

JUKI®

**High-speed, Cylinder-bed, 1-needle, Needle-feed Lockstitch Machine
with Large Hook**

DLN-6390

DLN-6390-7 (with automatic thread trimmer)

*The last word in cylinder-bed
lockstitch machines, intended for
bottom hemming processes for
jeans, casual pants and work
uniforms has been launched.*



DLN-6390S



This newest and most advanced machine has been developed in the pursuit of upgraded seam quality and improved workability in bottom hemming processes.

The machine offers excellent seam quality and sewing capabilities.

- The needle bar stroke is as high as 35mm. This offers increased penetration of the needle into the material to improve adaptability to heavy-weight materials.
- The machine demonstrates excellent sewing capabilities, when sewing heavy-weight denim or multi-layered portions, that free it of sewing troubles such as stitch gathering, stitch skipping and needle breakage.
- The machine is able to sew material with a low presser foot pressure while preventing the material from flapping. As a result, the material can be sewn free of puckering.
- The top- and bottom-roller style feed mechanism forms seams with increased consistency to achieve improved hemming quality while reducing uneven hems.



Highly consistent and reliable thread trimmer mechanism.

- The machine employs a highly reliable horizontal thread trimming mechanism which cuts thick thread without fail.
- The entire knife unit can be installed/removed.
- The moving knife position can be easily adjusted.
- The knife unit is of a bed device type. This means that adjustment of the knife unit is not required after removing the throat plate.
- Every time that operation of the thread trimmer occurs, the air blower keeps the knife clean by blowing off thread chips from the blade, ensuring the reliable operation of the thread trimmer.



Efficient workability.

- Coupled to the automatic presser lifter, the hemming binder automatically opens/closes. This enables efficient operation.
- The binder can be adjusted both longitudinally and laterally.
- The binder can also be independently opened/closed by operating the knee switch (knee lifter for machines without a thread trimmer).



DLN-6390-7

* For machines DLN-6390 that are not provided with a thread trimmer, the binder can be opened/closed simultaneously with the presser lifting action by means of the knee lifter supplied with the machine. Knee lifter (Part No.: 400-04417)



- The machine is provided with a 1.7-fold hook, which demonstrates remarkable productivity.



- The needle feed amount can be easily adjusted with the scale dial, so as to get the best suited seam quality when the material or thread is changed.



The lubrication mechanism effectively reduces oil stains on the material.

- The machine has adopted a forced circulation mechanism in consideration of reliable oiling and oil leakage prevention.
- The frame and cylinder-bed sections are provided with a circulation feature to prevent oil leakage. In addition, to ensure reliable operation, a gasket is fitted inside the frame, preventing any leakage of oil from the needle bar.
- The machine comes with a newly designed needle bar sliding mechanism that is highly durable and free of play.



Parts from your current machine are also compatible with the DLN-6390/-6390-7.

Feed rollers, pressers, feed adjusting gears and binders from the UNION SPECIAL 63900 model machine can be attached to the DLN-6390/-6390-7 with no additional machining or adjustments.

Parts provided as standard

Presser foot

1/2" Part No.: 300-31108

Binder

1/2" Part No.: 300-15309

Feed roller

1/2" Part No.: 276-38006 (Top roller)

1/2" Part No.: 276-35705 (Bottom roller)

Options



Hem width 3/8"

① Part No.: 300-31009

Hem width 1"

② Part No.: 277-94601



Hem width 1" (asm.)

③ Part No.: 400-10327



1/2" roller (knurled type)

④ Part No.: 300-20705 (Top roller)

⑤ Part No.: 300-32106 (Bottom roller)

1" roller (knurled type)

⑥ Part No.: 277-94403 (Top roller)

⑦ Part No.: 277-94502 (Bottom roller)

Table of feed amount adjustment/conversion gears

The shaded portion indicates the factory-attached gear present at the time of delivery. It can be interchanged with other gears supplied with the machine to support four different feed amounts.



Feed pitch	Top gear		Bottom gear		Remarks
	JUKI part No.	Engraved marker	JUKI part No.	Engraved marker	
4.2mm (6 stitch/inch)	300-37600	63949-47	300-37501	63949-33	Option
3.6mm (7 stitch/inch)	300-37303	63949-44	300-37402	63949-36	Supported by the gear supplied with the machine.
3.2mm (8 stitch/inch)	300-33302	63949-41	300-33203	63949-39	Standard factory-attached gear present at the time of delivery
2.8mm (9 stitch/inch)	300-33203	63949-39	300-33302	63949-41	Supported by changing over the factory-attached top and bottom gears.
2.5mm (10 stitch/inch)	300-33104	63949-37	300-33401	63949-43	Option
2.3mm (11 stitch/inch)	300-37402	63949-36	300-37303	63949-44	Supported by the gear supplied with the machine.
2.1mm (12 stitch/inch)	300-37501	63949-33	300-37600	63949-47	Option

SPECIFICATIONS

Model name	DLN-6390	DLN-6390-7
Application	Bottom-folding and hemming (lockstitch type)	
Max. sewing speed	5,000rpm	
Stitch length	Standard gears: 3.2mm (2.8mm) / Supplied gears: 2.3mm, 3.6mm / Optional gears: 2.1mm, 2.5mm, 4.2mm (utilized by changing pitch conversion gears)	
Needle	SCHMETS UY180GVS Nm140 range of use: Nm90 ~ Nm150 (equivalent to #14 ~ #22.5)	
Needle bar stroke	35mm	
Hook	Automatic-lubrication type exclusive full-rotary 1.7-fold hook	
Lift of the presser foot	Max. 14mm	
Feed system	Top- and bottom-roller style	
Binder open/close type	Manual type	Driven by air cylinder
Compressed air and air consumption	0.5MPa (0.5kgf/cm ²), 10Nℓ /min	
Lubrication	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	
Cylinder-bed diameter	180mm	
Weight of the machine head	34.5kg	36.5kg

* Pulley sizes are described in the Instruction Manual.

DEVICE CONFIGURATIONS BY MODEL

	DLN-6390	DLN-6390-7
Thread trimmer	-	Provided as standard
Manual binder (coupled to the presser lifter)	Provided as standard	-
Pneumatic AK device (auto-lifter)	-	Provided as standard
Pneumatic binder (coupled to the AK device)	-	Provided as standard
Edge guide	Accessory	Accessory
Mechanical wiper	-	Provided as standard
Thread trimmer air blower	-	Provided as standard
Needle cooler	Option	Option

OPTIONS

Needle cooler

The needle cooler helps reduce the occurrence of thread breakage caused by needle heat when sewing is performed at a speed of 4,000rpm or more.

The components differ with the type of machine head, i.e. with or without the thread trimmer. Selections should be made by referring to the following table.

Machine head	Type	Part No.
For DLN-6390	Mechanical valve type, provided with regulator	400-04071
For DLN-6390-7	Solenoid valve type, not provided with regulator	400-04070

WHEN YOU PLACE ORDERS

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

Without automatic thread trimmer

DLN6390S

Application	Code
Standard	S

With automatic thread trimmer

DLN6390S7W0

Application	Code
Standard	S

Wiper and automatic reverse feed function		
Wiper	Automatic reverse feed function	Code
Provided	Not provided	W0

Option	Code
Not provided	Z
With needle cooler	A

● 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.



JUKI CORPORATION HEAD OFFICE

The environmental management system to promote and conduct
① the technological and technical research, the development and design of the products in which the environmental impact is considered,
② the conservation of the energy and resources, and the recycling in the research, development, design, distribution, sale and maintenance service of the industrial sewing machines, household sewing machines and industrial-use robots, etc. and in the purchase, distribution and sale of the household commodities including the healthcare products.

Jeans Leg Hemmer Workstation

WSDLNPFS07J362

with head **DLN6390S7W0A**

Top and bottom continuous roller feed, cylinderbed, lockstitch machine with double capacity bobbin. For making a 1/2" (12.7mm) turned-down hems on jeans, overalls, etc., with split hemming attachment. Needle cooler provided with sewing head.

The sewing head is factory-mounted to the pedestal for fast installation. All that is necessary is to hook up the air, mount the threadstand and attach an electrical plug.

Workstation WSDLNPFS07J362 features:

- standard pedestal
- electronic DC motor
- electro-mechanical thread trimming system
- electro-pneumatic presser foot lift
- electro-pneumatic folder opener



Sewing Speed	max. 5000 SPM	
Number of Stitches	6-12 SPI	
Stitch Length	2.1-4.2mm	
Stitch/Seam Type	301EFb-1 (inv.)	
Hem Width	1/2" (12.7mm)	
	also available: 3/8" (9.5mm), 1" (25mm)	
Cylinder Circumference	7.1" (180mm)	
Needle	180GVS-140/054	

Manufacturers wanting to convert 63900 pedestal installations to the new DLN6390S7 should purchase Kit 29480DLN. This kit is for 1400D pedestals only, and does not include DC motor.



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