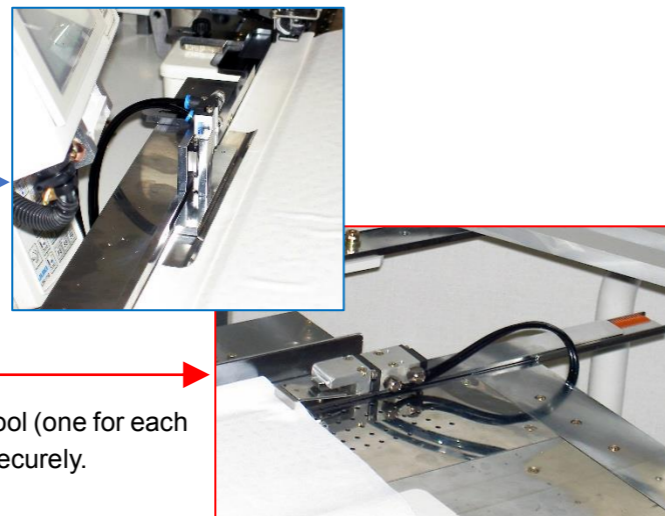


Optional Accessories

- ★ Robot Loader
See inside pages

- ★ Front Edge Presser
This presser tool is useful in case of front edge section does not stay on the vacuum plate because of harder/thicker materials and/or no iron pressing is performed.



- ★ Fabric Clamper
Depending on the type of materials, you can add this clamp tool (one for each left end and right end) to fix materials on the vacuum plate securely.

Specification (U-2604-BH only)

★ Machine Head	JUKI LBH-1790 Direct-Drive Motor type
★ Max. Sewing Speed	4,200 rpm, normal: 3,600 rpm
★ Needles	DP x 5 # 11J-14J
★ Feeding System	Pulse Motor (0.1 mm step)
★ Max. Feeding Length	720 mm
★ Feeding Directions	for Men: L→R, for Ladies: R→L (also good for finished products)
★ # of Pattern Memory	20 (expandable)
★ Seam Margin	5-20 mm (see Fig1-A)
★ Distance to the Top Button Hole	Limitless (min. 20 mm) (see Fig1-B)
★ Interval of Button Holes	Limitless (See Fig1-C)
★ Button Hole Length	12.7 mm (standard) 15.9 mm (max.) (See Fig1-D)
★ # of Button Holes	Limitless (0-30, with intervals of 20 mm)
★ Table Height	950 mm
★ Power Supply	200 V / AC 950 VA
★ Air	0.5 MPa
★ Dimensions	W 1,750 x D 600 x H 1,200 mm

Daily Output (U-2604-BH only)

2,400 pcs. of front body fabric / 8h
 ★ 2 sets, 1 operator, 5 button holes each with 100 mm interval

Configurations

- ★ Perfect Sync. System (Presser and Vacuum Plate)
- ★ Direct-Drive Machine Head
- ★ Powerful Vacuum Plate
- ★ For MEN'S/For LADIES' Mode Sensor
- ★ Stacker
- ★ Stacker Turn-Over Shaft
- ★ LCD Touch Panel
- ★ Bobbin Counter
- ★ Air Duster Gun

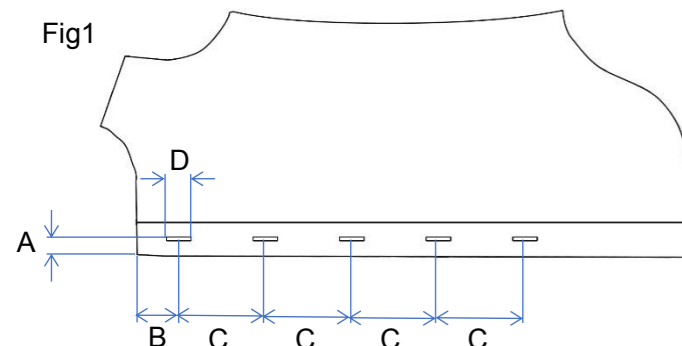
Specifications (Robot Loader only)

★ Fabric Length	700 mm
★ Max. Loading Height	200 mm
★ Power Supply	24 V / DC
★ Air	0.5 MPa
★ Dimensions	W 1,050 x D 350 x H 1,200 mm

In the interests of product improvement, appearance and/or specifications are subject to change without prior notice.



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Just place the material and the machine sews button holes

U-2604-BH is an indexing machine that sets button holes at accurate positions quickly and automatically using a vacuum plate to move front-body panels

You just need to lay the materials on the table, and the button holes are completed instantly

Intelligent and perfect sync. between machine head and vacuum plate secures high-quality button hole sewing

With the optional Robot Loader, the entire process of loading materials, button holing, and piling up can be unmanned
 (Related product: Button Sewing Indexer MODEL U-2607-LK/U-2607-MB, available separately)





Button Hole Feeder

Model U-2604-BH

Model U-2604-BH/AUT (w/ Robot Loader)



Direct Drive Machine Head Onboard



For MEN'S

U-2604-BH comes with the Direct-Drive Motor type machine head (max. 4200 rpm sewing speed). Its electronic thread tension control system

automatically keeps the optimum tension of needle thread and bobbin thread, resulting in beautiful button hole shapes.

Remaining length of thread after trimming is always kept to a minimum, and the thread-fray-prevention mechanism prevents the finished seam from loosening. Its dry-head system does not require lubrication (except hook section), preventing oil stains on the fabrics.

Simply Lay Front Body Panel on the Table



For LADIES'

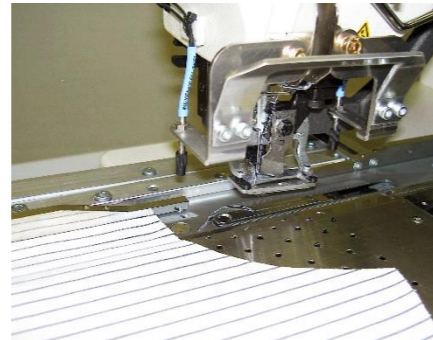
Just put front body panels on the table. Operators do not need to pay attention to the positioning of left or right strictly. This feature enables higher productivity.

2 x photoelectric sensors (for MEN and for LADIES) detect the upper end of front body panel and the computer calculates the distance from the upper end and top button, button hole intervals,

of button holes precisely and automatically. Feeder transports the materials for MEN from left to right, and the materials for LADIES from right to left. Materials are piled up tidily on the stacker automatically.

Alternatively, you can place the material and set the position of top button hole just under the machine presser, and the machine starts button sewing immediately.

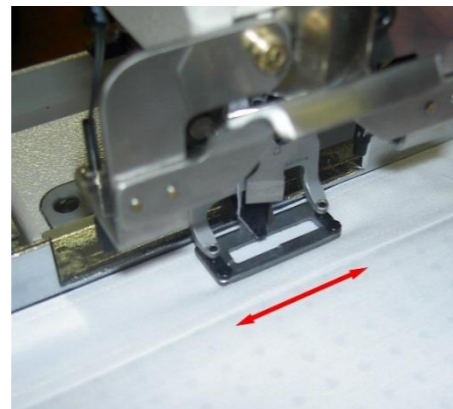
Flexible Positioning of Top Button Hole



This machine detects the upper edge of front body panel using photoelectric sensor and feeds it with vacuum plate without clamp. Consequently, it has a flexibility to change the position of top button hole which

the predecessor models did not have. This feature is especially suitable for the shirts for Japanese market called "Cool-Biz" type.

Perfect Sync. of Machine Head and Vacuum Plate



Vacuum plate securely holds fabrics and precisely transports them (0.1 mm step). It perfectly synchronizes the movement of the machine head during button holing. No extra adjustment work is required even when the shape or size of

button hole is changed.

Powerful Vacuum Plate

Its powerful vacuum plate is able to securely hold fabrics even with wrinkles or with naturally curved front edge because of stitches. Vacuum plate moves (0.1 mm increments) thanks to the stepping motor, realizing high precision of button hole positioning. It performs the perfect feeding even with heavier fabrics or finished products.

Thread Breakage Detector (T.B.D.)

T.B.D. detects the thread breakage and stops the machine immediately. Operator can choose to step back or step forward before restart and continue the operation. This feature helps to

reduce the waste of time and extra work.

Variety of Button Hole Intervals



Up to 20 patterns of button hole intervals can be stored as equal intervals. In the case of unequal intervals, users can differentiate each interval as they like by inputting each distance one by one on the touch panel. Up to 20 patterns can be stored as unequal intervals.

Stacker (with Stacker Turn-Over Shaft)



Stacker mechanism on the right side of machine piles up front body panels of both MEN and LADIES. (MEN: top is right, LADIES: top is left) Thanks to its stacker turn-over shaft, materials are piled up tidily.

Operators can change the stacker mode (MEN/LADIES) instantly without complicated procedure.

LCD Touch Panel Secures Easy Operation



Various parameters such as distance from the upper end to the top button, button intervals, # of buttons, bobbin counter, pattern # etc. are displayed at once on the touch panel, allowing users to change settings with

easy operations.

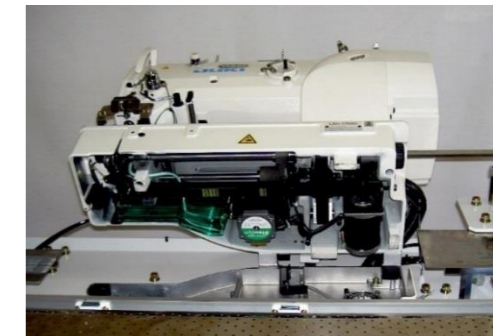
Other parameters such as MENS/LADIES, machine head on/off, vacuum on/off, stacker on/off etc. can be instantly selected. Above mentioned patterns can be stored up to 20. Red alert screen is displayed together with beep when bobbin thread becomes zero.

Emergency stop and restart at thread breakage, activating the maintenance mode etc... everything is easy to understand.

Margins between Front Edge and Button Holes

The margin from front edge to button holes can be set within the range of 5 mm – 20 mm. The positions of long gauges (for MEN/for LADIES) can be adjusted instantly just by loosening/tighten thumb screws. The position of scale is adjustable as well in order to precisely fix the gauges at the right positions.

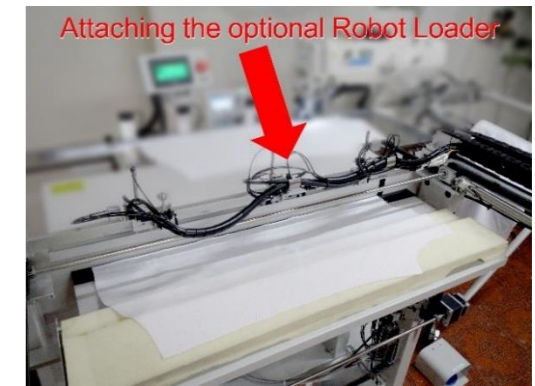
Meticulously Designed for Maintenance



In the case of fixing the button holes, users can enter the maintenance page on the touch panel. Choose pattern # and press "skip" or "run", then users can fix the specific button holes.

At the situation of maintenance or periodical check of machine head, a part of top cover of the table is detachable without using any tool, and users can tilt the machine head instantly.

Unmanned Operation with Optional Robot Loader



Attaching the optional Robot Loader

With the optional Robot Loader, it is possible for users to realize the unmanned operation of the entire production process: loading ->

button holing -> stacking. Since the Robot Loader synchronizes the cycle time of the main unit, users can expect the maximum overlapping of those two units.

Robot Loader can be easily attached /detached. Users can decide to use the machine with or without Robot Loader based on the situations (e.g. mass production lot or small production lot).

