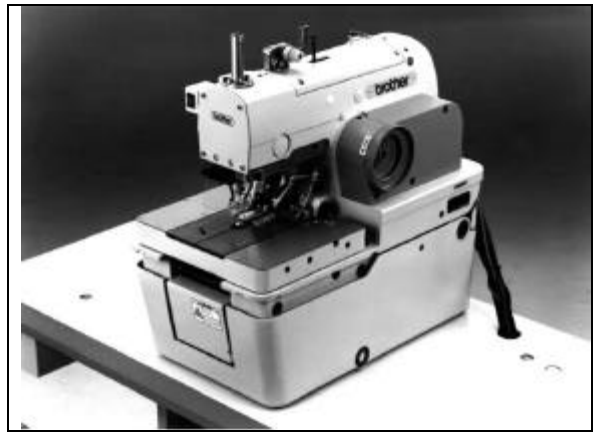


# DH4-B981

## Electronic Eyelet Button Holer



### Specifications

Main use	Jeans and work clothes
Sewing speed	1,400 – 2,000 rpm (200-rpm steps)
Buttonhole length	L1: 14 – 18 mm L5: 28 – 32 mm L2: 18 – 22 mm L6: 32 – 36 mm L3: 22 – 26 mm L7: 36 – 40 mm L4: 26 – 30 mm
Stitch length	0.9 – 1.8 mm
Stitch width	1.5 – 3.2 mm
Tacking length	4 – 10 mm or none
Cloth presser height	16 mm
Stitch shape changing	Selected by DIP switch setting
Cut timing selection	Selected by DIP switch setting
Starting method	Dual switch (cloth presser switch and start switch) or single switch
Feed method	Intermittent feed by three pulse motors (X, Y, θ)
Needle	DO × 558 Nm 80 – Nm 120 (Schumetz)
Safety equipment	Built-in emergency stop function and automatic stopping device which stops the machine when the safety circuit is activated.
Motor	Inverter-type induction motor
Air pressure	Main regulator: 0.49 Mpa Knife pressure regulator: 0.3 Mpa
Air consumption	43.2 l / min (8 cycle / min)
Noise level	81 dB at max. speed of 2,000 rpm, measured according to ISO 10821
Dimensions	1,200 mm (W) × 590 mm (D) × 1,120 mm (H)
Work table legs	T-shaped height-adjustable type
Power supply	Single-phase 110, 200, 220, 230, 240 V Three phase 220, 380, 415 V Max. electric power consumption: 1kVA
Weight	163.5 kg

### DH4- B981 -

		Upper thread trimmer	Lower thread trimmer Short type*	Fly indexer
-02*	Standard bar tacking / eyelet buttonhole with taper bar	○	○*	Option
52*	Eyelet buttonhole with taper bar (with fly indexer)	○	○*	○

\*-02 and -52 specifications are further divided into L1 – L7 specifications in accordance with the stitch length. Please be sure to specify the stitch length when ordering.

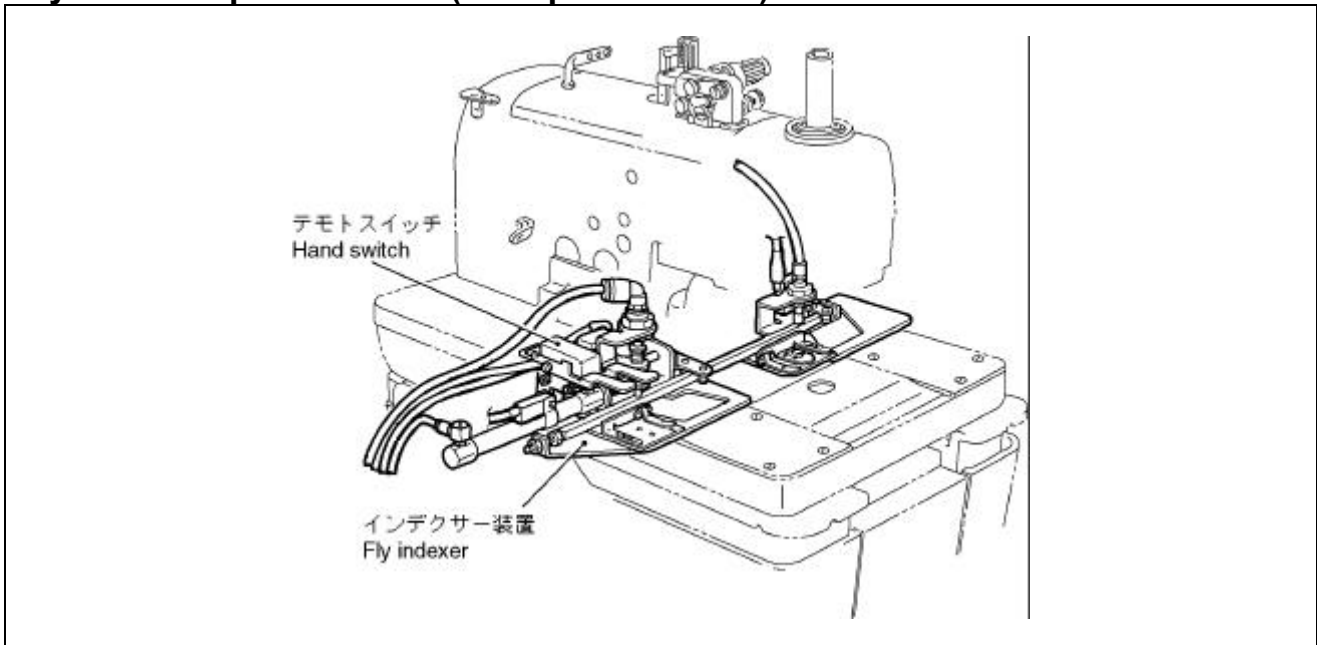
## (For -02) Parts for changing buttonhole length

Parts set	Contents
< L1 14 – 18 mm >	
Exchange parts set (L1) S44238-001	(L1) plate (R) assy S38576-301
	(L1) plate (L) assy S38577-201
	Harness 981 (L1) S43337-000
	Hammer (S12) S37702-001
	Hammer (S16) S37704-001
< L2 18 – 22 mm >	
Exchange parts set (L2) S44239-001	(L2) plate (R) assy S38578-301
	(L2) plate (L) assy S38579-201
	Harness 981 (L2) S43338-000
	Hammer (S16) S37704-001
	Hammer (S20) S37706-001
< L3 22 – 26 mm >	
Exchange parts set (L3) S44240-001	(L3) plate (R) assy S38580-301
	(L3) plate (L) assy S38581-201
	Harness 981 (L3) S43339-000
	Hammer (S20) S37706-001
	Hammer (S24) S37708-001
< L4 26 – 30 mm >	
Exchange parts set (L4) S44271-001	(L4) plate (R) assy S38582-301
	(L4) plate (L) assy S38583-201
	Harness 981 (L4) S43340-000
	Hammer (S24) S37708-001
	Hammer (S28) S42053-001
< L5 28 – 32 mm >	
Exchange parts set (L5) S44272-001	(L5) plate (R) assy S41470-101
	(L5) plate (L) assy S41471-101
	Harness 981 (L5) S43341-000
	Hammer (26) S37197-001
	Hammer (30) S37199-001

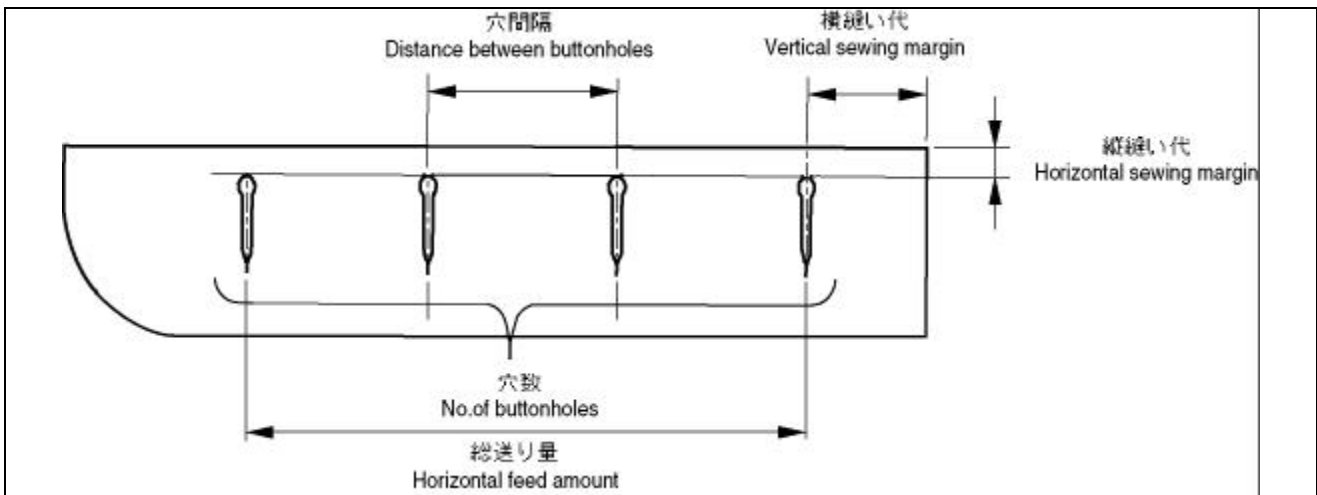
**(For -02) Parts for changing buttonhole length**

Parts set	Contents
< L6 32 – 36 mm >	
Exchange parts set (L6) S44273-001	(L6) plate (R) assy S41472-101
	(L6) plate (L) assy S41473-101
	Harness 981 (L6) S43342-000
	Hammer (30) S37199-001
	Hammer (34) S37201-001
< L7 36 – 40 mm >	
Exchange parts set (L7) S44274-001	(L7) plate (R) assy S41474-101
	(L7) plate (L) assy S41475-101
	Harness 981 (L7) S43343-000
	Hammer (34) S37201-001
	Hammer (38) S35093-001

## Fly indexer specifications (- 52 specifications)



Max. hole spacing	50.8 mm
Max. overall feed amount	152.4 mm
No. of holes	1 - 9
Horizontal sewing margin	9 - 21 mm
Vertical sewing margin	30 - 40 mm

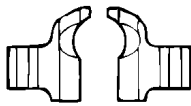
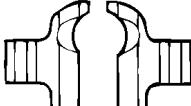
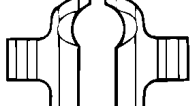
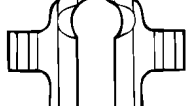
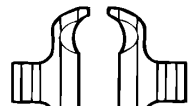
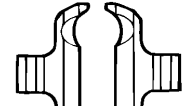
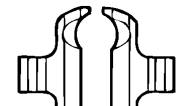


Part name	Part code	Applicable specifications
Fly indexer assy, 981	S44279-001	For L1, L2, L5
	S44281-001	For L3, L4, L6, L7

## Gauge parts list

### Cloth presser

[Models B981]

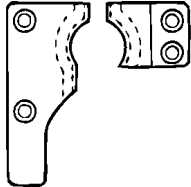
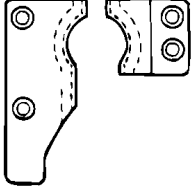
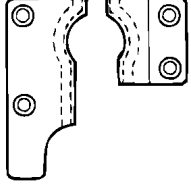
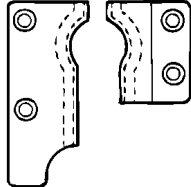
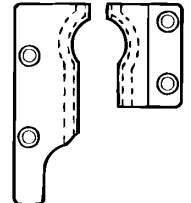
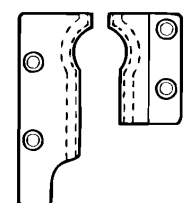
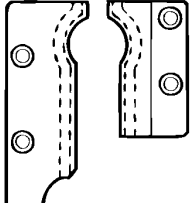
L	S37755-001	S37689-001	S37691-001	S37759-001
R	S37754-001	S37690-001	S37692-001	S37758-001
	L1 <14 – 18 mm>	L2 <18 – 22 mm>	L3 <22 – 26 mm>	L4 <26 – 30 mm>
				
-02 & -52	S41484-001	S41486-001	S41488-001	
	S41483-001	S41485-001	S41487-001	
	L5 <26 – 38 mm>	L6 <32 – 36 mm>	L7 <36 – 40 mm>	
				

### For waist band cloth presser

Parts set	Contents
< L3 22 – 26 mm >	
Cloth presser (L3W) set S43701-000	Cloth presser (L-L3W) assy S43702-000
	Cloth presser (R-L3W) assy S43703-000
< L4 26 – 30 mm >	
Cloth presser (L4W) set S43704-000	Cloth presser (L-L4W) assy S43705-000
	Cloth presser (R-L4W) assy S43706-000

### Needle plate

[Models B981]

L	S37643-101 (L1L)	S37645-101 (L2L)	S37647-101 (L3L)	S37649-101 (L4L)
R	S37644-101 (L1R)	S37646-101 (L2R)	S37648-101 (L3R)	S37650-101 (L4R)
	L1 <14 – 18 mm>	L2 <18 – 22 mm>	L3 <22 – 26 mm>	L4 <26 – 30 mm>
				
-02 & -52	S40823-001 (L5L)	S41480-001 (L6L)	S41482-001 (L7L)	
	S41822-101 (L5R)	S41479-001 (L6R)	S41481-001 (L7R)	
	L5 <14 – 18 mm>	L6 <32 – 36 mm>	L7 <36 – 40 mm>	
				

## Gauge parts list

### Knife

[Models B981]

S35439-101 <38 mm>	S35437-101 <38 mm>	S35480-101 <38 mm>	S35482-101 <38 mm>	S35408-101 (S) <38 mm>

## Hammer

[Models B981]

	Size (mm)	S10	S12	S14	S16	S18
L1-L4	Part code	S37701-001	S37702-001	S37703-001	S37704-001	S37705-001
	Size (mm)	S20	S22	S24	S26	-
L5-L7	Part code	S37706-001	S37707-001	S37708-001	S37709-001	-
	Size (mm)	20	22	24	26	28
	Part code	S35092-001	S37195-001	S37196-001	S37197-001	S37198-001
	Size (mm)	30	32	34	36	38
	Part code	S37199-001	S37200-001	S37201-001	S37202-001	S35093-001

## Double chain stitch looper mechanism

Use	Eye Looper	Looper, R	Spreader, L	Spreader, R
Standard	S35411-001	S35410-001	S35413-101	S35412-101
For heavy	S35471-001		S35472-101	
For single chain stitch	S49078-001		S49079-001	

## Throat plate

Use	Throat plate
For -00 and -01	 A = 1.8 mm B = 4.6 mm S47033-001
For -00 and -01 (For small hole)	A = 1.8 mm B = 4.6 mm S47034-001
For -02	A = 1.8 mm B = 4.6 mm S37752-001
For straight bar tack	A = ----- B = 4.6 mm S39923-101