

BAS-311F-0

Programmable Electronic Pattern Sewer
With Cylinder Bed



Model

BAS-311F-0□□

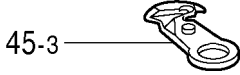


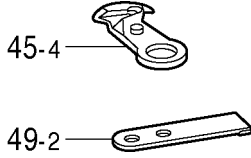
1	For heavy-weight materials
2	For medium-weight materials
3	For extra heavy-weight materials
4	For special use

S	Work clamp lifter (Solenoid type)
A	Work clamp lifter (Pneumatic type)

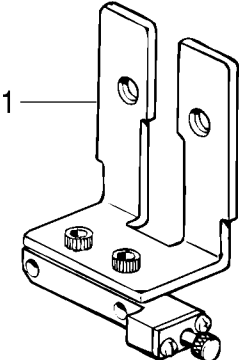
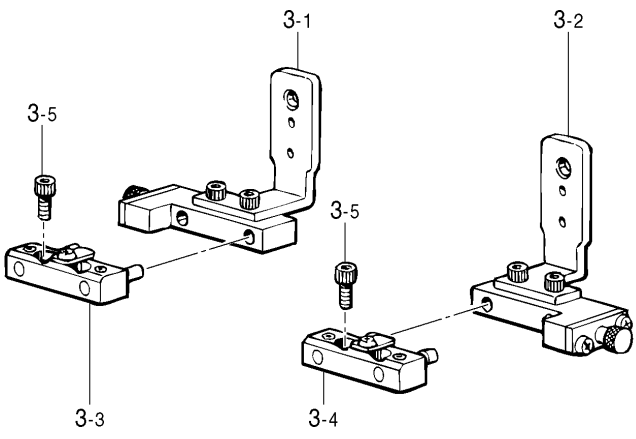
Specifications

Stitch formation	Single needle lock stitch
Sewing machine	Lock stitch, pattern tacking sewing machine (with large shuttle hook)
Maximum pattern size	130 × 60 mm
Maximum stitch number	20,000 (One pattern)
Stitch length	0.05 - 12.7 mm
Maximum sewing speed	2,500 rpm (When stitch length is 3 mm or less)
Feed mechanism	Intermittent feed, pulse motor drive
Rotary hook	Shuttle hook (Standard rotary hook is sold separately)
Needle	DP × 5, DP × 17, MR
Data storage method	3.5 floppy disk 2HD/1.44 MB, 2DD
Test function	Operation test function provided for use with low speed drive
Safety devices	Automatic stop function for activation in the event of misoperation realized with intermediate stop function and safety circuits
Work clamp height	For solenoid – Max. 25 mm, for pneumatic – Max. 30 mm
2-step work clamp	For solenoid – unit work clamp, for pneumatic – separate work clamp
Work clamp lift stroke	18 mm
Intermittent stroke	0 or 3 (Factory default) – 8 mm
Weights	Machine head: 65 kg, Control box: 10-20 kg (Depending on destination)
Power supply	Single-phase 110 V, 220 V, 230V, 240 V 3-phase 220 V, 380 V, 400 V, 600 VA
Motor	Three-phase 400 W induction motor
Air pressure	0.5 MPa 1.8 l/min
Power table	T-shaped for use sitting or standing
Machine dimensions	Sitting: 1,200 W × 590 D × 1,120 H mm Standing: 1,350 H mm (Excluding spool stand)

Thread trimmer mechanism

Standard part	Ref. No.	Part name	Part code	Q'ty
 <p>45-3</p>	45-3	Movable knife assy, N	S49988-001	1
 <p>49-1</p>	49-1	Fixed knife	S10210-201	1
Option part	Ref. No.	Part name	Part code	Q'ty
 <p>45-1 45-2</p>	45-1	Movable knife assy	S10205-001	1
	45-2	Movable knife assy, L	S40934-101	1
For Kevlar thread	Ref. No.	Part name	Part code	Q'ty
 <p>45-4</p> <p>49-2</p>	45-4	Movable knife assy	S31612-001	1
	49-2	Fixed knife, hard material	S30128-001	1

One-touch work clamp (Option parts)

	Ref. No.	Part name	Part code	Q'ty
 <p>1</p>	1	One-touch holder assy, UN	S24612-001	1
 <p>3-1 3-2</p> <p>3-5</p> <p>3-3 3-4</p>	3	One-touch work clamp set	S44794-001	1
	3-1	One-touch holder assy, L	S20280-101	1
	3-2	One-touch holder assy, R	S20286-101	1
	3-3	Work clamp holder assy, L	S20289-101	2
	3-4	Work clamp holder assy, R	S20293-101	2
	3-5	7本ボルト 4.37 x 8 Bolt, socket SM 4.37 x 8	018680-822	8

Work clamp

	Ref. No.	Part name	Part code	Q'ty
	75-3	Work clamp guide bracket	S42798-001	1
	75-4	Work clamp adjusting plate	S42799-001	2
	75-5	Adjusting plate	S42800-001	2
	75-6	Work clamp, SE - OP	S42802-001	2
	75-7	Screw, pan SM3.57 – 40 x 5	062670-512	4

*These optional parts are used to prevent work clamp looseness.

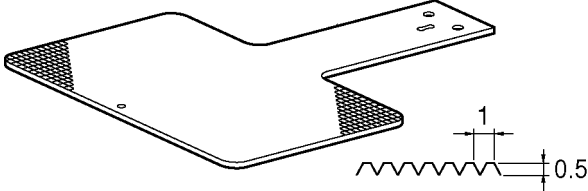
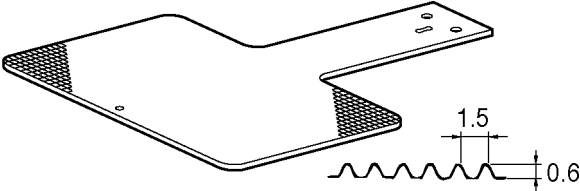
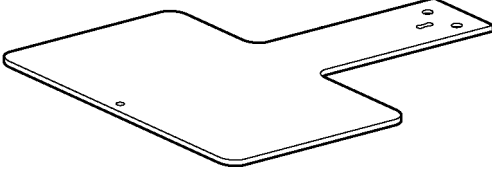
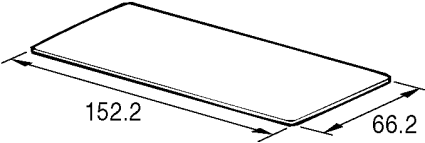
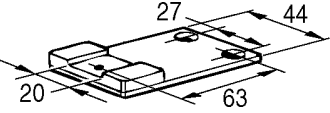
Blank for work clamp

	Part name	Part code	Q'ty
	<Thick 3.2 mm> Work clamp blank, A – 3.2	S43824-001	1
	<Thick 4.0 mm> Work clamp blank, A – 4.0	S43826-001	1
	<Thick 5.0 mm> Work clamp blank, A – 5.0	S43828-001	1
	<Thick 3.2 mm> Work clamp blank, B – 3.2	S43825-001	1
	<Thick 4.0 mm> Work clamp blank, B – 4.0	S43827-001	1
	<Thick 5.0 mm> Work clamp blank, B – 5.0	S43829-001	1
	<Thick 6.0 mm> Work clamp blank, – 6.0	S43830-001	1

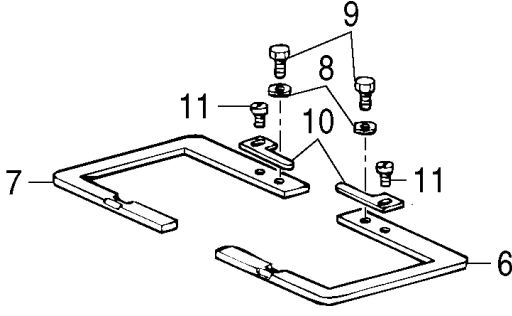
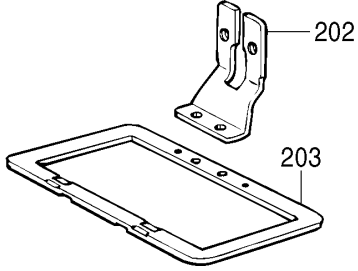
One-touch cassette clamp assy

	Part name	Part code	Q'ty
	<Thick 0.5 mm> Cassette clamp assy, OT 311	S43691-001	1
	<Thick 1.0 mm> Cassette clamp assy, OT 311	S43691-002	1
	<Thick 2.0 mm> Cassette clamp assy, OT 311	S43691-003	1

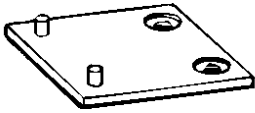
For feed plate attachment

	Part name	Part code	Q'ty
	Feed plate blank, A 311	S55164-001	1
	Feed plate blank, B 311	S55165-001	1
	Feed plate blank, C 311	S55166-001	1
	Feed plate inner plate	S43823-001	1
	Feed plate setting bracket	S12586-001	1

Work clamp

	Ref. No.	Part name	Part code	Qty
	6	Work clamp, R 311	S42772-001	1
	7	Work clamp, L 311	S42773-001	1
	8	Washer, plain M4.37	025680-232	2
	9	Bolt, SM4.37 x7	153403-002	2
	10	Positioning plate	S10065-001	2
	11	Screw, pan SM4.37-40 x 5	062680-512	2
	202	Work clamp, UN ; SOL	S43986-201	1
	203	Work clamp, 311 UN	S43987-001	1

For one-touch work clamp

	Part name	Part code	Qty
	OT - feed plate bracket assy	S14841-001	1

Feed plate blank for one-touch work clamp

	Part name	Part code	Qty
	<Thick 1.2 mm> OT – feed plate blank, A	S43700-001	1
	<Thick 1.2 mm> OT – feed plate blank, B	S43821-001	1
	<Thick 1.2 mm> OT – feed plate blank, C	S43822-001	1

For sewing the bar tack "61.5 x 86.5"

	Ref. No.	Part name	Part code	Qty
	159	Work clamp, SR	S14254-001	1
	160	Work clamp, SL	S14255-001	1
	163	OT – work clamp assy, D	S14846-001	2
	164	Screw, flange SM4.37	149168-001	2

Feed plate for one-touch work clamp

	Part name	Part code	Qty
	For denim <Thick 1.2 mm> OT – feed plate blank, DE	S14253-001	1
	For general <Thick 1.2 mm> OT – feed plate	S14252-001	1

For one-touch work clamp
For basting the vent

	Ref. No.	Part name	Part code	Q'ty
	165	Feed plate	S13092-001	1
	166	Work clamp, R	S13090-001	1
	167	Work clamp, L	S13091-001	1

For attaching the thread loop

	Ref. No.	Part name	Part code	Q'ty
	168	Feed plate	S13098-001	1
	169	Work clamp, R	S13096-001	1
	170	Work clamp, L	S13097-001	1

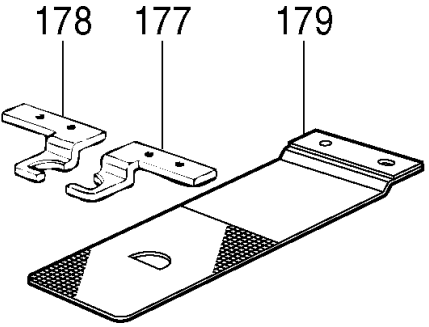
For sewing the bar tack "23 x 6"

	Ref. No.	Part name	Part code	Q'ty
	171	Work clamp, R311 - 004	S23818-001	1
	172	Work clamp, L311 - 004	S23819-001	1
	173	Feed plate, 311 - 004	S23820-001	1

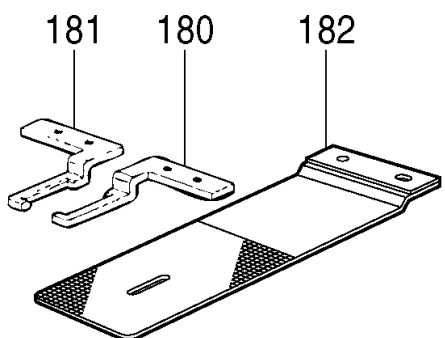
For sewing the bar tack "10.4 x 4.4"

	Ref. No.	Part name	Part code	Q'ty
	174	Work clamp, R311 - 005	S23821-001	1
	175	Work clamp, L311 - 005	S23822-001	1
	176	Feed plate, 311 - 005	S23823-001	1

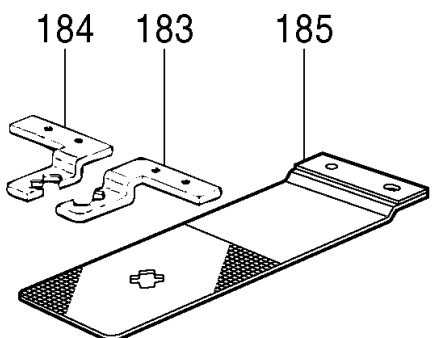
For one-touch work clamp
 For sewing the bar tack "Semi-circle"

	Ref. No.	Part name	Part code	Q'ty
	177	Work clamp, R311 – 006	S23824-001	1
	178	Work clamp, L311 – 006	S23825-001	1
	179	Feed plate, 311 - 006	S23826-001	1

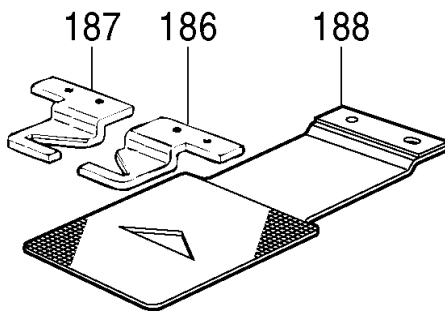
For sewing the bar tack "6 x 23"

	Ref. No.	Part name	Part code	Q'ty
	180	Work clamp, R311 – 007	S23827-001	1
	181	Work clamp, L311 – 007	S23828-001	1
	182	Feed plate, 311 - 007	S23829-001	1

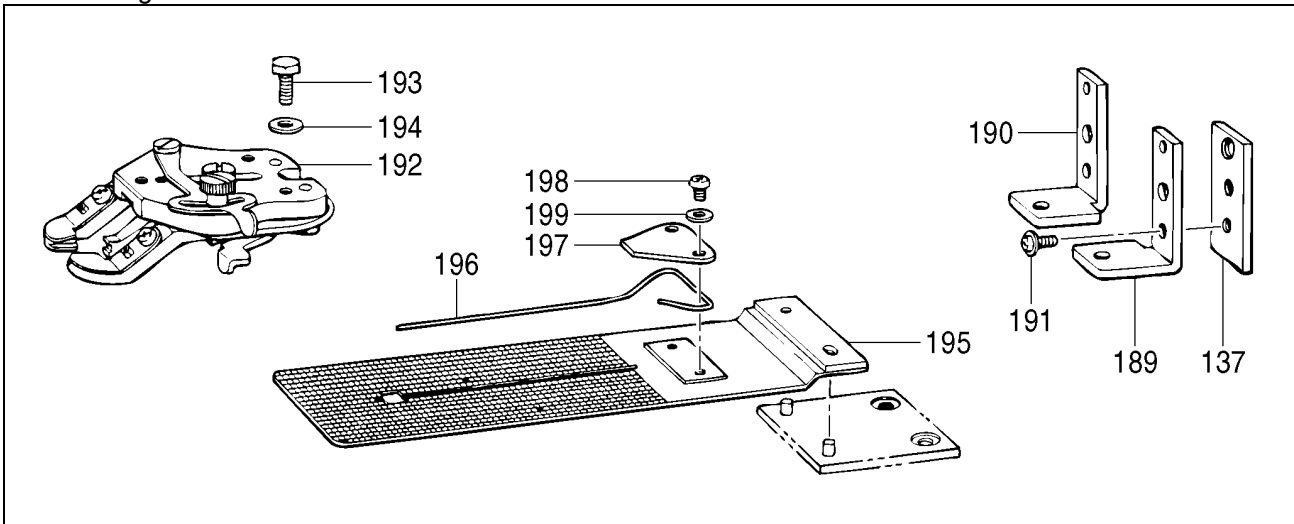
For sewing the bar tack "X - cross"

	Ref. No.	Part name	Part code	Q'ty
	183	Work clamp, R311 – 008	S23830-001	1
	184	Work clamp, L311 – 008	S23831-001	1
	185	Feed plate, 311 - 008	S23832-001	1

For sewing the bar tack "Triangle"

	Ref. No.	Part name	Part code	Q'ty
	186	Work clamp, R311 – 009	S23833-001	1
	187	Work clamp, L311 – 009	S23834-001	1
	188	Feed plate, 311 - 009	S23835-001	1

For attaching the button



Ref. No.	Part name	Part code	Q'ty
137	Button clamp holder	S31365-000	2
189	BU work clamp, U - R	S14848-001	1
190	BU work clamp, U - L	S14849-001	1
191	Screw, flange SM4.37	149168-001	2
192	Button clamp assy	S30015-001	1
193	Bolt, SM4.76	117363-001	2
194	Washer, plain M4.76	025710-232	2
195	OT - feed plate, 7 plain	S14069-001	1
196	Spring, 1.2	153871-001	1
197	Spring	S14073-001	1
198	Screw, pan SM3.57 - 40 x 5	062670-512	2
199	Washer, plain 4	102707-002	2

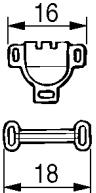
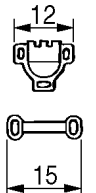
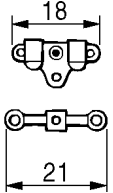
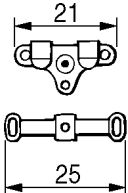
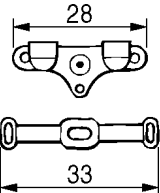

For one-touch work clamp

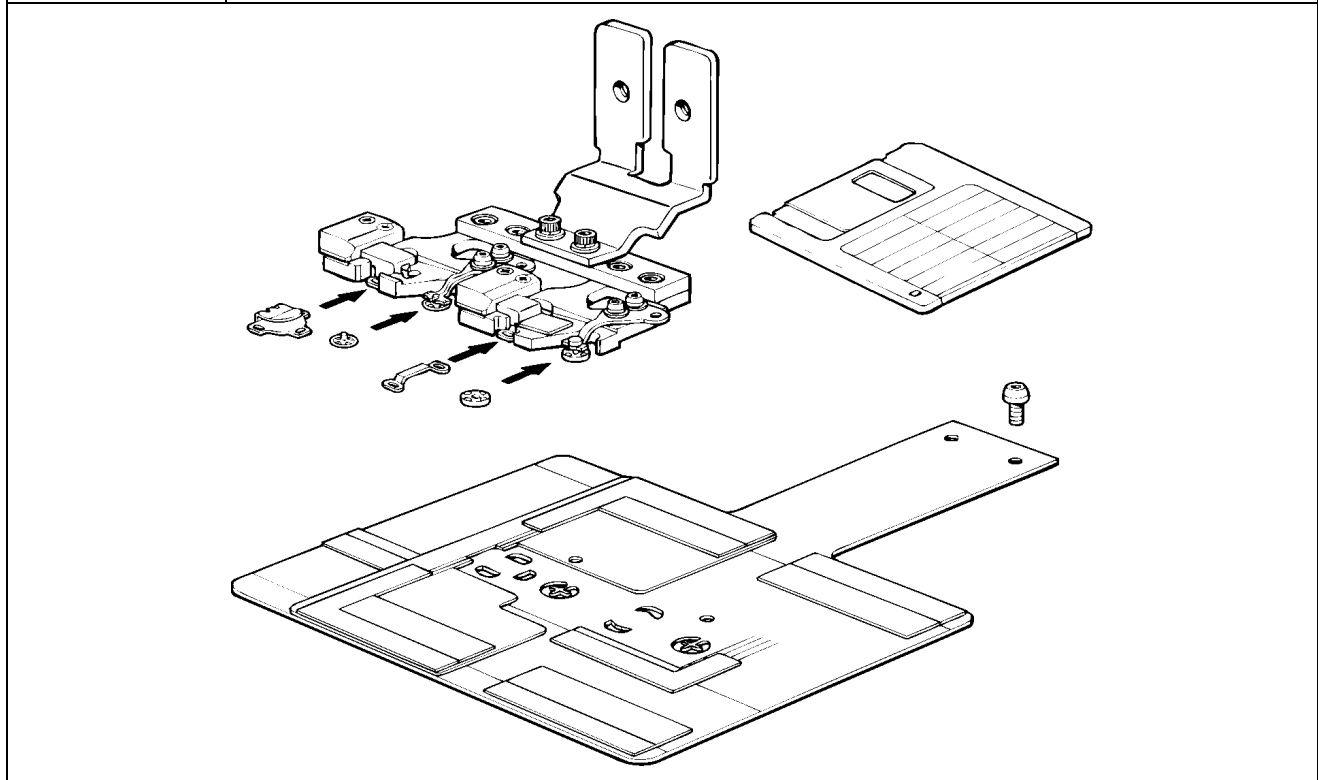
	Ref. No.	Part name	Part code	Q'ty
	156	Holder plate, cassette	S13006-001	1
	157	Pin, cassette holder	S13007-001	2
	158	Nut, 3 SM3.18 - 40	021660-306	2

For gauge parts

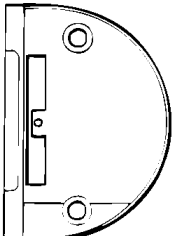
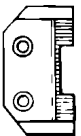
	Part name	Part code	Q'ty
	H - position standard plate assy	S42888-001	1

Snap fastener and hook attachment device

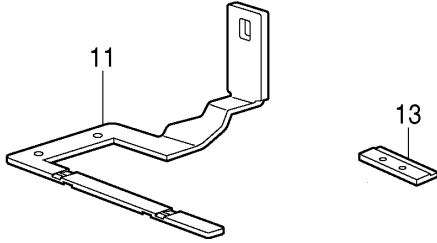
Part name	311 – S.H device set				
	M - 508K	M - 528K	M - 520K	M - 525K	M - 533K
Part code	S42803-001	S42806-001	S42808-001	S42810-001	S42812-001
Hook size (mm)					
Snap size (mm)	OM $\phi 7.6, \phi 8.6$ 				



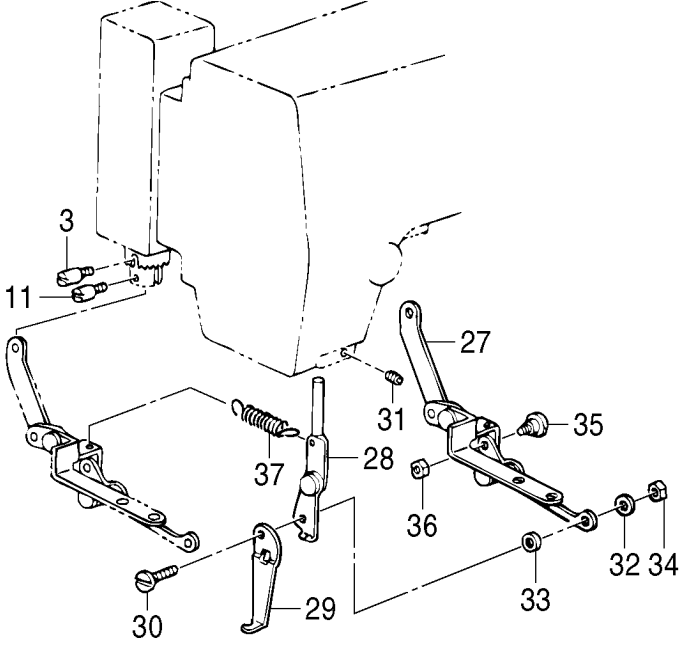
For sewing the belt with hook

	Part name	Part code	Qty
	Needle plate, H	S13099-001	1
	Feed dog, H	S13100-001	1

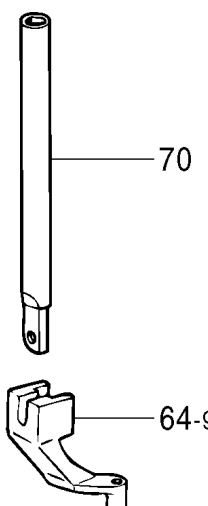
Option parts

			
Ref. No.	Part name	Part code	Qty
11	Outer work clamp foot, 312-2	S12644-001	1
13	Inner clamp, LL	S10542-001	1

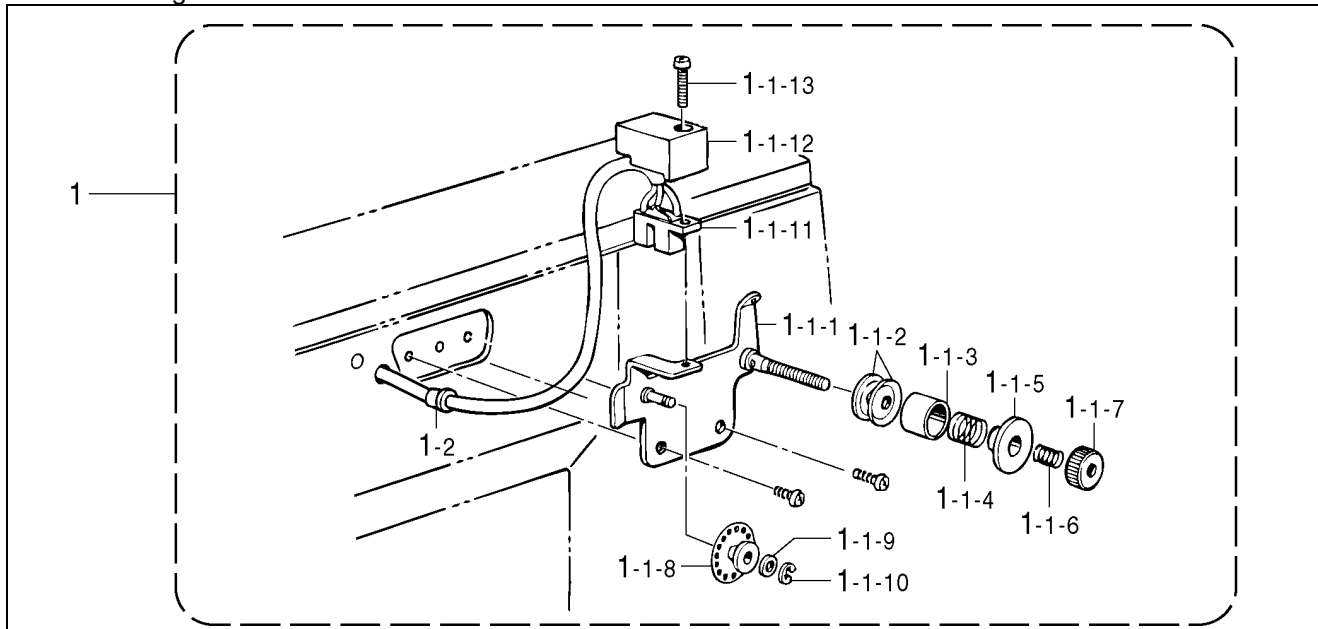
Thread wiper mechanism

			
Ref. No.	Part name	Part code	Qty
3	Plunger pin	S25456-001	1
11	Plunger pin	S25456-001	1
27	Thread wiper assy, side	S42859-001	1
28	Wiper arm assy	S42864-101	1
29	Thread wiper, A	156206-001	1
30	Screw, SM3.57 x 10	S13385-001	1
31	Set screw, socket (CP) SM4.76	014710-522	1
32	Washer	S21875-001	1
33	Collar	S12668-001	1
34	Nut, 2 SM3.57	021670-202	1
35	Shoulder screw, SM3.18	100659-001	1
36	Nut, 1 SM3.18	021660-102	1
37	Spring	159111-001	1

Thread wiper mechanism

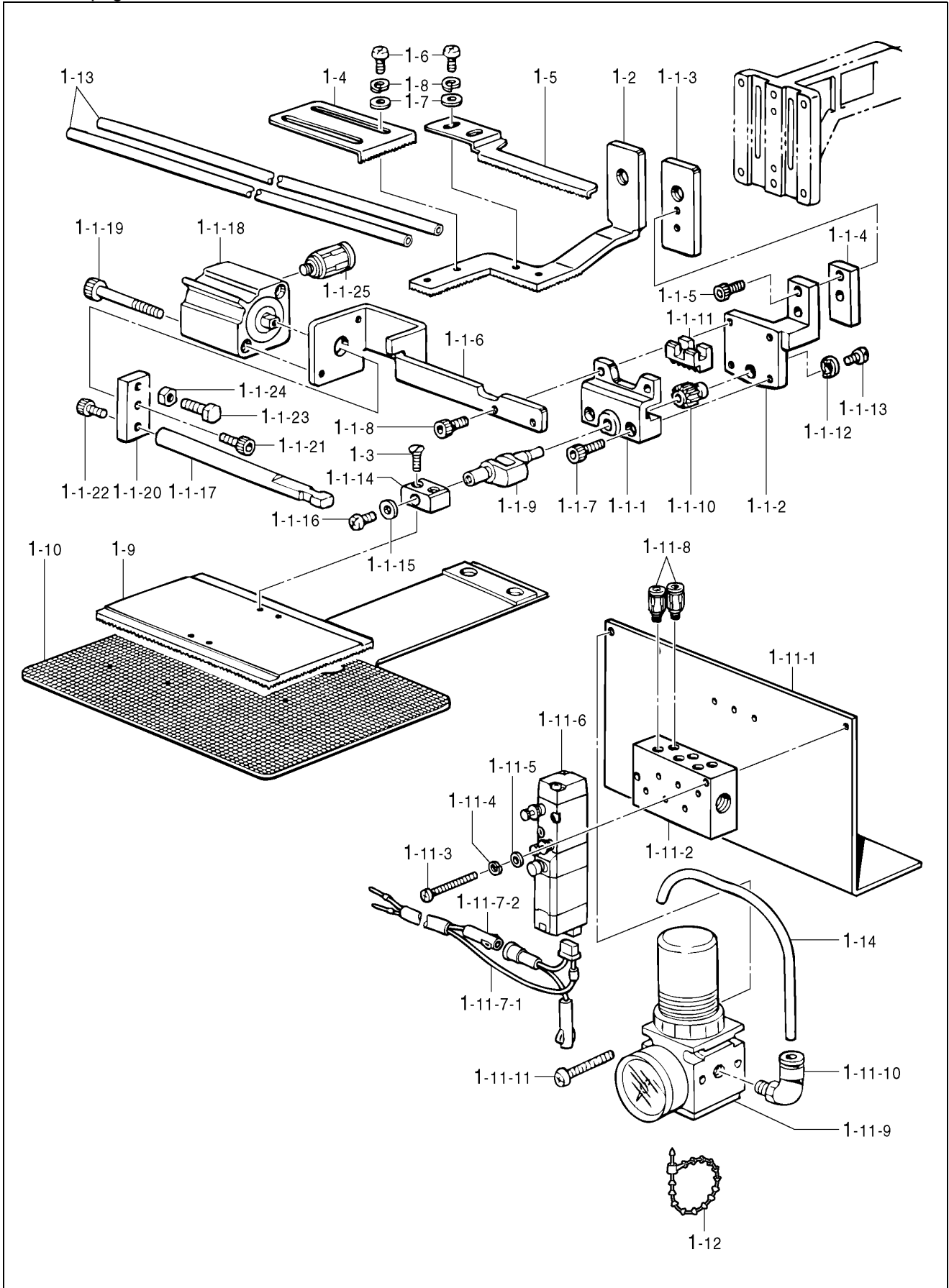
	Ref. No.	Part name	Part code	Q'ty
	64-9	Presser foot, XA	S42849-101	1
	70	Presser bar, side	S42880-001	1

Thread breakage detector



Ref. No.	Part name	Part code	Q'ty
1	TR. breakage detector set, R	S43833-109	1
1-1	TR. breakage detector assy, R	S43834-109	1
1-1-1	Detector bracket assy	S18032-001	1
1-1-2	Disc, thread guide	144504-001	2
1-1-3	Disc, thread guide	146206-009	1
1-1-4	Pre-tension spring	146058-001	1
1-1-5	Pre-tension nut	146059-001	1
1-1-6	Spring	146060-000	1
1-1-7	Tension nut	155510-001	1
1-1-8	Pulley, A	157255-100	1
1-1-9	Washer, plain S3	025030-135	1
1-1-10	Retaining ring, E2	048020-342	1
1-1-11	Sensor assy	S43835-100	1
1-1-12	Sensor cover	S18037-009	1
1-1-13	Screw, pan M3 x 16	062301-616	1
1-2	Cord bush	146080-000	1

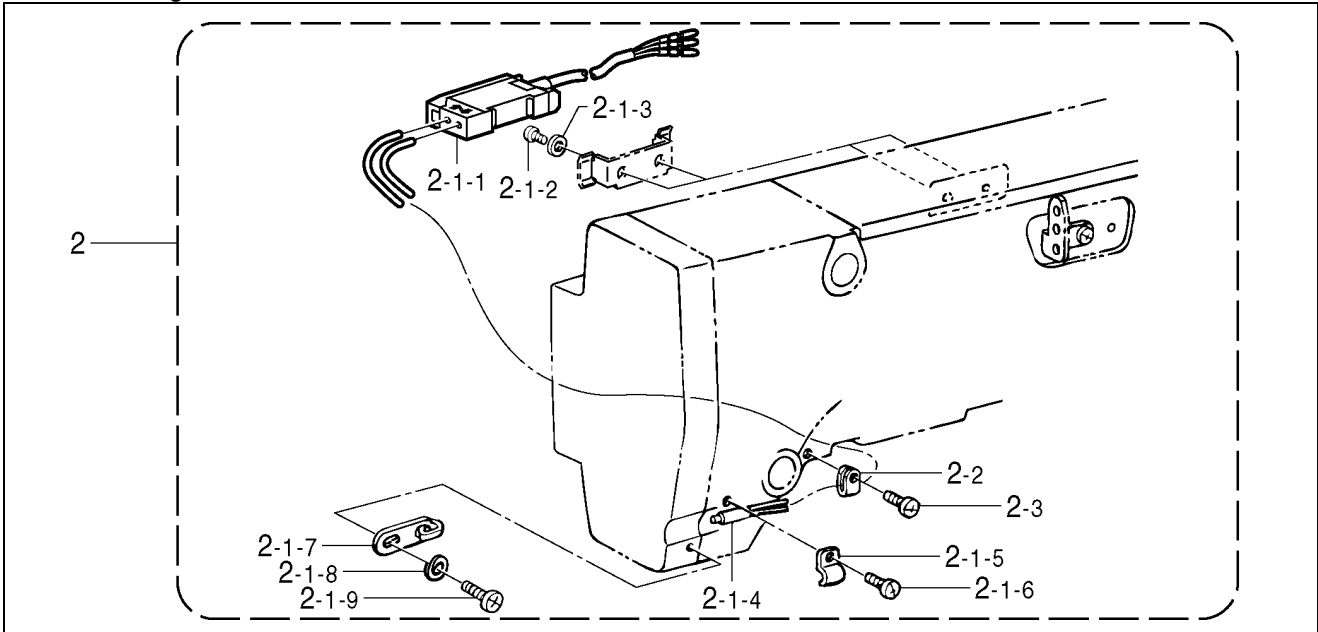
Inner clamping device



Inner clamping device

Ref. No.	Part name	Part code	Qty
1	Inner clamping device set	S44793-009	1
1-1	Work clamp clank assy, LA	S12633-209	1
1-1-1	Work clamp crank holder, A	S12634-009	1
1-1-2	Work clamp crank holder, B	S12635-009	1
1-1-3	Work clamp crank holder, C	S12636-001	1
1-1-4	Washer, crank holder	S12641-009	1
1-1-5	Bolt, socket SM4.37 – 40 x 12	018681-232	2
1-1-6	Reverse cylinder bracket	S12638-009	1
1-1-7	Bolt, socket M3 x 12	018301-236	2
1-1-8	Bolt, socket M3 x 10	018301-036	2
1-1-9	Work clamp clank, LA	S05665-001	1
1-1-10	Reverse gear	154235-001	1
1-1-11	Reverse rack	154236-001	1
1-1-12	Washer	145087-001	1
1-1-13	Set screw, SM3.18	149831-101	1
1-1-14	Work clamp plate holder, L	154237-001	1
1-1-15	Washer, plain S3.5	025350-132	1
1-1-16	Screw, SM3.57	100242-003	1
1-1-17	Reverse rod	S12637-009	1
1-1-18	Reverse cylinder	S12639-001	1
1-1-19	Bolt, socket M3 x 35	S12642-009	2
1-1-20	Joint	S12640-009	1
1-1-21	Bolt, socket M3 x 8	018300-836	1
1-1-22	Bolt, socket M3 x 8	018300-836	1
1-1-23	Bolt, M5 x 12	017501-216	1
1-1-24	Nut, 2 M5	021500-216	1
1-1-25	Half union, Q4M5	S18415-101	2
1-2	Outer work clamp, 312 – 1	S12643-001	1
1-3	Screw, flat SM3.18	117291-002	2
1-4	Positioning plate, L	154252-001	1
1-5	Positioning plate, R	154253-001	1
1-6	Screw, pan SM3.57 – 40 x 5	062670-512	4
1-7	Washer, plain L3.5	025350-332	4
1-8	Washer, spring 2 – 3.5	028350-242	4
1-9	Work clamp plate blank, A	154256-101	1
1-10	Feed plate blank, 312 – 1	S12645-001	1
1-11	Inner clamp valve assy, 3	S44745-009	1
1-11-1	Valve setting plate, 4 – 5H	S31570-209	1
1-11-2	Air manifold, 3	S44748-001	1
1-11-3	Screw, pan M3 x 25	062302-505	2
1-11-4	Washer, spring 2 – 3	028030-242	2
1-11-5	Washer, plain M3	025030-232	2
1-11-6	Solenoid valve	S43683-001	1
1-11-7	Valve harness, x 1	S43696-000	1
1-11-7-1	Valve harness	S44746-000	1
1-11-7-2	Valve harness, 24 V	S44750-000	1
1-11-8	Half union, Q4M5	S18415-101	2
1-11-9	Regulator assy	S45252-000	1
1-11-10	Joint, 3109-4-10	S45254-000	2
1-11-11	Screw, pan M4 x 40	062404-005	2
1-12	Bead band	340400-001	2
1-13	Air tube, 4L = 1300	S03803-000	2
1-14	Air tube, 4L = 300	S28741-000	1

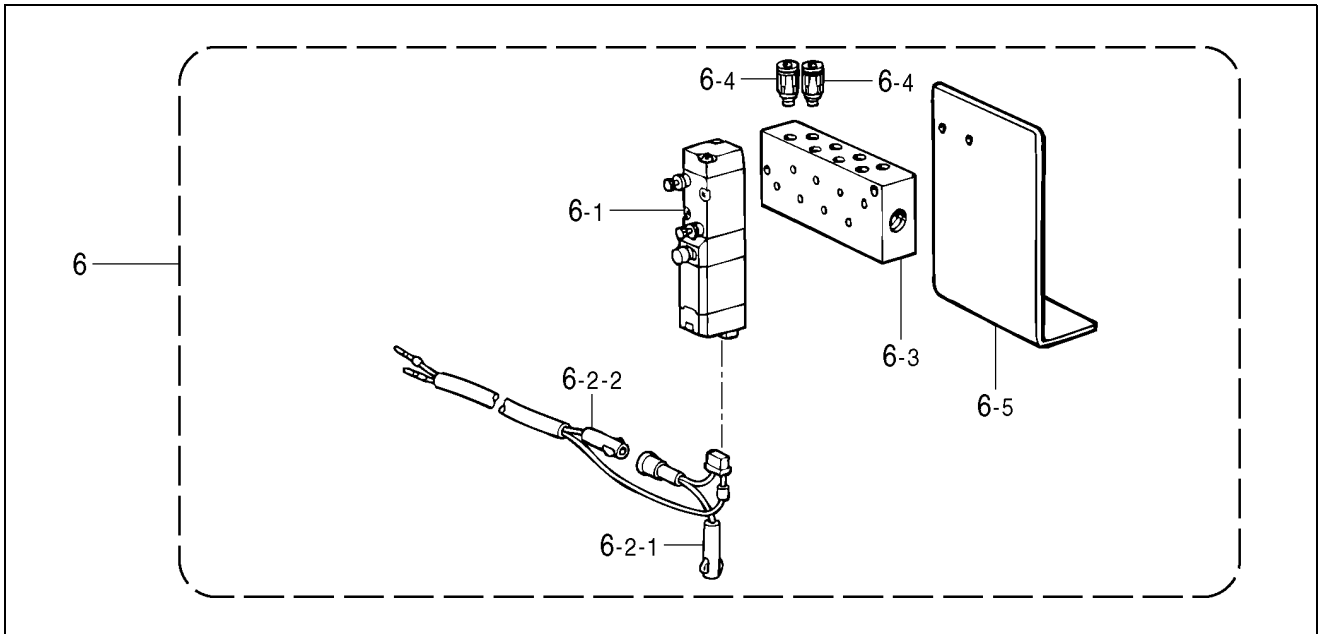
Thread breakage detector



Ref. No.	Part name	Part code	Qty
2	TR. breakage detector set, F	S43836-301	1
2-1	TR. breakage detector assy, F	S43977-201	1
2-1-1	Amplifier unit	S43279-200	1
2-1-2	Screw, pan M3 x 6	062300-612	2
2-1-3	Washer, plain M3	025030-232	2
2-1-4	Fiber unit, N	S29468-100	1
2-1-5	Sensor setting plate	S11884-001	1
2-1-6	Screw, pan M3 x 6	062300-612	1
*2-1-7	Thread guide, face plate	S02617-001	1
*2-1-8	Washer, spring 2-3.5	028350-242	1
*2-1-9	Screw, bind SM3.57-40 x 6	060670-612	1
*2-2	Cord holder, NK-2N	625010-000	1
*2-3	Screw, bind SM3.57-40 x 6	060670-612	1

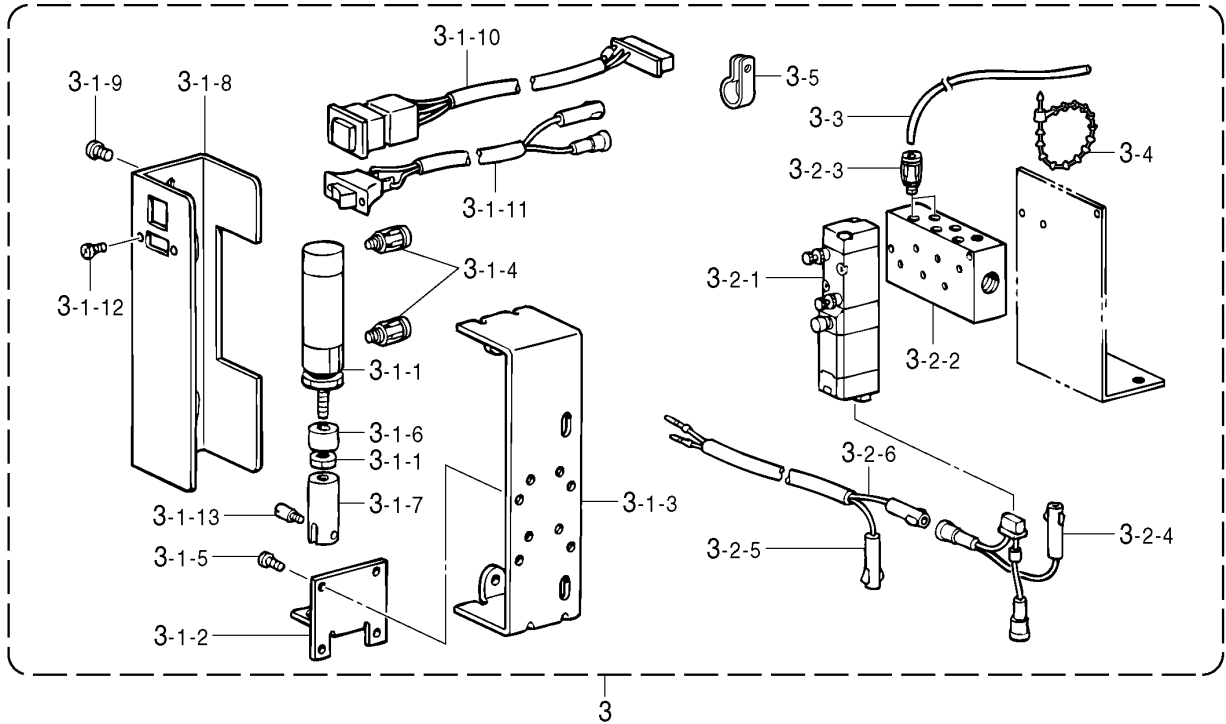
The part indicated with * is for BAS-311E, 311F-0, and 311EL.

Solenoid valve



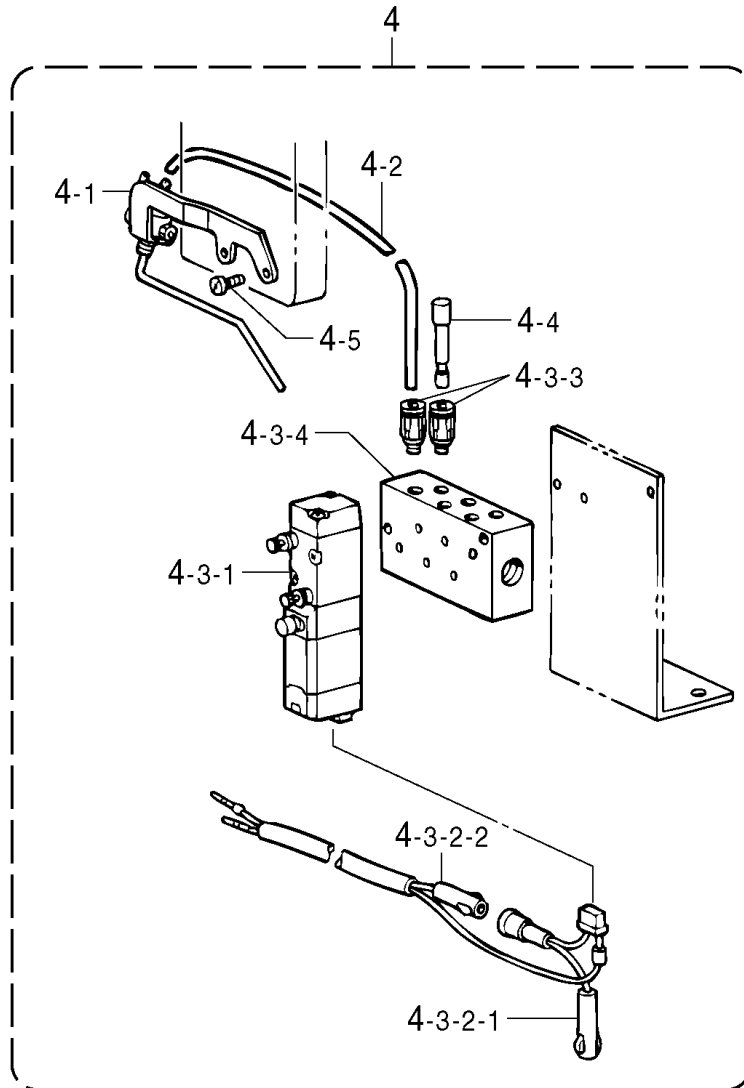
Ref. No.	Part name	Part code	Qty
6	Solenoid valve assy, OP4	S43847-201	1
6-1	Solenoid valve	S43683-001	1
6-2	Valve harness, x 1	S43696-000	1
6-2-1	Valve harness	S44746-000	1
6-2-2	Valve harness, 24V	S44750-000	1
6-3	Air manifold, 4	S44749-001	1
6-4	Half union, Q4M5	S18415-101	2
6-5	Setting plate, 4-5 valve	S31554-009	1

Pneumatic thread wiper



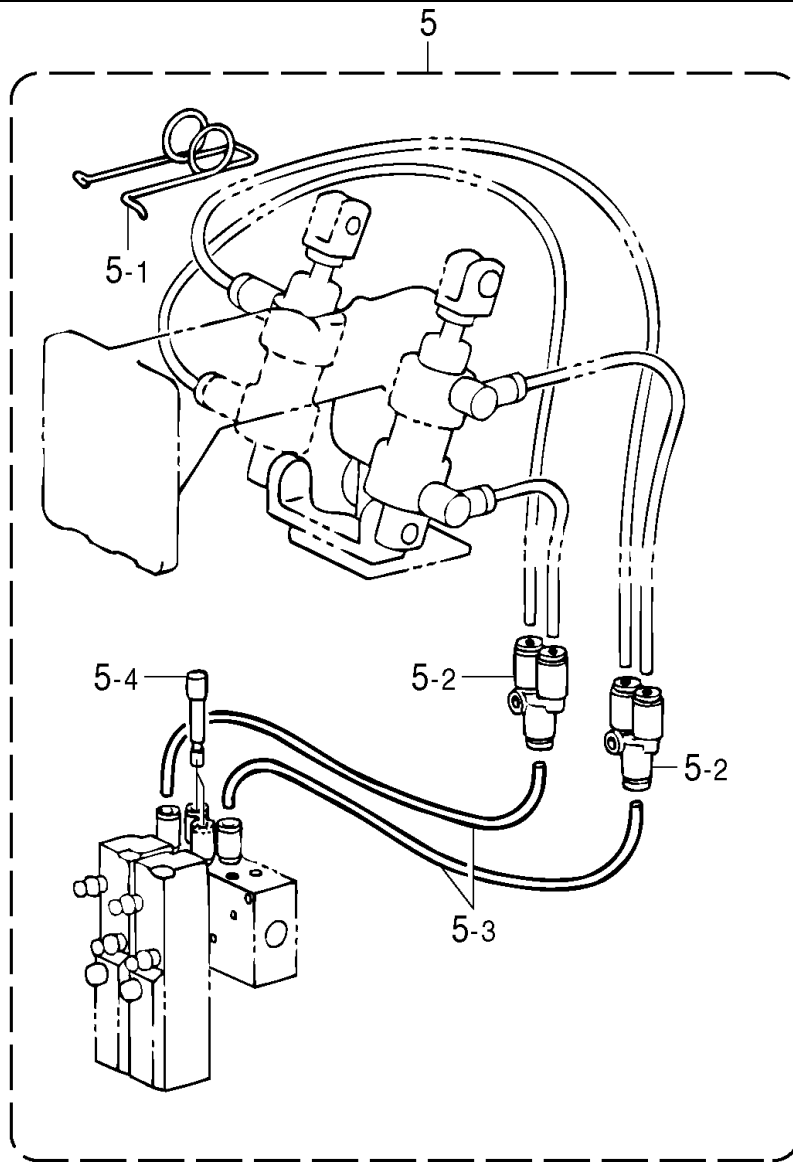
Ref. No.	Part name	Part code	Qty
3	TR. wiper set, pneumatic type	S43841-109	1
3-1	TR. wiper assy, pneumatic type	S43842-109	1
3-1-1	Air cylinder	S17942-100	1
3-1-2	Cylinder support plate	S31777-001	1
3-1-3	Setting plate, solenoid	S10214-109	1
3-1-4	Half union, Q4M5	S18415-101	2
3-1-5	Screw, pan SM3.57-40 x 6	062670-612	4
3-1-6	Stopper, cylinder	S31778-000	1
3-1-7	Joint, cylinder	S31779-001	1
3-1-8	Cylinder cover	S31776-109	1
3-1-9	Screw, pan SM4.37-40 x 5	062680-512	2
3-1-10	EM-switch assy	S43203-000	1
3-1-11	Thread wiper switch assy	S43843-009	1
3-1-12	Screw, pan M3 x 6	062300-612	2
3-1-13	Plunger pin	S02680-001	1
3-2	AW-solenoid valve assy, 3	S43844-001	1
3-2-1	Solenoid valve	S43683-001	1
3-2-2	Air manifold, 3	S44748-001	1
3-2-3	Half union, Q4M5	S18415-101	2
3-2-4	AW-valve harness, A	S44759-000	1
3-2-5	AW-valve harness, B	S44760-000	1
3-2-6	Valve harness, 24V	S44750-000	1
3-3	Air tube, 4L = 1900	S15031-008	2
3-4	Bead band	340400-001	7
3-5	Cord holder, 7N	149287-000	4

Needle cooler



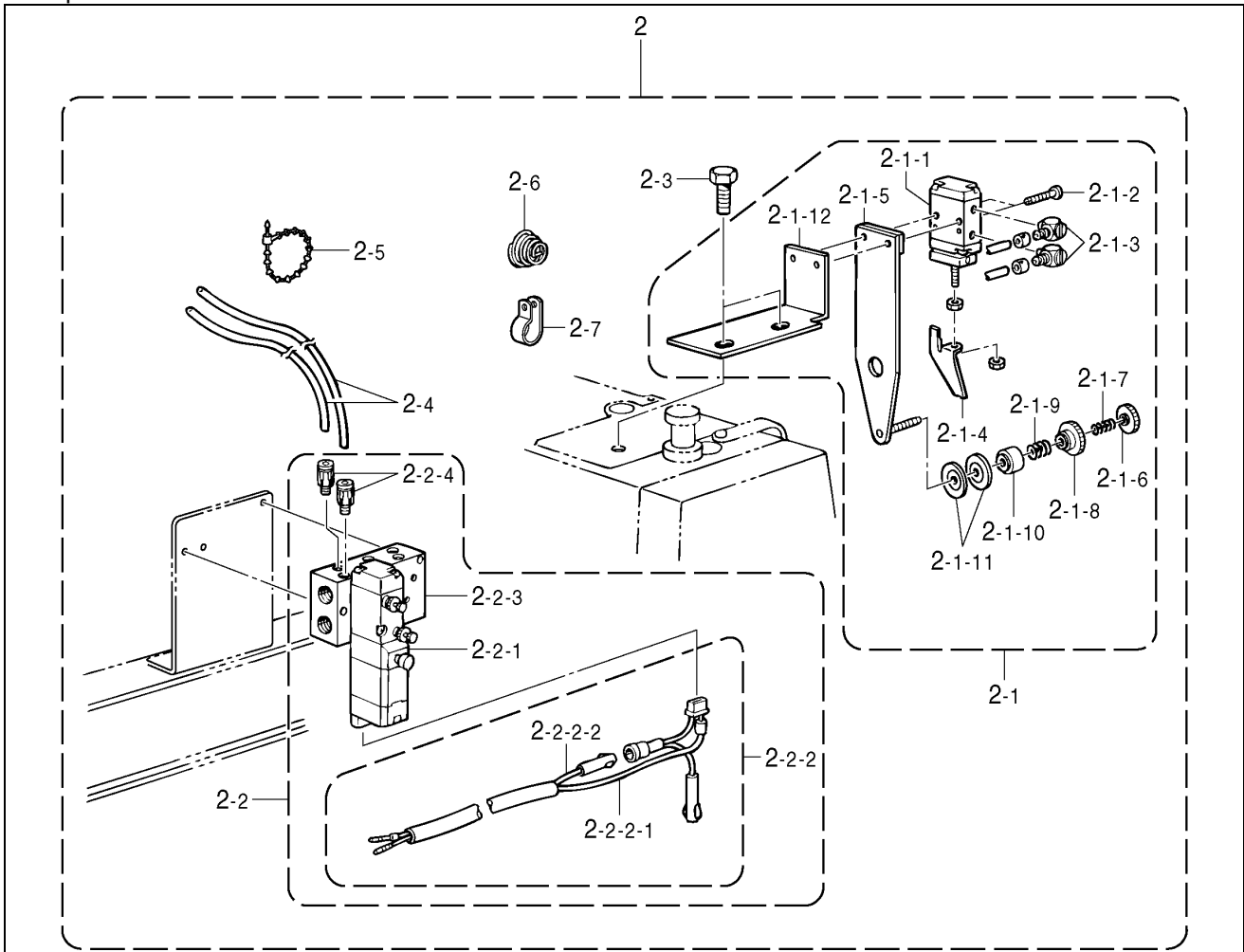
Ref. No.	Part name	Part code	Qty
4	Needle cooler set	S43846-009	1
4-1	Needle blower	S18027-101	1
4-4-2	Air tube, 4L=1900	S15031-008	1
4-3	Solenoid valve assy, OP3	S43839-008	1
4-3-1	Solenoid valve	S43683-001	1
4-3-2	Valve harness, x 1	S43696-000	1
4-3-2-1	Valve harness	S44746-000	1
4-3-2-2	Valve harness, 24V	S44750-000	1
4-3-3	Air manifold, 3	S44748-001	1
4-3-4	Half union, Q4M5	S18415-101	2
4-4	Plug, 4	S04897-000	1
4-5	Screw, pan SM3.57-40 x 8	062670-812	2

Soft work clamp



Ref. No.	Part name	Part code	Qty
5	Soft work clamp set	S43979-001	1
5-1	Spring	S43980-001	1
5-2	Union, Y4	S12104-000	2
5-3	Air tube, S-C (L=200)	S08140-000	2
5-4	Plug, 4	S04897-000	2

2-step thread tension device



Ref. No.	Part name	Part code	Qty
2	2-step thread tension device set, 1	S43837-001	1
2-1	2-step thread tension assy	S43838-001	1
2-1-1	Air cylinder, 10 x 10	S34706-000	1
2-1-2	Bolt, socket M3 x 20	018302-032	2
2-1-3	Tube elbow, M-5HL-4	S12150-000	2
2-1-4	Countersink claw	S34533-001	1
2-1-5	Sub tension bracket assy	S34534-001	1
2-1-6	Tension nut	155510-001	1
2-1-7	Spring	146060-000	1
2-1-8	Pre-tension nut	146059-001	1
2-1-9	Pre-tension spring	146058-001	1
2-1-10	Disc presser, thread guide	146206-009	1
2-1-11	Disc, thread guide	144504-001	2
2-1-12	Cylinder setting bracket	S34536-001	1
2-2	Solenoid valve assy, OP3	S43839-005	1
2-2-1	Solenoid valve	S43683-001	1
2-2-2	Valve harness, x 1	S43696-000	1
2-2-2-1	Valve harness	S44746-000	1
2-2-2-2	Valve harness, 24V	S44750-000	1
2-2-3	Air manifold, 3	S44748-001	1
2-2-4	Half union, Q4M5	S18415-101	2
2-3	Bolt, SM7.94 x 18	017821-813	2
2-4	Air tube, 4L=1900	S15031-008	2
2-5	Bead band	340400-001	5
2-6	Spring, tension	104525-001	1
2-7	Cord holder, 7N	149287-000	3

GAUGE PARTS LIST

Presser foot

Ref. No. A ★	Ref. No. B	Ref. No. C	Ref. No. D
Ref. No. E	Ref. No. F	Ref. No. G	Ref. No. J
Ref. No. XA			

Needle hole plate

Ref. No. A	Ref. No. D	Ref. No. E ★	Ref. No. ED	Ref. No. F ★
Ref. No. FD	Ref. No. H	Ref. No. L	Ref. No. M ★	Ref. No. FM
Ref. No. 3	Ref. No. A-F			

GAUGE PARTS LIST

Ref. No.	Part name	Part code	Qty
A	Presser foot, A	S42843-001	1
	"OPTION PARTS"		
B	Presser foot, B	S42844-001	1
C	Presser foot, C	S42845-001	1
D	Presser foot, D	S42846-001	1
E	Presser foot, E	S42847-001	1
F	Presser foot, F	157237-001	1
G	Presser foot, G	158592-001	1
J	Presser foot, J	S42848-001	1
	<For Horizontal wiper>		
XA	Presser foot, XA	S42849-101	1
	<311F for Heavy-weight materials>		
E	Needle hole plate, E $\phi 2.6$	S10212-101	1
	<311F for Medium-weight materials>		
F	Needle hole plate, F $\phi 2.2$	S10213-001	1
	<311F for Extra heavy-weight materials>		
M	Needle hole plate, M $\phi 4.0$	S34348-001	1
	"OPTION PARTS"		
A	Needle hole plate, A $\phi 1.6$	S10211-001	1
D	Needle hole plate, D $\phi 2.6$	S29997-001	1
ED	Needle hole plate, ED $\phi 3.4$	S30925-001	1
FD	Needle hole plate, FD $\phi 2.2$	S30926-001	1
H	Needle hole plate, H $\phi 2.6$	S30450-001	1
L	Needle hole plate, L $\phi 3.3$	S25127-001	1
FM	Needle hole plate, FM $\phi 2.2$	S49980-001	1
3	Needle hole plate, 3 $\phi 3.0$	S40217-001	1
A-F	Needle hole plate, A-F $\phi 1.6$	S51449-001	1

*The parts marked with ★ are standard parts