

Technical Specifications

Dimensions

Length	1650 mm
Width	800 mm
Height	1300 mm

Table height

Manually adjustable from	850 mm to 1.150 mm
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Weight

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

Compressed air

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



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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 engineered workstation

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.



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



BASS 3204Z

Sewing system for pocket openings with integrated endless zipper



Automatic zip fastener extraction device



Laser markings indicate the exact pocket pouch position



Stepper motor-controlled fleece feed



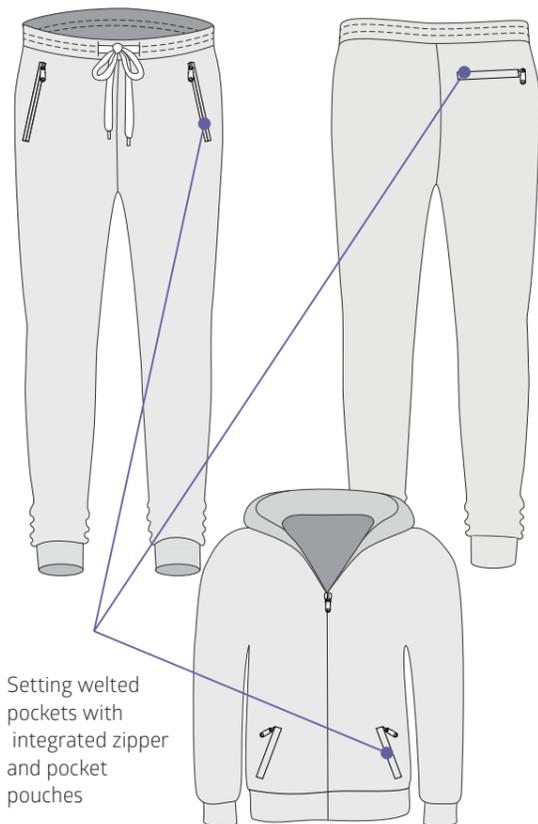
Cutter block with stepper motor drive



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.