

BAS-311F-0

BAS-311F-L

BAS-326F-0

Programmable Electronic Pattern Sewer
With Cylinder Bed



Model

BAS-311F-0

1	For heavy-weight materials
2	For medium-weight materials
3	For extra heavy-weight materials
4	For special use

S	Work clamp lifter (Solenoid type)
A	Work clamp lifter (Pneumatic type)

BAS-311F-L A

1	For heavy-weight materials, Work clamp lifter (Pneumatic type)
4	For special use, Work clamp lifter (Pneumatic type)

BAS-326F-0 A



1	For heavy-weight materials, Work clamp lifter (Pneumatic type)
2	For medium-weight materials, Work clamp lifter (Pneumatic type)
4	For special use, Work clamp lifter (Pneumatic type)

Specifications

Stitch formation	Single needle lock stitch
Sewing machine	Lock stitch, pattern tacking sewing machine (with large shuttle hook)
Maximum pattern size	BAS-311F-0: 130 × 60 mm, BAS-311F-L: 220 × 60 mm, BAS-326F-0: 220 × 100 mm
Maximum stitch number	20,000 (One pattern)
Stitch length	0.05 - 12.7 mm
Maximum sewing speed	2,500 rpm (When stitch length is 3 mm or less)
Feed mechanism	Intermittent feed, pulse motor drive
Rotary hook	Shuttle hook (Standard rotary hook is sold separately)
Needle	DP × 5, DP × 17, MR
Data storage method	3.5 floppy disk 2HD / 1.44 MB, 2DD
Test function	Operation test function provided for use with low speed drive
Safety devices	Automatic stop function for activation in the event of misoperation realized with intermediate stop function and safety circuits
Work clamp height	BAS-311F-0: For solenoid – Max. 25 mm, for pneumatic – Max. 30 mm BAS-311F-L, BAS-326F-0: Max. 30 mm
2-step work clamp	For solenoid – unit work clamp, for pneumatic – separate work clamp
Work clamp lift stroke	18 mm
Intermittent stroke	0 or 3 (Factory default) – 8 mm
Weights	BAS-311F-0 machine head: 65 kg, BAS-311F-L, 326F-0 machine head: 70 kg Control box: 10-20 kg (Depending on destination)
Power supply	Single-phase 110 V, 220 V, 230V, 240 V 3-phase 220 V, 380 V, 400 V, 600 VA
Motor	Three-phase 400 W induction motor
Air pressure	0.5 MPa 1.8 l / min
Power table	T-shaped for use sitting or standing
Machine dimensions	Sitting: 1,200 W × 590 D × 1,120 H mm Standing: 1,350 H mm (Excluding spool stand)

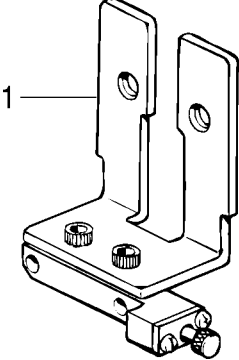
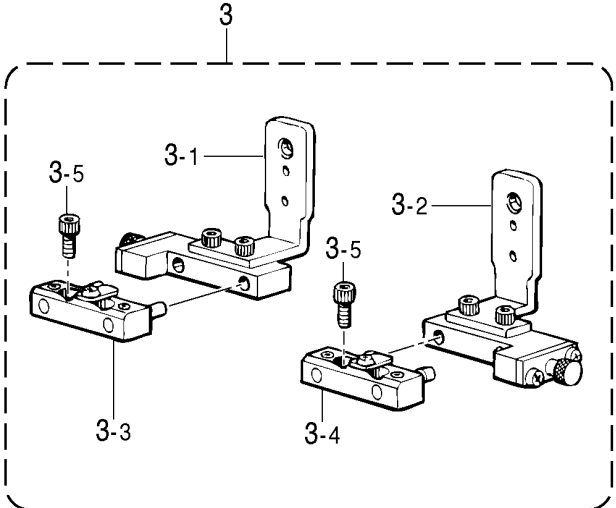
Thread trimmer mechanism

BAS-311F-0, 311F-L, 326F-0

	Ref. No.	Part name	Part code	Q'ty
 <p>45-3</p>	45-3	Movable knife assy, N	S49988-001	1
 <p>49-1</p>	49-1	Fixed knife	S10210-201	1

One-touch work clamp (Option parts)

BAS-311F-0, 311F-L

	Ref. No.	Part name	Part code	Q'ty
 <p>1</p>	1	One-touch holder assy, UN	S24612-001	1
 <p>3</p> <p>3-5</p> <p>3-1</p> <p>3-2</p> <p>3-3</p> <p>3-4</p>	3	One-touch work clamp set	S44794-001	1
	3-1	One-touch holder assy, L	S20280-101	1
	3-2	One-touch holder assy, R	S20286-101	1
	3-3	Work clamp holder assy, L	S20289-101	2
	3-4	Work clamp holder assy, R	S20293-101	2
	3-5	Bolt, socket SM 4.37 x 8	018680-822	8

One-touch work clamp (Option parts)

BAS-326F-0

Ref. No.	Part name	Part code	Q'ty
6	One-touch work clamp set	S57954-001	1
6-3	One-touch holder assy, L	S57955-001	1
6-4	One-touch holder assy, R	S57957-001	1
4	Work clamp holder set, L	S20822-101	1
4-1	Work clamp holder assy, L	S20289-101	1
4-2	Bolt, socket SM4.37 x 8	018680-822	2
5	Work clamp holder set, R	S20823-101	1
5-1	Work clamp holder assy, R	S20293-101	1
5-2	Bolt, socket SM4.37 x 8	018680-822	2

Work clamp

BAS-311F-0, 311F-L

Ref. No.	Part name	Part code	Q'ty
75-3	Work clamp guide bracket	S42798-001	1
75-4	Work clamp adjusting plate	S42799-001	2
75-5	Adjusting plate	S42800-001	2
75-6	Work clamp, SE - OP	S42802-001	2
75-7	Screw, pan SM3.57 - 40 x 5	062670-512	4

*These optional parts are used to prevent work clamp looseness.

Work clamp

BAS-326F-0

Ref. No.	Part name	Part code	Q'ty
5	Work clamp, UN326L	S51042-001	1
77	Work clamp guide bracket	S42798-001	1
78	Adjusting plate	S56536-001	2
79	Adjusting plate	S42800-001	2
81	Screw, pan SM3.57 - 40 x 6	062670-612	4
141	Work clamp, UN	S56537-001	1

*These optional parts are used to prevent work clamp looseness.

Blank for work clamp

BAS-311F-0

	Part name	Part code	Q'ty
	<Thick 3.2 mm> Work clamp blank, A – 3.2	S43824-001	1
	<Thick 4.0 mm> Work clamp blank, A – 4.0	S43826-001	1
	<Thick 5.0 mm> Work clamp blank, A – 5.0	S43828-001	1
	<Thick 3.2 mm> Work clamp blank, B – 3.2	S43825-001	1
	<Thick 4.0 mm> Work clamp blank, B – 4.0	S43827-001	1
	<Thick 5.0 mm> Work clamp blank, B – 5.0	S43829-001	1
	<Thick 6.0 mm> Work clamp blank, – 6.0	S43830-001	1

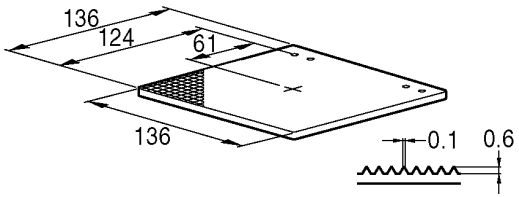
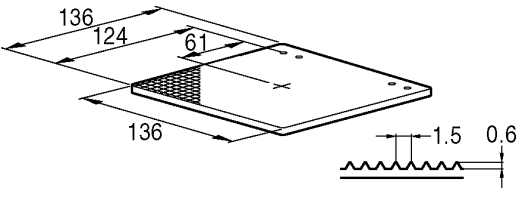
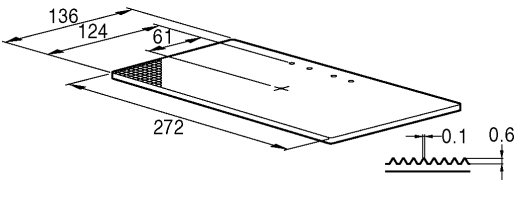
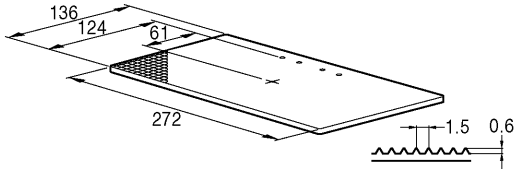
Blank for work clamp

BAS-311F-L

	Part name	Part code	Q'ty
<p>For left</p>	<Thick 3.2 mm> Work clamp blank, A – 3.2 311L	S57729-001	1
	<Thick 4.0 mm> Work clamp blank, A – 4.0 311L	S57731-001	1
	<Thick 5.0 mm> Work clamp blank, A – 5.0 311FL	S57733-001	1
<p>For left</p>	<Thick 3.2 mm> Work clamp blank, B – 3.2 311L	S57730-001	1
	<Thick 4.0 mm> Work clamp blank, B – 4.0 311L	S57732-001	1
	<Thick 5.0 mm> Work clamp blank, B – 5.0 311FL	S57734-001	1
	<Thick 6.0 mm> Work clamp blank, 6.0 311FL	S57735-001	1

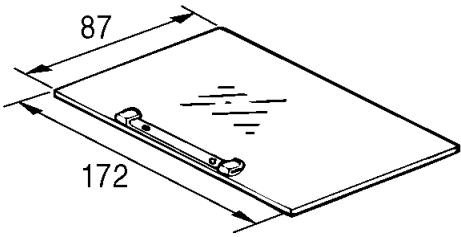
Blank for work clamp

BAS-326F-0

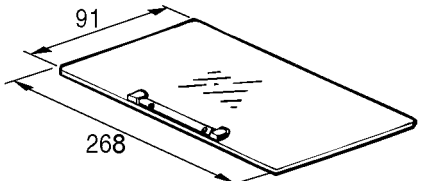
	Part name	Part code	Q'ty
	<Thick 3.2 mm> Work clamp blank, SE A - 3.2	S51051-001	1
	<Thick 4.0 mm> Work clamp blank, SE A - 4.0	S51053-001	1
	<Thick 5.0 mm> Work clamp blank, SE A - 5.0	S51055-001	1
	<Thick 6.0 mm> Work clamp blank, SE A - 6.0	S51057-001	1
	<Thick 3.2 mm> Work clamp blank, SE B - 3.2	S51052-001	1
	<Thick 4.0 mm> Work clamp blank, SE B - 4.0	S51054-001	1
	<Thick 5.0 mm> Work clamp blank, SE B - 5.0	S51056-001	1
	<Thick 6.0 mm> Work clamp blank, SE B - 6.0	S51058-001	1
	<Thick 3.2 mm> Work clamp blank, UN A - 3.2	S51059-001	1
	<Thick 4.0 mm> Work clamp blank, UN A - 4.0	S51061-001	1
	<Thick 5.0 mm> Work clamp blank, UN A - 5.0	S51063-001	1
	<Thick 6.0 mm> Work clamp blank, UN A - 6.0	S51065-001	1
	<Thick 3.2 mm> Work clamp blank, UN B - 3.2	S51060-001	1
	<Thick 4.0 mm> Work clamp blank, UN B - 4.0	S51062-001	1
	<Thick 5.0 mm> Work clamp blank, UN B - 5.0	S51064-001	1
	<Thick 6.0 mm> Work clamp blank, UN B - 6.0	S51066-001	1

One-touch cassette clamp assy

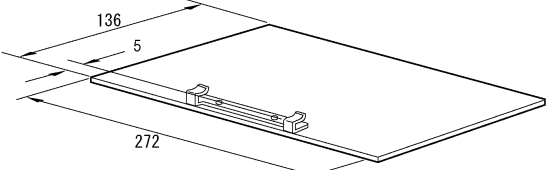
BAS-311F-0

	Part name	Part code	Q'ty
	<Thick 0.5 mm> Cassette clamp assy, OT 311	S43691-001	1
	<Thick 1.0 mm> Cassette clamp assy, OT 311	S43691-002	1
	<Thick 2.0 mm> Cassette clamp assy, OT 311	S43691-003	1

BAS-311F-L

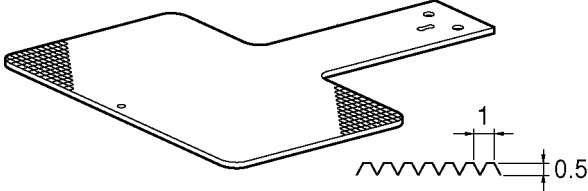
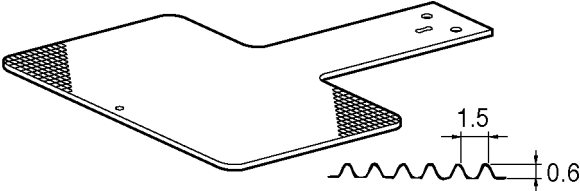
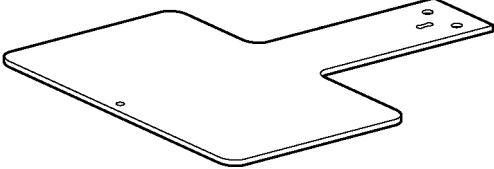
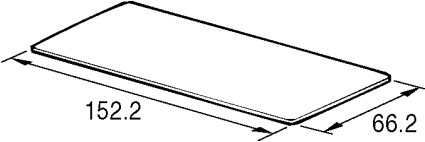
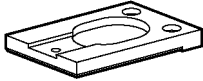
	Part name	Part code	Q'ty
	<Thick 0.5 mm> Cassette clamp assy, OT 311L	S57737-001	1
	<Thick 1.0 mm> Cassette clamp assy, OT 311L	S57739-001	1
	<Thick 2.0 mm> Cassette clamp assy, OT 311L	S56540-001	1

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	Part name	Part code	Q'ty
	<Thick 0.5 mm> Cassette clamp plate assy, 326 - OT	S51067-001	1
	<Thick 1.0 mm> Cassette clamp plate assy, 326 - OT	S51069-001	1
	<Thick 2.0 mm> Cassette clamp plate assy, 326 - OT	S51071-001	1

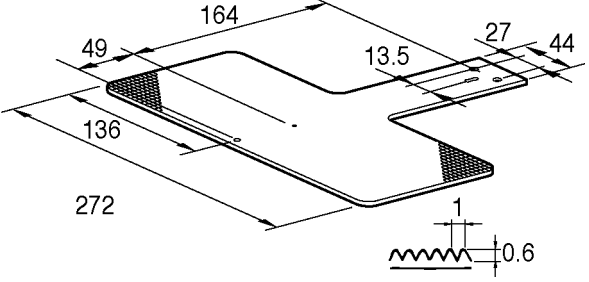
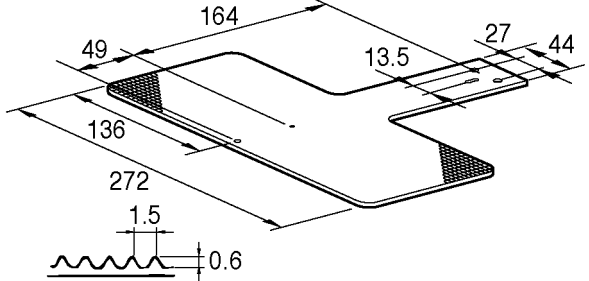
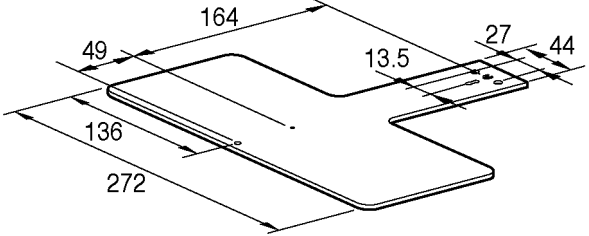
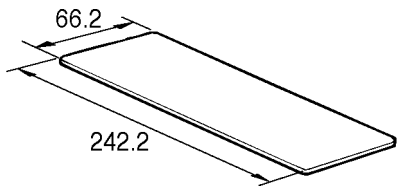
For feed plate attachment

BAS-311F-0

	Part name	Part code	Q'ty
	Feed plate blank, A 311	S55164-001	1
	Feed plate blank, B 311	S55165-001	1
	Feed plate blank, C 311	S55166-001	1
	Feed plate inner plate	S43823-001	1
	Feed plate setting bracket	S51804-001	1

For feed plate attachment

BAS-311F-L

	Part name	Part code	Q'ty
	<p><Thick 1.2 mm> Feed plate blank, A 311L</p>	<p>S57723-001</p>	<p>1</p>
	<p><Thick 1.2 mm> Feed plate blank, B 311L</p>	<p>S57724-001</p>	<p>1</p>
	<p><Thick 1.2 mm> Feed plate blank, C 311L</p>	<p>S57725-001</p>	<p>1</p>
	<p>Feed plate inner plate</p>	<p>S45603-001</p>	<p>1</p>

For feed plate attachment

BAS-326F-0

	Part name	Part code	Q'ty
	<p><Thick 1.2 mm> Feed plate blank, 326A</p>	S57844-001	1
	<p><Thick 1.2 mm> Feed plate blank, 326B</p>	S57845-001	1
	<p><Thick 1.2 mm> Feed plate blank, 326C</p>	S57846-001	1
	<p>Feed plate inner plate</p>	S48555-000	1

Work clamp

BAS-311F-0

	Ref. No.	Part name	Part code	Q'ty
	6	Work clamp, R 311	S42772-001	1
	7	Work clamp, L 311	S42773-001	1
	8	Washer, plain M4.37	025680-232	2
	9	Bolt, SM4.37 x7	153403-002	2
	10	Positioning plate	S10065-001	2
	11	Screw, pan SM4.37-40 x 5	062680-512	2
	202	Work clamp, UN ; SOL	S43986-201	1
	203	Work clamp, 311 UN	S43987-001	1

Work clamp

BAS-311F-L


	Ref. No.	Part name	Part code	Qty
	6	Work clamp, R 311L	S55931-001	1
	7	Work clamp, L 311L	S55932-001	1
	8	Washer, plain M4.37	025680-232	2
	9	Bolt, SM4.37 x 7	153403-002	2
	10	Positioning plate	S10065-001	2
	11	Screw, pan SM4.37-40 x 5	062680-512	2

BAS-326F-0

	Ref. No.	Part name	Part code	Qty
	6	Work clamp, R 326	S51030-001	1
	7	Work clamp, L 326	S51031-001	1
	8	Washer, plain M4.37	025680-232	2
	9	Bolt, SM4.37 x 7	153403-002	2
	10	Positioning plate	S10065-001	2
	141	Work clamp, UN	S56537-001	1
	5	Work clamp, UN 326	S51042-001	1

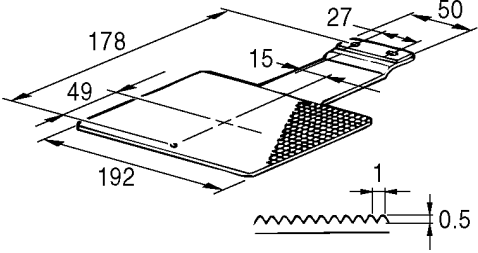
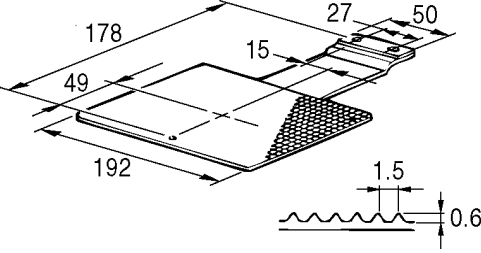
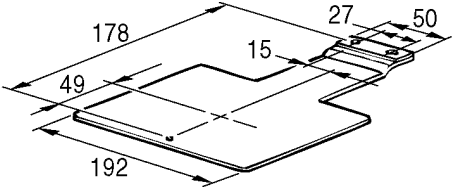
For one-touch work clamp

BAS-311F-0, 311F-L, 326F-0

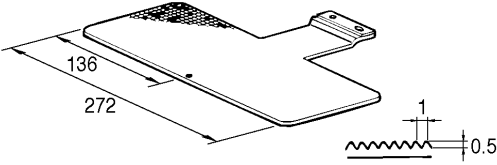
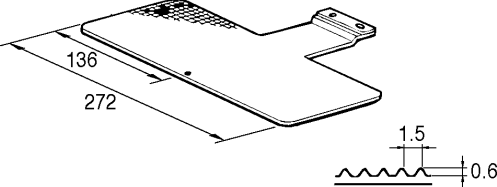
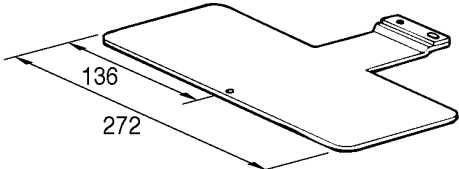
	Part name	Part code	Qty
	OT – feed plate bracket assy	S57952-001	1

Feed plate blank for one-touch work clamp

BAS-311F-0

	Part name	Part code	Qty
	<Thick 1.2 mm> OT – feed plate blank, A	S43700-001	1
	<Thick 1.2 mm> OT – feed plate blank, B	S43821-001	1
	<Thick 1.2 mm> OT – feed plate blank, C	S43822-001	1

BAS-311F-L

	Part name	Part code	Qty
	<Thick 1.2 mm> OT – feed plate blank, A 311L	S57726-001	1
	<Thick 1.2 mm> OT – feed plate blank, B 311L	S57727-001	1
	<Thick 1.2 mm> OT – feed plate blank, C 311L	S57728-001	1

Feed plate blank for one-touch work clamp

BAS-326F-0

	Part name	Part code	Qty
	<Thick 1.2 mm> OT – feed plate blank, A	S51048-101	1
	<Thick 1.2 mm> OT – feed plate blank, B	S51049-101	1
	<Thick 1.2 mm> OT – feed plate blank, C	S51050-101	1

For sewing the bar tack “61.5 x 86.5”

BAS-311F-0, 311F-L

	Ref. No.	Part name	Part code	Qty
	159	Work clamp, SR	S14254-001	1
	160	Work clamp, SL	S14255-001	1
	163	OT – work clamp assy, D	S14846-001	2
	164	Screw, flange SM4.37	149168-001	2

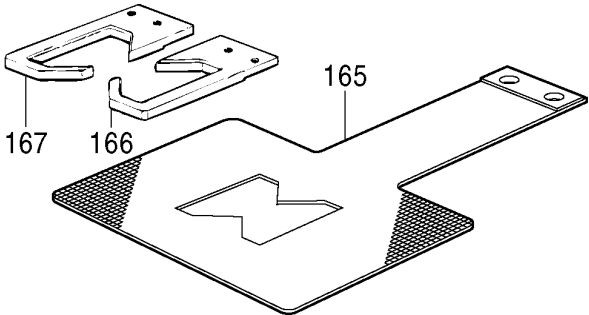
Feed plate for one-touch work

BAS-311F-0, 311F-L

	Part name	Part code	Qty
	For denim <Thick 1.2 mm> OT – feed plate blank, DE	S14253-001	1
	For general <Thick 1.2 mm> OT – feed plate	S14252-001	1

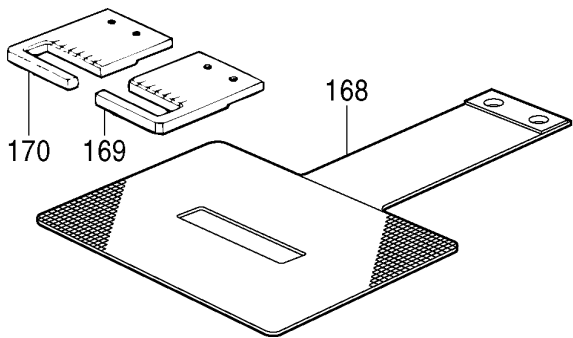
**For one-touch work clamp
For basting the vent**

BAS-311F-0, 311F-L

	Ref. No.	Part name	Part code	Q'ty
	165	Feed plate	S13092-001	1
	166	Work clamp, R	S13090-001	1
	167	Work clamp, L	S13091-001	1

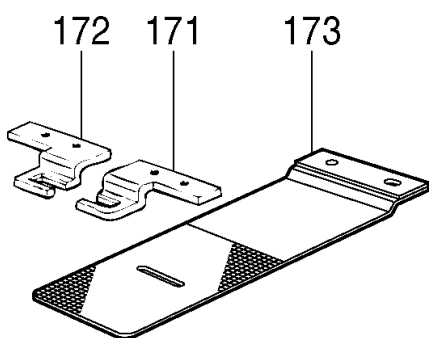
For attaching the thread loop

BAS-311F-0, 311F-L

	Ref. No.	Part name	Part code	Q'ty
	168	Feed plate	S13098-001	1
	169	Work clamp, R	S13096-001	1
	170	Work clamp, L	S13097-001	1

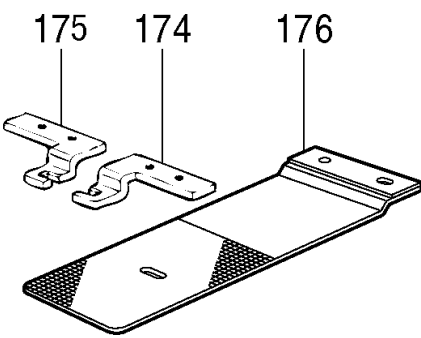
For sewing the bar tack "23 x 6"

BAS-311F-0, 311F-L

	Ref. No.	Part name	Part code	Q'ty
	171	Work clamp, R311 - 004	S23818-001	1
	172	Work clamp, L311 - 004	S23819-001	1
	173	Feed plate, 311 - 004	S23820-001	1

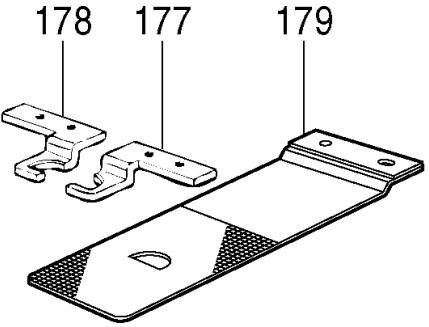
For sewing the bar tack "10.4 x 4.4"

BAS-311F-0, 311F-L

	Ref. No.	Part name	Part code	Q'ty
	174	Work clamp, R311 - 005	S23821-001	1
	175	Work clamp, L311 - 005	S23822-001	1
	176	Feed plate, 311 - 005	S23823-001	1

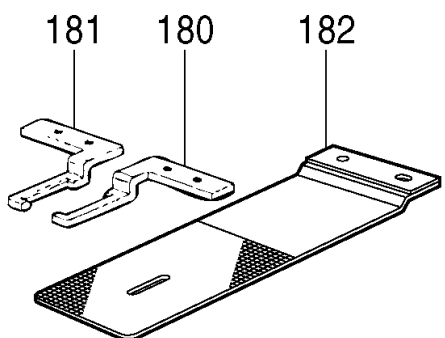
For one-touch work clamp
For sewing the bar tack "Semi-circle"

BAS-311F-0, 311F-L

	Ref. No.	Part name	Part code	Q'ty
	177	Work clamp, R311 – 006	S23824-001	1
	178	Work clamp, L311 – 006	S23825-001	1
	179	Feed plate, 311 - 006	S23826-001	1

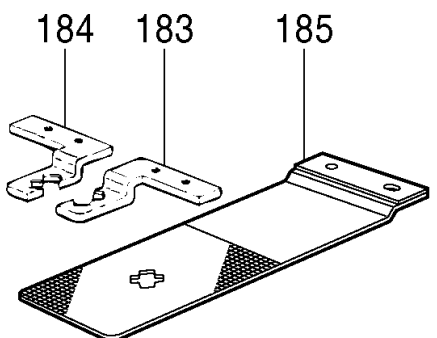
For sewing the bar tack "6 x 23"

BAS-311F-0, 311F-L

	Ref. No.	Part name	Part code	Q'ty
	180	Work clamp, R311 – 007	S23827-001	1
	181	Work clamp, L311 – 007	S23828-001	1
	182	Feed plate, 311 - 007	S23829-001	1

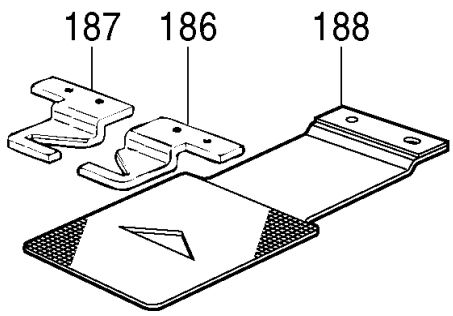
For sewing the bar tack "X - cross"

BAS-311F-0, 311F-L

	Ref. No.	Part name	Part code	Q'ty
	183	Work clamp, R311 – 008	S23830-001	1
	184	Work clamp, L311 – 008	S23831-001	1
	185	Feed plate, 311 - 008	S23832-001	1

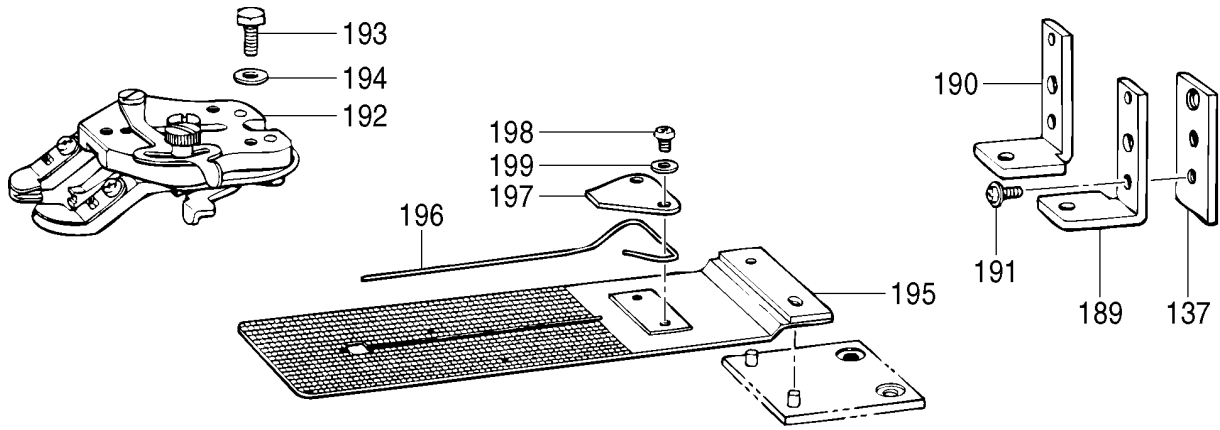
For sewing the bar tack "Triangle"

BAS-311F-0, 311F-L

	Ref. No.	Part name	Part code	Q'ty
	186	Work clamp, R311 – 009	S23833-001	1
	187	Work clamp, L311 – 009	S23834-001	1
	188	Feed plate, 311 - 009	S23835-001	1

For attaching the button

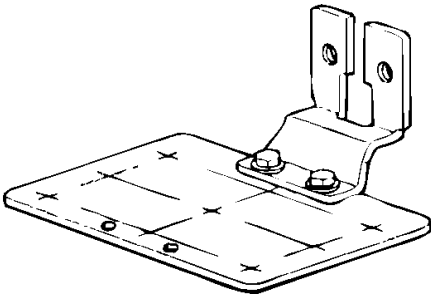
BAS-311F-0, 311F-L



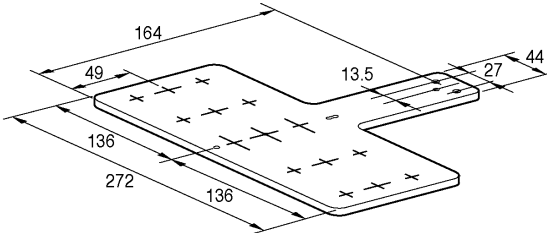
Ref. No.	Part name	Part code	Q'ty
137	Button clamp holder	S31365-001	2
189	BU work clamp, U - R	S14848-001	1
190	BU work clamp, U - L	S14849-001	1
191	Screw, flange SM4.37	149168-001	2
192	Button clamp assy	S30015-101	1
193	Bolt, SM4.76	117363-001	2
194	Washer, plain M4.76	025710-232	2
195	OT - feed plate, 7 plain	S14069-001	1
196	Spring, 1.2	153871-001	1
197	Spring	S14073-001	1
198	Screw, pan SM3.57 - 40 x 5	062670-512	2
199	Washer, plain 4	102707-002	2

For gauge parts

BAS-311F-0

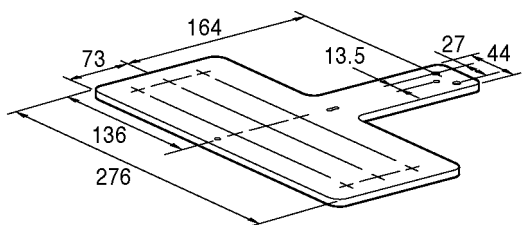
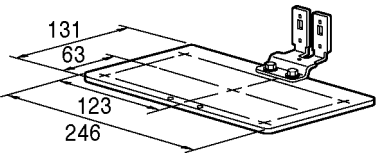
	Part name	Part code	Q'ty
	H - position standard plate assy	S42888-001	1

BAS-311F-0, 311F-L

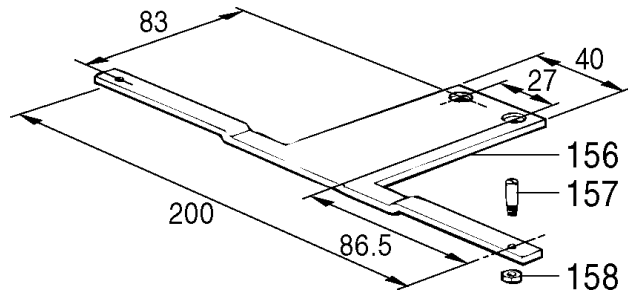
	Part name	Part code	Q'ty
	H - position standard plate assy	S55161-001	1

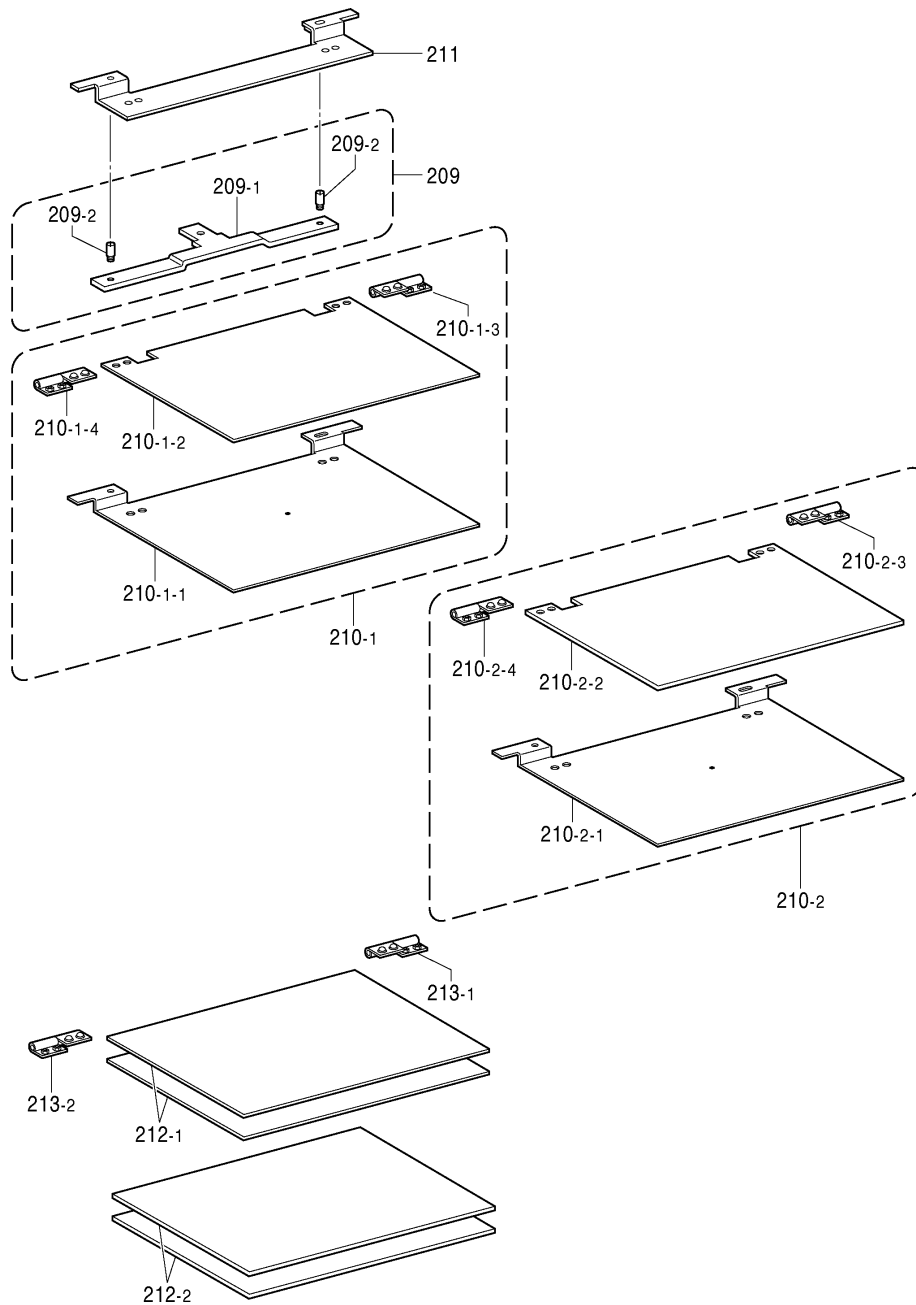
For gauge parts

BAS-326F-0

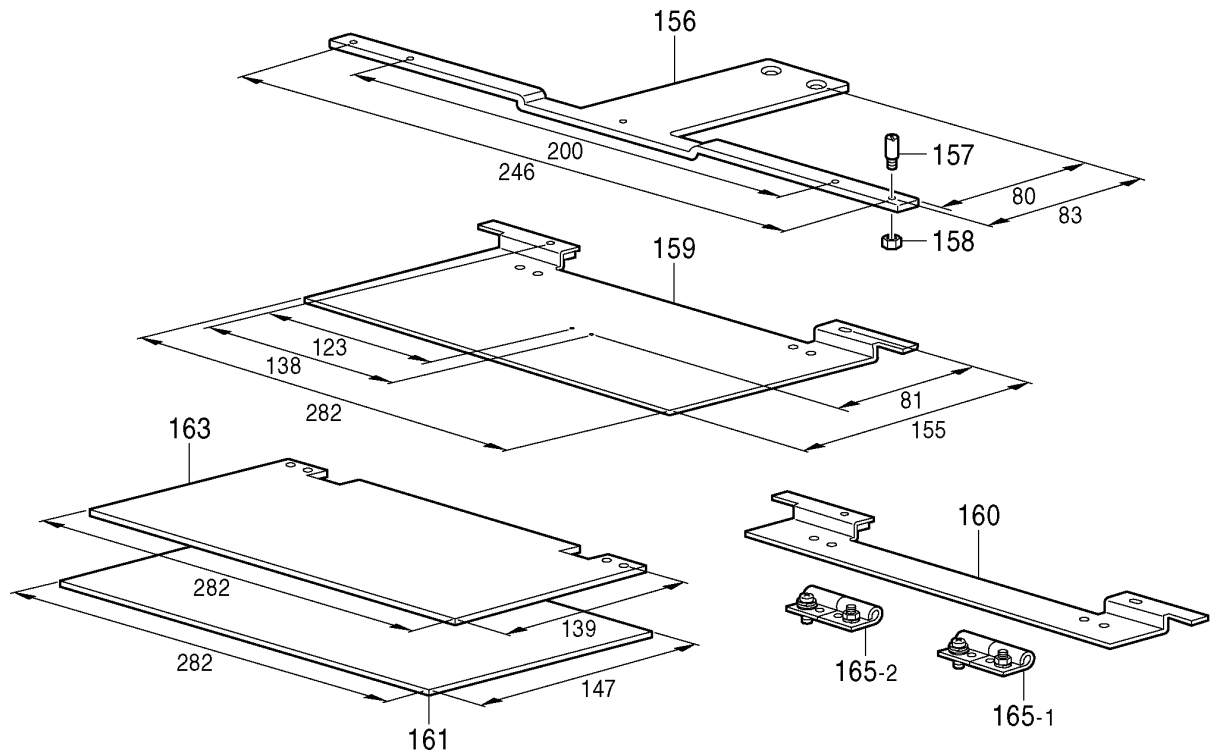
	Part name	Part code	Q'ty
	H – position standard plate assy	S55954-001	1
	H-position standard plate assy	S56538-001	1

For cassette holder

	Ref. No.	Part name	Part code	Q'ty
	156	Holder plate, cassette	S13006-001	1
	157	Pin, cassette holder	S13007-001	2
	158	Nut, 3 SM3.18 - 40	021660-306	2



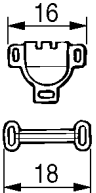
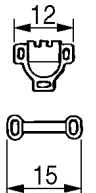
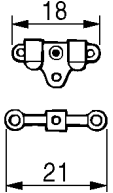
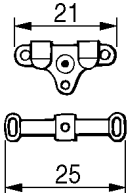
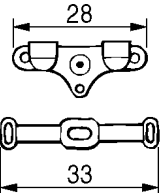

Ref. No.	Part name	Part code	Q'ty
209	Cassette holder plate assy	S02963-201	1
290-1	Cassette holder plate	S33533-101	1
209-2	Pin, C-holder	S19629-001	2
210-1	Cassette presser assy, A	S02959-101	1
210-1-1	Cassette plate, D-A	S02966-101	1
210-1-2	Cassette plate, U-A :T=1	S02968-000	1
210-1-3	Hinge assy, R	152632-001	1
210-1-4	Hinge assy, L	152633-001	1
210-2	Cassette presser assy, B	S02960-101	1
210-2-1	Cassette plate, D-A	S02966-101	1
210-2-2	Cassette plate, U-B :T=2	S02971-000	1
210-2-3	Hinge assy, R	152632-001	1
210-2-4	Hinge assy, L	152633-001	1
	<For resin plate>		
211	Cassette plate, D-B	S02967-101	2
212-1	Cassette lower plate, A : T=1	S02969-000	2
212-2	Cassette lower plate, B: T=2	S02970-000	2
213-1	Hinge assy, R	152632-001	2
213-2	Hinge assy, L	152633-001	2

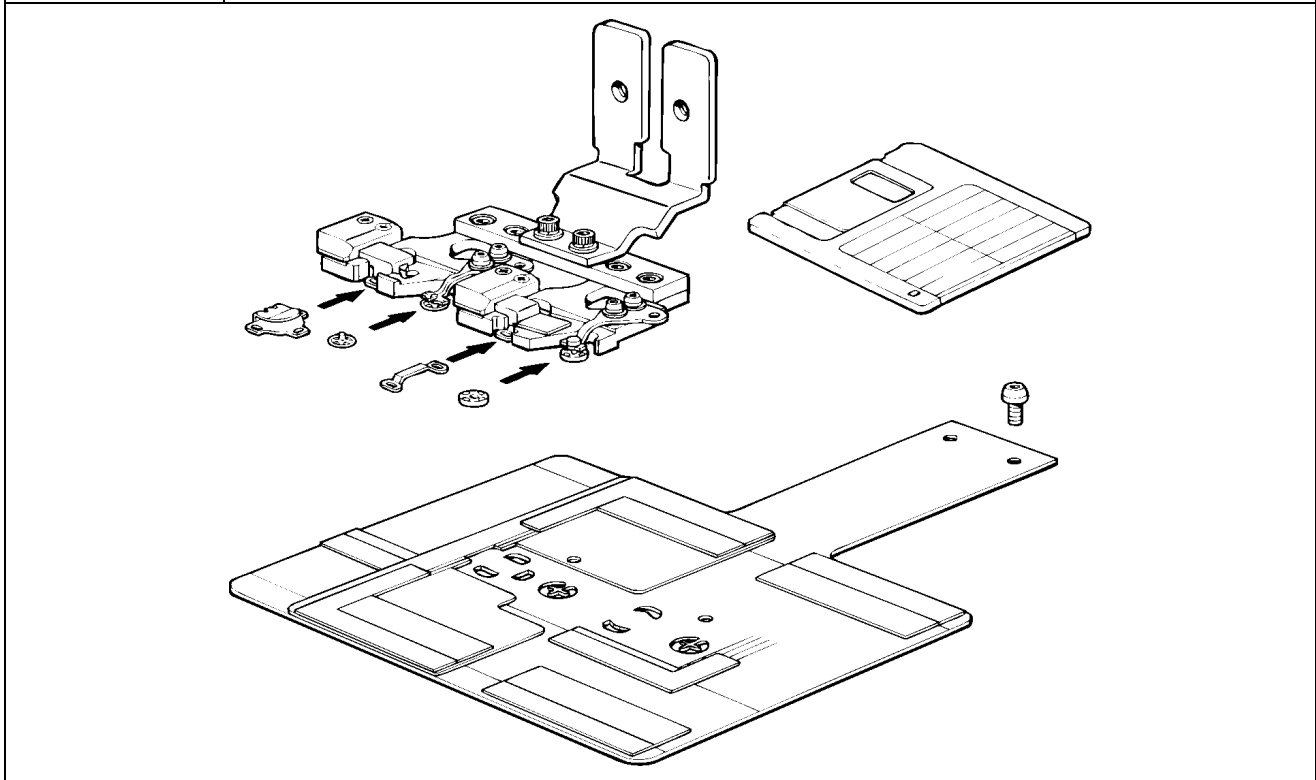


Ref. No.	Part name	Part code	Q'ty
156	Cassette holder plate	S57849-001	1
157	Pin	S13007-001	2
158	Nut, 3 SM3.18 - 40	021660-306	2
159	Cassette plate, D - A 180	S14392-201	1
160	Cassette plate, D - B 180	S14388-101	1
161	< Thick 1.0 mm > Cassette lower plate, D - A 180	S14386-000	1
161	< Thick 2.0 mm > Cassette lower plate, D - B 180	S14387-000	1
163	< Thick 1.0 mm > Cassette plate, U - A 180	S14389-000	1
163	< Thick 2.0 mm > Cassette plate, U - B 180	S14390-000	1
165-1	Hinge assy, R	152632-001	1
165-2	Hinge assy, L	152633-001	1

Snap fastener and hook attachment device

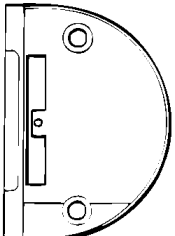
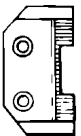
BAS-311F-0, 311F-L

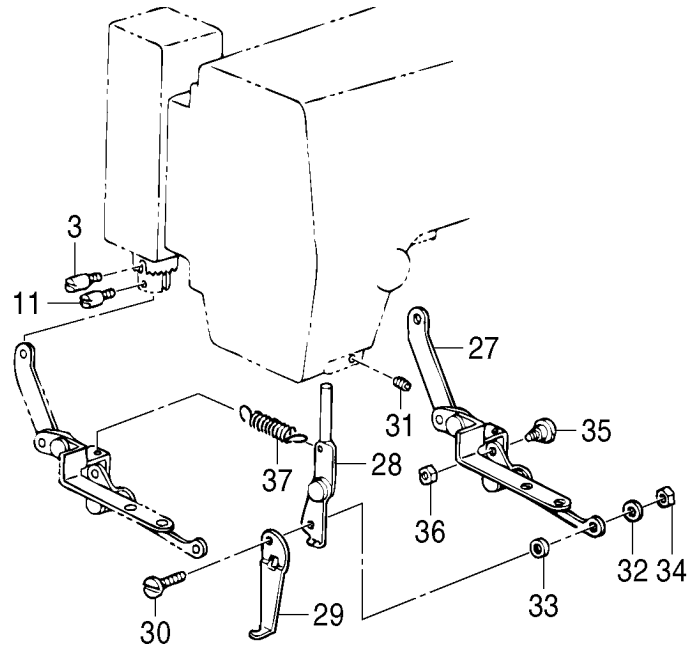
Part name	311 – S.H device set				
	M - 508K	M - 528K	M - 520K	M - 525K	M - 533K
Part code	S42803-001	S42806-001	S42808-001	S42810-001	S42812-001
Hook size (mm)					
Snap size (mm)	OM $\phi 7.6, \phi 8.6$ 				



For sewing the belt with hook

BAS-311F-0, 311F-L

	Part name	Part code	Qty
	Needle plate, H	S13099-001	1
	Feed dog, H	S13100-001	1

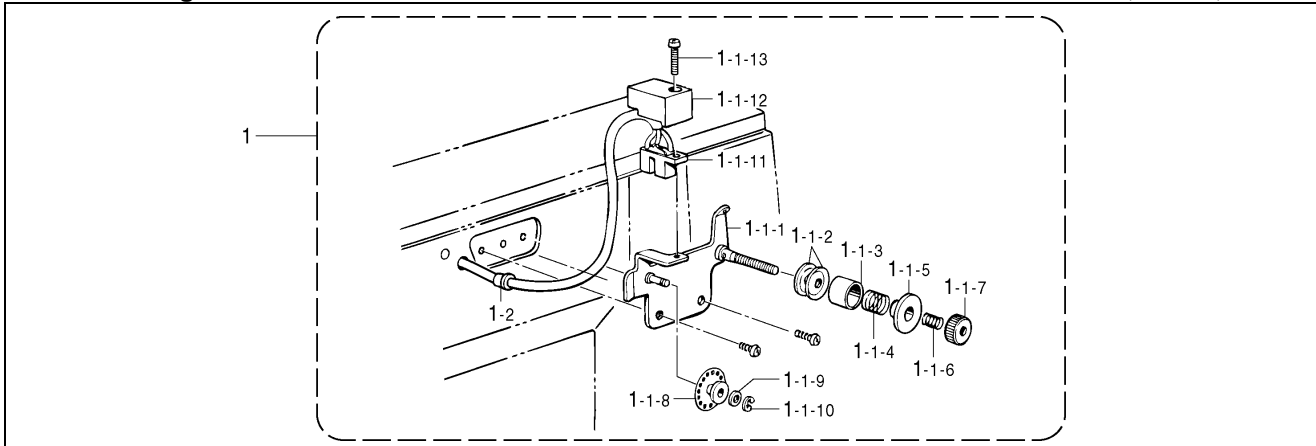


Ref. No.	Part name	Part code	Q'ty
3	Plunger pin	S25456-001	1
11	Plunger pin	S25456-001	1
27	Thread wiper assy, side	S42859-001	1
28	Wiper arm assy	S42864-101	1
29	Thread wiper, A	156206-001	1
30	Screw, SM3.57 x 10	S13385-001	1
31	Set screw, socket (CP) SM4.76	014710-522	1
32	Washer	S21875-001	1
33	Collar	S12668-001	1
34	Nut, 2 SM3.57	021670-202	1
35	Shoulder screw, SM3.18	100659-001	1
36	Nut, 1 SM3.18	021660-102	1
37	Spring	159111-001	1

	Ref. No.	Part name	Part code	Q'ty
	64-9	Presser foot, XA	S42849-101	1
	70	Presser bar, side	S42880-001	1

Thread breakage detector

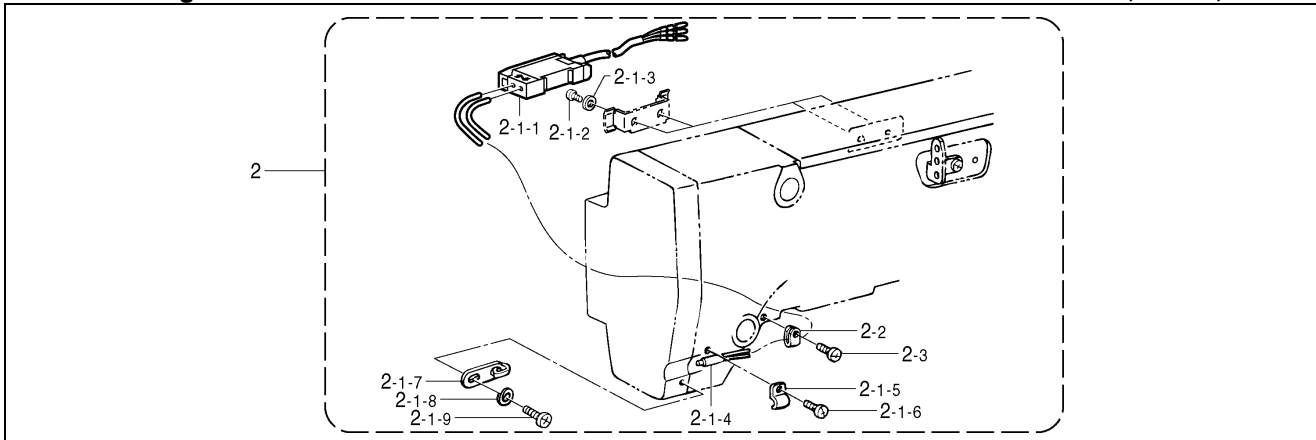
BAS-311F-0, 311F-L, 326F-0



Ref. No.	Part name	Part code	Q'ty
1	TR. breakage detector set, R	S43833-109	1
1-1	TR. breakage detector assy, R	S43834-109	1
1-1-1	Detector bracket assy	S18032-001	1
1-1-2	Disc, thread guide	144504-001	2
1-1-3	Disc, thread guide	146206-009	1
1-1-4	Pre-tension spring	146058-001	1
1-1-5	Pre-tension nut	146059-001	1
1-1-6	Spring	146060-000	1
1-1-7	Tension nut	155510-001	1
1-1-8	Pulley, A	157255-100	1
1-1-9	Washer, plain S3	025030-135	1
1-1-10	Retaining ring, E2	048020-342	1
1-1-11	Sensor assy	S43835-100	1
1-1-12	Sensor cover	S18037-009	1
1-1-13	Screw, pan M3 x 16	062301-616	1
1-2	Cord bush	146080-000	1

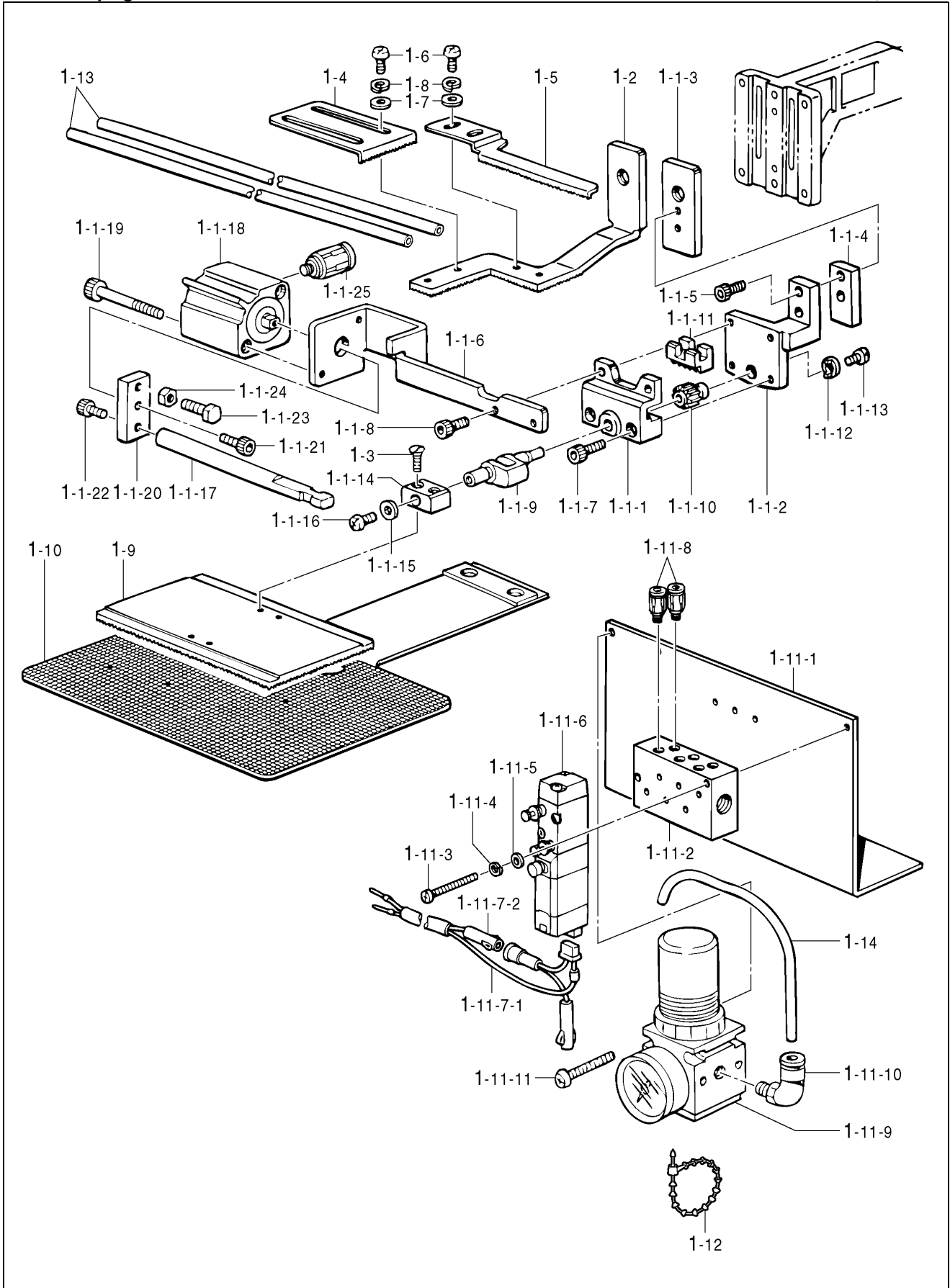
Thread breakage detector

BAS-311F-0, 311F-L, 326F-0



Ref. No.	Part name	Part code	Q'ty
2	TR. breakage detector set, F	S43836-301	1
2-1	TR. breakage detector assy, F	S43977-201	1
2-1-1	Amplifier unit	S43279-200	1
2-1-2	Screw, pan M3 x 6	062300-612	2
2-1-3	Washer, plain M3	025030-232	2
2-1-4	Fiber unit, N	S29468-100	1
2-1-5	Sensor setting plate	S11884-001	1
2-1-6	Screw, pan M3 x 6	062300-612	1
*2-1-7	Thread guide, face plate	S02617-001	1
*2-1-8	Washer, spring 2-3.5	028350-242	1
*2-1-9	Screw, bind SM3.57-40 x 6	060670-612	1
*2-2	Cord holder, NK-2N	625010-000	1
*2-3	Screw, bind SM3.57-40 x 6	060670-612	1

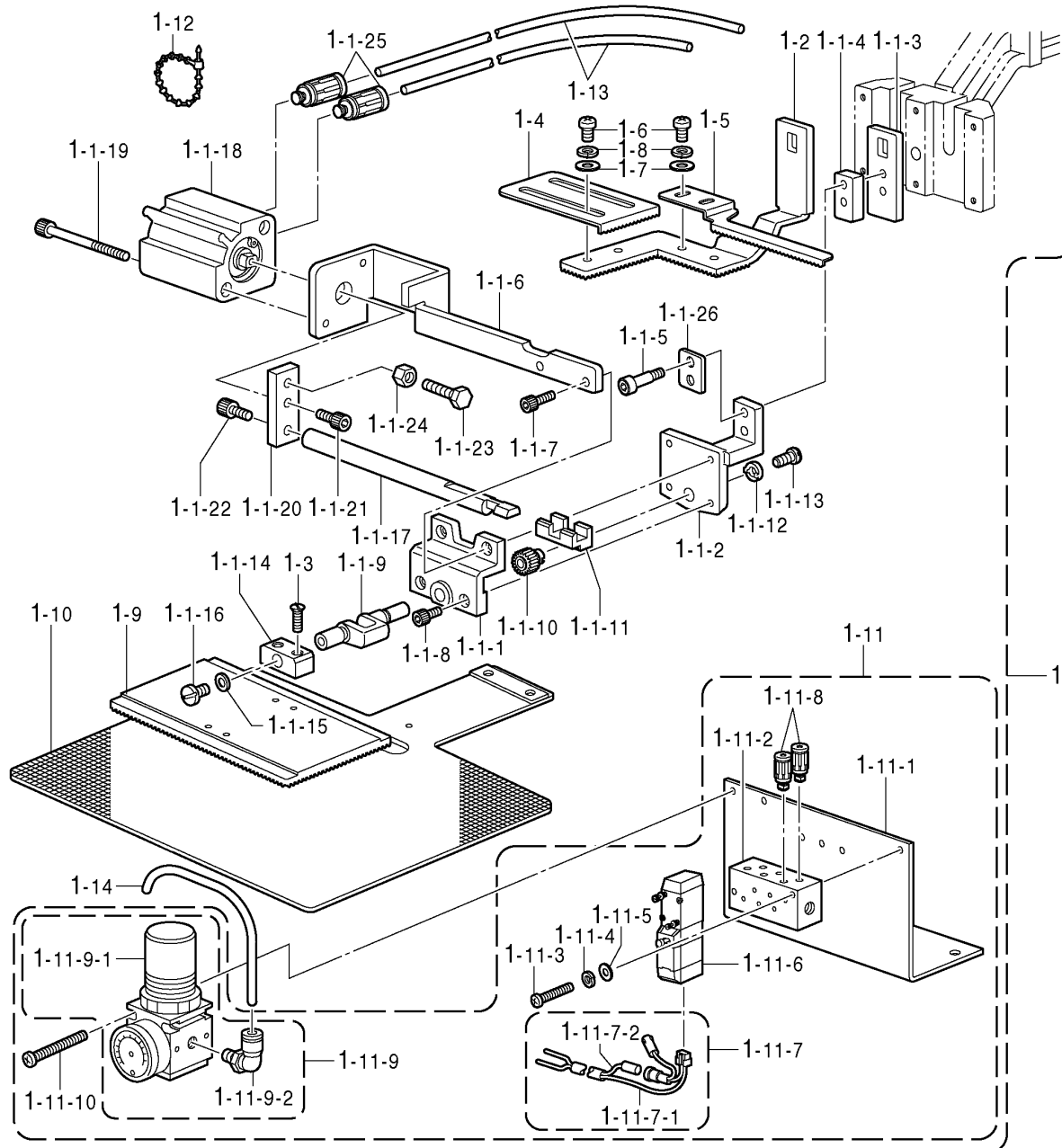
The part indicated with * is for BAS-311F-0 and 311F-L..



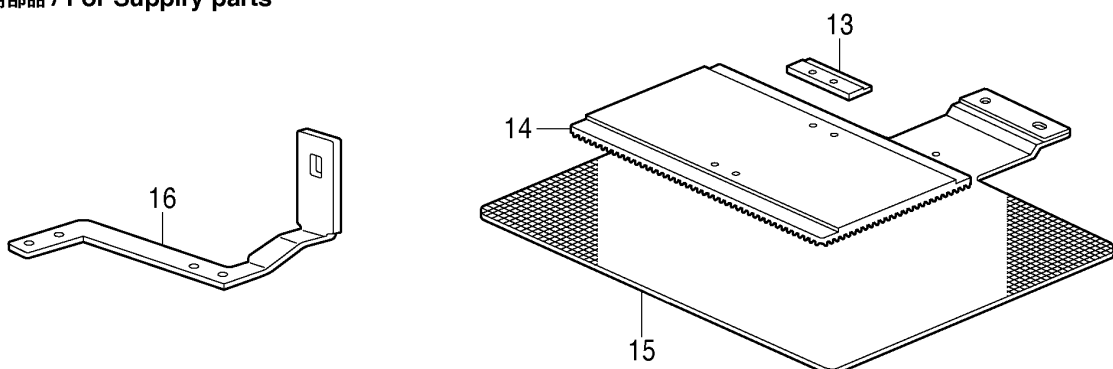
Inner clamping device

BAS-311F-0, 311F-L

Ref. No.	Part name	Part code	Qty
1	Inner clamping device set	S44793-009	1
1-1	Work clamp clank assy, LA	S12633-209	1
1-1-1	Work clamp crank holder, A	S12634-009	1
1-1-2	Work clamp crank holder, B	S12635-009	1
1-1-3	Work clamp crank holder, C	S12636-001	1
1-1-4	Spacer, crank holder	S12641-009	1
1-1-5	Bolt, socket SM4.37 – 40 x 12	018681-232	2
1-1-6	Reverse cylinder bracket	S12638-009	1
1-1-7	Bolt, socket M3 x 12	018301-236	2
1-1-8	Bolt, socket M3 x 10	018301-036	2
1-1-9	Work clamp clank, LA	S05665-001	1
1-1-10	Reverse gear	154235-001	1
1-1-11	Reverse rack	154236-001	1
1-1-12	Washer	145087-001	1
1-1-13	Set screw, SM3.18	149831-101	1
1-1-14	Work clamp plate holder, L	154237-001	1
1-1-15	Washer, plain S3.5	025350-132	1
1-1-16	Screw, SM3.57	100242-003	1
1-1-17	Reverse rod	S12637-009	1
1-1-18	Reverse cylinder	S12639-001	1
1-1-19	Bolt, socket M3 x 35	S12642-009	2
1-1-20	Joint	S12640-009	1
1-1-21	Bolt, socket M3 x 8	018300-836	1
1-1-22	Bolt, socket M3 x 8	018300-836	1
1-1-23	Bolt, M5 x 12	017501-216	1
1-1-24	Nut, 2 M5	021500-216	1
1-1-25	Half union, Q4M5	S18415-101	2
1-2	Outer work clamp, 312 – 1	S12643-001	1
1-3	Screw, flat SM3.18	117291-002	2
1-4	Positioning plate, L	154252-001	1
1-5	Positioning plate, R	154253-001	1
1-6	Screw, pan SM3.57 – 40 x 5	062670-512	4
1-7	Washer, plain L3.5	025350-332	4
1-8	Washer, spring 2 – 3.5	028350-242	4
1-9	Work clamp plate blank, A	154256-101	1
1-10	Feed plate blank, 312 – 1	S12645-001	1
1-11	Inner clamp valve assy, 3	S44745-009	1
1-11-1	Valve setting plate, 4 – 5H	S31570-209	1
1-11-2	Air manifold, 3	S44748-001	1
1-11-3	Screw, pan M3 x 25	062302-505	2
1-11-4	Washer, spring 2 – 3	028030-242	2
1-11-5	Washer, plain M3	025030-232	2
1-11-6	Solenoid valve	S43683-001	1
1-11-7	Valve harness, x 1	S43696-000	1
1-11-7-1	Valve harness	S44746-000	1
1-11-7-2	Valve harness, 24 V	S44750-000	1
1-11-8	Half union, Q4M5	S18415-101	2
1-11-9	Regulator assy	S45252-000	1
1-11-10	Joint, 3109-4-10	S45254-000	2
1-11-11	Screw, pan M4 x 40	062404-005	2
1-12	Bead band	340400-001	2
1-13	Air tube, 4L = 1300	S03803-000	2
1-14	Air tube, 4L = 300	S28741-000	1
	For supply parts		
	<For sewing the belt & hook>		
2	Needle plate, H	S13099-001	1
3	Feed dog, H	S13100-001	1
4	OT feed plate blank, 312	S14598-001	1
5	Outer work clamp foot, 312*2	S12644-001	1
6	Inner clamp, LL	S10542-001	1



" 補給用部品 / For Supply parts "



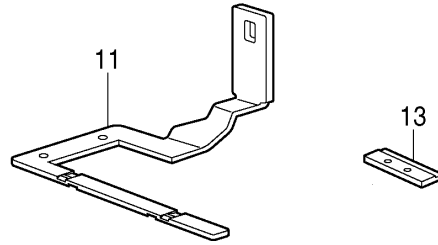
Inner clamping device

BAS-326F-0

Ref. No.	Part name	Part code	Qty
1	Inner clamping device set, 326F	S44793-009	1
1-1	Work clamp clank assy, LA	S12633-209	1
1-1-1	Work clamp crank holder, A	S12634-009	1
1-1-2	Work clamp crank holder, B	S12635-009	1
1-1-3	Work clamp crank holder, C	S12636-001	1
1-1-4	Spacer	S12641-009	1
1-1-5	Bolt, socket SM4.37 x 18	018681-232	2
1-1-6	Reverse cylinder bracket	S12638-009	1
1-1-7	Bolt, socket M3 x 12	018301-236	2
1-1-8	Bolt, socket M3 x 10	018301-036	2
1-1-9	Work clamp clank, LA	S05665-001	1
1-1-10	Reverse gear	154235-001	1
1-1-11	Reverse rack	154236-001	1
1-1-12	Washer	145087-001	1
1-1-13	Set screw, SM3.18	149831-101	1
1-1-14	Work clamp plate holder, L	154237-001	1
1-1-15	Washer, plain S3.5	025350-132	1
1-1-16	Screw, SM3.57-40 x 5	100242-003	1
1-1-17	Reverse rod	S12637-009	1
1-1-18	Reverse cylinder	S12639-001	1
1-1-19	Bolt, socket M3 x 35	S12642-009	2
1-1-20	Joint	S12640-009	1
1-1-21	Bolt, socket M3 x 8	018300-836	1
1-1-22	Bolt, socket M3 x 8	018300-836	1
1-1-23	Bolt, M5 x 12	017501-216	1
1-1-24	Nut, 2 M5	021500-216	1
1-1-25	Half union, Q4M5	S18415-101	2
1-1-26	Spacer, crank holder	S44424-001	1
1-2	Work clamp, outer :326F-1	S12643-001	1
1-3	Screw, flat SM3.18	117291-002	2
1-4	Positioning plate, L	154252-001	1
1-5	Positioning plate, R	154253-001	1
1-6	Screw, pan SM3.57 – 40 x 5	062670-512	4
1-7	Washer, plain L3.5	025350-332	4
1-8	Washer, spring 2 – 3.5	028350-242	4
1-9	Work clamp plate blank, A	154256-101	1
1-10	Feed plate blank, H	S12645-001	1
1-11	Inner clamp valve assy, 3	S44745-009	1
1-11-1	Setting plate, 4 – 5H :valve	S31570-209	1
1-11-2	Air manifold, 3	S44748-001	1
1-11-3	Screw, pan M3 x 25	062302-505	2
1-11-4	Washer, spring 2 – 3	028030-242	2
1-11-5	Washer, plain M3	025030-232	2
1-11-6	Solenoid valve	S43683-001	1
1-11-7	Valve hamess, x 1	S43696-000	1
1-11-7-1	Valve hamess	S44746-000	1
1-11-7-2	Valve hamess, 24 V	S44750-000	1
1-11-8	Half union, Q4M5	S18415-101	2
1-11-9-1	Regulator assy	S45252-000	1
1-11-9-2	Regulator	S45253-000	1
1-11-10	Joint, 3109-4-10	S45254-000	2
1-11-11	Screw, pan M4 x 40	062404-005	2
1-12	Bead band	340400-001	2
1-13	Air tube, 4L = 1300	S03803-000	2
1-14	Air tube, 4L = 300	S28741-000	1
	"For supply parts"		
13	Inner clamp, LL	S10542-001	1
14	Work clamp blank, A326L	S51077-001	1
15	OT-feed plate blank, H :326L	S51078-101	1
16	Work clamp, outer :326F-3	S57857-001	1

Option parts

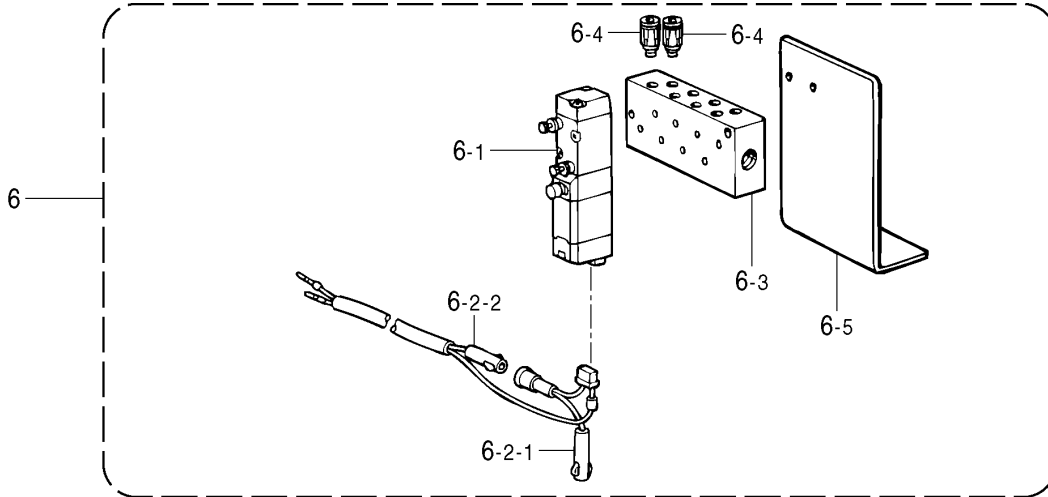
BAS-311F-0, 311F-L



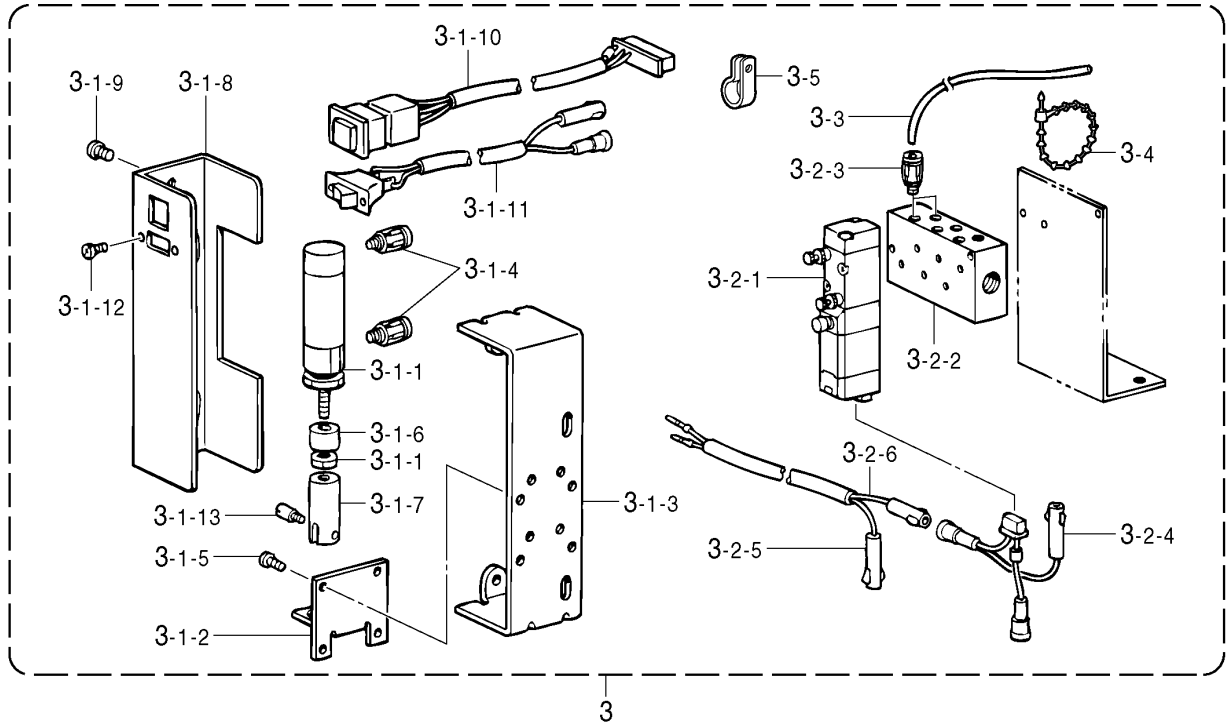
Ref. No.	Part name	Part code	Qty
11	Outer work clamp foot, 312-2	S12644-001	1
13	Inner clamp, LL	S10542-001	1

Solenoid valve

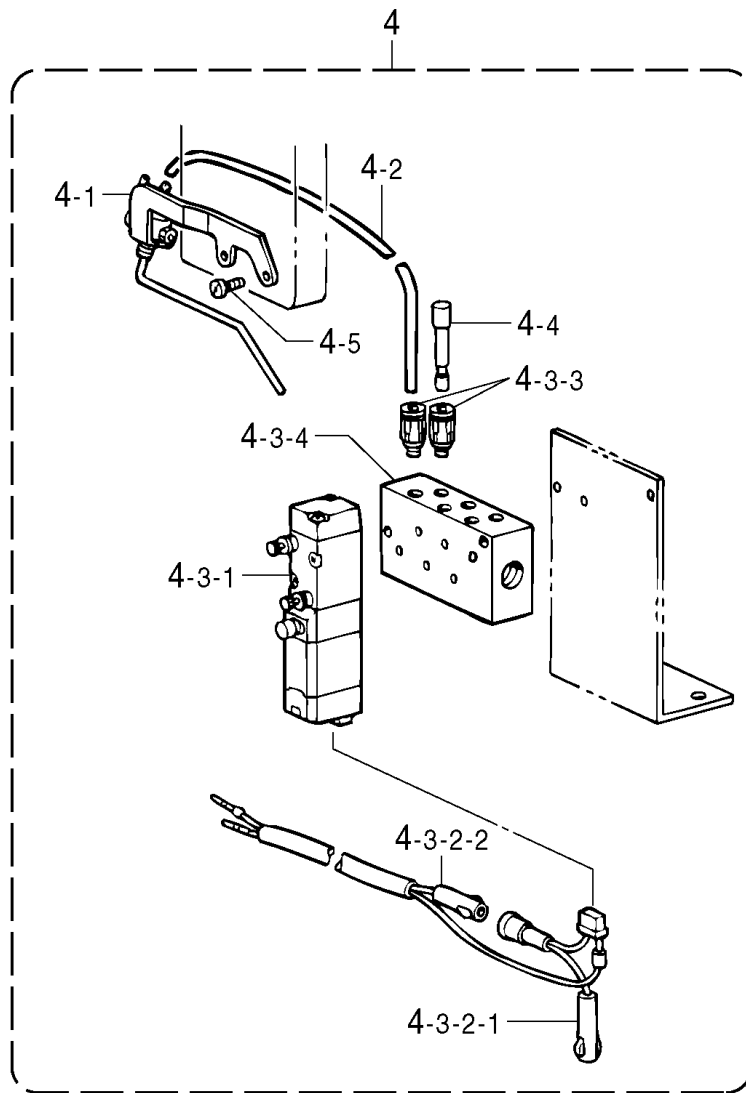
BAS-311F-0, 311F-L, 326F-0



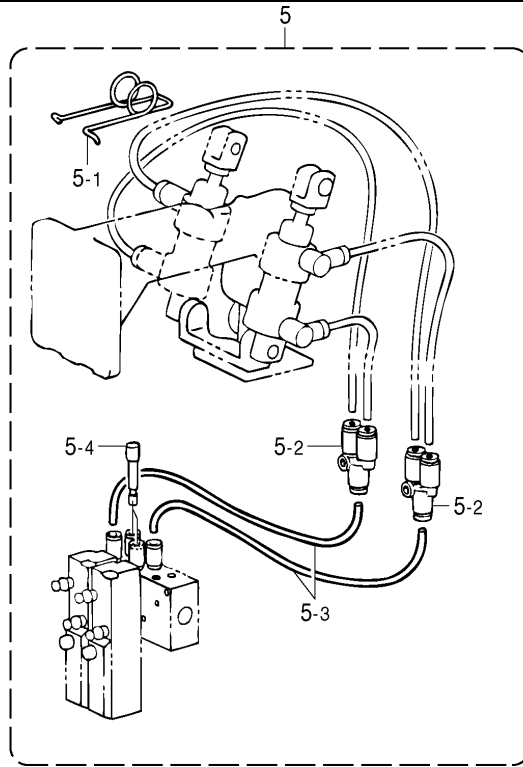
Ref. No.	Part name	Part code	Qty
6	Solenoid valve assy, OP4	S43847-201	1
6-1	Solenoid valve	S43683-001	1
6-2	Valve harness, x 1	S43696-000	1
6-2-1	Valve harness	S44746-000	1
6-2-2	Valve harness, 24V	S44750-000	1
6-3	Air manifold, 4	S44749-001	1
6-4	Half union, Q4M5	S18415-101	2
6-5	Setting plate, 4-5 valve	S31554-009	1



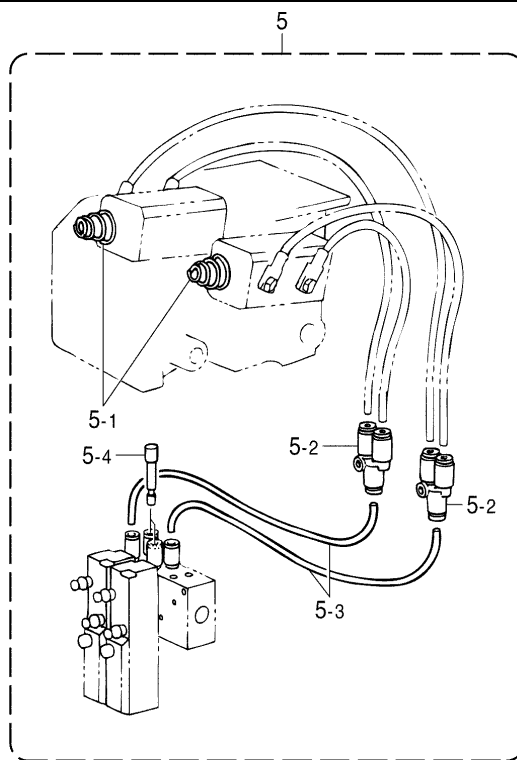
Ref. No.	Part name	Part code	Qty
3	TR. wiper set, pneumatic type	S43841-109	1
3-1	TR. wiper assy, pneumatic type	S43842-109	1
3-1-1	Air cylinder	S17942-100	1
3-1-2	Cylinder support plate	S31777-001	1
3-1-3	Setting plate, solenoid	S10214-109	1
3-1-4	Half union, Q4M5	S18415-101	2
3-1-5	Screw, pan SM3.57-40 x 6	062670-612	4
3-1-6	Stopper, cylinder	S31778-000	1
3-1-7	Joint, cylinder	S31779-001	1
3-1-8	Cylinder cover	S31776-109	1
3-1-9	Screw, pan SM4.37-40 x 5	062680-512	2
3-1-10	EM-switch assy	S43203-000	1
3-1-11	Thread wiper switch assy	S43843-009	1
3-1-12	Screw, pan M3 x 6	062300-612	2
3-1-13	Plunger pin	S02680-001	1
3-2	AW-solenoid valve assy, 3	S43844-001	1
3-2-1	Solenoid valve	S43683-001	1
3-2-2	Air manifold, 3	S44748-001	1
3-2-3	Half union, Q4M5	S18415-101	2
3-2-4	AW-valve harness, A	S44759-000	1
3-2-5	AW-valve harness, B	S44760-000	1
3-2-6	Valve harness, 24V	S44750-000	1
3-3	Air tube, 4L = 1900	S15031-008	2
3-4	Bead band	340400-001	7
3-5	Cord holder, 7N	149287-000	4



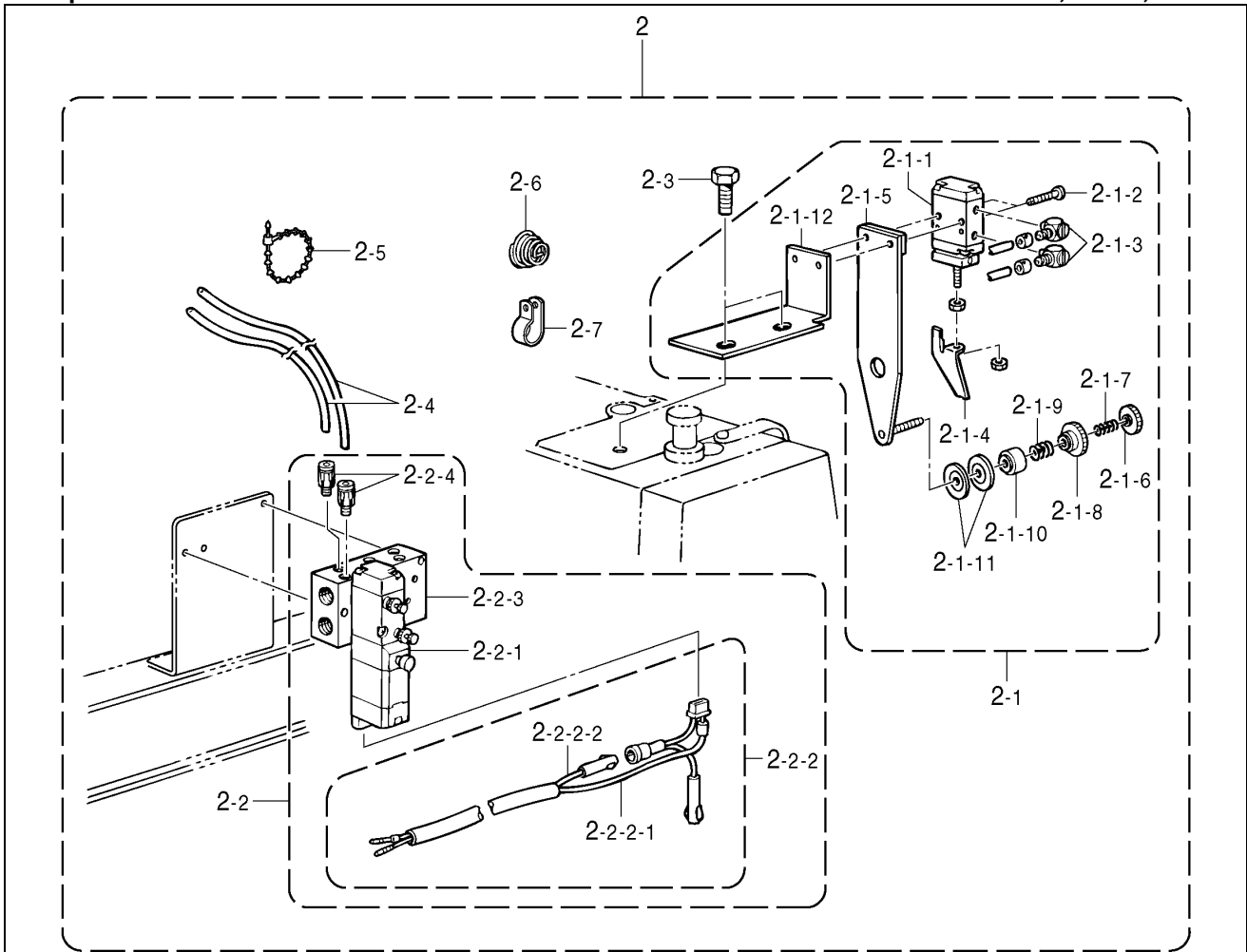
Ref. No.	Part name	Part code	Qty
4	Needle cooler set	S43846-009	1
4-1	Needle blower	S18027-101	1
4-4-2	Air tube, 4L=1900	S15031-008	1
4-3	Solenoid valve assy, OP3	S43839-008	1
4-3-1	Solenoid valve	S43683-001	1
4-3-2	Valve harness, x 1	S43696-000	1
4-3-2-1	Valve harness	S44746-000	1
4-3-2-2	Valve harness, 24V	S44750-000	1
4-3-3	Air manifold, 3	S44748-001	1
4-3-4	Half union, Q4M5	S18415-101	2
4-4	Plug, 4	S04897-000	1
4-5	Screw, pan SM3.57-40 x 8	062670-812	2



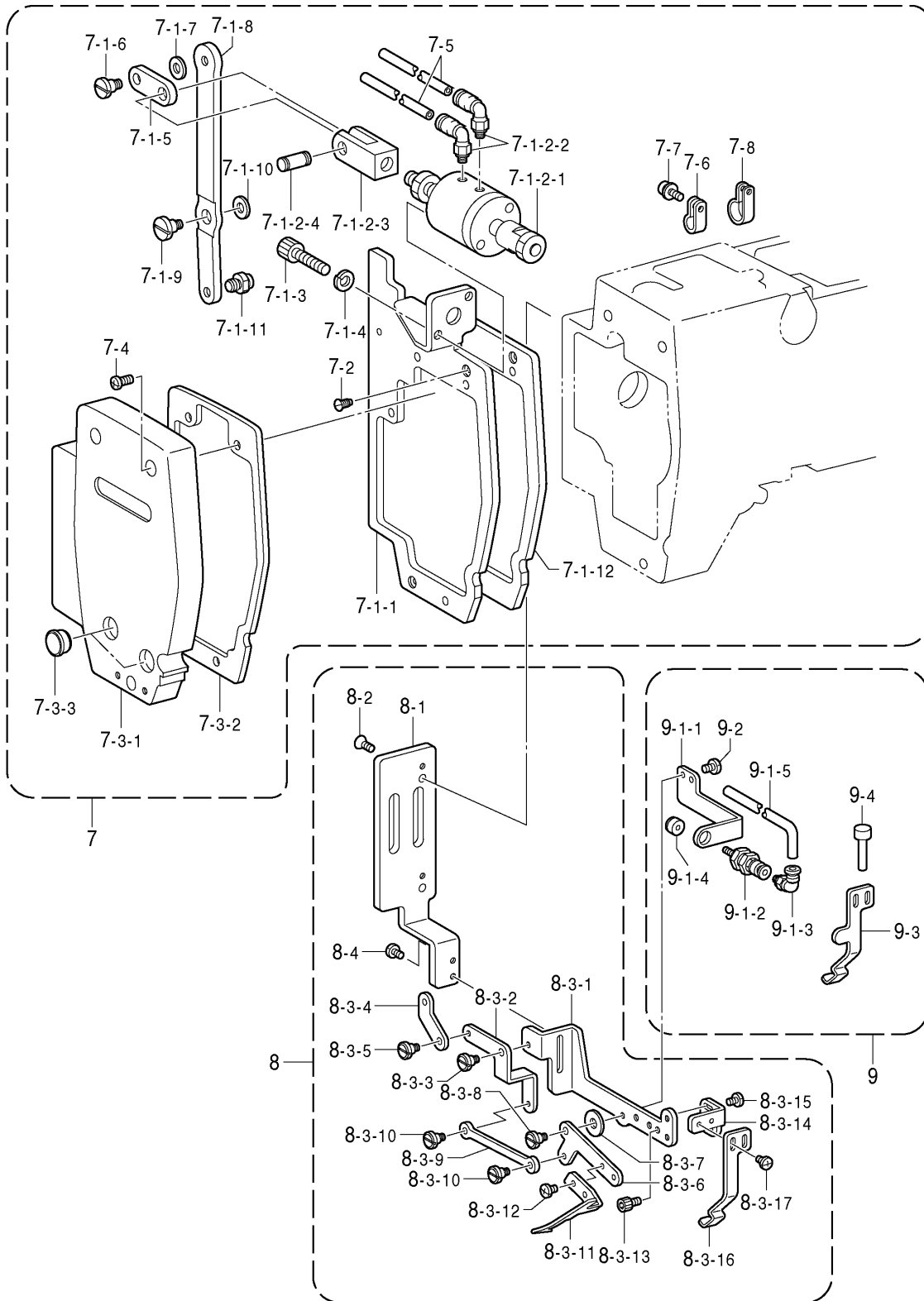
Ref. No.	Part name	Part code	Qty
5	Soft work clamp set	S43979-001	1
5-1	Spring	S43980-001	1
5-2	Union, Y4	S12104-000	2
5-3	Air tube, S-C (L=200)	S08140-000	2
5-4	Plug, 4	S04897-000	2



Ref. No.	Part name	Part code	Qty
5	Soft work clamp set	S44450-001	1
5-1	Spring	S44412-001	2
5-2	Union, Y4	S12104-000	2
5-3	Air tube, S-C (L=200)	S08140-000	2
5-4	Plug, 4	S04897-000	2



Ref. No.	Part name	Part code	Qty
2	2-step thread tension device set, 1	S43837-101	1
2-1	2-step thread tension assy	S43838-101	1
2-1-1	Air cylinder, 10 x 10	S34706-000	1
2-1-2	Bolt, socket M3 x 20	018302-032	2
2-1-3	Tube elbow, M-5HL-4	S12150-000	2
2-1-4	Countersink claw	S34533-001	1
2-1-5	Sub tension bracket assy	S34534-001	1
2-1-6	Tension nut	155510-001	1
2-1-7	Spring	146060-000	1
2-1-8	Pre-tension nut	146059-001	1
2-1-9	Pre-tension spring	146058-001	1
2-1-10	Disc presser, thread guide	146206-009	1
2-1-11	Disc, thread guide	144504-001	2
2-1-12	Cylinder setting bracket	S34536-001	1
2-2	Solenoid valve assy, OP3	S43839-005	1
2-2-1	Solenoid valve	S43683-001	1
2-2-2	Valve harness, x 1	S43696-000	1
2-2-2-1	Valve harness	S44746-000	1
2-2-2-2	Valve harness, 24V	S44750-000	1
2-2-3	Air manifold, 3	S44748-001	1
2-2-4	Half union, Q4M5	S18415-101	2
2-3	Bolt, SM7.94 x 18	017821-813	2
2-4	Air tube, 4L=1900	S15031-008	2
2-5	Bead band	340400-001	5
2-6	Spring, tension	104525-001	1
2-7	Cord holder, 7N	149287-000	3



<Thread release cylinder set>			
9	Thread release cylinder set	S53155-001	1
9-1	Thread release cylinder assy	S53080-001	1
9-1-1	Cylinder bracket	S53081-001	1
9-1-2	Cylinder, 6 x 5	S16996-000	1
9-1-3	Elbow, M5	S18382-000	1
9-1-4	Needle thread presser	S16997-100	1
9-1-5	Air tube, 4 x 2.5 L=1900	S15031-008	1
9-2	Screw, bind SM4.37-40 x 5	060680-512	2
9-3	TR-presser, S	S53082-001	1
9-4	Plug, 4	S04897-000	1

Auxiliary device (Option parts)

BAS-311F-0, 311F-L, 326F-0

Ref. No.	Part name	Part code	Qty
	<2-step work clamp device>		
7	2-step work clamp device, 311	S51436-001	1
7-1	2-step work clamp assy, 311	S51471-001	1
7-1-1	Spacer, 311	S51472-001	1
7-1-2	Cylinder assy, 25-10	S51473-000	1
7-1-2-1	Cylinder, 25-10	S51474-000	1
7-1-2-2	Elbow union, 4M5	S11426-000	2
7-1-2-3	Knuckle joint	S41523-000	1
7-1-2-4	Pin	S41524-000	1
7-1-3	Bolt, socket M6 x 20	018062-036	2
7-1-4	Washer, spring 2-6	028060-246	2
7-1-5	Link	S51476-001	1
7-1-6	Shoulder screw, SM6.35	150451-001	1
7-1-7	Washer, plain 6.5	153138-001	1
7-1-8	Lever	S51477-001	1
7-1-9	Shoulder screw, SM5.95	S19817-001	1
7-1-10	Washer, plain 6.5	153138-001	1
7-1-11	Roller shaft, w/screw SM6.35	S51478-001	1
7-1-12	Packing, 311	S51788-001	1
7-2	Screw, flat SM4.37-40x8	100032-004	3
7-3	Face plate assy, 2-SF :311	S51480-009	1
7-3-1	Packing, 2-SF	S51481-009	1
7-3-2	Packing, 2-SF	S51482-000	1
7-3-3	Rubber cap, 13.5	117934-001	2
7-4	Screw, pan SM4.76-32x14	062711-412	3
7-5	Air tube, 4x2.5L=1900	S15031-008	2
7-6	Cord holder, 6N	525664-000	1
7-7	Screw, pan (S/P washer) M4 x 8	0A5400806	1
7-8	Cord holder, 8N	525567-000	3
	<U-thread nipper device>		
8	U-thread nipper device	S53154-001	1
8-1	Solenoid base plate	S53071-001	1
8-2	Screw, flat SM4.37-40x8	100032-004	2
8-3-1	Thread nipper assy, 300E	S53070-001	1
8-3-1-1	Fulcrum plate, TR-nipper	S53072-001	1
8-3-1-2	Crank, TR-nipper	S53073-001	1
8-3-1-3	Shoulder screw, M4	S46842-001	1
8-3-1-4	Connecting rod, SOL	S53074-001	1
8-3-1-5	Shoulder screw, SM4.37	113730-001	1
8-3-1-6	Bracket, TR-nipper	S53075-001	1
8-3-1-7	Washer	S19543-001	1
8-3-1-8	Shoulder screw, M4	S46842-001	1
8-3-1-9	Connecting plate, TR-nipper	S53076-001	1
8-3-1-10	Shoulder screw, SM4.37	113730-001	2
8-3-1-11	U-thread nipper	S53077-001	1
8-3-1-12	Screw, bind SM3.57-40 x 5	060670-512	2
8-3-1-13	Bolt, socket SM4.37	018680-522	1
8-3-1-14	Bracket, TR-presser	S53078-001	1
8-3-1-15	Screw, bind SM3.57 40 x 5	060670-512	2
8-3-1-16	TR-presser	S53079-001	1
8-3-1-17	Screw, bind SM3.57-40 x 5	060670-512	2
8-4	Screw, bind SM3.57-40 x 5	060680-512	2

GAUGE PARTS LIST

Presser foot

BAS-311F-0, 311F-L, 326F-0

Ref. No. A ★	Ref. No. B	Ref. No. C	Ref. No. D
Ref. No. E	Ref. No. F	Ref. No. G	Ref. No. J
Ref. No. XA			

Needle hole plate

BAS-311F-0, 311F-L, 326F-0

Ref. No. A	Ref. No. D	Ref. No. E ★	Ref. No. ED	Ref. No. F ★
Ref. No. FD	Ref. No. H	Ref. No. L	Ref. No. M ★	Ref. No. FM
Ref. No. 3 ザゲリ	Ref. No. A-F			














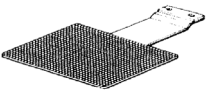
GAUGE PARTS LIST
















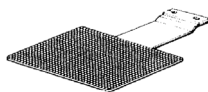
BAS-311F-0, 311F-L, 326F-0

Ref. No.	Part name	Part code	Qty
A	Presser foot, A	S42843-001	1
	"OPTION PARTS"		
B	Presser foot, B	S42844-001	1
C	Presser foot, C	S42845-001	1
D	Presser foot, D	S42846-001	1
E	Presser foot, E	S42847-001	1
F	Presser foot, F	157237-001	1
G	Presser foot, G	158592-001	1
J	Presser foot, J	S42848-001	1
	<For Horizontal wiper>		
XA	Presser foot, XA	S42849-101	1
	<311F for Heavy-weight materials>		
E	Needle hole plate, E ϕ 2.6	S10212-101	1
	<311F for Medium-weight materials>		
F	Needle hole plate, F ϕ 2.2	S10213-001	1
	<311F for Extra heavy-weight materials>		
M	Needle hole plate, M ϕ 4.0	S34348-001	1
	"OPTION PARTS"		
A	Needle hole plate, A ϕ 1.6	S10211-001	1
D	Needle hole plate, D ϕ 2.6	S29997-001	1
ED	Needle hole plate, ED ϕ 3.4	S30925-001	1
FD	Needle hole plate, FD ϕ 2.2	S30926-001	1
H	Needle hole plate, H ϕ 2.6	S30450-001	1
L	Needle hole plate, L ϕ 3.3	S25127-001	1
FM	Needle hole plate, FM ϕ 2.2	S49980-001	1
3	Needle hole plate, 3 ϕ 3.0	S40217-001	1
A-F	Needle hole plate, A-F ϕ 1.6	S51449-001	1

*The parts marked with ★ are standard parts

BAS-311F-0, 311F-L

Subclass	BAS-311F-0			BAS-311F-0, -L	
	1S, 4S	2A	3A	1A, 4A	
Part name / Specification	Heavy materials (Solenoid type)	Medium materials (Pneumatic type)	Extra heavy materials (Pneumatic type)	Heavy materials (Pneumatic type)	
Needle hole plate 	(ϕ 2.6) S10212-101 E	(ϕ 2.2) S10213-001 F	(ϕ 4.0) S34348-001 M	(ϕ 2.6) S10212-101 E	
Bobbin case assy	S59221-001 LC		S59222-001 LD	S59221-001 LC	
Tension spring	S48664-001 AN		S16075-101 B	S48664-001 AN	
Screw 	S16492-101				
Spring, antispin 	S15667-001				
Bobbin 	S15665-001 LA		S15666-001 LB	S15665-001 LA	
Inner rotary hook assy 	SA1890-001 LG	SA2173-001 LF	SA1890-001 LG		
Large shuttle hook 	152686-101 B	152682-101 A	152686-101 B		
Tension spring  	115188-001		107606-001	115188-001	
	107606-001	104525-001	S06548-001	107606-001	
Spring 	144588-001 B	154419-001	144588-001 B		
Needle bar thread guide  	S02438-001 A		S02439-001 B	S02438-001 A	
Needle assy	SA1645-021	SA1752-016	SA1645-025	BAS-311F-0	BAS-311F-L
				SA1645-021	SA1645-019
Needle 	DPx17#21 145646-021	DPx5#16 107415-016	DPx17#25 145646-025	DPx17#21 145646-021	DPx17#19 145646-019
Presser foot 	S42843-001A		S42844-001 B	S42843-001 A	
Feed plate 	S55163-001 B	S55162-001 A	S55163-001 B	BAS-311F-0	BAS-311F-L
				S55163-001 B	S55941-001 LB

		BAS-326F-0		
Subclass		1A	2A	4A
Part name / Specification		厚物 Heavy materials	中厚物 Medium materials	厚物 Heavy materials
Needle hole plate 		(φ2.6) S10212-101 E	(φ2.2) S10213-001 F	(φ2.6) S10212-101 E
Bobbin case assy 		S59221-001 LC		
Tension spring 		S48664-001 AN		
Screw 		S16492-101		
Spring, antispin 		S15667-001		
Bobbin 		S15665-001 LA		
Inner rotary hook assy 		SA1890-001 LG	SA2173-001 LF	SA1890-001 LG
Large shuttle hook 		152686-101 B	152682-101 A	152686-101 B
Tension spring  		115188-001		
		107606-001	104525-001	107606-001
Spring 		144588-001 B	154419-001	144588-001 B
Needle bar thread guide  		S02438-001 A		
Needle assy		SA1645-021	SA1752-016	SA1645-021
Needle 		DPx17#21 145646-021	DPx5#16 107415-016	DPx17#21 145646-021
Presser foot 		S42843-001A		
Feed plate 		S55953-001 B	S55952-001 A	S55953-001 B