## Technical Specifications

**Dimensions**
Length/with bundle clamp ...........................................1.300 mm/1.700 mm
Width .........................................................................................1.100 mm
Height   ......................................................................................1.400 mm

**Table height**
Manually adjustable from  ........................................ 890 mm  to 1.150 mm

**Weight**
Basic equipment ............................................................................270 kg

**Compressed air**
Nominal pressure...................................................................20 NI/6 bar

**Power supply**
Rated voltage ...............................................................220V/50/60 Hz
AC voltage ....................................................................220V/50/60 Hz
Power consumption..................................................................0,7 kWh

## Sewing System

Maximum sewing speed ........................................................ 4500 rpm
Maximum seam length......................................250 mm/optional 300 mm
Maximum seam depth.................................................................50 mm
Stitch length...........................................................................0,5–5 mm
Needle system...............................................................................134
Needle size ....................................................................70–100 Nm

## Examples of output

14–16 seams per minute (without tacked seam)

## Basic equipment

- Lock stitch sewing head Brother with direct drive and motor controller, AC voltage 190–240 Volt, 50/60 Hz, with integrated thread cutter
- Micro-processor controller with LCD display and USB slot
- Pre laying station with integrated vacuum
- Transfer station, movable with controlled stepper motor
- X-axis drive (clamp transport)  with controlled stepper motor
- Y-axis drive (movable sewing head) with controlled stepper motor
- Bundle clamp
- Blow-off unit
- Needle thread monitor with bobbin thread counter
- Height-adjustable frame
- Machine-specific operator software for creating and administering sewing programs

**Options:**
- Vacuum pump
- Sewing clamp for seams up to 300mm

Automatic serging unit
Automatic pocket welting
Engineered workstation
Automatic joining seam machines
Automatic short seamer machines
Special machines



Darts and pleats appear to be simple seams at first sight, but they have a great impact on the fitting shape of trousers, skirts and blouses as well as on the location of the piped pocket on the rear side of trousers. One basic problem with these seams is that the sewing part is placed over a blade. In doing so, the sensitive materials (stretch, among others) are stretched and drawn. This has an unfavourable impact on the sewing result. In order to counter this problem, we have developed the automatic short seamer BASS 5950.

## Advantages

**High productivity: 14–16 seams/minute (without tack seam)**

**Simple operation – quick learning process**

**Easiest creation and administration of the stitching programs on the PC with machine-specific operator software**

**There are almost no limits for the shape of the darts thanks to the X-Y controller**

**All types of stitches can be processed without changing over the machine and merely by changing the program**

**Automated-Sewing-Systems AG**

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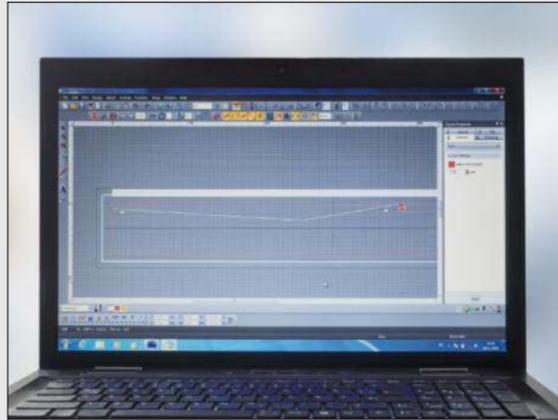
*Simplest preparation and administration of the sewing programs on the PC with machine-specific operator software*



*Placing the sewing part on the marking lights of the pre laying station. Fixing it with a vacuum*



*Acceptance and sewing the programmed darting machine with the X-Y controller*



*Accurate stitching on the dart tip (no cone formation)*



Dart for ladies' blouse (Photo **1 und 2**)

Dart on the rear of the trousers (Photo **1 und 2**)

Waist fold (Photo **3 und 4**)

## Sample seams

This is only a small selection of sample seams. With the machine-specific operator software in conjunction with the newly developed X-Y controller, there are almost no limits as far as the shape of the waist folds and darts are concerned.
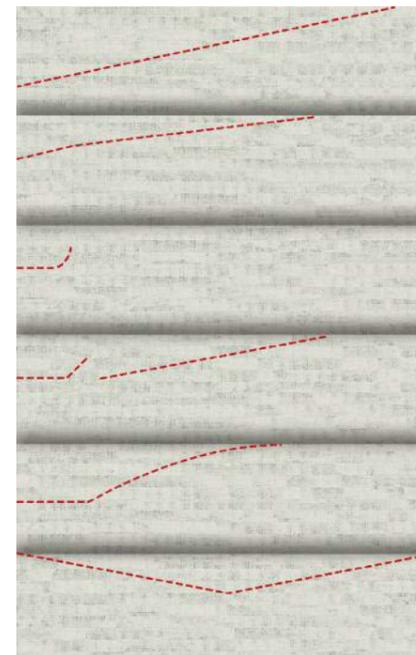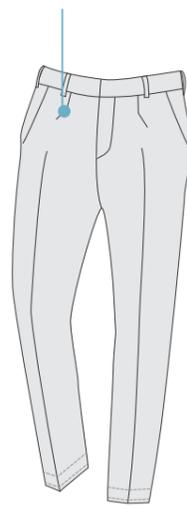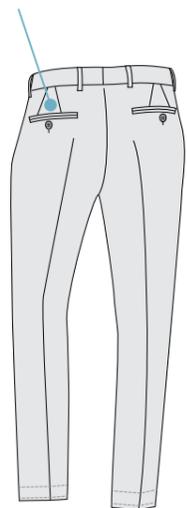


**1** *Single tip dart (rear side of the trousers, ladies' blouse) with straight end of the tip*

**2** *Single tip shaped dart (rear of the trouser, ladies' blouse) with mild run-out*

**3** *Waist fold (open or closed)*

**4** *Waist fold with tacked seam for better ironing of the pleat*

**5** *Shaped darts for ladies' trousers and skirts with a cut waistline*

**6** *Two-tipped dart*

## Advantages

✔ Prompt positioning and fixing of the sewing material on the pre laying station with the help of a vacuum
✔ Three programmable marking lights for accurate and clear positioning of the sewing parts on the pre laying station
✔ Accurate stitching with stitch condensation over the tip of the dart (no cone formation)
✔ Overlapping working method, 14–16 seams per minute, without a tacked seam
✔ Simple operation – quick learning process
✔ There are almost no limits for the shape of the darts thanks to the X-Y controller
✔ All types of seams can be processed without changing over the machine and merely by changing the program
✔ Easiest creation and administration of the stitching programs on the PC with machine-specific operator software
✔ Micro-processor controller with integrated USB slot and a memory capacity of 60 stitches
✔ Consistently good quality even with difficult materials

## Production Process

The use of the BASS 5950 ensures an enormous gain in productivity and seam quality, and overlapping working method as well as consistent sewing results with different materials.

**Program pre-selection:**
The programmed seam is selected on the control panel.

**Manual working steps:**
Three marking lights ensure exact positioning of the sewing part on the pre laying station.

**Automatic sewing process:**
The pre laying station with the sewing part positioned and fixed by vacuum moves to the transfer station. This accepts the sewing part and moves to the programmed dart depth (controlled stepper motor, programmable in 0.1 mm steps). The clamp (X-axis) now takes over the sewing part and feeds it to the stitching head (Y-axis).

At the end of sewing, the sewing part is blown off. During the sewing process, the next sewing part can be positioned on the pre laying table. It moves in automatically after the blow-off operation. This provides completely overlapping working method.

## Performance Profile

The BASS 5950 is a sewing system on which darts can be stitched rationally and with consistently good seam quality. Due to the X-Y controller, there are almost no limits for the shape of the darts.

All shapes of seams can be processed without retrofitting the machine by changing the program. The operation of the workstation is oriented for a very quick learning process.

**Work ergonomics:**
The system must be operated as a workstation in standing position. The height of the table can be adjusted to the body height of the operator.