

- Default setting
- ← Same contents as arrows direction
- * Note

430F		
MSWNo	MSWNo	Setting detail
1	1	Work clamp/button clamp lift timing when sewing is complete
		OFF Does not lift automatically.
		1 Lifts at the final stitch position.
		2 Lifts after moving to the sewing start position.

2		
3		

100	100	Slow start pattern setting method
		OFF The sewing speed for the first 1 - 5 stitches is set by memory switch Nos. 151 – 155.
		ON Follows the slow start patterns for each program. Can be selected Lo1 to Lo9
200	200	Single stitch test feed
		OFF During test feeding, sewing starts and automatically continues to the last stitch.
		ON During test feeding, the mechanism moves one stitch at a time.
300	300	Display of counter
		OFF Lower thread counter
		ON Production counter

401	401	Button hole distance display (BE-438F only)
		OFF X-scale and Y-scale will be displayed as pattern outer dimensions (mm).
		ON X-scale and Y-scale will be displayed as button hole distances (mm).
402	402	X-scale/Y-scale mm display
		OFF Displayed as %.
		ON Displayed as mm.

404	404	Display for program numbers 1 to 89 (1 to 64 for BE-438F)
		OFF Program numbers 1 to 89 (1 to 64 for the BE-438F) are skipped.
		ON Program numbers 1 to 89 (1 to 64 for the BE-438F) are displayed.

311H		
MSWNo	MSWNo	Setting detail
1		← * Default setting is 2
2		→
3		→
100		← * Default setting is "OFF".
200		←
300		←
400	400	Setting of sewing condition
		OFF Use common parameter for all programs
		ON Use parameter for each program independently
		* When MSW400 set to OFF, cycle program will skip for selecting program number.
402		←
403	403	→
		0 Continuous split (split menu is always enabled)
		1 Independent split
		* No function assetting 0 of BAS-311G

311G		
MSWNo	MSWNo	Setting detail
1	1	←
		OFF Lifts at the final stitch position.
		ON Lifts after moving to the sewing start position.
		* MSW58 can be set "Dose not lift automatically".
2	2	Separated-type work clamp drop operation (pneumatic specification)
		0 Work clamp dropping in 1 step
		1 Work clamp drops in the order left → right.
		2 Work clamp drops in the order right → left.
3	3	Work clamp drop operation (solenoid specifications)
		0 Analog dropping: Work clamp drops in direct proportion to the pedal depression amount, and sewing starts when the pedal is fully depressed
		1 1st step drop: Work clamp drops when pedal is depressed to the 1st step, and sewing starts when pedal is depressed to the 2nd step
		2 2nd step drop: Work clamp drops to intermediate height when the pedal is depressed to the 1st step, and work clamp drops and sewing starts when the pedal is depressed to the 2nd step.
100		← * Default setting is "OFF".
200		←
300		←
400	400	User programs
		OFF Disabled
		ON User program mode is enabled.
401	401	Cycle program
		OFF Disabled
		ON When sewing user programs, the set programs are sewn in numeric order.
402		←
403	403	Split mode selection
		0 Continuous split (split menu is disabled before split detection)
		1 Continuous split (split menu is always enabled)
		2 Independent split

430F		
405	405	Cycle program No. display (C01 to C30)
		OFF Cycle program numbers are skipped ON Cycle program numbers are displayed
406	406	Program numbers switched by F keys
		0 When the F1 to F4 keys are pressed, operation switches to program numbers 1 to 4.
		1 When the F1 to F4 keys are pressed, operation switches to program numbers 201 to 204.
		2 When the F1 to F4 keys are pressed, operation switches to cycle program numbers C01 to C04
		3 When the F1 to F4 keys are pressed, operation switches to the program number which has been pre-assigned to the respective key. F1:MSW407 F2:MSW408 F3:MSW409 F4:MSW410
407	407	Program No. assigned to the F1 key 1 - 999, C01 - C30 Default setting is 1
408	408	Program No. assigned to the F2 key 1 - 999, C01 - C30 Default setting is 2
409	409	Program No. assigned to the F3 key 1 - 999, C01 - C30 Default setting is 3
410	410	Program No. assigned to the F4 key 1 - 999, C01 - C30 Default setting is 4
500	500	Thread nipper operation OFF Not used
		ON Used * However, all of the following conditions must be satisfied. Memory switch No. 100 = ON Memory switch No. 566 = ON Slow start speed is Lo8 or Lo9 Sewing speed is 1500 sti/min. or more]

311H		
405	405	* When MSW400 set to OFF, cycle program will skip for selecting program number.
		←
406	406	0 When the F1 to F4 keys are pressed, operation switches to program numbers 101 to 104
		1 When the F1 to F4 keys are pressed, operation switches to cycle program numbers C01 to C04
		2 When the F1 to F4 keys are pressed, operation switches to the program number which has been pre-assigned to the respective key. F1:MSW407 F2:MSW408 F3:MSW409 F4:MSW410
		←
407	407	100 - 999, C01 - C30 Default setting is 101
408	408	100 - 999, C01 - C30 Default setting is 102
409	409	100 - 999, C01 - C30 Default setting is 103
410	410	100 - 999, C01 - C30 Default setting is 104

311G		
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50	50	311G MSW50 ⇒ 311H MSW
		1 → MSW70=1 MSW71=1 2 → MSW70=1 MSW71=2 3 → MSW70=2 MSW72=1 4 → MSW70=2 MSW72=2 5 → MSW70=2 MSW72=3 6 → MSW70=2 MSW72=4 7 → MSW70=2 MSW72=5 8(Solenoid) → MSW70=1 MSW71=3 8(Air) → MSW70=2 MSW72=6 9 → MSW70=3 MSW73=1 10 → MSW70=3 MSW73=2 11 → MSW70=3 MSW73=3 12 → MSW70=2 MSW72=7
51	51	Work clamp/button clamp operation before moving to the sewing start position
		OFF The work clamp/button clamp cannot operate before moving to the sewing start position. ON The work clamp/button clamp can operate even before moving to the sewing start position.
52	52	Work clamp/button clamp operation during pause (split program)
		OFF The work clamp/button clamp can rise automatically during a pause (split program). ON The work clamp/button clamp cannot rise automatically during a pause (split program).

51	51	→
		←
52	52	←

50	Work clamp operating mode	
	1	Standard single pedal
	2	Single pedal with no automatic work clamp lifter
	3	Standard 2 pedal
	4	2 pedal with no automatic work clamp lifter
	5	Left/right work clamp → Intermittent presser foot 2-step work clamp
	6	Left and right alternating 2-step work clamp
	7	Using Treadle unit
	8	2-step work clamp using two presses
	9	Standard 3 pedal
	10	3 pedal with independent home detection
	11	Special 3 pedal with independent home detection
12	Single pedal operation using work clamp switch	
51	Work clamp operation before moving to the sewing start position	
	OFF	The work clamp cannot operate before moving to the sewing start position. ON The work clamp can operate even before moving to the sewing start position.
52	52	←

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60	60	Time after the work clamp drops until the upper shaft starts rotating [mS] 0 - 3000 Default setting : 0 mS
70	70	Type of foot switch used 1 Treadle unit 2 Two pedal foot switch
71	71	Treadle unir operating mode 1 (1st step) Drop → (2nd step) Start 2 (1st step) Drop to intermediate height → (2nd step) Drop and start
72	72	Two pedal foot switch operating mod 1 (Work clamp switch 1st step) Drop, (Start switch) Start 2 (Work clamp switch 1st step) Drop to intermediate height → (Work clamp switch 2nd step) Drop, (Start switch) Start 3 (While work clamp switch depressed to 1st step) Work clamp/button clamp rises, (Start switch) start 4 (Work clamp switch 1st step) Drop → (Work clamp switch 2nd step) Start 5 (Work clamp switch 1st step) Drop to intermediate height → (Work clamp switch 2nd step) Drop and start

311H

53		→
54		→
55		→
56		→
57		→
* Unified to MSW001		
59	Setting for work clamp weight (pneumatic type only)	
	0	Standard
	1	Use heavier work clamp
60		←
70		←
	1	Treadle unit (Solenoid type default setting)
	2	Two pedal foot switch
	3	Three pedal foot switch
71		←
	1	Standard treadle unit operation
	2	Single pedal with no automatic work clamp lifter
	3	Two stage clamp down motion
72		←
	1	Standard two pedal operation (Peumatic type default setting)
	2	Standard two pedal operation w/o automatically work clamp lift up
	3	Left/right work clamp → Intermittent presser foot 2-step work clamp
	4	Left and right alternating 2-step work clamp
	5	Using Treadle unit
	6	2-step work clamp using two presses
	7	Single pedal operation using work clamp switch
73	Three pedal operation	
	1	Standard 3 pedal operation
	2	3 pedal with independent home detection
	3	Special 3 pedal with independent home detection

311G

53		Time from intermittent presser foot lifting until feed mechanism starts moving 0 - 999 Default setting is 100 [ms].
54		Intermittent presser foot drop timing 0 Presser foot drops when the work clamp switch is depressed, but it does not drop at the feed retract position. 1 Presser foot drops when the work clamp switch is depressed. 2 Presser foot drops at the sewing start, regardless of the work clamp switch operation.
55		Work clamp signal valve special output for pneumatic-type work clamp (pneumatic specifications) 0 Disabled 1 Valve output is reversed for pneumatic specifications 2 Reverse valve output is output simultaneously for 2-position valve specifications.
56		Thread winding operation before home position is detected OFF Thread winding cannot be carried out before home position is detected. ON Thread winding can be carried out before home position is detected.
57		Work clamp operation when feed moves to sewing start position after home position is detected OFF Work clamp stays dropped after home position is detected ON Work clamp lifts automatically after home position is detected.
58		Work clamp operation at sewing end OFF Work clamp lifts automatically at the sewing end ON Work clamp does not lift automatically at the sewing end

430F

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150	150	Highest needle position stop	
		OFF	Disabled
		ON	When the upper shaft stops, the motor operates in reverse to return the needle bar close to its highest position.
151	151	1st stitch sewing speed at the sewing start	
		200 - 3200	
152	152	2nd stitch sewing speed at the sewing start	
		200 - 3200	
153	153	3rd stitch sewing speed at the sewing start	
		200 - 3200	
154	154	4th stitch sewing speed at the sewing start	
		200 - 3200	
155	155	5th stitch sewing speed at the sewing start	
		200 - 3200	
156	156	Sewing speed for 5th stitch before the sewing end	
		200 - 3200	
157	157	Sewing speed for 4th stitch before the sewing end	
		400 - 3200	
158	158	Sewing speed for 3rd stitch before the sewing end	
		400 - 3200	
159	159	Sewing speed for 2nd stitch before the sewing end	
		400 - 3200	
161	161	Effective hammer operation when needle does not pierce	
		OFF	Disabled
		ON	Enabled
162	162	Regulation of sewing speed changes due to sewing pitch changes	
		OFF	Not restricted (Sewing speed varies depending on sewing pitch of the sewing data.)
		ON	Restricted (Speed is fixed at the minimum sewing speed for the maximum pitch of the sewing data.)

150	←
151	← *Setting range 200 - 2800
152	← *Setting range 200 - 2800
153	← *Setting range 200 - 2800
154	← *Setting range 200 - 2800
155	← *Setting range 200 - 2800
156	← *Setting range 200 - 2800
157	← *Setting range 200 - 2800
158	← *Setting range 200 - 2800
159	← *Setting range 200 - 2000
161	←
162	←

150	←
151	← *Setting range 200 - 2700
152	← *Setting range 200 - 2700
153	← *Setting range 200 - 2700
154	← *Setting range 200 - 2700
155	← *Setting range 200 - 2700
156	← *Setting range 200 - 2700
157	← *Setting range 200 - 2700
158	← *Setting range 200 - 2700
159	← *Setting range 200 - 2000
161	←
162	←

430F		
163	163	Sewing speed limit value
		1200 - 3200 Default setting : 3200
164	164	Thread trimming operation prevention
		OFF Thread trimming is carried out in accordance with the sewing data. ON All thread trimming operations are disabled.
165	165	Stop position at highest needle position stop
		-20 - 20 Default setting : 0
166	166	Delay time until reverse operation starts during highest needle position stop operation
		10 - 500 Default setting : 150
167	167	Servo lock operation
		ON Enabled OFF Disabled
168	168	Servo lock timer setting
		OFF 1 - 120 Default setting : OFF
169	169	Servo lock release rotation angle
		30 - 89 Default setting : 45
170	170	Lowers the allowable speed for the sewing pitch by the amount set.
		.0 - 2800 Default setting : 0
171	171	Automatic needle lifter operation
		ON If the needle bar is not at the needle up stop position during work clamp/button clamp home position detection, it moves automatically to the needle up stop position. OFF An "UP" error is displayed without the needle bar moving automatically.

311H		
163		← *Setting range 1200 - 2800
164		←
165		← *Setting range -20 - 20
166		←
167		←
168		←
169		←
170		←
171		←

311G		
163		← *Setting range 1200 - 2700
164		←
165		← *Setting range -15 - 0

250	250	Home position detection at the sewing end
		OFF 縫い終わり時、送り板は始点位置へ戻る ON At the sewing end, the work clamp/button clamp will detect the home position and then move to the sewing start position.
251	251	Feeding speed
		1 100mm/s (Slow)
		2 200mm/s
		3 300mm/s
		4 400mm/s
5 500mm/s (Fast)		
252	252	High-speed test feed method
		OFF Normally slow, but becomes faster when the foot switch is depressed to the 1st step ON High-speed feeding starts at the same time test feeding starts.
253	253	Moving method to the sewing start point
		0 Treadle unit
		1 [RESET] key
		2 External input switch [EXIN3]

250		←
251		←
252		←
253		←

250		←
251		←
252		←
253		←
	OFF Start switch	
	ON External input switch [EXIN3]	

254

260	260	-80 - 80	Default setting : -15
261	261	-80 - 80	
262	262	-80 - 80	
263	263	-80 - 80	
264	264	-80 - 80	
265	265	-80 - 80	
266	266	-80 - 80	
267	267	OFF	No restriction
		1 - 99	When the specified number of stitches from the sewing start is exceeded, the feed timing returns to the standard timing.
268	268	0	Feed start reference
		1	Needle up reference
		2	Feed end reference
269	269	0	Feed start reference
		1	Needle up reference
		2	Feed end reference
270	270	0	Moves to sewing start position and then stops.
		2	Home position detection is carried out, then moves to the sewing start position and stops.

254	0	No restriction
	1	Home position detection X→Y, move to start position Y→X.
	2	Home position detection Y→X, move to start position X→Y.
	3	Move avoid center of work clamp.
260	-80 - 80	Default setting : 0
261	-80 - 80	Default setting : 0
262	-80 - 80	Default setting : 0
263	-80 - 80	Default setting : 0
264	-80 - 80	Default setting : 0
265	-80 - 80	Default setting : 0
266	-80 - 80	Default setting : 0
267		
268		
269		
270	0	Move to sewing start position w/o home position detecting.
	1	Home position detection operation is disabled, but feed moves through the middle of the sewing area.
	2	Home position detection is carried out, then moves to the sewing start position and stops.
	3	Move to sewing start position when program number has been changed.

254	Movement path from home position to start position	
	0	Moves to the start position simultaneously for X and Y, in the order of in front of Y→middle of X.
	1	Moves to start position in the order of X start point→Y start point in the order of in front of Y→middle of X.
	2	Moves to start position in the order of right edge of X→Y start point→X start point in the order of right edge of X→in front of Y.
	3	Moves to start position in the order of left edge of X→Y start point→X start point in the order of left edge of X→in front of Y.
260	-10 - 10	Default setting : 0, Unit : 8°
261	-10 - 10	Default setting : 0, Unit : 8°
262	-10 - 10	Default setting : 0, Unit : 8°
263	-10 - 10	Default setting : 0, Unit : 8°
264	-10 - 10	Default setting : 0, Unit : 8°
265	-10 - 10	Default setting : 0, Unit : 8°
266	-10 - 10	Default setting : 0, Unit : 8°
267		
268	0	
	1	
	2	
	3	Linked to speed
269	Adjusts the feed motor output	
	-5 - 5	-5: Low← 0: Standard → 5: High
270	Home position detection operation when the program is changed	
	0	Disabled
	1	Home position detection operation is disabled, but feed moves through the middle of the sewing area.
	2	Enabled

430F		
271	271	Work clamp/button clamp standby position
		OFF The sewing start position becomes the standby position. ON The center of the sewing area is the standby position (escape point).
272	272	Reduced feed noise
		OFF Disabled ON Enable (Operating speed is limited to 2500 sti/min.)
273	273	Start switch operation after program is changed
		OFF Only moves to sewing start position ON Moves to sewing start position and starts

311H

311G

350

* This function is done by protect setting

350		Operation panel changing limitation	
	0	No limits on changing setting values using the operation panel.	
	1	Program numbers, XY scale, sewing speed, lower thread counter, work clamp height, intermittent height and digital tension values cannot be changed.	
	2	Program numbers, XY scale, sewing speed, work clamp height, intermittent height and digital tension values cannot be changed.	
	3	Program numbers cannot be changed.	
	4	Program numbers and XY scale settings cannot be changed.	
	5	Program numbers, XY scale and sewing speed settings cannot be changed.	
	6	XY scale settings cannot be enlarged. (They can be reduced.)	
	7	Sewing speed setting cannot be changed.	

351

* This function is done by protect setting

351		Changing memory switches	
	OFF	Allowed	
	ON	Forbidden	

352		
352	352	Production counter counting units
		OFF Counted for each item of sewing data. ON Counted for each cycle program.

352 →

352		Counting method for lower thread counter and production counter	
	0	Counted for each item of sewing data	
	1	Counted for each thread trimming operation.	
	2	Counted when sewing data ends or when split stops	

353		
353	353	Lower thread counter counting operation
		OFF Counted at the sewing end. ON Counted at the sewing start.

353 ←

353 ←

354

354 →

354		Switching program numbers using an external switch	
	0	Disabled	
	1 - 9	Program number is switched by option input (EXIN6 - EXIN10).	

355

355 →

355		Switches split numbers using an external switch	
	OFF	Disabled	
	ON	Split number is switched by option input (EXIN6 – EXIN10).	

430F

460

451

Split mode selection	
OFF	Continuous split mode
ON	Independent split mode

452

460

X direction sewing area limitation	
0.0 - 40.0	

461

Y direction sewing area limitation	
0.0 - 30.0	

462

Enlargement/reduction reference point	
0	Center of sewing frame
1	Sewing start point
2	Center of pattern
3	Front of pattern center
4	Back of pattern center
5	Back-left corner of sewing area
6	Front-left corner of sewing area
7	Back-right corner of sewing area
8	Front-right corner of sewing area

463

Enlargement/reduction of bar tacking	
OFF	Bar tacking stitch lengths (pitch less than approx. 1 mm) are not enlarged or reduced.
ON	Bar tacking stitch lengths (pitch less than approx. 1 mm) are also enlarged or reduced.

464

465

Setting parallel movement amount for sewing pattern	
1	The movement amount is initialized when the power is turned off and when the program number, pattern number, X-scale or Y-scale is changed.
2	The movement amount is retained when the power is turned off, but is initialized when the program number, pattern number, X-scale or Y-scale is changed.
3	The movement amount can be set for each program using parameters.

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311H

* This setting can be done by MSW270.

* This setting can be done by MSW403.

* This function is done by protect setting

460

0 - 150	←
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461

0 - 100	←
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462

	←
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* This function is not assigned for BAS-311H.

* This function is not assigned for BAS-311H.

465

	←
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* Deleted this memory switch setting for BAS-311H.

* Deleted this memory switch setting for BAS-311H because can't be read data of A type machines.

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	→
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311G

450

Moving to start point when switching user programs	
OFF	Feed moves to the start point after starting and switching.
ON	Feed moves to the next sewing start point at the same time as the user program switches.

452

Limitations on changing settings for user programs.	
OFF	No limit
ON	User program contents cannot be changed.

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0~130	←
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461

0~100	←
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462

0	Center of sewing frame
1	Sewing start point
2	Center of pattern

463

	←
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464

Enlargement/reduction ratio in XY directions	
OFF	Disabled
ON	Enlargement/reduction ratio setting is the same for X and Y

465

Storing parallel movement amount for sewing pattern	
OFF	Initialized when program number or enlargement/reduction ratio is changed and when power is turned off.
ON	Initialized when program number or enlargement/reduction ratio is changed but not when power is turned off.

466

Reading sewing data from eternal media into internal memory	
0	Normal mode
1	Overwrite mode
2	Assignment mode

467

Changing gear ratio correction method when reading from a 2DD floppy disk.	
0	Automatic conversion as specified by sewing machine model.
1	BAS-311A data is read.
2	BAS-326A data is read.
3	BAS-341A/BAS-342A data is read.

468

Retract point switching at parallel movement point	
OFF	Disabled
ON	The position moved to by parallel movement is recorded as the retract point.

430F		
469	469	Tension value setting
		OFF Set separately for each program. ON A common tension value is set for all programs.
470	470	Work clamp/button clamp height setting for each program
		OFF A common work clamp/button clamp height is set for all programs. ON Work clamp/button clamp height is set separately for each program.
471	471	Work clamp/button clamp raise position setting 10 - 17 Default setting : 14
472	472	Work clamp/button clamp intermediate drop position setting 1 - 17 Default setting : 1

550	550	Output for needle cooler device when machine is stopped.
		OFF Disabled 100 - 2000 Output is continued for the specified time. [mS]
551	551	Upper thread tension release at the sewing start
		OFF Not released 1 - 3 Released during the specified number of stitches.

552

553

554	554	Use of the thread breakage sensor
		OFF Disabled ON Fiber type thread detector
555	555	Sewing start sensing sensitivity for thread breakage sensor
		OFF 5 stitches at sewing start, 3 stitches during sewing ON 10 stitches at sewing start, 3 stitches during sewing

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311H

550	←
551	←
552	→ * Units 1 degree steps
* BAS-311H does not equipped upper thread nipper device	
554	←
555	←
556	→
557	→
558	→
559	→
560	→
561	→

311G

550	←
551	Tension release setting at the sewing start OFF Disabled ON Enabled
552	Tension release timing during thread trimming [Units 8 degree steps] -10 - 1 -10: Early ← 0: Standard → 1: Late
553	Thread nipping timing 1 - 4 1: Early ← 2: Standard → 4: Late Default setting : 2
554	←
555	←
556	Inner clamping device 0 Disabled 1 Inner clamping device is used. (Retract operation is carried out at the sewing end to prevent interference with the needle.) 2 Inner clamping device is used. (No retract operation at the sewing end.) 3 Inner clamping device operates for 1/4 of the sewing pattern and returns for the other 3/4.
557	External wiper device 0 Disabled 1 Solenoid-type wiper device is used. 2 Pneumatic-type wiper device is used.
558	External error monitoring input OFF Disabled ON Enabled (P10, option input No. 13 [AIRSW])
559	Operating indicator output OFF Disabled ON Option output No. 9 to No. 11
560	Automatic ejector 0 Disabled 1 Standard operation 2 Sewing starts when cassette sensor is ON. 3 Start switch is enabled even if cassette sensor is OFF.
561	Timer from sensor detection to sewing start when automatic ejector automatic starting is set. 0 - 999 Default setting : 100 [mS]

430F

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Newly available on KE-430FS

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to
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311H

* No digital tension equipped on BAS-311H

* This function can be set by MSW564.

2-step tension is possible

564	OFF	Disabled
	ON	2-step tension is used.

565

* No nipper device equipped on BAS-311H

567

Detecting timing for bobbin thread detector

569	0	Not used
	1	Before sewing starts
	2	End of sewing
	3	before and end of sewing

Waiting time for bobbin thread detector is completed

570	1 - 99	Default setting : 30 x 10 [mS]
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Waiting time for bobbin thread detector reaction

571	1 - 99	Default setting : 30 x 10 [mS]
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Signal output time for bobbin thread detector

572	1 - 99	Default setting : 50 x 10 [mS]
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580 - 599 Omit these memory switch setting for KE-430F only such as thread nipper, trimming solenoid

Error release method when operation has stopped

650	0	Press the RESET key on the operation panel.
	1	Press the RESET key or the STOP switch (optional)
	2	Press the RESET key or external input switch (EXIN2).

Needle stop position when sewing is interrupted by the STOP switch

651	OFF	Needle stops in the down position.
	ON	Needle stops in the up position.

Thread trimming operation when sewing is paused

652	OFF	Thread trimming is carried out when the pause is canceled.
	ON	Thread trimming is not carried out when the pause is canceled.

311G

Changes the digital tension setting value.

562	OFF	Tension number can be changed regardless of the sewing data.
	ON	Only tension No. 0 and the tension numbers detected in the sewing data can be changed.

2-step tension is possible

563	OFF	Disabled
	ON	2-step tension is used.

Increases maximum tension release force when using a spring-type

564	0	Disabled
	1	Do not use this setting.
	2	Do not use this setting.
	3	Increases the force.
	4	Increases force to the maximum.

566

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653

* External input switch : EXIN3

* External input switch : EXIN3

Needle stop position when sewing is interrupted by the STOP switch

651	0	Needle stops in the down position.
	1	Needle stops in the up position.
	2	Needle stops in the up position after thread trimming.

Resuming sewing after sewing is paused

653	OFF	STOP switch → RESET key → ▼ key → Sewing starts
	ON	STOP switch → RESET key → Sewing starts

430F		
654	654	Stop switch has been installed after sold
		OFF Disabled
		ON Enabled
655	655	Disables the needle up stop position monitoring sensor
		OFF Enabled (If needle up stop position is incorrect, "UP" will be displayed.)
		ON Disabled

656		
657	657	Time from error occurring to buzzer stopping
		OFF Buzzer does not stop.
		2 - 30 Buzzer stops after the specified time.

750	750	Continuous operation mode
		OFF Disabled
		ON While the foot switch is being depressed to the 2nd step, the work clamp moves up and down once and then continuous operation starts.

751	751	Continuous operation cycle time adjustment timer [mS]
		0 - 3000 Operation interval Default setting : 200
752	752	Sewing machine ID code
		00 - 99 Default setting : 00

756	756	Thread winding speed limit
		OFF Upper limit is not limited to 2000 sti/min.
		ON Upper limit is limited to 2000 sti/min.

850	850	Specification code setting
		3
		5
		K
		F

951	951	Eyelet bar tack closing device (old 432 series)
		OFF Disabled
		1 Eyelet bar tacker closing device operates after the work clamp has dropped.
		2 Eyelet bar tack closing device operates at the sewing start.

952		
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311H		
655		* Default setting will be different depend on specifications ←
656		→
655		←

750		→
751		←
752		←

* No data reading for old models on BAS-311H

* Always Speed limit is limited on BAS-311H ←

* Monitoring criteria for feeding is always same on BAS-311H

850	850	←
		3
		5
		7

951		→
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* No perfect specificaton on BAS-311H

311G		
655		←
656	656	Home position return when sewing is paused
		OFF Mechanism moves to home position and then moves to sewing start position.
		ON Mechanism steps back to the sewing start position along the sewing path without moving to the home position.
657	657	Status od optional output when stop switch is pressed
		OFF Optional output will be OFF.
		ON When resewing after stopped, optional output will be stay ON.

750	750	←
		0 Disabled
		1 ←
		2 While the foot switch is being depressed, the work clamp moves up and down twice and then continuous operation starts.
		3 While the foot switch is being depressed, the work clamp moves up and down three times and then continuous operation starts.

* Setting range : 0 - 255 ←

752		←
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755	755	Reading/writing sewing data for old models
		OFF Only compatible with floppy disks.
		ON Reading and writing using CF cards is possible in data read/write mode

756	756	Main shaft angle display mode
		OFF Disabled
		ON Main shaft angle is displayed when sewing machine starts.

757	757	Nonitoring criteria for feeding
		OFF Standard
		ON High precision

850	850	←
		0 Specification of factory original setting
		1 For heavy weight materials
		2 For midium weight materials
		3 For car sheet belt application

950	950	Automatic start for extended option output No. 1
		OFF Disabled
		ON Sewing machine starts when extended option output No. 1 is ON.

951	951	Program number output
		OFF Disabled
		ON When the last two digits of the program number are 1 to 15, the program number is output in 4 bits to extended option output 4 - 7.

952	952	Feed timing at the sewing start (For perfect stitch specification)
		OFF Thread is prevented from pulling out
		ON Thread tightening is emphasized