

## Compact-type, Computer-controlled Cycle Machine for radial tacking with a punch

# AMS-206CSS-5250

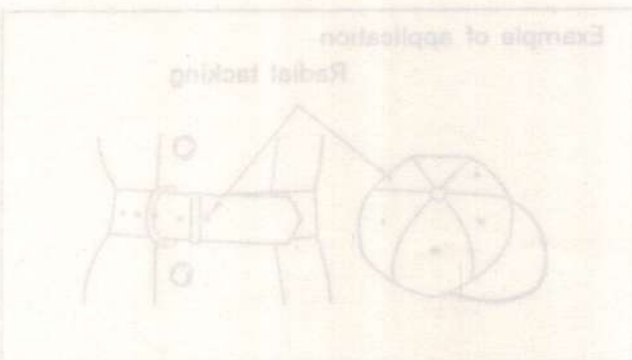
# INSTRUCTION MANUAL/PARTS LIST

## 1. Features

- 1) The single machine is capable of punching a hole in the material and radially tacking the punched hole.
- 2) The machine can punch a hole in the material and perform radial tacking continuously, thereby saving labor.
- 3) Radial tacking pattern can be enlarged/reduced.
- 4) The sewing machine is adaptable to almost all specifications of radial tacking by enlarging/reducing one of the three different kinds of standard service patterns.
- 5) One of the four different sizes of holes can be selected.
- 6) Four different sizes of holes including optional ones are available (replacing a punch and punch receiver). Furthermore, the size of hole can be changed in a short period of time.
- 7) The machine can also be used as the standard type of cycle machine.
- 8) The machine can be used as a computer-controlled cycle machine for shape tacking by changing over the DIP switch.

## 2. Specifications

- 1) Model : AMS-206CSS-5250
- 2) Model name : Compact-type, computer-controlled cycle machine for radial tacking with a punch
- 3) Application : Radial tacking on the cloth, balls of coats and one-piece dresses and baseball caps
- 4) Needle : DP x 5 #14



## Introduction

Congratulations on your purchase of a JUKI computer-controlled cycle machine for radial tacking with a punch AMS-206CSS-5250.

To get the most out of the many function of the machine 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.

This Instruction Manual only covers the mechanisms related to "radial tacking with a punch."

So, read this manual in combination with the Instruction Manual for the AMS-205C/206C so as to use the machine in the best operating conditions.

## I. General

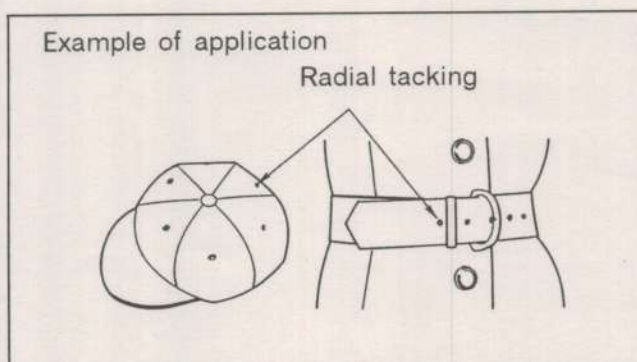
The AMS-206CSS-5250 is a computer-controlled, 1-needle, cylinder-bed, lockstitch machine for industrial use that is designed exclusively for radial tacking.

### 1. Features

- 1) This single machine is capable of punching a hole in the material and radially tacking the punched hole.  
The machine can punch a hole in the material and perform radial tacking continuously, thereby saving labor.
- 2) Radial tacking pattern can be enlarged/reduced.  
The sewing machine is adaptable to almost all specifications of radial tacking by enlarging/reducing one of the three different kinds of standard service patterns.
- 3) One of the four different sizes of holes can be selected.  
Four different sizes of holes including optional ones are available (replacing a punch and punch receiver). Furthermore, the size of hole can be changed in a short period of time.
- 4) The machine can also be used as the standard type of cycle machine.  
The machine can be used as a computer-controlled cycle machine for shape tacking by changing over the DIP switch.

### 2. Specifications

- 1) Model : AMS-206CSS-5250
- 2) Model name : Compact-type, computer-controlled cycle machine for radial tacking with a punch
- 3) Application : Radial tacking on the cloth belts of coats and one-piece dresses and baseball caps
- 4) Needle : DP x 5 #14





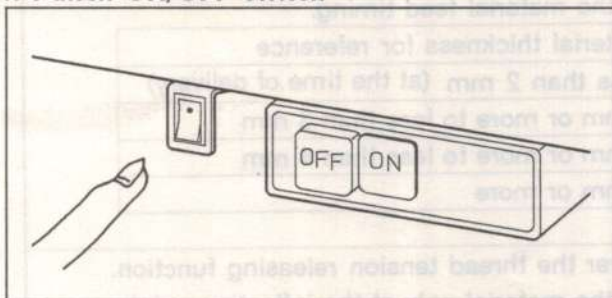
## II. Operation

### 1. Function of switches

[Caution] This section explains only the mechanisms which are different from the AMS-206C.

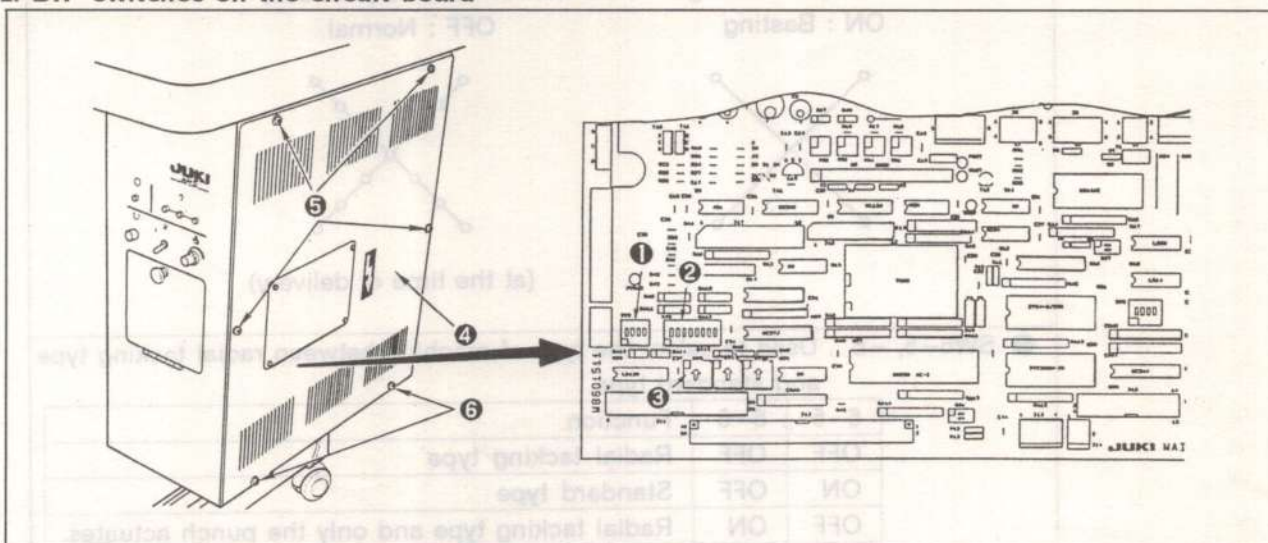
Refer to the Instruction Manual for the AMS-206C for the other mechanisms which are not covered by this manual.

#### 1. Punch ON/OFF switch




This switch is used to select either "punching a hole with the punch lowered, then tacking the hole" or "tacking without punching a hole" after depressing the start switch regardless of data contained in DATA ROM. (When the switch is set in the state as shown in the figure on the left, the punch comes down and makes a hole in the material, then tacks the punched hole.)

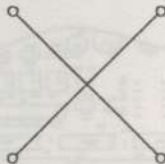
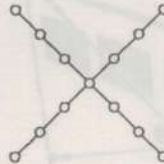

#### 2. DIP switches on the circuit board



Remove four screws ⑤ from control box cover ④, loosen two screws ⑥ and remove cover ④ from the control box. Now, you can see DIP switches ① through ③ on the main circuit board. The function of the switches are described below.

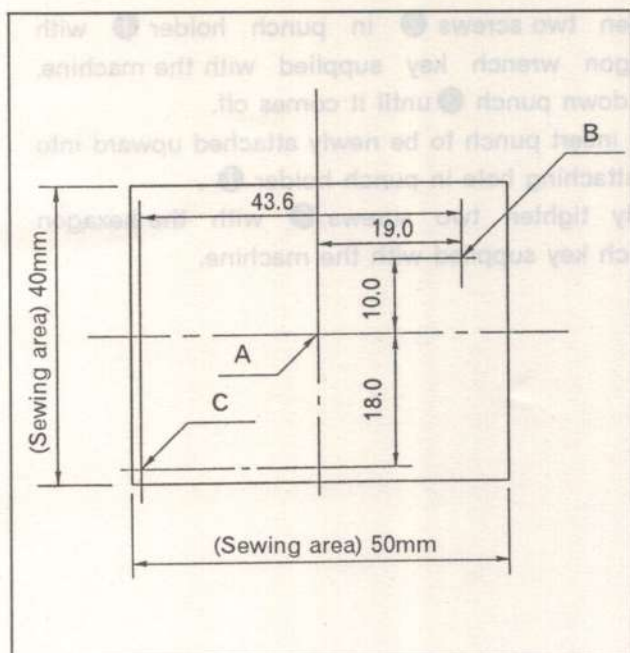
Name of switch	Function
① DIP switch 2 (SW2)	<p>● SW2-1 .... Used to change over the start position. For the machine for radial tacking, the machine moves to the punching position regardless the ON/OFF setting of this switch.</p> <p>● SW2-2 .... Used to change over actuation/stop of the intermediate presser. ON ..... Intermediate presser stops. OFF .... Intermediate presser actuates. (at the time of delivery)</p> <p>● SW2-3 .... Used to change over enlargement/reduction of the reference point for sewing start and reference point for origin.</p>
	<p>ON</p> <p>Sewing start point</p> <p>Origin</p> <p>OFF (at the time of delivery)</p> <p>Origin</p>



Name of switch	Function																														
	<ul style="list-style-type: none"><li>● SW2-4 ..... Used to change over actuation/stop of the wiper. ON .... The wiper stops. OFF ... The wiper actuates. (At the time of delivery)</li></ul>																														
<div>⑥ DIP switch 6 (SW6)</div> <div><div>ON</div><div><div><div></div></div><div><div></div></div><div><div></div></div><div><div></div></div><div><div></div></div><div><div></div></div><div><div></div></div><div><div></div></div></div><div>12345678</div></div>	<ul style="list-style-type: none"><li>● SW6-1, -2 ... Used to select the material feed timing.<table><tr><td>6-1</td><td>6-2</td><td>Material thickness for reference</td></tr><tr><td>ON</td><td>ON</td><td>Less than 2 mm (at the time of delivery)</td></tr><tr><td>OFF</td><td>ON</td><td>2 mm or more to less than 3 mm</td></tr><tr><td>ON</td><td>OFF</td><td>3 mm or more to less than 4 mm</td></tr><tr><td>OFF</td><td>OFF</td><td>4 mm or more</td></tr></table></li><li>● SW6-7 ..... Used to change over the thread tension releasing function. The needle enters the material only at the inflection points. (Stitch length of 6.2 mm or more is possible.)<div>ON : Basting<div></div>OFF : Normal<div><div>(at the time of delivery)</div></div></div></li><li>● SW6-5, -6 .. Used to select the type of machine between radial tacking type and standard type.<table><tr><td>6-5</td><td>6-6</td><td>Function</td></tr><tr><td>OFF</td><td>OFF</td><td>Radial tacking type</td></tr><tr><td>ON</td><td>OFF</td><td>Standard type</td></tr><tr><td>OFF</td><td>ON</td><td>Radial tacking type and only the punch actuates.</td></tr><tr><td>ON</td><td>ON</td><td>Standard type</td></tr></table></li><li>● SW6-8 ..... Used to change over the sewing speed at the start of sewing. ON ..... High speed: Use this mode if you want to shorten the cycle time. However, be careful when creating a sewing pattern since troubles such as stitch skipping and slip-off of the thread may occur at the start of sewing in accordance with the directions of stitches or the combination of material and thread. OFF ..... Standard (at the time of delivery)</li><li>● SW6-3, -4 ..... These are used for maintenance. Do not use them.</li></ul>	6-1	6-2	Material thickness for reference	ON	ON	Less than 2 mm (at the time of delivery)	OFF	ON	2 mm or more to less than 3 mm	ON	OFF	3 mm or more to less than 4 mm	OFF	OFF	4 mm or more	6-5	6-6	Function	OFF	OFF	Radial tacking type	ON	OFF	Standard type	OFF	ON	Radial tacking type and only the punch actuates.	ON	ON	Standard type
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ON	ON	Standard type																													
<div>⑤ Rotary DIP switch 5 (SW5)</div> <div></div>	<ul style="list-style-type: none"><li>● SW5 For the sewing machine for radial tacking, set the switch to "C." Tension disk is raised for 200 ms. when the sewing machine starts to rotate so as to prevent the needle thread from slipping off at the start of sewing.</li></ul>																														

## 2. Origin for the sewing machine for radial tacking and input of a sewing pattern

### (1) Origin for the sewing machine for radial tacking



Point A : Origin for the AMS-206C

Point B : Origin for the machine for radial tacking

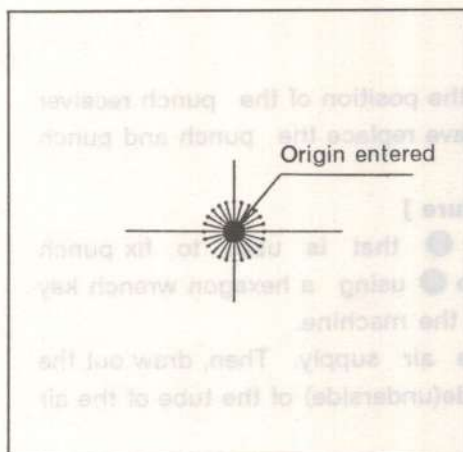
Point C : Punching position

Origin and punching position for the sewing machine for radial tacking

The origin for the AMS-206CSS-5250 (for radial tacking) is specified to a point that is 19 mm away from the origin for the AMS-206C in terms of X direction and 10 mm away from it in terms of Y direction. The punching point is specified to a point that is 43.6 mm away from the origin for the machine for radial tacking in terms of X direction and 28 mm away from it in terms of Y direction.

### (2) Input of a sewing pattern

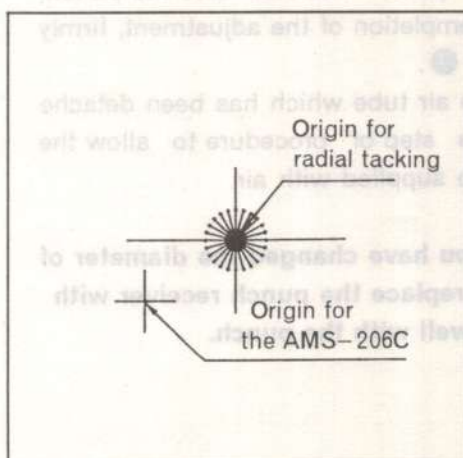
- When using PGM-1, -2 or -10



Input the point entered as origin as data on the center of radial tacking.

**[Note] It is not necessary to input data on jump and second origin for punching.**

- When using PGM-5



Connect the PGM-5 to the AMS-206C. Specify the input mode, and the feeding frame automatically moves to the origin for radial tacking. Specify the test sewing mode, and the feeding frame automatically moves to the punching position.

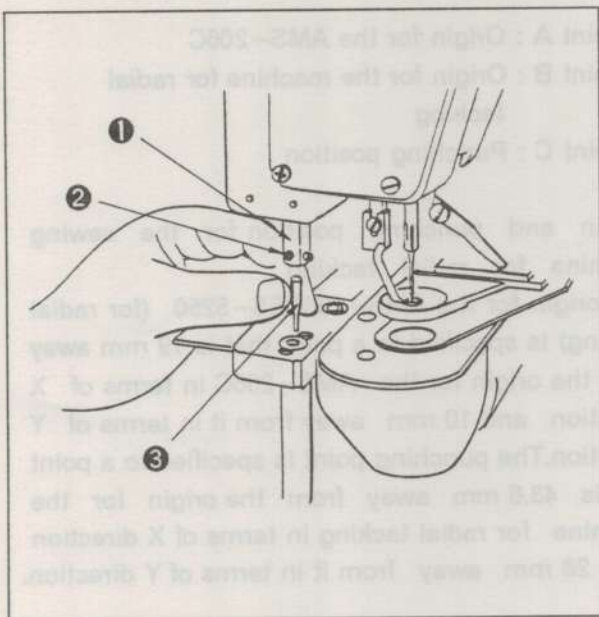
When you input data on radial tacking, take the origin for radial tacking as the center of radial tacking.

**[Note] It is not necessary to input data on jump and second origin for punching.**



### 3. How to replace the punch and punch receiver

#### (1) How to replace the punch

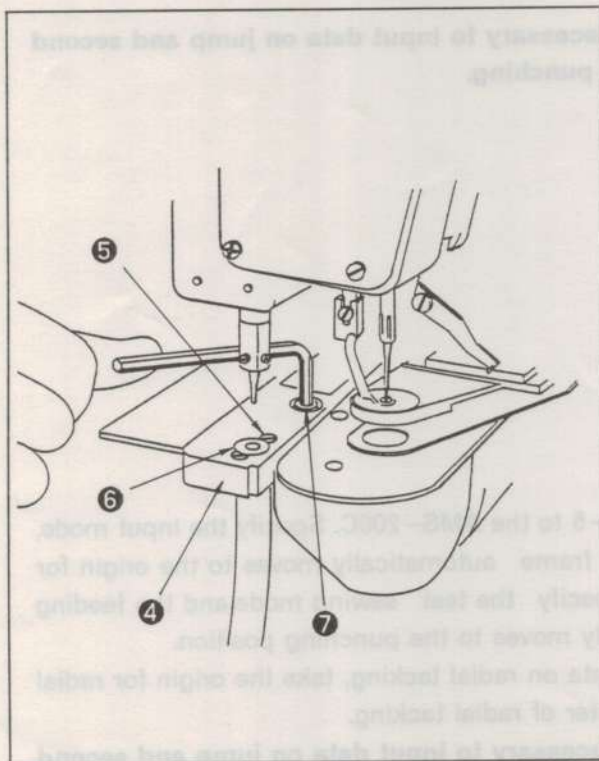


Loosen two screws ② in punch holder ① with hexagon wrench key supplied with the machine. Pull down punch ③ until it comes off. Fully insert punch to be newly attached upward into the attaching hole in punch holder ①. Firmly tighten two screws ② with the hexagon wrench key supplied with the machine.

#### (2) How to replace the punch receiver

Loosen two screws ⑤ in the punch receiver that is mounted on punch receiving plate ④. Remove punch receiver ⑥. Fit the punch receiver to be newly attached in the hole in punch receiving plate ④, then firmly tighten screws ⑤.

#### (3) Adjusting the position of the punch receiver



Be sure to adjust the position of the punch receiver whenever you have replaced the punch and punch receiver.

##### [ Steps of procedure ]

1. Loosen screw ⑦ that is used to fix punch receiving plate ④ using a hexagon wrench key supplied with the machine.
2. Turn OFF the air supply. Then, draw out the leading-in side (underside) of the tube of the air cylinder.
3. Lower the punch by hand and adjust the position of punch receiving plate ④ for a good fit between the punch receiver and the punch.
4. After the completion of the adjustment, firmly tighten screw ⑦.
5. Re-insert the air tube which has been detached in the above step of procedure to allow the machine to be supplied with air.

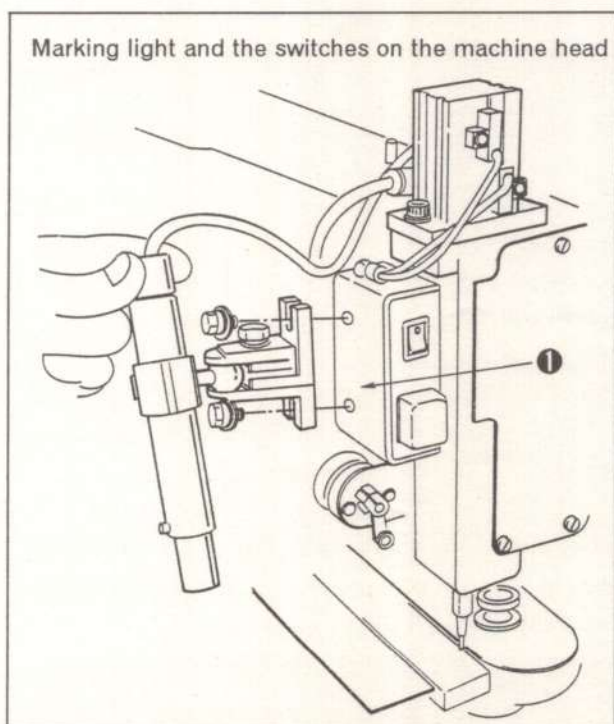
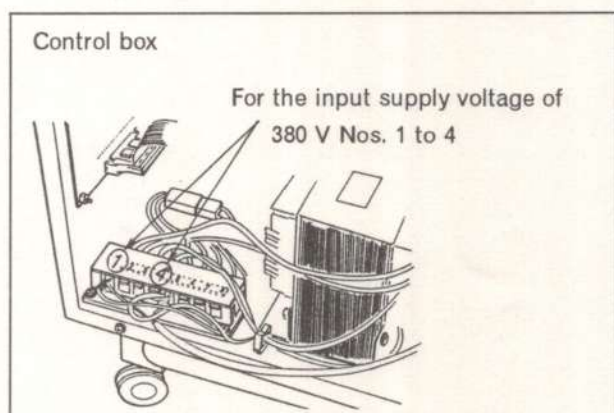
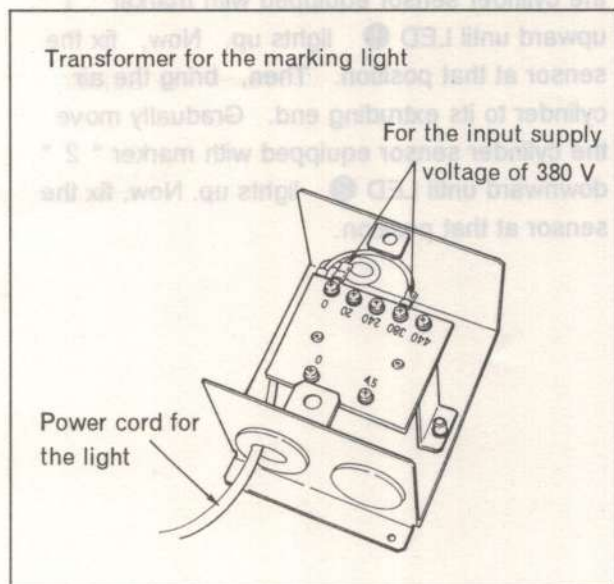
##### [Caution]

Whenever you have changed the diameter of punch, also replace the punch receiver with one that fits well with the punch.

## 4. How to attach a marking light (optional)

### (1) Installing and wiring the transformer box

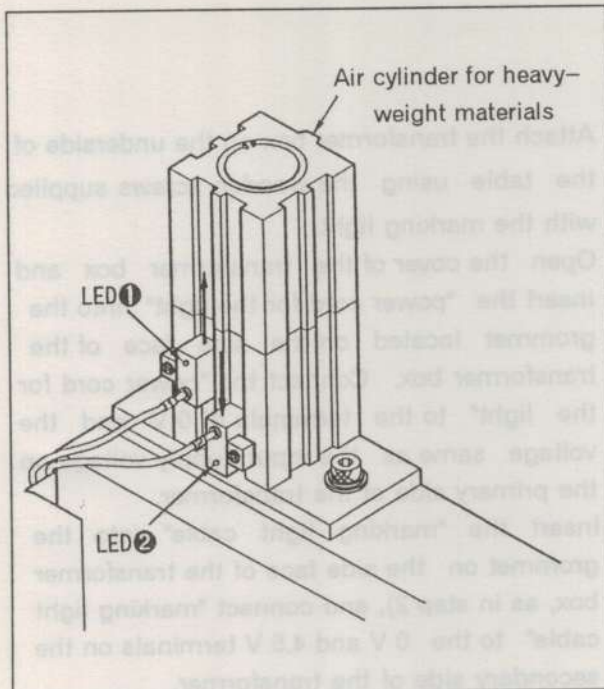
- For the control box for export (240 V to 440 V)



- 1) Attach the transformer box on the underside of the table using the wooden screws supplied with the marking light.
- 2) Open the cover of the transformer box and insert the "power cord for the light" into the grommet located on the side face of the transformer box. Connect the "power cord for the light" to the terminals of 0 V and the voltage same as the input supply voltage on the primary side of the transformer.
- 3) Insert the "marking light cable" into the grommet on the side face of the transformer box, as in step 2), and connect "marking light cable" to the 0 V and 4.5 V terminals on the secondary side of the transformer.
- 4) Put the "power cord for the light" in the control box through the cable inlet located on the rear side of the control box. Then connect the "power cord for the light" to the terminal block No. 1 and terminal of the voltage same as the input supply voltage.
- 5) Turn ON the power switch and confirm that the marking light lights up. Then close the cover of the control box and that of the transformer box.
- 6) Fix the marking light (base) on cover ❶ of the switch mounting base on the machine head using the screws supplied with the unit. Then, adjust the position of focus of the illumination.
- 7) Neatly arrange the marking light cables with the cable clip band supplied with the unit so as to keep them out of way of your work.



## 5. Adjusting the cylinder sensor



Turn OFF the air supply and bring the air cylinder to its retracting end. Gradually move the cylinder sensor equipped with marker " 1 " upward until LED ① lights up. Now, fix the sensor at that position. Then, bring the air cylinder to its extruding end. Gradually move the cylinder sensor equipped with marker " 2 " downward until LED ② lights up. Now, fix the sensor at that position.

3)

4)

5)

6)

7)

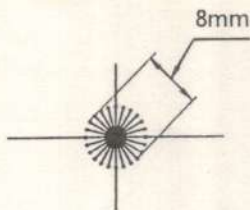
8)



## 6. Table of service patterns

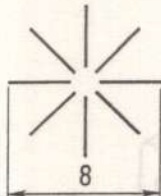


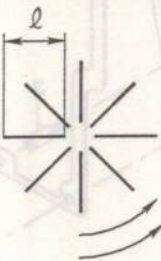


Data ROM contains data on three different kinds of radial tacking of which outside diameter is 8 mm with a scale of 100 %.

These three kinds of radial tacking differ in terms of stitching density.



Pattern No.	Stitching density
No.1	Coarse
No.2	Medium
No.3	Dense
No.4	Coarse
No.5	Medium
No.6	Dense

Input patterns .....Stitch shape can be input as desired. Note that the following sewing patterns have been factory-input at the time of delivery.

Sewing pattern	No.1	No.2	No.3
Stitching density	Coarse	Medium	Dense
Number of times of sewing	once	once	once
Pattern shape			
Sewing pattern	No.1	No.2	No.3
Stitching density	Coarse	Medium	Dense
Number of times of sewing	twice	twice	twice
Pattern shape			

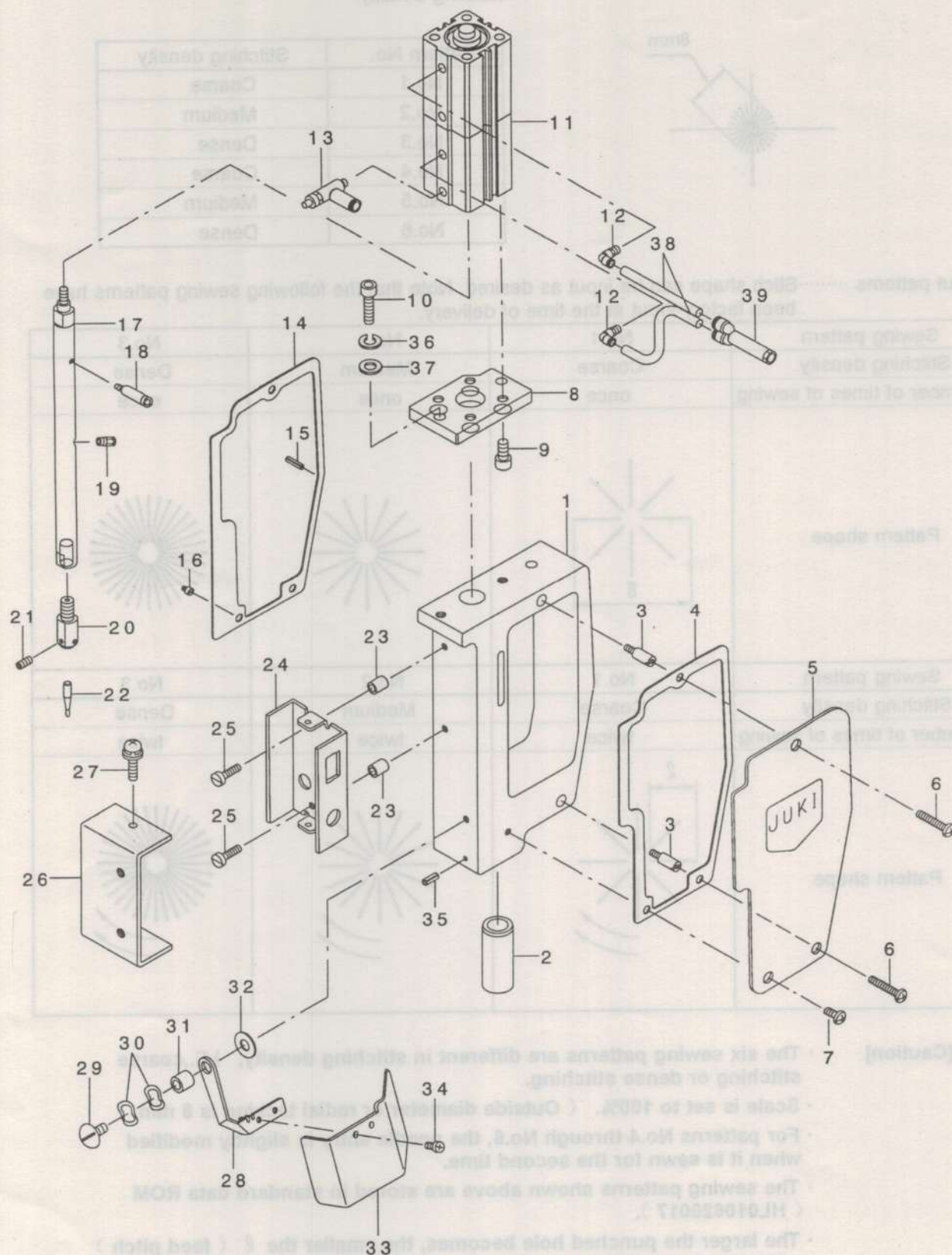
### [Caution]

- The six sewing patterns are different in stitching density, I.E., coarse stitching or dense stitching.
- Scale is set to 100%. ( Outside diameter or radial tacking is 8 mm. )
- For patterns No.4 through No.6, the needle entry is slightly modified when it is sewn for the second time.
- The sewing patterns shown above are stored in standard data ROM ( HL010620017 ).
- The larger the punched hole becomes, the smaller the  $l$  ( feed pitch ) will become, and vice versa.

# PARTS LIST

## 1. PUNCH COMPONENTS (1)

パンチ関係 (1)

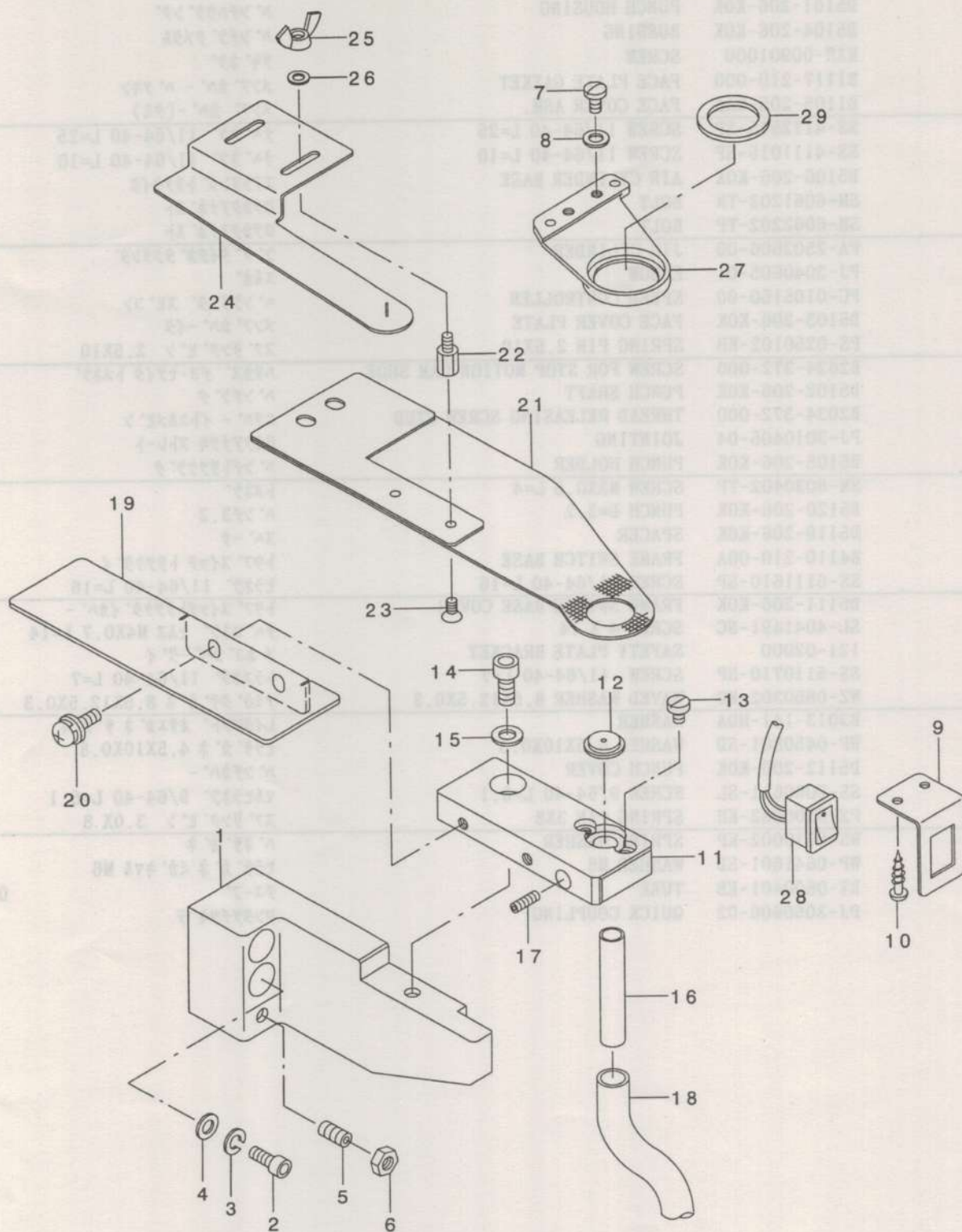




REF. NO	NOTE	PART NO.	DESCRIPTION	ヒソメイ	Qty
1		D5101-206-KOK	PUNCH HOUSING	ハ'ンチハウジング	1
2		D5104-206-KOK	BUSHING	ハ'ンチジ'クメタル	1
3		MAR-00901000	SCREW	ツギ'ネジ'	2
4		B1117-210-000	FACE PLATE GASKET	メンブ'カハ' - ハ'ツキン	1
5		B1105-205-0AA	FACE COVER ASM.	メンブ'カハ' - (クミ)	1
6		SS-4112515-SP	SCREW 11/64-40 L=25	ナハ'ネジ' 11/64-40 L=25	2
7		SS-4111015-SP	SCREW 11/64-40 L=10	ナハ'ネジ' 11/64-40 L=10	1
8		D5106-206-KOK	AIR CYLINDER BASE	エアシリンダ'トリツケイタ	1
9		SM-6061202-TN	BOLT	ロツカクアナホ'ルト	4
10		SM-6062202-TP	BOLT	ロツカクアナホ'ルト	2
11		PA-2502506-00	JIG CYLINDER	ジ'ク'タイチカ'タリシリンダ'	1
12		PJ-3040605-01	ELBOW	エルボ'	2
13		PC-0105160-00	SPEED CONTROLLER	ハ'ンシリンダ' スピ'コン	1
14		D5103-206-KOK	FACE COVER PLATE	メンブ'カハ' - イタ	1
15		PS-0250102-KH	SPRING PIN 2.5X10	スプ'リンク'ピ'ン 2.5X10	1
16		B2624-372-000	SCREW FOR STOP MOTION CAM SHOE	ハリカス' チョーセツイタ トメネジ'	1
17		D5102-206-KOK	PUNCH SHAFT	ハ'ンチジ'ク	1
18		B2034-372-000	THREAD RELEASING SCREW STUD	ニツハ' - イトコルメピ'ン	1
19		PJ-3010405-04	JOINTING	6カクアナツキ ストレート	1
20		D5105-206-KOK	PUNCH HOLDER	ハ'ンチトリツケジ'ク	1
21		SM-8030402-TP	SCREW M3X0.5 L=4	トメネジ'	2
22		D5120-206-KOK	PUNCH D=3.2	ハ'ンチ3.2	1
23		D5119-206-KOK	SPACER	スハ' - サ	2
24		B4110-210-00A	FRAME SWITCH BASE	トウブ' スイッチ トリツケタ'イ	1
25		SS-6111610-SP	SCREW 11/64-40 L=16	ヒラネジ' 11/64-40 L=16	2
26		D5111-206-KOK	FRAME SWITCH BASE COVER	トウブ' スイッチトリツケタ'イカハ' -	1
27		SL-4041491-SC	SCREW 4 X 14	ナハ'コネジ' セムス M4X0.7 L=14	2
28		121-02000	SAFETY PLATE BRACKET	メ'ホコ'カハ' - タ'イ	1
29		SS-5110710-SP	SCREW 11/64-40 L=7	トラスネジ' 11/64-40 L=7	1
30		WZ-0850302-KO	WAVED WASHER 8.5X12.5X0.3	ナミカ'タサ'カ'ネ 8.5X12.5X0.3	2
31		B3013-141-HOA	WASHER	リタイロツト' オサエカ'ネ サ'カ'ネ	1
32		WP-0450801-SD	WASHER 4.5X10X0.8	ヒラサ'カ'ネ 4.5X10X0.8	1
33		D5112-206-KOK	PUNCH COVER	ハ'ンチカハ' -	1
34		SS-7090611-SL	SCREW 9/64-40 L=6.1	マルヒラネジ' 9/64-40 L=6.1	2
35		PS-0300082-KH	SPRING PIN 3X8	スプ'リンク'ピ'ン 3.0X 8	1
36		WS-0610002-KP	SPRING WASHER	ハ'ネサ'カ'ネ	2
37		WP-0641601-SD	WASHER M6	ヒラサ'カ'ネ ミカ'キマル M6	2
38		BT-0600401-EB	TUBE	チューブ'	0.2
39		PJ-3050600-02	QUICK COUPLING	ワンタツチツキ'テ	1

## 2. PUNCH COMPONENTS (2)

### パンチ関係 (2)



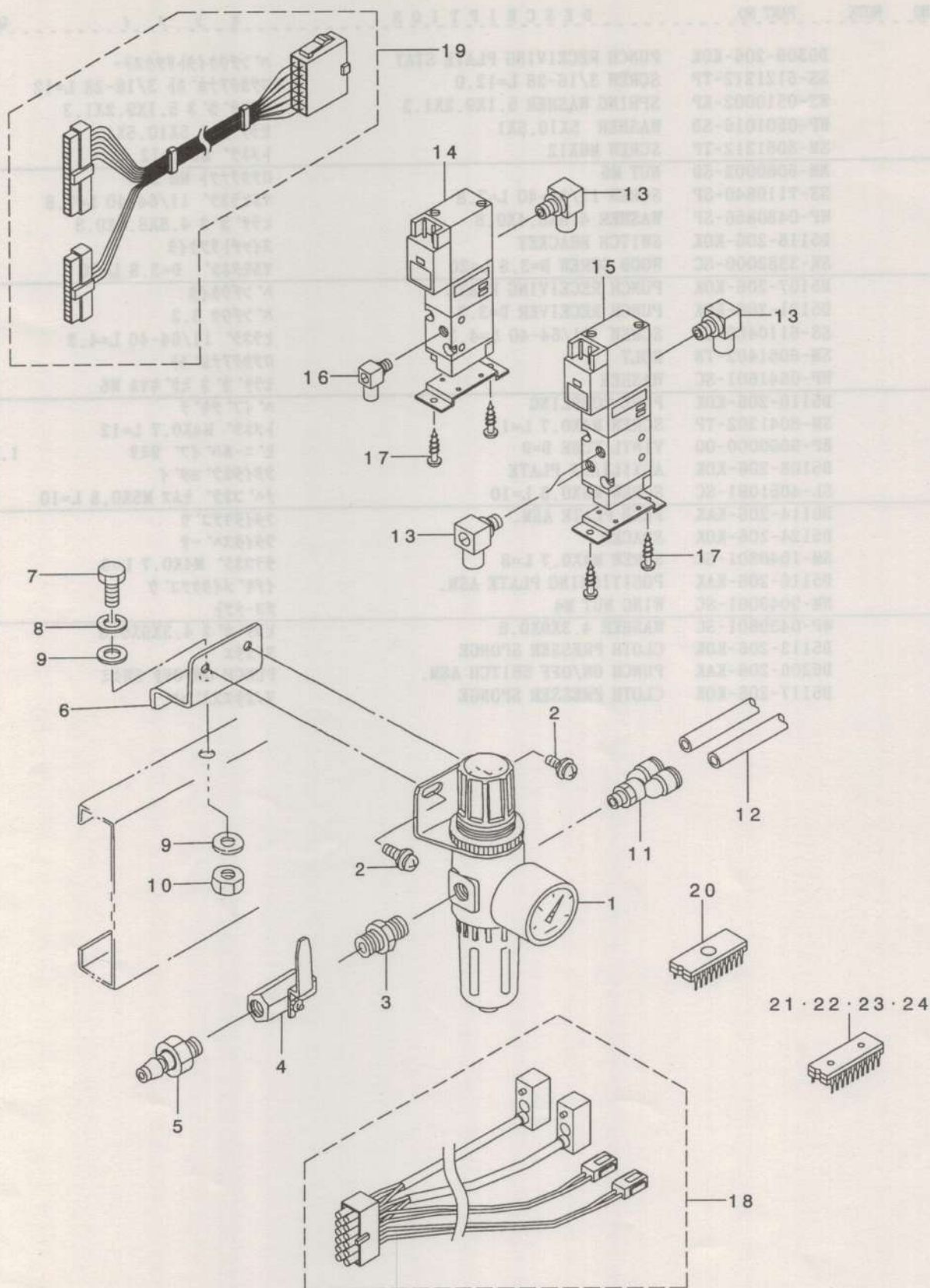


REF. NO	NOTE	PART NO.	DESCRIPTION	ヒソメイ	Qty
1		D5309-206-KOK	PUNCH RECEIVING PLATE STAY	ハ'ンチウケイタトリツクステー	1
2		SS-6121212-TP	SCREW 3/16-28 L=12.0	ロツカクアナホ'ルト 3/16-28 L=12	2
3		WS-0510002-KP	SPRING WASHER 5.1X9.2X1.3	ハツキサ'カ'ネ 5.1X9.2X1.3	2
4		WP-0501016-SD	WASHER 5X10.5X1	ヒラサ'カ'ネ 5X10.5X1	2
5		SM-8061212-TP	SCREW M6X12	トメネシ' M6 L=12	1
6		NM-6060002-SD	NUT M6	ロツカクナツト M6 2ツユ	1
7		SS-7110840-SP	SCREW 11/64-40 L=7.8	マルヒラネシ' 11/64-40 L=7.8	2
8		WP-0480856-SP	WASHER 4.8X8.4X0.8	ヒラサ'カ'ネ 4.8X8.4X0.8	2
9		D5118-206-KOK	SWITCH BRACKET	スイッチトリツクイタ	1
10		SK-3382000-SC	WOOD SCREW D=3.8 L=20	マルモクネシ' D=3.8 L=20	2
11		D5107-206-KOK	PUNCH RECEIVING PLATE	ハ'ンチウケイタ	1
12		D5121-206-KOK	PUNCH RECEIVER D=3.2	ハ'ンチウケ 3.2	1
13		SS-6110480-SL	SCREW 11/64-40 L=4.3	ヒラネシ' 11/64-40 L=4.3	2
14		SM-6061402-TN	BOLT	ロツカクアナホ'ルト	1
15		WP-0641601-SC	WASHER	ヒラサ'カ'ネ ミカ'キマル M6	1
16		D5110-206-KOK	PIPE COUPLING	ハ'イフ'ツギ'テ	1
17		SM-8041202-TP	SCREW M4X0.7 L=12	トメネシ' M4X0.7 L=12	1
18		BP-9000000-00	VINYL TUBE D=9	ビ'ニールハ'イフ' 9ミリ	1.5
19		D5108-206-KOK	AUXILIARY PLATE	シタイタホシ'ヨタ'イ	1
20		SL-4051091-SC	SCREW M5X0.8 L=10	ナハ'コネシ'セムス M5X0.8 L=10	2
21		D5114-206-KAK	FEED PLATE ASM.	シタイタツゴ'ウ	1
22		D5124-206-KOK	SPACER	シタイタスハ'ーサ	2
23		SM-1040801-SC	SCREW M4X0.7 L=8	サラコネシ' M4X0.7 L=8	2
24		D5116-206-KAK	POSITIONING PLATE ASM.	イチキ'メイタツゴ'ウ	1
25		NM-9040001-SC	WING NUT M4	チヨ'ナツト	2
26		WP-0430801-SC	WASHER 4.3X9X0.8	ヒラサ'カ'ネ 4.3X9X0.8	2
27		D5113-206-KOK	CLOTH PRESSER SPONGE	ヌノオサエ	1
28		D5206-206-KAK	PUNCH ON/OFF SWITCH ASM.	PUNCH ON/OFF SWクミ	1
29		D5117-206-KOK	CLOTH PRESSER SPONGE	ヌノオサエホ'ソシ'	1

SS-SS-SS-15

### 3. PNEUMATIC & CORD COMPONENTS

エアー・束線関係





REF. NO.	NOTE	PART NO.	DESCRIPTION	ヒョウメイ	Qty
1		PF-0552040-B0	FILTER REGULATOR	フィルタレキ ユレータ	1
2		SL-4051091-SC	SCREW M5X0.8 L=10	ナハ コネシ セムス M5X0.8 L=10	2
3		PJ-0305200-01	RING JOINT (NIPPLE)	カンツキ テ (ニツフ ル)	1
4		G5430-116-000	AIR COCK	エアコック	1
5		PJ-3090052-03	QUICK JOINT PLUG	ワンタツチシ ヨイント.フ ラク	1
6		B8211-206-000	FILTER INSTALLING PLATE	フィルタ トリツケイタ	1
7		SM-9082023-SE	SCREW M8 L=20	ロツカクホ ルト M8 L=20	1
8		WS-0861410-KR	SPRING WASHER 8.6X15X1.4	ハ ネサ カ ネ 8.6X15X1.4	1
9		WP-0871602-SE	WASHER 8.7X18X1.6	ヒラサ カ ネ 8.7X18X1.6	2
10		NM-6080721-SE	NUT M8	ロツカクナツト M8	1
11		PJ-3080652-03	JOINT	フ ランチ	1
12		BT-0600401-EB	TUBE	チューブ	2.5
13		PJ-0460540-02	HOSE ELBOW	ホースエルボ ウ	4
14		PV-1305320-00	3-PORT SOLENOID VALVE	3ホ ートデ ンシ ハ ン	1
15		PV-1505300-00	5-PORT SOLENOID VALVE	5ホ ートデ ンシ ハ ン	1
16		PJ-0460525-03	HOSE ELBOW	ホース エルボ	1
17		SK-3412000-SC	WOOD SCREW D=4.1 L=20	マルモクネシ D=4.1 L=20	4
18		D5201-206-KAK	SOLENOID VALVE CORD ASM.	スイツチデ ンシ ハ ンコト クミ	1
19		M8830-519-BAN	P17-J40 CORD ASM.	P17-J40チユウケイコト クミ	1
20		HL-0087301-22	IC	IC	1
21	#01	HL-0106200-17	IC	IC	1
22	#02	HL-0106200-18	IC	IC	1
23	#03	HL-0106200-19	IC	IC	1
24	#04	HL-0106200-20	IC	IC	1

NOTE (注記) #01....FOR PUNCH DIA. 2.0MM パンチ径2.0MM用  
#02....FOR PUNCH DIA. 1.5MM パンチ径1.5MM用  
#03....FOR PUNCH DIA. 2.5MM パンチ径2.5MM用  
#04....FOR PUNCH DIA. 3.0MM パンチ径3.0MM用

#### 4. OPTIONAL PART COMPONENTS オプション関係

REF. NO.	NOTE	PART NO.	DESCRIPTION	ヒョウメイ	Qty
1		D5303-206-KAK	PUNCH ASM., A (D=1.5)	ハ ンチAクミ	1
2		D5305-206-KAK	PUNCH ASM., B (D=3)	ハ ンチBクミ	1
3		D5307-206-KAK	PUNCH ASM., C (D=4)	ハ ンチCクミ	1
4		D5301-206-KCK	MARKING LIGHT UNIT, DOMESTIC	マーキング ライト コクナイソウクミ	1
5		D5309-206-KCK	MARKING LIGHT UNIT, EXPORT	マーキング ライト ユシユツソウクミ	1

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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.