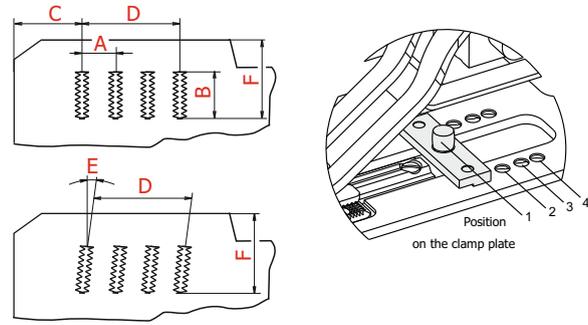


Technical Specifications

	S-4000 ISBH+I SM		S-4001 ISBH+I SM	
	No Angle	Angle	No Angle	Angle
Sewing Head	AMF Reece S-4000/S-4001			
Motor	DC Drive			
Sewing Speed	1,500 - 3,800 spm			
Stitch Type	Single Thread Chainstitch			
Stitch Density	3 - 12 s/cm (8 - 30 spi)			
Stitch Bite	1.7 mm - 2.3 mm (1/15" - 3/32")			
Buttonhole Type	Imitation Sleeve Buttonhole			
Number of Buttonholes	1 - 8			
Distance between Buttonholes (A)	4 - 73 mm (3/16" - 2 5/8") Adjustable in Programme			
Buttonhole Length (B)	15.8 mm - 25 mm (5/8" - 1")			
Maximum Distance from Edge (C)	67 mm (2 5/8")			
Maximum Distance First to Last Buttonhole (D)	up to 73 mm (2 5/8")			
Angle Adjustable (E)	0°	0° - 20°	0°	0° - 20°
Maximum Distance from Edge (F)	up to 70 mm (2 3/4")			
Thread Trimming	Pneumatic			
Recommended Thread	Core Spun Polyester No. 80, 100, 120		Tex Size 30, 40, 50, 60 Core Spun Polyester No. 80, 100	
Recommended Needle	AMF Reece Series 750 Size 90/14, 80/12, 70/10			
Clamp Height	12.7 mm (1/2")			
Maximum Work Thickness	3 mm (1/8")			
Clamping	Pneumatic			
Lubrication	Semi - Automatic			
Control System	PLC			
Table Types	Crosswise			
Electrical Requirements	230 V 50/60 HZ 1 phase (according to EN 60204-1)			
Air Requirements	5.5 bar (80 psi) 14l/m (.5 cfm)			
Dimensions Head and Table	1100 mm (L) x 600 mm (W) x 710 mm (H)			
Dimensions Packed Weight	1300 (L) x 770 (W) x 1150 (H) 171 kg Gross			

The chart shows a distance from the edge of the buttonhole in dependence on the clamp turning angle. The given values are relevant to 20 mm buttonhole.

Position	Indexer Angle (E)	Max. Length (D)	Depth (F)
1	0°	73 mm	48 mm
	6°	65 mm	48 mm
	10°	63 mm	48 mm
	15°	54 mm	47 mm
	20°	51 mm	46 mm
2	0°	73 mm	59 mm
	6°	65 mm	59 mm
	10°	63 mm	59 mm
3	0°	73 mm	65 mm
	6°	65 mm	65 mm
4	0°	73 mm	70 mm



Accuracy of illustration and description of equipment shown herein apply to products as manufactured at time of publication.

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S-4000/S-4001

Imitation Sleeve Buttonhole

The S-4000/S-4001 ISBH is an electronically controlled chainstitch straight buttonhole machine designed for sewing decorative non-functional buttonholes on jacket sleeves. The machine is based on the well known AMF Reece S-4000 range of machines having all of the features the same.



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Features

Electronic Stop and Start Motion extends machine life and improves machine reliability by eliminating the stop motion and clutch mechanisms.

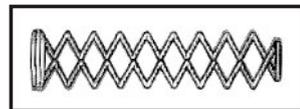
High Sewing Speed combined with low noise level is adjustable from 1,500 spm to 3,800 spm.

DC Drive Motor fully enclosed within the head casting eliminates the need for an under the table mounted clutch motor, pulley, belt and brake. This reduces required maintenance and eliminates oil and dust around the working area.

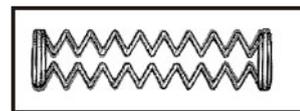
Pneumatic System is used for the thread trimming and clamping that reacts to different material thicknesses and types of fabric. Together with the **Single Pedal Electronic Start** it increases production and reduces operator's fatigue.

Semi-Automatic Lubrication System and Oil Monitor provide additional safeguards that increase machine life and dependability.

The Appearance of Imitation Sleeve Buttonhole is different to a normal buttonhole which is squared at both ends. The ISBH non-cut buttonhole has one squared end and the other „show“ end has less stitches which gives a rounded effect. This is achieved by the use of a special cam. On the finished garment the button is sewn over the squared end.



ISBH Buttonhole



Normal Buttonhole

Applications

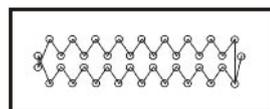
The **S-4000 ISBH** machine is used when sewing imitation non-functional buttonholes on sleeve cuffs of men's and ladies' jackets, suits and sport coats etc.

The **S-4001 ISBH** machine is designed primarily for decorative sewing of buttonholes using special threads such as silk.

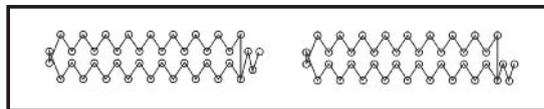
Option

Laser Light System for S-4000 ISBH Indexer model that marks the position of the sleeve at the beginning of sewing cycle.

Different Buttonhole Shapes can be sewn with other two cams that can be ordered extra from AMF Reece. The machine is supplied with the standard cam (see the pictures below).



Standard Cam

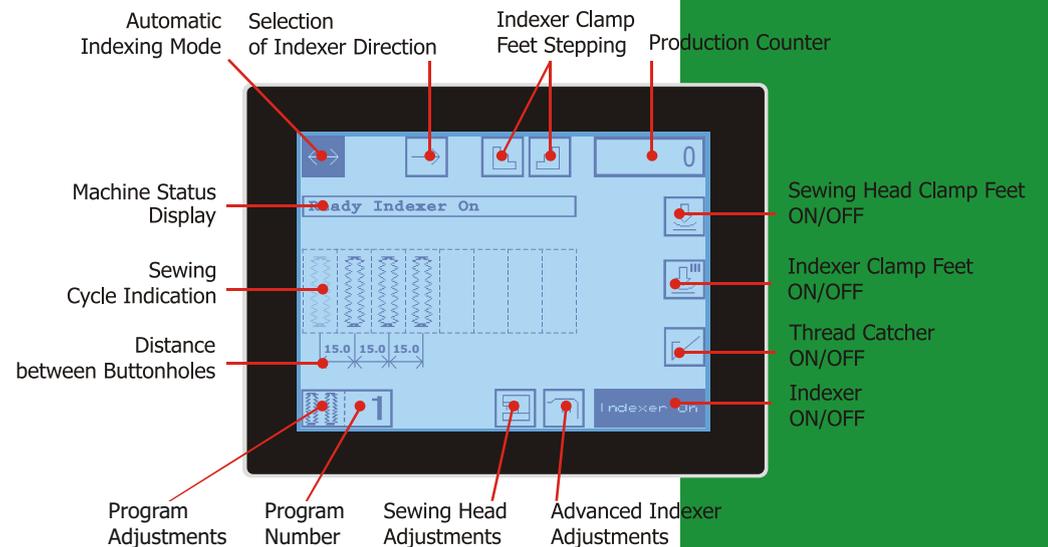


Optional Cams

S-4000/S-4001 ISBH with Indexer

S-4000 ISBH with Indexer is programmable to sew imitation buttonholes at specific distances between each buttonhole. The number of buttonholes and the distance required between them are selected by the operator on the control panel.

Touch Screen Control Panel

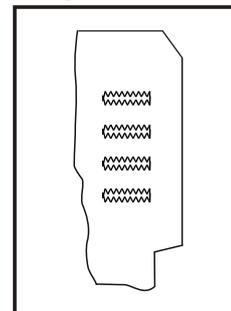


When using the S-4000 ISBH with Indexer, the operator simply places the sleeve cuff into the correct sewing position for the first buttonhole and during the sewing cycle prepares the next piece for sewing.

Indexer can be set to feed from left to right, right to left or to alternate between both. This feature is used when the work comes to the operator in pairs.

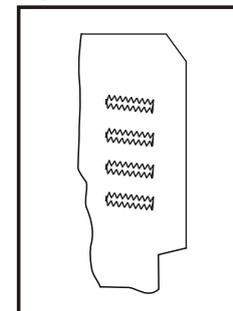
The machine clamps can be set to sew imitation buttonholes at an angle of 0 to 20 degrees from a sleeve cuff. This feature is usually required when sewing buttonholes on ladies' jackets while on menswear the buttonholes are normally sewn parallel to the cuff.

No Angle



Buttonholes placed parallel to sleeve cuff

Angle



Buttonholes sewn at an angle to sleeve cuff

For further explanation see the technical specifications.



Imitation Buttonholes on Fine Suits



Laser Light System