BUTTON SEW THROUGH THE BUTTON HOLE

B448/BA15

FITTING

ADJUSTING

OPERATING
B448/BA15 BUTTON SEW THROUGH THE BUTTON HOLE

INSTRUCTIONS

FITTING

1) Remove the 'loose button wire' (button float bar) part No.S07111-001 (fig.1).

2) Change the needle hole plate for a flat type, i.e. without the raised hole. (fig.2).

3) Remove the existing button clamp bracket S03464-101, Button clamp holder assembly S07080-001, and bracket 153835-006 (fig.3).

4) Fit the modified bracket 153835-006 and return the old part for credit. (fig.3).

5) Drill and tap the end of the button clamp holder S07080-001 (ref.drawing 448/03000/35) and fit the cylinder unit (photo.B).

6) Assemble the button clamp parts to the modified button clamp bracket/opener S03464-101 and return the old bracket for credit. (photo.A).

7) Fit the modified presser lift roller arm shaft S07072-001 (fig.4)

8) Fit the modified button catch plate (fig.5)

9) Fit the main clamp lowering cylinder and head reset switch assembly (photo.C).

10) Fit the start cylinder to the start solenoid (photo.D)

11) Fit the main control unit under the table top and drill a suitable hole in the table top for the air tubes to reach the head mounted air cylinders.

12) Fit the 3 position switch unit (photo.E).

13) Fit the foot switch unit (photo.F).

11) Connect the air tubes and head reset switch wire as per diagram (ref. drawing 438/3000/39)

12) Connect the electrical supply.
    YELLOW/GREEN = EARTH
    BLUE = NEUTRAL
    BROWN = LIVE 220 - 240 VAC OR 110-120 VAC
    (SELECT CONTROL BOX LINK)

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B448/BA15 BUTTON SEW THROUGH THE BUTTON HOLE

ADJUSTMENTS & OPERATING INSTRUCTIONS

1) Adjust the button loading arm S07075-001 so that the tips of the pins in the button catch plate are just clear of the underside of the button latch plate S09582-001.

2) Adjust the button clamp height to line up with the button movement arm S07075-001.

3) Turn the machine by hand to make sure the button alignment is correct and there is no fowling between the finger opening cylinder and the button loading parts. Switch on the unit and press the reset switch, the reset switch must be pressed each time the unit is switched on for the time.

The button clamp is lowered in two steps, to adjust step 1, set the step switch to position 3. Place the garment under the sewing clamp with the button hole central. Press the start switch ONCE to lower the clamp to position 1.

Adjust the height of the clamp assembly so that the tips of the button hole opening fingers are approximately 1mm above the button hole. This is done by the screw in the end of the cylinder (photo.B).

4) OPENING FINGER LENGTH.

The length of the button hole opening fingers must be adjusted for optimum results. They must be long enough to penetrate the thickness of the button hole to maintain a positive action. However, if these are left too long this will create excessive button stand off. The best length is approximately 0.5mm longer than the thickness of the buttonholed fabric. These must be filed to the correct length and re-polished.

3 POSITION SWITCH.

POSITION 1. Is for standard sewing.

POSITION 2. Gives 2 step action. First press of the start switch lowers the clamp to the first position and opens the button hole. Second press of the start switch starts the machine. This facility is used for easy to handle garments and more experienced operators.

POSITION 3. Gives 3 step action. First press of the start switch will lower the clamp to the first position to allow the fingers to be aligned with the button hole. Second press of the start switch will lower the clamp to the second position and open the button hole. Third press of the start switch will start the machine.

After sewing is complete, pull the garment away QUICKLY to allow the button to be released easily from the clamp and to allow the next button to be loaded.
BUTTON CLAMP HOLDER

PART NUMBER S07081-001

3 HOLES D&T M5

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R. Tension Release mechanism / Spannungsverminderung
Mécanisme de relâche-tension / Mecanismo de liberador de tensión

S. Tread wiper mechanism / Fadenwischvorrichtung
Mécanisme de tire-fil / Mecanismo de limpiador de hilos

From the library of: Superior Sewing Machine & Supply LLC
- Button feeder mechanism (2) / Knopfzuführungvorrichtung (2)
  Alimentation pour boutons (2) / Botón de alimentación (2)

b. Button feeder mechanism (3) / Knopfzuführungvorrichtung (3)
  Alimentation pour boutons (3) / Botón de alimentación (3)