with an active tension mechanism, it is able to set a needle thread tension that matches various sewing conditions (such as thread, material and sewing speed) on the operation panel, store the data in memory and reproduce it.

The machine is provided as standard with auto-lifter that uses a stepping-motor system. This helps reduce operator fatigue.

The direct-drive head (with no belt), which is directly connected to a compact AC servomotor, achieves outstanding. This head helps create a comfortable working environment with reduced vibration and noise.

The arm section of the machine head is fitted with a hand pulley. This allows the operator to visually check the needle entry points.

Needle thread grasping mechanism helps produce consistent knot tying at the beginning of sewing. (This device has been factory-set to "invoking prohibited" status at the time of delivery.)

The machine is provided as standard with 51 different sewing patterns. The machine permits easy changeover of sewing patterns for effortless execution of an inexhaustible range of sewing specifications. *For LK-1900B, the standard no. of sewing patterns is 50.

The LK-1900B is also able to sew buttons using the same data used for the LK-1900 (EP-ROM).

In cases where the needle entry point for button sewing is to be corrected, the sewing starting point can be corrected without the adjustment of the relevant mechanism.

The needle thread tension can be separated according to stitching type or portion of a seam, such as the beginning part of the seam, base stitched part, zigzag stitched part and end of the seam (fastening stitch).

When the operation panel IP-420U is used in combination with the active tension, the needle thread tension can be set on a stitch-by-stitch basis. This helps eliminate undesired thread tension variations at a multi-layered part of a material or with sewing direction, thereby contributing to upgraded seam quality.

The operation panel IP-420U is used in combination with the active tension, the needle thread tension can be set on a stitch-by-stitch basis. This helps eliminate undesired thread tension variations at a multi-layered part of a material or with sewing direction, thereby contributing to upgraded seam quality.
Computer-controlled, High-speed Bartacking Machine with bird’s nest preventing / shorter-thread remaining functions

LK-1900BB

The world’s first

Thanks to the Bird’s nest preventing/shorter-thread remaining functions, manual thread-nipping is no longer required and gives soft and smooth feeling on the bartaking sections where directly contact skin such as brassieres and tank tops.

LK-1900B

The machine achieves sewing speed of 3,200st/min. The machine’s thread-trimming etc. have been increased to significantly shorten total cycle time.

LK-1900B-SS

LK-1900B-BS

LK-1900BB

LK-1901B

LK-1901B-SS

LK-1902B

LK-1902B-SS

LK-1902B-HS

The material drawing mechanism can be switched to ON/OFF.

Three different sewing patterns are prepared to enable easy switchover of sewing sizes. If the sewing patterns are assigned to the pattern keys on the operation panel, the sewing patterns can be called up or changed with single-key operation.

The machine sews the most optimally suited bartacks on eyelet buttonholes on the front bodices of garments and straight buttonholes that differ in stitch number and size on jacket lapels, thereby improving the finished quality of sewing products.

The machine is provided with a material-drawing mechanism which draws the right and left parallel portions of an eyelet buttonhole near to one another.

The machine performs bartacking with the right and left parallel portions of the eyelet buttonhole drawn near to one another after the buttonhole is clamped under the work clamp foot, thereby finishing highly durable and well-tensed eyelet buttonholes.

The sewing pattern best suited to the sewing product to be bartacked can be selected by single-key operation.

Three different sewing patterns are prepared to enable easy switchover of sewing sizes. If the sewing patterns are assigned to the pattern keys on the operation panel, the sewing patterns can be called up or changed with single-key operation.

The sewing pattern best suited to the sewing product to be bartacked can be selected by single-key operation.

The material drawing mechanism can be switched to ON/OFF.

The material drawing amount can be adjusted to 3mm at maximum. The material drawing mechanism can be switched ON/OFF in accordance with the setting of the memory switch. With these features, the material drawing mechanism can be used with greater flexibility.
# TABLE OF THE STANDARD PATTERNS

<table>
<thead>
<tr>
<th>No.</th>
<th>Stitch diagram</th>
<th>Number of stitches</th>
<th>Sewing size (mm)</th>
<th>Number of work clamp foot</th>
<th>Large bartacking</th>
<th>Small bartacking</th>
<th>Large bartacking</th>
<th>Linear bartacking</th>
<th>Lengthwise bartacking</th>
<th>Lengthwise linear bartacking</th>
<th>Round bartacking</th>
<th>Radial tacking</th>
<th>Knit goods bartacking</th>
<th>Large size bartacking</th>
<th>Semilunar bartacking</th>
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</tbody>
</table>

(Note 1) Sewing size shows the dimensions when the scale rate is 100%.

2. Refer the No. of work clamp foot to the separate table of work clamp foot.

3. For No. 22, modify the work clamp foot blank for use.

4. Use the patterns with ✽ marks for sewing denim.

5. No. 51 is the pattern No. 1 without thread clamp.

6. For LK-1900BB, the pattern No. 51 is not selectable.
### TABLE OF THE WORK CLAMP FOOT

<table>
<thead>
<tr>
<th>No. of work clamp foot</th>
<th>1</th>
<th>2</th>
<th>3</th>
<th>4</th>
<th>5</th>
<th>6</th>
<th>7</th>
<th>8</th>
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</thead>
<tbody>
<tr>
<td>Work clamp foot</td>
<td>13016562(arrow)</td>
<td>13548557(arrow)</td>
<td>13542964(arrow)</td>
<td>13548515(arrow)</td>
<td>13542461(arrow)</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

| Work clamp foot        | 14116107 | 14116404 | 14116800 | 14116305 | 14116206 |
| Feed plate             | 14116209 | 13548003 | 13545803 | 14116602 |

| Finger guard           | 26224204 | 13548300 |

#### Installation
- Install a finger guard suitable for each work clamp foot when replacing the work clamp foot.

### OPTION

#### Simple work clamp kit for the LK-1900B Series
- Conventionally, the front plate has to be removed to change the work clamp. With the new work clamp kit, the work clamp can be changed without removing the plate.

- The lever for lifting the work clamp can be independently slid back and forth.
- The machine parts can be adjusted and replaced entirely by hand without screwdrivers or other tools. Changing parts is now a “clean-hands” procedure.

#### Foot pedal for standing work (optional)
- 2-pedal unit for standing work
  - [Part No. M65205800A0]
- PK-57
  - [Part No. GPK570018B0]

#### IP-420U Operation panel provided with programmable functions
- The IP-420U is a new operation panel configured with a “input function” not available in standard panel.
  - [Part No. M85125900A0]
  - [Part No. M85125900A0]

**IP-420U** should be ordered as a part. SP-420U: 41001488B1
**TABLE OF THE OPTIONAL PARTS**

<table>
<thead>
<tr>
<th>Part name</th>
<th>Type</th>
<th>Feature</th>
<th>Part No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Feed plate blank</td>
<td>Without knurl/with plating</td>
<td>Sewing area 20×40</td>
<td>14120109</td>
</tr>
<tr>
<td></td>
<td>With knurl/with plating</td>
<td>Sewing area 20×40</td>
<td>14120307</td>
</tr>
<tr>
<td></td>
<td>Without knurl/stainless</td>
<td>Sewing area 20×40</td>
<td>14120505</td>
</tr>
<tr>
<td></td>
<td>steel</td>
<td>Sewing area 30×40</td>
<td>40021855</td>
</tr>
<tr>
<td></td>
<td>Without knurl/with plating</td>
<td>Sewing area 30×40</td>
<td>40021856</td>
</tr>
<tr>
<td></td>
<td>With knurl/with plating</td>
<td>Sewing area 30×40</td>
<td>40021857</td>
</tr>
<tr>
<td></td>
<td>Without knurl/stainless</td>
<td>Sewing area 30×40</td>
<td>40021858</td>
</tr>
<tr>
<td></td>
<td>steel</td>
<td>Sewing area 30×40</td>
<td>40021859</td>
</tr>
<tr>
<td>Work clamp foot</td>
<td>Face plate for presser blank</td>
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<td>14121263</td>
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<tr>
<td>face plate (asm.)</td>
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<tr>
<td>Work clamp foot blank</td>
<td>With knurl/with plating</td>
<td></td>
<td>40021869</td>
</tr>
<tr>
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<td>left</td>
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<tr>
<td>Needle hole guide</td>
<td>A=1.6 B=2.6</td>
<td>With relief slit Standard type</td>
<td>D2426B20000</td>
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<td></td>
<td>A=1.6 B=2.0</td>
<td>Without relief slit F and M types</td>
<td>D2426B20C00</td>
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<td></td>
<td>A=2.3 B=4.0</td>
<td>Without relief slit for heavy-weight material</td>
<td>14109067</td>
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<td>Finger guard (1)</td>
<td>A=65.5 B=64</td>
<td>Active tension</td>
<td>13533104</td>
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<td></td>
<td>A=69 B=74</td>
<td>For extra-large bartacking</td>
<td>13548300</td>
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<td>Finger guard (2)</td>
<td>A=66.5 B=43</td>
<td>For lengthwise bartacking</td>
<td>13573407</td>
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<tr>
<td>Finger guard (3)</td>
<td>A=21.5 B=35.5 L=67</td>
<td>For lengthwise bartacking</td>
<td>14135035</td>
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<tr>
<td>Finger guard (4)</td>
<td>A=21.5 B=35.5 L=58.5</td>
<td>For specially ordered work clamp</td>
<td>14120000</td>
</tr>
</tbody>
</table>

**SPECSIFICATIONS**

**Model name**

<table>
<thead>
<tr>
<th>LK-1900B-SS</th>
<th>LK-1900B-HS</th>
<th>LK-1900B-FS</th>
<th>LK-1900B-MS</th>
<th>LK-1900B-WS</th>
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</thead>
<tbody>
<tr>
<td>Application</td>
<td>Standard</td>
<td>For foundation</td>
<td>For foundation</td>
<td>For heavy-weight materials</td>
</tr>
<tr>
<td>Max. sewing speed</td>
<td>3,200sti/min</td>
<td>3,500sti/min</td>
<td>3,000sti/min</td>
<td>2,700sti/min</td>
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<tr>
<td>Sewing area</td>
<td>30mm (L) × 40mm (W)</td>
<td>30mm (L) × 40mm (W)</td>
<td>30mm (L) × 40mm (W)</td>
<td>30mm (L) × 40mm (W)</td>
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<tr>
<td>Stitch length</td>
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<td>0.1~10mm (0.1mm step)</td>
<td>0.1~10mm (0.1mm step)</td>
<td>0.1~10mm (0.1mm step)</td>
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<tr>
<td>Needle bar stroke</td>
<td>41.2mm</td>
<td>41.3mm</td>
<td>41.4mm</td>
<td>41.5mm</td>
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<tr>
<td>Lift of the work clamp foot</td>
<td>Standard (by using the reverse-rotation needle-up function)</td>
<td>Standard (by using the reverse-rotation needle-up function)</td>
<td>Standard (by using the reverse-rotation needle-up function)</td>
<td>Standard (by using the reverse-rotation needle-up function)</td>
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<tr>
<td>Auto-timer</td>
<td>Provided as standard (stepping motor type)</td>
<td>Provided as standard (stepping motor type)</td>
<td>Provided as standard (stepping motor type)</td>
<td>Provided as standard (stepping motor type)</td>
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<tr>
<td>Needle thread tension</td>
<td>Active tension (electronic thread tension control system)</td>
<td>Active tension (electronic thread tension control system)</td>
<td>Active tension (electronic thread tension control system)</td>
<td>Active tension (electronic thread tension control system)</td>
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<tr>
<td>Hook (at the time of delivery)</td>
<td>DP×17 (14L)</td>
<td>DP×17 (14L)</td>
<td>DP×17 (14L)</td>
<td>DP×17 (14L)</td>
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<td>Number of stitches that can be stored in memory</td>
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<td>Max. 20,000 stitches</td>
<td>Max. 20,000 stitches</td>
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<td>Applicable pattern number</td>
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<td>50 patterns</td>
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<tr>
<td>Number of data that can be input</td>
<td>200 patterns (for up to 150 patterns, sewing data can be added.)</td>
<td>200 patterns (for up to 150 patterns, sewing data can be added.)</td>
<td>200 patterns (for up to 150 patterns, sewing data can be added.)</td>
<td>200 patterns (for up to 150 patterns, sewing data can be added.)</td>
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<tr>
<td>Enlarging/Reducing facility</td>
<td>20~200% (1% step), Pattern enlargement/reduction can be done by increasing/decreasing the stitch length</td>
<td>20~200% (1% step), Pattern enlargement/reduction can be done by increasing/decreasing the stitch length</td>
<td>20~200% (1% step), Pattern enlargement/reduction can be done by increasing/decreasing the stitch length</td>
<td>20~200% (1% step), Pattern enlargement/reduction can be done by increasing/decreasing the stitch length</td>
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<td>Internal-organs memory</td>
<td>Internal-organs memory</td>
<td>Internal-organs memory</td>
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<td>Machine head (include motor) &amp; Control box</td>
<td>42kg &amp; 5.6kg</td>
<td>42kg &amp; 5.6kg</td>
<td>42kg &amp; 5.6kg</td>
<td>42kg &amp; 5.6kg</td>
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**Silicone oil pipe**

- The silicone oil pipe are the parts which cool the heat of a needle.
- Type: Part No.
  - Silicone oil pipe: 40040910
  - Rubber plug: 1A1050640R0
  - Oil felt: 13501705
  - Silicone oil thread guide: B1127280000
  - Screw 11/94 - 10 L5: SS4116015SP
  - Silicone oil pouring hole: 13501408
WHEN YOU PLACE ORDERS
Please note when placing orders, that the model name should be written as follows:

**Machine head**

**Bartacking**

**LK1900B**

- **Application**
  - Standard: S
  - For heavy-weight materials: H
  - For foundation: F
  - For knits and knitted materials: M
  - With large hook for heavy-weight materials: W
  - Bird’s nest preventing / Shorter-thread remaining functions: B

- **Head type**
  - Standard: S
  - Bird’s nest preventing / Shorter-thread remaining functions: B

- **Code Work clamp foot**
  - Standard: S

- **Attachment**
  - Not provided: 000

- **Power supply**
  - 3-phase: 200~240V

- **Operation panel**
  - Standard panel: SS

**Control box**

- **Head type**
  - Standard: S
  - Bird’s nest preventing / Shorter-thread remaining functions: B

- **Code Work clamp foot**
  - Standard: S

- **Attachment**
  - Not provided: 000

- **Power supply**
  - 3-phase: 200~240V
  - Single-phase: CE 200~240V (not provided with power switch)

**Eyelet buttonhole bartacking**

**LK1901B**

- **Application**
  - Standard: S

- **Code Work clamp foot**
  - Standard: S

- **Attachment**
  - Not provided: 000

**Belt-loop attaching**

**LK1902B**

- **Application**
  - Standard: S
  - For heavy-weight materials: H

- **Code Work clamp foot**
  - Standard: S

- **Attachment**
  - Not provided: 000

- **Power supply**
  - 3-phase: 200~240V

- **Operation panel**
  - Standard panel: SS

- **Option panel**
  - IP420U

**JUKI ECO PRODUCTS**

The LK-1900B Series is an eco-friendly product which complies with JUKI ECO PRODUCTS standards for protecting the environment:

- The sewing machine complies with the “Juki Group Green Procurement Guidelines” on the use of hazardous substances, which is stricter than other restrictions, such as those of the RoHS Directive.
- This sewing machine reduces power consumption by 15% as compared with the conventional models.

For details of JUKI ECO PRODUCTS, refer to: http://www.juki.co.jp/eco_e/index.html

The RoHS Directive is an EU Directive limiting the use of 6 hazardous substances (lead, hexavalent chromium, mercury, cadmium, PBB and PBDE) in electrical and electronic equipment. The Juki Green Procurement Guideline is the voluntarily established criteria to eliminate not only the aforementioned six substances, but also other ones which also adversely affect the environment.

To order, please contact your nearest JUKI distributor.

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