

# BAS-326H-484

220mm x 100mm

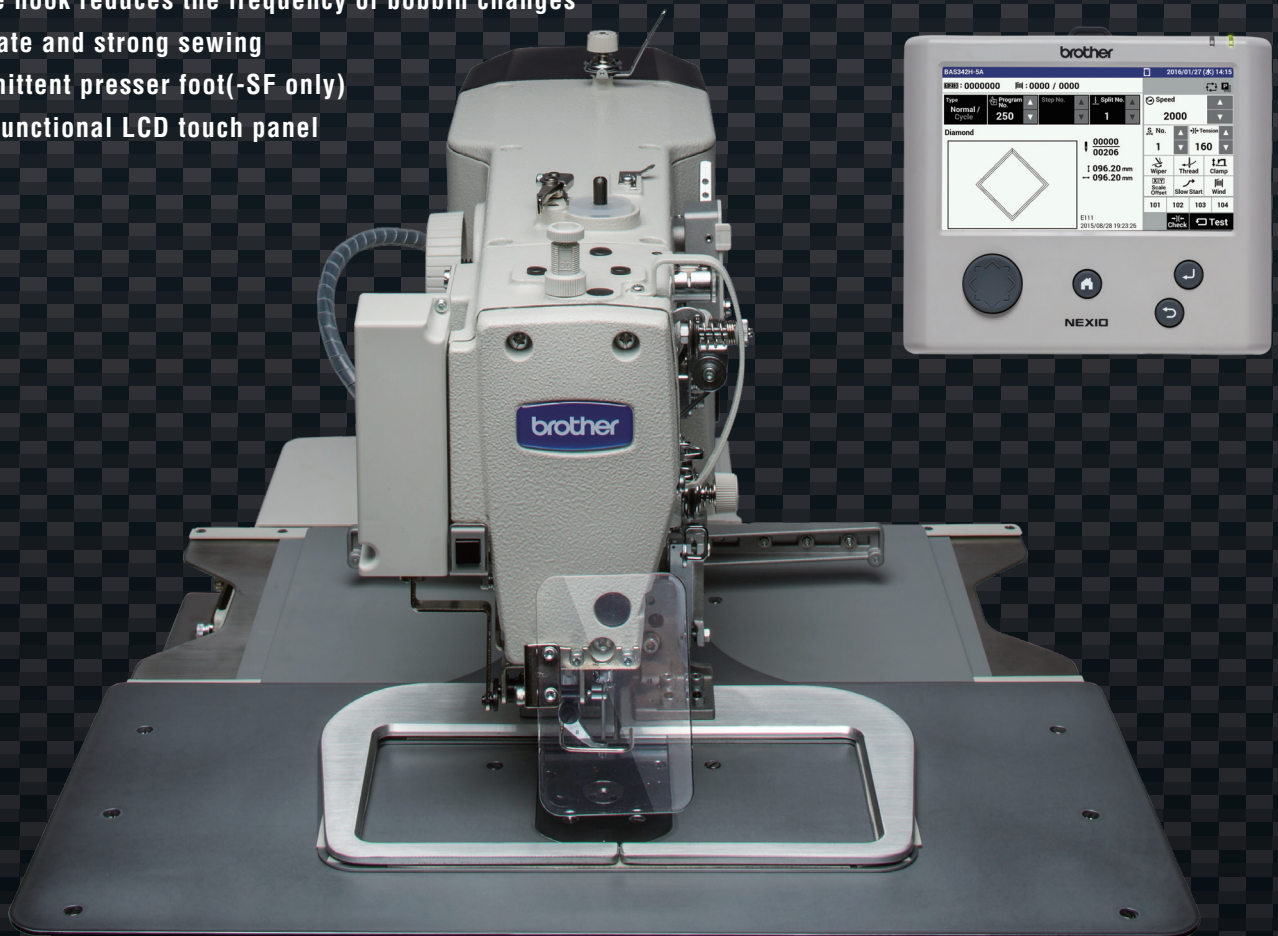
# BAS-326H-484SF

220mm x 100mm

**Direct Drive Programmable Electronic Pattern Sewing Machine  
with Cylinder Bed and rotary hook**

With the enlarged sewing area, the machine brings accurate and strong sewing for heavy and extra-heavy materials. The high functional LCD touch panel that offers easy programming, helps to reduce the preparation time.

- Treble hook reduces the frequency of bobbin changes
- Accurate and strong sewing
- Intermittent presser foot(-SF only)
- High functional LCD touch panel



# NEXIO

# Superior Quality and High Speed

With the enlarged sewing area, the machine brings accurate and strong sewing for heavy and extra-heavy materials. The high functional LCD touch panel that offers easy programming and helps to reduce the preparation time.

## 1 Accurate and strong sewing even for extra-heavy materials

### Exceptional stitch quality

The use of the advanced controlled, heavy duty feed mechanism provides excellent, superb stitch quality and tight stitching even for extra-heavy sewing applications. Also, the upper thread feeding device which supplies the necessary length of upper thread at the start of sewing, preventing the thread from pulling-out regardless of the material feeding amount.



six-ply sewing for seatbelt

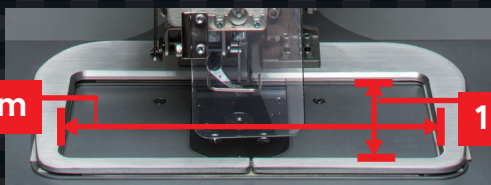
### Accurate thread wiper and thread cutting by pneumatic cylinders (optional heat cutter)

The thread wiper and thread cutting mechanism are driven by pneumatic cylinders. The upper thread can be wiped accurately even under conditions where the thread is difficult to pull out of the material. The strong air pressure allows extra thick threads to be cut accurately and consistently.

## 2 Sewing Area is Enlarged to 220mmx100mm

The sewing area is enlarged to 220mmx100mm, compared to the previous model.

It is suitable not only for seatbelt sewing but also for webbing materials.



## 3 Treble Hook Equipped

Treble hook is equipped as standard so that the frequency of bobbin changes can be reduced, leading to productivity enhancement.

## 4 Great Needle Penetration

Powerful motor(550W) outputs large amounts of torque even at slow speeds so that strong needle penetration force can be obtained. If the needle penetration resistance increases, vibration control (intermittent impact) automatically increases the penetration force.

## 5 Wide Range of Application with Intermittent Presser Foot (-SF only)

Presser foot presses needle area steadily while sewing, preventing skipped stitches, thread breakage and needle breakage. It enables the use for a wide range of applications even loose materials.

By setting a suitable height of the presser foot for the thickness of the material, excessive or insufficient pressing by the presser foot can be prevented, enabling a finish with uniform thread tightening.







## 6 Best User Experience with LCD Touch Panel

7-inch large screen and easy programming functions via LCD touch panel enable an intuitive operation. It is easy to understand in a few steps without the instruction manual or previous experience.

### Sewing Pattern Outline Edit

The outline of the sewing pattern can be adjusted, to assure an easy program editing.

### Jog Key (Brother Only)

Direction can be controlled by the jog key. You can feel the touching so it is useful when creating the programs and adjusting the needle position while checking the needle point.



### Memory Switch Settings

The detail of Memory switch settings can be checked on the panel without the manuals.

Settings Memory Switch		
001: Work clamp lift timing after sewing is complete		[12]
002: Work clamp drop operation		[12]
100: Sewing start speed		ON
300: Single-stitch test feed		OFF
400: Detailed settings sewing condition		OFF
403: Select split mode		[10]
407: Program No. assigned to the F1 key		[10]
		OK

### Error Message Display

When an error occurs, the error message and solution are displayed on the panel.

<b>E025</b>
The foot pedal was being depressed to the 2nd step (For 2, 3 pedal, start switch was being depressed) when power was turned on. Release foot from the pedal or switch. (Subcode = 1)

## Specifications /

# BAS-326H-484 / BAS-326H-484SF (with Intermittent Presser Foot)

	BAS-326H-484	BAS-326H-484SF
Stitch form	Single needle lock stitch	
Max. sewing speed	2,200 sti/min	
Max. sewing are (X x Y)	220 x 100mm	
Feed mechanism	Intermittent feed, pulse motor drive	
Stitch length	0.05 -12.7mm	
Max. No. of stitches	20,000 stitches (per program)	
No. of sewing data items that can be stored	999(Internal memory, SD card, USM memory)*	
Work clamp lift method	Pneumatic cylinder method, Separate-type work clamp	
Work clamp height	Max. 27.5mm	
Intermittent presser foot lift amount	19.5mm	
Intermittent presser foot stroke	2-4.5mm, 4.5mm-10mm or 0(Default setting 3mm)	
Hook	Treble hook	
Wiper device	Standard equipment	
Thread trimmer	Standard equipment	
Thread take-up lever	Standard equipment	
Thread breakage detector	Standard equipment	
Cycle programs	30	
Motor	AC servo motor, 550W	
Weight	Machine head approx.88kg, LCD panel approx. 0.8kg, Control box 9kg(differs depending on desitination)	
Power	Single-phase 110V / 220V / 230V, 3-phase 220V / 380V / 400V (For single-phase 100V and 3-phase 380V / 400V, the trans box is required)	
Air pressure / Consumption	0.5MPa 1.8l/min	

\* The number of data items and stitches that can be stored will vary depending on the number of stitches in each program. No guarantees of operation can be given for any media.



**RoHS  
Compliant**

BAS-326H-484/484SF is compliant with the RoHS Directive(the restriction of the use of certain hazardous substances in electrical and electronic equipment) which came into effect in the EU in July 2006.



Brother has established voluntary environmental standards for products and created the "Brother Green Label". BAS-326H-484/484SF is certified as an environment-conscious sewing machine according to the "Brother Green Label" standard.



Please read instruction manual before using the machine for safety operation.

-Product specifications are subject to change for improvement without notice.

-Photographs are for illustration purpose. They may not represent actual operating conditions and may display optional parts.

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