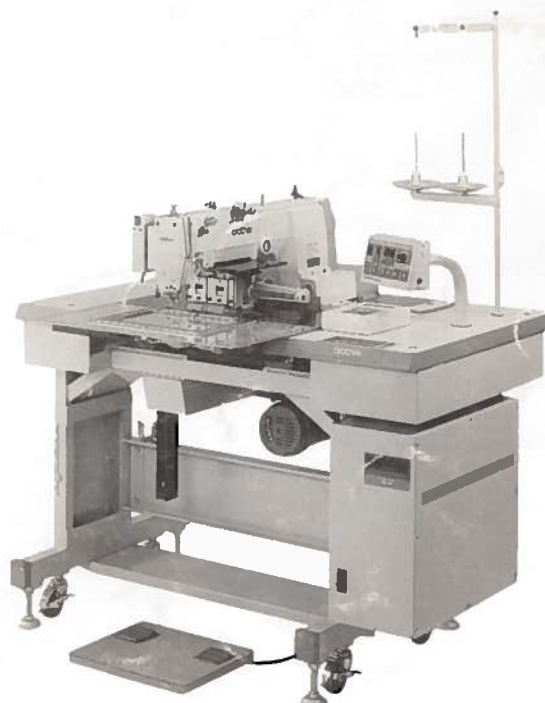


**BAS-300 Series**  
**Programmable electronic pattern**  
**sewer with cylinder bed**

**BAS-304·311**  
**BAS-326·340**

**APPLICATION EXAMPLES**





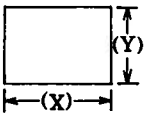
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# Basic Specifications Table for the BAS-300 Series

Model	BAS-304	BAS-311	BAS-326	BAS-340
<b>Specifications</b> Sewing range (mm) 	(X) (Y) 50 x 50	(X) (Y) 100 x 60 · Uses presser reverse MAX 100 x 60 MIN 20 x 13	(X) (Y) 150 x 100 ※(L) 180 x 100 · Uses presser reverse MAX 150 x 90 MIN 20 x 13 ※(L) MAX 180 x 90 MIN 20 x 13	(X) (Y) 250 x 150 · Uses presser reverse MAX 100 x 60 MIN 20 x 13
Sewing speed (max. spm)	2000			
Stitch pitch and speed	1000-2000spm - 0.2-3.0mm 750-1500spm - 3.2-4.4mm 600-1200spm - 4.6-6.2mm 600- 800spm - 6.4-8.0mm			1000-2000spm - 0.1-3.0mm 750-1500spm - 3.1-4.4mm 600-1000spm - 4.5-6.3mm 600spm - 6.4-12.7mm
Max. no. of needles	2000			4000
Presser lifting height (mm)	18	18 (Air type: 20)	20	30
Rotary hook	Half rotation (double hook)			
Pattern data storage	3.5" floppy disk			
Intermittent presser stroke (mm)	0, 4, 7 can be selected			0, 3, 8
Feed method	X-Y intermittence 1 pulse 0.2			X-Y intermittence 1 pulse 0.1
Testing equipment	Built-in operation test function for low and high speeds; taking out stitches during sewing possible			
Safety equipment	Built-in stopping function, built-in automatic stopping mechanism for when safety circuit detects occurrence of a problem			
Power supply	Single-phase:100V 3-phase:200V			
Specifications	Solenoid-type	Solenoid-type Air-type Compressor Y/N		Air-type
Programming machine	Programming machine Y/N			

1912-1913

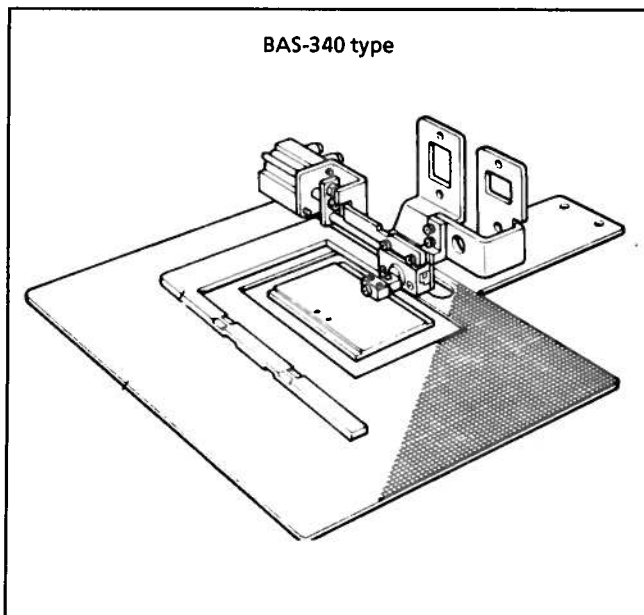
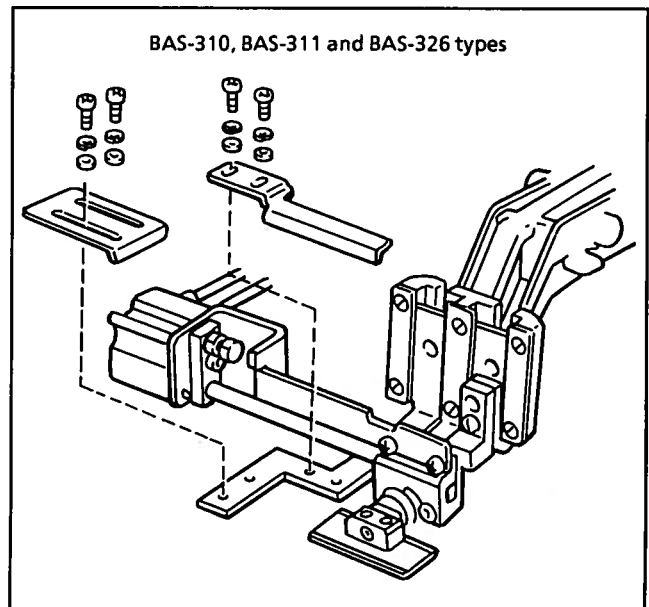
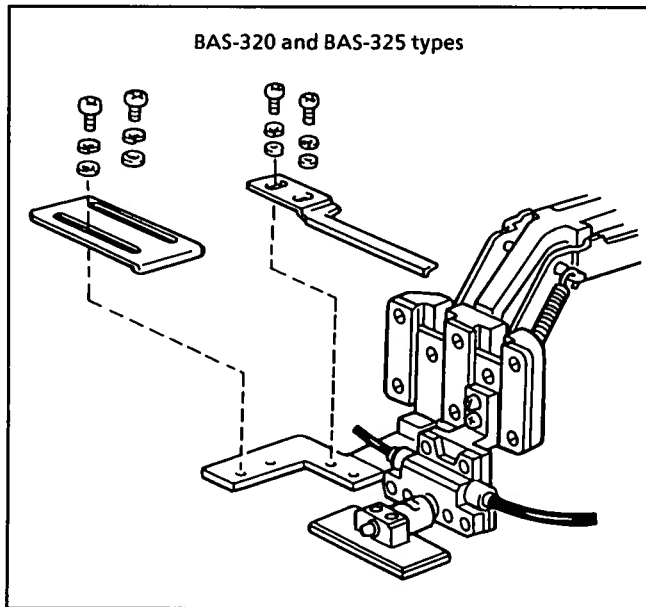
1912-1913

# 1. Label Sewing

BAS-311·326·340

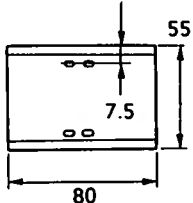
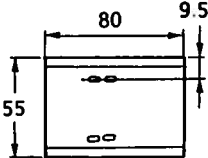
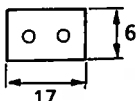
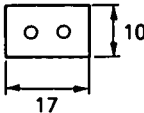

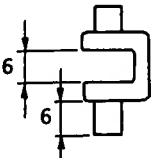
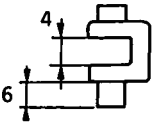
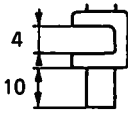
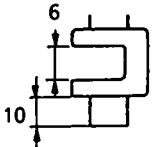
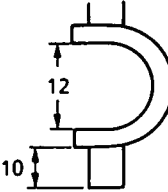
To perform label sewing, attach the inner clamp reverse device to the sewing machine. The inner clamp device is available as an option for each model as follows:

## Reverse device (Option)



- ※ For BAS-310 S12651-001
- For BAS-311 S12651-101
- For BAS-320 S05650-001
- For BAS-325 S09569-001
- For BAS-326 S15522-001
- For BAS-340 S19994-001

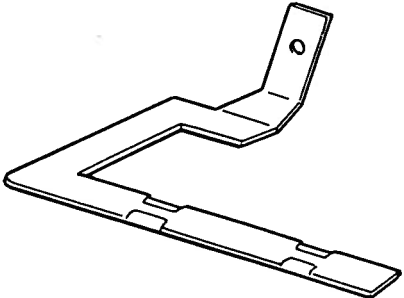
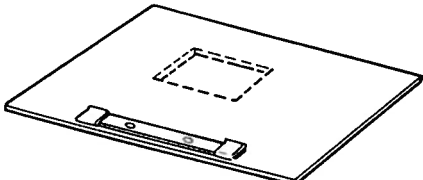
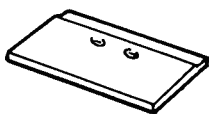
## Presser Plate Blank, Presser Plate Holder and Work Clamp Crank (Option)

Presser plate blank	<p>156492-000</p> 	<p>154256-001</p> 			
Presser plate holder	<p>S type 154291-001</p> 	<p>L type 154237-001</p> 	<p>※ Presser plate holder screws</p> <p>Screw: 2 pcs </p> <p>117291-001</p>		
Presser crank	<p>SS type S04516-001</p> 	<p>S type 154297-001</p> 	<p>L type 154234-001</p> 	<p>LA type S05665-001</p>  <p>Note 1</p>	<p>LL type S10541-001</p>  <p>Note 2</p>

### Notes

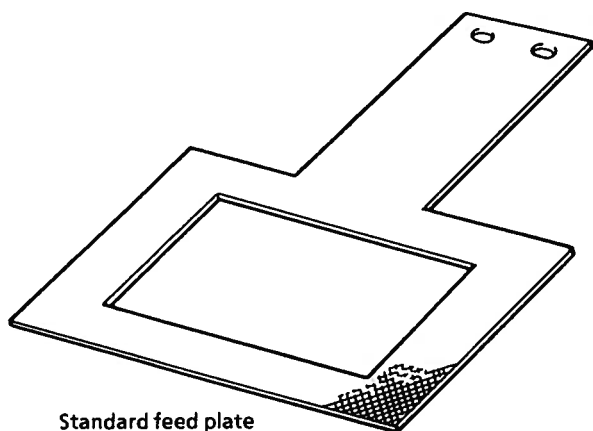
1. This is the standard crank for each inner clamp reverse device assembly.
2. This can be used for zigzag sewing using the presser foot.

## Other optional parts

External presser foot	OT presser plate assembly	Inner clamp LL
S12644-001	157251-001 (t = 2 mm)	S10542-001
 <p>※ When sewing a label to a plain part, it is advisable to use this presser foot together with the OT presser plate for easier positioning.</p>		 <p>Note: This inner clamp is made to the smallest size. It is advisable to make an inner clamp from a plastic plate and paste it to the reverse surface of the inner clamp LL by means of tape or super glue, which is easier than using an iron plate.</p>

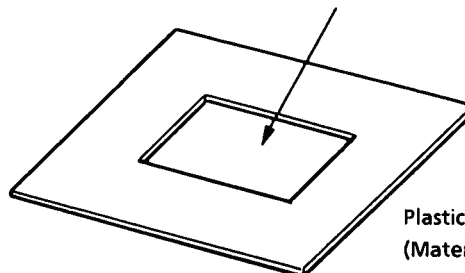


## Processing the feed plate



Standard feed plate

ネーム外形寸法と  
Make it to the size of the outside dimension of the label.

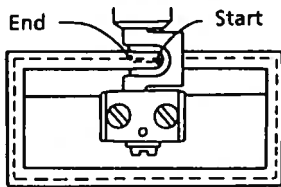



Plastic plate  $t = 1$  mm  
(Material: ABS)

Make the plastic plate so that the outside can fit  
in the inside of the feed plate.

## Collection of Sewing Examples

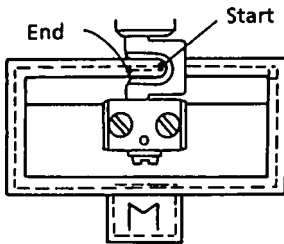
### Square label sewing



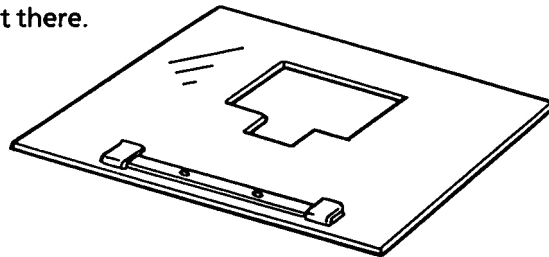
- Be sure to start programming from the start position as shown in the left-hand figure.
- It is advisable to use the  key on the programmer device for easier operation.
- Make a back stitch within the crank range as shown in the left-hand figure.

Cycle time	10 sec
Productivity	About 2,000 pcs/day

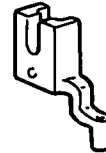
### Square label and sub-label sewing



- Process the OT presser plate so that the sub-label can fit there.



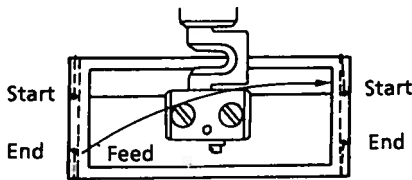
- Using the presser foot C prevents skipped stitches.



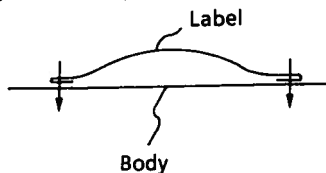
Presser foot C  
152637-001

Cycle time	15 sec
Productivity	About 1,300 pcs/day

### Vertical double label sewing



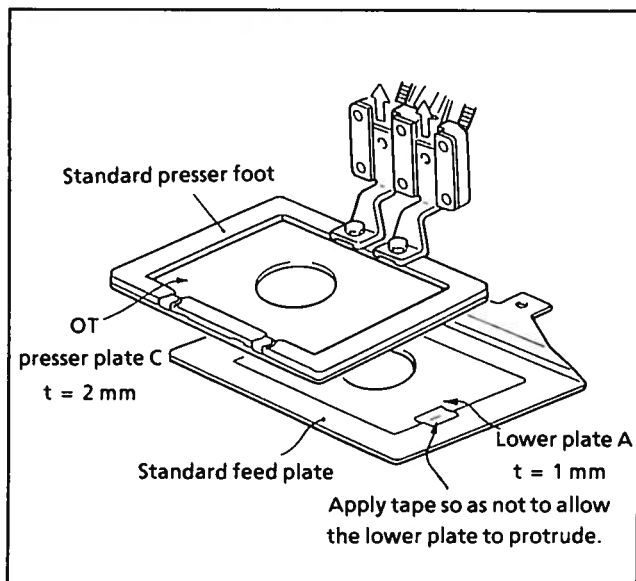
※ Floating label sewing



- After sewing the left side, cut the thread, feed the material and start sewing the right side.
- If there are too many bird's nests in the thread remainings on the reverse side of the material or if thread trimming is intended to be carried out later, the program (999L) that keeps the thread cutter inactive is available.
- To make a floating name sewing for knitted materials, keep pulling the material slightly while sewing.

Cycle time	12 sec
Productivity	About 1,680 pcs/day

### Sewing procedure

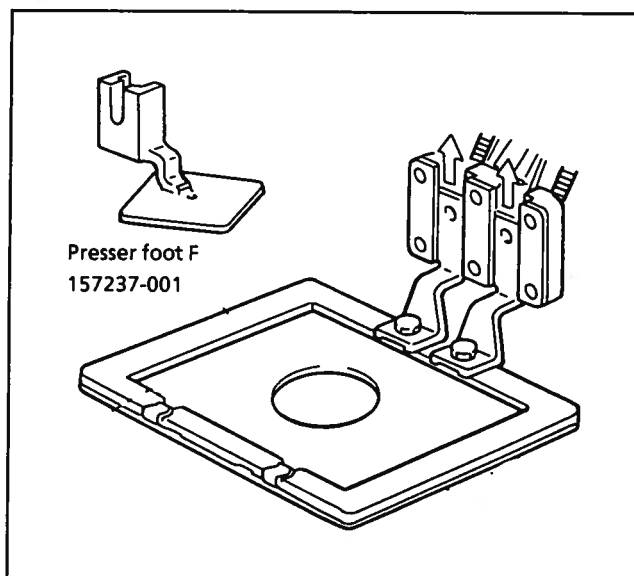
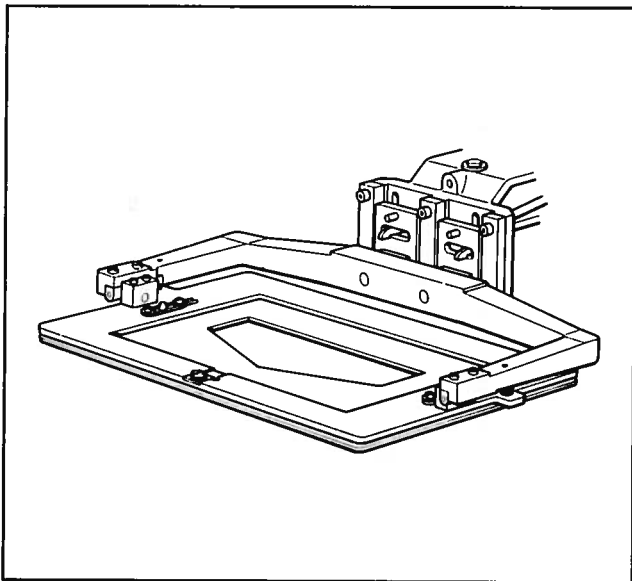


#### [Machining the OT clamp plate]

1. Process the OT presser plate to the same dimensions as the outside of the emblem to be sewn.  
 ※ Use a punch cutter or a thread saw.
2. Make an lower plate with the same dimensions as the feed plate.  
 ※ Process the lower plate so that its dimensions are the same as those of the OT presser plate which is to be positioned above the lower plate.

#### [Programming]

1. Attach presser foot A before programming.
2. If the stitching is programmed so that presser foot A can pass smoothly through the hole of the processed OT presser plate, the seam margin will be about 2 mm.

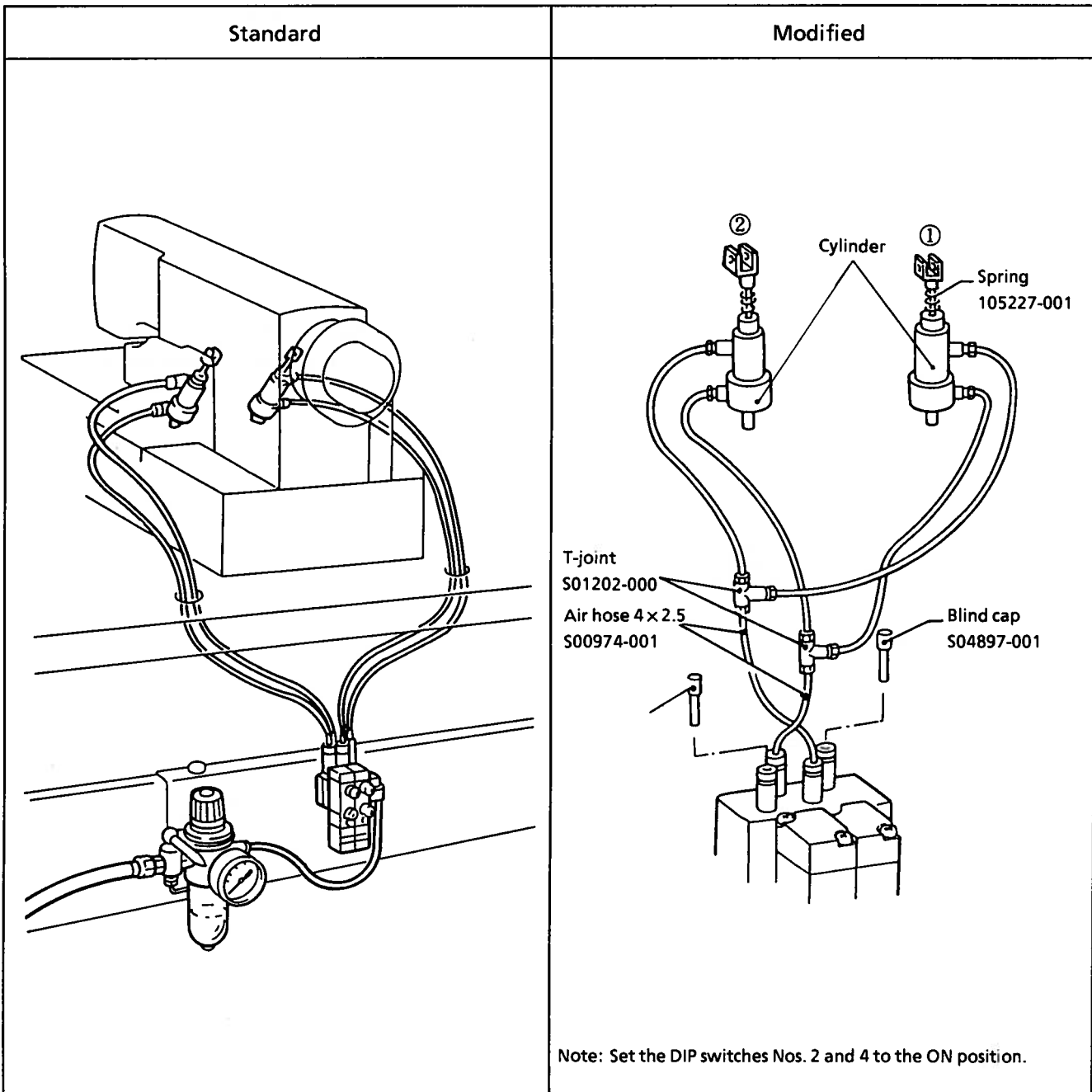


#### [Sewing]

1. When using the presser foot F, set the intermittent stroke to "0".
2. If presser foot F is used, a slight pressing can be applied while sewing.

## Two-stage positioning presser clamp

- If the emblem has already been pasted to the body, it is advisable to set the clamp in the two-stage positioning press for easier positioning and emblem sewing.
- This can be used for sewing large-sized materials for which the sewing position is hard to determine.



### [Operation Method]

- 1) If the foot switch pedal is depressed to the first stage, the cylinder air will be released and the clamp will be lowered by the spring pressure.  
 ※ The material is not yet pressed at this stage.
- 2) If the foot switch pedal is depressed to the second stage, air will enter the cylinder and both clamps will firmly press the material.
- 3) Then, if the foot switch pedal is depressed again, both clamps will be raised.

### 3. Snap and Hook Sewing



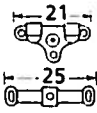
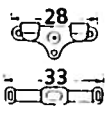
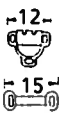


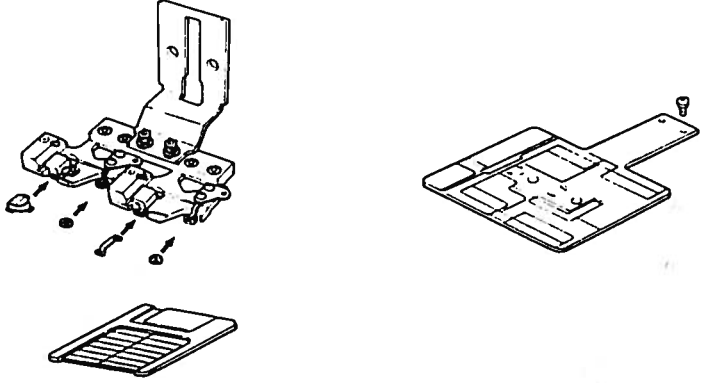
BAS-304·311

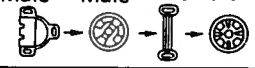

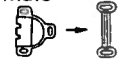

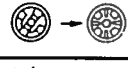
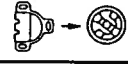
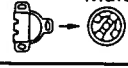
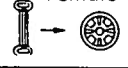
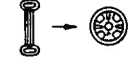
#### BAS-304 and 311

BAS-311-04 is a snap and hook type.

For standard specifications, a M-580K hook and an OMØ8.6 snap are used.

(Made by Oishi Kinzoku)









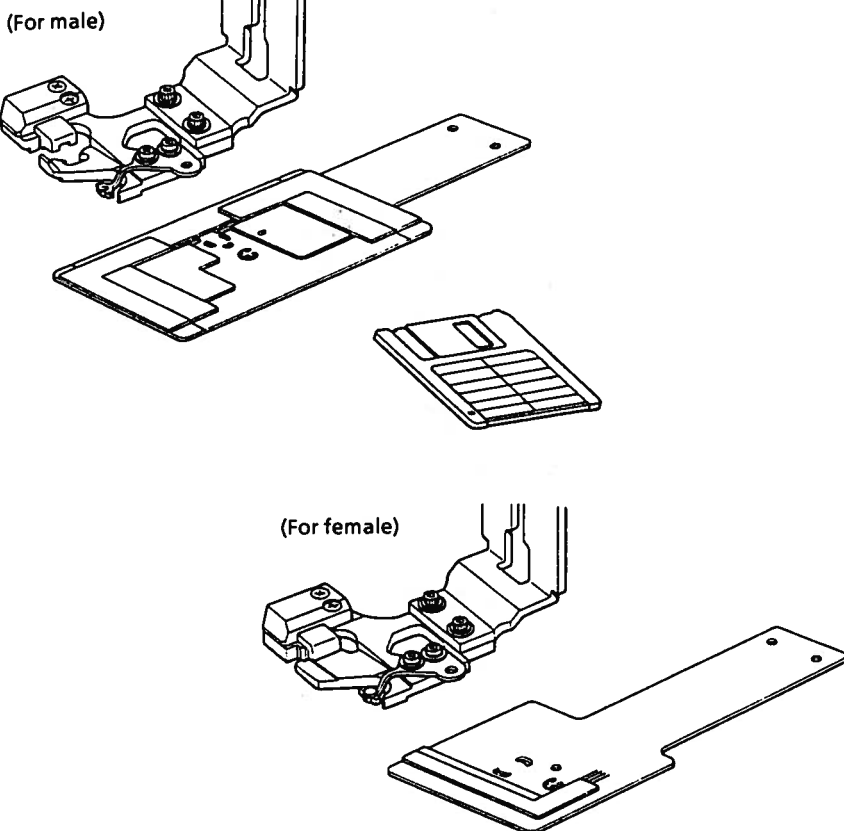
Parts name	Snap and hook unit				
	For M-508K	For M-520K	For M-525K	For M-533K	For M-528K
Parts code	S10477-001	S12572-001	S12573-001	S13110-001	S12571-001
Hook size (mm)					
Snap size (mm)	(OM Ø8.6) 				(OM Ø7.6) 
					

Program No.	Sewing order (Snap: 8.6Ø)	Program No.	Sewing order (Snap: 7.6Ø)
1	Male Male Female Female 	6	Male Male Female Female 
2	Male Female 	7	Male Female 
3	Male Female 	8	Male Male 
4	Male Male 	9	Female Female 
5	Female Female 		

Note: When changing or modifying the stitching, connect the programming machine provided as standard to the sewing machine.

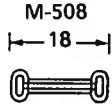
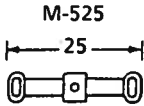

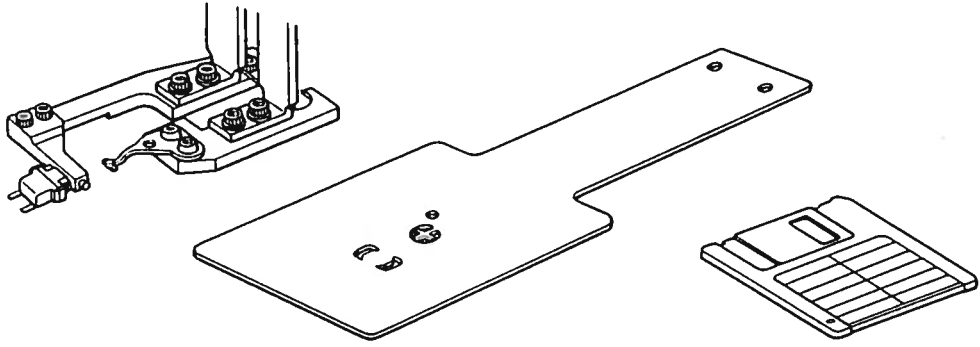
# BAS-304 and 311

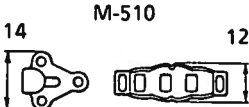
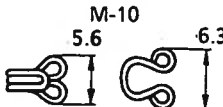
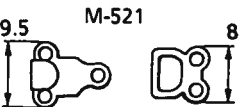

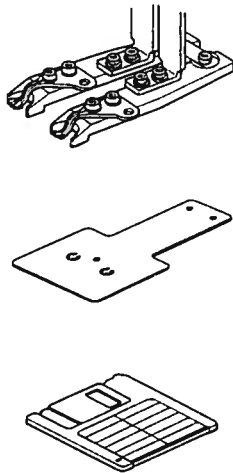
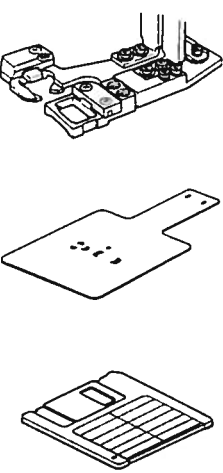
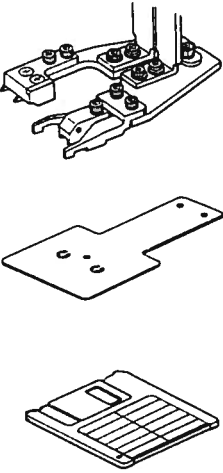
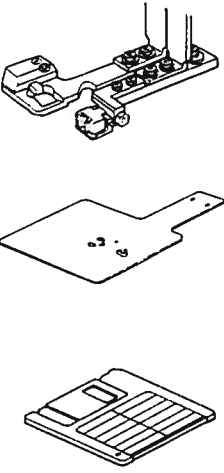
(Made by Oishi Kinzoku)

Parts name	310-HS unit			
Parts code	S18581-001	S18590-001	S18598-001	S18606-001
Hook size (mm)	M-508 (Male) 	M-508 (Female) 	M-525 (Male) 	M-525 (Female) 
Snap size (mm)	OM $\varnothing$ 7.6, $\varnothing$ 8.6 (Male) 	OM $\varnothing$ 7.6, $\varnothing$ 8.6 (Female) 	OM $\varnothing$ 7.6, $\varnothing$ 8.6 (Male) 	OM $\varnothing$ 7.6, $\varnothing$ 8.6 (Female) 
Shape				

# BAS-304 and 311



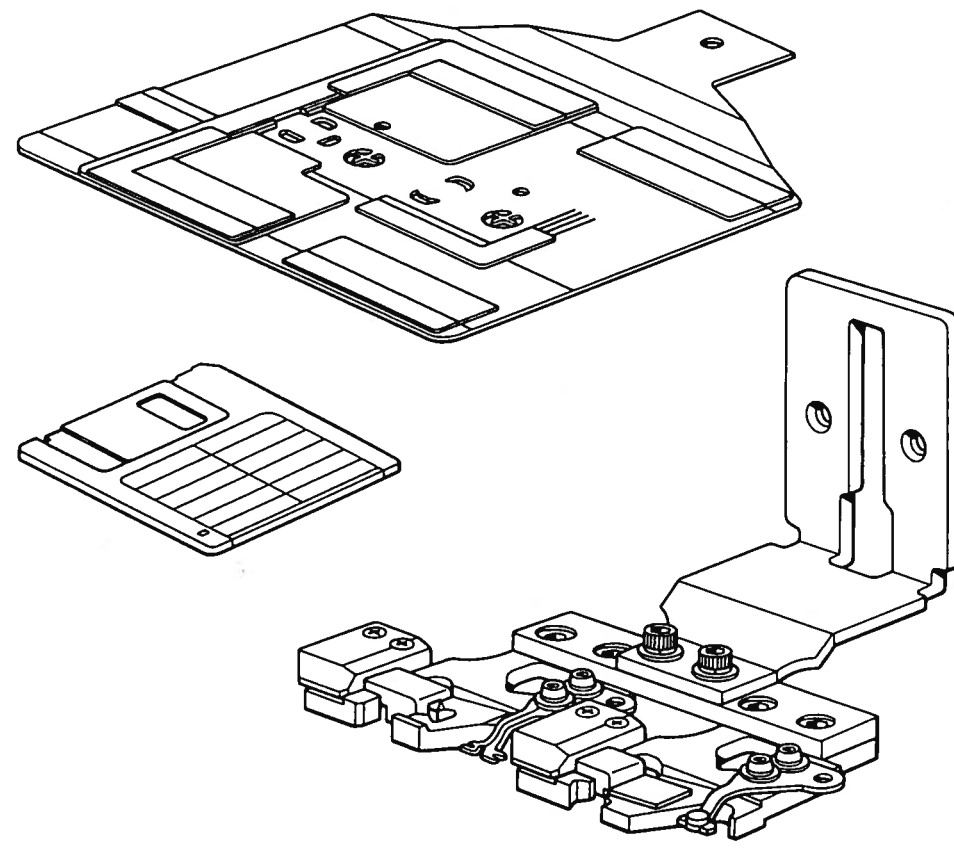
(Made by Oishi Kinzoku)

Parts name	310-AS unit	
Parts code	S18614-001	S18621-001
Hook size (mm)	M-508 18 	M-525 25 
Snap size (mm)	OM $\varnothing$ 7.6, $\varnothing$ 8.6 (Female) 	
Shape		

Parts name	310-SW unit	310-HE unit		
Parts code	S21553-001	S21559-001	S21565-001	S21591-001
Hook size (mm)	—	M-510 14 12 	M-10 5.6 6.3 	M-521 9.5 8 
Snap size (mm)	OM $\varnothing$ 7.6, $\varnothing$ 8.6 	—	—	—
Shape				

# BAS-311 and 326

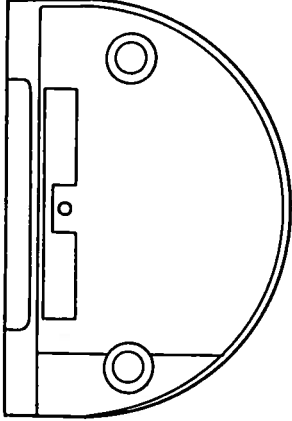
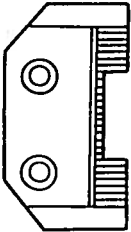
(Made by Oishi Kinzoku)

Parts name	326-SH unit
Parts code	S09645-001
Hook size (mm)	
Snap size (mm)	<p>OM<math>\phi</math>7.6, <math>\phi</math>8.6 (Female)</p> 
Shape	

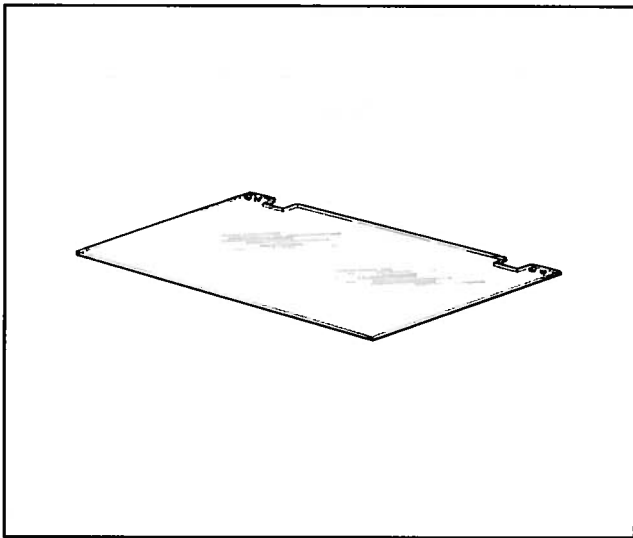


**Reference**

Belt part hook sewing attachments for plain sewer with automatic thread trimmer

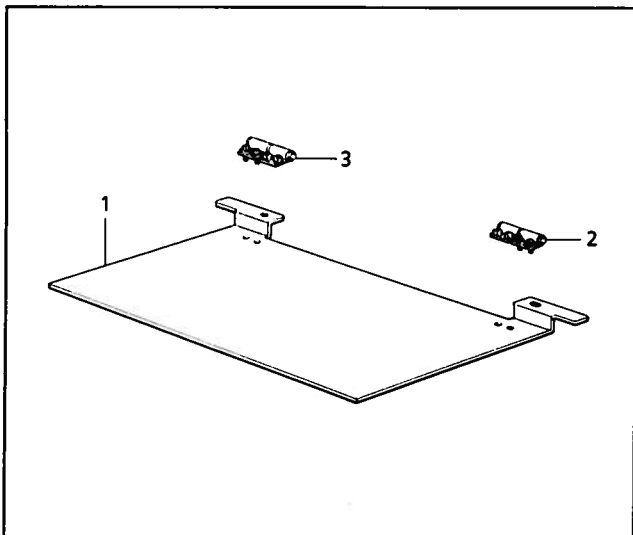
Parts name	Parts code	Shape
Needle plate H	S13099-001	
Feed dog H	S13100-001	

## Making the Clamp

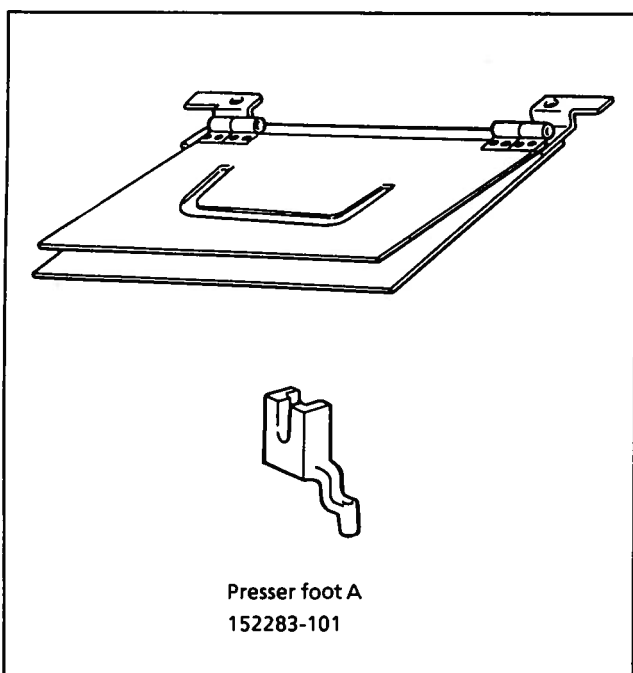


1) When making the clamp, use the parts provided as cassette-type optional parts.

- Cassette plate U-A (t = 1)  
S02968-001
- Cassette plate U-B (t = 2)  
S02971-001



- 1 Cassette plate D-A  
S02966-001
- 2 Butterfly program (right)  
152632-001
- 3 Butterfly program (left)  
152633-001

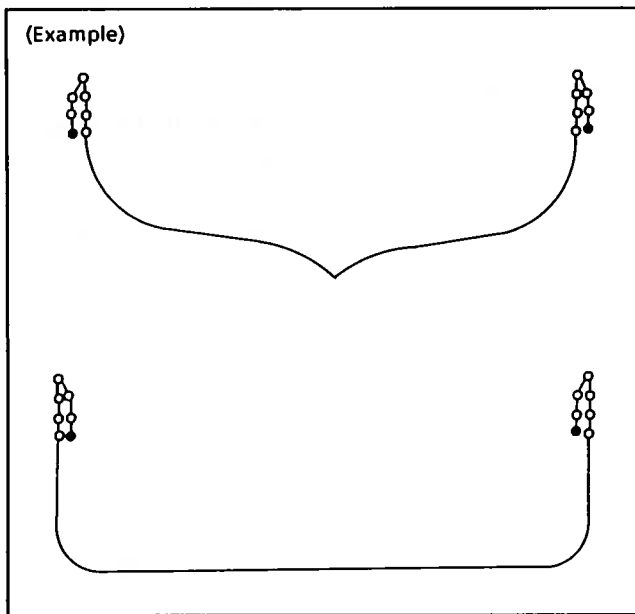


2) When using presser foot A for sewing, because the outside diameter of presser foot A is 4mm, process the width of the cassette plate groove to be 5mm.

NOTE: Use a punch cutter or a thread saw for processing.

3) If the material being sewn slips during sewing, sewing can be carried out more easily if sandpaper or thin rubber is stuck to the lower surface of the cassette plate U and the upper surface of the cassette plate D.


## Programming Procedure



- 1) Set a stitch diagram such as the ones shown at left between the cassette plates U and D.

NOTE: Secure the stitch diagram with tape, etc., so that it does not move.

- 2) Use the feed key on the programmer machine to program so that the end of the needle follows the stitch line.

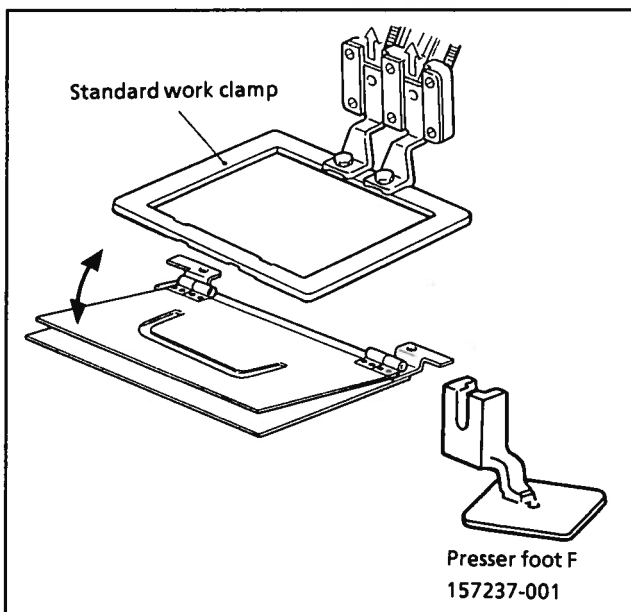
At this time, programming will be easier if the line key (  ) is used along straight lines and the smoothing function is used along curved lines.

NOTE: For the BAS-325, the trace function can be used for programming.

- 3) After programming, attach the presser foot A, and give a test run to the sewing machine to make sure that presser foot A passes smoothly along the center of the cassette plate groove.

If any interference is found, adjust the cassette plate or the program to clear the interference.

## Sewing



- 1) When sewing, press the cassette plate from the top with the standard work clamp.

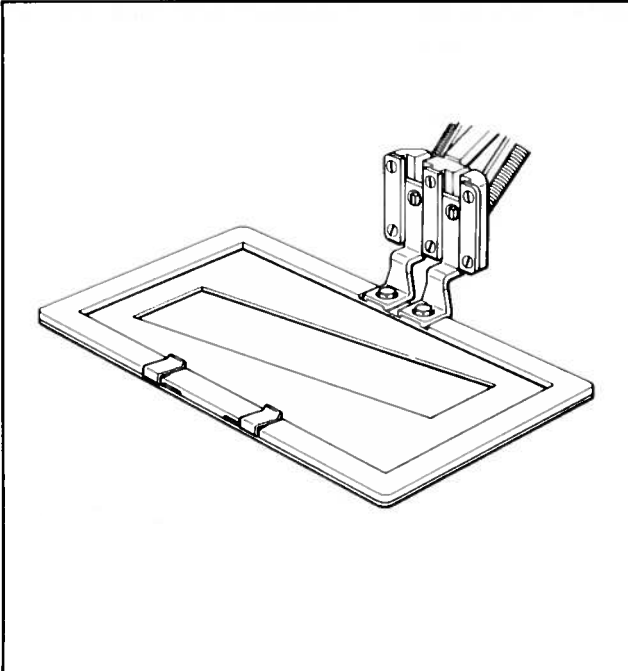
- 2) When using the presser foot F, set the intermittent presser stroke at "0", and keep pressing the cassette plate during sewing.

## 5. Breast Pocket Trim Sewing

BAS-311-326-340

Before programming, make sure that the length, width and angle of the breast pocket have been finished to the specified dimensions.

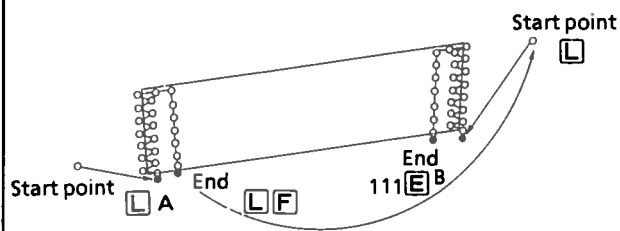
### If There Are No Dimension Differences



#### [Work Clamp]

- 1) Process the OT presser plate to match the length, width and angle of the breast pocket.
- 2) If the lower surface of the OT presser plate is positioned, sewing can be carried out easily.

(Example)

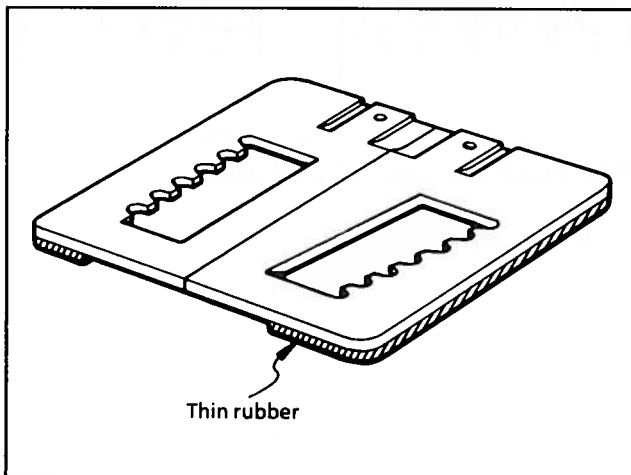


#### [Programming]

If there is no difference in the breast pocket dimensions (size) on sides A and B, both sides can be sewn in a single cycle.

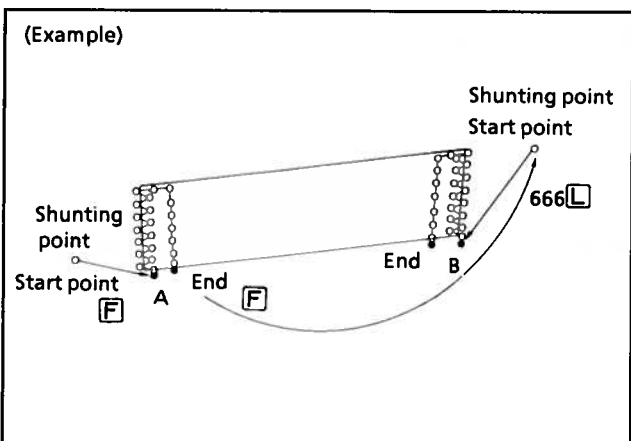
To program this single cycle sequence, program a shunt feed (F) between points A and B.

## If There Are Dimension Differences



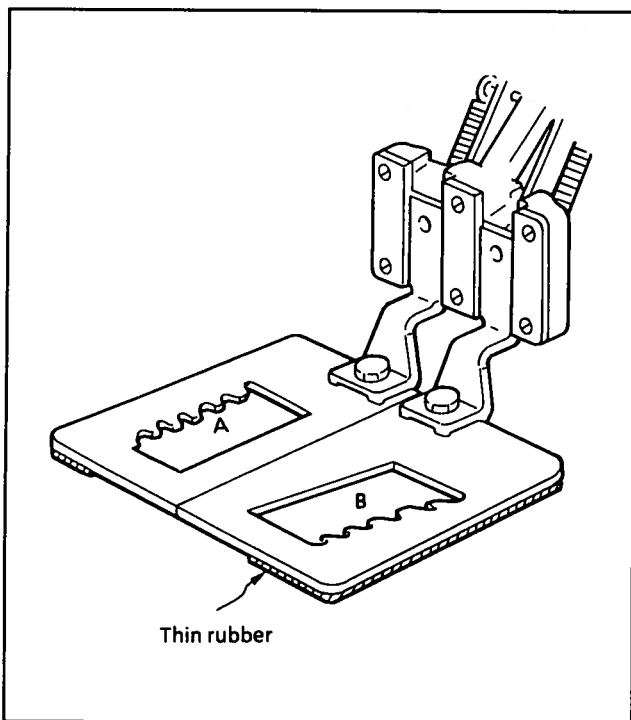
### [Work Clamp]

- 1) Process the work clamp plate to match the dimensions of the breast pocket.
- 2) If thin rubber or sand paper is stuck to the lower surface of the work clamp blank, then the material will be firmly clamped and sewing can be carried out easily.



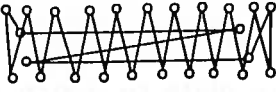
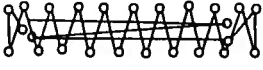
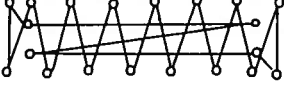

### [Programming]

Use a split program. Enter a shunt feed (F) from the final stitch position in seam A to the initial stitch position in seam B, and then enter 666 L at that start point.



### [Sewing]

- 1) This program enables the presser foot to be lifted at B to reconfirm the position of the material. The sewing procedure is sew A, move to the shunting point at B, and stop the sewing machine. Raise the clamp to check the material position and then restart the machine. Seam B will be sewn, and after the machine returns to the shunting point at A, it will stop and the clamp will be raised.
- 2) When setting the material, adjust the DIP switch located on the circuit board or modify the air tube so that the clamp can be provided with two-stage positioning.
  - ※ Two-stage positioning unit
    - If the clamp foot switch (SW) is pressed to the first stage, air will be released from the clamp cylinder, and the clamp will be lowered by the spring force. Because the clamp does not press the material at this time (floating by 1 to 2 mm), the material can be moved freely and set in the specified position.
    - If the foot switch is pressed to the second stage, air enters the cylinder, and the clamp will press the material firmly. (Refer to p. 6)

 <p>Number of stitches: 42 Stitch size: 7 - 16 x 1 - 2</p>	 <p>Number of stitches: 35 Stitch size: 7 - 20 x 1.5 - 3</p>	 <p>Number of stitches: 28 Stitch size: 6.5 - 16 x 1 - 2</p>	 <p>Number of stitches: 21 Stitch size: 3 - 7 x 1 - 2</p>
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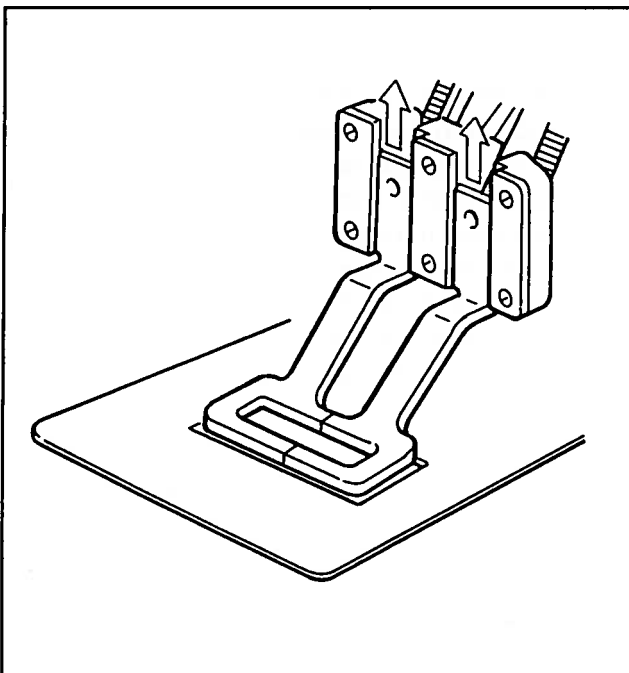
• The bar tacking as shown above can be programmed and sewn freely.

## Programming Procedure

Because the number of cross stitches is small, it is advisable to use the enlargement function to make programming easier.

1. Enlarge the stitching pattern by five or ten times the original size.
2. After the  $\square$  key is pressed, "905" will be displayed in the STEP space for 5 times enlargement, and "910" will be displayed for 10 times enlargement.
3. Press the  $\square$  key.
4. Use the jog key to set the program for each stitch.
5. After programming the final stitch, key in "111  $\square$ ".
6. Save the program on the floppy disk.
7. Although the stitch pattern was enlarged, the program will be written in the original size on the floppy disk.

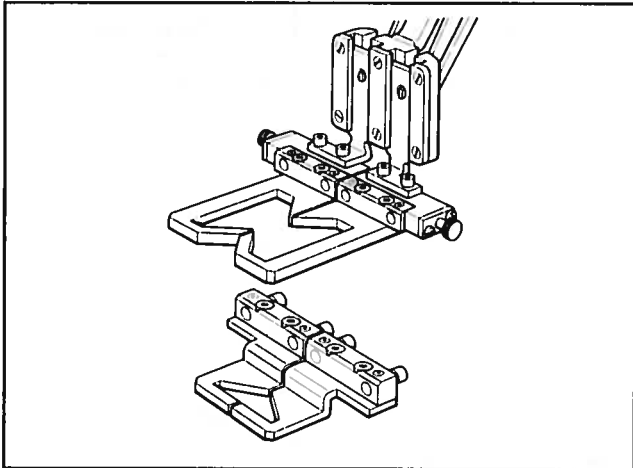
## Work clamp (Option)



• OT presser foot D assembly	S14846-001	2
• Presser foot SL	S14255-001	1
• Presser foot SR	S14254-001	1
• OT feed plate bracket assembly	S14841-001	1
• OT feed plate	S14252-001	1
• Screw	149168-001	2

## One-touch Work Clamp (Option)

A one-touch work clamp (option) is provided to make conversion and positioning of the work clamp blank easier.



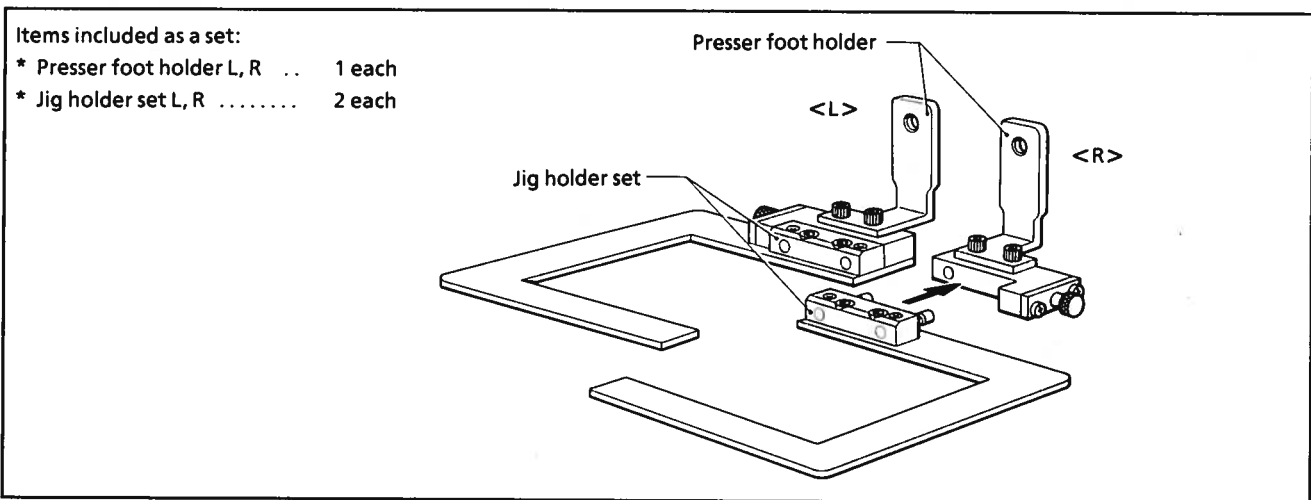
※ For BAS-311 ..... S20279-001

※ For BAS-326 ..... S20813-001

BAS-311 ..... Max. sewing thickness is 5mm (sewing area at this time is 100 x 60mm).

BAS-326 ..... Max. sewing thickness is 5.5mm (sewing area at this time is 150 x 100mm).

Note: If the sewing thickness is greater than the maximum, the range of use of the thread wiper will be limited.



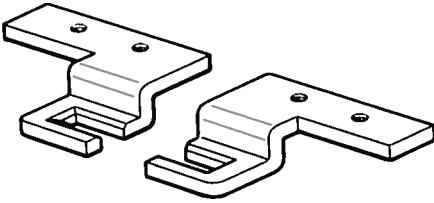
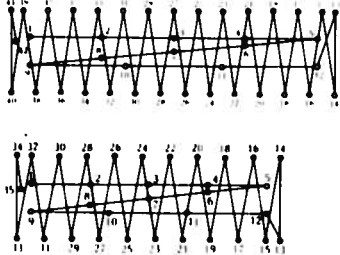
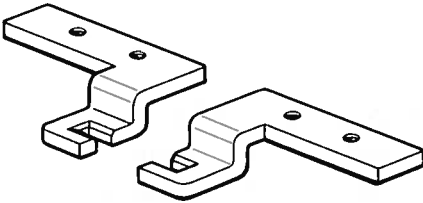
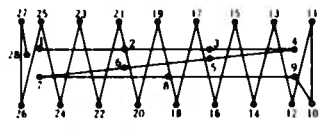
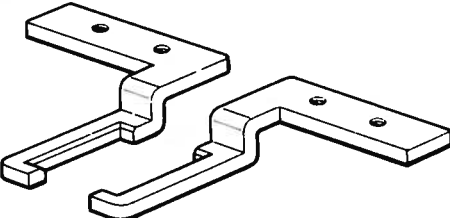
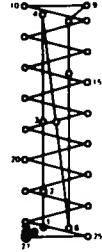
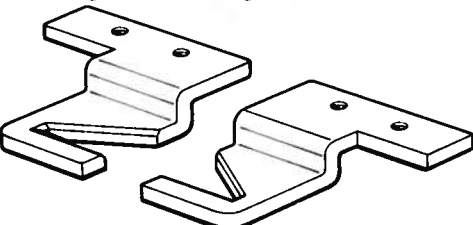
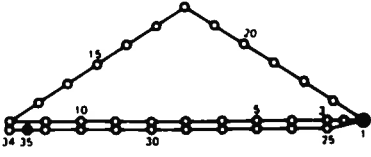
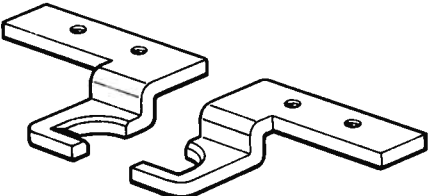
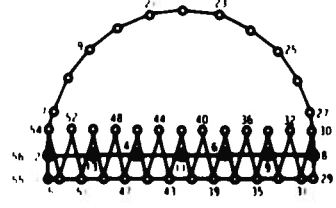
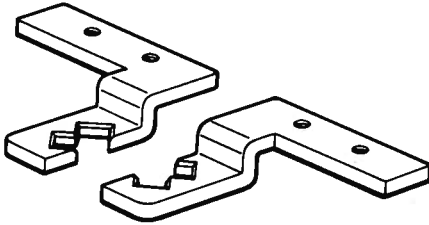
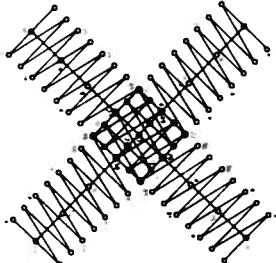
### Screw holder set

<For both BAS-311 and BAS-326>

Parts name	Jig holder L set	Jig holder R set
Parts code	S20822-001	S20823-001
Shape		


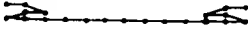

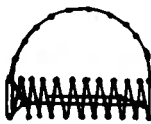
**One-touch Work Clamp (Option)**


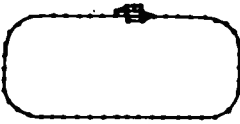
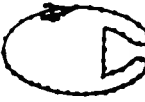

A work clamp for all types of bar tacking can be attached as the one-touch work clamp for the BAS-311.

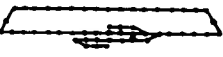
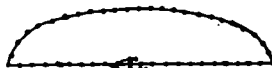
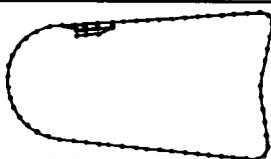
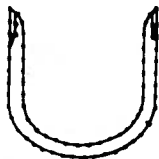
Work Clamp	Stitch pattern (reference)	Parts code
<p>[For large bar tacking] (L) (R)</p> 		<p>(R) S23818-001 (L) S23819-001</p> <p>Feed plate: S23820-001</p>
<p>[For small bar tacking] (L) (R)</p> 		<p>(R) S23821-001 (L) S23822-001</p> <p>Feed plate: S23823-001</p>
<p>[For vertical bar tacking] (L) (R)</p> 		<p>(R) S23827-001 (L) S23828-001</p> <p>Feed plate: S23829-001</p>
<p>[For triangular bar tacking] (L) (R)</p> 		<p>(R) S23833-001 (L) S23834-001</p> <p>Feed plate: S23835-001</p>
<p>[For half-moon bar tacking] (L) (R)</p> 		<p>(R) S23824-001 (L) S23825-001</p> <p>Feed plate: S23826-001</p>
<p>[For cross bar tacking] (L) (R)</p> 		<p>(R) S23830-001 (L) S23831-001</p> <p>Feed plate: S23832-001</p>


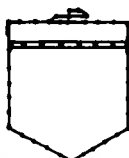
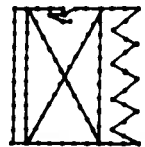


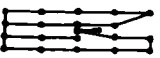
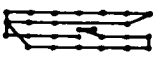
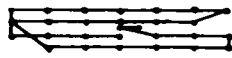

## Other Stitching Patterns





<p>Butterfly pattern stitch</p>  <p>Number of stitches: 84/4 Stitch size: 5 x 5</p>	<p>Straight label stitch</p>  <p>Number of stitches: 84/4 Stitch size: 20 - 25 x 0</p>	<p>Trapezoidal zigzag stitch</p>  <p>Number of stitches: 70 Stitch size: 16 x 6</p>	<p>Half-moon tackstitch</p>  <p>Number of stitches: 56 Stitch size: 12 x 7</p>
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<p>Label attaching stitch</p>  <p>Number of stitches: 70 Stitch size: 50 x 12</p>	<p>Label attaching stitch</p>  <p>Number of stitches: 84 Stitch size: 86 x 28</p>	<p>Label attaching stitch</p>  <p>Number of stitches: 63 Stitch size: 31 x 20.5</p>	<p>Trapezoidal pattern stitch</p>  <p>Number of stitches: 98 Stitch size: 50 - 60 x 20 - 30</p>
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<p>Shoehorn stitch</p>  <p>Number of stitches: 56 Stitch size: 60 x 3</p>	<p>Shoehorn stitch</p>  <p>Number of stitches: 35 Stitch size: 48 x 10</p>	<p>Shoehorn stitch</p>  <p>Number of stitches: 98 Stitch size: 92.5 x 55.5</p>	<p>Pattern stitch</p>  <p>Number of stitches: 112 Stitch size: 50 x 54</p>
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<p>Front hok attaching stitch</p>  <p>Number of stitches: 112/2 Stitch size: 20.5 x 15.9</p>	<p>Facing hem stitch</p>  <p>Number of stitches: 70 Stitch size: 20 x 29</p>	<p>Safety belt stitch</p>  <p>Number of stitches: 112 Stitch size: 35.1 x 40.3</p>
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<p>Hand loop stitch</p>  <p>Number of stitches: 42/2 Stitch size: 6 - 14 x</p>	<p>Hand loop stitch</p>  <p>Number of stitches: 28 Stitch size: 6 - 14 x</p>	<p>Hand loop stitch</p>  <p>Number of stitches: 28 Stitch size: 14 - 25 x</p>	<p>Hand loop stitch</p>  <p>Number of stitches: 56 Stitch size: 45 x 21</p>
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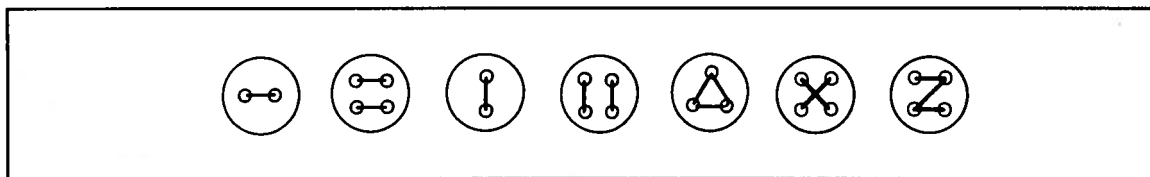
<p>Button attaching stitch</p>  <p>Number of stitches: 9 or 18 Stitch size: 2.5 - 6.5 x 0 - 6.5</p>	<p>Button attaching stitch</p>  <p>Number of stitches: 9 or 18 Stitch size: 2.5 - 6.5 x 0 - 6.5</p>	<p>Button attaching stitch</p>  <p>Number of stitches: 9 or 18 Stitch size: 2.5 - 6.5 x 0 - 6.5</p>	<p>Button attaching stitch</p>  <p>Number of stitches: 18 Stitch size: 2.7 x 2.7</p>
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If a three-hole button clamp and a special-purpose PROM are attached to the BAS-304 or BAS-311, they can be used as lock stitch button sewers.

## Features

1. Stitching can be quickly changed, requiring no trouble to replace the feed cam.
2. Sewing of three-hole buttons and various button sewing as shown in the below figure can be achieved.
3. Up to ten sewing patterns can be stored in the memory.
4. If the button clamp is removed, the machines can be used as electronic sewing machines.

## Sewing Patterns

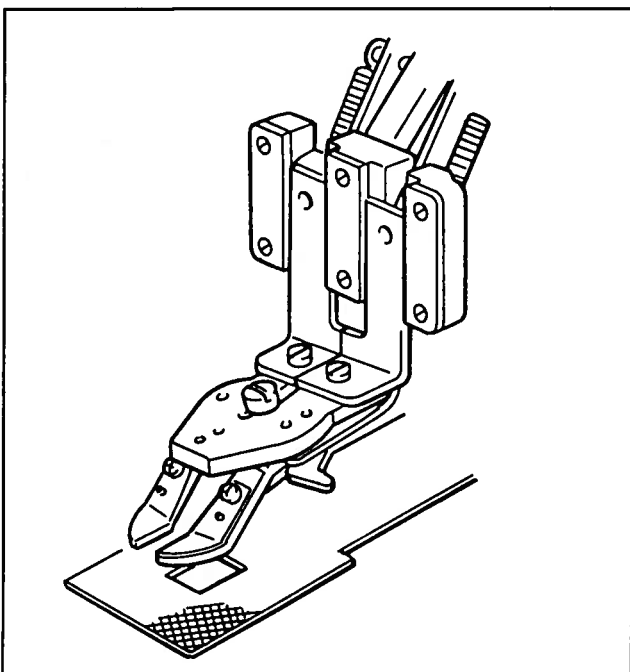


## Sewing Preparation

Attach the special-purpose PROM, and turn the DIP switch No. 5 located on the circuit board to ON. The button clamp and the needle will not touch each other because the machine origin point will come be at the front.

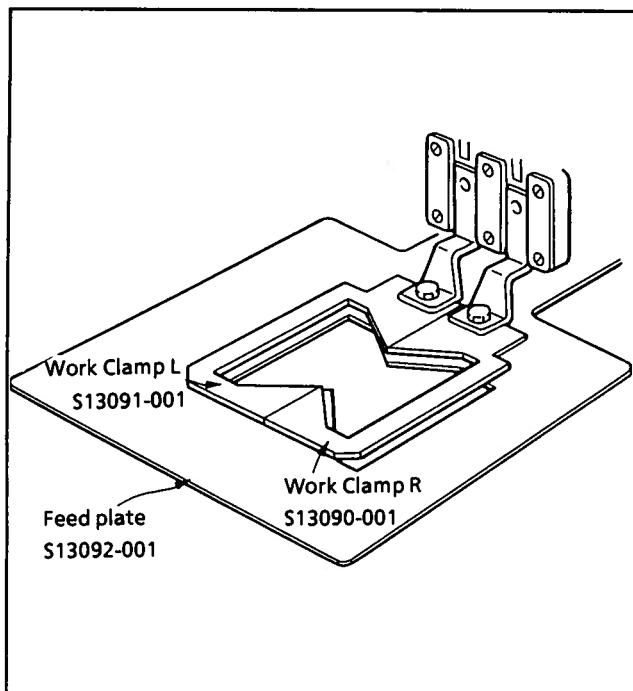
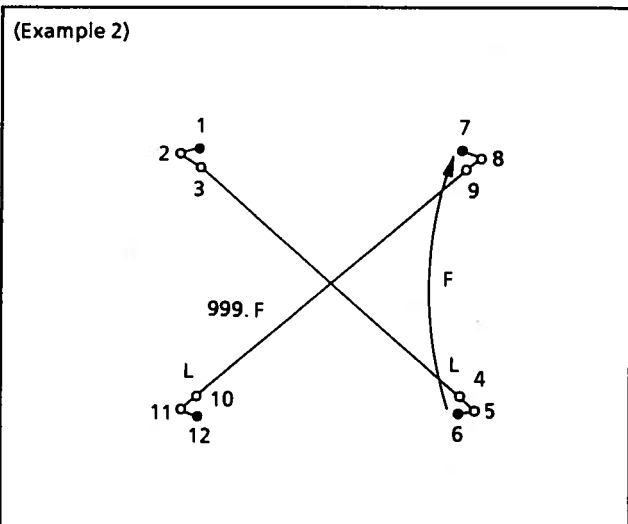
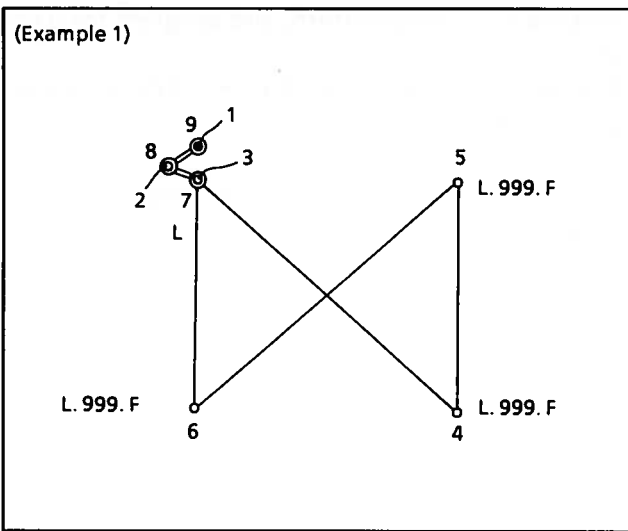
Before turning on the power, be sure to move the needle to the button position.

## Replacement Parts



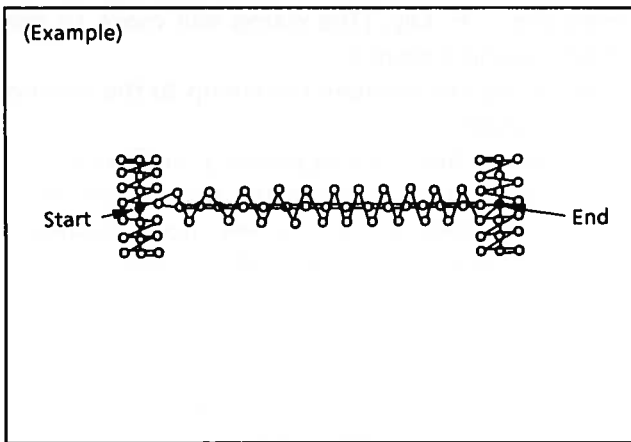
1. BU presser foot UL	S14849-001	1
2. BU presser foot UR	S14848-001	1
3. Presser foot D assembly	S14846-001	2
4. OT feed plate bracket assembly	S14841-001	1
5. OT feed plate	S14069-001	1
6. Button float spring	153871-001	1
7. Float spring presser plate	S14073-001	1
8. PROM for button sewing (304)	Special order	1
PROM for button sewing (311)	S15167-001	1
9. Screw	149168-001	2
10. Screw	062670-512	2
11. Washer	102707-002	2
12. Bolt 4.76	117363-001	2
13. Washer 4.76	025710-232	2
14. Button clamp	S03463-001	1


## Programming Procedure



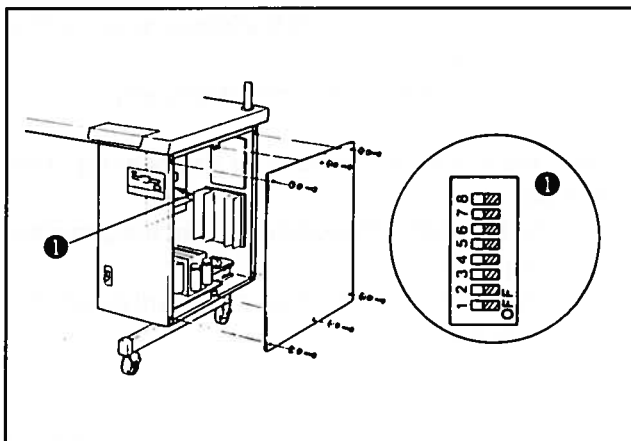
1. Press the **[P]** key. (The clamp will move to the machine origin point.)
2. Use the jog key to move the clamp to the sewing start position.
3. Program the first stitch by pressing the **[L]** key.
4. In the same way, program the second and third stitches by pressing the **[L]** key. Note, however, that movement should be made for two or more pulses.
5. After "999" is displayed in the third stitch position, press the **[F]** key, and move the needle to the fourth stitch by pressing the jog key.
6. Program by pressing the **[L]** key.
7. In the same way, program the movement from the fourth stitch to the fifth stitch, from the fifth stitch to the sixth stitch, and from the sixth stitch to the seventh stitch.
8. Program the eighth and ninth stitches by using the jog key and the **[L]** key.
9. After programming the ninth stitch, key in "111 **[E]**".
10. Then, the clamp will return to the sewing start position.
11. Press the READ/WRITE switch to store the program in the floppy disk.
12. Press the **[P]** key to clear the display of the programming machine.

## Programming procedure

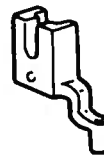


1. Prepare a stitching pattern, and program for each stitch.  
For the linear part, press the  key for easier programming.
2. The seam pitch for the linear part and the zigzag part covered by cross stitching should preferably be 3.0 to 4.0 mm.

## Sewing Preparation



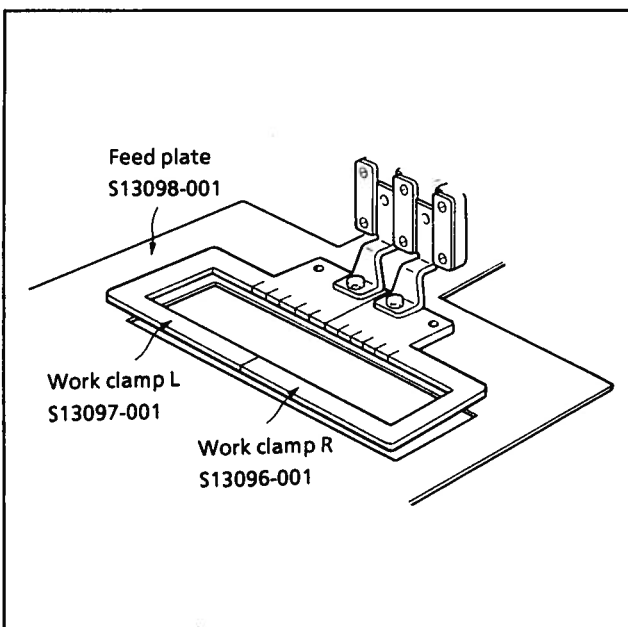
1. Use the presser foot A.



Presser foot A  
152283-101

2. Turn the DIP switch No. 2 located on the circuit board to ON, and the clamp will operate in two stages for easier working.

## Work Clamp

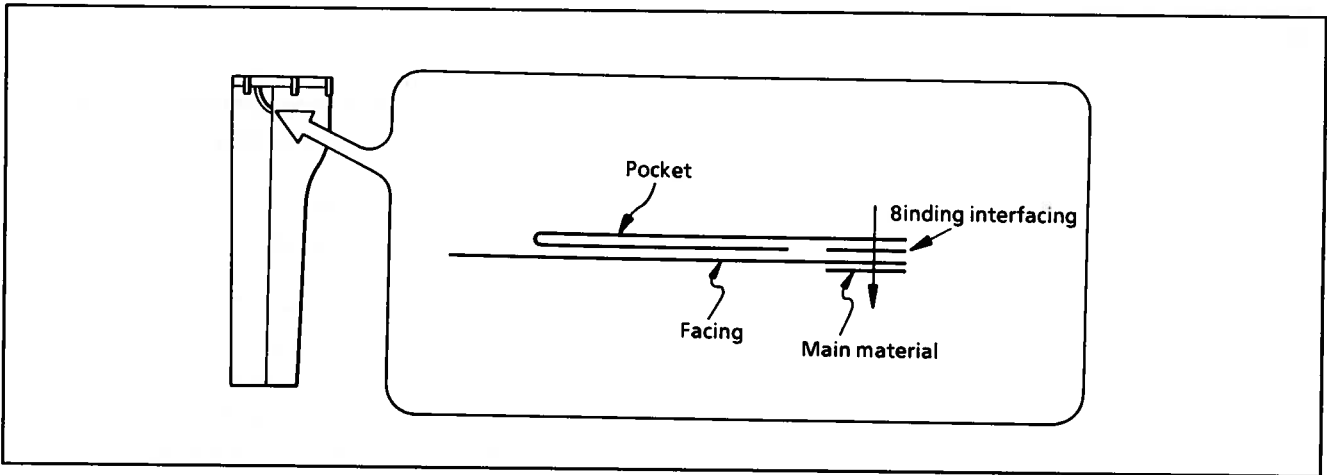


- Feed plate . . . . . S13098-001
- Work Clamp L . . . S13097-001
- Work Clamp R . . . S13096-001

## 10. Seaming for Slacks Pocket Brims

BAS-326

When sewing seams for slacks pocket brims, using the BAS-326 and BAS-373 (width 180mm x length 100mm) can provide symmetric curved lines.

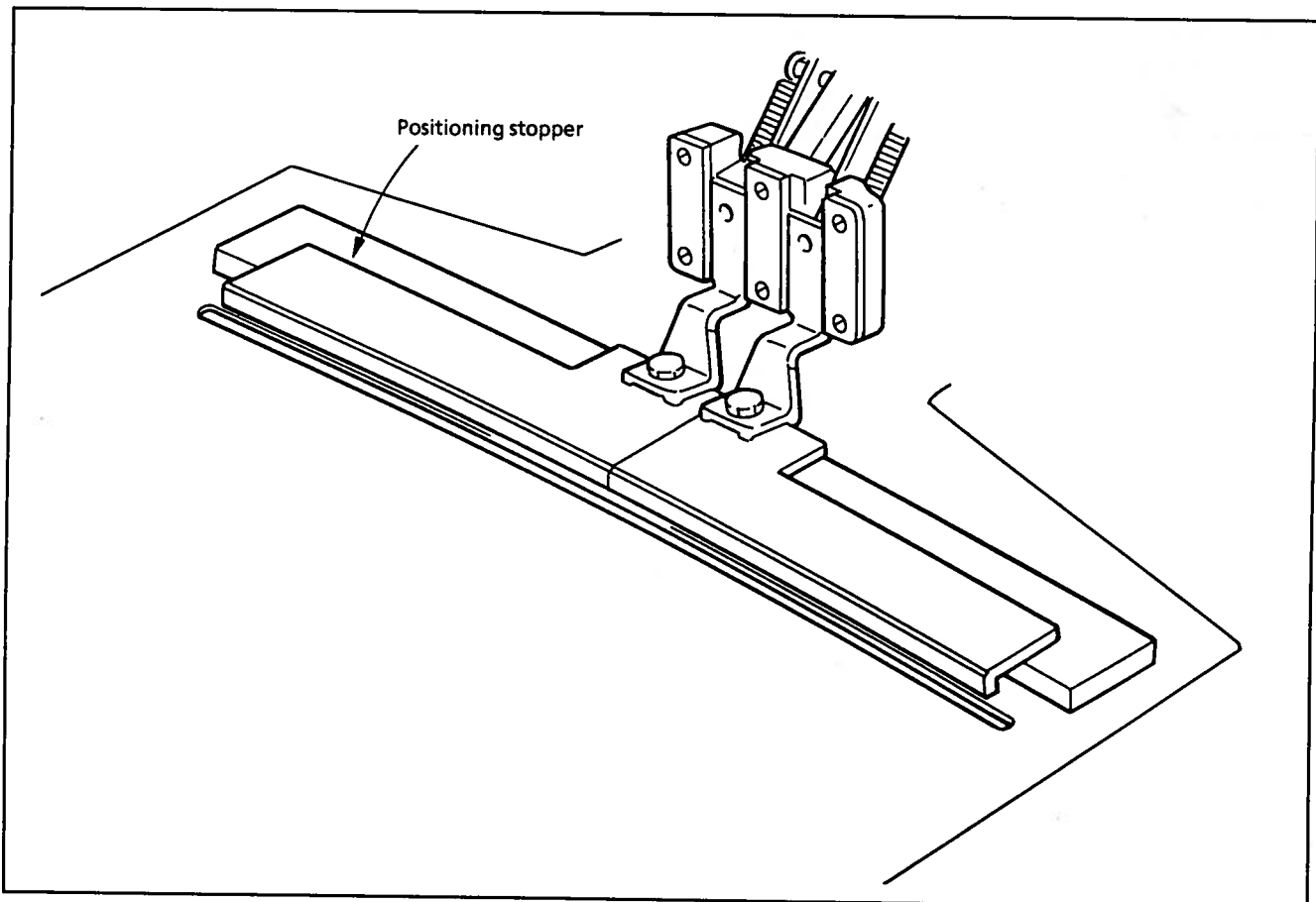


### Programming procedure

Program curved lines easily by using the smoothing program.

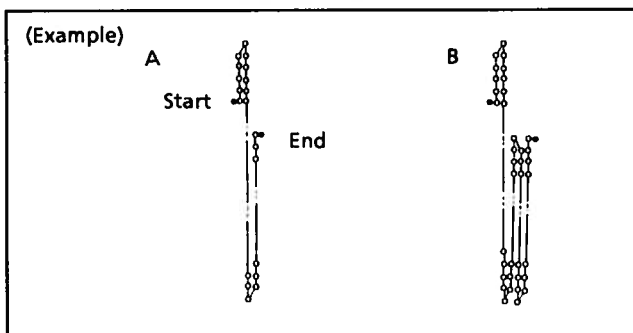
If the split program is used, the left start and the right start will be made alternately, improving sewing efficiency.


### Example of Using the Work Clamp

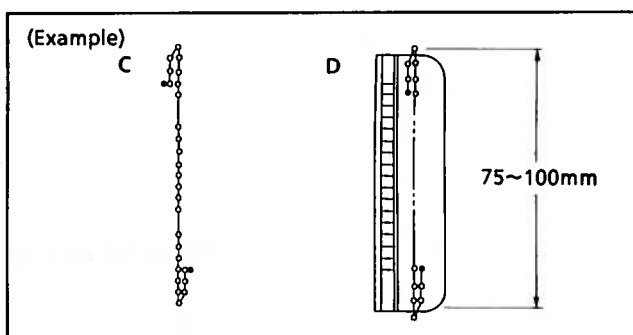


The BAS-311 can store up to 10 patterns for darts sewing, and a wide range of darts lengths from 75-100mm can also be used.

## Programming procedure



1. Patterns A and B are programmed by specifying the seam pitch and then pressing the  key.
2. Pattern C is provided with a part with wide seam pitch (6 to 7 mm) for passing the wire hook.
3. For pattern D, the program can be set so that lap sewing at both ends for sewing the curtain height adjuster plastic plate is possible. This changes the machine speed to low speed during lap sewing and protects the needle from breakage.



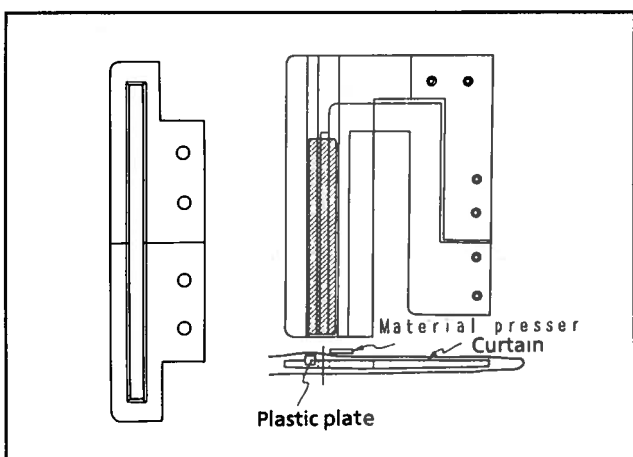
## Applicable sewing machine

- Use a air specifications type with strong pressing pressure because the materials to be sewed vary from thick materials to thin lace.
- A 100V compressor can also be provided.
- The BAS-311 is of horizontal head specifications.

## Sewing Preparation

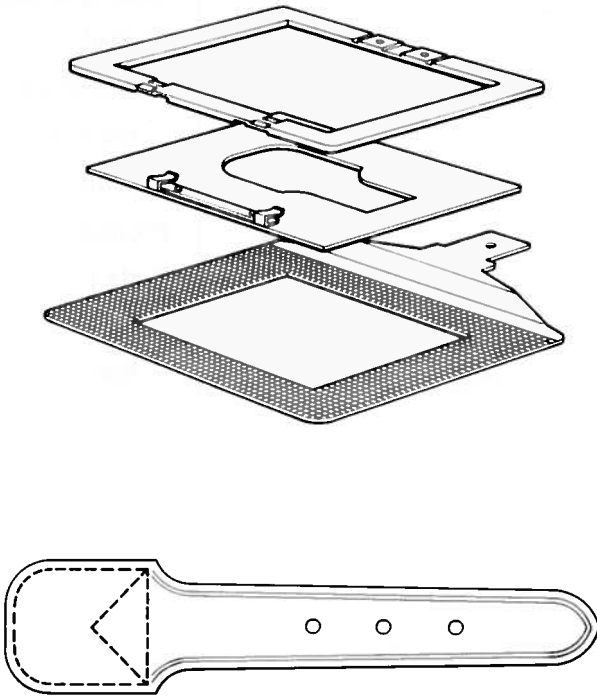
- Set the intermittent stroke at 7 mm.
- Use the presser foot A (152283-101).

## Example of Using the Work Clamp



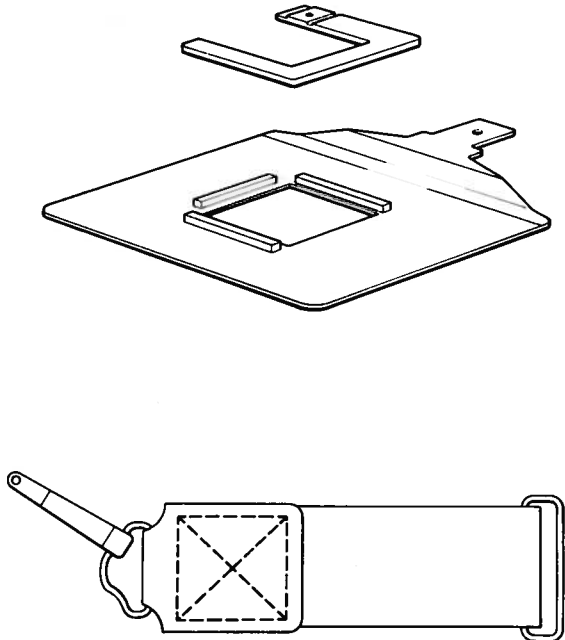
## 12. Bag Handle Sewing

BAS-326

Work clamp and sewing pattern	
	<ul style="list-style-type: none"><li>· Sewing speed: 1,000spm</li><li>· Thread:<ul style="list-style-type: none"><li>Nylon upper thread #20</li><li>lower thread #30</li></ul></li><li>· Needle: DP x 5 #21</li><li>· Programming time: 10 min.</li><li>· Cycle time: 11 sec.</li><li>· Daily production output:<ul style="list-style-type: none"><li>2,618 pieces</li></ul></li></ul>

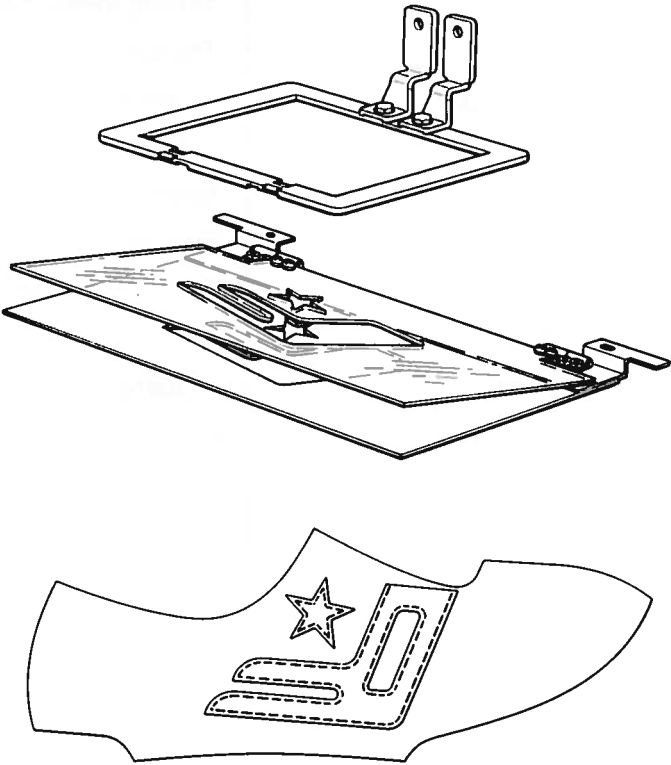
## 13. Shoulder Bag Strap Sewing

BAS-326

Work clamp and sewing pattern	
	<ul style="list-style-type: none"><li>· Sewing speed: 1,500spm</li><li>· Thread:<ul style="list-style-type: none"><li>Tetron upper thread #20</li><li>lower thread #30</li></ul></li><li>· Needle: DP x 5 #21</li><li>· Programming time: 10 min.</li><li>· Cycle time: 17 sec.</li><li>· Daily production output:<ul style="list-style-type: none"><li>1,649 pieces</li></ul></li></ul>

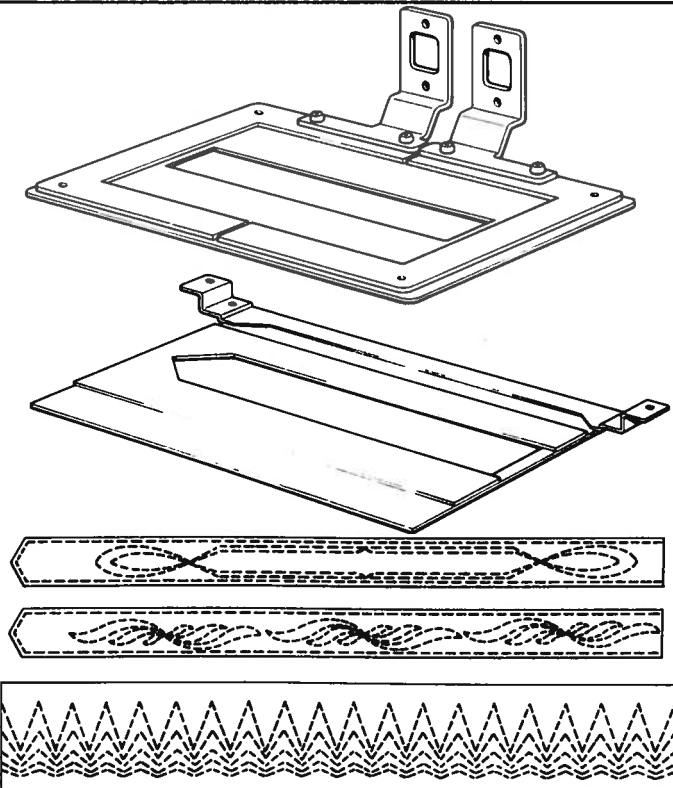
## 14. Belt Decoration Sewing

BAS-340

Work clamp and sewing pattern	
	<ul style="list-style-type: none"><li>· Sewing speed: 1,250spm</li><li>· Thread:<ul style="list-style-type: none"><li>Tetron upper thread #30</li><li>lower thread #50</li></ul></li><li>· Needle: 134KKD #100</li><li>· Programming time: 20 min.</li><li>· Cycle time: 32 sec.</li><li>· Daily production output:<ul style="list-style-type: none"><li>900 pieces</li></ul></li></ul>

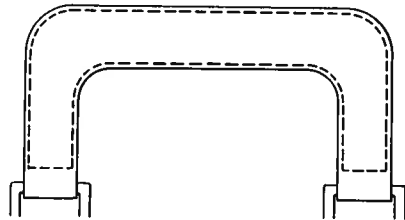
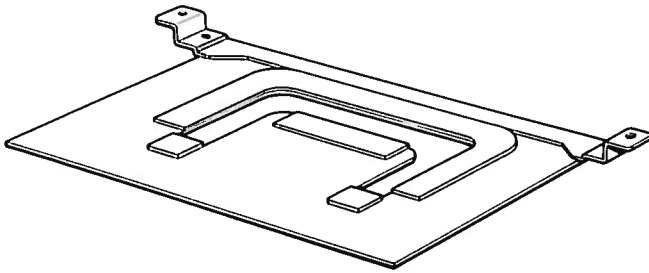
## 15. Briefcase Handle Sewing

BAS-340

Work clamp and sewing pattern	
	<ul style="list-style-type: none"><li>· Sewing speed: 800spm</li><li>· Thread:<ul style="list-style-type: none"><li>Nylon upper thread #20</li><li>lower thread #30</li></ul></li><li>· Needle: DP x 17 #21</li><li>· Programming time: 20 min.</li><li>· Cycle time: 26 sec.</li><li>· Daily production output:<ul style="list-style-type: none"><li>1,000 pieces</li></ul></li></ul>



Work clamp and sewing pattern

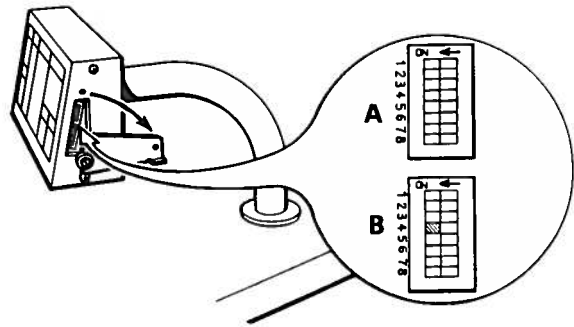
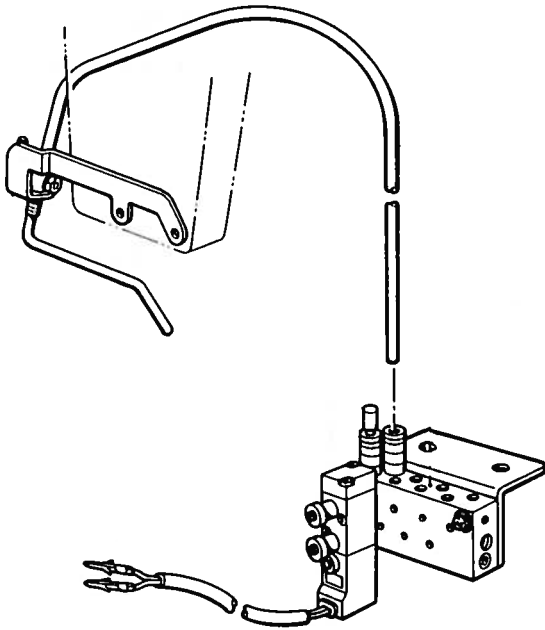


- Sewing speed: 1,500spm
- Thread:
  - Tetron upper thread #20
  - lower thread #30
- Needle: DP x 5 #8 - #21
- Material: Cushion
- Clamp method: Cassette type
- Presser foot: A-F
- Cycle time: 14 sec.
- Daily production output:
  - 2,058 pieces (514 sets)

# Optional Parts

## BAS-340

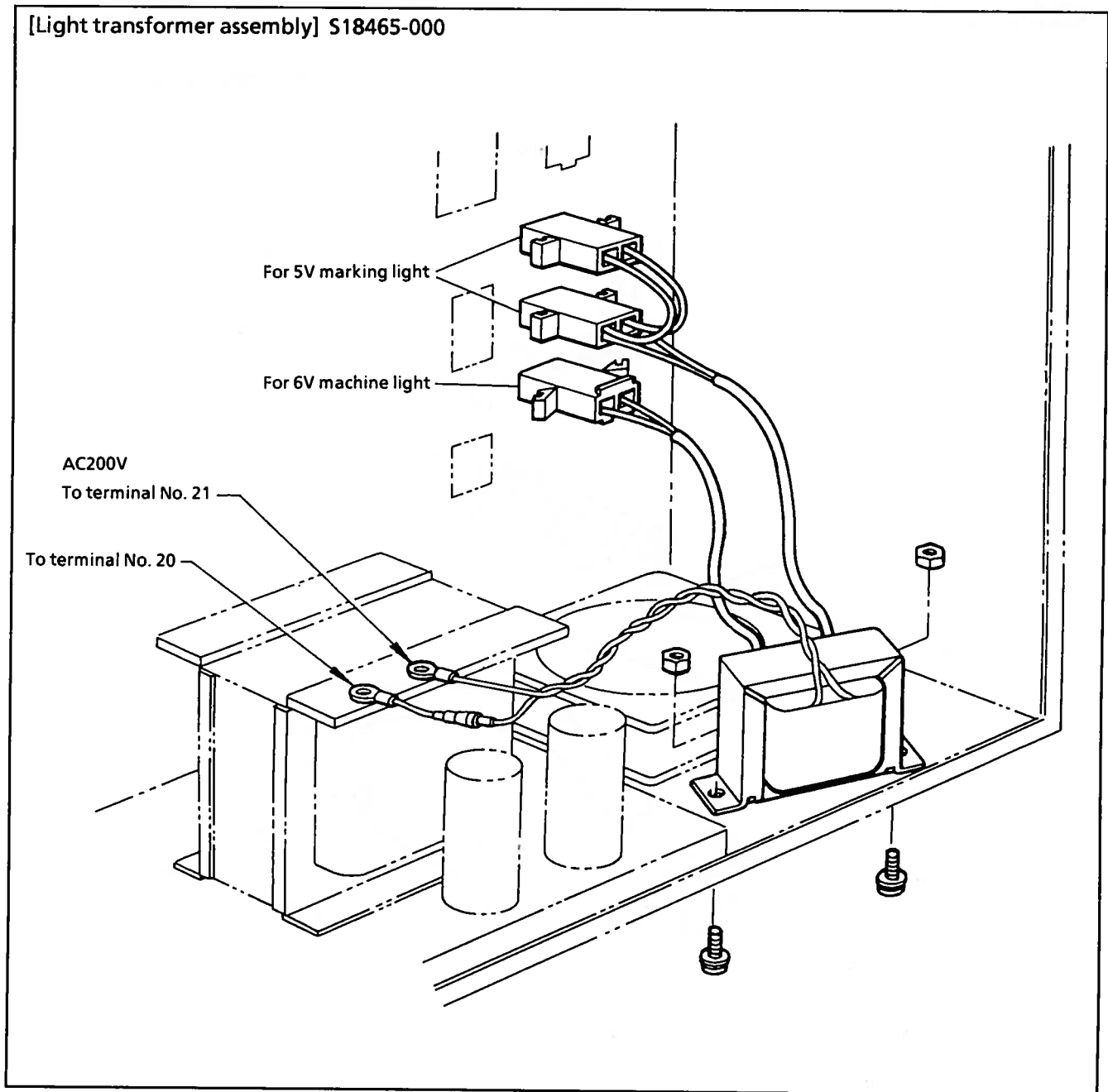
[Needle cooler assembly] S21110-009



※ When the needle cooler assembly is attached, set the DIP switch B-4 to ON as shown above.

# Optional Parts

**BAS-311-326**



※ Connect the following parts to the other ends of the respective connectors.

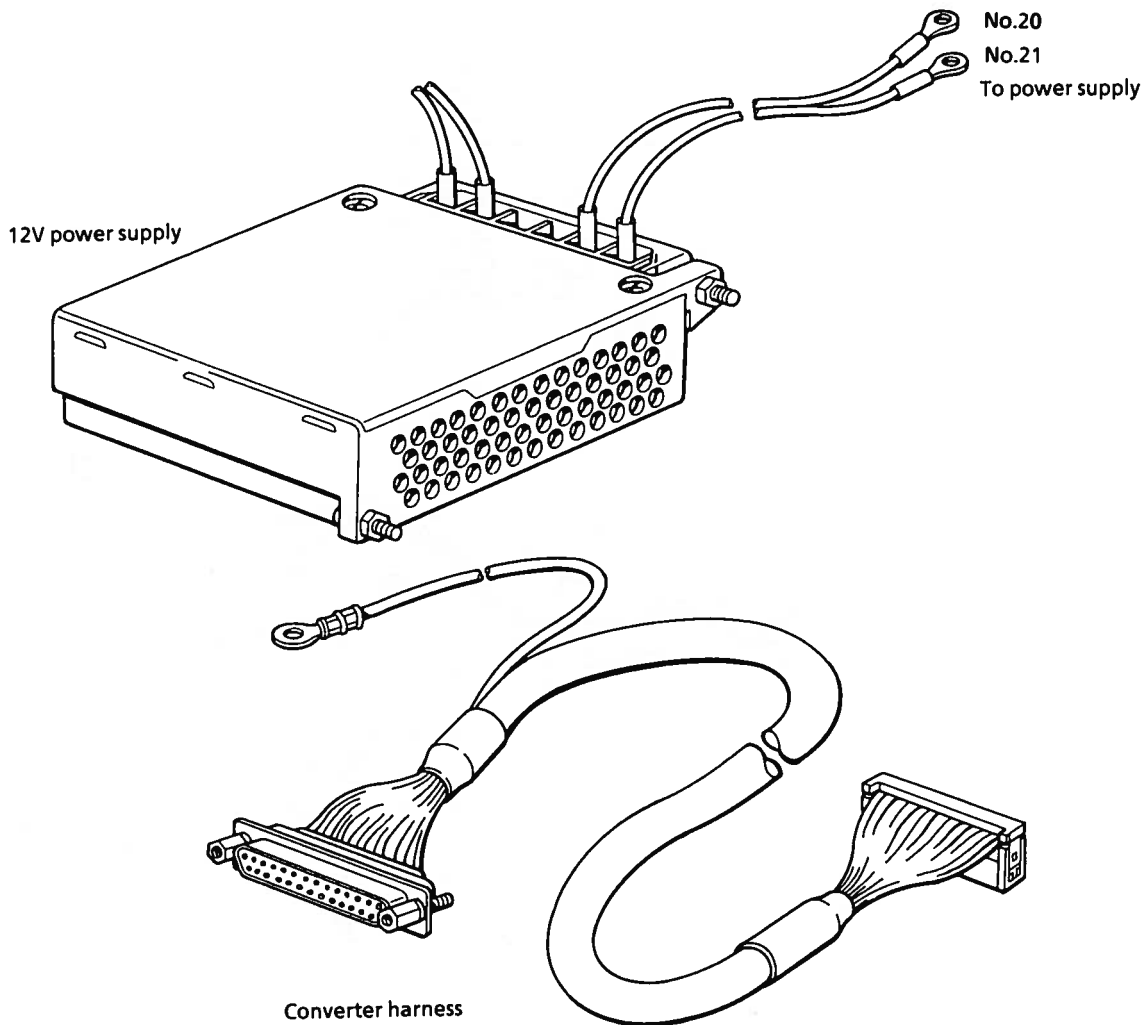
	6V machine light	5V marking light
Connector pin	MOLEX Female pin 1381ATL (143548-000) 2	MOLEX Male pin 1380TL (143549-000) 4
Connectors	MOLEX 3191-02R1 (S18466-000) 1	MOLEX 1545P (S05008-000) 2

# Optional Parts

## BAS-326

### [Data Converter assembly] S18051-001

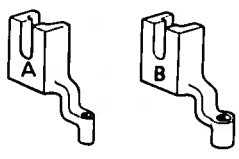
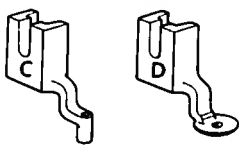
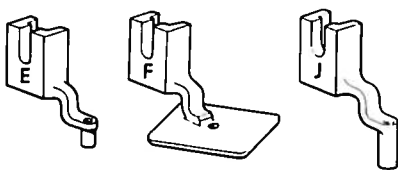
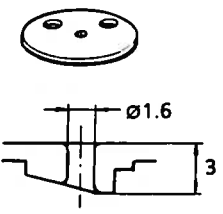
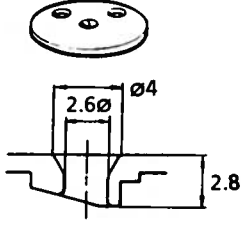
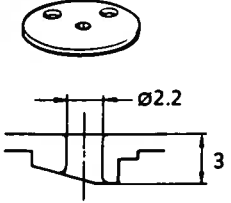
If this assembly is used, data in the BAS-320 and BAS-325 micro disk (2.5") and data in the BAS-326 floppy disk (3.5") can be interchanged.



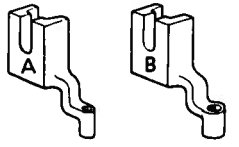
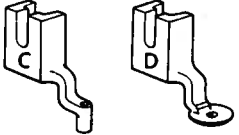
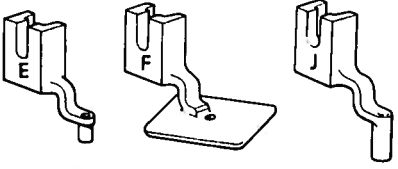
※ The BAS-320 has a different area size, so correct before making conversions.

# Optional Parts Table

## BAS-304

Presser foot		
		
A $\varnothing 2.5$ 152283-101 B $\varnothing 4$ 152636-001	C $\varnothing 2$ 152637-001 D $\varnothing 3$ 154069-001	E $\varnothing 1.6$ 154089-001 F $\varnothing 2$ 157237-001 J $\varnothing 2.5$ S13815-001
Needle hole plate		
		
A : S10211-001	E : S10212-101	F : S10213-001

## BAS-311

Presser foot		
		
A $\varnothing 2.5$ 152283-101 B $\varnothing 4$ 152636-001	C $\varnothing 2$ 152637-001 D $\varnothing 3$ 154069-001	E $\varnothing 1.6$ 154089-001 F $\varnothing 2$ 157237-001 J $\varnothing 2.5$ S13815-001

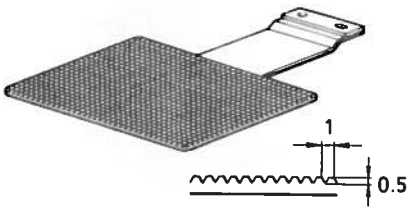
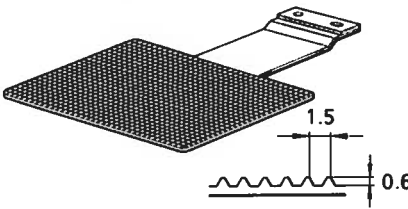
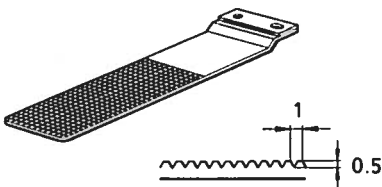
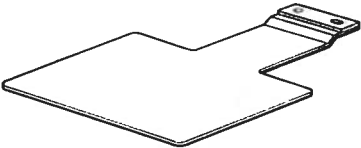
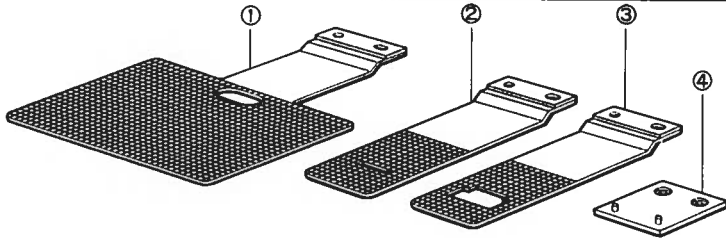
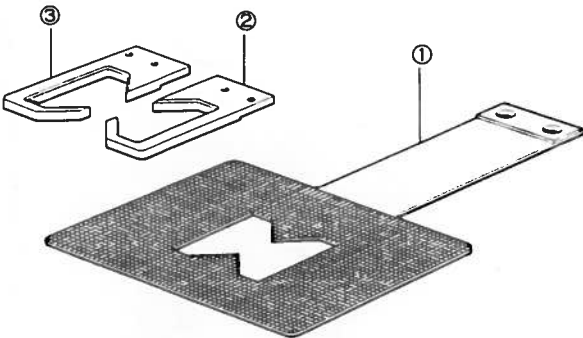
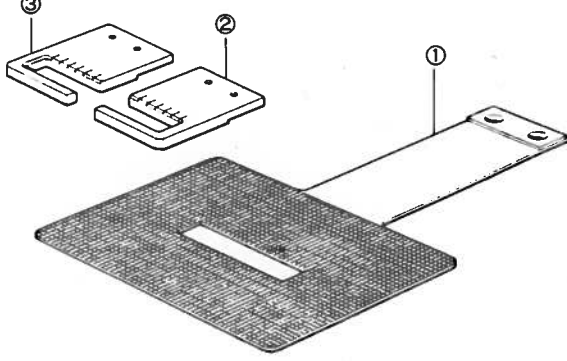

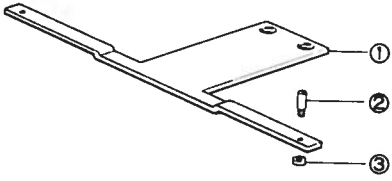
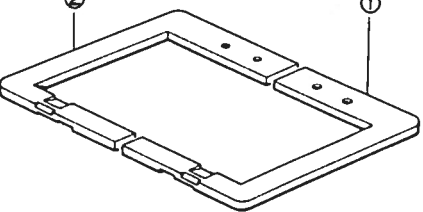
# Optional Parts Table

**BAS-311**

Needle hole plate		
A : S10211-001	E : S10212-101	F : S10213-001
Work clamp blank		
E-1 : 153526-000	E-3 : 154386-000	E-4 : S10269-000
OT presser plate assembly		
A : 157248-001	B : 157250-001	C : 157251-001
Feed plate blank		
A : S10265-000	B : S10266-000	
E : S13566-000	H : S19659-000	

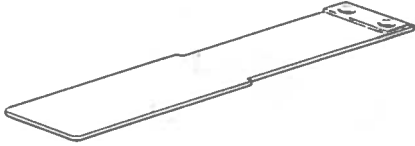
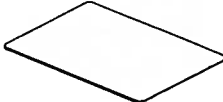
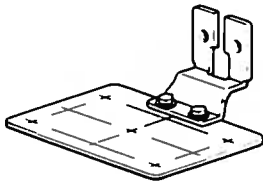
# Optional Parts Table

## BAS-311

OT feed plate blank (t = 1.2)		
		
(C) S14844-001	(D) S14845-001	(F) S14251-001
		
(G) S19666-001	① (312) S14598-001 ② (DE) S14253-001	③ (ST) S14252-001 ④ Frame assembly for OT feed plate bracket S14841-001
For basting		For loop sewing
		
① Feed plate 310-2 S13092-001 ② Work clamp (R) S13090-001 ③ Work clamp (L) S13091-001	① Feed plate 310-3 S13098-001 ② Work clamp (R) S13096-001 ③ Work clamp (L) S13097-001	
BAS-320/325 feed plate attachment		
		
Feed plate attachment bracket: S12586-001	① Cassette supporter plate S13006-001 ② Cassette supporter pin S13007-001 ③ 3 types of nut 021660-306	① Work clamp (R): S10411-001 ② Work clamp (L): S10412-001

# Optional Parts Table

## BAS-311

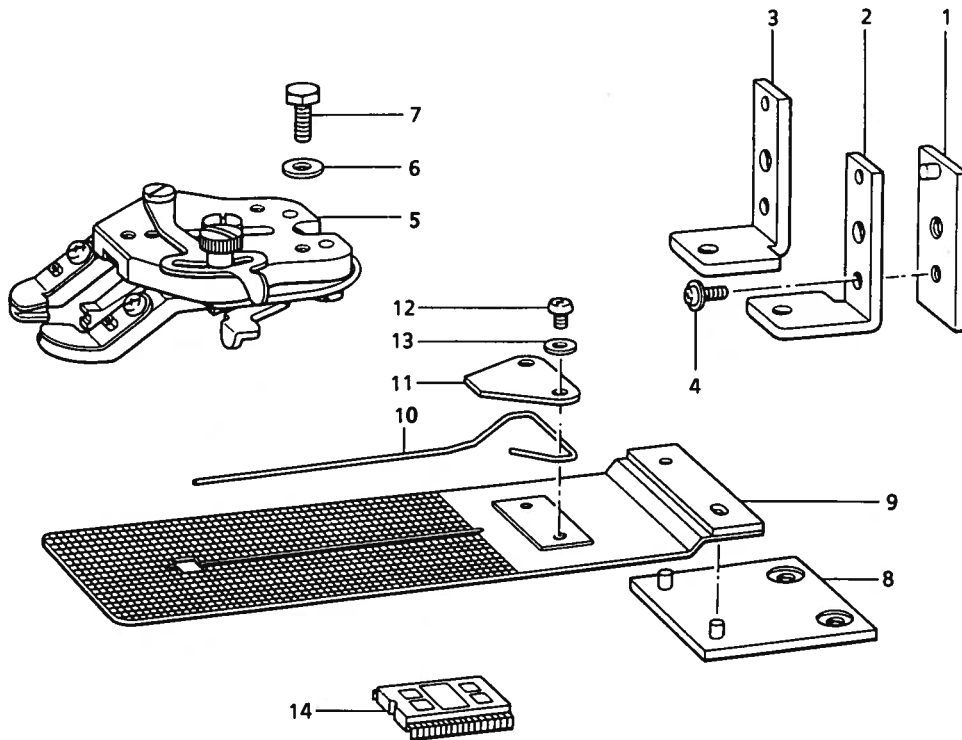
For cylinder bed	Feed plate lower plate (for C, D)	Home position reference plate assembly
 <p style="text-align: right;">t = 1.2</p>		
Feed plate blank E: S13566-001	S13567-000	S13046-001



# Optional Parts Table

**BAS-304-311**

## Attachment for button sewing



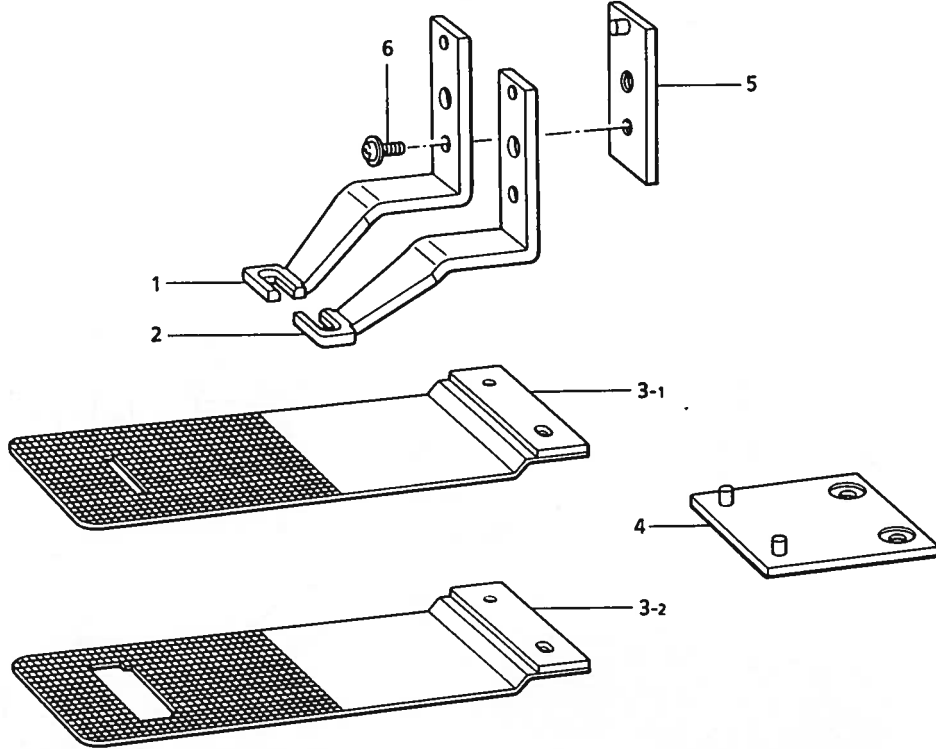
1	OT presser foot D assembly	2	S14846-001	8	OT feed plate bracket assembly	1	S14841-001
2	BU presser foot U-R	1	S14848-001	9	OT feed plate 7 flat	1	S14069-001
3	BU presser foot U-L	1	S14849-001	10	Button float spring 1.2	1	153871-001
4	Screw 4.37	2	149168-001	11	Float spring presser plate	1	S14073-001
5	Button clamp assembly	1	S03463-001	12	Screw 357-40 × 5	2	062670-512
6	Bolt 4.76	2	117363-001	13	Washer	2	102707-002
7	Flat washer 4.76	2	025710-232	14	PROM for button sewing	1	S15167-001

※ The PROM for button sewing in the BAS-304 is available by special order.

# Optional Parts Table

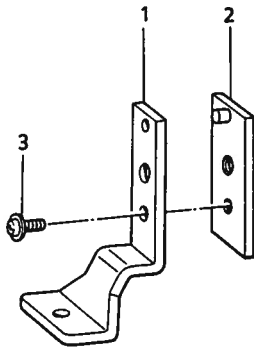
**BAS-311**

## Attachment for bar tacking



1	Presser foot SR	1	S14254-001	4	OT feed plate bracket assembly	1	S14841-001
2	Presser foot SL	1	S14255-001	5	OT presser foot D assembly	2	S14846-001
3-1	OT feed plate DE	1	S14253-001	6	Screw 4.37	2	149168-001
3-2	OT feed plate ST	1	S14252-001				

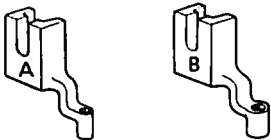
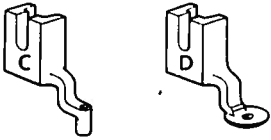
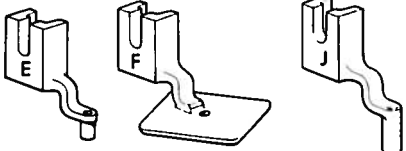
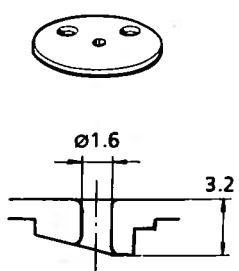
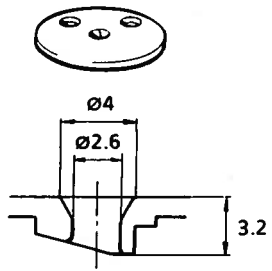
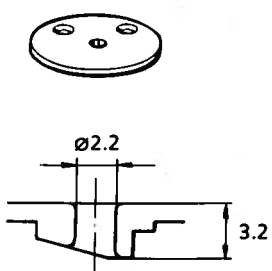
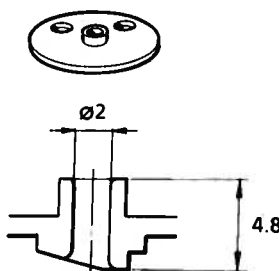
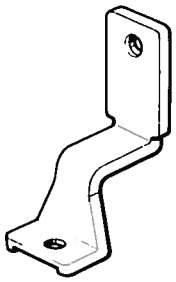
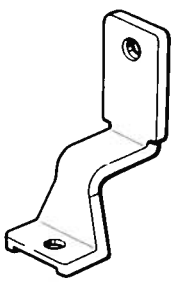
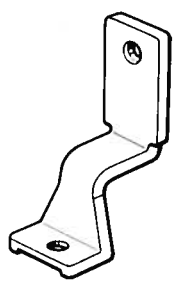
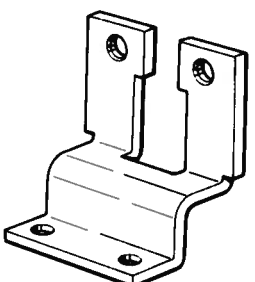


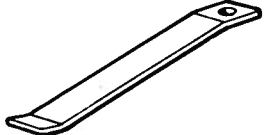
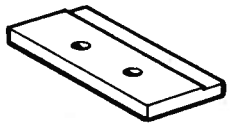
## Attachment for one-touch work clamp



1	OT presser foot	1	S14850-001
2	OT presser foot D assembly	1	S14846-001
3	Screw 4.37	1	149168-001

# Optional Parts Table

## BAS-326

Presser foot							
							
A $\varnothing 2.5$	152283-101	C $\varnothing 2$	152637-001	E $\varnothing 1.6$	154089-001		
B $\varnothing 4$	152636-001	D $\varnothing 3$	154069-001	F $\varnothing 2$	157237-001		
				J $\varnothing 2.5$	S13815-001		
Needle plate hole							
							
A : S02371-001		E : S02372-001		F : S02373-001		FH : S10690-001	
Presser foot							
							
S : S02441-001		M : S02288-001		L : S02469-001		MM : S05667-001	
Presser spring			Inner clamp LL				
							
1 : S02853-001		2 : S02854-001		3 : S02855-001		LL : S10542-001	

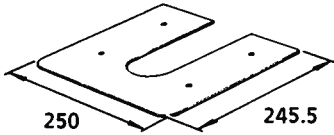
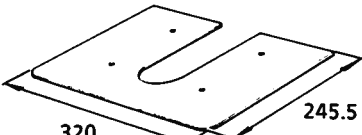
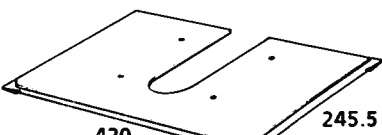
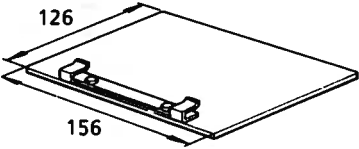
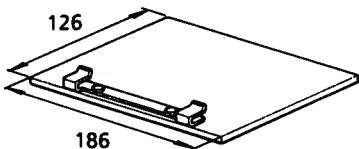
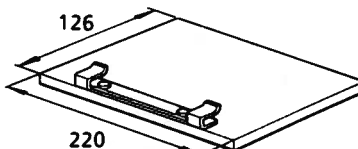
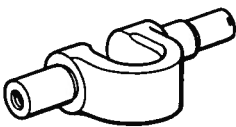
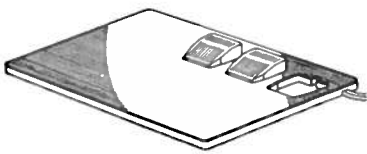
# Optional Parts Table

## BAS-326

Cassette work clamp	
① Cassette work clamp 1R      S02845-001 ② Cassette work clamp 1L      S02846-001	① Cassette work clamp 2R      S02847-001 ② Cassette work clamp 2L      S02848-001
① Cassette work clamp 3R      S02849-001 ② Cassette work clamp 3L      S02850-001	① Cassette work clamp 4R      S02851-001 ② Cassette work clamp 4L      S02852-001
1. Cassette plate D-A              S02966-001 2. Butterfly program (right)      152632-001 3. Butterfly program (left)      152633-001	1. Cassette plate U-A (t = 1)      S02968-000 2. Cassette plate U-B (t = 2)      S02971-001
1. Cassette supporter plate assembly      S02963-001 1. Cassette supporter plate assembly 180      S14384-001 2. Cassette plate D-B180              S14388-001 3. Cassette lower plate A180              S14386-000	Work clamp L                      S02470-001

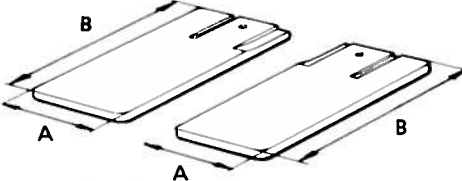
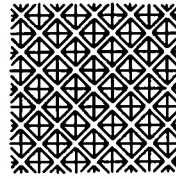
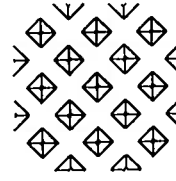
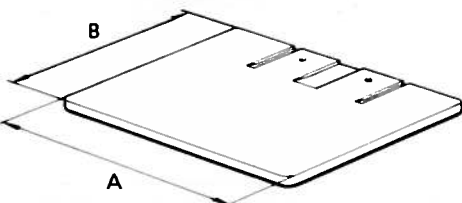
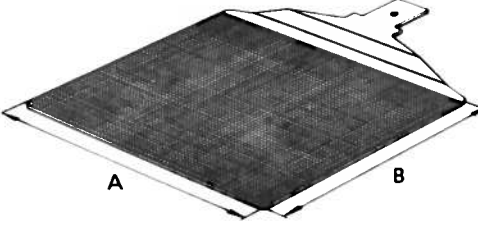
# Optional Parts Table

## BAS-326

Sub-plate		
		
250 245.5	320 245.5	420 245.5
Sub-plate S S02442-001	Sub-plate L S02443-001	Sub-plate 180 S10682-001
OT presser plate		
		
126 156	126 186	126 220
OT presser plate A assembly S03902-001 (t=0.5) OT presser plate B assembly S03903-001 (t=1) OT presser plate C assembly S03904-001 (t=2)	OT presser plate A assembly 150 S09378-001 (t=0.5) OT presser plate B assembly 150 S09379-001 (t=1) OT presser plate C assembly 150 S09380-001 (t=2)	OT presser plate A assembly 180 S13695-001 (t=0.5) OT presser plate B assembly 180 S13697-001 (t=1) OT presser plate C assembly 180 S13698-001 (t=2)
Work clamp crank	Foot operation pedal plate	
		
Work clamp plate LL S10541-001	Foot operation switch plate L assembly S02984-002	

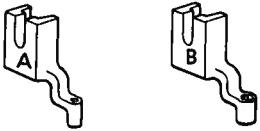
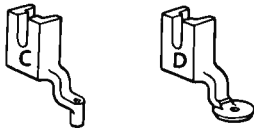
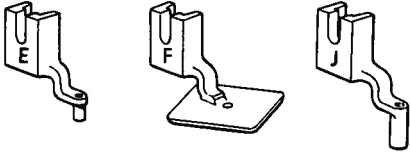
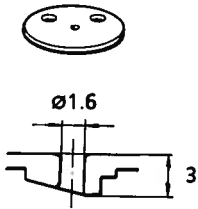
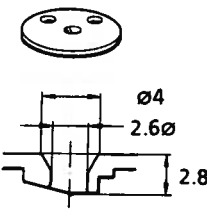
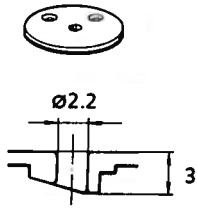
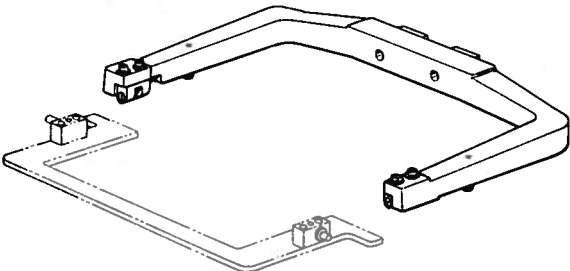
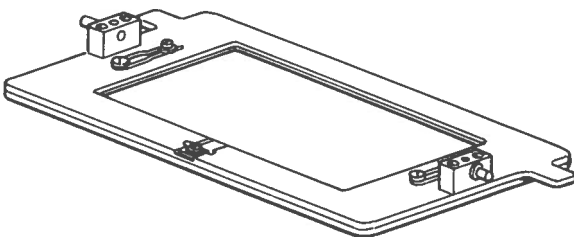
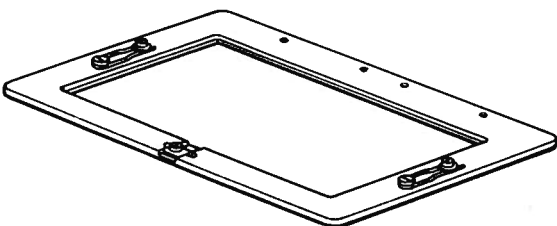
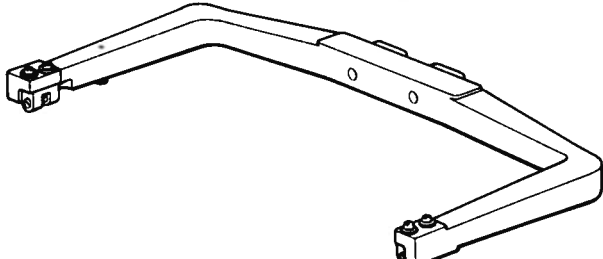
# Optional Parts Table

## BAS-326

Part names		Plate thickness	Size (A × B)	Lozenge	Parts code
<p>Work clamp blank</p>  <p>Lozenge</p>  <p>S</p> <p>Lozenge</p>  <p>L</p>	B-1R	3.2	39 × 80	S	153448-000
	B-1L				153449-000
	B-3L	4	39 × 80	L	153470-000
	B-3R				153471-000
	1-3R	3.2	50 × 110	S	S02821-000
	1-3L				S02822-000
	1-4R	4	50 × 110	L	S02823-000
	1-4L				S02824-000
	1-5R	5	50 × 110	L	S02825-000
	1-5L				S02826-000
	2-3R	3.2	75 × 135	S	S02827-000
	2-3L				S02828-000
	2-4R	4	75 × 135	L	S02829-000
	2-4L				S02830-000
	2-5R	5	75 × 135	L	S02831-000
	2-5L				S02832-000
	150R-3	3.2	90 × 135	S	S09370-000
	150L-3				S09371-000
	150R-5	5	90 × 135	L	S09372-000
	150L-5				S09373-000
L-180	3.2	123 × 135	S	S13694-000	
<p>Work clamp blank</p> 	3-3	3.2	100 × 80	S	S02833-000
	3-4	4		L	S02834-000
	3-5	5		S02835-000	
	4-3	3.2	125 × 110	S	S02836-000
	4-4	4		L	S02837-000
	4-5	5		S02838-000	
	5-3	3.2	150 × 135	S	S02839-000
	5-4	4		L	S02840-000
	5-5	5		—	S02841-000
	5-3A	3.2		—	S02981-000
	5-4A	4		—	S02982-000
	5-5A	5		—	S02983-000
	150-3	3.2	180 × 135	S	S09374-000
	150-5	5	L	S09375-000	
	180	3.2	216 × 135	S	S13693-000
<p>Feed plate blank</p> 	1	1	170 × 140	Lozenge	S02234-000
	2	2		—	S02843-000
	3	1		S02844-000	
	4	2	246 × 148	Hole	S02842-001
	5				S03309-001
	150	1	200 × 140	—	S09376-000
	180		230 × 140	—	S13692-000

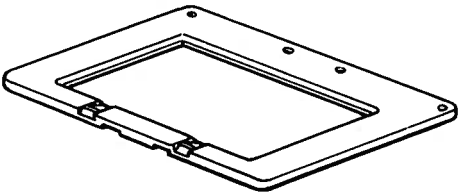
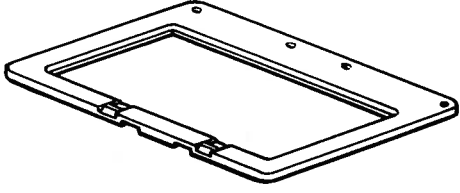
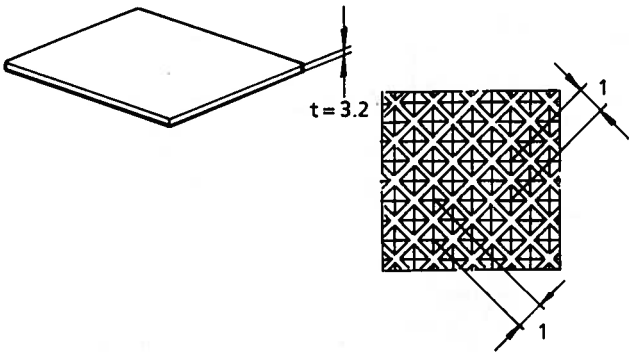
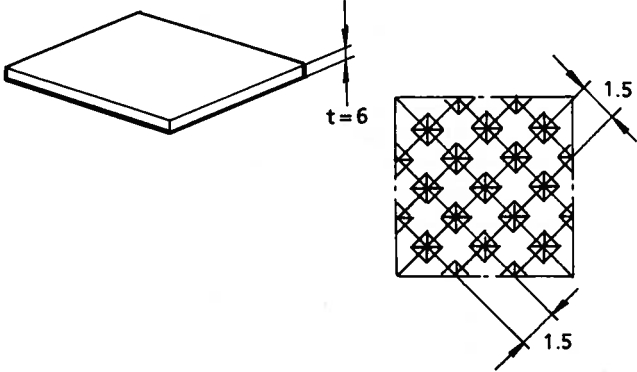
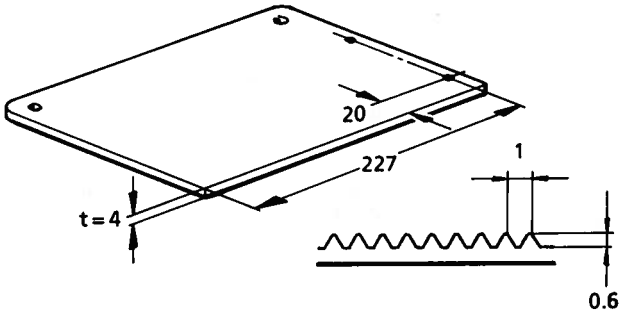
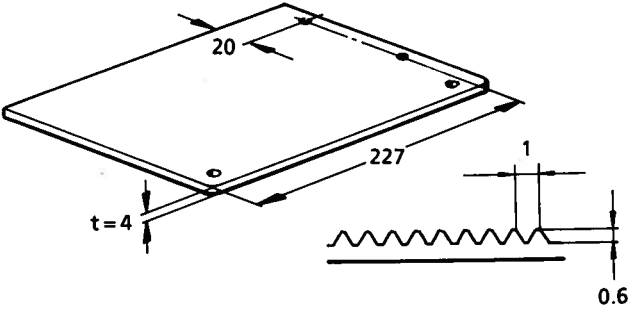
# Optional Parts Table

## BAS-340

Presser foot		
		
A $\varnothing 2.5$ 152283-101 B $\varnothing 4$ 152636-001	C $\varnothing 2$ 152637-001 D $\varnothing 3$ 154069-001	E $\varnothing 1.6$ 154089-001 F $\varnothing 2$ 157237-001 J $\varnothing 2.5$ S13815-001
Needle hole plate		
		
A : S10211-001	E : S10212-101	F : S10213-001
Presser foot UNS assembly	Presser plate UNS assembly	
		
※ This can also be used as the cassette work clamp for the BAS-326.		
S19620-009 (180 × 100)	S19611-001 (180 × 100)	
Presser foot UNL assembly	Work clamp	
		
S19635-001 (250 × 150)	S19609-009 (250 × 150)	

# Optional Parts Table

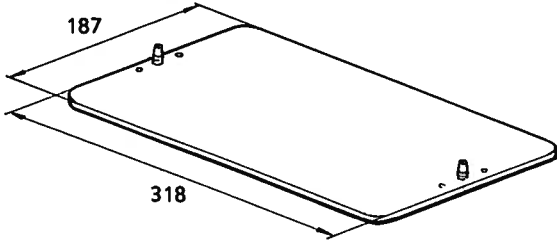
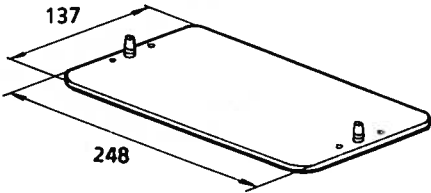
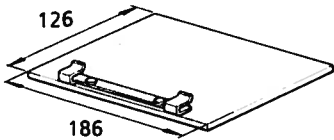
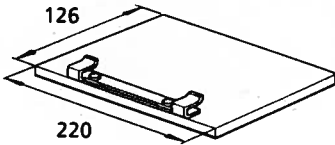


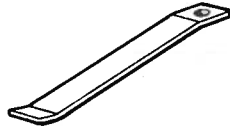
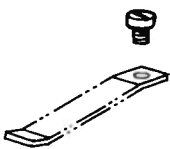
## BAS-340

Work clamp SEU	
	
S19637-001 (180 x 100)	S19638-001 (150 x 100)
Work clamp blank	
	
E1 : S17979-001	E4 : S17981-001
	
L : S19599-001	R : S19600-001



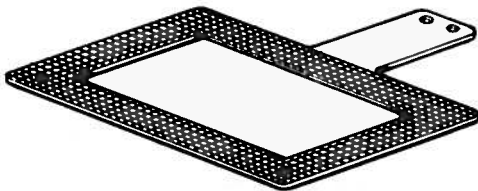
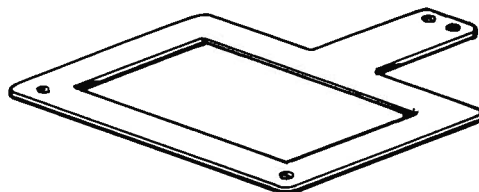
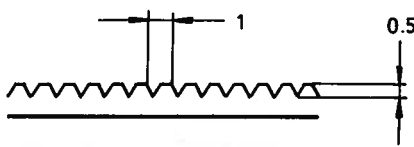
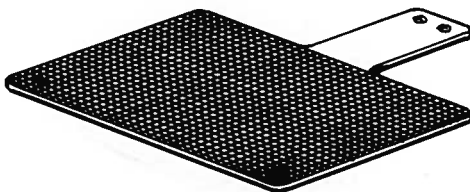
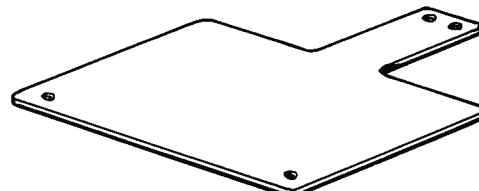
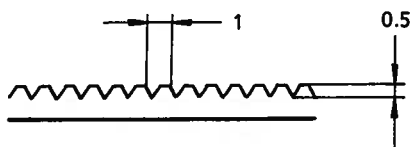
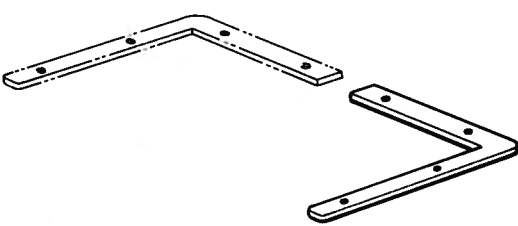
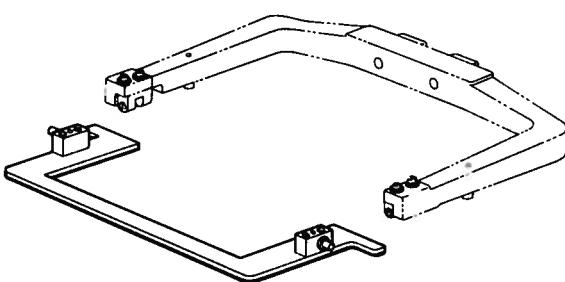
# Optional Parts Table

## BAS-340

OT work clamp assembly					
					
2	S19594-001 (T=2, 250×150)	S2	S19618-001 (T=2, 180×100)		
3	S19592-001 (T=3, 250×150)	S3	S19616-001 (T=3, 180×100)		
4	S17982-001 (T=4, 250×150)	S4	S19614-001 (T=4, 180×100)		
					
A-150	S09378-001 (T=0.5)	A-180	S13695-001 (T=0.5)		
B-150	S09379-001 (T=1)	B-180	S13697-001 (T=1)		
C-150	S09380-001 (T=2)	C-180	S13698-001 (T=2)		
Presser spring					
 <p>t=0.4</p>		 <p>t=0.6</p>		 <p>t=0.8</p>	
1	S02853-001	2	S02854-001	3	S02855-001
Screw 4.37					
		107419-002			

# Optional Parts Table

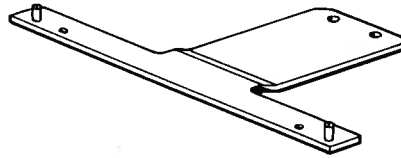
**BAS-340**

Feed plate			
			
			
A	S17894-001	C	S18543-001
Feed plate blank			
			
			
A	S17976-001	C	S17978-001
Presser plate			
			
<p>※ This can also be used as the cassette work clamp for the BAS-326.</p>			
C-1	S19634-001	C-2	S19914-001

# Optional Parts Table

## BAS-340

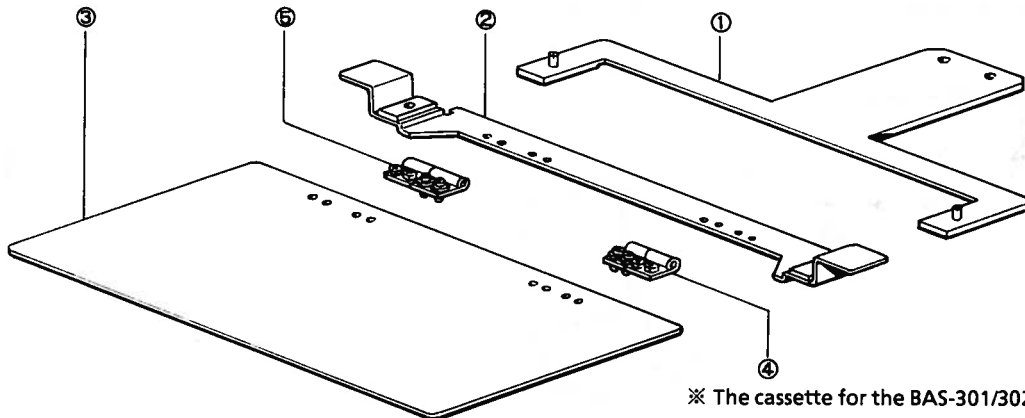
### Cassette supporter plate 326 assembly



※ The cassette for the BAS-326/326L can be used.

S19912-001

### Cassette supporter plate assembly



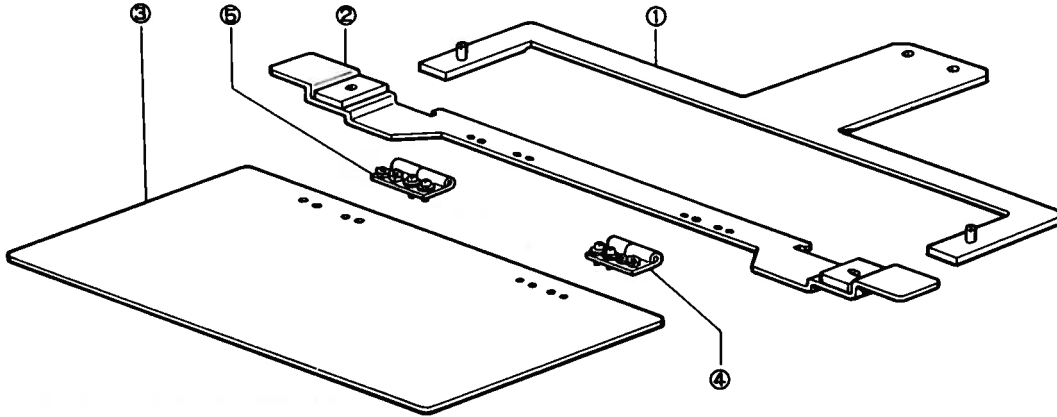
※ The cassette for the BAS-301/302 can be used.

①	Cassette supporter plate	S19627-001	④	Butterfly program (right)	152632-001
②	Cassette body	S19630-001	⑤	Butterfly program (left)	152633-001
③	Cassette lower plate	S19631-001			
Cassette center plate			Cassette upper plate		
1	(T = 1.0)	S19643-000	1	(T = 1.0)	S19644-000
2	(T = 2.0)	S19632-000	2	(T = 2.0)	S19633-000

# Optional Parts Table

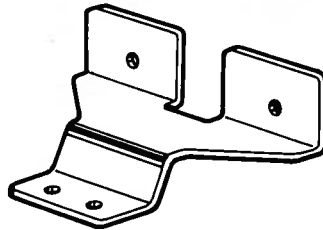
## BAS-340

### Cassette supporter plate assembly



①	Cassette supporter plate 340L assembly	S20753-001	④	Butterfly program (right)	152632-001
②	Cassette body 340L	S20755-001	⑤	Butterfly program (left)	152633-001
③	Cassette lower plate	S19631-001			

### Presser foot (SEU)



※ The work clamp for the BAS-326 can be used.

S20756-001

# BAS-300 series programming functions table

This is a guide list for using during programming. Please refer to this table for the correct instructions when you are programming.

Function	Instruction code keys	BAS-304	BAS-311	BAS-326	BAS-340
Quit	111 <input type="button" value="E"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Clear data	222 <input type="button" value="R"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Low speed conversion	666 <input type="button" value="L"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Trace	555 <input type="button" value="L"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Repeat	333 <input type="button" value="L"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Point symmetry	440 <input type="button" value="L"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
X axis symmetry	441 <input type="button" value="L"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Y axis symmetry	442 <input type="button" value="L"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Return	443 <input type="button" value="L"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Traced drawing K Mirror	001 <input type="button" value="M"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Traced drawing K Mirror	011 <input type="button" value="M"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Traced drawing K Mirror K	010 <input type="button" value="M"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Smoothing	When pitch is 3mm: 030M When not set: 2mm <input type="button" value="0"/> <input type="button" value="3"/> <input type="button" value="0"/> <input type="button" value="M"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Smoothing end	Be sure to press the corner. 789 <input type="button" value="L"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Double-row sewing width setting	For width 2mm <input type="button" value="2"/> <input type="button" value="2"/> <input type="button" value="0"/> <input type="button" value="M"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Split program	<input type="button" value="F"/> 666	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Setting enlargement and reduction modes	888 <input type="button" value="M"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Setting X ratio for enlargement and reduction modes ( <input type="text" value=""/> <input type="text" value=""/> <input type="text" value=""/> is 000 - 199%)	<input type="text" value=""/> <input type="text" value=""/> <input type="text" value=""/> <input type="button" value="F"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Setting Y ratio for enlargement and reduction modes ( <input type="text" value=""/> <input type="text" value=""/> <input type="text" value=""/> is 000 - 199%)	<input type="text" value=""/> <input type="text" value=""/> <input type="text" value=""/> <input type="button" value="M"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Parallel movement during sewing	<input type="button" value="F"/> 777	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Split program with no thread trimming	<input type="button" value="F"/> 888	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Cross stitching ( <input type="text" value=""/> can be a numeral from 0-9)	77 <input type="text" value=""/> <input type="button" value="L"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Basting program	<input type="button" value="F"/> 999	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Setting enlargement input	For twofold input <input type="button" value="9"/> <input type="button" value="0"/> <input type="button" value="2"/> <input type="button" value="M"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>

For instructions on operating the programming machine, refer to the operating instructions for each machine.

