

**JUKI®**

**MH-380** (parallel 2-needle)

**MH-382** (tandem 2-needle)

High-speed, Flat-bed, 2-needle Double Chainstitch Machine



**MH-382**

**MH-380**

**MH-380 • MH-382**

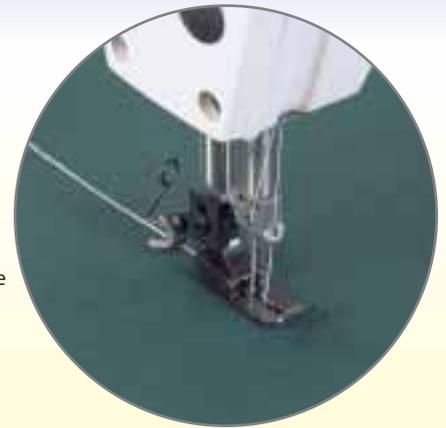
Various attachments allow the machine to adapt to many different processes.

Many different attachments have been developed for the machine. This means that the JUKI MH Series sewing machine can adapt to many kinds of processes and specifications including hemming, welting and decorative stitching. Accurate stitching performance and durable finished seams are particularly necessary in the chainstitching process. JUKI ensures high-quality sewing with a higher degree of consistency with its unique looper mechanism and consistent condensation stitching mechanism. Furthermore, highly efficient operation is achieved by using a chain-off thread cutting device.



#### MH-380

(Parallel 2-needle, double chainstitching machine)  
\*Equipped with a lapping seam folder as standard



#### MH-382

(Tandem 2-needle, double chainstitching machine)



Stitch dial

Lever for condensation stitching

MH-380

### The machine ensures outstanding reliability and durability.

It comes with JUKI's unique inclined crank type looper mechanism. This gives the machine outstanding durability. You can use the sewing machine for a long time without ever worrying about looper failure.

### Stitch length can be adjusted with ease.

The machine incorporates a stitch dial for adjusting the stitch length. For lockstitch machines, which are the most popular type of sewing machines, the stitch length is also adjusted using a stitch dial. This means you can adjust the stitch length as desired without difficulty.

### The machine is capable of performing consistent condensation stitching, ensuring finished seams of higher quality.

You can easily set the machine to perform condensation stitching by operating the lever. Condensation stitches that prevent the thread from fraying can be consistently sewn.

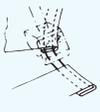
### Many different kinds of attachments contribute to enhanced production efficiency.

Attachments (optional) have been prepared for many different applications, including sewing sides of jeans, slacks and skirts, hemming pockets, making decorative stitches on tape for sportswear. Furthermore, a chain-off thread cutter (AT-8, optional) that helps enhance production efficiency is also available.

## DEVICES AND ATTACHMENTS

● **Chain-off thread cutter**

**AT-8**

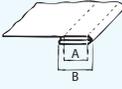


**Applicable machines:** MH-380, MH-382  
**Class of work:** Jeans, Working wear  
**Applications:** Cut a chaining thread bridging two workpieces continuously sewn by chainstitch in the way that a knife blade of the cutter is dropped. Best suited for continuous sewing on pocket openings of jeans or working wear.

Guide width mm (in)	Part No.
Tandem 2-needle	40042785
4.0 (5/32)	40042787
4.8 (3/16)	40042788
6.4 (1/4)	40042790
7.9 (5/16)	40042791

● **Down turn hemmer**

**L050**



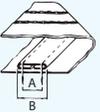
**Applicable machines:** MH-380  
**Class of work:** Jeans, Working pants  
**Applications:** Hem jeans hip pocket mouth, especially suit for sections where high quality straight stitch is required.

Finished width (mm)	Part No.
14	MAL-0500POAO
12	MAL-0500MOAO
11	MAL-0500LOAO
10	MAL-0500KOAO

A: Needle gauge  
B: Finished width

● **Decorative tape attaching foot**

**B050**



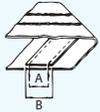
**Applicable machines:** MH-380  
**Class of work:** Sportswear, Training wear, Swimsuits, Uniforms, Boxer pants, Rompers  
**Applications:** Stitch accent line attach tapes  
**Materials:** Cotton bias tape, or plain woven tape for some limited process.

Finished width (mm)	Needle gauge mm (in)	Tape width (mm)	Part No.
17	12.7 (1/2)	34	MAB-0500SLAO
15	9.5 (3/8)	30	MAB-0500QKAO
12	7.9 (5/16)	24	MAB-0500MHAO
10	6.4 (1/4)	20	MAB-0500KFAO
8	4.8 (3/16)	16	MAB-0500HDAO
6	4.0 (5/32)	14	MAB-0500GCAO

A: Needle gauge  
B: Finished width

● **Decorative tape attaching foot**

**B051**



**Applicable machines:** MH-380  
**Class of work:** Ladies' wear, Children' wear, Sportswear, Uniforms  
**Applications:** Attach decorative tapes and reinforcement tapes  
**Materials:** Tape: Synthetic suede cloth tape, decorative tape, plain woven tape. Contact us for special type of tapes.

Finished width (mm)	Needle gauge mm (in)	Part No.
17	12.7 (1/2)	MAB-0510SLAO
15	9.5 (3/8)	MAB-0510QKAO
12	7.9 (5/16)	MAB-0510MHAO
10	6.4 (1/4)	MAB-0510KFAO
9	5.6 (7/32)	MAB-0510JEAO
8	4.8 (3/16)	MAB-0510HDAO

A: Needle gauge  
B: Finished width

● **Tape cutter**

**AT28**



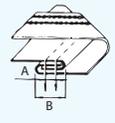
**WHEN YOU PLACE ORDERS**

Switch	Code	Needle gauge mm (in)	Code
Finger switch	A	3.2 (1/8")	B
Knee switch	B	4.0 (5/32")	C
		4.8 (3/16")	D
		5.6 (7/32")	E
		6.4 (1/4")	F
		7.9 (5/16")	H
		9.5 (3/8")	K
		12.7 (1/2")	L

\*Needle gauges, 1/8, 5/32, 3/16, 3/8 and 1/2, should be specially ordered.

● **Lap seam folder (Reverse)**

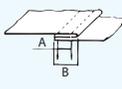
**M052**



A: Needle gauge  
B: Finished width

● **Left feed top stitch folder**

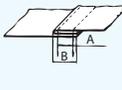
**M054**



A: Needle gauge  
B: Finished width

● **Right feed top stitch folder**

**M055**



A: Needle gauge  
B: Finished width

**Applicable machines:** MH-380  
**Class of work:** Jeans, Working pants, Pants, Overalls  
**Applications:** Sew side seams  
**Materials:** Medium heavy-weight materials and heavy-weight materials such as denim, drill, etc.

Finished width (mm)	Needle gauge mm (in)	Part No.
17	12.7 (1/2)	MAM-0520SOAO
14	9.5 (3/8)	MAM-0520POAO
12	7.9 (5/16)	MAM-0520MOAO
10	6.4 (1/4)	MAM-0520KOAO
10	5.6 (7/32)	MAM-0520K0AO
9	4.8 (3/16)	MAM-0520JOAO

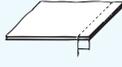
**Applicable machines:** MH-380  
**Class of work:** Jeans, Working pants, Jackets, Skirts  
**Applications:** Sew side seams. Attach flat faces of garments.

Finished width (mm)	Needle gauge mm (in)	Part No.
17	12.7 (1/2)	MAM-0540SOAO
14	9.5 (3/8)	MAM-0540POAO
12	7.9 (5/16)	MAM-0540MOAO
10	6.4 (1/4)	MAM-0540KOAO
10	5.6 (7/32)	MAM-0540K0AO
9	4.8 (3/16)	MAM-0540JOAO
8	4.0 (5/32)	MAM-0540HOAO

**Applicable machines:** MH-380  
**Class of work:** Jeans, Working pants, Jackets, Skirts  
**Applications:** Sew side seams. Attach flat faces of garments.

Finished width (mm)	Needle gauge mm (in)	Part No.
17	12.7 (1/2)	MAM-0550SOAO
14	9.5 (3/8)	MAM-0550POAO
12	7.9 (5/16)	MAM-0550MOAO
10	6.4 (1/4)	MAM-0550KOAO
10	5.6 (7/32)	MAM-0550K0AO
9	4.8 (3/16)	MAM-0550JOAO
8	4.0 (5/32)	MAM-0550HOAO

● **Superpose joining guide**

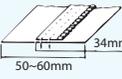


Edge allowance: Max. 20mm

**Applicable machines:** MH-382  
**Applications:** Used with lockstitch machines or chainstitch machines to sew side seam, and similar runstitch & joining edge of garments with different curve lines

Type	Part No.
Light-weight material	MAH-027000AA
Medium-weight material	MAH-027000AB
Heavy-weight material	MAH-027000AH
Spacer (assy.)	MAH-025020AO

● **Zipper guide**



**Applicable machines:** MH-380  
**Class of work:** Jeans, Working pants  
**Applications:** Sew zippers on left files  
**Materials:** Medium-weight materials such as jeans denim, cotton gabardine, drill etc.

Part No.
MAQ-020000AO

## SPECIFICATIONS

- Applicable model :** MH-380 (Cannot be use with the thread trimmer type.)  
**Operating method :** Air drive by air switch  
**Applications :** Cutting various tapes related to attaching reinforcement tape and decorative tape  
**Cut specifications :** Knife width 20mm  
 Cutting range of the knife 16mm or less  
**Air pressure :** 0.15~0.5 MPa (1.5~5.0kgf/cm<sup>2</sup>)

## APPLICATIONS

Model	Application
<b>MH-380 (parallel 2-needle)</b>	<ul style="list-style-type: none"> <li>Sewing sides of slacks</li> <li>Hemming or welting garment parts</li> <li>Attaching lining tape</li> </ul>
<b>MH-382 (tandem 2-needle)</b>	<ul style="list-style-type: none"> <li>Joining seat of slacks</li> </ul>

## TABLE OF EXCHANGING GAUGE SETS

### MH-380

Description Gauge components	Throat plate	Needle clamp asm.	Presser foot asm. (with finger guard)	Feed dog	Rear moving needle guard	Right fix needle guard	Left needle guard
3.2mm (1/8")	B1103-380-B00	B1406-019-BA0	B1509-038-BB0	B1613-380-B00	B2311-380-B00	B2315-380-000	B2312-380-000
4.0mm (5/32")	B1103-380-C00	B1406-019-CA0	B1509-038-CB0				
4.8mm (3/16")	B1103-380-D00	B1406-019-DA0	B1509-038-DB0	B1613-380-D00	B2311-380-E00	B2315-380-000	B2312-380-000
5.6mm (7/32")	B1103-380-E00	B1406-019-EA0	B1509-038-EB0	B1613-380-F00			
6.4mm (1/4")	B1103-380-F00	B1406-019-FA0	B1509-038-FB0	B1613-380-H00	B2311-380-H00	B2315-380-000	B2312-380-000
7.9mm (5/16")	B1103-380-H00	B1406-038-HA0	B1509-038-HB0				
9.5mm (3/8")	B1103-380-K00	B1406-038-KA0	B1509-038-KB0	B1613-380-K00	B2311-380-L00	B2315-380-000	B2312-380-000
12.7mm (1/2")	B1103-380-L00	B1406-038-LA0	B1509-038-LBB	B1613-380-L00			

### MH-382

—	B1103-382-000	B1406-019-BA0	B1524-382-0B0	B1613-382-000	B2311-382-000	B2312-382-000
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### MH-380

Description Gauge components	Right looper	Left looper	Bed slide asm.	Bed slide asm.	Folder		
					M	MH	H
3.2mm (1/8")	B2030-380-000	B2031-380-000	B1104-380-AA0	B1108-380-BA0	B9126-038-BAA	B9126-038-BAB	B9126-038-BAC
4.0mm (5/32")					B9126-038-CAA	B9126-038-CAB	B9126-038-CAC
4.8mm (3/16")					B9126-038-DAA	B9126-038-DAB	B9126-038-DAC
5.6mm (7/32")					B9126-038-EAA	B9126-038-EAB	B9126-038-EAC
6.4mm (1/4")					B9126-038-FAA	B9126-038-FAB	B9126-038-FAC
7.9mm (5/16")					B9126-038-HAA	B9126-038-HAB	B9126-038-HAC
9.5mm (3/8")				—	—	—	
12.7mm (1/2")				—	—	—	B1108-380-LA0

### MH-382

—	B2030-380-000	B2031-380-000	B1104-380-AA0	B1108-380-BA0	—	—	—
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## SPECIFICATIONS

Model name	MH-380	MH-382
	Parallel 2-needle	Tandem 2-needle
Max. sewing speed	6,000sti/min *	
Max. stitch length	4mm	
Lift of the presser foot	By hand: 5.5mm, By knee: 10mm	
Needle bar stroke	30mm	
Needle (at the time of delivery)	TV×7 (#14) #9~#21	
Thread take-up	Needle bar thread take-up	
Stitch length adjustment	By stitch dial (lockstitch)	
Condensation stitches	By lever for condensation stitching	
Looper system	Rocking type looper	
Looper stroke	22.6mm	
Elliptical motion	2.4~3.7mm	
Lubrication	Automatic	
Lubricating oil	JUKI New Defrix Oil No.1 (equivalent to ISO VG7)	
Needle cooler	Optional	

\* "sti/min" stands for "Stiches per Minute"



JUKI CORPORATION HEAD OFFICE  
An environmental management system to promote and conduct the following:  
(1) Eco-friendly development of products and technologies  
(2) Green procurement and green purchasing  
(3) Energy conservation (reduction in carbon-dioxide emissions)  
(4) Resource saving (reduction of papers purchased, etc.)  
(5) Reduction and recycling of waste  
in the activities of research, development, design, sales, distribution, and maintenance services of industrial sewing machines and industrial robots, etc., including sales and maintenance services of data entry systems.

### 1) Size code

3.2mm (1/8") = B
4.0mm (5/32") = C
4.8mm (3/16") = D
5.6mm (7/32") = E
6.4mm (1/4") = F
7.9mm (5/16") = H
9.5mm (3/8") = K
12.7mm (1/2") = L

### 2) Folder code

M (for light weight materials) = A
MH (for medium heavy weight materials) = B
H (for heavy weight materials) = C

## WHEN YOU PLACE ORDERS

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

MH380 U MH382U

Needle gauge	Code	B	C	D	E	F	G	H	K	L	N
mm		3.2	4.0	4.8	5.6	6.4	7.1	7.9	9.5	12.7	19.1
inch		1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	1/2	3/4

● To order, please contact your nearest JUKI distributor.

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http://www.juki.com

\* 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 catalogue prints with environment-friendly soy ink on recycle paper.