Direct Drive
Programmable electronic pattern sewer with cylinder bed

- Sewing data is sewn faithfully and attractively
- High maximum sewing speed
- Economical operation with low power consumption
- Work clamp lift amount can be adjusted easily from the operation panel
- Easy-to-use programmer PD-3000 (optional product)

The world’s highest sewing speed has been achieved and beautiful seams can be produced even at high speeds. It provides high sewing quality and increases productivity for a wide range of applications while saving energy.

High quality sewn products made with beautiful stitching

High quality stitching exactly the way it is programmed even at high-speed sewing
With adoption of the high-rigid feed mechanism with servo-control, high-precision pattern sewing is available and feed drifting, which is electronic sewing machine-specific, does not occur even with high speed or weighty material sewing.

Low thread tension sewing is possible with stable thread tension
The high-rigid feed mechanism with servo-control and the needle bar / thread take-up mechanism having optimal timing and stroke have realized stable thread tightening at low tension sewing. It has enlarged the range of balanced thread tensions.
Presser foot control mechanism always provides uniform thread tightness

When thickness of material has been changed, the height of the stepping presser foot is changed so that a fixed amount of presser foot moving is constantly provided. This prevents the stepping presser foot from lifting too much or being excessively pressed and thus uniform thread tightness can be obtained. The height of the stepping presser foot can be set with no tools required, simply by entering a numeric value from the operation panel or in a program. Furthermore, you can use user programs to set the stepping presser foot height to the desired height separately for each sewing program.

Smooth and beautiful stitches can be produced with a minimum resolution of 0.05 mm

Since the data is resolved at 0.05 mm per pulse for the feed, slanted lines and curves are accurately sewn with beautiful finishes. Also, a simple single point embroidery motif can be sewn, and embroidering on heavy materials, which is not easy with a general embroidery machine, is also possible.

Productivity is increased with maximum sewing speed of 2,700 rpm

With the adoption of a Brother's unique direct drive motor, starting and stopping is quick. Machine time has been reduced by approximately 10% compared to the previous model and thus productivity is increased.

Economical operation with low power consumption

The direct drive mechanism greatly reduces power transmission losses, and a compact and energy-efficient motor has also been adopted. These innovations result in energy savings of approximately 50% from previous models. This is a programmable electronic pattern sewer with the lowest power consumption in the market.
**Powerful needle penetration force**

A more powerful motor (550W) has been adopted. The needle penetration force is powerful even at low speeds, and there is plenty of power available for sewing thick materials.

**Work clamp lift amount can be set on operation panel (Solenoid specification)**

As the work clamp operation is controlled by a pulse motor, the work clamp lift amount can be set simply by entering a numeric value at the operation panel without need of using tools. Furthermore, you can use the user programs to set desired work clamp lift amount for each program respectively. No need to adjust the amount at every change of programs.

**3 types of work clamp lowering operation (Solenoid specification)**

You can select desired work clamp lowering operation from three patterns by changing the memory switch settings.

Two-step drop: The work clamp drops from the highest position to pause at an intermediate position, then drops to the lowest position. Quick and accurate positioning of materials can be made with optimal work clamp height. The total cycle time can be reduced.

One-step drop: The work clamp drops from the highest position to the lowest position at once. The quick pressing operation is suitable for occasions when the positioning materials with the work clamp is not necessary while it is positioned with the feed plate beforehand.

Analog dropping: The work clamp comes down in direct proportion to the pedal depression amount without steps. You can lower it with making subtle positioning of materials.

* The factory setting is the two-step drop.

**Large-capacity memory capable of storing bulky data**

Large-capacity memory (*512 programs, 500,000 stitches) is embedded in the sewing machine so that a large quantity of data can be stored. There is no need to read a program each time it has been changed.

A compact flash (CF) card has been adopted for handling a large amount of data. Read and write speed is fast, which allows multiple data to be copied or moved to other sewing machines or computers for data management.

*The number of patterns and stitches which can be stored depends on the number of stitches for each program.*
**Easy programmer* with large color LCD**

*Easy programming*
- Programs can be easily created in the same procedure as the programmer of the previous model.
- A shape of pattern data can be checked while it is created.
- Comments can be added to the program. Also, horizontal and vertical sizes are displayed so that programs of similar figures can be identified.

*Sewing data can be managed with programmer*
Sewing data management is easy because sewing data image can be displayed and sewing data can be copied and moved easily.

*optional product

**Sewing area 130x100mm (BAS-311G)**
The sewing area of the BAS-311G is 130x100mm, which is larger than that of the previous model. It offers a wider range of applications, especially in sewing bags and jeans.

**Evenly applied presser pressure**
The angle of the work clamp can be adjusted. Pressure is given evenly to the front, rear and sides of the work clamp so that a sewn product can be clamped firmly and accurate sewing finish is obtained.

**Changing sewing pattern is simple**

*Work clamp can be replaced quickly and accurately*
Simply by loosening the two screws, the work clamp can be replaced quickly. It can also be installed accurately by using the positioning pins.

*Feed plate can be replaced accurately*
When replacing the feed plate, stitch data can be easily and accurately aligned with the feed plate by aligning the reference holes of the needle plate and the feed plate.
The adoption of a linear guide (both X and Y feed directions) has improved feed durability.

Inner clamping device*
This is operated with the outer presser by air and so material slippage will not occur. It is suitable for sewing around labels, emblems and Velcro straps.

Thread breakage detector**
When it detects thread breakage, the sewing machine stops automatically and warns its operator. It is helpful when one operator uses many machines at the same time.

Upper thread nipper**
This holds upper thread after thread trimming. It prevents the thread from tangling on the back of material, thus giving a better sewing finish. It also prevents the thread from pulling out of a needle at sewing start.

Horizontal wiper**
It wipes upper thread in the horizontal direction and is used in conjunction with the inner clamping device.

Needle cooler**
This is a pneumatic type needle cooler which prevents thread breakage due to heat. It is particularly useful for sewing heavy materials or sewing at high speeds.

Air wiper (vertical wiper)**
This is driven by a pneumatic cylinder and useful when a thread cannot be completely pulled out from fabric in sewing extra heavy materials.

Triple pedal for standing operation**
In addition to the start pedal, the right and left pedals operate independently. This allows fabric to be positioned even more precisely.

Brother has established the “Brother Green Label” in conformity with ISO 14021 international standard and JIS Q14021 Japanese Industrial Standard. BAS-311G and 326G have been approved for this standard. The models are environment-conscious machines achieving industry’s top energy saving with the direct drive system, use of lead-free solder in all PCB, and significant extension of the hook’s lifetime.

Industry’s top energy saving with the direct drive system
Use of lead-free solder in all PCB
Significant extension of the hook’s lifetime

Options

Simple adjustment

Driver phase can be adjusted easily
The driver phase can be adjusted from the side without tilting the sewing machine. This reduces time taken for the adjustment and improves productivity when materials are changed.

Pulley positioned in convenient location
The pulley is positioned in the convenient location on the side of the sewing machine arm. Needle drop and hook timing can be checked easily.

Improved durability

Environmentally friendly

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* The part codes are different for 311G and 326G.
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# Specifications

<table>
<thead>
<tr>
<th>BAS-311G-0</th>
<th>BAS-326G-0</th>
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</thead>
<tbody>
<tr>
<td><strong>Application</strong></td>
<td><strong>Work clamp</strong></td>
</tr>
<tr>
<td>1</td>
<td>For heavy materials</td>
</tr>
<tr>
<td>2</td>
<td>For medium materials</td>
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## Model Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Lock stitch</th>
<th>Double hook</th>
<th>Sewing area</th>
<th>Stitch length</th>
<th>Thread trimmer</th>
<th>Thread wiper</th>
<th>Max sewing speed</th>
<th>Air consumption</th>
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<tbody>
<tr>
<td>BAS-311G</td>
<td>★</td>
<td>2</td>
<td>130 × 100 mm</td>
<td>0.05 - 12.7 mm</td>
<td>★</td>
<td>★</td>
<td>2,700 rpm</td>
<td>1.7 l/min</td>
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<tr>
<td>BAS-326G</td>
<td>★</td>
<td>2</td>
<td>220 × 100 mm</td>
<td>0.05 - 12.7 mm</td>
<td>★</td>
<td>★</td>
<td>2,700 rpm</td>
<td>1.7 l/min</td>
</tr>
</tbody>
</table>

- **Sewing machine**: Lock stitch pattern tacking sewing machine (with double-capacity hook)
- **Stitch form**: Single needle lock stitch
- **Max. sewing speed**: 2,700 rpm for BAS-311G, 2,700 rpm for BAS-326G
- **Sewing size (X × Y)**: Max. 130 × 100 mm for BAS-311G, Max. 220 × 100 mm for BAS-326G
- **Feed mechanism**: Stepping feed (pulse motor drive)
- **Stitch length**: 0.05 - 12.7 mm
- **No. of stitches**: 20,000 stitches per pattern
- **Work clamp drive**: Pulse motor drive
- **Height of work clamp**: Solenoid: Max. 25 mm, Pneumatic: Max. 30 mm, Max. 30 mm
- **2-step work clamp**: Solenoid: Unit work clamp, Pneumatic: Separate work clamp
- **Stepping presser foot lift amount**: 22 mm
- **Stepping presser foot stroke**: 0 or 2 - 10 mm (Factory setting: 3 mm)
- **Hook**: Double-capacity shuttle hook (Standard capacity hook: Option)
- **Thread wiper**: Standard equipment
- **Thread trimmer**: Standard equipment
- **Data storage media**: Flash memory (Sewing patterns can be added using CF card), 3.5 floppy disk 2HD/1.44MB, 2DD (option)
- **Motor**: AC servo motor 550W
- **Weight**: Machine head: Approx. 88 kg, Operation panel: Approx. 0.6 kg, Control box: 14.2 - 16.2 kg (depending on destination)
- **Power supply**: Single phase 100V / 220V, 3-phase 200V/220V/380V/400V , 400VA
- **Air pressure**: 0.5 Mpa, 1.7 l/min