








AUTOMATED-SEWING-SYSTEMS



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Welcome to A-S-S AG



STEFAN ORESKOVIC
Chairman of the Board



HELMUT NEUBURGER
Chairman of Sales

To develop and build high quality and efficient sewing systems in Germany: with this requirement we founded the A-S-S AG in the year 2000. Previously we had been working for more than 25 years with renowned manufacturers of our industry. These experiences have linked with fresh ideas, which consistently meet customer requirements and create innovative solutions. So our company could constantly grow. Today, among others, seam-closing and pocket welting machines as well as engineered workstations are to be found in our portfolio. The sales figures have passed meanwhile over 6,000 machines.

Made in Germany: We constrain, program and assemble exclusively in our factory in Bessenbach near Aschaffenburg. This guarantees a consistently high quality for all our machines - also individual pieces and small series, which we produce for the individual customer requirements.

Your Board of Directors

Stefan Oreskovic Helmut Neuburger

In the middle of Germany



Conveniently located

Our company location in Bessenbach near to Aschaffenburg in Germany is only a 30 minute drive from Frankfurt international airport.

Visitors and interested customers are always welcome to visit us. After an appointment agreement our production unit can be shown as well.

Own solar system on the roof of our Companies building

Since July 2011, our own company solar system has been producing clean electricity from solar energy.

Every sewing system that leaves our building has been manufactured climate-neutral.



Quality from A to Z

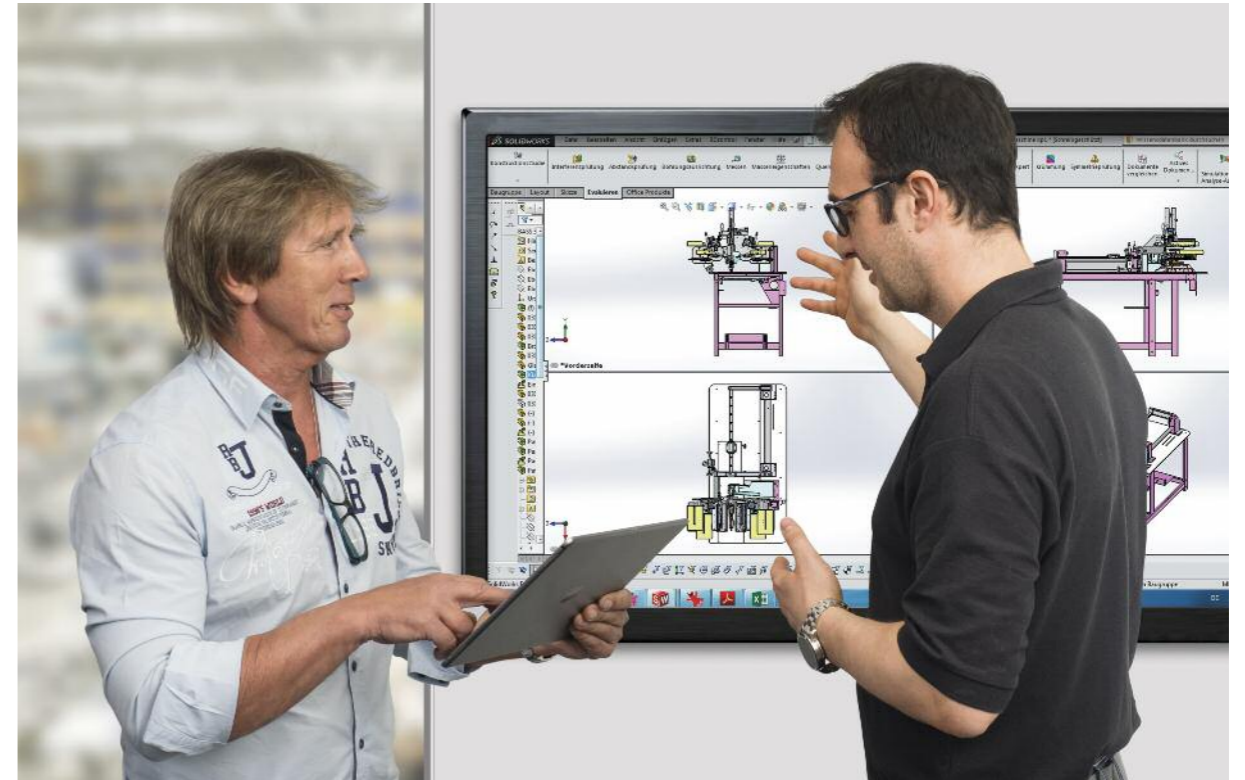


Development – Construction – Programming

Our knowledge of market and customers ensures to built our sewing systems consistent to meet the needs. This applies both for modifications of proven products as well as for new developments. Our technicians also produce small parts, such as needle holders, sewing feet or needle plates. What we are particularly distinguished for, is the development and construction of individual sewing systems for specific requirements.

Accurate and individually matching

All work steps are carried out at A-S-S AG under one roof. Short distances and constant information exchange provide a smooth teamwork of the involved engineers. Our customers benefit from this: in all A-S-S sewing systems hardware and software are perfectly matched and yield first-class results.





Assembly

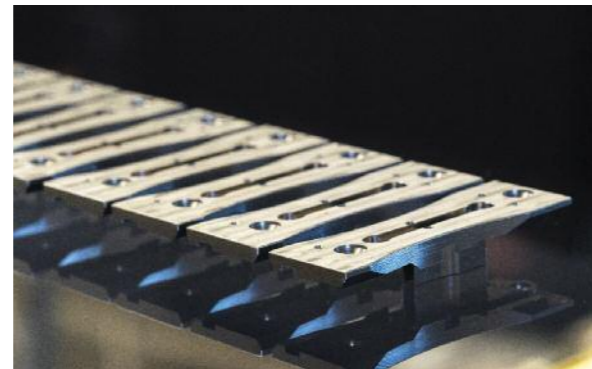
We use only high quality materials and components that guarantee a long-term and efficient operation of the sewing systems. The assembly as well as various test runs are carried out at our plant in Bessenbach. After delivery, our Technicians take over the installation and the first commissioning at customers place.





CNC-milling

Last but not least, our focus is on the mechanical processing, which is realized with highest precision. With modern CNC milling we manufacture high-quality components for our sewing systems. Timely agreements between the respective experts of our company ensure, that all manufacturing processes are optimally coordinated.



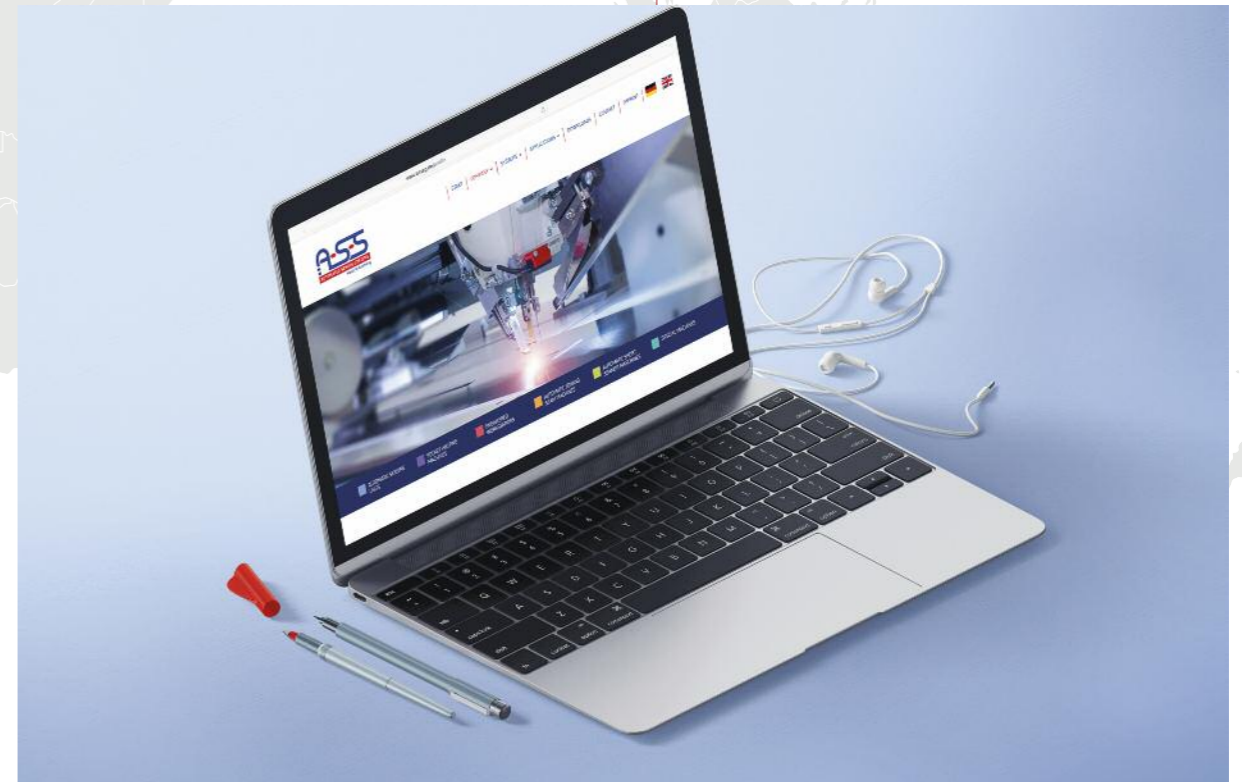
International – global

We market our sewing systems via an international dealer network. The A-S-S product guarantee and the A-S-SS service promise are self-evident at all locations without restriction.

Contact staff

We will gladly answer your questions, personally or on our website:
www.assag.de

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OVERVIEW OF MACHINERY

Automatic serging unit

| | | Jacket | Trousers | Shirt | Special solution |
|-----------|---|--------|----------|-------|------------------|
| BASS 2020 | Simple overlock | • | | | |
| BASS 2065 | Front and back trousers overlock | | • | | |
| BASS 2560 | Double head overlock | | • | | |
| BASS 2565 | Double head overlock special for stretch fabric | | • | | |

Automatic pocket welting

| | | Jacket | Trousers | Shirt | Special solution |
|--------------|---|--------|----------|-------|------------------|
| BASS 3050 | Economy version | • | • | | |
| BASS 3204 | Selected version | • | • | | |
| BASS 3204B | Breastwelt Version | • | | | |
| BASS 3204Z | Version with zipper process | • | | | • |
| BASS 3400 | Binder version with zipper process | | | | • |
| BASS 3504 IP | Selected full automatic version for inside pockets | • | • | | |
| BASS 3504 J | Selected full automatic version for outside pockets | • | • | | |
| BASS 3504 T | Selected full automatic version for back pockets | • | • | | |

Engineered workstation

| | | Jacket | Trousers | Shirt | Special solution |
|-----------|-----------------------|--------|----------|-------|------------------|
| EWS 6100 | Waistband stitching | | • | | |
| EWS 6200 | Heel Tape Sewing | | • | | |
| EWS 6300 | Seam closing | • | | | |
| EWS 6350 | Seam closing | • | • | | |
| EWS 6400 | Sleeve lining closing | • | | | |
| EWS 6450 | Sleeve closing | • | | | |
| EWS 6500 | Zipper attaching | | • | | |
| EWS 6600 | Overlock backseam | | • | | |
| EWS 6800 | Pin Tuck MC | | | | • |
| EWS 6900 | Waistband lining | | • | | |
| EWS 7000 | Seam closing | • | • | | |
| BASS 8040 | T-shirt hemming MC | | | • | • |
| BASS 8050 | Canvas tape | • | | | |
| BASS 9880 | Twintronic MC | | • | | |

Automatic joining seam machines

| | | Jacket | Trousers | Shirt | Special solution |
|-----------|---|--------|----------|-------|------------------|
| BASS 4100 | Long seamer closing | | | • | |
| BASS 4200 | Closing seam with binding device (chain stitch) | • | | | |
| BASS 4250 | Closing seam with binding device (lock stitch) | • | | | |

Automatic short seamer machines

| | | Jacket | Trousers | Shirt | Special solution |
|-----------|--|--------|----------|-------|------------------|
| BASS 5100 | Side seam pockets (chinos) | | | • | |
| BASS 5110 | Sleeve lining attaching | • | | | |
| BASS 5150 | Back pocket attaching | | • | | |
| BASS 5300 | Pocket facing attaching | • | • | | |
| BASS 5310 | Combination of BASS 5100 and BASS 5300 | • | • | | |
| BASS 5350 | Pocket facing attaching (sportswear) | • | • | | |
| BASS 5400 | Left fly topstitching | | | • | |
| BASS 5500 | Left fly topstitching economy version | | | • | |
| BASS 5600 | Topstitching front pocket | | | • | |
| BASS 5700 | Left and right fly attaching, front pocket attaching | | | • | |
| BASS 5800 | Combination of BASS 5300 + BASS 5700 | | | • | |

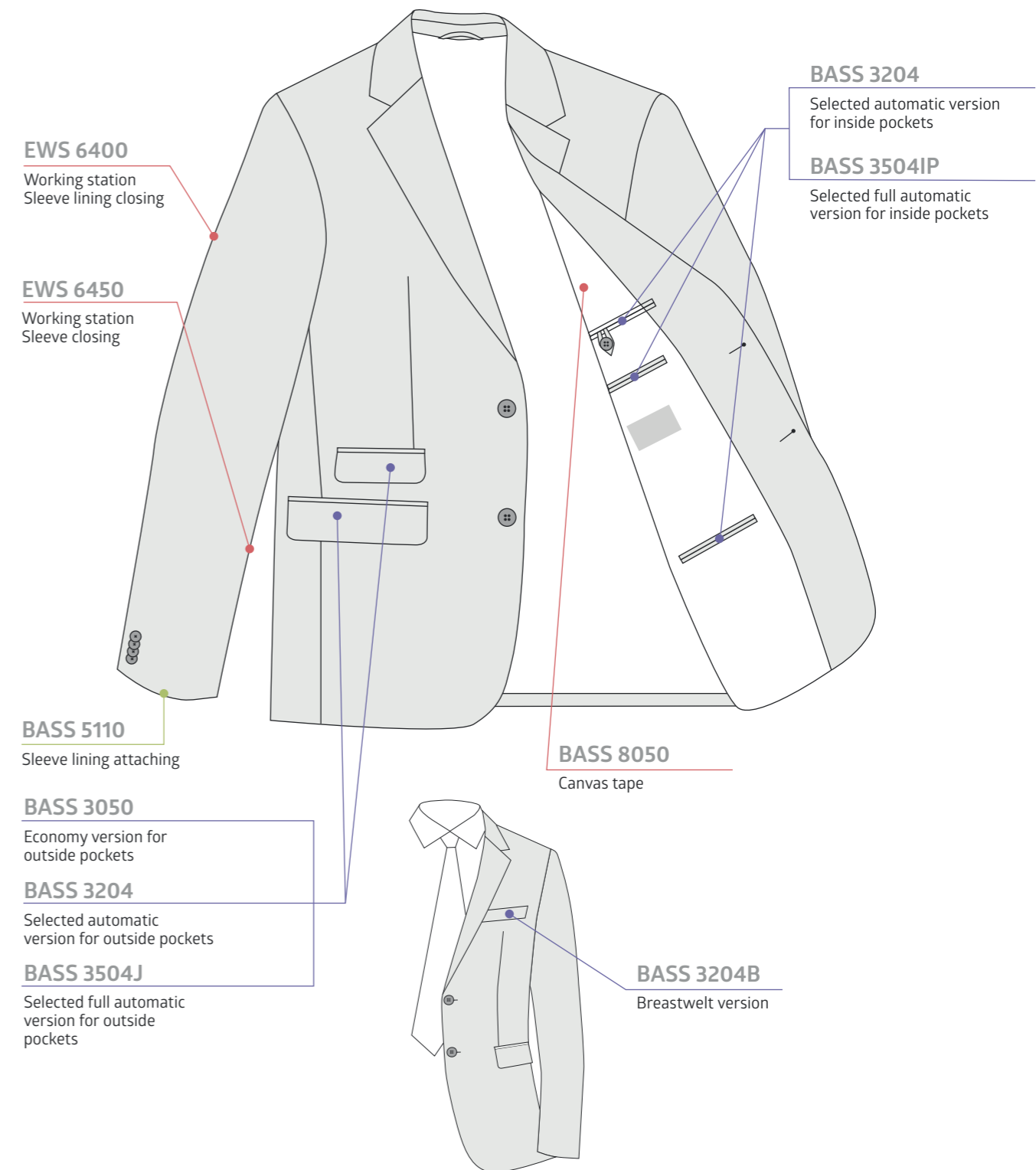
Special machines

| | | Jacket | Trousers | Shirt | Special solution |
|-----------|---|--------|----------|-------|------------------|
| BASS 5900 | Dart sewer blouses and shirts | | | • | • |
| BASS 5950 | Dart sewer trousers | | • | | |
| BASS 8010 | Working station for tacking and cutting | | | | • |
| BASS 8070 | Tape rolling device | | | | • |
| BASS 8120 | Overlock working station | | | | • |
| BASS 8130 | Belt MC | | | | • |
| BASS 8160 | Working station for safety belt | | | | • |

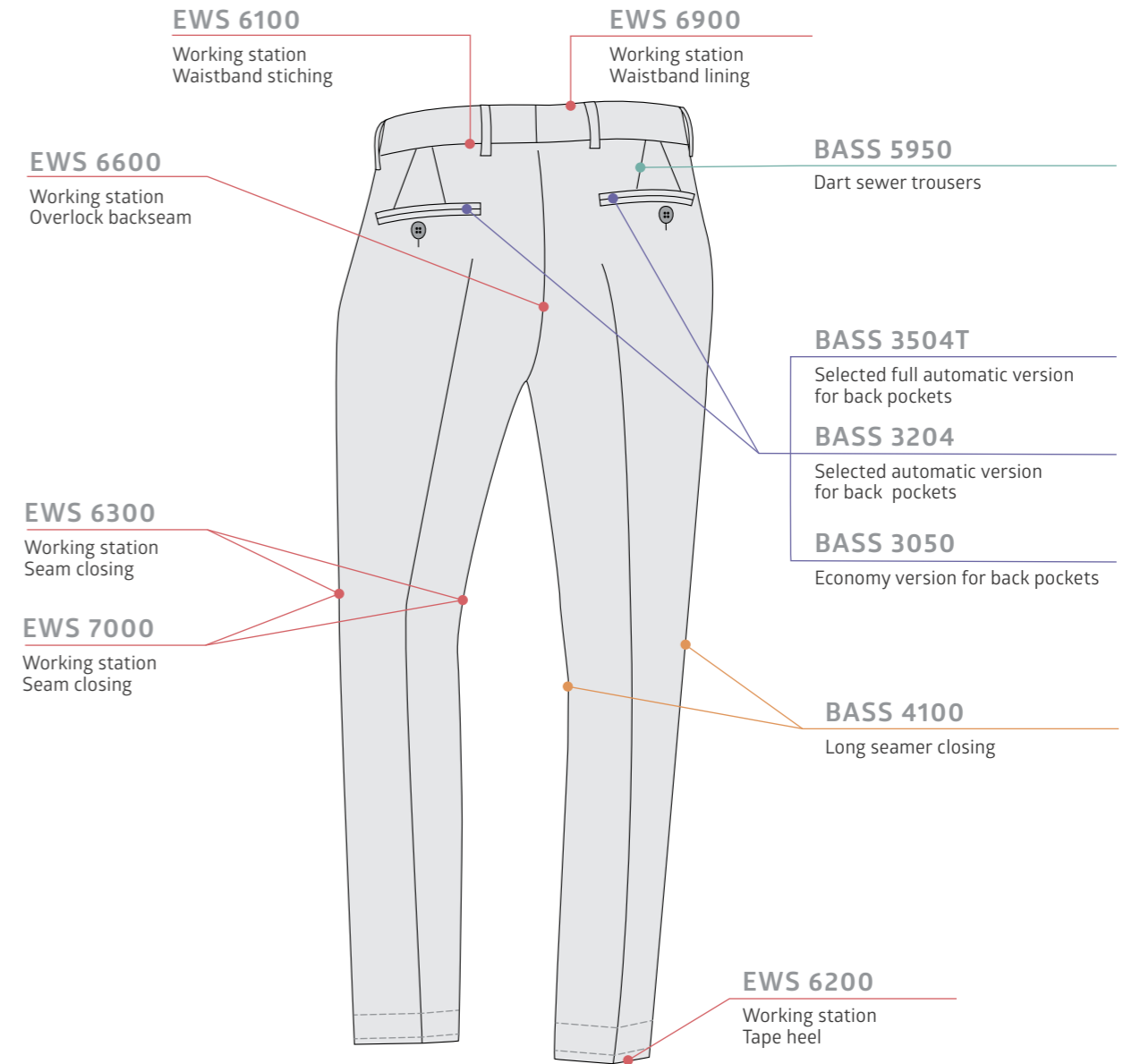
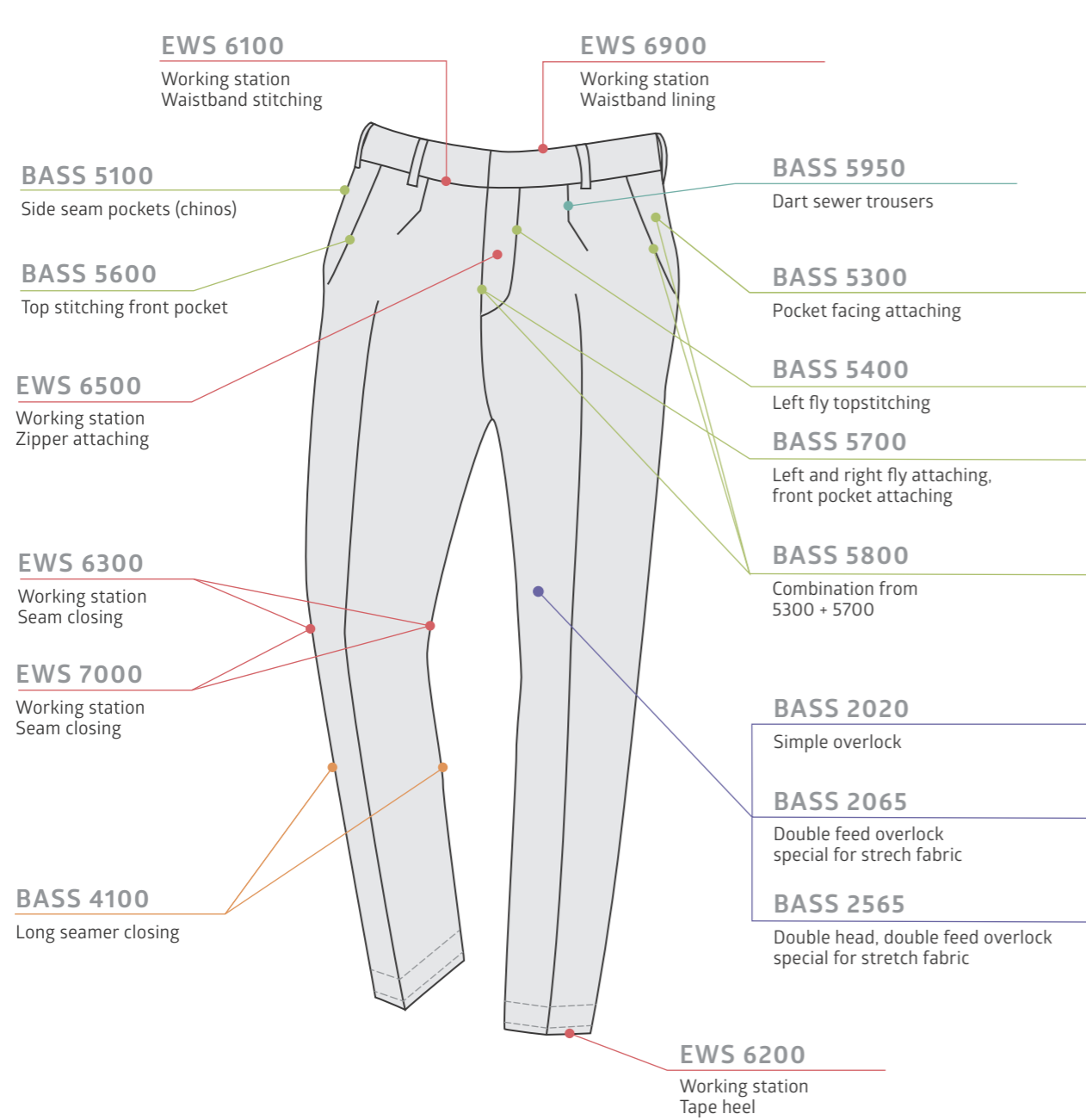
Stacker

| | | Jacket | Trousers | Shirt | Special solution |
|--------|--------------------|--------|----------|-------|------------------|
| 201/6 | Flip stacker | • | • | | |
| 201/7 | Flip stacker | • | • | | |
| 400/41 | Small part stacker | • | • | | |
| 400/51 | Small part stacker | • | • | | |
| 500 | Bundle clamp | • | • | | |

Automatic sewing machines for jacket production



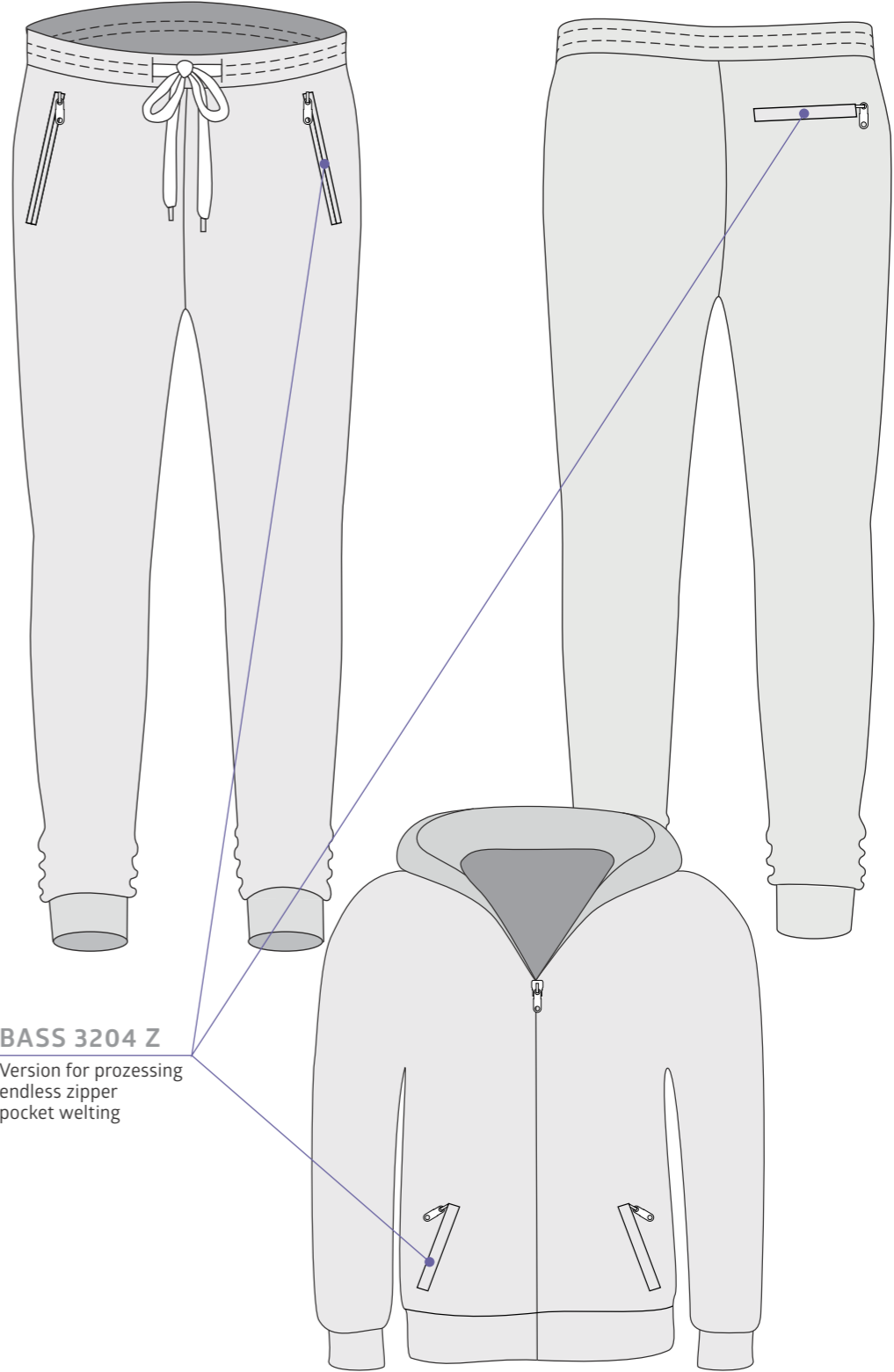
Automatic sewing machines for trousers production



Dart sewer blouses and shirts



Automatic Sewing Machine for Sports- and Outdoor Wear



AUTOMATIC SERGING UNITS

- Automatic serging units
- Automatic pocket welting
- Engineered workstations
- Automatic joining seam machines
- Automatic short seamer machines
- Special machines

BASS 2020

Single head serging machine for serging skirts, trousers and small pieces



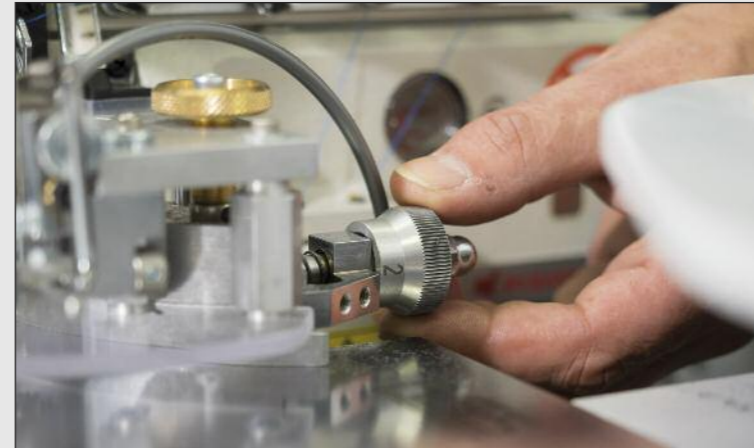
The BASS 2020 is a versatile single head serging machine for processing trouser parts without knee lining as well as skirt parts and small pieces. It combines speed with good sewing quality.

Advantages

- Serging up to 600 trousers per day with 8 long seams
- Simple selection of the sewing programs
- Flexible combinations of manual and automated seams
- Contour guide working with absolute reliability



Easy programming and administration as well as retrieval of the saved sewing programs



With the quick adjustment, the contour guide is adjusted to the sewing material



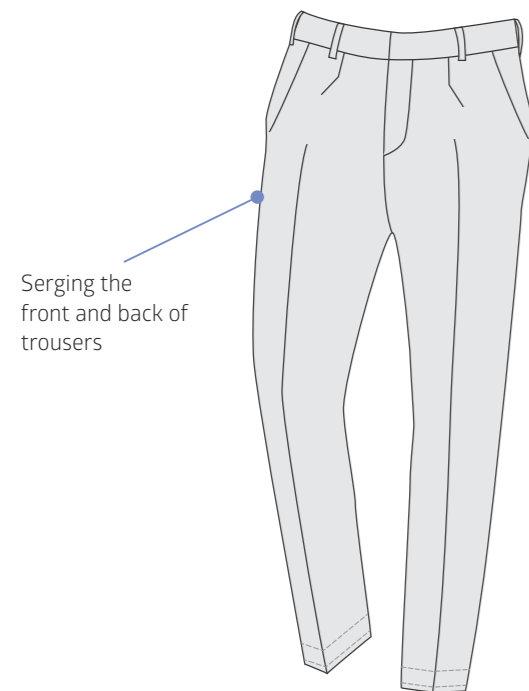
The optimal unit for sewing work: Contour guide, photocell and sewing head.



The exact and fast working stacker unit deposits the sewing parts for further processing.

Sample seams

The sewing widths can be selected. We offer 4mm, 5mm or 6mm for the standard sewing head, with other widths on request.



Advantages

- ✓ Simple selection of the sewing programs
- ✓ Contour guide working with absolute reliability
- ✓ Powerful sewing head for high sewing speeds
- ✓ Automatic discharge with subsequent de-stacking of the sewing material
- ✓ Overlapping working is possible

Production Process

The preliminary seams:

Seam, fly and hip bends can be sewn manually on the sewing head.

Program pre-selection:

Preliminary and main seams are selected on the control panel. With the quick adjustment, the contour guide is adjusted to the material.

Automatic sewing process:

The sewing part is placed on the contour guide and the sewing operation starts automatically via photocell. Immediately after starting the sewing operation, the next sewing part can be placed.

The sewn part is discharged from the working table and is stacked automatically by the stacking unit.

Work ergonomics:

The height of the table can be adjusted to the body height of the operator.

Performance Profile

The BASS 2020 is a compact single-head sewing machine for rational serging of skirt and trouser parts without knee lining as well as small parts.

The crotch and side seams are trimmed in an automatic sewing operation. In the process, the sewing parts are guided independently by the contour guide providing secure seams to the sewing machine and processed there, discharged and stacked.

BASS 2020

Single head serging machine for serging skirts, trousers and small pieces

Technical Specifications

Dimensions

| | |
|--------------|---------|
| Length..... | 1700 mm |
| Width..... | 900 mm |
| Height | 1700 mm |

Table height

| | |
|--------------------------------|--------------------|
| Manually adjustable from | 890 mm to 1.250 mm |
|--------------------------------|--------------------|

Weight

| | |
|----------------------|--------|
| Basic equipment..... | 125 kg |
|----------------------|--------|

Compressed air

| | |
|-----------------------|-------------|
| Nominal pressure..... | 20 NI/6 bar |
|-----------------------|-------------|

Power supply

| | |
|------------------------|---------------|
| Rated voltage..... | 220V/50/60 Hz |
| AC voltage | 220V/50/60 Hz |
| Power consumption..... | 0,7 kWh |

Sewing System

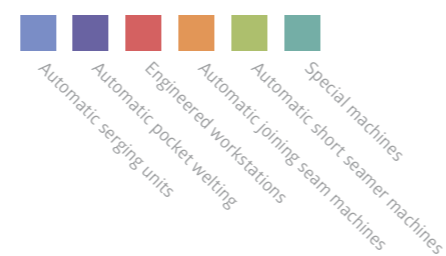
| | |
|--|---------------------------|
| Maximum sewing speed | 7500 rpm |
| Stitch length..... | 1,0-3,8 mm |
| Differential (Pegasus EX5204)/ 0.7-6.0 mm..... | Sewing widths from 4-8 mm |
| Differential (Pegasus EX 5204-24445) / 0.7-6 mm..... | Sewing width 9 mm (Jeans) |
| Needle system..... | B 27 |
| Needle size..... | 80-110 Nm |

Examples of output

Serging the front and back parts of trousers (8 seams per trouser): 600 pairs in 8 hours
 Serging fronts of trousers with curved slits and seam (8 seams per trouser): 560 in 8 hours
 Serging the backs of trousers with curved hips and seam (8 seams per trouser): 560 in 8 hours

Basic equipment

- Pegasus EX5204, 3-thread
- Standard sewing width 6 mm
- Drive Efka DC,
- AC voltage 220 V, 50/60 Hz
- Control panel MT 800 with micro-processor control for 20 freely programmable seams as well as a memory chip for data backup
- Adjustable height contour guide with roller lifting
- Automatic chain cutting
- Dirt extraction with waste container
- Stacking device
- Height-adjustable frame



BASS 2065

Single-head sewing machine for serging trouser parts with or without knee lining



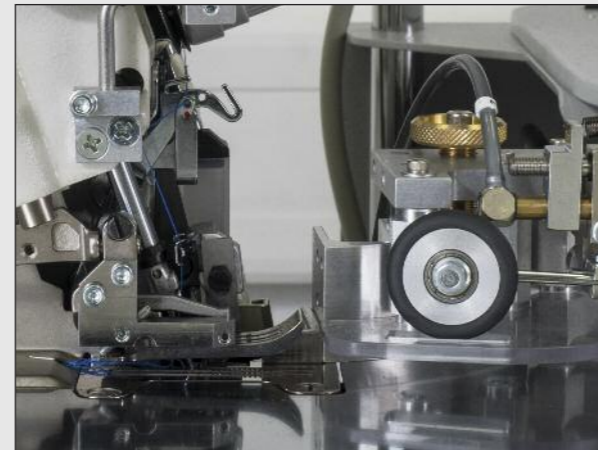
The BASS 2065 is a versatile single-head sewing machine for processing trouser parts either with or without knee lining.

Advantages

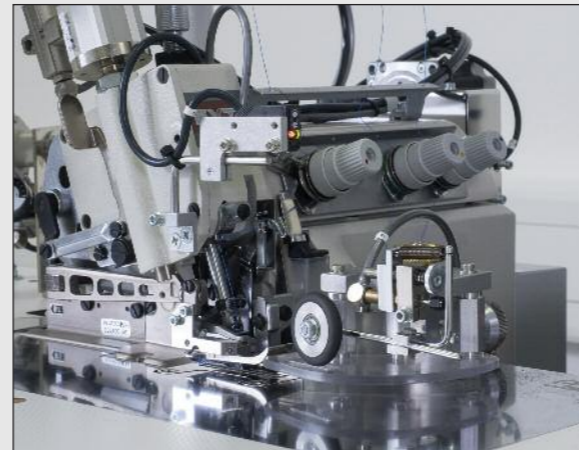
- Up to 450 trousers per day. (Front part of the trousers with knee lining, 8 long seams and 8 short seams)
- Powerful sewing head for high sewing speeds
- Separately controllable stepper motors for differential and top transport



Easy programming and administration as well as retrieval of the saved sewing programs



With the quick adjustment, the contour guide is adjusted to the sewing material.



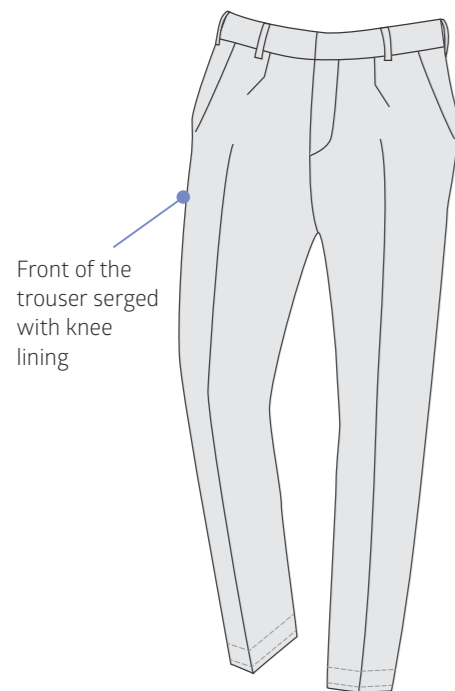
The contour guide, photo cell and sewing head form an optimal unit



The exact and fast working stacker unit deposits the sewing parts for further processing.



Stepper motor-controlled differential and top transport



Front of the trouser serged with knee lining

Sample seams

The sewing widths can be selected. We offer 4mm, 5mm or 6mm stitch width.

The sewing result when using the BASS 2065 illustrates the incorporation of additional width in the lining on the one hand and absolutely smooth cover fabric on the other side.



View of the front of the trouser with lining (inside + outside)

Advantages

- ✓ Simple selection of the sewing programs
- ✓ Contour guide working with absolute reliability
- ✓ Simple adjustment of the width distribution via the display
- ✓ Powerful sewing head for high sewing speeds
- ✓ Lining fixing station no longer necessary
- ✓ Automatic discharge with subsequent de-stacking of the sewing material

Production Process

The preliminary seams:

Hem, slit and hip bends can be sewn manually on the sewing head.

Program pre-selection:

The sewing program including the width specification for differential and top transport is adjusted on the control panel. With the quick adjustment, the contour guide is adjusted to the material.

Automatic sewing process:

The sewing part is placed on the contour guide and the sewing operation starts automatically via the signal of the photocell.

The roller device controls the progress of the seam with an assured contour.

Immediately after starting the sewing operation, the next sewing part can be placed.

The sewn part is discharged from the working table and is stacked automatically by the stacker device.

Performance Profile

The BASS 2065 is a versatile single-head sewing machine for processing trouser parts either with or without knee lining.

The separate stepper motor controller for differential and top feeding enables accurate specification of the desired width in the lining. With this feature, the BASS 2065 is particularly suitable for processing modern stretch materials.

Serging with knee lining is designed for lining that has been cut to size.

The seam always starts at the edge of the waist. The knee lining can be sewn either as the overlay or the underlay.

BASS 2065

Single-head sewing machine for serging trouser parts with or without knee lining

Technical Specifications

Dimensions

Length.....2.100 mm
Width.....900 mm
Height1.700 mm

Table height

Manually adjustable from 890 mm to 1.150 mm

Weight

Basic equipment.....150 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage.....220V/50/60 Hz
AC voltage220V/50/60 Hz
Power consumption.....0,7 kWh

Sewing System

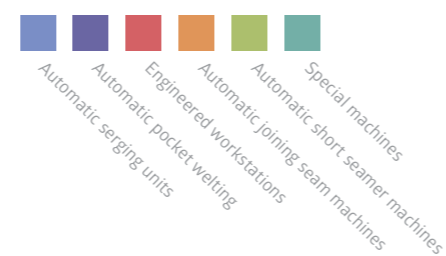
Maximum sewing speed 6.000 rpm
Stitch length..... 1,0-3,8 mm
Differential..... 1-6 mm
Obertransport..... 1-16 mm
Nahtbreiten.....4-6 mm
Needle system..... B 27
Needle size..... 80-110 Nm

Examples of output

Up to 450 trousers per day.
(Front part of the trousers with knee lining, 8 long seams and 8 short seams)

Basic equipment

- Two or three threads overlocking machine: Pegasus EXT5204
- Standard seam width 6 mm
- Drive Efka DC,
- AC 220 V, 50 / 60 Hz
- Microprocessor controller with LCD display for 60 programmable seams and memory chip for data backup
- Adjustable height contour guide with roller ventilation
- Automatic chain separation
- Dirt extraction with waste container
- Stacking device
- Machine frame of adjustable height



BASS 2565

Dual-head automatic sewing machine for serging trouser parts with or without knee lining



By operating with independent stepper motor controller for differential and top transport, the BASS 2565 masters the fullness distribution perfectly and without a problem, even for modern, elastic materials.

With simultaneous operation of both sewing heads, two seams can be trimmed extremely efficiently.

Advantages

Up to 2200 rear side of trousers with 4 serged seams* each or up to 1450 front side of trousers with knee lining and 4 serged seams each in 8 hours*

Simple selection of the sewing programs

Contour guide working with absolute reliability

Powerful sewing heads for high sewing speeds

Separately controllable stepper motors for differential and top transport

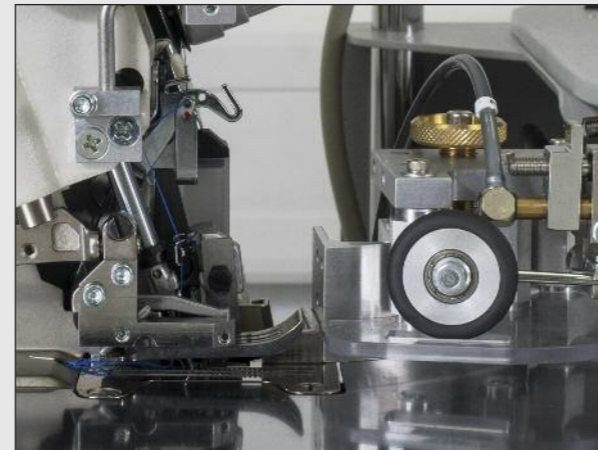
*The back seam and hem are sewn manually, and the crotch seam and side seam are sewn automatically

BASS 2565

Dual-head automatic sewing machine for serging trouser parts with or without knee lining



Easy preparation and administration as well as retrieval of the saved sewing programs



With the quick adjustment, the contour guide is adjusted to the sewing material



Contour guide, photo cell and sewing head form an optimal unit



The exact and fast working stacker unit deposits the sewing parts for further processing.



Stepper motor-controlled differential and top transport

Sample seams

The sewing widths can be selected. We offer 4mm, 5mm or 6mm seam width.

The sewing result when using the BASS 2565 illustrates the incorporation of additional width in the lining on the one hand and absolutely smooth cover fabric on the other side.



Serging the front of the trouser with knee lining and the rear of the trouser

Advantages

- ✓ Simple selection of the sewing programs
- ✓ Freely programmable seam controller with memory for 20 programs
- ✓ Contour guide working with absolute reliability
- ✓ Simple adjustment of fullness distribution via the display
- ✓ Powerful sewing head for high sewing speeds
- ✓ Lining fixing station
- ✓ Automatic discharge with subsequent de-stacking of the sewing material

Production Process

Preliminary and main seams are selected on the control panel.

The preliminary seams: Hem, slit and hip curves can be sewn manually on the A-sewing head

Program pre-selection:

The sewing program including the fullness specification for differential and top transport is adjusted on the control panel. With the quick adjustment, the contour guide is adjusted to the material.

For knee lining processing: Before the seam operation, the knee lining is fixed for the 2nd seam at the correct position.

Automatic sewing process:

The sewing part is placed on the contour guide and the sewing operation starts automatically via photocell. The roller device controls the progress of the seam with an assured contour. Thereafter, the sewn part is transported automatically to the 2nd sewing head and the second seam gets serged.

The sewn part is discharged from the working table and is stacked automatically by the stacker device.

Performance Profile

The BASS 2565 is a versatile dual-head automatic sewing machine for processing trouser parts either with or without knee lining.

The separate stepper motor controller for differential and top transport enables accurate specification of the desired width in the lining.

With this feature, the BASS 2565 is particularly suitable for processing modern stretch materials.

The seam begins either at the edge of the waist or at the edge of the hem, and the knee lining sewn on is always below the top fabric.

The adhesive tacker secures the correct position of the lining for the second seam.

Technical Specifications

Dimensions

| | |
|--------------|---------|
| Length..... | 2100 mm |
| Width..... | 900 mm |
| Height | 1700 mm |

Table height

Manually adjustable from 850 mm to 1250 mm

Weight

Basic equipment.....225 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

| | |
|------------------------|---------------|
| Rated voltage..... | 220V/50/60 Hz |
| AC voltage | 220V/50/60 Hz |
| Power consumption..... | 0,7 kWh |

Sewing System

| | |
|---|--------------|
| Maximum sewing speed: Pegasus EXT5204 | 6000 rpm |
| Stitch length..... | 1-3,8 mm |
| Differential | 0,7-6 mm |
| Top transport..... | 1-16 mm |
| Seam widths..... | 4-6 mm |
| Needle system..... | B27 |
| Needle size..... | 80 Nm-110 Nm |

Examples of output

Up to 2200 rear side of trousers with 4 trimmed seams each or up to 1450 front side of trousers with knee lining and 4 trimmed seams each in 8 hours

Basic equipment

- Two or three thread over-locking machine: 2 x Pegasus EXT5204
- Standard seam width 6 mm (special widths of 4mm or 5mm possible)
- Efka motor, DC or AC 220 V, 50/60 Hz
- Microprocessor controller with LCD display for 20 programs with 8 seams each and memory chip for data backup
- Adjustable height contour guide with roller ventilation
- Yarn stop motion (2-yarn or 3-yarn optionally)
- Automatic chain separation
- Dirt extraction with waste container
- Stacking device
- Machine frame height adjustable



AUTOMATIC POCKET WELTING

- Automatic serging units
- Automatic pocket welting
- Engineered workstations
- Automatic joining seam machines
- Automatic short seamer machines
- Special machines

BASS 3050

Sewing system for pocket openings



The BASS 3050 is a sewing system that can process all prevalent straight pocket openings with or without flaps.

Simple operation and high working speed characterise this universal automatic welted pocket machine.

Advantages

- Up to 2400* welted pockets in 8 hours
- Simple operation – Quick learning process
- High degree of automation
- High operating speed

* Depending on the shape of the pocket and number of additional parts (pocket pouches, welts, flaps, facings)



Easy administration and retrieval of the pre-programmed seams for diverse applications



The swivel-out folding station enables easy access for set-up and service work

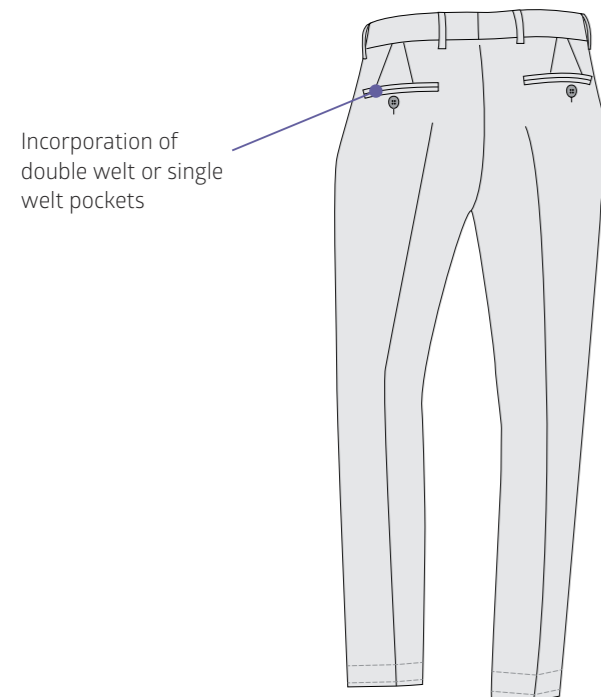


Laser markings for accurate and clear positioning



The ready-made parts are stacked automatically

Sample seams



Incorporation of double welt or single welt pockets

All straight double or single welt pockets, with or without flaps can be processed.



1 Double welt pocket



2 Double welt pocket with flap



3 Single welt pocket

Advantages

- ✓ Simple operation
- ✓ Quick learning process
- ✓ Quick changeover from double welting to single welting
- ✓ Customised setting for stitching and transport speed
- ✓ Automatic sensing of flap length
- ✓ Independent drives for clamp transport as well as all cutting systems
- ✓ Easily programmable
- ✓ Needle distances can be retrofitted from 8 mm–24 mm, in steps of 2 mm
- ✓ Cutter adjustment for corner cutter position in steps of 0.1 mm

Production Process

Program pre-selection:

The pre-programmed seam is selected on the control panel.

Manual working steps:

Weltings, flaps and additional parts are kept on tray table and fed manually.

Automatic sewing process:

The pocket opening gets sewn and cut fully automatic in one pass. Next, the ready-made sewn is placed by the stacker for further processing.

Work ergonomics

The swivel-out folding station enables easy access for set-up and service work.

Performance Profile

The BASS 3050 is a universal automatic welt pocket sewing machine. The machine processes all prevalent pocket openings with and without flaps.

The BASS 3050 is impressive with its high operating speed. The clamp transport and all cutter systems of the sewing machine have their own separate drive. The clamp transport is controlled fully automatically by a stepper motor and the centre cutter is driven by a separate electric motor.

BASS 3050

Sewing system for pocket openings

Technical Specifications

Dimensions

Length.....1650 mm
Width.....800 mm/1170 mm
Height1300 mm

Table height

Manually adjustable from 850 mm to 1.150 mm

Weight

Basic equipment.....200 kg
Basic equipment with stacker220 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage..... 220V/50/60 Hz
AC voltage220V/50/60 Hz
Power consumption.....0,7 kWh

Sewing System

Maximum sewing speed 3000 rpm
Stitch length.....0,5-3,0 mm
Needle system.....2134 - 85
Needle size.....90-100 Nm
Needle distances (2 mm steps)..... 8-24 mm for selection
(6,4 mm; 26-32 mm available against extra charge)

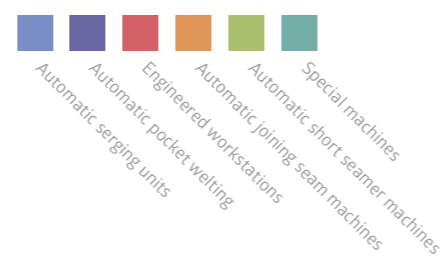
Examples of output

Up to 2400* welted pockets in 8 hours

* Depending on the shape of the pocket and number of additional parts (pocket pouches, welts, flaps, facings)

Basic equipment

- Brother two-needle lockstitch sewing head B-8422 with fixed needle bar
- Pivotal sewing head
- Direct drive DC motor
- AC voltage 190 V-240 V, 50/60 Hz
- Micro-processor controller with LCD display and memory chip for data backup
- Main clamp drive by controlled stepper motor with automatic length adjustment from 20-200 mm (optionally 240 mm),
- Quick adjustment for corner cutter
- Adjustment range in 10mm/ 0.1 mm steps
- Lateral corner cutter adjustment with a cam
- Corner cutter holder with adjustable cutting width
- Programmable lowering of the transport clamp
- Programmable start and end back tack or optionally adjustable stitch condensing-
- Double welt unit
- Needle and bobbin thread sensor
- Thread cutter device



BASS 3204

Sewing system for pocket openings



The BASS 3204 is a universal automatic welted pocket sewing machine. The sewing machine processes all prevalent pocket openings with and without flaps. The incorporation of a zipper can be integrated easily into the sewing operation. Even welted breast pockets can be incorporated with the appropriate options.

Simple operation and high working speed characterise this universal automatic welted pocket machine.

Advantages

- High operating speed: 4-5 pockets per minute
- Numerous options are selectable
- Simple operation – Quick learning process
- High degree of automation

BASS 3204

Sewing system for pocket openings



Easy administration and retrieval of the pre-programmed seams for diverse applications



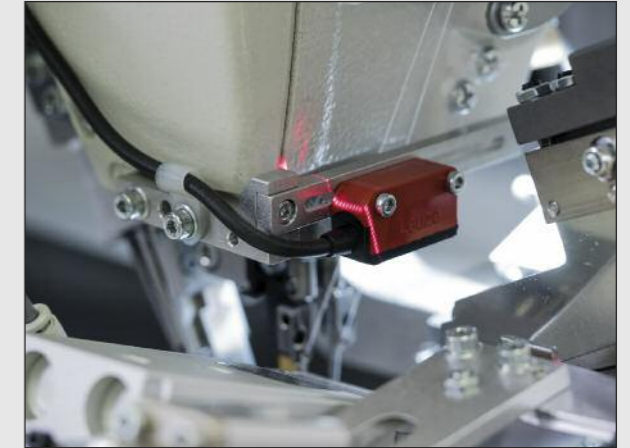
Easy access for service and set-up work



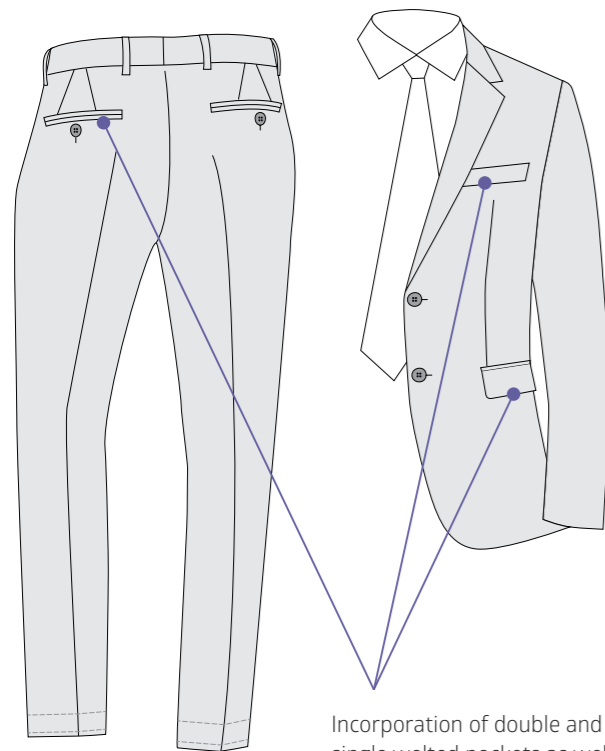
Accurate positioning with the help of the 5 position lamps



Quick and accurate de-stacking with the 201/6 stacker



Flap sensing by photocell



Incorporation of double and single welted pockets as well as welted breast pockets

Sample seams

A few examples of the use of the BASS 3204 for sports jacket, blazer and trousers are illustrated here.



Advantages

- ✓ Quick learning process
- ✓ Numerous options for special applications
- ✓ Quick changeover from double piping to single piping
- ✓ Freely programmable controller with memory for 40 seams
- ✓ Customised setting for stitching and transport speed
- ✓ Customised programming possible for stitch length, seam locking or adjustable stitch length
- ✓ Independent drives for clamp transport as well as all cutter systems
- ✓ Pocket opening lengths from 20-200 (optional 240 mm)
- ✓ Easily programmable
- ✓ Needle distances can be retrofitted from 8 mm-24 mm, in steps of 2 mm
- ✓ Cutter adjustment for corner cutter position in steps of 0.1 mm
- ✓ Automatic clamp adjustment when folder is changed
- ✓ Automatic seam length adjustment

Production Process

Program pre-selection:

The pre-programmed seam is selected on the control panel. Laser markings ensure position of the sewing parts.

Manual working steps:

First, the sewing parts are placed in position. The welting, flaps and enclosed parts are kept ready on the laying table and fed manually.

Automatic sewing process:

The pocket opening is sewn completely automatically in one sewing operation and cut. Optional chosen stacker is placing the sewing piece for further processing.

Work ergonomics

The swivel-out folding station enables easy access for set-up and service work.

Performance Profile

The BASS 3204 is a universal automatic welted pocket sewing machine. The sewing machine processes all prevalent pocket openings with and without flaps.

The incorporation of a zipper can be integrated easily into the sewing operation. Even welted breast pockets can be incorporated with the appropriate options.

Simple operation and high working speed characterise this universal automatic welted pocket machine.



BASS 3204

Sewing system for pocket openings

Technical Specifications

Dimensions

Length.....1650 mm
 Width.....800 mm/1170 mm
 Height1300 mm

Table height

Manually adjustable from 850 mm to 1.150 mm

Weight

Basic equipment.....200 kg
 Basic equipment with stacker220 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage..... 220V/50/60 Hz
 AC voltage220V/50/60 Hz
 Power consumption.....0,7 kWh

Sewing System

Brother 2-needle head B-842 with fixed needle bar
 Brother 2-needle head B-845 with disengageable
 needle bar.....max. 3000 stitches/min.
 Stitch length.....0.5-3mm
 Needle system.....2134-85
 Needle size.....90-100 Nm
 Needle distances (2 mm steps).....8-24 mm for selection
 (6,4mm; 26-32 mm gegen Aufpreis)

Examples of output

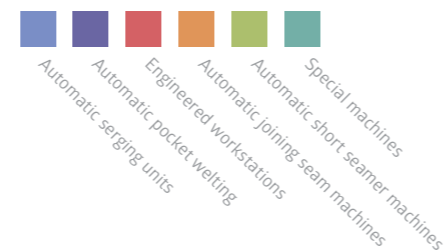
2000-2400 welted pockets in 8 hours

Basic equipment

- Two needle lockstitch sewing head
- Direct drive
- Micro-processor controller with LCD display and memory chip for data backup
- Main clamp drive by controlled stepper motor with automatic length adjustment from 20-200 mm, optionally 240 mm
- Quick adjustment for corner cutter
- Adjustment range in 10 mm/0.1 mm steps
- Lateral corner cutter adjustment with a cam
- Corner cutter holder with adjustable cutting width
- Programmable lowering of the transport clamp
- Programmable start and end backtack or optionally adjustable stitch condensing
- Double welt unit clamp push-back blocking
- Needle and bobbin thread sensor
- Thread cutter device

Options:

- Bundle clamp or stacker
- Device for slanted openings
- Vacuum device
- Stepper motor controlled fleece guide
- Head with split needle bar B-8452



BASS 3204B

Sewing system for welted breast pockets



The BASS 3204B is an automatic pocket sewing machine specially engineered for sewing in welted breast pockets. Simple operation and high operating speed characterise this universal automatic pocket sewing machine.

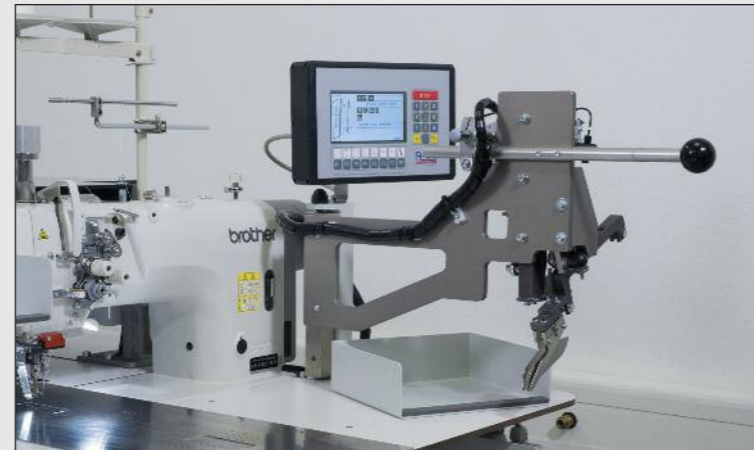
Advantages

- High operating speed:
up to 1200 pockets in 8 hours
- Simple operation and quick learning process
- High degree of automation

*depending on the type and shape of the border and enclosed sections



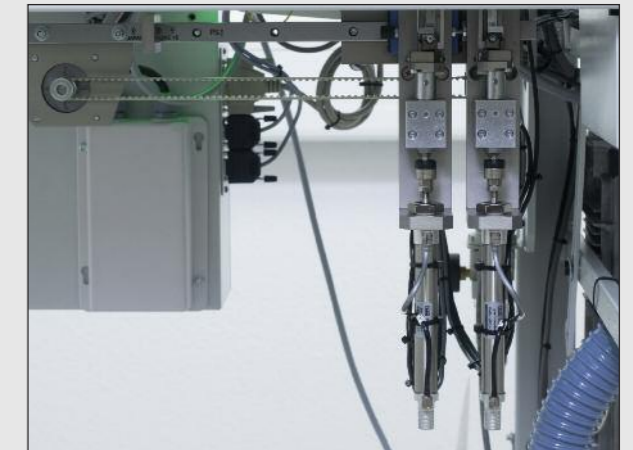
Easy preparation and administration as well as retrieval of the saved programs



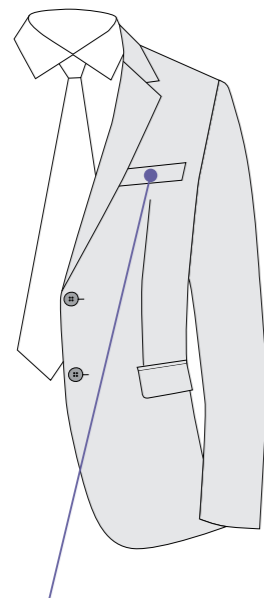
The swivel-out folding station enables easy access for set-up and service work



Accurate positioning by eight position lamps



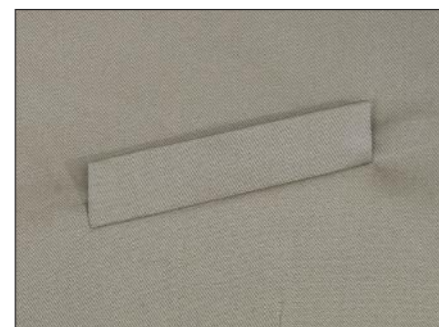
Cutter block with stepper motor drive



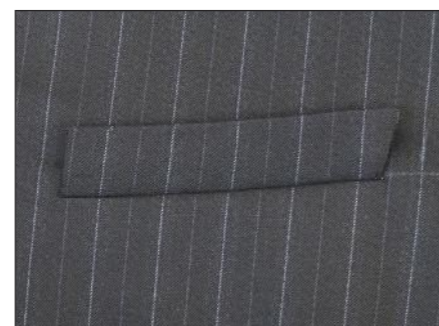
Sewing welted breast pocket in a sports jacket or blazer

Sample seams

A few examples of the use of the BASS 3204 B are illustrated here.



1 Breast strip in single colour top material



2 Breast strip in striped top material

Advantages

- ✓ Simple operation
- ✓ Quick learning process
- ✓ Easily programmable
- ✓ Freely programmable controller with memory for 40 seams
- ✓ Customised setting for sewing and transport speed
- ✓ Customised programming possible for stitch length, backtacking or condensed stitching.
- ✓ Independent stepper motor drives for transport clamp and all cutting systems
- ✓ Automatic welt sensing

Production Process

Program pre-selection:

The pre-programmed seam is selected on the control panel..

Manual working steps:

First, the sewing parts are placed in position. The welt and enclosed sections are kept ready on the laying table and fed manually.

Automatic sewing process:

The pocket opening is sewn completely automatically in one sewing operation and cut. Next, the ready-made sewn parts is placed by the stacker for further processing.

Work ergonomics

The swivel-out folding station enables easy access for set-up and service work.

Performance Profile

The BASS 3204 B is an automatic machine for all prevalent welted breast pockets. It is impressive with its high operating speed. The clamp transport and all cutter systems of the sewing machine have their own separate drive: The clamp transport is controlled fully automatically by a stepper motor and the centre cutter is driven by a separate electric motor.

BASS 3204B

Sewing system for
welted breast pockets

Technical Specifications

Dimensions

Length.....1650 mm
Width/ with stacker..... 800 mm/1170 mm
Height1300 mm

Table height

Manually adjustable from 850 mm to 1.150 mm

Weight

Basic equipment.....200 kg
Basic equipment with stacker220 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage..... 220V/50/60 Hz
AC voltage220V/50/60 Hz
Power consumption.....0,7 kWh

Sewing System

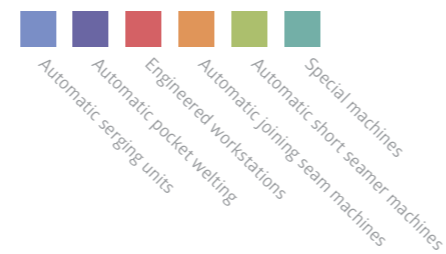
Brother 2-needle head B-842 with fixed needle bar
Brother 2-needle head B-845 with split needle bar
needle bar.....max. 3000 stitches/min.
Stitch length..... 0.5-3mm
Needle system.....2134-85
Needle size..... 90-100

Examples of output

High operating speed: up to 1200 pockets in 8 hours
*depending on the type and shape of the border and enclosed sections

Basic equipment

- Brother 2-needle double stitch sewing head B-8452 with divided needle bar
- Direct drive
- Micro-processor controller with LCD display and memory chip for data backup
- Main clamp drive by controlled stepper motor with automatic length adjustment from 20-150 mm.
- Quick adjustment for corner cutter
- Adjustment range in 10 mm/ 0.1 mm steps
- Corner cutter holder with adjustable cutting width
- Programmable lowering of the transport clamp
- Programmable start and end back tacking or optionally adjustable stitch condensation
- Clamp push-back blocking
- Needle distance 10 mm
- Needle and bobbin thread sensor
- Thread cutter device



BASS 3204Z

Sewing system for pocket openings
with integrated endless zipper

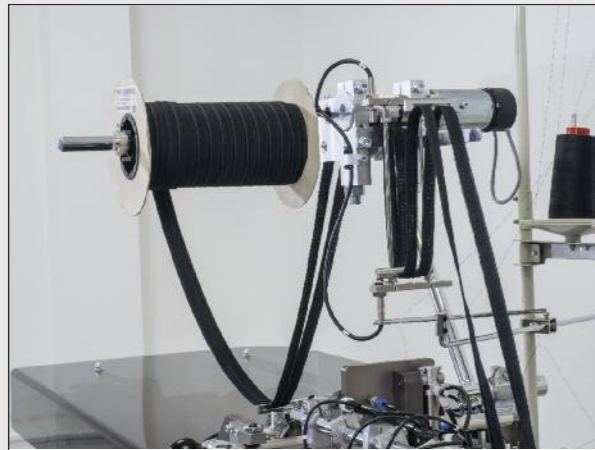


The BASS 3204Z is a sewing system that can process all prevalent straight and slanted pocket openings with integrated endless zipper.

Simple operation and high working speed characterise this universal automatic pocket welting machine.

Advantages

- High working speed: up to 3-4 pockets/minute of integrated endless
- Integrated continuous zipper
- Simple operation – Quick learning process
- High degree of automation



Automatic zip fastener extraction device



Laser markings indicate the exact pocket pouch position



Stepper motor-controlled fleece feed



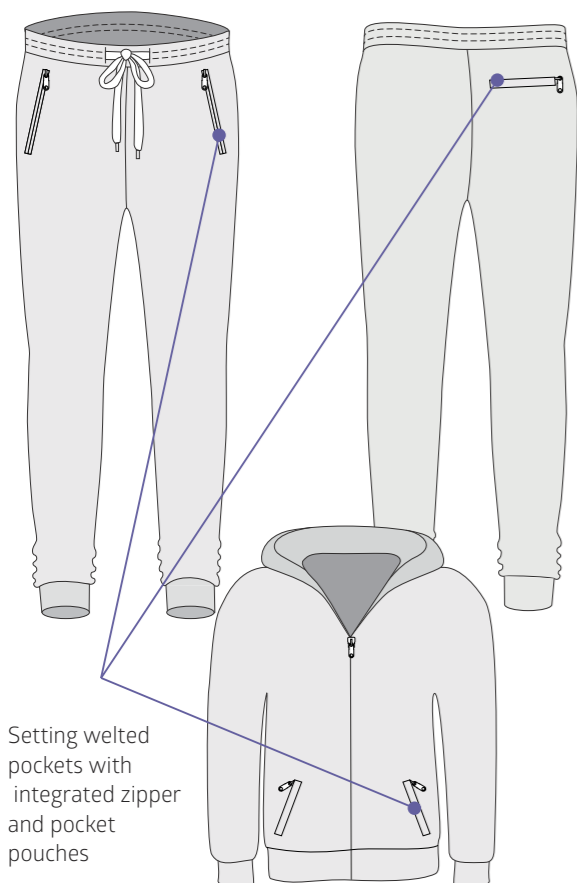
Cutter block with stepper motor drive



Pneumatic scissors for cutting off the endless zipper

Sample seams

Two examples of the use of the BASS 3204Z for jogging suits are illustrated here



Setting welted pockets with integrated zipper and pocket pouches



1 Double welt pocket with zipper



2 Single welt pocket with zipper

Advantages

- ✓ Quick learning process
- ✓ Numerous options for special applications
- ✓ Quick changeover from double welt to single welt
- ✓ Freely programmable controller with memory for 40 seams
- ✓ Customised setting for stitching and transport speed
- ✓ Customised programming possible for stitch length, back tacking or stitch condensation
- ✓ Independent drives for clamp transport as well as all cutting systems
- ✓ Pocket opening lengths from 20-200 (optional 240 mm)
- ✓ Easily programmable
- ✓ Needle distances are available from 8 mm-16 mm, in steps of 2 mm
- ✓ Adjustment for corner cutting device position in steps of 0,1 mm
- ✓ Automatic clamp adjustment when folder is changed

Production Process

Program pre-selection:

The pre-programmed seam is selected on the control panel. Laser markings ensure position of the sewing parts.

Manual working steps:

The piping and pocket pouch are kept ready on the laying table and fed manually

Automatic sewing process:

The pocket opening is stitched fully automatically in a stitching operation and the zip fastener tape is cut off. The pocket is cut in the next step.

Thereafter, the stitched part is removed by hand* and placed for further processing.

Work ergonomics

The swivel-out folding station enables easy access for set-up and service work.

*depending on the size of the stitched part

Performance Profile

The BASS 3204Z is a universal automatic sewing machine for welted pockets with zip fastener and is impressive with its high working speed.

The system handles all prevalent pocket openings with endless zip fastener from the roll. The pocket pouches are inserted with welting strips and processed automatically.

The clamp transport and all cutter systems of the sewing system have their own separate drive. The clamp transport is controlled fully automatically by a stepper motor and the centre cutter is driven by a separate electric motor.

A pneumatic set of scissors cuts off the zipper tape after the stitching operation.

BASS 3204Z

Sewing system for pocket openings with integrated endless zipper

Technical Specifications

Dimensions

| | |
|--------------|---------|
| Length..... | 1650 mm |
| Width..... | 800 mm |
| Height | 1300 mm |

Table height

| | |
|--------------------------------|--------------------|
| Manually adjustable from | 850 mm to 1.150 mm |
|--------------------------------|--------------------|

Weight

| | |
|------------------------------------|--------|
| Basic equipment..... | 200 kg |
| Basic equipment with stacker | 220 kg |

Compressed air

| | |
|-----------------------|-------------|
| Nominal pressure..... | 20 NI/6 bar |
|-----------------------|-------------|

Power supply

| | |
|------------------------|---------------|
| Rated voltage..... | 220V/50/60 Hz |
| AC voltage | 220V/50/60 Hz |
| Power consumption..... | 0,7 kWh |

Sewing System

| | |
|--|-------------------------|
| Brother 2-needle head B-842 with fixed needle bar | |
| Brother 2-needle head B-845 with disengageable needle bar..... | max. 3000 stitches/min. |
| Stitch length..... | 0.5-3mm |
| Needle system..... | 2134-85 |
| Needle size..... | 90-100 |
| Needle distances (2 mm steps)..... | 8-16 mm for selection |

Examples of output

300-1700* welted pockets

* Depending on the shape of the pocket and number of additional parts (pocket pouches, piping, flaps, border parts)

Basic equipment

- Two needle lockstitch sewing head
- Direct drive
- Micro-processor controller with LCD display and memory chip for data backup
- Main clamp drive by controlled stepper motor with automatic length adjustment from 20-200 mm, optionally 240 mm
- Quick adjustment for corner cutter
- adjustment range 10 mm/ 0.1 mm steps
- Lateral corner knife adjustment via eccentric
- Corner cutting device with adjustable cutting width
- Automatic fleece feed by stepper motor
- Programmable lowering of the transport clamp
- Programmable start and end locking or optionally adjustable stitch condensation
- Double piping unit clamp push-back blocking
- Needle distance 16 mm
- Needle and bobbin thread sensor
- Thread cutter device

Options:

- Bundle clamp or stacker



BASS 3504

Sewing system for pocket openings



The BASS 3504 is a premium automatic welt pocket sewing machine. The sewing machine processes all prevalent pocket openings with and without flaps. The incorporation of a zip can be integrated easily into the sewing operation. Simple operation and high working speed characterise this universal automatic piped pocket machine.

Advantages

- High working speed – up to 5 pockets per minute
- Simple operation – Quick learning process
- High degree of automation
- Universal use



Easy preparation and administration as well as retrieval of the saved programs



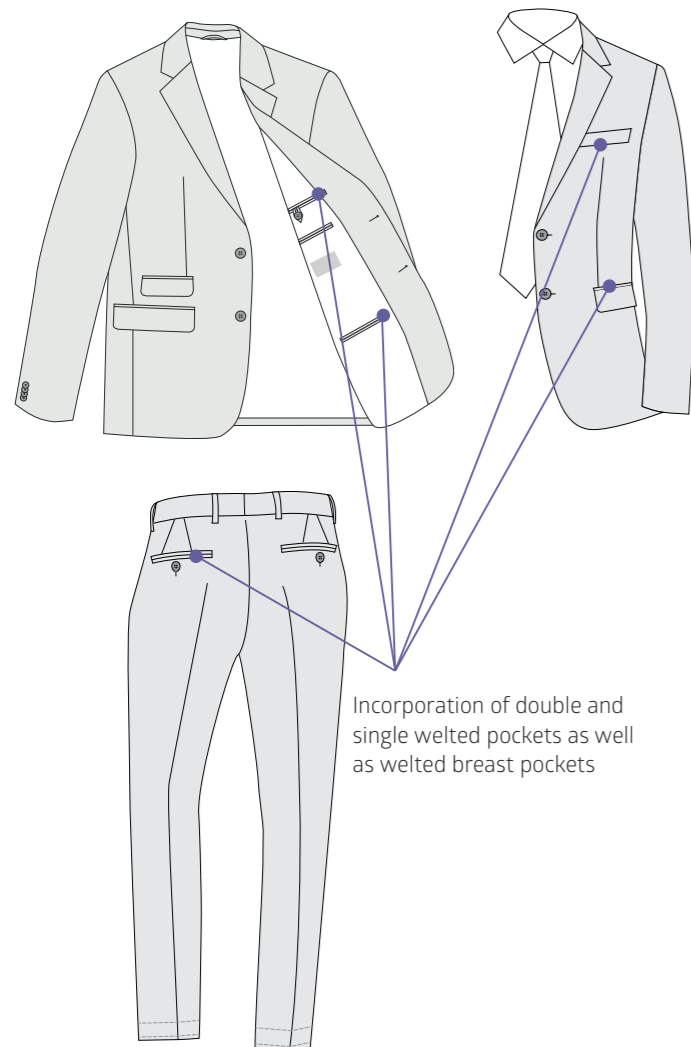
Accurate positioning by the 8 position lamps (3 optional)



Automatic transfer unit for piping and accessories



Cutter block for straight and slanted corner cuts



Incorporation of double and single welted pockets as well as welted breast pockets

Sample seams

An example of the use of the BASS 3504 for inner pockets is illustrated here. Pocket openings can optionally be worked straight or slanted, with or without flaps.



Advantages

- ✓ Simple operation
- ✓ Easily programmable
- ✓ Quick learning process
- ✓ Numerous options for special applications
- ✓ Quick changeover from double piping to single piping
- ✓ Upstream piping cutter and automatic transfer unit for accessories
- ✓ Freely programmable controller with memory for 40 seams
- ✓ Customised setting for stitching and transport speed
- ✓ Customised programming possible for stitch length, backtacking or stitch condensation
- ✓ Independent drives for clamp transport and all cutter systems
- ✓ Needle distances can be retrofitted from 8 mm-30 mm (in steps of 2 mm)
- ✓ Automatic clamp adjustment when folders get changed
- ✓ Automatic flap length sensing

Production Process

Program pre-selection:

The pre-programmed seam is selected on the control panel.

Sewing procedure: Inside pockets for jackets

The piping cutter is positioned on the left. The piping strip with nonwoven reinforcement is lined up at the ruler stop. Both pocket bag pieces are fixed to the left and right storage area with a clamp. The feeding of the parts, the sewing on of the pocket bag parts and the subsequent sewing process are handled fully automatically.

Sewing procedure: External pockets for jackets

The piping cutter is positioned on the right. The double piping strip is lined up at the ruler stop. The flap is accordingly fixed to the left storage area with a clamp. The feeding of the parts, the positioning of the accessories and the subsequent sewing process are handled fully automatically.

Sewing procedure: Pocket openings for trousers

The piping cutter is positioned on the left. The piping strip is lined up at the ruler stop. The flap or optionally the pocket facing is fixed to the right storage area with a clamp. The feeding of the flap or pocket facing and the subsequent sewing process are handled fully automatically. Fully-sewn parts are transported from the roller unit and stacked on the stacker (201/6) for further processing.

Performance Profile

The BASS 3204 is a fully automatic welted pocket sewing machine for all prevalent pocket openings with and without flaps. It is impressive with its high operating speed.

The clamp transport and all cutter systems of the sewing machine have their own separate drive: The clamp transport is controlled by a stepper motor and the centre cutter is driven by a separate electric motor.

The automatic machine is fitted with a flexible, automatic transfer unit for accessories, which supports the processing of straight and diagonal sports jacket inner and outer pockets as well as pocket openings for trousers.

Work ergonomics

The swivel-out folding station enables easy access for set-up and service work.

Technical Specifications

Dimensions

Length..... 1650 mm
 Width..... 800 mm/1170 mm
 Height 1300 mm

Table height

Manually adjustable from 850 mm to 1.150 mm

Weight

Basic equipment..... 200 kg
 Basic equipment with stacker 220 kg

Compressed air

Nominal pressure..... 20 NI/6 bar

Power supply

Rated voltage..... 220V/50/60 Hz
 AC voltage 220V/50/60 Hz
 Power consumption..... 0,7 kWh

Sewing System

Maximum sewing speed 3000 rpm
 Stitch length..... 0,5-3,0 mm
 Needle system..... 2134-85
 Needle size..... Nm 90-Nm100
 Needle distances (2 mm steps)..... 8-24 mm for selection
 (6,4 mm; 26-30 mm available against extra charge)

Examples of output

1800-2400* welted pockets in 8 hours
 Depending on the shape of the pocket and number of additional parts, as well as the attachments
 (pocket bag, piping, flaps, facing sections; stacker, bundle clamp)

Basic equipment

- Brother twin needle lockstitch sewing head B-8422 with fixed needle bar or Brother B-8452 with split needle bar
- Direct drive motor
- Microprocessor controller with LCD display and memory chip for data backup
- Main clamp drive by controlled stepper motor with automatic length adjustment from 20-200 mm
- Fast cutter adjustment for corner cutter position 10 mm /in steps of 0.1 mm
- Piping cutter
- Programmable lowering of the main clamp
- Lateral corner cutter adjustment with a cam
- Corner cutter holder with adjustable cutting width
- Programmable lowering of the transport clamp
- Programmable start and end back tacking or optionally adjustable stitch condensation
- Double welt unit
- Clamp push-back blocking
- Needle distance 8-30 mm
- Needle and bobbin thread sensor
- Thread cutter device
- Five separately programmable laser markings

Options:

BASS 3504T: Trousler pockets

Piping strip feed from the left, automatic transfer unit for accessories from the right

BASS 3504J: Jacket pockets

Piping strip feed from the right, automatic transfer unit for accessories from the left

BASS 3504IP: Jacket inner pockets

Piping strip feed from the left, automatic transfer unit for accessories from the right and left



ENGINEERED WORKSTATION

- Automatic serging units
- Automatic pocket welting
- Engineered workstations
- Automatic joining seam machines
- Automatic short seamer machines
- Special machines

EWS 6100

Designed workplace for stitching
the waist in the seam shadow



The sewing machine EWS 6100 was conceived for stitching trouser and skirt waists in seam shadow.

Advantages

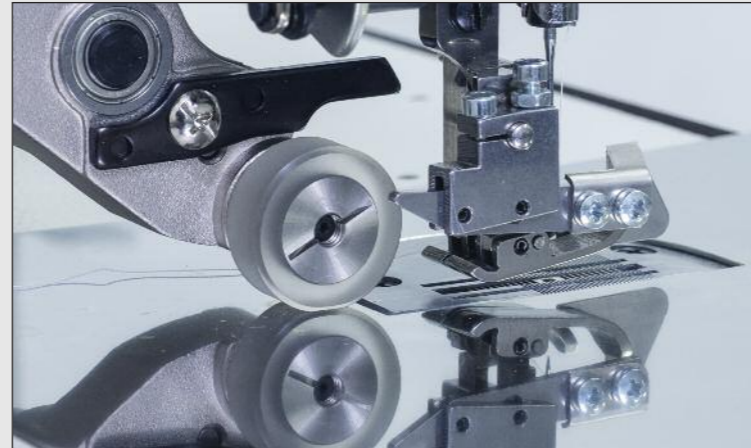
- Up to 600 trousers in 8 hours (depending on the seam length)
- Simple operation
- Quick learning process

EWS 6100

Designed workplace for stitching the waist in the seam shadow



Control panel for adjusting various sewing functions



The puller ensures optimal and prompt transport of the sewn material

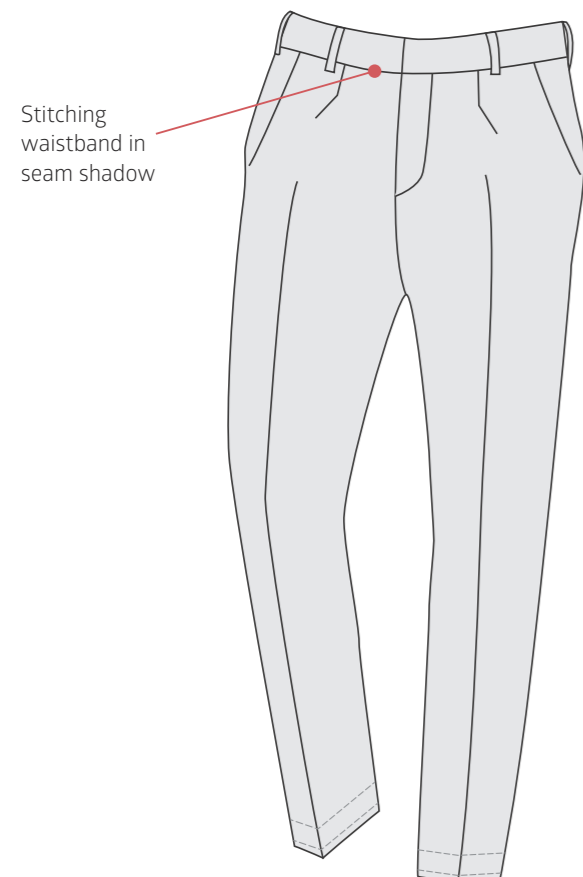


Special presser foot for stitching in the shadow of the seam



Working table shaped for ease of production

Sample seams



Here is an example of the seam



Advantages

- ✓ Simple operation
- ✓ Quick learning process
- ✓ Up to 600 trousers in 8 hours (depending on the seam length)

Production Process

The EWS 6100 is impressive with its easy operator navigation. With few settings, the machine can be set up for high production yield.

Program pre-selection:

The number of backtack stitches and the pulling speed of the puller transport are preset on the control panel.

Sewing procedure:

The sewing part is placed on the spring-loaded stop. The puller transport brings the waist in place. The sewing part can be sewn quickly over the rounded table guide. Back tacking can be switched on by pressing button, or automatically integrated in seam programm. The sewing operation is completed by cutting the thread automatically.

Work ergonomics:

The system can be operated as a workstation either in standing or sitting position. The height of the table can be adjusted to the body height of the operator.

Performance Profile

The EWS 6100 is an optimally designed workplace for stitching trousers and skirt waistbands in shadow seam. The liberal procedure below the sewing base enables easy display of the sewing part.

The puller transport synchronised to the sewing speed stretches the sewing part and ensures a good seam quality. The pulling speed of the puller can be controlled smoothly and continuously and thus, it can be adjusted to any sewing material. The puller is lifted during by back tacking at the beginning and end of the seam. The number of back tacking stitches can be set on the control panel.

EWS 6100

Designed workplace for stitching the waist in the seam shadow

Technical Specifications

Dimensions

Length.....600 mm
Width.....1100 mm
Height1200 mm

Table height

Manually adjustable from 700 mm to 1.100 mm

Weight

Basic equipment..... 110 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

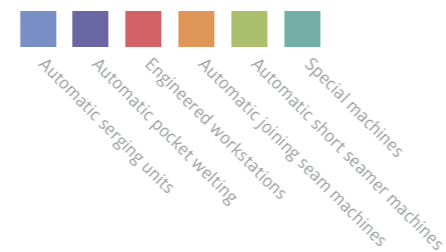
Rated voltage.....220V/50/60 Hz
AC voltage220V/50/60 Hz
Power consumption.....0,7 kWh

Sewing System

Maximum sewing speed 4000 rpm
Stitch length.....0,5–4,2 mm
Needle system.....134 R
Needle size.....80–110 Nm

Examples of output

Up to 600 trousers in 8 hours (depending on the seam length)



Basic equipment

- Sewing head Brother S-7220C-403
- Integrated direct drive sewing drive with controller
- AC voltage 190 V-240 V, 50/60 Hz
- Backtacking button
- Puller transport with pneumatic lifting and lowering
- Machine frame of adjustable height

EWS 6200

Engineered workplace for sewing on heel tape to trousers hem



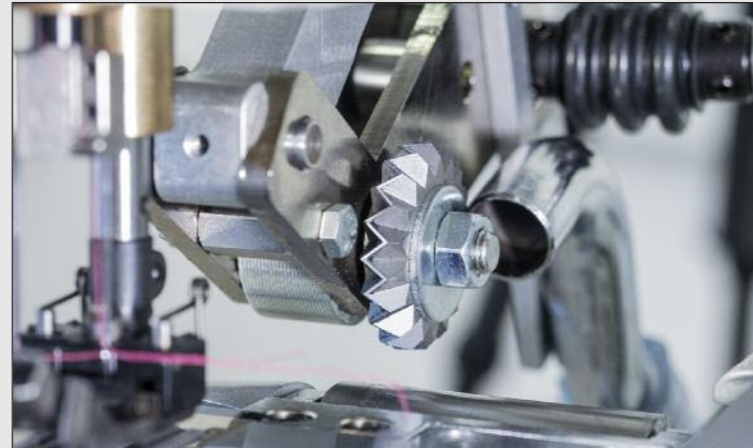
The sewing machine EWS 6200 is a compact semi-automatic machine for sewing heel tape to trouser legs that have already been closed.

Advantages

- Up to 1200 trousers in 8 hours
- Quick learning process – simple operation
- Easy retrieval of the sewing programs
- Multi-width adjustment via program control
- Sewing and pinking possible with a single operation



Simple administration and retrieval of the programmed seams



Sewing and pinking possible simultaneously



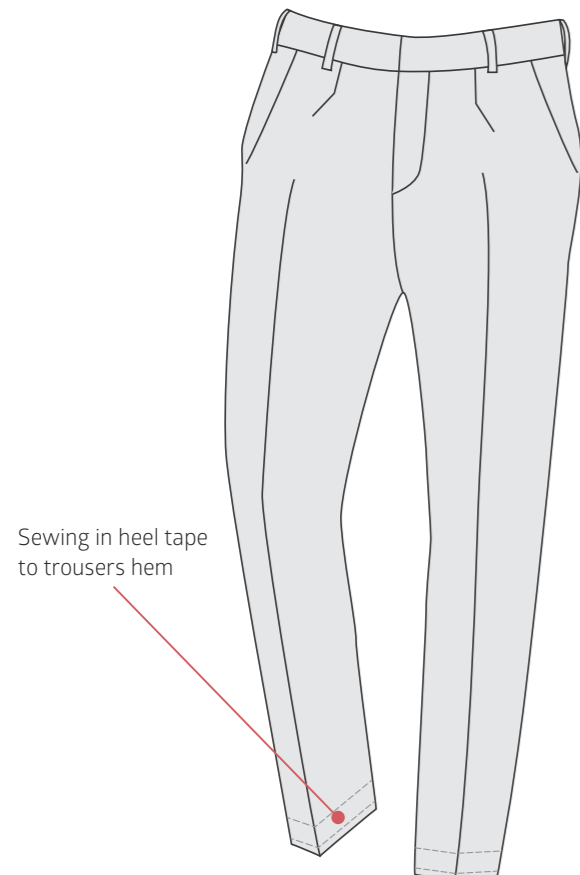
Exact tape guide to the sewing base



Bobbin holder and magazine function

Sample seams

Here are two examples for the possible working modes with the EWS 6200, with or without pinking mechanism



Advantages

- ✓ Freely programmable controller
- ✓ Quick learning process
- ✓ Easy retrieval of the sewing programs
- ✓ Fullness adjustment via program control
- ✓ Simple operation
- ✓ Automatic chain separation
- ✓ Automatic tape cutting at the end of the sewing operation
- ✓ Up to 6 bobbins of heel tape ready at hand

Production Process

Program pre-selection:

At the beginning, the matching sewing program including the width specification is selected. Next, the distance of the heel tape to the edge of the seam is adjusted with the help of an edge guide.

Manual working steps:

After placing the heel tape in the guide, you can begin with the sewing operation. The trouser heel tape is fed from the bobbin, measured automatically and cut off by the integrated tape cutting device at the end of the seam. Now, the trouser leg is placed into the machine and the sewing operation is initiated with the pedal.

Automatic sewing process:

The seam is now sewn with pedal control. After completion of the sewing operation, the sewn part is blown off. With the add-on fitting "Pinking mechanism", the trouser seam edge can be pinked simultaneously with the sewing operation.

Work ergonomics:

The system can be operated as a workstation either in standing or sitting position. The height of the table can be adjusted to the body height of the operator.

Performance Profile

The EWS 6200 is a semi automatic sewing machine for sewing trouser heel tape to trouser legs that have already been closed.

The heel tape is fed from the bobbin, measured automatically and cut off by the integrated tape cutting device at the end of the seam.

The fullness for the liner tape can be adjusted to suit the material.

The sewing machine can process a foot width up to a circumference of minimum 37 cm.

The maximum width of the trouser cuff is 5 cm.

EWS 6200

Engineered workplace for sewing on heel tape to trousers hem

Technical Specifications

Dimensions

Length800 mm
Width..... 500 mm
Height1700 mm

Table height

Manually adjustable from 850 mm to 1150 mm

Weight

Basic equipment.....120 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage..... 220V/50/60 Hz
AC voltage220V/50/60 Hz
Power consumption..... 0,7 kWh

Sewing System

Maximum sewing speed 4500 rpm
Stitch length..... 1,0–4,0 mm
Needle system..... TVx5
Needle size.....80–110 Nm

Examples of output

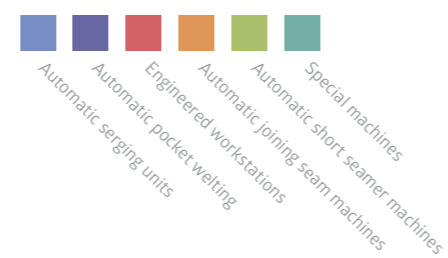
Up to 1200 trouser seams with liner tape in 8 hours

Basic equipment

- Sewing head Kansai DX 9902-2L/UTC
- AC voltage 190 V-240 V, 50/60 Hz
- Micro-processor controller with LCD display
- Automatic thread cutter
- Automatic tape cutter
- Bobbin holder with magazine feature for 6 heel tape bobbins

Options :

- Pinking device
- Bundle clamp



EWS 6300

Sewing machine for processing closing seams



The EWS 6300 sewing machine is a compact and semi-automatic machine for closing seams, side or inside seams in trousers. However, even closing seams for sports jackets, skirts or sleeves can be handled with the EWS 6300.

Advantages

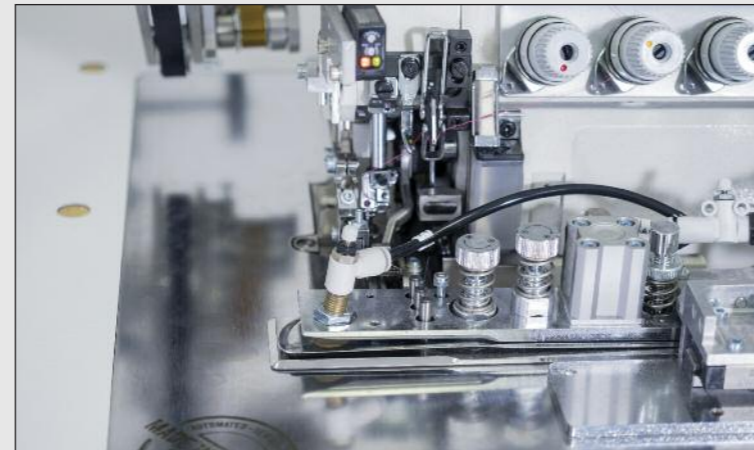
- Up to 450 trousers, crotch and side seams in 8 hours
- Freely programmable controller
- Easy retrieval of the sewing programs
- Multi-width adjustment via program control

EWS 6300

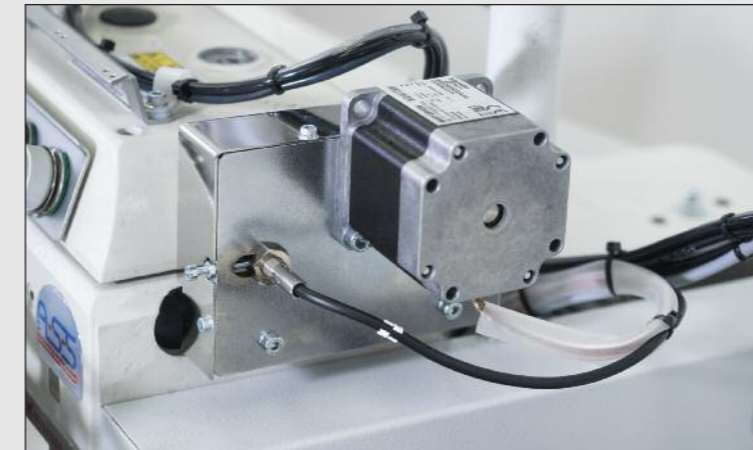
Sewing machine for processing closing seams



Easy administration and retrieval of the programmed seams via the program controller



The accurately adjustable contour guide ensures consistent seam widths over the entire length of the seam



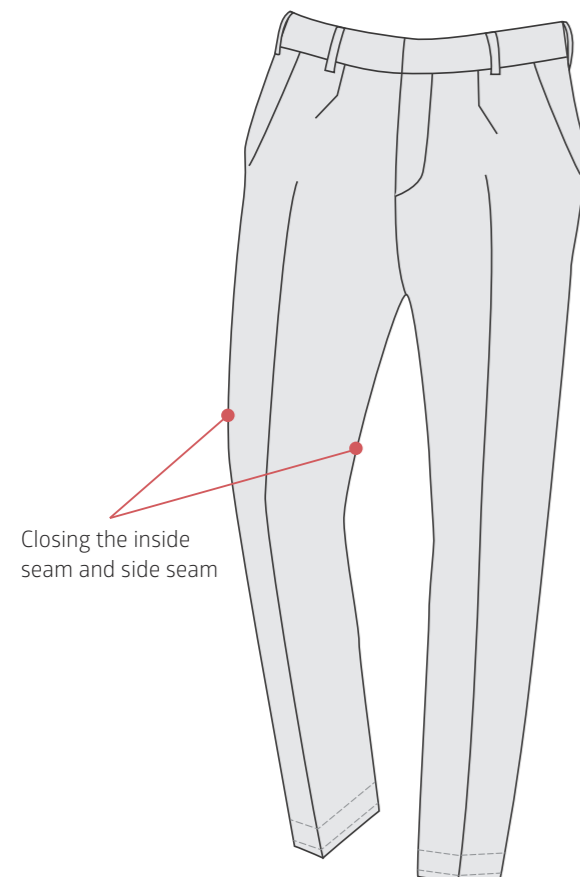
Multi-width adjustment via stepper motor



Fully automatic de-stacking device

Sample seams

An example of usage options of the EWS 6300, closing the side seam and inside seam for trousers.



Closing the inside seam and side seam



Advantages

- ✓ Freely programmable controller
- ✓ Quick learning process
- ✓ Easy retrieval of the sewing programs
- ✓ Multi-width adjustment via program control
- ✓ Simple operation
- ✓ Automatic chain separation

Production Process

Program pre-selection:

The programmed seam is selected on the control panel.

Manual working steps:

The contour guide is adjusted to the sewing material. Sewing routes, e.g. sharp hip bends or side and slanted pocket seams are guided manually. Next, the contour guide that can be moved laterally, is moved in.

Automatic sewing process:

The residual seam is sewn automatic and the chain is automatically separated. Next, the finished sewn section is stacked on the stacker (Type 201/6) for further processing.

Work ergonomics:

The system can be operated as a workstation either in standing or sitting position. The height of the table can be adjusted to the body height of the operator.

Performance Profile

The EWS 6300 sewing machine is a compact and semi-automatic machine for closure of seams. The powerful sewing equipment processes side or inside seams on sports jackets, skirts or sleeves.

You can use a safety seam, double chain seam or overlock seam as seam/stitch type.

The beginning and end of the seam are controlled by photocell sensing. An accurately adjustable contour guide ensures consistent seam widths over the entire length of the seam.

The multi-width distribution can be adjusted partially by seam programming.

The practically proven switching device enables smooth changeover from manual sewing, e.g. with sharp hip curves and automatic execution of the rest.

EWS 6300

Sewing machine for processing closing seams

Technical Specifications

Dimensions

Length1300 mm
 Width/with stacker..... 800 mm/1400 mm
 Height1500 mm

Table height

Manually adjustable from 850 mm to 1150 mm

Weight

Basic equipment.....130 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage..... 220V/50/60 Hz
 AC voltage220V/50/60 Hz
 Power consumption..... 0,7 kWh

Sewing System

Maximum sewing speed 6000 rpm
 Stitch length.....1,0–3,8 mm
 Differential.....0,7–6,0 mm
 Obertransport.....1,0–6,0 mm
 Nahtbreite..... 0,9–12 mm
 Needle system.....B 27
 Needle size.....80–110 Nm

Examples of output

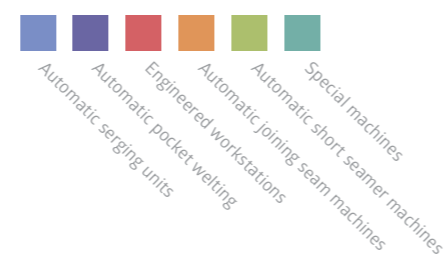
Up to 450 trouser, inside and side seams in 8 hours

Basic equipment

- Sewing head: Pegasus EXT3216-03/233-K 5x6-KH-021-H
- Efka direct drive AB 286
- AC voltage 190 V-240 V, 50/60 Hz
- Micro-processor controller with LCD display and memory chip for data backup
- Adjustable height contour guide unit that can be moved perpendicular to the sewing direction
- Interface for pneumatic stacker connection
- Individually adjustable stepper motors for multi-width distribution
- Automatic thread cutter
- Machine frame of adjustable height
- Stepper motor control for differential and top transport
- Automatic chain separation
- Dirt extraction with collection container

Optionen:

- Sewing head for jeans material: Pegasus EXT3216-04/435-K 5x6-KH-021-H
- Sewing head for medium-heavy material: Pegasus EXT3244-03/333-K 5x2x4-KH-021-B
- You may enquire about individual sewing kits with various seam widths from us or your authorized Pegasus dealer.



EWS 6450

Sewing machine for processing closure seams on previously finished sleeves with and without seam interruption



The sewing machine EWS 6450 is the rational and simple solution for closure seams or previously finished fabric and lined sleeves, with and without seam interruption.

Advantages

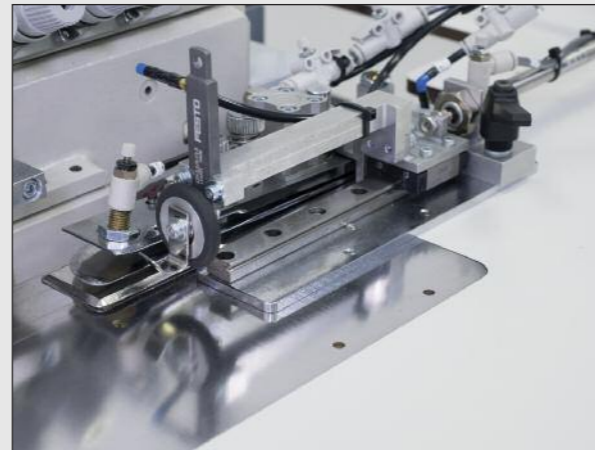
- Up to 800 pairs of sleeve seams in 8 hours
- Freely programmable controller
- Quick learning process
- Easy retrieval of the sewing programs

EWS 6450

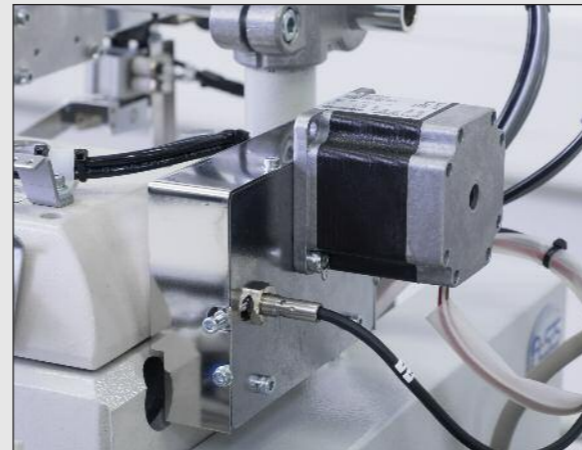
Sewing machine for processing closure seams on previously finished sleeves with and without seam interruption



Easy administration and retrieval of the pre-programmed seams via the program controller



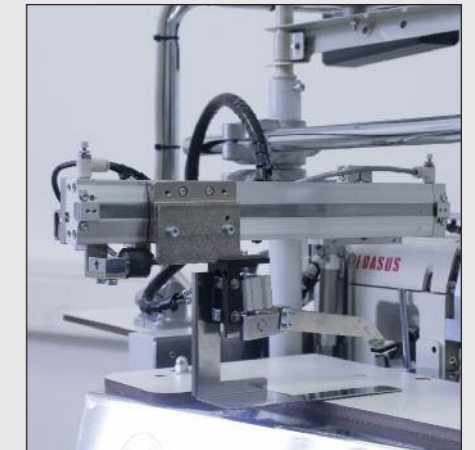
The accurately adjustable contour guide ensures consistent seam widths over the entire seam length even with seam interruption



Fullness adjustment via stepper motor



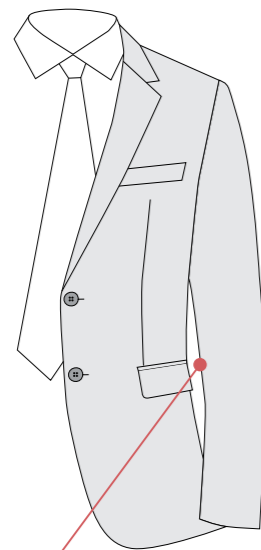
Fully automatic stacking device



Auxiliary transport clamp for sewing interruption

Sample seams

Here is a sports jacket sleeve, underarm seam closed with the EWS 6450



Closing the outer material and lined sleeve seam



Advantages

- ✓ Freely programmable controller
- ✓ Quick learning process
- ✓ Easy retrieval of the sewing programs
- ✓ Fullness adjustment via program control
- ✓ Simple operation
- ✓ Automatic chain separation
- ✓ Automatic sewing interruption according to the programming
- ✓ Automatic transport for sewing interruption with thread cutting feature

Production Process

Program pre-selection:

The programmed seam is selected on the control panel.

Manual working steps:

The contour guide is adjusted to the sewing material. The sewing parts are taken from where they are stored, placed on the table-top and brought congruently to the needle. The outer material seam is sewn manually up to the lining seam (lining by hand). Next, the contour guide is moved in and the automatic seam is initiated with the help of the pedal.

Automatic sewing process:

After starting the sewing operation, the seam is sewn up to the sewing interruption. In case of sewing interruption, the transport device takes the sewing material and brings it to the position of the next start of the seam in order to complete sewing the part. Next, the ready-made sewn section is placed by the stacker (201/6) for further processing.

Work ergonomics:

The machine is constructed with a sitting workplace for the operator. The table height can be adjusted individually to the operator.

Performance Profile

The EWS 6450 sewing machine is a compact and powerful workplace for closing elbow seams.

Sewing interruption in the sleeves with lining is programmed and executed automatically. The sewing head, Pegasus EXT 3216-03 works with a double chain stitch seam (Type 401).

The beginning and end of the seam are controlled by photocell sensing. An adjustable contour guide that can be moved laterally ensures consistent seam widths over the entire length of the seam.

The multi-width distribution can be adjusted partially by seam programming.

EWS 6450

Sewing machine for processing closure seams on previously finished sleeves with and without seam interruption

Technical Specifications

Dimensions

Length/with bundle clamp1300 mm
Width/with stacker..... 800 mm/1400 mm
Height1500 mm

Table height

Manually adjustable from 850 mm to 1150 mm

Weight

Basic equipment.....120 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage..... 220V/50/60 Hz
AC voltage220V/50/60 Hz
Power consumption..... 0,7 kWh

Sewing System

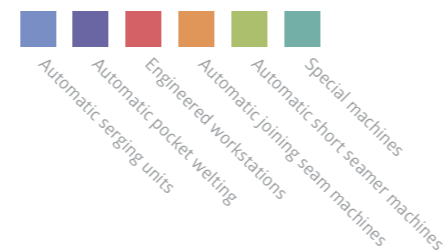
Maximum sewing speed 6000 rpm
Stitch length.....1,0-3,8 mm
Differential.....0,7-6,0 mm
Obertransport.....1,0-6,0 mm
Nahtbreite..... 0,9-12 mm
Needle system.....B 27
Needle size.....80-110 Nm

Examples of output

Up to 800 pairs of sleeves (depending on the seam length) in 8 hours

Basic equipment

- Sewing head: Pegasus EXT3216-03/233-K 5x6-KH-021-H
- Efka direct drive AB 286 AC voltage 190 V-240 V 50/60 Hz
- Micro-processor controller with LCD display and memory chip for data backup
- Contour guide unit (can be moved perpendicular to the sewing direction)
- Interface for pneumatic stacker connection
- Automatic chain separation in case of sewing interruption
- Automatic photocell sensing for the beginning and end of the seam
- Stitch condensing programmable fullness distribution by differential upper and bottom feed via stepper motor controller
- Chain separation with dirt extraction and waste container
- Machine frame of adjustable height
- Dirt extraction with collection container
- Throw-over stacker 201/6-2 (for 500 mm wide parts)
- Transport for sewing interruption with thread cutter
- Auxiliary guide roller on the contour guide
- Memory Chip



EWS 6500

Sewing machine for sewing endless zippers on fly pieces automatically



The EWS 6500 sewing machine has been designed for efficient sewing of endless zipper on fly pieces.

Advantages

- Up to 6500 fly pieces in 8 hours
- Simple operation – Quick learning process
- Overlapping working

EWS 6500

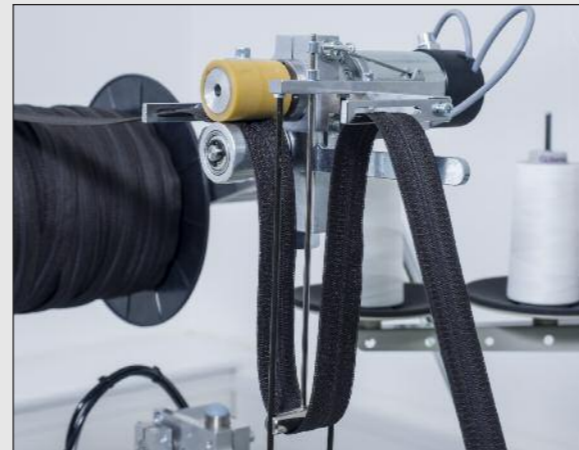
Sewing machine for sewing endless zippers on fly pieces automatically



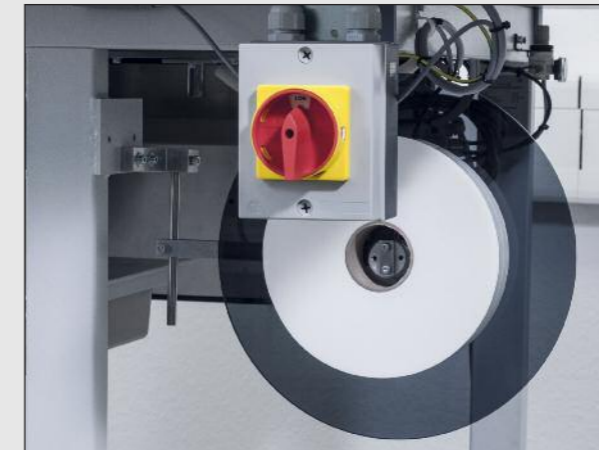
Easy administration and retrieval of the pre-programmed seams via the program controller



Machine stencil and zipper guide ensure consistent seam quality and guarantee the optimal seam result



The endless zipper tape is fed automatically via the unwinding unit



Fleece tape for stabilising the seam runs simultaneously automatically



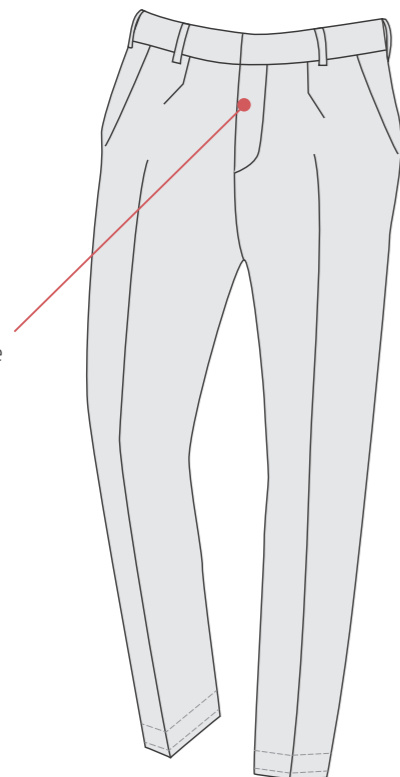
Automatic removal and de-stacking (optional)

Sample seams

The finished fly piece, top side with zipper and bottom side with fleece tape.



Sew the endless zipper tape on the fly piece



Advantages

- ✓ Simple operation
- ✓ Quick learning process
- ✓ Overlapping working

Production Process

Program pre-selection:

The programmed seam is selected on the control panel.

Manual working steps:

The proper sewing program is selected via the controller. The endless zipper is brought into the guide. The fly facing part is placed on the edge ruler and the sewing operation is initiated with the help of a manual switch.

Automatic sewing process:

After initiating the sewing operation, the zipper tape is stitched to the fly facing part.

The sewn parts are then cut by hand and deposited. Optionally, the machine may be fitted with an automatic cutter and stacking device. In this case, you need not cut manually.

Performance Profile

The EWS 6500 sewing machine stitches endless zippers on the fly pieces. The chain of the double chain seam lies at the bottom of the fly piece. Thus, you can no longer see the chain on the finished trouser and this also ensures greater safety of the seam. The accurate transport technology with separate material feed for the zipper and fly piece enables processing of the most diverse materials.

Even less experienced personnel achieve top-class sewing results on account of the ease of operation. The fully overlapped method of working ensures maximum productivity.

EWS 6500

Sewing machine for sewing endless zippers on fly pieces automatically

Technical Specifications

Dimensions

Length.....1700 mm
Width.....1400 mm
Height1700 mm

Table height

Manually adjustable from 1000 mm

Weight

Basic equipment.....220 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage.....220V/50/60 Hz
AC voltage190V-240V V/50/60 Hz
Power consumption.....0,9 kWh

Sewing System

Maximum sewing speed 6000 rpm
Stitch length.....1,0-4,0 mm
Needle system.....TVx7
Needle size.....90-110 Nm

Examples of output

Up to 6500 fly pieces in 8 hours

Basic equipment

- Head needle distance 4.8 mm, double chain stitch seam
- Lower tape guide
- Bobbin holder with guide for zipper

Optional :

- Automatic trimmer
- Small parts stacker



EWS 7000

Sewing machine for processing closing seams



The EWS 7000 sewing machine is a compact and semi-automatic machine for closing seams, side or inside seams in trousers. However, even closing seams for sports jackets, skirts or sleeves can be handled with the EWS 7000.

Advantages

- Up to 450 trousers, crotch and side seams in 8 hours
- Quick learning process – simple operation
- Easy retrieval of the sewing programs
- Multi-width adjustment via program control

EWS 7000

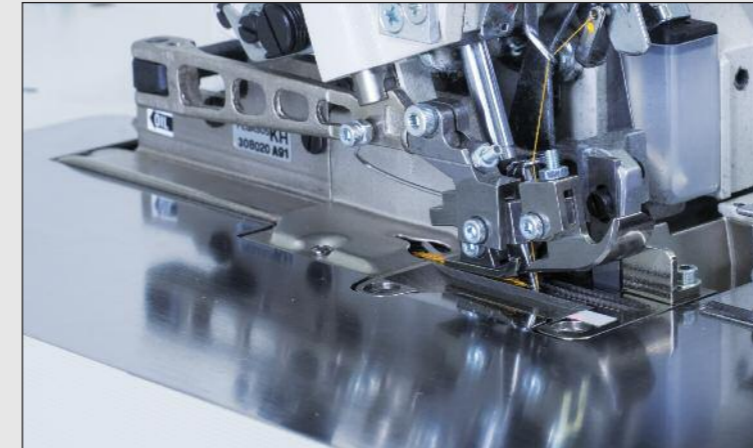
Sewing machine for processing closing seams



Easy administration via the program controller



The accurately adjustable contour guide ensures consistent seam widths over the entire length of the seam



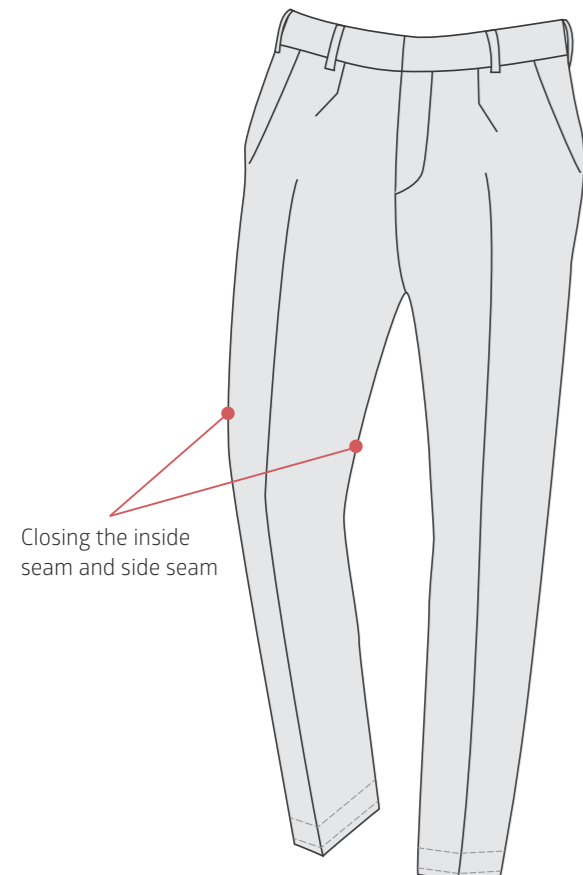
Special presser foot for optimal material transport (optional)



Fully automatic de-stacking device

Sample seams

An example of usage options of the EWS 7000, closing the side seam and inside seam for trousers.



Advantages

- ✓ Quick learning process
- ✓ Easy retrieval of the sewing programs
- ✓ Simple operation
- ✓ Automatic chain separation

Production Process

Program pre-selection:

The programmed seam is selected on the control panel.

Manual working steps:

The contour guide is adjusted to the sewing material. Sewing routes, e.g. sharp hip bends or side and slanted pocket seams are guided manually. Next, the contour guide that can be moved laterally, is moved in.

Automatic sewing process:

The residual seam is sewn automatic and the chain is automatically separated. Next, the finished sewn section is stacked on the stacker (Type 201/6) for further processing.

Work ergonomics:

The system can be operated as a workstation either in standing or sitting position. The height of the table can be adjusted to the body height of the operator.

Performance Profile

The EWS 7000 sewing machine is a compact and semi-automatic machine for closure of seams. The powerful sewing equipment processes side or inside seams on sports jackets, skirts or sleeves.

You can use a safety seam, double chain seam or overlock seam as seam/stitch type.

The beginning and end of the seam are controlled by photocell sensing. An accurately adjustable contour guide ensures consistent seam widths over the entire length of the seam.

The multi-width distribution can be adjusted partially by seam programming.

The practically proven switching device enables smooth changeover from manual sewing, e.g. with sharp hip curves and automatic execution of the rest.

Technical Specifications

Dimensions

Length1300 mm
 Width/with stacker..... 800 mm/1400 mm
 Height1500 mm

Table height

Manually adjustable from 850 mm to 1150 mm

Weight

Basic equipment.....130 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage..... 220V/50/60 Hz
 AC voltage220V/50/60 Hz
 Power consumption..... 0,7 kWh

Sewing System

Maximum sewing speed 7000 rpm
 Stitch length.....1,0–3,8 mm
 Differential..... 0,7–6,0 mm
 Top feeding..... 1,0–6,0 mm
 Seam width..... 0,9–12 mm
 Needle system..... B 27
 Needle size.....80–110 Nm

Examples of output

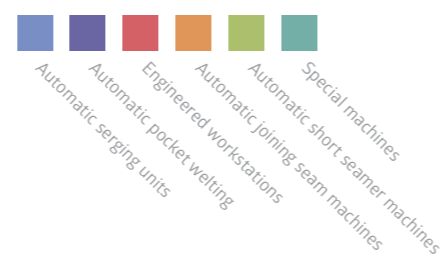
Up to 450 trousers, inside and side seams in 8 hours

Basic equipment

- Sewing head: EX3216-03/233K5x5-KH-021-H
- Efka direct drive AB 286
- AC voltage 190 V-240 V, 50/60 Hz
- Micro-processor controller with LCD display and memory chip for data backup
- Adjustable height contour guide unit that can be moved perpendicular to the sewing direction
- Interface for pneumatic stacker connection
- Automatic thread cutter
- Machine frame of adjustable height
- Automatic chain separation
- Dirt extraction with collection container

Optionen:

- Sewing head for jeans material: Pegasus EX3216-04/435-K 5x6-KH-021-H
- Sewing head for medium-heavy material: Pegasus EX3244-03/333-K 5x2x4-KH-021-B
- You may enquire about individual sewing kits with various seam widths from us or your authorized Pegasus dealer.





AUTOMATIC JOINING SEAM MACHINES

- Automatic serging units
- Automatic pocket welting
- Engineered workstations
- Automatic joining seam machines
- Automatic short seamer machines
- Special machines

BASS 4100

Engineered workstation for the semi-automatic joining of side and inside seams



The BASS 4100 is a sewing machine to produce assembly seams. Can be used for side and inside seams on trousers, as well as for assembly seams on sports jackets and skirts. The selection of three stitch types, safety seam, double chain stitch and overlocking stitch enables varied use for women's outerwear and men's and boys' outerwear.

Advantages

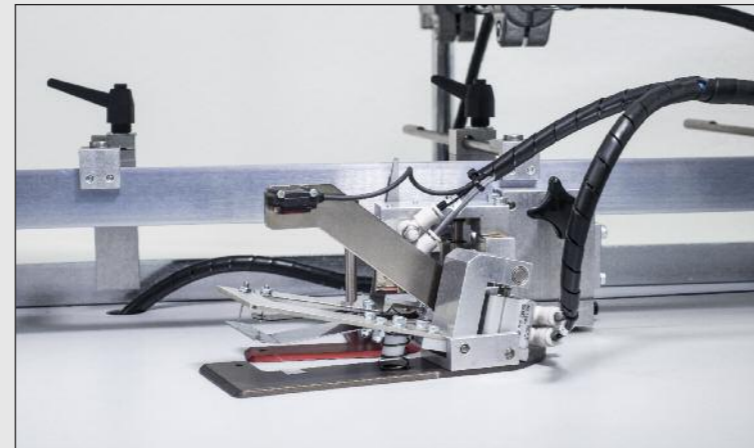
- Up to 2400 seams per day/8 hours
- Simple selection of the sewing programs
- Proven combination of manual and automated seams
- Contour guide working with absolute reliability
- Powerful sewing head for high sewing speeds

BASS 4100

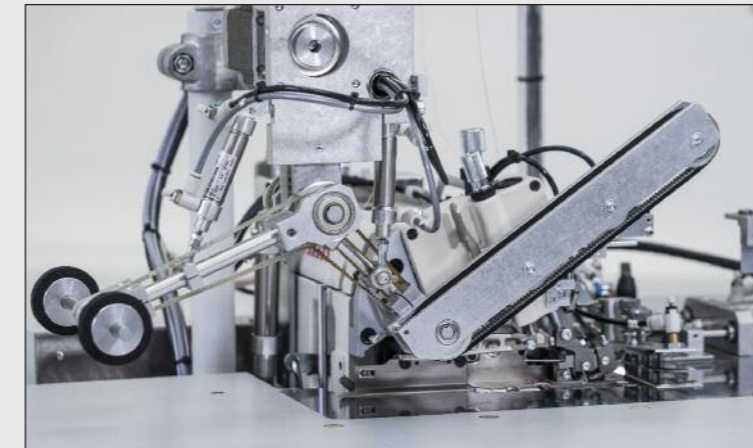
Engineered workstation for the semi-automatic joining of side and inside seams



Easy preparation and administration as well as retrieval of the saved programs



The sewing material is guided optimally with the guide clamp



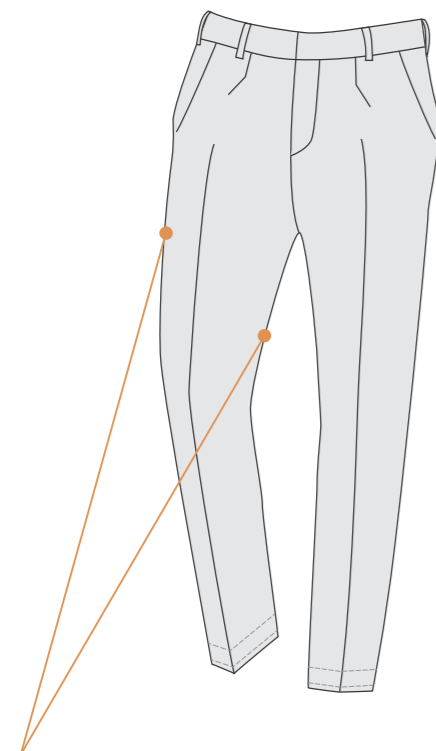
Absolutely reliable contour guide working and additional conveyor transport



Fully automatic de-stacking device

Sample seams

Here is an example of a seam with the stitch pattern 516 safety. We optionally offer overlocking stitch, double chain stitch and also 6-thread safety stitch.



Close side and inside seams

Advantages

- ✓ Simple selection of the sewing programs
- ✓ Proven combination of manual and automated seam
- ✓ Contour guide working with absolute reliability
- ✓ Powerful sewing head for high sewing speeds
- ✓ Quick learning process
- ✓ Fully overlapping working sequence possible

Production Process

Program pre-selection:

The pre-programmed seam is selected on the control panel..

Manual working steps:

The contour guide is adjusted to the sewing material. The sewing part is fixed in place with the guide clamp. Difficult sewing sequences, e.g. sharp hip bends or side and slanted pocket seams are guided manually. The automatic sewing process gets initiated after releasing the contour guide.

Automatic sewing process:

The residual seam is sewn in a sewing operation and the chain is automatically separated. Next, the finished sewing part is stacked.

Work ergonomics

The system is designed as a standing workstation, and can be operated both with a foot switch and a knee switch. The height of the table can be adjusted to the body height of the operator.

Performance Profile

The BASS 4100 is a sewing system for assembly seams. Can be used for side and inside seams on trousers, sports jackets and skirts. The easy-to-use system guarantees high working productivity with a very short learning time.

You can use a safety seam, double chain stitch seam or overlock seam as the stitch pattern. The beginning and end of the seam are controlled by photocell sensing. An accurately adjustable contour guide ensures consistent seam widths over the entire length of the seam.

The fullness distribution can be adjusted partially by programming. The practically proven device enables smooth changeover from manual sewing, e.g. over the pocket opening, and the automatic sewing of the rest of the seam.

Technical Specifications

Dimensions

| | |
|---------------------------|-----------------|
| Length/ with stacker..... | 2200 mm/3000 mm |
| Width..... | 1100 mm |
| Height | 1300 mm |

Table height

| | |
|--------------------------------|--------------------|
| Manually adjustable from | 850 mm to 1.150 mm |
|--------------------------------|--------------------|

Weight

| | |
|------------------------------------|--------|
| Basic equipment..... | 150 kg |
| Basic equipment with stacker | 275 kg |

Compressed air

| | |
|-----------------------|-------------|
| Nominal pressure..... | 20 NI/6 bar |
|-----------------------|-------------|

Power supply

| | |
|------------------------|---------------|
| Rated voltage..... | 220V/50/60 Hz |
| AC voltage | 220V/50/60 Hz |
| Power consumption..... | 0,6 kWh |

Sewing System

| | |
|----------------------------|-------------|
| Maximum sewing speed | 6000 rpm |
| Stitch length..... | 1,0-3,8 mm |
| Differential..... | 0,7-6,0 mm |
| Obertransport..... | 1,0-6,0 mm |
| Needle distances..... | 0,9-12 mm |
| Needle system..... | B 27 |
| Needle size..... | Nm 80-Nm110 |

Examples of output

Up to 600 trousers (side and inside seams) in 8 hours

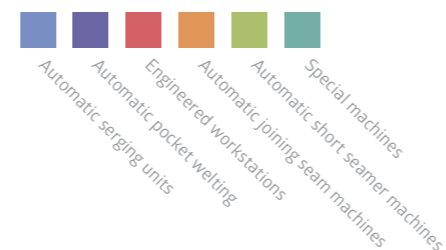
Basic equipment

- Sewing head: Pegasus EXT 3216-03/233-K 5x6-KH-021-H
- Efka Direct Drive AB 286
- AC voltage 220 V, 50/60 Hz
- Microprocessor controller with LCD display and memory chip for data backup
- Adjustable height contour guide unit that can be moved perpendicular to the sewing direction
- Interface for pneumatic stacker connection
- Manually adjustable fullness distribution with differential transport and top feeding
- Automatic thread cutter
- Automatic chain separation
- Dirt extraction with collection container
- Preparation table with guide clamp and reverse device
- Stepper motor control for differential and top feeding
- Preloading station for overlapping working method

Options:

- Sewing head for denim: Pegasus EXT 3216-04/435-K 5x6-KH-021-H (high lift)
- Sewing head for medium-heavy material: Pegasus EXT 3244-03/333-K 5x2x4-KH-021-B
- Folding stacker
- Additional conveyor transport

You may enquire about individual sewing threads with various seam widths from us or your Pegasus dealer.





AUTOMATIC SHORT SEAMER MACHINES

- Automatic serging units
- Engineered pocket welting
- Automatic joining seam machines
- Automatic short seamer machines
- Special machines

BASS 5100

Automatic machine for short seams for curved and straight seam pockets



The BASS 5100 is a sewing machine for processing straight and curved (side) seam pockets.

Advantages

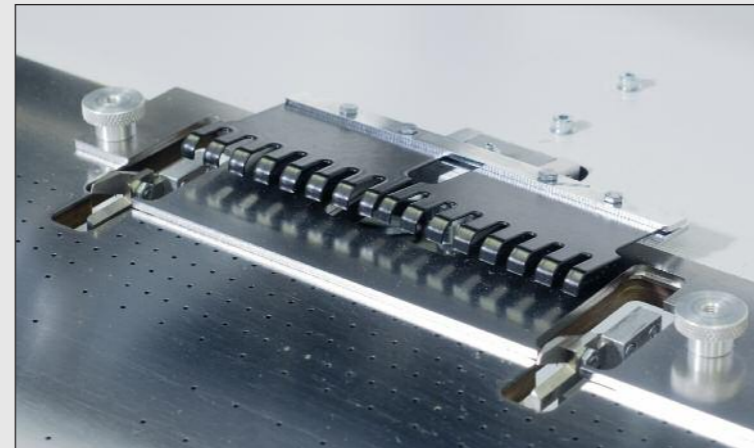
- Up to 2800 seam pockets in 8 hours (dependent on the seam length)
- Quick learning process
- Simple operation
- Freely programmable

BASS 5100

Automatic machine for short seams for curved and straight seam pockets



Easy preparation and administration as well as retrieval of the saved programs



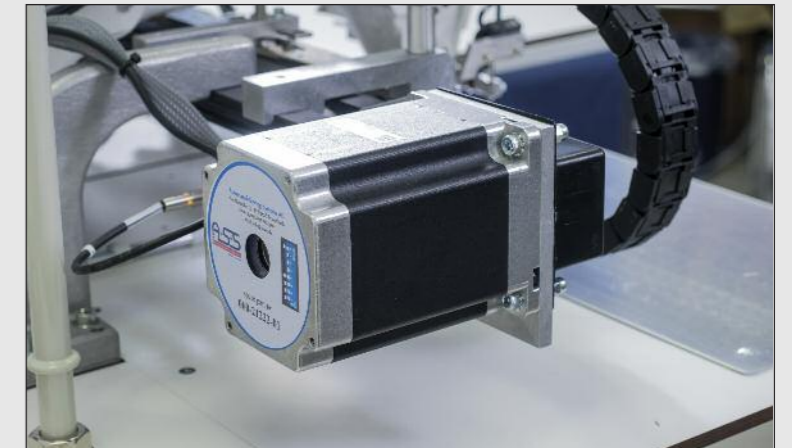
Laying station for side seam pockets



Set-up kits for curved pockets



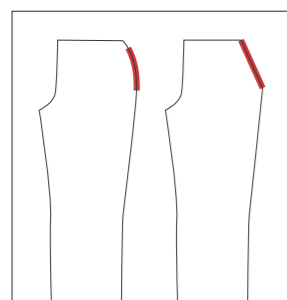
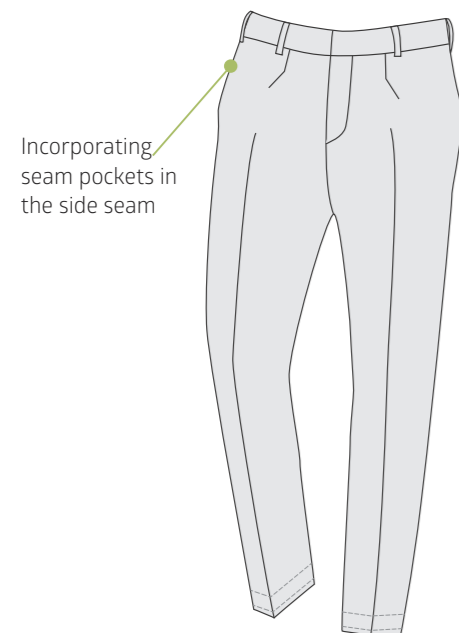
Set-up kits for straight pockets



Stepper motor-controlled transport

Sample seams

A few examples of the use of the BASS 5100 are illustrated here. A high level of sewing accuracy characterises the BASS 5100 for the production of side sewn pockets.



1 Straight pocket opening



2 Curved pocket opening

Advantages

- ✓ Quick learning process
- ✓ Simple operation
- ✓ Freely programmable
- ✓ Back tacking or adjustable stitch condensation possible
- ✓ Display of the machine functions as graphical icons
- ✓ Customised programming of stitch length
- ✓ Automatic seam length sensing by photocell
- ✓ Simple adjustment of seam width

Production Process

Program pre-selection:

The programmed seam is selected on the control panel.

Manual working steps:

The bundle with the trouser parts is placed in the bundle clamp (optional). Then, the front of the trouser is positioned at the edge stop, the vacuum is activated and the pre-finished pocket pouch is placed over the trouser part. After initiating the sewing operation, depending on the shape of the pocket, one or two notch cutters are switched on and the sewing part is brought below the needle with the transport clamp.

The operator can prepare the next sewing part just after the sewing part has been taken by the transport device and thus work in an overlapping and efficient manner.

Automatic sewing process:

The sewing parts are taken from the transport clamp and moved to the needle. Then sewing starts. After completion of the sewing operation, the sewn part is blown off.

Work ergonomics:

The system can be operated as a workstation either in standing or sitting position. The height of the table can be adjusted to the body height of the operator.

Performance Profile

The use of the BASS 5100 ensures enormous savings in time with respect to productivity by the completely overlapping working method as well as consistent sewing results with various materials.

It is possible to sew pockets in the side seam, curved and straight shapes with the BASS 5100. Depending on the shape of the pocket opening, the sewing is done optionally with one or two notch cutters.

BASS 5100

Automatic machine for short seams for curved and straight seam pockets

Technical Specifications

Dimensions

Length/with bundle clamp 1600 mm
Width 950 mm
Height 1.300 mm

Table height

Manually adjustable from 850 mm to 1150 mm

Weight

Basic equipment 200 kg

Compressed air

Nominal pressure 20 NI/6 bar

Power supply

Rated voltage 220V/50/60 Hz
AC voltage 220V/50/60 Hz
Power consumption 0,7 kWh

Sewing System

Maximum sewing speed 4500 rpm
Maximum seam length 165 mm for curved pockets and variable for straight pockets
Maximum seam depth 50 mm
Stitch length 0,5–4,5 mm
Needle system 134
Needle size 80–110 Nm

Examples of output

Up to 2800* seam pockets in 8 hours

*dependent on the seam length

Basic equipment

- Lock stitch head Brother 7200 with integrated DC positioning drive and motor controller,
- Electromagnetic thread cutter
- Freely programmable micro-processor controller with LCD display
- Main clamp drive by controlled stepper motor
- Sensing the start and end of the sewing material by photocell
- Back tacking at the beginning and end of the seam or stitch condensation as an option
- Needle thread monitoring (bobbin thread monitoring as an option)
- Manually adjustable frame height from 850 mm to 1150 mm
- AC voltage 190 V-240 V, 50/60 Hz
- Electromagnetic thread cutter device
- Straight clamp
- Curved clamp
- Memory Chip
- Scissors for cutting notches

Options:

- Bundle clamp
- Vacuum pump



BASS 5300

Automatic sewing machine for folding and felling pocket facings on pocket pouches



The BASS 5300 is a sewing machine in which all straight facings can be stitched efficiently and with good stitch quality on the pocket pouch.

Advantages

- Stitching up to 4500 pocket facings in 8 hours
- Variable topstitching widths
- Quick learning process
- Simple operation

BASS 5300

Automatic sewing machine for folding and felling pocket facings on pocket pouches



Easiest preparation and administration as well as retrieval of the saved sewing programs



After placing the pocket pouch and laying the border, the machine performs the following work steps such as in-feed, sewing operation and de-stacking automatically.



Seam length detection by the photo cell



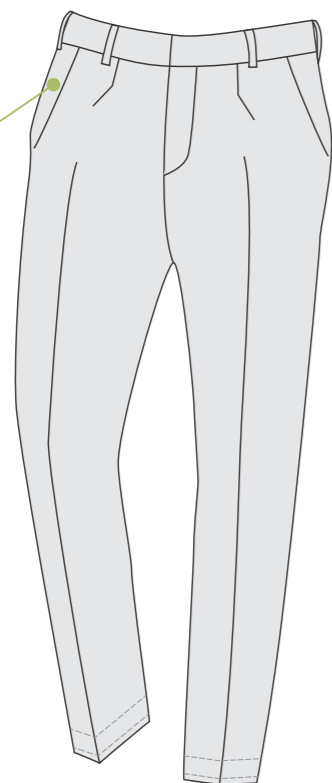
The stacker places the sewing parts for the subsequent operation

Sample seams

Here are a few sewing examples such as pocket pouches with borders for the hip pockets or for the front slide-in pocket.



Stitching straight pocket facings on pocket pouches



Advantages

- ✓ Variable stitching widths
- ✓ Quick learning process
- ✓ Simple operation
- ✓ Freely programmable
- ✓ Backtacking or adjustable stitch condensation possible
- ✓ Stitching of all straight pocket facings possible
- ✓ Display of the machine functions by graphical icons
- ✓ Customised programming of seam lengths
- ✓ Automatic seam length sensing with the help of a photocell
- ✓ Easy adjustment of seam widths

Production Process

Program pre-selection:

The pre-programmed seam is selected on the control panel.

Working steps:

The border is positioned on the laying station. The pocket pouch is positioned on the table.

Automatic sewing process:

The pleating operation is initiated automatically while picking up the facing and thereafter, it is placed on the pocket pouch. Now the transport unit transports it to the needle. After sewing, the stacking unit brings the sewing material to the stacking position.

Work ergonomics:

The system can be operated as a workstation either in standing or sitting position. The height of the table can be adjusted to the body height of the operator.

Performance Profile

The BASS 5300 is a sewing machine with which all straight facing can be stitched efficiently and with good stitching quality on pocket pouches. Different top stitch width can be adjusted by an efficient folding device.

The program enables sewing over the entire length of the pocket pouch as well as sewing only over the length of the facings.

Operation at the workstation is designed for quick learning process.

The machine functions are marked as graphical icons – the associated function parameters are displayed additionally in plain text.

BASS 5300

Automatic sewing machine for folding and felling pocket facings on pocket pouches

Technical Specifications

Dimensions

Length.....1600 mm
Width.....950 mm
Height1300 mm

Table height

Manually adjustable from 890 mm to 1150 mm

Weight

Basic equipment.....200 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage.....220V/50/60 Hz
AC voltage220V/50/60 Hz
Power consumption.....0,7 kWh

Sewing System

Maximum sewing speed 4500 rpm
Stitch length.....0,5-5 mm
Needle system.....134
Needle size.....80-110 Nm

Examples of output

Felling up to 4500 pocket facings in 8 hours

Basic equipment

- Lockstitch sewing head Brother 7200 with integrated DC motor and motor controller,
- Electromagnetic thread cutter
- Freely programmable micro-processor controller with LCD display
- Main clamp drive by controlled stepper motor
- Sensing the start and end of the sewing material by photocell
- Backtacking or stitch condensation programmable at the beginning and the end of the seam or sewing density as an option
- Laying station up to 360 mm
- Border length (max. seam length up to 450 mm)
- Small parts stacker with automatic lowering (by photocell)
- Needle thread monitoring (bobbin thread monitoring as an option)
- Height adjustable frame
- Trays for pocket pouches and facings



BASS 5310

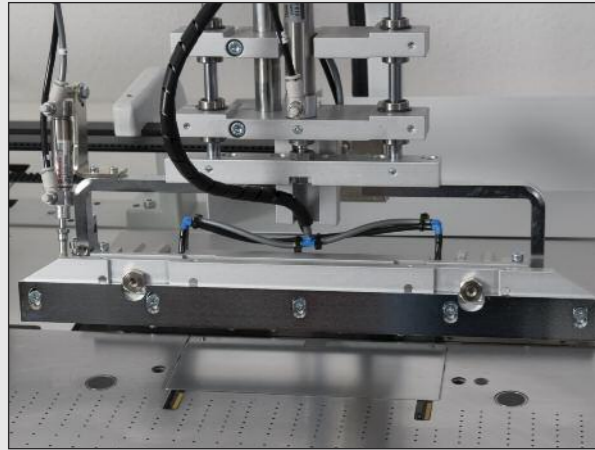
Automatic short seamer for pocket facings and pockets (US style)



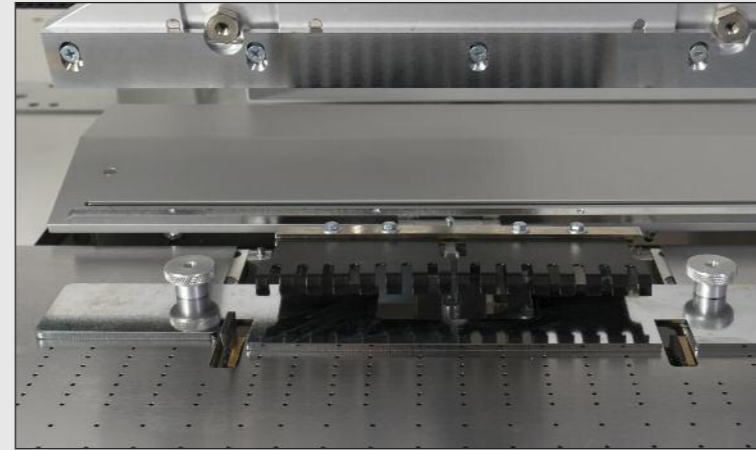
The BASS 5310 is a sewing system for processing straight and curved side seam pockets pockets as well as all straight pocket facings on pocket pouches of the front and rear sides of trousers.

Advantages

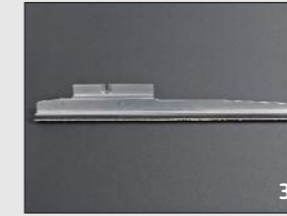
- Up to 4500 pieces of facings on the pocket pouch per day/8 hours, up to 2800 pieces of sewn pockets per day/8 hours (each depending on the seam length)
- Quick learning process
- Simple operation
- Freely programmable
- Flexible sewing system



Placing station for stitching on pocket facings



Placing station for pockets in the side seam



Set-up changed for curved pockets in the side seam (Figure 1)



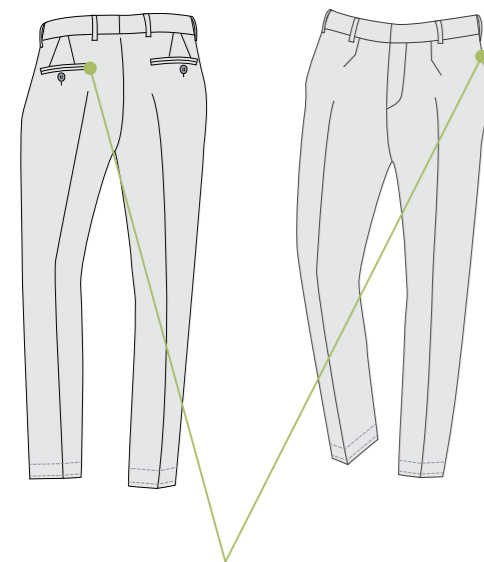
Set-up changed for straight pockets in the side seam (Figure 2)

Stitching on the clamp for pocket facings (Figure 3)



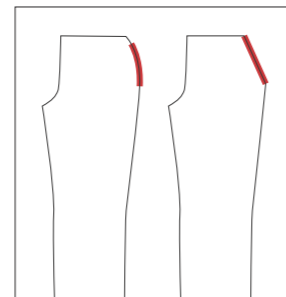
Bundle clamp for side seam pockets

Sample seams

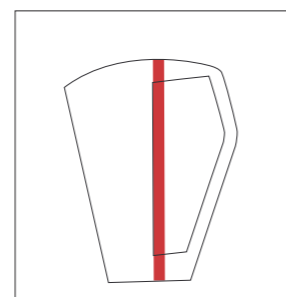


Sewing side seam pockets and felling pocket on pocket pouch

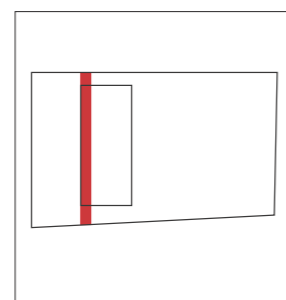
A few examples of the use of the BASS 5310 are illustrated here schematically.



1 Pocket openings in side seam
Straight and curved opening shapes are possible



2 Felling on front trouser pocket pouch



3 Felling on rear trouser pocket pouch

Advantages

- ✓ Operation at the workstation is designed for very quick learning process. The machine functions are marked as graphical icons – the associated function parameters are displayed additionally in the national language configured.
- ✓ Freely programmable controller
- ✓ Processing of pocket facings of all sizes
- ✓ Customised programming for stitch length
- ✓ Optional programming feature for stitch condensation or stitch locking
- ✓ Automatic seam length sensing with the help of a photocell
- ✓ Simple top-stitch width adjustment

Production Process

Program pre-selection:

The pre-programmed seam is selected on the control panel.

Working steps:

Position the front of the trouser on the mechanical stop, activate the vacuum and place the pre-stitched pocket pouch over the trouser part. Now, depending on the shape of the pocket, one or two notching cutters are switched on and the sewing part is brought with the transport clamp below the needle. After the sewing operation, the sewing part is blown off. The operator can prepare the next sewing part just after the sewing part has been accepted by the transport device and thus work in an overlapping and efficient manner.

Automatic sewing process:

The pocket facings is folded fully automatically, positioned, brought under the needle and stitched. After the sewing operation, the transport device accepts the sewing part and brings it to the end position where it is then de-stacked automatically.

Work ergonomics:

The system can be operated as a workstation either in standing or sitting position. The height of the table can be adjusted to the body height of the operator.

Performance Profile

The use of the BASS 5310 ensures an enormous gain in productivity and seam quality. Fully overlapping method of working, as well as consistent sewing results with different materials.

Sewing pockets with side seams – curved and straight shapes. Depending on the shape of the pocket opening, work is done optionally with one or two notch cutters.

The BASS 5310 is a sewing system in which all straight facings and pocket pouches can be stitched rationally and with good seam quality. All top-stitch widths can be adjusted with the help of an efficient pleat system. The program enables sewing over the entire length of the pocket pouch as well as sewing only over the length of the facings.

BASS 5310

Automatic short seamer for pocket facings and pockets (US style)

Technical Specifications

Dimensions

Length/with bundle clamp 1.600 mm
 Width 950 mm
 Height 1.300 mm

Table height

Manually adjustable from 890 mm to 1.150 mm

Weight

Basic equipment 200 kg

Compressed air

Nominal pressure 20 NI/6 bar

Power supply

Rated voltage 220V/50/60 Hz
 AC voltage 220V/50/60 Hz
 Power consumption 0,7 kWh

Sewing System

Maximum sewing speed 4500 rpm
 Stitch length 0,5-5 mm
 Needle system 134R
 Needle size 80-110 Nm

Examples of output

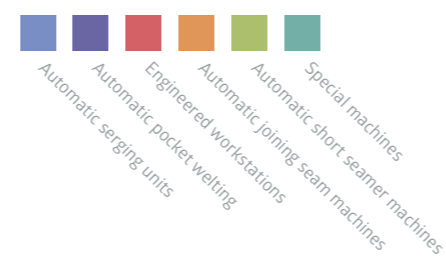
Stitching on a pocket border: 4500 seams in 8 hours,
 stitching front pockets: 2800 seams in 8 hours

Basic equipment

- Top-stitch head Brother 7200 with integrated DC positioning drive and motor controller, AC voltage 190-240 Volts, 50-60 Hz
- Electromagnetic thread cutter
- Micro-processor controller freely programmable, with LCD display and graphical user interface (GUI)
- Main chamber drive by controlled stepper motor
- Sensing the start and end of the sewing material with the help of a photocell
- Locking device for the start and end of the seam, as well as stitch condensation (optionally adjustable)
- Folding and placing station up to 350 mm edge length (max. seam length up to 450 mm)
- Small parts stacker with automatic lowering with the help of the photocell
- Needle thread monitor
- Straight clamp
- Curved clamp
- Height-adjustable frame
- Trays for pocket pouches and borders
- Memory chip
- Scissors for cutting notches

Options :

- Bundle clamp
- Vacuum pump



BASS 5400

Sewing system for stitching the left side trouser fly section



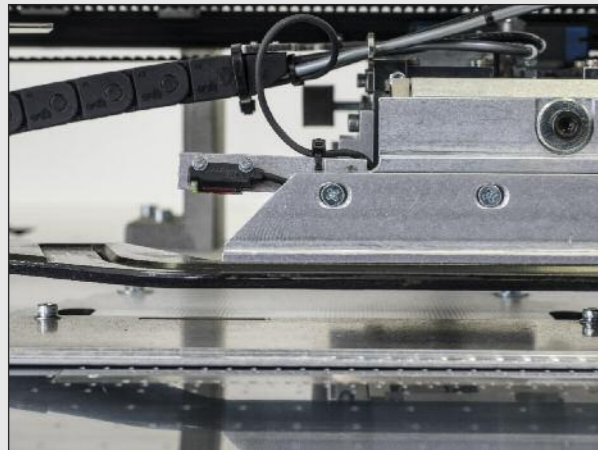
The BASS 5400 is a sewing system for stitching the left zip fly section. It is characterised by precision and efficiency equally. The seam length detection enables different fly lengths to be stitched automatic.

Advantages

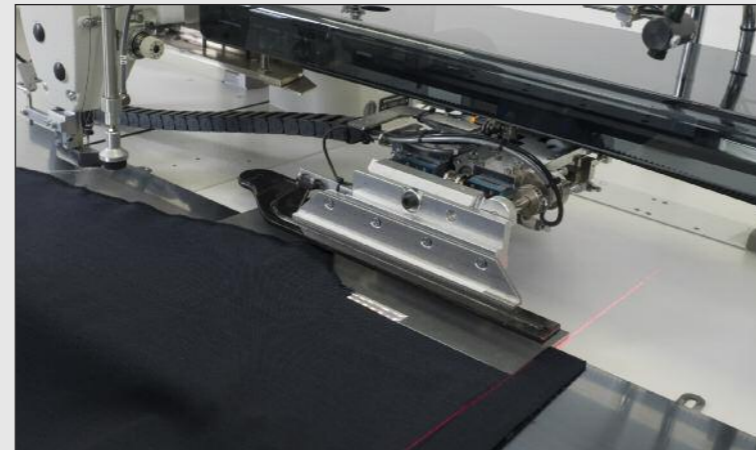
- Up to 3000 pre-ironed fly sections in 8 hours
- Freely programmable controller
- Accurate start and end of the seam

BASS 5400

Sewing system for stitching the left side trouser fly section



Automatic seam length detection by a photocell



The sewing item positioned exactly in advance by the operator is accepted by the transport clamp

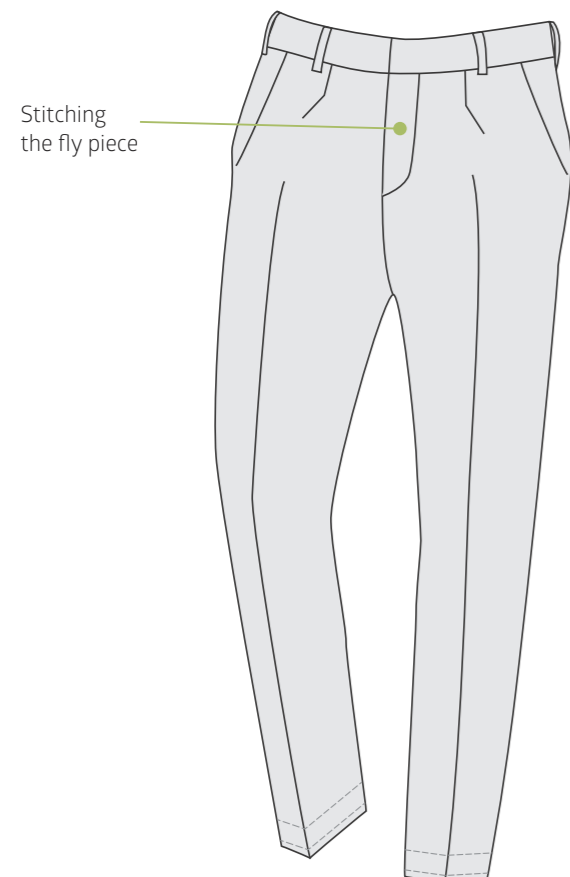


Adjustment of the stitching width using an adjusting wheel



Matching picture of the sewing program

Sample seams



An example for stitching the fly piece. The end of the seam may also lie on the waistband if the style requires this.



Advantages

- ✓ Quick learning process
- ✓ Freely programmable
- ✓ Simple operation
- ✓ Accurate start and end of the seam
- ✓ Automatic seam length adjustment
- ✓ Overlapping working method
- ✓ Maximum repeating accuracy with the help of stepper motor technology
- ✓ 4 different stitching widths that can be retrieved with the help of quick adjustment

Production Process

Program pre-selection:

The pre-programmed seams for different stitch widths are selected on the control panel, and set on the transport clamp.

Working steps:

The left front trouser with the clipped fly piece, the zip puller already drawn up and the waistline stitched previously is placed on the laser marking and held in place by triggering the vacuum. The different stitching widths can be specified by the customer (30–42 mm).

Automatic sewing process:

The transport rail matching the shape of the seam accepts the sewing item and transports it below the needle. The sewing item is stitched starting at the bend of the slot. Depending on the working method, the end of the seam lies exactly on the edge of the waist, in the waistband or on the upper edge of the waistband. The sewing item is blown off automatically at the end.

Work ergonomics:

The system must be operated as a workstation in standing position. The height of the table can be adjusted to the body height of the operator.

Performance Profile

The BASS 5400 was designed to stitch the left trouser fly piece for classical men's trousers. The operator positions the material with the help of a laser marking. The end of the seam lies exactly below the edge of the waist or on the waistband.

BASS 5400

Sewing system for stitching the left side trouser fly section

Technical Specifications

Dimensions

| | |
|--------------------------------|---------|
| Length/with bundle clamp | 1250 mm |
| Width | 1050 mm |
| Height | 1690 mm |

Table height

| | |
|--------------------------------|--------------------|
| Manually adjustable from | 890 mm to 1.150 mm |
|--------------------------------|--------------------|

Weight

| | |
|----------------------|--------|
| Basic equipment..... | 200 kg |
|----------------------|--------|

Compressed air

| | |
|-----------------------|-------------|
| Nominal pressure..... | 20 NI/6 bar |
|-----------------------|-------------|

Power supply

| | |
|------------------------|---------------|
| Rated voltage..... | 220V/50/60 Hz |
| AC voltage | 220V/50/60 Hz |
| Power consumption..... | 0,7 kWh |

Sewing System

| | |
|----------------------------|--|
| Maximum sewing speed | 5000 rpm (ex factory setting at 4200 rpm) |
| Stitch length..... | 0,5-5 mm |
| Needle system..... | 134 |
| Needle size..... | 90-110 Nm |

Examples of output

Approx. 3000 pre-ironed fly pieces

Basic equipment

- Lockstitch sewing head Brother 7200 with integrated DC motor and motor controller
- Micro-processor controller freely programmable, with LCD display and graphical user interface (GUI)
- Main clamp drive by controlled stepper motor
- Back tacking programmable on seam-start and seam end, as well as stitch condensation
- Quick adjustment for 4 variable fly widths
- Blowing device to blow off the parts
- Vacuum device prepares for connection to the own vacuum system or a vacuum pump (extra fitting)
- Laser marking (last stitch exactly on the edge of the waist)
- Needle thread monitor (bobbin thread sensor optional)
- Stitch length 285 mm (optional 345 mm)
- Height-adjustable frame
- Memory chip



BASS 5600

Sewing system for stitching wing pockets



With the BASS 5600 sewing system, you can sew wing pockets up to a length of 250 mm and with different stitching widths. The sewing system achieves maximum possible efficiency both by overlapping working method as well as by consistent sewing results with different materials.

Advantages

- Up to 2000 wing pockets in 8 hours
- Quick learning process
- Simple operation

BASS 5600

Sewing system for stitching wing pockets



Easy administration and retrieval of the pre-programmed seams and seam widths



With the help of the model-specific markings, the sewing material can be positioned accurately for the subsequent sewing process



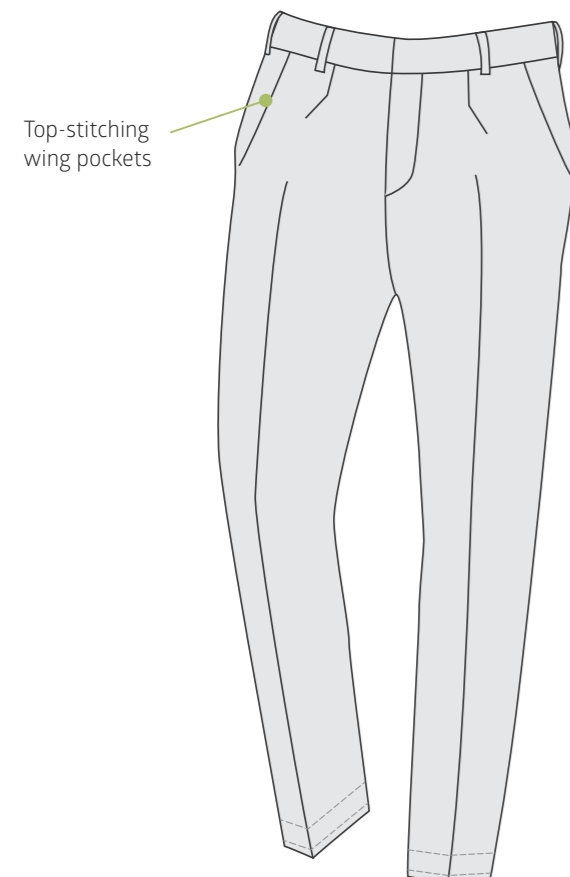
Photocells for detecting the start and end of the seam



The top-stitch widths are adjusted mechanically

Sample seams

A few examples of sewing with different seam widths are illustrated here



Advantages

- ✓ Quick learning process
- ✓ Individual stitch length programming
- ✓ Simple operation
- ✓ Seam locking or adjustable stitch condensation available as options
- ✓ 4 seam widths to choose from
- ✓ Automatic cutting and folding of the sewing material
- ✓ Freely programmable controller
- ✓ Overlapping working method

Production Process

Program pre-selection:

The pre-programmed seam is selected on the control panel. The top-stitch widths are preselected mechanically.

Working steps:

The sewing material is placed on the pre laying table. Next, scissors cuts the material and folds it. After acceptance by the transport device, the sewing material is brought to the stitching position, stitched and then blown off out of the machine by a special device.

Work ergonomics:

The system must be operated as a workstation in standing position. The height of the table can be adjusted to the body height of the operator.

Performance Profile

The use of the BASS 5600 ensures an enormous gain in productivity. Completely overlapping working method as well as consistent sewing results with different materials ensure the maximum possible effectiveness. You can adjust up to 4 different top-stitch widths. Operation at the workstation is designed for quick learning process.

The machine functions are marked as graphical icons – the associated function parameters are displayed additionally in the national language configured.

Processing wing pockets up to a length of 250 mm

BASS 5600

Sewing system for stitching wing pockets

Technical Specifications

Dimensions

Length/with bundle clamp 1.600 mm
Width..... 950 mm
Height 1.300 mm

Table height

Manually adjustable from 890 mm to 1.150 mm

Weight

Basic equipment..... 270 kg

Compressed air

Nominal pressure..... 20 NI/6 bar

Power supply

Rated voltage..... 220V/50/60 Hz
AC voltage 220V/50/60 Hz
Power consumption..... 0,7 kWh

Sewing System

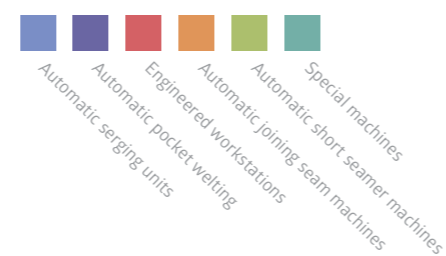
Maximum sewing speed 4500 rpm
Stitch length..... 0,5–5 mm
Needle system..... 134R
Needle size..... 80–110 Nm

Examples of output

Up to 2000 wing pockets in 8 hours

Basic equipment

- Lock stitch sewing head Brother with direct drive and motor controller, AC voltage 190–240V, 50/60Hz, with integrated thread cutter
- AC voltage 190–240 Volt, 50–60 Hz
- Electromagnetic thread cutter
- Micro-processor controller freely programmable, with LCD display and graphical user interface (GUI)
- Main clamp drive by controlled stepper motor
- Sensing the start and/or end of the sewing material with the help of a photocell
- Back tacking programmable on seamstart and seam end, as well as stitch condensation
- Needle thread monitor (bobbin thread sensor optional)
- Height-adjustable frame
- Laser for positioning the sewing material
- Folding station
- Blow-off device
- Pre laying table



BASS 5700

Sewing machine for clipping and sewing the fly pieces and pocket pieces



The BASS 5700 sewing machine is designed for small to medium size trouser production facilities. It can clip and sew the left fly piece and left pocket piece at the opening. The right fly piece can be stitched on with an additional add-on (Option).

Advantages

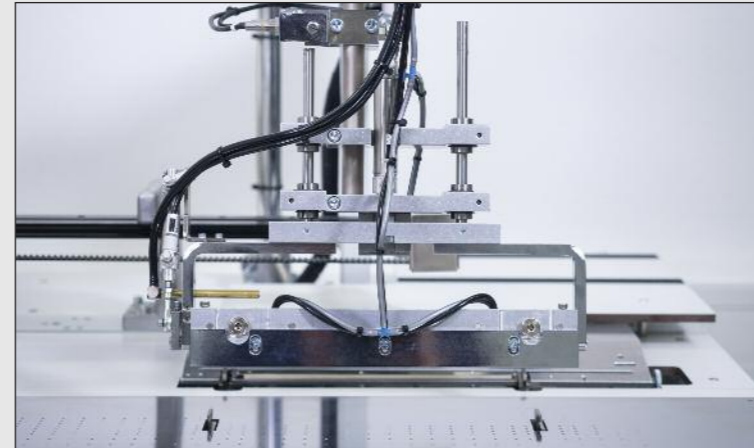
- Up to 600 complete trousers (2 x fly pieces, 2 x pocket opening)
- Flexible use for pocket opening and fly pieces
- Freely programmable controller
- Customised seam length programming
- Quick learning process
- High utilisation level of the seam length

BASS 5700

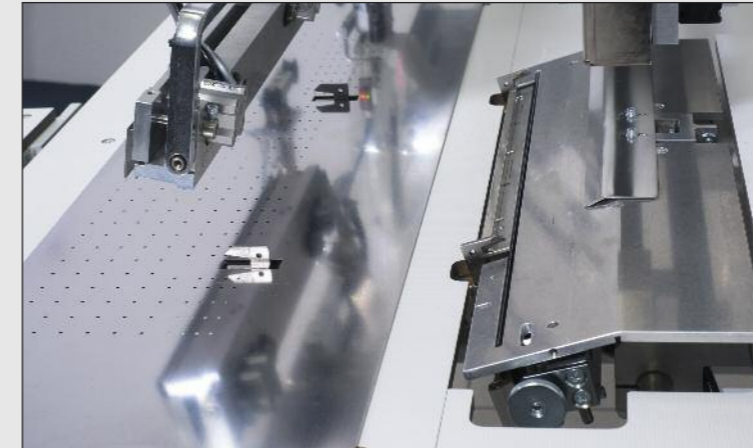
Sewing machine for clipping and sewing the fly pieces and pocket pieces



Easy administration and retrieval of the pre-programmed seams for diverse applications



Folder for holding and positioning pocket pieces and fly pieces

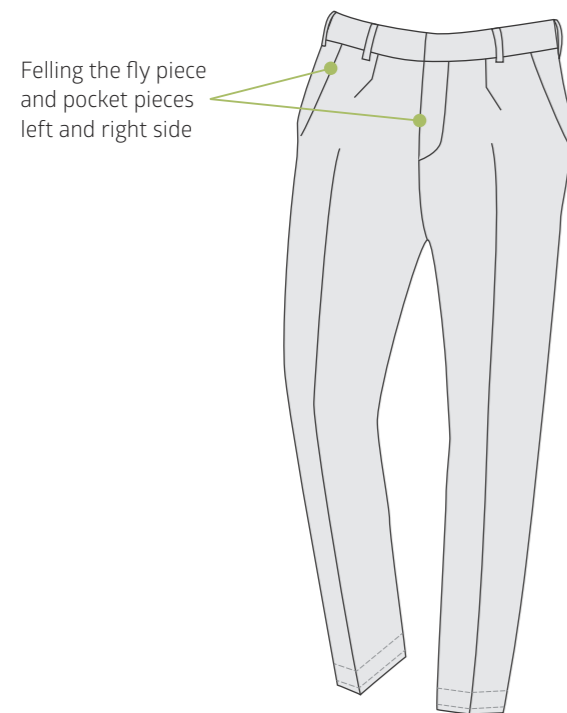


Pick-up station, folder and pneumatic scissors for cutting



Optional clamp with hold-down device

Sample seams



Felling the fly piece and pocket pieces left and right side

Pocket openings / wing pockets and the fly pieces can be felled with the BASS 5700 sewing system



Advantages

- ✓ Freely programmable controller
- ✓ Customised seam length programming
- ✓ Quick learning process
- ✓ High level of utilisation of the seam length even for small quantities
- ✓ Stitch condensation or back tacking is programmable
- ✓ Overlapping method of working possible
- ✓ Automatic seam length sensing with photocell
- ✓ Use for 2 different work steps

Production Process

Program pre-selection:

The pre-programmed seam is selected on the control panel.

Working steps:

Top-stitching the fly facing on the left side:
The front part of the trousers is fixed on the working table by the vacuum and the left fly piece is placed on the front part of the trouser by the pleating station after it is accepted. The transport device accepts the sewing material.

Top-stitch the pocket piece on the left and right sides:

The procedure is the same as that of the left fly piece.

Stitch on the right fly piece*:

After placing the front part of the trousers, the edge ruler tilts to the position of the zipper half. The zipper and fly facing are positioned and the transport device accepts the sewing material.

(*optional)

Work ergonomics:

The system can be operated as a workstation either in standing or sitting position. The height of the table can be adjusted to the body height of the operator.

Performance Profile

The BASS 5700 sewing machine is designed even for small to medium size trousers production facilities. Both pocket entries and the left side fly piece can be top-stitched on the front part of the trousers. Operation at the workstation is designed for a quick learning process. The machine functions are marked as graphical icons, and the associated function parameters are also displayed in the international language.

BASS 5700

Sewing machine for clipping and sewing the fly pieces and pocket pieces

Technical Specifications

Dimensions

Length.....1.600 mm
Width.....950 mm
Height.....1.300 mm

Table height

Manually adjustable from 850 mm to 1.150 mm

Weight

Basic equipment.....200 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage..... 220V/50/60 Hz
AC voltage220V/50/60 Hz
Power consumption.....0,7 kWh

Sewing System

Maximum sewing speed 4500 rpm
Stitch length.....0,5-5 mm
Needle system.....134
Needle size.....80-110 Nm

Examples of output

Up to 600 complete trousers (2 x fly pieces, 2 x pocket opening)

Basic equipment

- Lockstitch sewing head Brother 7200 with integrated DC positioning drive and motor controller,
- AC voltage 190-240 Volt, 50/60 Hz
- Electromagnetic thread cutter device
- Microprocessor controller freely programmable, with LCD display and graphical user interface (GUI)
- Folding and placing station (up to 318 mm fly piece length)
- Sensing the start and end of the sewing material smoothly and continuously by photocell
- Back tacking programmable for seam start and seam ending, as well as stitch condensation (optionally adjustable)
- Automatic cutting notches for the trouser part and the fly piece
- Vacuum device (for faster positioning of the sewing material) prepared for connection to the in-house vacuum system or vacuum pump
- Needle thread monitoring (bobbin thread monitoring as an option)
- Automatic blowing off of the parts at the end of the seam
- Height adjustable frame

Options:

- Supplementary transport clamp
- Movable ruler guide for sewing right side fly piece



BASS 5800

Sewing system for felling and sewing the fly pieces, pocket facings and wing pockets



The sewing system BASS 5800 is designed for small to medium size trouser production facilities. Beside felling pocket facings on pocket pouches, the left fly piece can be felled and the right fly piece can be felled on, and even the right and left pocket facings can be felled at the opening.

Advantages

- Up to 480 complete trousers (2 x fly piece, 4 x pocket facings)
- Flexible use for pocket opening, fly pieces and pocket facings
- High utilisation level of the sewing system

BASS 5800

Sewing system for felling and sewing the fly pieces, pocket facings and wing pockets



Easy administration and retrieval of the pre-programmed seams for diverse applications



Folder for holding and positioning borders and fly pieces



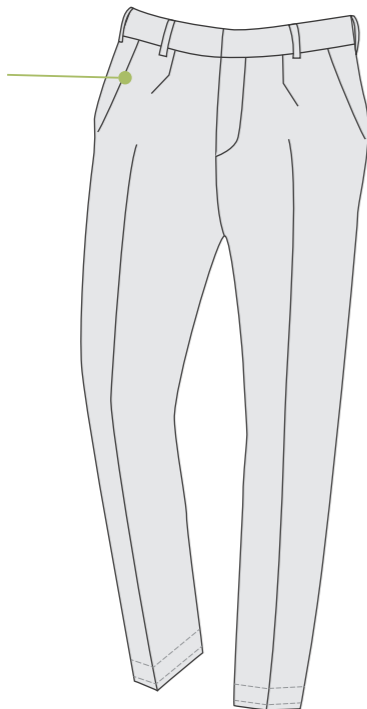
Retracted ruler for placing the zipper and fly piece



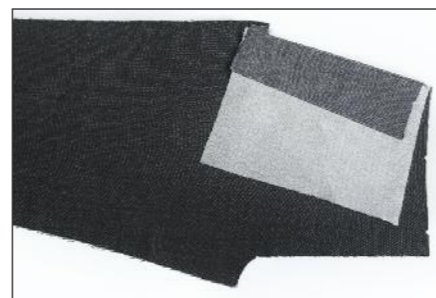
Automatic stacker for pocket pouches

Sample seams

Incorporating pocket openings, fly pieces and facings on pocket pouches



Three different work steps can be done efficiently and with high seam quality on BASS 5800.



Advantages

- ✓ Freely programmable controller
- ✓ Processing of pocket facings of all sizes
- ✓ Customised seam length programming
- ✓ Quick learning process
- ✓ High level of utilisation of the sewing system even for small quantities
- ✓ Stitch condensation or seam locking is programmable
- ✓ Overlapping method of working possible
- ✓ Automatic seam length sensing with photocell
- ✓ Use for three different work steps

Production Process

Program pre-selection:

The pre-programmed seam is selected on the control panel.

Working steps:

Top-stitch the facing:
After picking up the facings, the pleating operation is initiated automatically and then placed on the pocket pouch. Now the transport unit moves it further to the needle. After sewing, the sewing material gets brought to the stacking position.

Felling the fly facing on the left side:

The front side of the trousers is fixed on the working table by the vacuum and the left fly piece is placed on the front part of the trouser by the pleating station after it is accepted. The transport unit accepts the sewing piece.

Felling the pocket piece on the left and right sides: The procedure is the same as the left fly piece.

Stitch on the right fly piece:

The front of the trouser is placed, the edge ruler is retracted to place the zipper half and the fly facing, the zipper and the fly facing are positioned and the main clamp and moves it towards the needle.

Performance Profile

The productivity of the system is enhanced with consistently high quality by the option of top-stitching pocket facings, pocket opening and also felling fly pieces.

Operation at the workstation is engineered for quick learning process.

The machine functions are marked as graphical icons – the associated function parameters are displayed additionally in the national language configured.

Work ergonomics:

The system can be operated as a workstation either in standing or sitting position. The height of the table can be adjusted to the body height of the operator.

Technical Specifications

Dimensions

Length/with bundle clamp 1600 mm
 Width 950 mm
 Height 1.300 mm

Table height

Manually adjustable from 850 mm to 1.150 mm

Weight

Basic equipment 200 kg

Compressed air

Nominal pressure 20 NI/6 bar

Power supply

Rated voltage 220V/50/60 Hz
 AC voltage 220V/50/60 Hz
 Power consumption 0,7 kWh

Sewing System

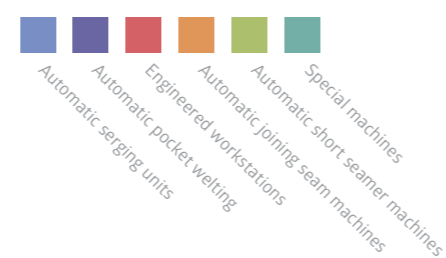
Maximum sewing speed 4500 rpm
 Stitch length 0,5-5 mm
 Needle system 134R
 Needle size 80-110 Nm

Examples of output

Up to 480 complete trousers (2 x fly piece, 4 x pocket facings)

Basic equipment

- Lockstitch sewing head Brother with direct drive and motor controller, AC voltage 190-240V, 50/60Hz, with integrated thread cutter
- AC voltage 190-240 Volt, 50-60 Hz
- Electromagnetic thread cutting device
- Micro-processor controller freely programmable, with LCD display and graphical user interface (GUI)
- Folding and placing station (up to 318 mm fly piece length)
- Variable length selection
- Sensing the start and end of the sewing material with the help of a photocell
- Back tacking programmable on seamstart and seam end, as well as stitch condensation
- Small parts stacker
- Automatic cutting notches for the trouser part and the fly piece
- Vacuum device prepares for connection to own vacuum system or vacuum pump
- Needle thread monitor (bobbin thread sensor optional)
- Automatic blowing off of the parts at the end of the seam
- Laser beam marking light
- Height-adjustable frame



BASS 5900

Sewing system for single-tip and double-tip bust and back darts



Darts and pleats appear to be simple seams at first sight, but they have a great impact on the fitting shape of shirts and blouses. One basic problem with these seams is that the sewing part is placed over a blade. In doing so, the sensitive materials (stretch, among others) are stretched and drawn. This has an unfavourable impact on the sewing result. In order to counter this problem, the company ASS has developed the automatic short seamer BASS 5900.



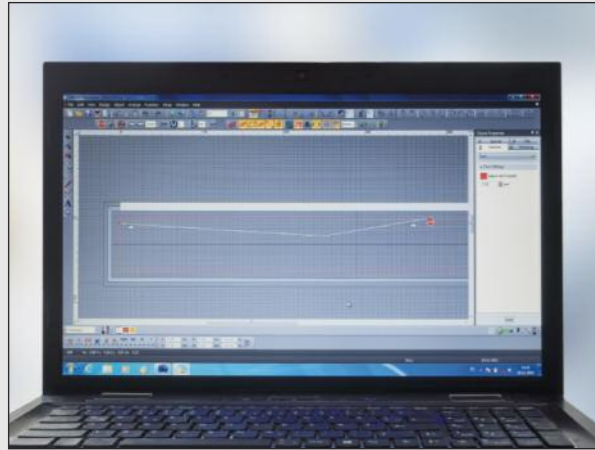
SPECIAL MACHINES



- Automatic serging units
- Automatic pocket welting
- Engineered workstations
- Automatic joining seam machines
- Automatic short seamer machines
- Special machines

Advantages

- High productivity: 5-6 darts/min. with a seam length of 400 mm and a sewing speed of 4000 rpm.
- Simple operation – Quick learning process
- Easiest creation and administration of the stitching programs on the PC with machine-specific operator software
- There are almost no limits for the shape of the darts thanks to the X-Y controller
- All types of stitches can be processed without changing over the machine and merely by changing the program



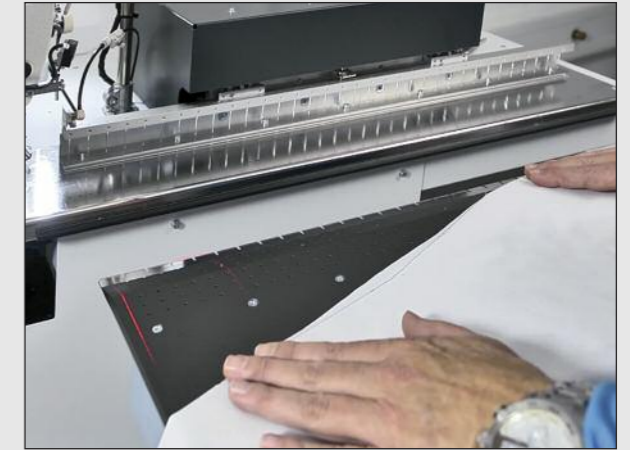
Simple creation and administration of the stitching programs on the PC with machine-specific operator software



Positioning of the sewing part on the marking lights of the pre-laying station



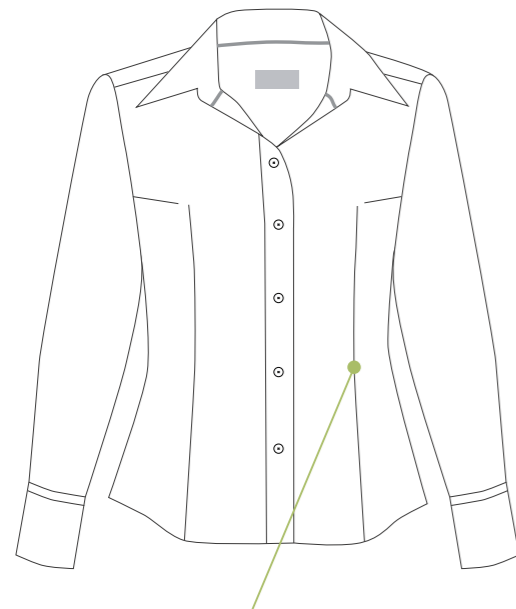
Automatic de-stacking of the sewed parts



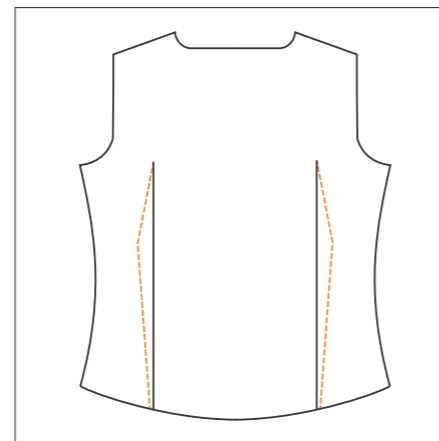
Accurate stitching on the tip of the dart (no cone formation)

Sample seams

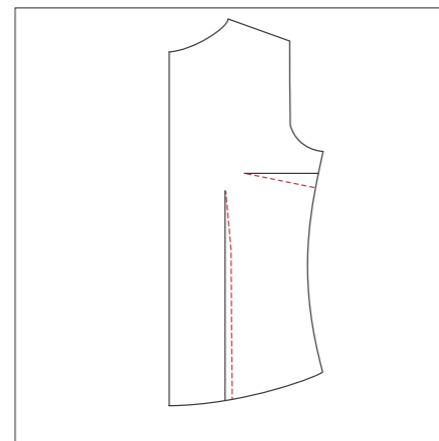
A few examples of the use of the BASS 5900 are illustrated here.



Waistline dart for ladies blouse



Single tip, waist dart for blouses, running out in the seam



Waist dart, single tip or double tip, as well as bust dart at the front of the blouse

Advantages

- ✓ Prompt positioning and fixing of the sewing material on the pre laying station with the help of a vacuum
- ✓ Three programmable marking lights for exact and clear positioning of the sewing part on the pre laying station
- ✓ Accurate stitching with stitch condensation over the dart tip (no cone formation)
- ✓ Overlapping working method / 4-5 seams per minute, without tack seam
- ✓ Simple operation, and as a result, quick learning process
- ✓ There are almost no limits for the shape of the darts thanks to the X-Y controller
- ✓ All types of stitches can be processed without changing over the machine and merely by changing the program
- ✓ Easiest creation and administration of the stitching programs on the PC with machine-specific operator software
- ✓ Micro-processor controller with integrated USB slot and a memory capacity of 60 stitches
- ✓ Consistently good quality even with difficult materials

Production Process

The use of the BASS 5900 ensures an enormous gain in productivity and seam quality. Overlapping method of working, as well as consistent sewing results with different materials.

Program pre-selection:

The pre-programmed seam is selected on the control panel.

Manual working steps:

Three marking lights ensure accurate positioning of the sewing part on the pre laying station.

Automatic sewing process:

The pre laying station with the sewing part positioned and fixed by vacuum moves to the transfer station. This accepts the sewing part and moves to the programmed dart depth (controlled stepper motor, programmable in 0.1 mm steps). Now the clamp accepts the sewing part (X-axis) and feeds it to the sewing head (Y-axis).

Automatic sewing of the programmed darting machine:

At the end of the seam, the clamp brings the sewing part to the stacking position where the de-stacking operation takes place. During the stitching, the next sewing part can be positioned on the pre laying table. This moves in after reaching a specific clamping position. This provides completely overlapped working method.

Performance Profile

The BASS 5900 is a sewing system on which darts can be darted rationally and with consistently good quality. There are almost no limits for the shape of the darts thanks to the X-Y controller. All shapes of seams can be processed without changing over the machine and merely by changing the program.

Work ergonomics:

The system must be operated as a workstation in standing position. The height of the table can be adjusted to the body height of the operator.

BASS 5900

Sewing system for single-tip and double-tip bust and back darts

Technical Specifications

Dimensions

Length/with bundle clamp 2100 mm
Width..... 1.100 mm
Height 1.400 mm

Table height

Manually adjustable from 890 mm to 1.150 mm

Weight

Basic equipment.....310 kg

Compressed air

Nominal pressure.....20 NI/6 bar

Power supply

Rated voltage..... 220V/50/60 Hz
AC voltage220V/50/60 Hz
Power consumption.....0,7 kWh

Sewing System

Maximum sewing speed 4500 rpm
Maximum seam length..... 570 mm
Maximum seam depth..... 50 mm
Stitch length.....0,5-5 mm
Needle system.....134
Needle size.....70-100 Nm

Examples of output

5-6 darts per min. with a seam length of 400 mm and a sewing speed of 4000 rpm.

Basic equipment

- Lockstitch sewing head Brother with direct drive and motor controller, AC voltage 190-240 Volt, 50/-60 Hz, with integrated thread cutter
- Micro-processor controller with LCD display and USB slot
- Pre laying station with integrated vacuum
- Transfer station, movable with controlled stepper motor
- X-axis drive (clamp transport) with controlled stepper motor
- Y-axis drive (movable sewing head) with controlled stepper motor
- Stacker
- Additional rotary device for de-stacking narrow sewing parts
- Needle thread monitor with bobbin thread counter
- Height-adjustable frame
- Machine-specific operator software for creating and administering sewing programs

Options:

- Vacuum pump



BASS 5950

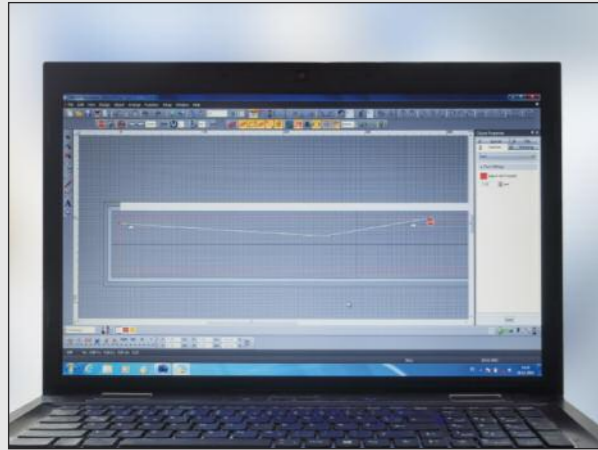
Automatic short seamer for waist pleats and darts



Darts and pleats appear to be simple seams at first sight, but they have a great impact on the fitting shape of trousers, skirts and blouses as well as on the location of the piped pocket on the rear side of trousers. One basic problem with these seams is that the sewing part is placed over a blade. In doing so, the sensitive materials (stretch, among others) are stretched and drawn. This has an unfavourable impact on the sewing result. In order to counter this problem, we have developed the automatic short seamer BASS 5950.

Advantages

- High productivity: 14-16 seams/minute (without tack seam)
- Simple operation – quick learning process
- Easiest creation and administration of the stitching programs on the PC with machine-specific operator software
- There are almost no limits for the shape of the darts thanks to the X-Y controller
- All types of stitches can be processed without changing over the machine and merely by changing the program



Simplest preparation and administration of the sewing programs on the PC with machine-specific operator software



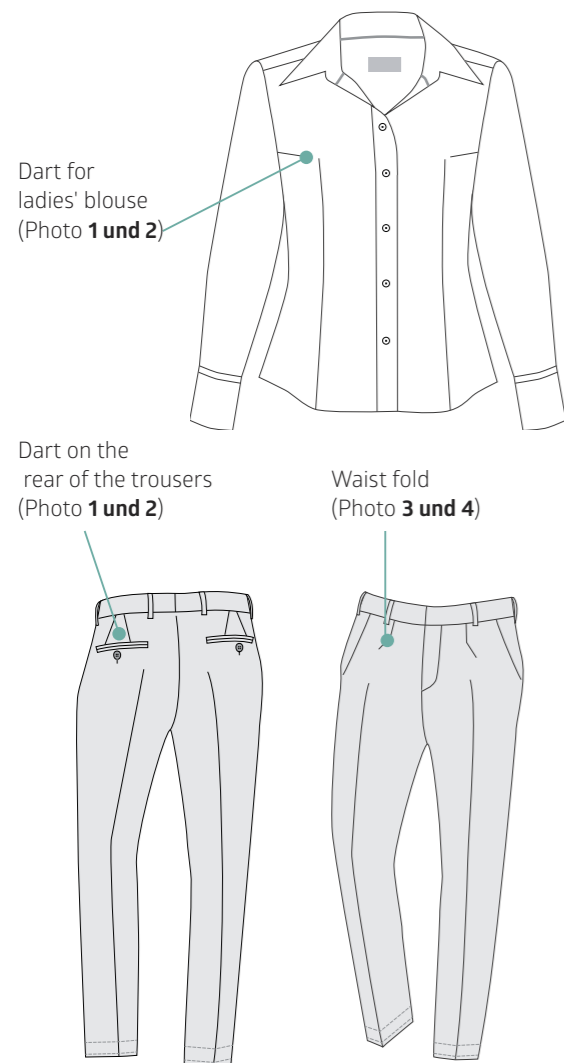
Placing the sewing part on the marking lights of the pre laying station. Fixing it with a vacuum



Acceptance and sewing the programmed darting machine with the X-Y controller



Accurate stitching on the dart tip (no cone formation)



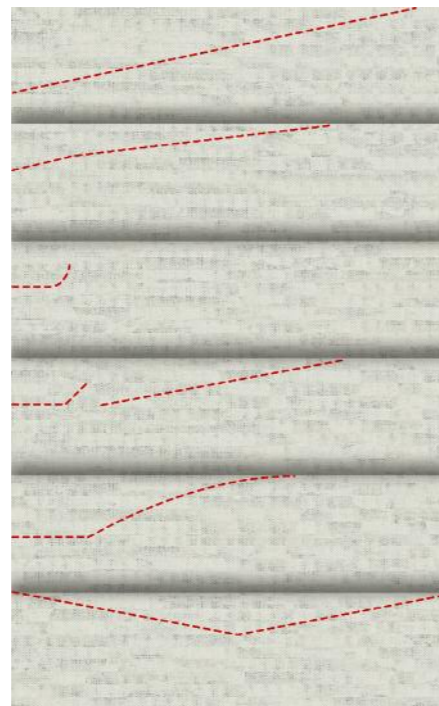
Dart for ladies' blouse (Photo 1 und 2)

Dart on the rear of the trousers (Photo 1 und 2)

Waist fold (Photo 3 und 4)

Sample seams

This is only a small selection of sample seams. With the machine-specific operator software in conjunction with the newly developed X-Y controller, there are almost no limits as far as the shape of the waist folds and darts are concerned.



- 1 Single tip dart (rear side of the trousers, ladies' blouse) with straight end of the tip
- 2 Single tip shaped dart (rear of the trouser, ladies' blouse) with mild run-out
- 3 Waist fold (open or closed)
- 4 Waist fold with tacked seam for better ironing of the pleat
- 5 Shaped darts for ladies' trousers and skirts with a cut waistline
- 6 Two-tipped dart

Advantages

- ✓ Prompt positioning and fixing of the sewing material on the pre laying station with the help of a vacuum
- ✓ Three programmable marking lights for accurate and clear positioning of the sewing parts on the pre laying station
- ✓ Accurate stitching with stitch condensation over the tip of the dart (no cone formation)
- ✓ Overlapping working method, 14–16 seams per minute, without a tacked seam
- ✓ Simple operation – quick learning process
- ✓ There are almost no limits for the shape of the darts thanks to the X-Y controller
- ✓ All types of seams can be processed without changing over the machine and merely by changing the program
- ✓ Easiest creation and administration of the stitching programs on the PC with machine-specific operator software
- ✓ Micro-processor controller with integrated USB slot and a memory capacity of 60 stitches
- ✓ Consistently good quality even with difficult materials

Production Process

The use of the BASS 5950 ensures an enormous gain in productivity and seam quality, and overlapping working method as well as consistent sewing results with different materials.

Program pre-selection:

The programmed seam is selected on the control panel.

Manual working steps:

Three marking lights ensure exact positioning of the sewing part on the pre laying station.

Automatic sewing process:

The pre laying station with the sewing part positioned and fixed by vacuum moves to the transfer station. This accepts the sewing part and moves to the programmed dart depth (controlled stepper motor, programmable in 0.1 mm steps). The clamp (X-axis) now takes over the sewing part and feeds it to the stitching head (Y-axis).

At the end of sewing, the sewing part is blown off. During the sewing process, the next sewing part can be positioned on the pre laying table. It moves in automatically after the blow-off operation. This provides completely overlapping working method.

Performance Profile

The BASS 5950 is a sewing system on which darts can be stitched rationally and with consistently good seam quality. Due to the X-Y controller, there are almost no limits for the shape of the darts.

All shapes of seams can be processed without retrofitting the machine by changing the program. The operation of the workstation is oriented for a very quick learning process.

Work ergonomics:

The system must be operated as a workstation in standing position. The height of the table can be adjusted to the body height of the operator.

Technical Specifications

Dimensions

Length/with bundle clamp 1.300 mm/1.700 mm
 Width 1.100 mm
 Height 1.400 mm

Table height

Manually adjustable from 890 mm to 1.150 mm

Weight

Basic equipment 270 kg

Compressed air

Nominal pressure 20 NI/6 bar

Power supply

Rated voltage 220V/50/60 Hz
 AC voltage 220V/50/60 Hz
 Power consumption 0,7 kWh

Sewing System

Maximum sewing speed 4500 rpm
 Maximum seam length 250 mm/optional 300 mm
 Maximum seam depth 50 mm
 Stitch length 0,5-5 mm
 Needle system 134
 Needle size 70-100 Nm

Examples of output

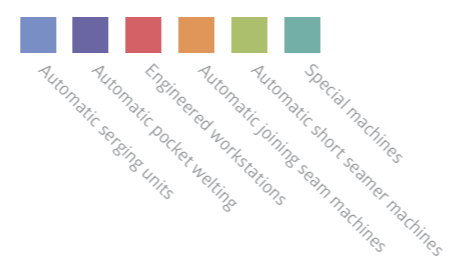
14-16 seams per minute (without tacked seam)

Basic equipment

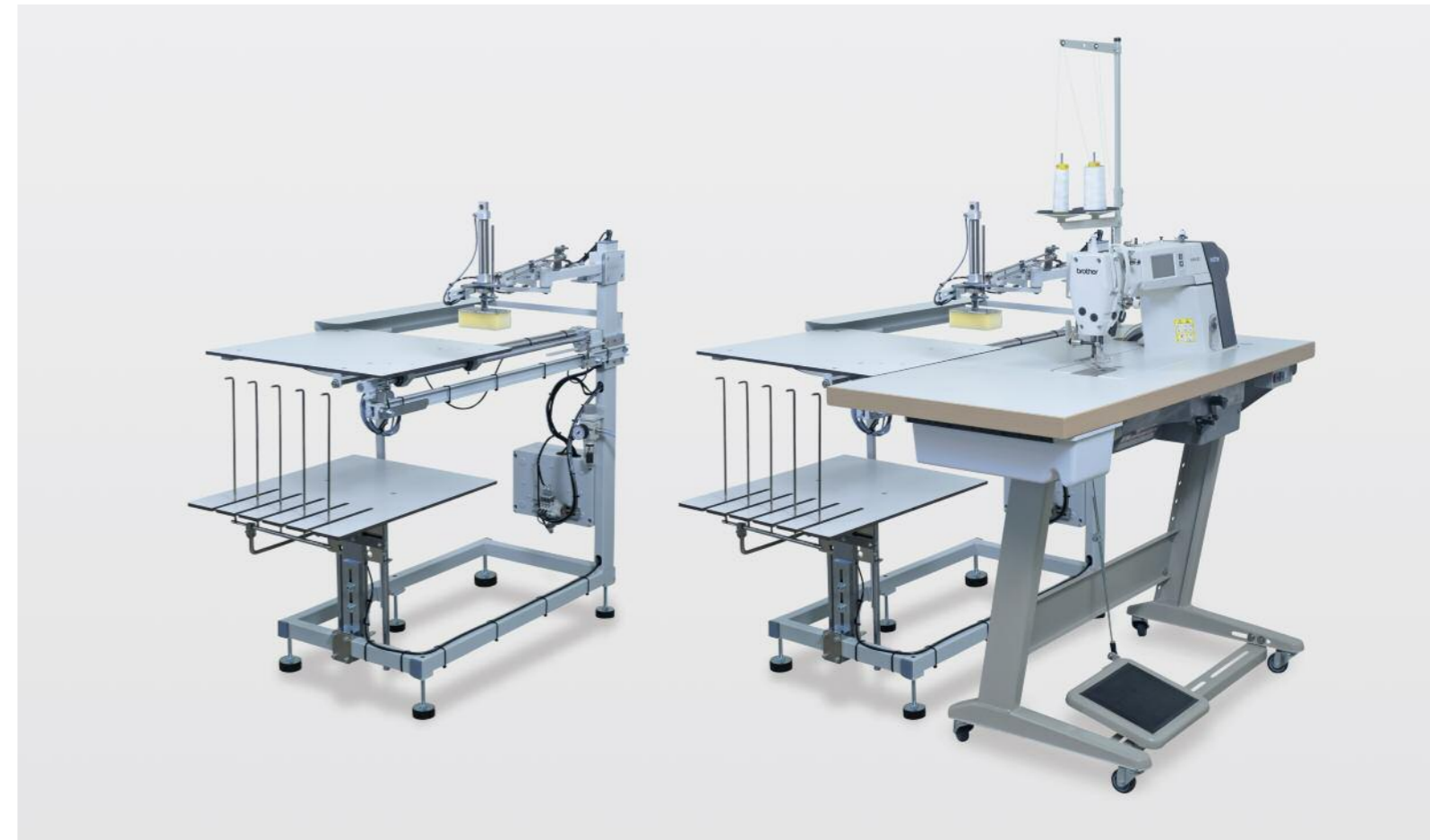
- Lock stitch sewing head Brother with direct drive and motor controller, AC voltage 190-240 Volt, 50/60 Hz, with integrated thread cutter
- Micro-processor controller with LCD display and USB slot
- Pre laying station with integrated vacuum
- Transfer station, movable with controlled stepper motor
- X-axis drive (clamp transport) with controlled stepper motor
- Y-axis drive (movable sewing head) with controlled stepper motor
- Bundle clamp
- Blow-off unit
- Needle thread monitor with bobbin thread counter
- Height-adjustable frame
- Machine-specific operator software for creating and administering sewing programs

Options:

- Vacuum pump
- Sewing clamp for seams up to 300mm



SPECIAL EQUIPMENT



Stacker Type 400/41

- enormous time saving
- higher operator performance
- proper bundle for further processing

The stacker 400/41 can be put on to all common sewing machines. Only a compressed air connection is necessary. Depending on the customer's requirements, the stacker can be triggered by a hand switch, knee switch, sensor or by the reverse pushed pedal.

Dimensions

Length 1.400 mm
Width 1.580 mm
Height 1.150 mm

Table height

Manually adjustable from 760 mm to 830 mm

Weight

Basic equipment 30 kg

Compressed air

Nominal pressure 20 NI/6 bar



Stacker Type 201/7

- enormous time saving
- higher operator performance
- proper bundle for further processing

The stacker 201/7 can be put on to all common sewing machines. Only a compressed air connection is necessary. Depending on the customer's requirements, the stacker can be triggered by a hand switch, knee switch or by the reverse pushed pedal.

Dimensions

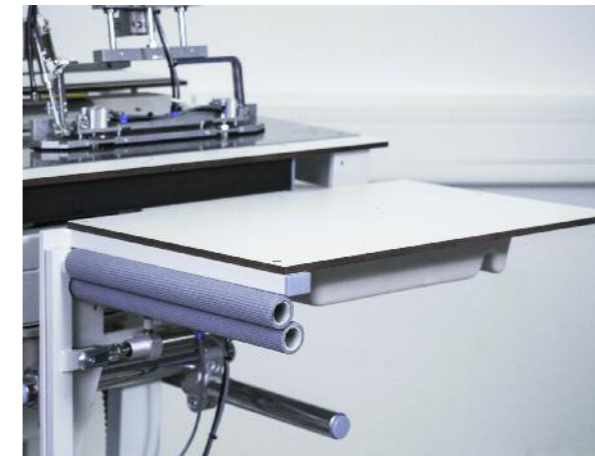
Length 1.100 mm
 Width 960 mm
 Height 940 mm

Weight

Basic equipment 40 kg

Compressed air

Nominal pressure 20 NI/6 bar



Pneumatic bundle clamp Type 500

Independent bundle clamp for standard workplaces and engineered workstations.

With the pneumatic bundleclamp Type 500 the depending operation will be optimized. Bundles are fixed for working in waterfall princip. Saving time for sewing piece handling, and a proper bundle, and higher operator efficiency is the result when using this bundle clamp.

Dimensions

Length 500 mm
 Width 380 mm
 Height 320 mm

Compressed air

Nominal pressure 20 NI/6 bar



Universal contour guide

Zippy-Guide for accurate seam widths, adjustable for thickness of fabrics and variable seamwidth – transversally movable with knee switch.

Universal contour guide is a pneumatic edge guide for precise seam widths, individually adjustable. Likewise, the edge guide can be adapted to differently strong material. The transversal guide is activated or deactivated by means of the supplied knee switch. Depending on the customer's requirements, the contour guide can be triggered by hand, knee switch, sensor or by the pedal. The current version is suitable for mounting on all common block machines.

Dimensions

Length 210 to 260 mm
 Width 80 mm
 Height 45 mm

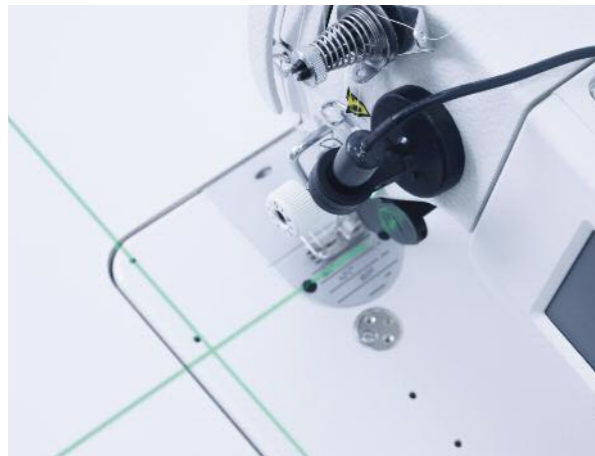
Compressed air

Nominal pressure 20 NI/6 bar



Positioning light (cross light)

Individual positioning light for all types of sewing machines. Due to the magnetic holder, requested position can be individually changed. The green colored light-cross can be used instead of marking manually with chalk or pencil, to fix seam start, or label positions, slit length and many other purposes. So handling- and process times will be reduced. Available as single light with power supply of 220V/ 56/60Hz. Optionally we supply a twin power supply for connection of two marking lights. (12/24 V power supply on demand)





More than 6,000 sewing machines worldwide

Since the year 2000, we develop and produce automatic sewing systems for the HAKA and DOB production and market them all over the world. Among others, our range of products include automatic piping pocket, closing seam and serging units as well as designed workplaces.

Ranging from the development and construction right up to installation and programming, we complete all work steps in our company in Germany. In this manner, we can ensure uniform and consistently high quality in all stages of production.

Our sewing systems provide functional and process-optimised solutions. We develop small quantities of special machines for specific customer requirements. We shall be pleased to prepare a unique offer even for you.



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