

**JUKI®**

# **MEB-3200 Series**

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



# **MEB-3200 Series**

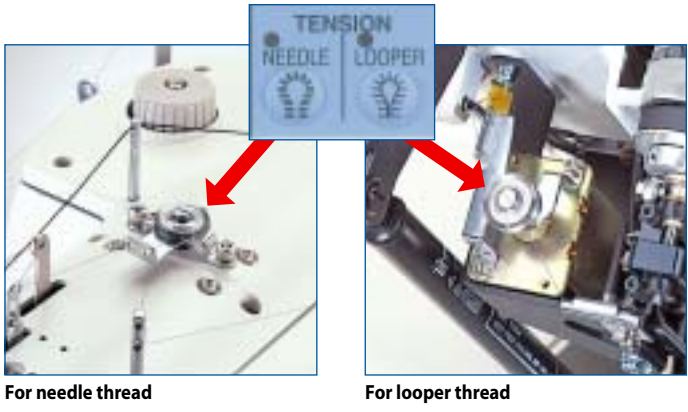
*The world's first machine that incorporating an active tension mechanism  
(computer-controlled thread tension mechanism)*

**THE FIRST  
IN THE  
WORLD!**

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

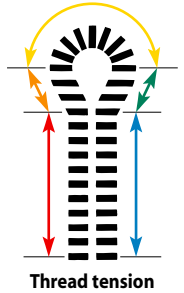
Needle and looper thread tensions can be digitally established on the operation panel according to sewing conditions. Data can be registered on a pattern-by-pattern basis to easily reproduce the same sewing conditions.

- 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.



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.



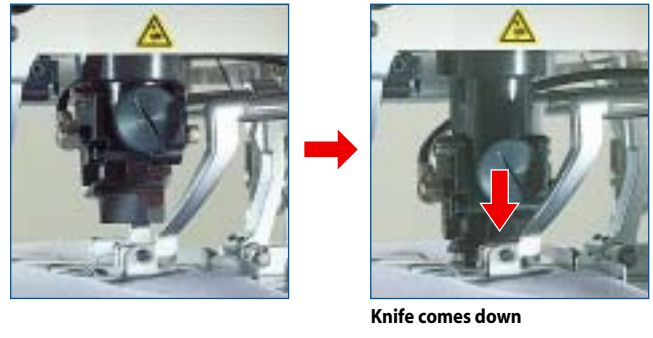
Threading work can be more easily.

- 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 suit the material 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



MEB-3200JS

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

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





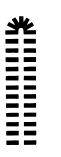
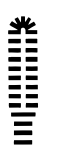
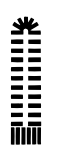
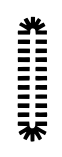


## HIGHER FLEXIBILITY

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.

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

							
Buttonhole without a bartack *	Buttonhole with a taper bar **	Buttonhole with a straight bartack **	Buttonhole with a round bartack **	Buttonhole without a bartack *	Buttonhole with a taper bar *	Buttonhole with a straight bartack *	Buttonhole with a round bartack *
Eyelet buttonhole				Straight buttonhole			

## 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.
- MEB-3200JS for jeans and MEB-3200CS for cotton pants and working uniform are able to cut the needle thread, looper thread and gimp to leave a shorter thread on the material. In addition, MEB-3200TS for trousers is able to cut the needle thread and looper thread to leave a shorter thread on the material. This eliminates the need for thread picking by hand, thereby increasing both efficiency and productivity.



Longer thread type  
(MEB-3200SS/RS)



Shorter thread type  
(MEB-3200JS/CS/TS)

### Shortened machine time.

- The machine runs at a maximum sewing speed of 2,200rpm to reduce the machine time.

## 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-3200JS

### 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.



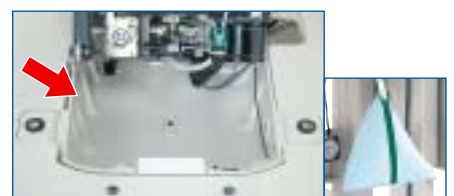
### Excellent maintainability.

- 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.



### 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



## SUBCLASS

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

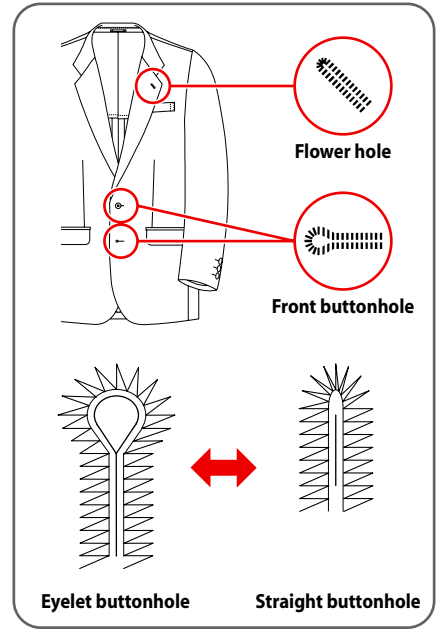
- The multi-cutting device incorporates a separate cloth cutting knife with two sections of blade — one intended for the eyelet sections of buttonholes and one intended for straight sections. When sewing men's wear, the machine can sew eyelet buttonholes on a front body and straight buttonholes on a 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



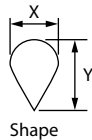
### REPLACEMENT GAUGES

#### 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
			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
		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-3200TS□□A for trousers

- The machine trims the needle thread and looper thread remaining on the material and can sew buttonholes on trousers in a single cycle up to the completion of bartacking. This increases both efficiency and productivity by eliminating thread nipping work. \*Gimps are not applicable.
- The flat knife cover facilitates the placement of a hip pocket bag on the machine.
- The machine is equipped as standard with a needle thread clamp device.



### 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



# 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	J	C	T	
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
Throat plate JA (standard)	320-43424	—	—	—	—	—	Nm120 ~ Nm130
Throat plate JB (for semi-wide stitch bite)	320-42830	—	—	○	—	—	Nm90 ~ Nm110
Throat plate JC (for wide stitch bite)	320-43135	—	—		—	—	Nm90 ~ Nm110
Throat plate JD (standard)	320-43622	—	—		—	—	Nm90 ~ Nm100
Throat plate JE (standard)	320-43523	—	—		○	—	Nm110 ~ Nm120
Throat plate JF (standard)	320-43325	—	—	—	—	—	Nm90 ~ Nm100
Throat plate TE	320-43713	—	—	—	—	○	Nm100 ~ Nm110

## Work clamp, complete

Part name	Part No.	Application				
		S	R	J	C	T
Compensating work clamp, complete S, for eyelet buttonholes	320-28458	—	—		○	—
Compensating work clamp, complete M, for eyelet buttonholes	320-28854	—	—	○		—
Compensating work clamp, complete L, for eyelet buttonholes	320-29050	—	—			—
Work clamp, complete for longitudinal buttonholes	320-31064	○	—	—	—	—

## Work clamp

Work clamp (left)						
Part name	Part No.	Application				
		S	R	J	C	T
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	J	C	T
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			○*		

## Presser support plate

\* Provided as standard for JE

Presser support plate (left)						
Part name	Part No.	Application				
		S	R	J	C	T
Presser support plate for eyelet buttonholes	320-27104	○	○	—	—	—
Presser support plate J, M for eyelet buttonholes	320-28912	—	—	○		—
Presser support plate C, S for eyelet buttonholes	320-28516	—	—		○	—
Presser support plate L for eyelet buttonholes	320-29100	—	—			—
Presser support plate for straight buttonholes	320-29506	—	—	—	—	—
Presser support plate for eyelet buttonholes	140-11506	—	—	—	—	○
Presser support plate for straight buttonholes	140-13700	—	—	—	—	—

Presser support plate (right)						
Part name	Part No.	Application				
		S	R	J	C	T
Presser support plate for eyelet buttonholes	320-27005	○	○	—	—	—
Presser support plate J, M for eyelet buttonholes	320-28805	—	—	○		—
Presser support plate C, S for eyelet buttonholes	320-28409	—	—		○	—
Presser support plate L for eyelet buttonholes	320-29001	—	—			—
Presser support plate for straight buttonholes	320-29407	—	—	—	—	—
Presser support plate for eyelet buttonholes	140-11407	—	—	—	—	○
Presser support plate for straight buttonholes	140-13601	—	—	—	—	—

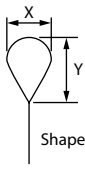
## Cloth cutting knife

For eyelet buttonhole								
Part No.	Shape (mm)		Max. cutting length (mm)	Application				
	X	Y		S	R	J*	C*	T*
140-41206	2.9	4.4	38	○	○	L	L	—
320-63604	2.9	4.4	24			S	○	○
320-63703	2.9	4.4	32				○	M
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					—

J, C Type ⇒ L: Accessory for compensating work clamp L, complete, for eyelet buttonholes (optional)

J type ⇒ S: Accessory for compensating work clamp S, complete, for eyelet buttonholes (optional)

C Type ⇒ M: Accessory for compensating work clamp M, complete, for eyelet buttonholes (optional)



For straight buttonhole								
Part No.	Shape (mm)		Max. cutting length (mm)	Application				
	X	Y		S	R	J*	C*	T*
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	J*	C*	T*
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	J*	C*	T*
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	J*	C*	T*
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					

\* For the J, C, T type, use cloth-cutting knife and knife guard that are equal in length to the maximum sewing length or shorter. (Maximum sewing length ⇒ S: 24mm, M: 32mm, L: 40mm)

## Left looper, left spreader

Applicable zigzag width (mm)	Left looper	Left spreader	Application				
	Part No.	Part No.	S	R	J	C	T
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	400~2,200rpm (100rpm step)				
Sewing length	10~38mm (with thread trimmer) 10~50mm (in case looper thread trimming device is removed)*1		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 The figures in ( ) parentheses are in case of taper bar	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 (2.3mm)		2.6~4.0mm*2 (2.5mm)	2.0~3.2mm*2 (2.5mm)	2.0~3.2mm (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 6d <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 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.

\*2 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
Trousers*	T

Power supply		Code
Single-phase	220~240V	K
3-phase	220~240V	D
	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*	M

\* When option category M (multi-cutting device, needle thread clamp device) is selected, S and R are the only sewing specification category available for selection (men's and ladies' wear).

● 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.



### JUKI CORPORATION HEAD OFFICE

Juki Corporation operates an environmental management system to promote and conduct the following as the company engages in the research, development, design, sales, distribution, and maintenance of industrial sewing machines, household sewing machines, industrial robots, etc., and in the provision of sales and maintenance services for data entry systems:  
 ①The development of products and engineering processes that are safe to the environment  
 ②Green procurement and green purchasing  
 ③Energy conservation (reduction in carbon-dioxide emissions)  
 ④Resource saving (reduction of papers purchased, etc.)  
 ⑤Reduction and recycling of waste  
 ⑥Improvement of logistics efficiency (modal shift and improvement of packaging, packing, etc.)

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