

Cylinder-bed, 1-needle, Unison-feed,  
Lockstitch Machine with a Vertical-axis Hook

**JUKI®**

**LS-1340**

**LS-1341** (with a large vertical-axis hook)

**LS-1342** (with a large vertical-axis hook and a gauge for small articles)

**LS-1342-7** (with a large vertical-axis hook, a gauge for small articles, and an automatic thread trimmer)



LS-1340



LS-1341



LS-1342

LS-1342-7-OBB/XC-E500

\* Control panel XC-E500 and pneumatic auto-lifter  
AK123C is optionally available.

# The LS Series offers a consistent stitching pitch and outstanding ability to sew sharp curves. This makes the machine ideal for the sewing of tubular articles.

## Sewing capabilities and feed performance that respond to a broad range of uses in the sewing of heavy-weight materials.

- With its larger needlebar stroke, larger lift of the presser foot, and newly adopted double-tension mechanism, the machine sews beautifully with thick threads (low count thread) and at higher thread tensions. This allows the machine to sew a broad range of heavy-weight materials.  
\* The LS-1340 is provided with a single-tension mechanism.
- The newly developed mode of highly rigid rectangular feed guarantees outstanding feed performance. In addition, the ratio between the alternating vertical movements of the walking foot and presser foot remains unchanged even when the material thickness changes. With this feature, the machine sews multi-layered parts of the material consistently and without stitch gathering.
- The machine is equipped as standard with a mechanism to correct uneven material feed by making-micro adjustments to the bottom-feed.

## Excellent for the sewing of sharp curves.

- The slimmed-down throat plate easily responds to the sewing of small tubular articles with diameters as small as 40mm. This enhances the machine's ability to smoothly sew not only bags and shoes, but also small articles such as wallets.
- In addition to the standard type machine, a machine provided with a gauge for small articles is available. (LS-1342, LS-1342-7)

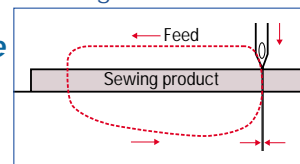


LS-1341



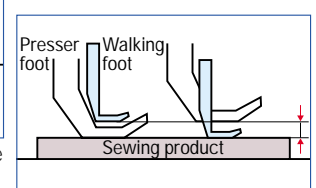
LS-1342

### Rectangular feed



- Compared with the elliptical feed, the rectangular feed helps reduce gathered stitches.

### Alternating vertical movement mechanism



- The ratio of alternate vertical movement remains unchanged even when the material thickness changes.



- Higher lift of the presser foot



- The maximum alternating vertical movement is 6.5mm.

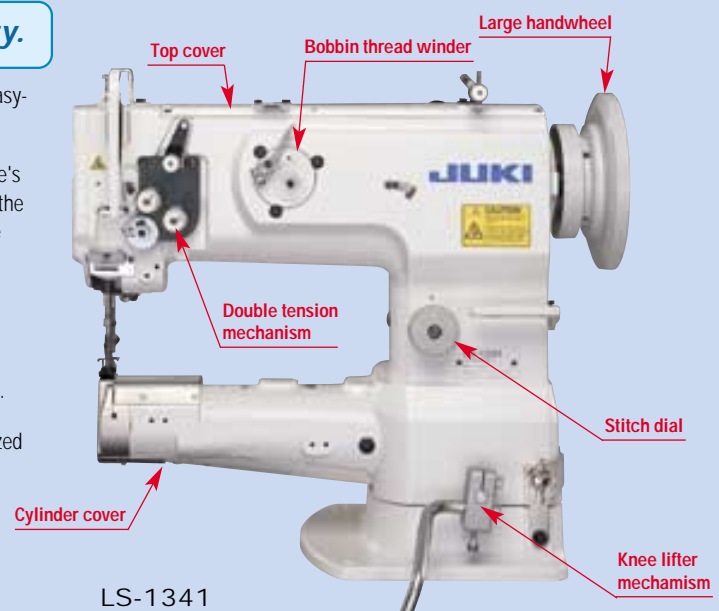
## The vertical stroke of the walking foot and presser foot can be easily set and changed. (LS-1342, LS-1342-7)

- The vertical stroke of the presser foot and walking foot (amount of alternating vertical movement) can be easily changed with the large dial mounted on the top of the machine head. The sewing speed is automatically regulated based on the vertical stroke setting. This ensures ideal sewing conditions at all times.



## Excellent operability and maintainability.

- The underside of the top end of the cylinder-bed is provided with an easy-to-remove cover. This promises easy cleaning of thread wastes.
- The stitch length can be easily selected by the stitch dial. The machine's enhanced operability features include a clear view of the area around the needle, placement of the bobbin thread winder on the front face of the machine arm, and a large handwheel (160mm).
- A knee-lifter mechanism is built in the bed. This reduces the pressure required to operate the knee-lifter and facilitates setup.
- The machine's full-open-type top design makes adjusting works easier.
- The machine comes with a lubricating mechanism that uses a centralized oil wick. This substantially reduces the time and trouble required for oiling the machine. (The hook needs manual oiling with an oiler.)
- A walking foot mechanism is built into the machine arm to prevent oil from scattering.



LS-1341



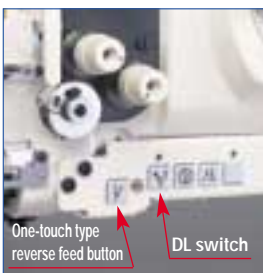
# Cylinder-bed, 1-needle, Unison-feed, Lockstitch Machine with a Large Vertical-axis Hook and an Automatic Thread Trimmer LS-1342-7

**The machine is provided as standard with an instantaneous change-over device for the alternate vertical movement amount (DL device).**



LS-1342-7-0BB/XC-E500  
\* XC-E500 control panel is optionally available.

For sewing processes that handle heavy-weight materials or multi-layered parts of material, the alternating vertical movements of the walking foot and presser foot can be quickly set to maximum by pressing the DL switch. The result is beautiful seams free from gathered stitches.



The machine is provided with both a hand switch and knee switch.

**A helpful automatic reverse feed function is provided as standard.**

With just a light press on the one-touch type reverse feed button, reverse feed stitching is actuated.



**Thread trimming without fail.**

The machine handles thread counts from #30 to #5. Its highly rigid thread trimming mechanism cuts the thread without fail. The machine can be applied to a broad range of sewing processes, including the sewing of bags.

**The area around the needle entry is designed to be easily observed.**

Since the needle thread-tension-release solenoid is fitted on the rear face of the machine head, the area around the needle entry is easily viewable. This substantially improves the operability of the machine.

**Gauge for small articles are provided as standard.**

The throat plate and feed dog are provided with a gauge that offers an excellent capability for the sewing of sharp curves. These gauges are especially useful for the sewing of curves of bags and leather cases.

## OPTIONS

### V type kit

The feed mechanism that can synchronize the binder in the piping-tape attachment process in the sewing of bags. (The V type kit cannot be installed on the LS-1342-7.)

Model name	Part No.
LS-1340	214-34758
LS-1341	214-34857
LS-1342	214-34956



LS-1341

### V type binder N074

Model name	Part No.	Tape width (mm)	Finish width (mm)
LS-1340 LS-1341 LS-1342	MAN-0740M0AB	26	12
	MAN-0740K0AB	22	10
	MAN-0740H0AB	18	8
	MAN-0740F0AC	13 ~ 14	6
	MAN-0740E0AC	11 ~ 12	5

### Gauge, Attachment

Part name	Part No.	Remarks
Edge guide	B9101-340-0A0	-
Binder set plate	B9104-340-000	For binder



Edge guide

### Pedal type lifter

Part No.
214-33404
SM-6051602TP
214-33503
SM-6051552TP × 2
B8133-019-000 × 2
B8131-019-000

### Suspended ruler H152

Part No.
MAH-152010A0
SS-7151610SP × 2
WP-0621016SD × 2
WS-0610002KN × 2

### 3-pedal unit PK75

Part No. GPK-750000A0  
(for LS-1342-7)  
Highly operable 3-pedal unit for standing work.



### Pneumatic auto-lifter

Model name	Type	Part No.	Switch type		Air regulator	
			Knee switch type	Pedal switch type	Not provided	Provided
LS-1340 LS-1341 LS-1342	AK119A	GAK-A19010A0	-	-	-	-
	AK119B	GAK-A19010B0	-	-	-	-
	AK120A	GAK-A20010A0	-	-	-	-
	AK120B	GAK-A20010B0	-	-	-	-
LS-1342-7	AK123C	GAK-A2302EB0	-	-	-	-

### Automatic reverse feed function

Model name	Part No.	Remarks
LS-1340, 1341, 1342	213-48552	Provided with an air regulator

\* To use a pneumatic auto-lifter and reverse feed function in combination with a machine that is without an automatic thread trimmer, select AK119A or AK119B.

### Instantaneous change-over device for the alternate vertical movement amount (DL device).\*

Model name	Part No.	Remarks
LS-1342	GDL-21000AB0	Accessories set containing [DL21 + Automatic reverse feed function + AK123B]
	GDL-21000EA0	[DL21 (E kit)] for installed after the setup of the machine

\* The DL device cannot be used alone. It must be used in a set together with the automatic reverse feed function and AK123B.

\* To mount the DL device to a machine provided with an auto lifter and automatic reverse feed function, the DL21 (E kit) should be purchased separately.

### Combination of optional devices

Model name	Combination	Pneumatic auto-lifter	Automatic reverse feed function	DL device
LS-1340 LS-1341 LS-1342	Automatic reverse feed function	-	-	-
	Pneumatic auto-lifter	AK120A	-	-
		AK120B	-	-
Pneumatic auto-lifter+ Automatic reverse feed function	AK119A	-	-	-
	AK119B	-	-	-
LS-1342	Pneumatic auto-lifter+ Automatic reverse feed function+ DL device	AK119B	-	DL21(E kit)
	Accessories set containing [AK123B+ Automatic reverse feed function+DL21]	-	-	-
LS-1342-7	Pneumatic auto-lifter+ Automatic reverse feed function+ DL device	AK123C	Provided as standard	Provided as standard

# SPECIFICATIONS

Model name	LS-1340	LS-1341	LS-1342	LS-1342-7
Gauge type	Standard		For small articles	
Max. sewing speed	2,500rpm			
Max. stitch length	6mm(Normal/Reverse feed)			
Needle bar stroke	36mm			
Lift of the presser foot	By hand: 9mm, By knee: 16mm			
Thread take-up	Slide type			
Amount of alternating vertical movement	2.5 ~ 6.5mm		1 ~ 6.5mm	
Hook	Vertical-axis standard hook	Vertical-axis 1.6 fold-capacity hook		
Needle (at the time of delivery)	135 x 17 (Nm140) Nm100 ~ Nm180	135 x 17 (Nm160) Nm100 ~ Nm180		
Thread	#50 ~ #8, B33 ~ B92, Nm=120/3 ~ 30/3	#40 ~ #5, B33 ~ B138, Nm=90/3 ~ 20/3	#30 ~ #5, B46 ~ B138, Nm=60/3 ~ 20/3	
Safety mechanism	Provided as standard			
Lubrication	Centralized oil wick lubrication (hook: by an oiler)			
Lubricating oil	JUKI New Defrix Oil No.2(equivalent to ISO VG32)			
Distance from needle to machine arm	255mm			
Cylinder-bed diameter	72mm			
Weight of the machine head	37.5kg		40kg	
Automatic reverse feed function	Option		Provided as standard	
Power requirement	-		Single-phase 100 ~ 120V, 220 ~ 240V 3-phase 200 ~ 220V, 220 ~ 240V	

To order, please contact your nearest JUKI distributor.

## WHEN YOU PLACE ORDERS

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

[Without an automatic thread trimmer] [With an automatic thread trimmer]

LS-134

LS-1342-7-OB

Specification	Code
Vertical-axis standard hook	1340
Vertical-axis 1.6 fold-capacity hook	1341
Vertical-axis 1.6 fold-capacity hook / Gauge for small articles*	1342

Specification	Code
Vertical-axis 1.6 fold-capacity hook / Gauge for small articles	1342

Pneumatic auto-lifter	Code
Not provided	
Pedal switch type (AK123C)	B

\* For the LS-1342, a servomotor or motor with an electronic stop mechanism should be used. (Speed control is required.)

[PSC box/control panel for SC]

SC-380-

PSC box		Code	
For General Export	Single-phase	220 ~ 240V	07
	3-phase	200 ~ 220V	11
For JUS(LA)*	Single-phase	110 ~ 120V	37
	3-phase	220 ~ 240V	38
For CE	Single-phase	220 ~ 240V	34

Control panel	Code
Not provided	00000
Control panel display language:English. Instruction manual comes in three different languages.	E500B
Control panel display language:English. Instruction manual comes in five different languages.	E500C

[Motor for SC]

M

Motor		Code	
For General Export	Single-phase	200 ~ 240V	60
	3-phase		
For JUS(LA)*	Single-phase	100 ~ 120V	61
	3-phase	200 ~ 240V	62
For CE	Single-phase	200 ~ 240V	63

\* JUS: North America and Central and South America.

### AC servomotor/controller SC-380

- The SC-380 is provided with many different standard functions, including speed-control, soft-start, automatic reverse stitching with the specified number of stitches, constant-dimension stitching, and overlapped (multi-layered) stitching. These functions ensure sewing performance optimally suited to the material and process.



### Control panel that improves functions of the sewing machine (optional)

- The XC-E500 is provided with program sewing and a host of other functions that contribute to increased efficiency.

XC-E500



**JUKI**<sup>®</sup>  
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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.



**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.