

## **Automatic Pocket Welting Machine**

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**APW-194N** (Without flap type)

**APW-195N** (Flap sewing type)

**APW-196N** (Slant pocket sewing type)



● APW-196N (equipped with options)

# APW-194N

The corner knife intervals can be automatically and accurately adjusted simply by setting a sewing length on the operation panel, ensuring that welts are finished with consistent quality at all times.



# APW-195N

When attaching flaps, the flap sensor detects the flap length for the accurate adjustment of the sewing length and corner knife intervals. Since the machine produces welts of consistent quality regardless of the welting length, it can be widely used for the continuous sewing of welts of different lengths.



# APW-196N

The machine is provided as standard with a turret-type set of seven pairs of corner knives that can be quickly selected and switched over in a single-motion. Sewing of welts requiring different cutting angles and depths can be easily set to respond to the pattern invoked on the operation panel.



**Productivity is increased by equipping the machine with a sewing speed capability of 2,500rpm.**

The machine comes with a high-speed machine head which operates at a normal sewing speed as high as 2,500rpm. The clamp foot returns to its home position at a higher speed and the number of stitches sewn when the machine runs idle before coming to a complete stop at the end of sewing is reduced, thereby reducing the sewing time and dramatically increasing productivity. The machine's operating efficiency is enhanced by its 1.6-fold capacity hook, which reduces time-consuming bobbin replacing works, and its monitoring device for the automatic detection of remaining bobbin thread, which is equipped as standard.

**Welting length can be automatically adjusted simple by changing the settings on the operation panel. (APW-194N)**

The corner knife intervals can be automatically and accurately adjusted simply by setting a sewing length on the operation panel, ensuring that welts are finished with consistent quality at all times.

**The machine automatically adjusts the welting length to the flap length. (APW-195N, APW-196N)**

When attaching flaps, the flap sensor detects the flap length for the accurate adjustment of the sewing length and corner knife intervals. Since the machine produces welts of consistent quality regardless of the welting length, it can be widely used for the continuous sewing of welts of different lengths.

**The machine can store ten different sewing patterns in memory and perform cycle sewing.**

The machine also retains data on ten different patterns, including data on stitching length, stacker operation, etc.. Cycle sewing with up to five combined patterns can be executed. With this feature, the machine offers higher productivity in welting on semi-custom-made garments under one-pattern-one-garment sewing system.

**The machine prevents slippage between welting patches made of slippery materials.**

With its improved material-clamping force during jumping and its newly adopted fluorocarbon resin coated binder that provides smoother material feed, the machine can reliably feed garment bodies and welting patches made of slippery materials to the sewing position. The result is beautifully finished seams with no slippage between the garment fabric and welting patch.

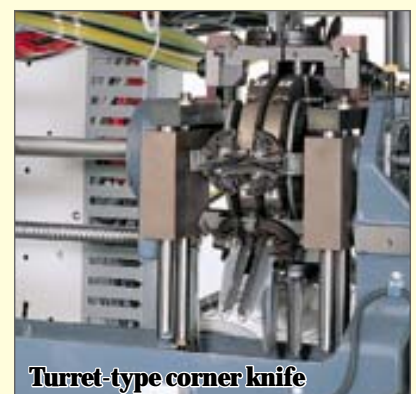
**The machine is compactly designed to save space. One of its main advantages is its outstanding workability.**

The machine offers improved welting capabilities and is compactly designed to allow efficient use in limited production spaces. In addition, by placing the clamp foot feeding mechanism on the top face of the table, obstacles are eliminated between the sewing table and clamp foot and a wider space is available under the arm. (Coats or raincoats can be placed on the machine in the lengthwise direction without folding.)

## APW-196N (Slant pocket sewing type)



The machine is provided as standard with a turret-type set of seven pairs of corner knives that can be quickly selected and switched over in a single-motion. Sewing of welts requiring different cutting angles and depths can be easily set to respond to the pattern invoked on the operation panel.

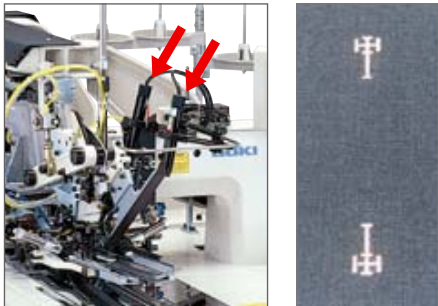


**Turret-type corner knife**



## Dart reference marking lamp

Since garments can be placed on the machine using dart locations as reference, the marking procedure is no longer required with this feature.



## Bobbin thread remaining amount detecting device

Every time the sewing completes, the bobbin thread remaining amount detecting device detects the remaining amount of bobbin thread. When the remaining bobbin thread reaches a predetermined length, the operator is notified by a message on the machine display and the machine is disabled (even when the pedal is depressed) to prevent troubles due to run-out of bobbin thread.



## Operation panel

The most frequently used keys on the operation panel are upsized to facilitate data input. By giving the operator a clear view of all the necessary sewing data, the machine's liquid crystal display allows the operator to continue sewing uninterrupted.



Maintenance works are conducted with the machine head tilted.

## SPECIAL SPECIFICATIONS

### Vacuum type table

The material is easily sucked in place through a hole in the main unit using the suction device and suction motor device in combination (both are optionally available).



## OPTIONS



SA84



SA85N



SA86N



SA101



SA96N



SA97N

double-side welt type

Model	Part No.	Description	Feature
SA84	GSA-840000A0A	Dart stretcher	The dart stretcher holds the end of the material when making a welt on a darted part of the material to make it easier to set the darted part and improve the reliability of the welting.
SA85N	GSA-85000DA0B	Needle gauge: 8, 10, 12mm	Shim device This device encloses a garment body between its upper and lower parts and feeds it to the needle entry area. It is especially useful for difficult-to-feed garment bodies.
	GSA-85000EA0B	Needle gauge: 14, 16mm	
	GSA-85000FA0B	Needle gauge: 18, 20mm	
SA86N	GSA-86000DA0	Needle gauge: 8~16mm	Automatic interlining feeder To improve workability, the automatic interlining feeder automatically delivers rolled interlining cloth onto the table and cuts it.
	GSA-86000EA0	Needle gauge: 18, 20mm	
SA88	GSA-880000A0	Stand for standing work	This stand is mounted under the main body of the machine to adjust the height of the main body to standing work.
SA89	GSA-890000A0A	Small-welt sewing device	This device is designed for the sewing of small welts as short as 35mm or less. The smallest possible welt size is 18mm. (Neither the center knife nor corner knife can be used for welts measuring 21mm or less.)
SA90N	GSA-90000GA0	Needle gauge: 8~12mm	Suction device (for sim type table) The device picks up the garment body by suction force to facilitate setting of materials on the machine. Use the device with a suction motor (SA91).
	GSA-90000HA0	Needle gauge: 14, 16mm	
	GSA-90000IA0	Needle gauge: 18, 20mm	
SA91	GSA-910000A0	Suction motor (for sim type table)	This is the blower motor for the suction device (SA90N).
SA92	GSA-920000A0	Automatic pocket bag presser (for sim type table)	The automatic pocket bag presser is used to hold pocket bags under the garment body when welting and pocket bag sewing are performed concurrently. *This device equipped as standard for APW-194N. (SA92 or SA101)
SA101	—	Automatic pocket bag presser (for standard table and vacuum type table)	
SA94	GSA-94000CA0	Center reference device	This optional device is useful to sew welts oriented longitudinally from the center of maximum-sized welts. It is intended for the sewing of welts with darts placed in the direct front-to-back center of the welting length.
SA96N	GSA-96000AA0B	Needle gauge: 8~14mm	The device is effective when used for sewing welts with flaps.
	GSA-96000BA0B	Needle gauge: 16~20mm	
SA97N	GSA-97000GA0A	Needle gauge: 8~14mm (for left)	Single-welt and double-welt change-over device (for APW-195N, APW-196N) The clamp foot can be moved by fingertip control. The sewing machine is well suited for the sewing of welts on upper garments since its specification can be easily changed over between double-welt type and single-welt type simply by changing a binder. The machine comes in three different types: the left single-welt type for sewing left single-welts, the right single-welt type for sewing right ones, and the double-side welt type designed to change over the welt type between the left and right single-welt types.
	GSA-97000HA0A	Needle gauge: 16~20mm (for left)	
	GSA-97000IA0A	Needle gauge: 8~14mm (for right)	
	GSA-97000JA0A	Needle gauge: 16~20mm (for right)	
	GSA-97000KA0A	Needle gauge: 8~14mm (for double)	
	GSA-97000LA0A	Needle gauge: 16~20mm (for double)	
SA98	GSA-980000A0	Single-welt and double-welt change-over device	The clamp foot can be shifted by a simple one-touch operation. Changeover between double-welt and single-welt sewing can be easily accomplished by replacing the binder. The single-welt changeover function comes in two different types: the right-hand single-welt type and left-hand single-welt type. *This device equipped as standard for APW-195N.
SP41	—	Grasping stacker	The general-purpose stacker has a wide range of applications, including men's wear, ladies' wear, sportswear, jumpers, etc.
SP42	—	Bar stacker	This stacker is suited to welting on the hip pockets of slacks, pants of working uniforms, etc.
SP43	—	Roller stacker	This is a stacker suited for small articles that cannot be feed by a bar stacker or grasping stacker.
SP42 + SP43	—	Roller bar stacker	Stacker that combines the features of SP42 and SP43. It is suited to the processing of both right and left front bodies of upper wear.



**SA98**



**SP41**



**SP42**

# WHEN YOU PLACE ORDERS

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

Pocket lip width (needle gauge: mm)	Code
8	A
10	B
12	C
14	D
16	E
18	F
20	G

**Option**  
See the under of this sheet.

Main unit	Code
Standard main unit with a side cover	A
Shim-type main unit with a side cover	B
Main unit with a side cover for vacuum device	C

Power supply	Code	
Single-phase	220V	D
	230V	G
	240V	E
3-phase	220V	K
	230V	Q
	240V	P
	380V	L
	400~415V	M
440V	N	

**194N**  
**APW195N**  
**196N**



Knife	Code
Right	1
* Left	2

\* For APW-194N, only "2" of "left-knife" is available.

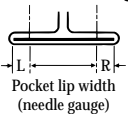
Stacker	194N	195N	196N	Code
Not provided	○	○	○	Z
SP41 (grasping stacker)	○	◎	◎	J
SP42 (bar stacker)	◎	○	○	K
SP43 (roller stacker)	○	○	○	L
SP42+SP43 (roller bar stacker)	○	○	○	M

◎: Main stacker ○: Can be combined

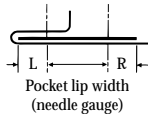
Single-welt change-over function	194N	195N*	196N	Code
Not provided	○	—	○	Z
SA97N left	—	○	○	D
SA97N right	—	○	○	E
SA97N both-side	—	○	○	F
SA98 left	○	○	—	L
SA98 right	○	○	—	R

\* For APW-195N, SA98 left or SA98 right of single-welt change-over function is delivered as standard.

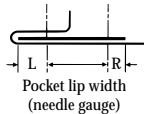
### Double-welting



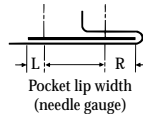
### Single-welting



Left



Right



Welt patch and welt patch base plate															
Double-welt				Single-welt								Variant double-welt			
Pocket lip width (needle gauge)	Size of welt Patch base plate		Code	Pocket lip width (needle gauge)	Size of welt Patch base plate		Code	Pocket lip width (needle gauge)	Size of welt Patch base plate		Code	Pocket lip width (needle gauge)	Size of welt Patch base plate		Code
	L-size	R-size			L-size	R-size			L-size	R-size			L-size	R-size	
8	3.3	3.3	A0	8	7.3	7.3	J0	8	7.3	3.3	L0	10	8.3	0.5	S1
10	4.3	4.3	A1	10	9.3	9.3	J1	8	3.3	7.3	L1				
12	5.3	5.3	A2	12	11.3	11.3	J2	10	9.3	4.3	L2				
14	6.3	6.3	A3	14	13.3	13.3	J3	10	4.3	9.3	L3				
16	7.3	7.3	A4	16	15.3	15.3	J4	12	11.3	5.3	L4				
18	8.3	8.3	A5	18	17.3	17.3	J5	12	5.3	11.3	L5				
20	9.3	9.3	A6	20	19.3	19.3	J6	14	13.3	6.3	L6				
10	3.8	3.8	B0					14	6.3	13.3	L7				
								16	15.3	7.3	L8				
								16	7.3	15.3	L9				
								18	17.3	8.3	M0				
								18	8.3	17.3	M1				
								20	19.3	9.3	M2				
								20	9.3	19.3	M3				

### Options

○: Can be attached to the machine S: Provided as standard (not included in options) with the machine

Code	Name of optional devices	APW-194N			APW-195N			APW-196N		
		Table type			Table type			Table type		
		Standard	Shim	Vacuum	Standard	Shim	Vacuum	Standard	Shim	Vacuum
ZZ	Not provided									
A2	SA84 Dart stretcher	○	○	○	○	○	○	○	○	○
A6	SA92 Pocket bag clamping device		S			○			○	
A7	SA88 Table stand for standing work	○	○	○	○	○	○	○	○	○
A8	SA89 Small welt sewing device	○	○	○	○	○	○	○	○	○
B1	SA94 Center reference device	○	○	○	○	○	○	○	○	○
B5	SA74/SA84/SA86N				○			○		
B8	SA84/SA92					○			○	
C2	SA74 Pattern-matching marking device				○	○		○	○	
E9	SA101 Pocket bag clamping device	S		S	○			○		○
F1	SA84/SA101				○			○		○
F3	SA84/SA89/SA90N/SA101							○		○
G0	SA86N Automatic interlining feeder	○		○	○			○		○
G1	SA84/SA86N	○		○	○			○		○
G2	SA86N/SA89	○		○	○			○		○
G3	SA90N Suction device			○				○		○
G4	SA90N/SA91			○				○		○
G5	SA96N Flap presser device	○	○	○						
G6	SA84/SA96N	○	○	○						
G7	SA88/SA96N	○	○	○						
H1	SA84/SA92/SA90N									○
H2	SA88/SA89	○	○	○	○	○	○	○	○	○
H3	SA84/SA88	○	○	○	○	○	○	○	○	○
H4	SA84/SA92/SA94					○			○	



# SPECIFICATIONS

Model name		APW-194N	APW-195N	APW-196N
		Without flap type	Flap sewing type	Slant pocket sewing type
Sewing speed		Normal 2,500rpm (1,000~2,500rpm)		
Stitch length	Regular stitching	Standard: 2.0mm (2.0~3.4mm)		
	Fastening stitching	Standard: 1.0mm (0.5~1.5mm)		
	Safety stitching Back-tack stitching	Standard: 2.0mm (1.0~3.4mm)		
Kinds of welts		Parallel double-welt, parallel single-welt, parallel variant double-welt (without flaps)	Parallel double-welt, parallel single-welt, parallel variant double-welt (with/without flaps)	Parallel double-welt, parallel single-welt, slant double-welt, slant single-welt, trapezoidal stitching (with/without flaps)
Sewing length (welt length)		Needle gauge 8~12mm: 35~180mm, Needle gauge 14mm or more: 50~180mm *By using the corresponding optional device, sewing length can be set to 18mm or more. However, for the sewing length of 21mm or less, neither the center knife nor the corner knife can be used.		
Number of patterns that can be stored in memory		10 patterns		
Cycle sewing		Possible (max. 5 different patterns can be combined)		
Needle gauge		8, 10, 12, 14, 16, 18, 20mm		
Needle (at the time of delivery)		ORGAN Mt × 190 (#16) #16~#18 SCHMETZ 190R (Nm100) Nm100~Nm110	ORGAN DP × 17 (#16) #16~#18 SCHMETZ SY3335 (Nm100) Nm100~Nm110	
Needle bar stroke		34.4mm	33.4mm	
Thread		SPUN #50		
Hook		Vertical-axis full-rotary 1.6 fold-capacity hook		
Machine head		2-needle, lockstitch machine with center knife	2-needle, lockstitch machine with organized split needle bar and center knife	
Thread take-up		Slide type		
Lubrication		By an oiler (machine head and hook)		
Lubricating oil		JUKI New Defrix Oil No.2 (equivalent to ISO VG32)		
Cloth feed system		By a servomotor drive		
Bobbin thread remaining amount detecting device		Provided as standard		
Power consumption		500W		
Compressed air and air consumption		0.5MPa (5.0kgf/cm <sup>2</sup> ), 40Nℓ /min		
Total weight		200kg	220kg	
Dimensions (excluding the stacker)		735mm (W) × 1,250mm (D) × 1,200mm (H)		
Height of table		820mm		
Production capacity		Approx. 2,300pcs./8 hours	Approx. 2,000pcs./8 hours	Approx. 2,300pcs./8 hours
(Sewing length of 150mm, allowance rate of 25%)				

● To order, please contact your nearest JUKI distributor.



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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 catalog is printed on recycle paper.