

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

MEB-3200SS

(for men's and ladies' wear)

MEB-3200RS

(for combined use for lateral and longitudinal buttonholing:
for men's and ladies' wear)

MEB-3200RD

(for combined use for lateral and longitudinal buttonholing:
for men's and ladies' wear, lateral-installation machine head)

MEB-3200JS

(for jeans)

MEB-3200CS

(for cotton pants and working wear)

JUKI®

*Direct
Drive
Innovation!*

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



MEB-3200RS

OUTSTANDING SEAM QUALITY, PRODUCTIVITY, AND OPERABILITY.

Next-generation computer-controlled eyelet buttonholing machine
that brings together a host of advanced sewing capabilities !

LIST OF THE REPLACEMENT GAUGES

● THROAT PLATE

Part name	Part No.	Application				Needle size
		S	R	J	C	
Throat plate A (standard)	320-42707	○	○	—	—	Nm90~Nm110
Throat plate B (for semi-wide stitch bite)	320-42905	—	—	—	—	Nm90~Nm110
Throat plate C (for wide stitch bite)	320-43002	—	—	—	—	Nm90~Nm110
Throat plate D (for narrow stitch bite)	320-43200	—	—	—	—	Nm90~Nm110
Throat plate JA (standard)	320-43408	—	—	○	—	Nm120~Nm130
Throat plate JB (for semi-wide stitch bite)	320-42814	—	—	—	—	Nm90~Nm110
Throat plate JC (for wide stitch bite)	320-43119	—	—	—	—	Nm90~Nm110
Throat plate JD (standard)	320-43606	—	—	—	—	Nm90~Nm110
Throat plate JE (standard)	320-43507	—	—	—	○	Nm110~Nm120
Throat plate JF (standard)	320-43309	—	—	—	—	Nm90~Nm100

● WORK CLAMP, COMPLETE

Part name	Part No.	Application			
		S	R	J	C
Compensating work clamp, complete S, for eyelet buttonholes	320-28458	—	—	—	○
Compensating work clamp, complete M, for eyelet buttonholes	320-28554	—	—	○	—
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
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	—	—	—	○

Work clamp (right)					
Part name	Part No.	Application			
		S	R	J	C
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	140-28607	—	—	○	—
Compensating work clamp S, 24mm for eyelet buttonholes	320-28201	—	—	—	○

[○ : Provided as standard No symbol : Optional]
 [△ : Accessory — : Installation is invalid.]

● CLOTH CUTTING KNIFE

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

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*
140-41404	0	0	38	△	△		
320-65302	0	0	24				
320-65401	0	0	32				

● PRESSER SUPPORT PLATE

Part name	Part No.	Application			
		S	R	J	C
Presser support plate (left) for eyelet buttonholes	320-27104	○	○	—	—
Presser support plate J (left) M for eyelet buttonholes	320-28904	—	—	○	○
Presser support plate (right) for eyelet buttonholes	320-27005	○	○	—	—
Presser support plate J (right) M for eyelet buttonholes	320-28805	—	—	○	○
Presser support plate (left) for straight buttonholes	320-29506	—	—	—	—
Presser support plate (right) for straight buttonholes	320-29407	—	—	—	—

● KNIFE GUARD

For eyelet buttonhole					
Size (mm)	Part No.	Application			
		S	R	J*	C*
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*
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	—	—	—	—

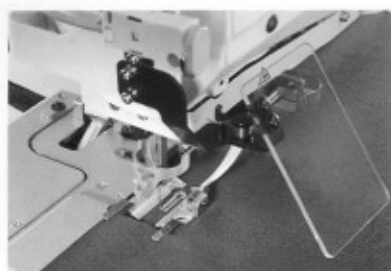
* For the J, C type, use a cloth-cutting knife and knife guard that are equal in length to the maximum sewing length or shorter.
(Maximum sewing length ⇒ S: 24mm, M: 32mm, L: 40mm)



MEB-3200SS



MEB-3200JS

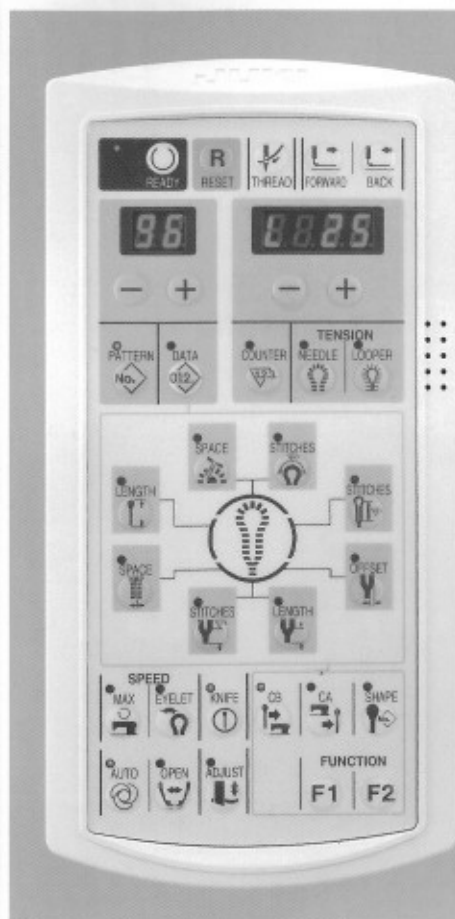


MEB-3200RD

(The work clamps are the same as those for the MEB-3200RS.)

EASY-TO-OPERATE MULTI-FUNCTIONAL OPERATION PANEL

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



- The operation panel permits hand-held manipulation.

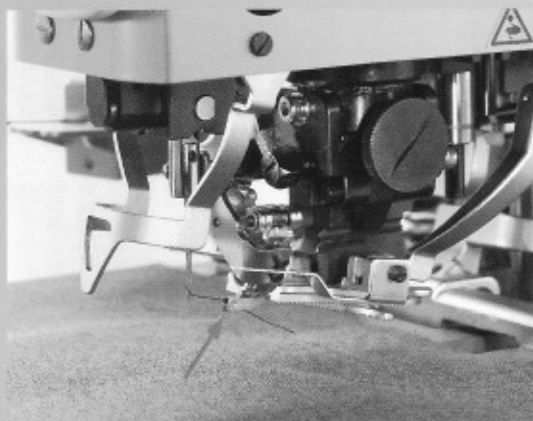
LIST OF MAJOR FUNCTIONS OF THE OPERATION PANEL

Item	Function
Needle threading	The needle bar turns by 180 degrees to allow the operator to thread the machine head from this side of the machine.
Forward	Moves the feed forward stitch by stitch.
Backward	Moves the feed backward stitch by stitch.
Pattern No.	Displays and specifies a pattern number.
Data No.	Displays and specifies a data number.
Counter	Can be used as a counter for the number pieces. (The counter can either count up or count down.)
Needle thread tension	Displays and specifies data on needle thread tension.
Looper thread tension	Displays and specifies data on looper thread tension.
Programming of data on detailed stitching shape	Specifies data on the respective buttonhole shape sections. Cutting length, number of parallel buttonhole sections, number of buttonhole eyelet sections, cutting space, eyelet section space, taper bar length, number of taper bar sections, taper bar offset.
Sewing speed	Specifies a sewing speed.
Sewing speed for eyelet section	Specifies a reduced speed for eyelet section.
Knife ON/OFF	Switches between operation with and without the knife.
Cut-before knife	Establishes data on the cut-before knife.
Cut-after knife	Establishes data on the cut-after knife.
Knife No.	Selects the type number of knife to be used.
Automatic operation	Switches between automatic operation and manual operation.
Material-opening device	Selects the mode used to hold open the material-opening device.
Knife adjustment	Enters the cloth cutting knife adjusting mode.
Function	Activates the desired data setting using the memory switch.

NEEDLE THREAD CLAMP DEVICE

- The machine with the needle thread clamp device is available as optional model.
- It tucks the needle thread in the seam, thereby eliminating thread end securing work.
- It clamps the needle thread to form a beautiful seam without fail from the first stitch.

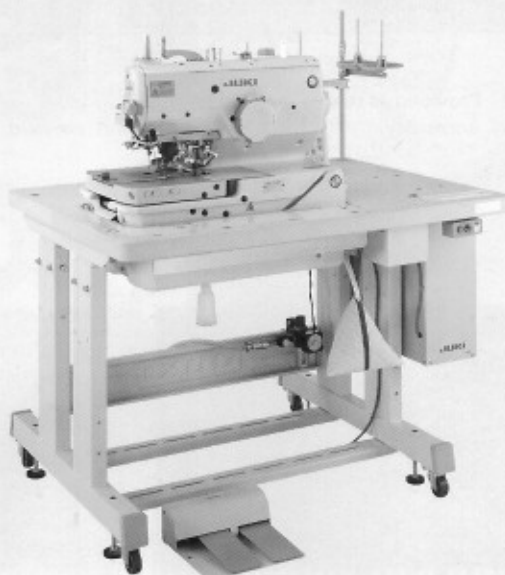
* Optional part: Part No.: 320-24465



MEB-3200RD

for combined use for lateral and longitudinal buttonholing:
For men's and ladies' wear
(lateral-installation type machine head)

- When sewing longitudinal buttonholes on longer materials, the ability to move the material to the right or left guarantee increased efficiency.

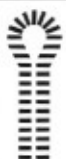




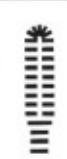




HIGHER FLEXIBILITY

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 with a taper bar	Buttonhole with a straight bartack	Buttonhole with a round bartack		Buttonhole with a taper bar	Buttonhole with a straight bartack	Buttonhole with a round bartack
EYELET BUTTONHOLE				STRAIGHT BUTTONHOLE			

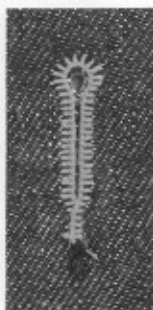
HIGHER PRODUCTIVITY

Reliable overall thread-trimming mechanism.

- The MEB-3200SS/RS/RD 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.
- The MEB-3200JS for jeans cuts needle threads, looper threads and gimps to leave shorter threads on the material. This eliminates the need for thread picking by hand, thereby increasing both efficiency and productivity.



Longer thread type
(MEB-3200SS/RS/RD)



Shorter thread type
(MEB-3200JS/CS)

Shortened machine time.

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

The machine is able to perform cycle sewing.

- For cycle sewing, different thread programs can be registered. As many as 15 different patterns (consisting of 1 to 15 steps) can be stored in one program.

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 or MEB-3200RD 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-3200RS

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.



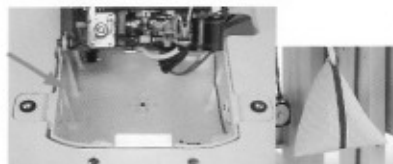
Excellent maintainability.

- 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

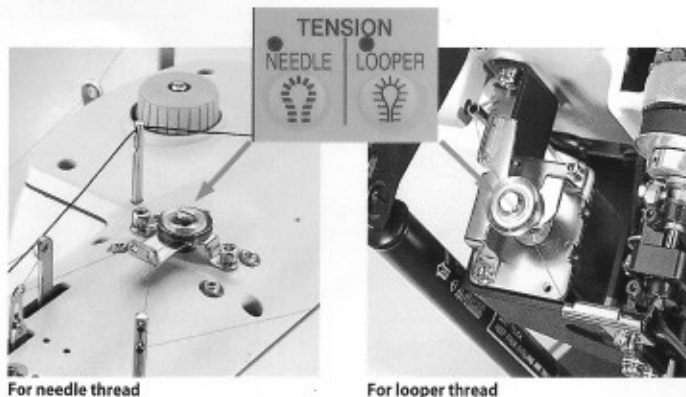
**THE FIRST
IN THE
WORLD!**

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.

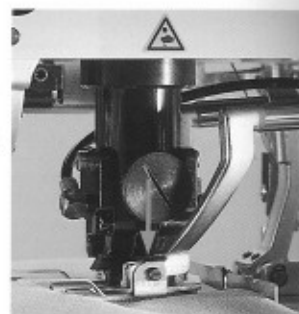
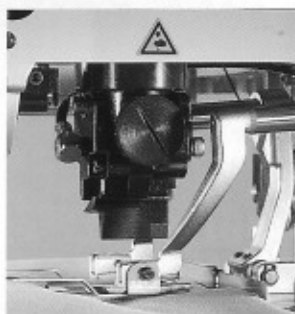


- Since fewer parts need to be threaded, the machine can be threaded more quickly and easily than conventional buttonholing machines.

EXCELLENT CAPABILITIES TO HELP IMPROVE SEAM QUALITY

Vertically driven cloth cutting knife controlled by a stepping motor.

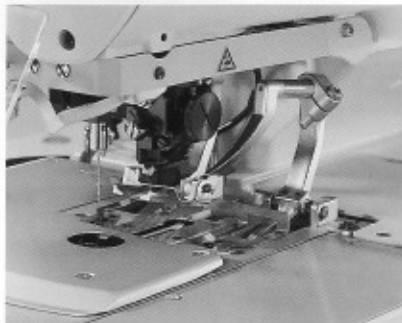
- The knife is controlled by a stepping motor. This enables easy adjustment of the knife pressure on the operation panel to suit the material to be used, thereby preventing irregular cutting.
- Data on knife pressure can be registered on pattern-by-pattern basis to establish the best-suited knife pressure 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.

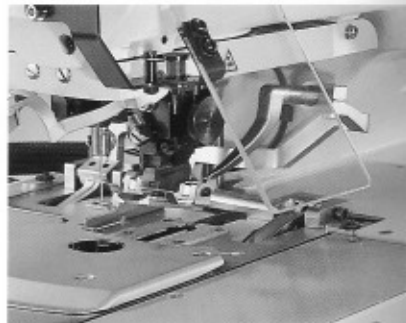
- The right and left work clamps are separately driven by independent air cylinders. With this mechanism, the work clamps reliably clamp materials of different thicknesses to prevent the materials from flopping.



MEB-3200SS



MEB-3200JS



MEB-3200RD

(The work clamps are the same as those for the MEB-3200RS.)

SPECIFICATIONS

Model name	MEB-3200SS	MEB-3200RS	MEB-3200RD	MEB-3200JS	MEB-3200CS
Application	For men's and ladies' wear	For combined use for lateral and longitudinal buttonholing: for men's and ladies' wear		For jeans	For cotton pants and working wear
Thread trimming style	Longer remaining thread			Shorter remaining thread	
Table stand	Standard	Standard	Lateral-installation machine head	Standard	Standard
Stitch system	1-needle, double chainstitch (with a 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)			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
				The figures in () parentheses are in case of taper bar	
Stitch bite width (at the time of delivery)	2.0~3.2mm				
	(2.3mm)	(2.3mm)	(2.3mm)	(2.5mm)	(2.5mm)
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 a stepping motor				
Method to drive the cloth-cutting knife	Vertically driven by stepping motor				
Needle (at the time of delivery)	D0×558 (Nm100) Nm90~Nm110			D0×558 (Nm120) Nm120~Nm130	D0×558 (Nm110) Nm110~Nm120
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 (5kgf/cm ²), 6Nℓ/min (8cycle/min)				
Power requirement and power consumption	Single-/3-phase, 550VA				
Dimensions	1,060mm (W)×790mm (D)×1,230mm (H)				
Total weight	185kg				

* 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

WHEN YOU PLACE ORDERS (complete)

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

MEB-3200 ☐ ☐ ☐ ☐

Application	Code
For men's and ladies' wear	S
For combined use for lateral and longitudinal buttonholing: for men's and ladies' wear	R
For jeans	J
For cotton pants and working wear	C

Table stand	Code
Standard	S
Lateral-installation machine head (with 2-pedal unit)	D

* The lateral-installation machine head (classified into category D) can be selected for the seam specification category R.

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

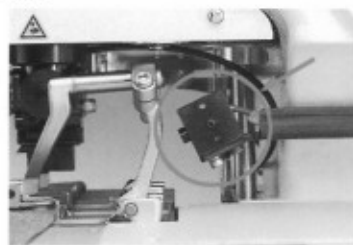
Option	Code
Not provided	Z
Needle thread clamp device	A

● To order, please contact your nearest JUKI distributor.

OPTIONS

● Marking lamp, asm. (Part No.: 320-70054)

When placing the material on the machine, accurate lateral positioning is guaranteed. (for S, J, C type)

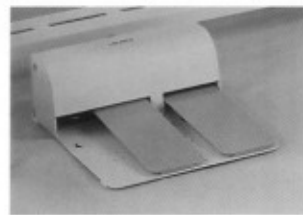


● Pedal switch, asm. (Part No.: M8590-513-0AA)

The work clamps can be lifted/lowered and the machine can be started using the pedal switch.

(The MEB-3200RD is provided as standard with the pedal switch, asm.)

* To use the pedal switch, asm., the pedal switch cable, asm. (M9014-620-0A0) will be also required.



JUKI
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TELEX : J22967
http://www.juki.co.jp

* 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.