

BASS 3504

Sewing system for
pocket openings

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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.....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



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.

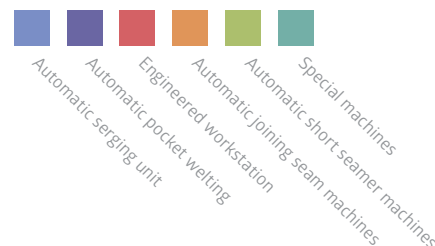
Advantages

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



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



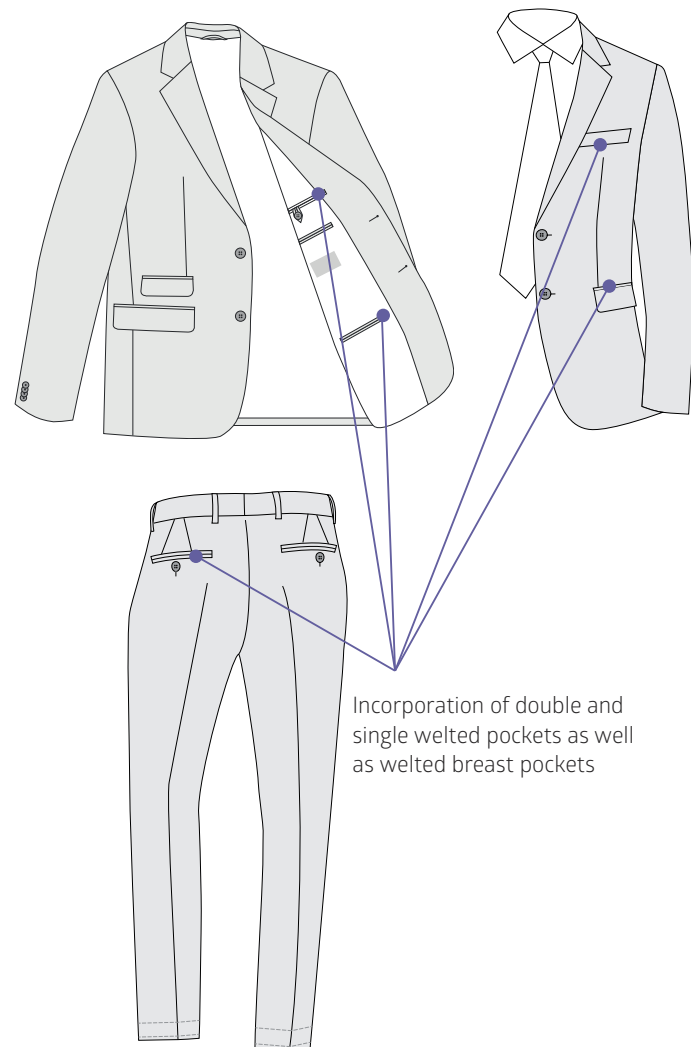
Accurate positioning by the 8 position lamps (3 optional)



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