

BAS-311G

Direct Drive Programmable electronic pattern sewer
with cylinder bed 130mm×100mm

BAS-326G

Direct Drive Programmable electronic pattern sewer
with cylinder bed 220mm×100mm

BAS-326G-PS

Direct Drive Programmable electronic pattern sewer
with Perfect Stitch hook and cylinder bed 220mm×100mm

- 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)



BAS-326G-PS

with Perfect Stitch hook

Direct Drive Programmable electronic pattern sewer with cylinder bed
220mm×100mm

**Achieved Perfect stitch area covering more than 90% of the sewing direction while realizing high quality sewing stitches.
Regardless of material, a superior stable sewing stitch can be obtained;
Appealing stitches are here to stay.**



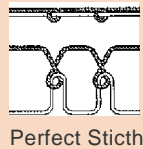
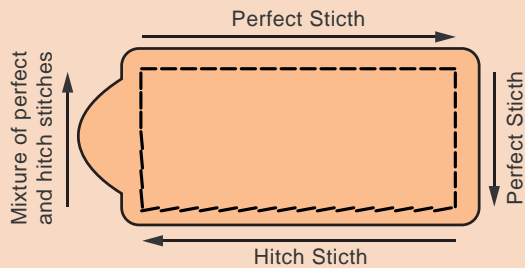
Realizing amazing high quality stitches

Special hook for perfect stitch has been newly developed and it ensures excellent thread tightening evenly. Uniform stitches and stable thread tightening can be obtained as compared with hitch stitch even with the change of sewing direction and material.

Wide-range perfect stitch area

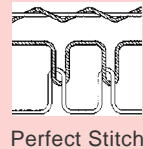
Complete perfect stitch has been achieved in rectangular pattern stitching as BAS-326G with Perfect Stitch covers its area at almost all sewing directions. Wide-range perfect stitch area contributes to improve your product quality and spread your range of sewing products.

〈Usual model〉



Perfect Sticth

〈BAS-326G-PS〉



Perfect Sticth



Realizing beautiful perfect stitch with special hook even with leather material which can usually be hitch sticth.

BAS-311G

130mm×100mm

BAS-326G

220mm×100mm

Direct Drive Programmable electronic pattern sewer
with cylinder bed

The world's high-class sewing speed has been achieved and bea It provides high sewing quality and increases productivity for a v

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 machinespecific, does not occur even with high speed or weighty material sewing.

Low thread tension sewing is possible with stable thread tension

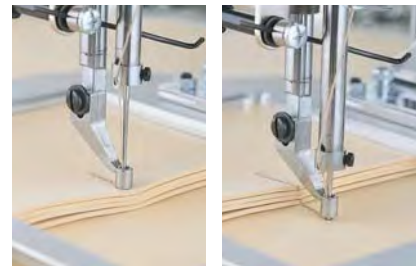
The high-rigid feed mechanism with servo-control and the needle bar / thread take-up mechanism having optimal timing and stroke have realized stable thread tightening at low tension sewing. It has enlarged the range of balanced thread tensions.



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 sti/min

With the adoption of a Brother's unique direct drive motor, starting and stopping is quick. Machine time has been reduced by approximately 19% compared to the previous model and thus productivity is increased.

* When sewing at a sewing speed of 2,700sti/min, set the stitch length to 4mm and under.

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.

Environmentally friendly

Brother has established its original "Brother Green Label" for the products, in conformity with ISO 14021 and JIS Q14021. BAS-311G and 326G is certified as an environment-conscious sewing machine according to the "Brother Green Label" standard. The machine is compliant with the RoHS Directive*. The use of the restricted substances such as lead, cadmium, hexavalent chromium is absolutely within the regulation values. Brother has been providing all its products in accordance with the RoHS Directive for all market areas(excluding machine tools).

* The RoHS Directive(the restriction of the use of certain hazardous substances in electrical and electronic equipment) came into effect in the EU in July 2006.



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

Beautiful seams can be produced even at high speeds.
Wide range of applications while saving energy.

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



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.



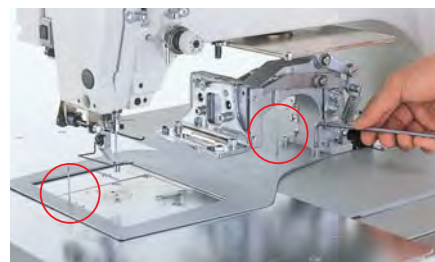
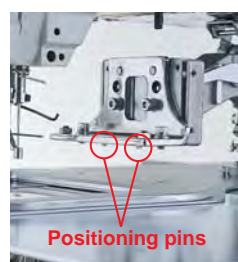
Changing sewing pattern is simple

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.



Work clamp lift amount can be set on operation panel (BAS-311G Motor-driven work clamp spec.)

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 (BAS-311G Motor-driven work clamp spec.)

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

Two-step lowering*:

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

One-step lowering:

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

Analog lowering:

The work clamp is lowered in direct proportion to the pedal depression amount without steps. You can lower it with making subtle positioning of materials.

* The factory setting is two-step lowering.



Simple adjustment

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.



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.



Options

- Needle cooler*
(SA5559101)
- Thread wiper set*
(Pneumatic type)
(SA5575101)
- Inner clamping device
(100 x 60)(SA7189101)
- Thread breakage detector
(SA5193101)
- Triple pedal foot switch
(SA6495101)
- Sewing data
programming software
PS-300B

* This device requires the optional solenoid valve set.



Specifications

BAS-311G-0

Application		Work clamp	
1	For heavy materials (#20 or similar thread)	S	Motor-driven work clamp
2	For medium materials (#50 or similar thread)	A	Pneumatic work clamp
3	For seat belt (#4 or similar thread)		



BAS-311G-01S

BAS-326G-0

Application		Work clamp	
1	For heavy materials (#20 or similar thread)	A	Pneumatic work clamp
2	For medium materials (#50 or similar thread)		
3	For seat belt (#4 or similar thread)		



BAS-326G-01A

※01A-PS for heavy materials only

Hook	
PS	Perfect stitch hook

	BAS-311G	BAS-326G	BAS-326G-PS*1
Sewing machine	Lock stitch pattern tacking sewing machine		
Stitch form	Single needle lock stitch		
Max. sewing speed	2,700sti/min*2		
Sewing area (X_Y)	Max.130 x 100 mm	Max. 220 x 100 mm	
Feed mechanism	Intermittent feed (pulse motor drive)		
Stitch length	0.05 - 12.7mm		
Max. number of stitches	20,000 stitches per pattern		
Work clamp drive	Pulse motor drive / Pneumatic drive	Pulse motor drive	
Work clamp lift amount	-0□S: Max. 25 mm -0□: Max. 30 mm	Max. 30 mm	
2-step work clamp	-0□S: Unit work clamp -0□A: Separate work clamp	Separate work clamp	
Height of stepping presser foot	22mm		19.5mm
Stepping presser foot stroke	2 - 4.5 mm, 4.5 - 10 mm or 0 (Factory setting:3mm)		
Hook	Double-capacity shuttle hook (Standard capacity hook: Option)		Double-capacity rotary hook
Thread wiper	Standard equipment		
Thread trimmer	Standard equipment		
Data storage media	Flash memory (Sewing patterns can be added using CF card)		
Motor	AC servo motor 550W		
Weight	Machine head: Approx. 88 kg(BAS-311G/326G)·Approx.90kg(BAS-326G-PS), 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/consumption	0.5Mpa 1.8 l/min		

*Thread counts are for reference. Please consult your local Brother sales office for details.

*1 BAS-326G-PS is for heavy materials only.

*2 When sewing at a sewing speed of 2,700 sti/min, set the stitch length to 4mm and under.

RoHS Compliant

BAS-311G/326G is compliant with the RoHS Directive (the restriction of the use of certain hazardous substances in electrical and electronic equipment) which came into effect in the EU in July 2006.

Product specifications are subject to change for improvement without notice. Please read instruction manual before using the machine for safety operation.



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Brother Industries, Ltd. Machinery & Solution Company
Kariya and Minato plants acquired ISO 9001 and 14001 certifications.

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